

Vollhartmetall-Werkzeuge

FRÄSEN
BOHREN
GEWINDEBEARBEITUNG
REIBEN





Wir möchten Ihnen unsere neuen Kataloge vorstellen

Der Katalog besteht aus drei Teilen: Drehwerkzeuge, Rotierende Werkzeuge und Vollhartmetallwerkzeuge. Das Produktangebot umfasst insgesamt über 30.000 Standardprodukte.

Drehwerkzeuge – Allgemeine Drehbearbeitung, Abstechen und Einstechen, Gewindedrehen, Multifunktionale Werkzeuge, Werkzeughalter und Adapter für Drehwerkzeuge

Rotierende Werkzeuge – Fräsen, Bohren, Aufbohren und Adapter für Rotierende Werkzeuge

Vollhartmetallwerkzeuge – Fräsen, Bohren, Gewindebohren und Reiben

Schauen Sie in den Produktübersichtsseiten am Anfang eines jeden Kapitels nach Ihrem Interessensgebiet, auf denen Sie durch Verweise zu der entsprechenden Produktseite geführt werden. Auf jeder Produktseite finden Sie im unteren Bereich Symbole mit Seitenverweisen zu ähnlichen Produkten und Informationen wie z. B. Werkzeughalter, Wendeschneidplatten und Schnittdaten.

Unser Gesamtangebot an circa 50.000 Produkten finden Sie auf www.sandvik.coromant.com. Bei speziellen Anforderungen stellen wir Ihnen ein großes Portfolio kundenspezifischer Werkzeuglösungen bereit, das genau auf Ihre Bedürfnisse abgestimmt werden kann.

Besuchen Sie www.sandvik.coromant.com und bestellen Sie Ihre Produkte und Ersatzteile mit Informationen zu aktuellen Maßen, Toleranzen und Schnittdaten.



Erläuterung der Referenzsymbole:



Bohrungsgröße - Empfehlungen



Schnittdaten



Sortenbeschreibung



Erklärung der ISO 13399 Parameter



Bestellnummern-schlüssel



Informationen zum Kühlschmierstoff



Nachschleifen



Information



Erste Wahl

Gute Wahl

Nicht verfügbar

Unser Produktportfolio

Bei allem, was wir tun, geht es um die Optimierung von Prozessabläufen und die Steigerung der Effizienz und Produktivität. Wir wissen aus Erfahrung, dass dies unterschiedliche Lösungen für unterschiedliche Kunden bei unterschiedlichen Operationen erfordert. Es gibt keine Patentlösung. Aus diesem Grund haben wir ein Angebot entwickelt, das Vollhartmetallwerkzeuge in drei verschiedenen Kategorien umfasst.



Versatile

Universelle Lösungen

Ein komplettes Angebot an Hochleistungsprodukten für hohe Bearbeitungsflexibilität und Kosteneffizienz.



Optimized

Optimierte Lösungen

Eine einzigartige Reihe an Hochleistungswerkzeugen, welche die für spezifische Anforderungen benötigte Effizienz, Zuverlässigkeit und Lebensdauer liefern.



Customized

Kundenspezifische Lösungen

Tailor Made und technisch hochentwickelte Lösungen, individuell gefertigt für höchste Leistungsansprüche.

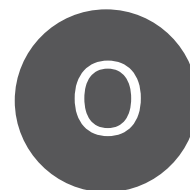
Wahl des richtigen Produkts

1. Wählen Sie den Anwendungstyp
2. Wählen Sie den entsprechenden Produktbereich für Ihre Anforderungen

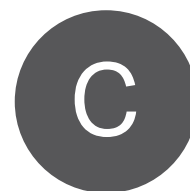
- Lösung für zahlreiche unterschiedliche Werkstoffe
- Robustes Werkzeug für unterschiedliche Anwendungen
- Ideal für kleine Serien und die Mischproduktion



- Optimierte Lösung für bestimmte Werkstoffe
- Auf spezifische Anwendungen abgestimmtes Werkzeug
- Ideal für mittlere und große Produktionsserien



- Ein individuelles, speziell für Ihre Anwendung maßgefertigtes Werkzeug
- Erweitertes Anwendungswissen und Expertenberatung
- Werkzeug ist nicht als Standard erhältlich



A

A Fräsen

B Bohren

C Gewindebohren

D Reiben

B

E Allgemeine Informationen

C

D

E

Fräsen



Universell

CoroMill® Plura Vollhartmetall-Schaftfräser	A10
Schaftfräser für große Eingriffsbreiten	A11-A24
Schaftfräser für mittlere Eingriffsbreiten	A25-A28
Schaftfräser mit Kordelverzahnung	A29
Kugelschaftfräser für die Profilbearbeitung	A31-A34
Schaftfräser für das Fasfräsen	A35-A37



Optimiert

CoroMill® Plura Vollhartmetall-Schaftfräser	A38
Schaftfräser für die Heavy Duty Bearbeitung	A39-A52
Schaftfräser für die High Feed Sidemilling Bearbeitung	A53-A64
Schaftfräser für die High Feed Facemilling Bearbeitung	A65-A68
Schaftfräser für Stabilität und Spanraum	A69-A80
Schaftfräser für die Hartbearbeitung	A81-A84
Schaftfräser für ISO N	A85-A92
Schaftfräser mit Kordelverzahnung	A93-A98
Schaftfräser für die Schlichtbearbeitung	A99-A104
Schaftfräser für die Mikrobearbeitung	A105
Kugelschaftfräser für die Mikrobearbeitung	A107-A110
Kugelschaftfräser für die Profilbearbeitung	A111-A120
Schaftfräser für das Besäumen	A121-A126
Schaftfräser für die Gewindebearbeitung	A127-A138
Hochgeschwindigkeitsschruppen	A139

CoroMill® 316 Vollhartmetall-Fräskopf	A141

Fräskopf für die Heavy Duty Bearbeitung	A142-A145
Fräskopf für Stabilität und Spanraum	A146-A149
Fräskopf für die High Feed Sidemilling Bearbeitung	A150
Fräskopf für die High Feed Facemilling Bearbeitung	A152-A154
Fräskopf für die Hartbearbeitung	A155
Fräskopf für ISO N	A157
Fräskopf mit Kordelverzahnung	A159
Fräskopf für die Profilbearbeitung	A161-A163
Fräskopf für die Schlichtbearbeitung	A164-A166
Fräskopf für das Fasfräsen	A167-A170
Keramik-Fräskopf für die Hochgeschwindigkeitsbearbeitung	A171

CoroMill® 326 Vollhartmetallfräser	A173

Fräser für das Anfasen	A174
Fräser für die Gewindebearbeitung	A175



Kundenspezifisch

E2



CoroMill® Plura - Optimiert



Erste Wahl für die optimierte Schrupp- und Schlichtbearbeitung

	Nutenfräsen bis zu 2xDc	Nutenfräsen bis zu 1xDc	Schweres Eckfräsen	Leichtes Eckfräsen ae bis zu 0.25xDc	High Feed Sidemilling	Schlichten	High Feed Facemilling		Werkzeug	Seite	Werkstoff
									Schaftfräser für die Heavy Duty Bearbeitung	A40-A47	
									Schaftfräser für die Heavy Duty Bearbeitung	A48-A52	
									Schaftfräser für ISO N	A86-A92	
									Schaftfräser für Stabilität und Spanraum	A78-A80	
									Schaftfräser für die Hartbearbeitung	A82-A84	
									Schaftfräser für die High Feed Sidemilling Bearbeitung	A54	
									Schaftfräser für die High Feed Sidemilling Bearbeitung	A55-A58	
									Schaftfräser für die High Feed Sidemilling Bearbeitung	A59-A64	
									Schaftfräser für die Schlichtbearbeitung	A100-A104	
									Schaftfräser für die High Feed Facemilling	A66-A68	
									Keramik-Schaftfräser für die Hochgeschwindigkeitsbearbeitung	A140	

Anwendungssymbole

Eckfräsen 	Besäumen 	Taschenfräsen 	Nutenfräsen 	Tauchfräsen 	Auskammern
Planfräsen 	Profilfräsen 	Gewindefräsen 	Spiralinterpolation 	Fasen innen 	Fasen außen

CoroMill® Plura - Optimiert

	Schaftfräser für die Heavy Duty Bearbeitung			Schaftfräser für die High Feed Sidemilling Bearbeitung				Schaftfräser für Stabilität und Spanraum
								
Werkstoff	Für Stahl	Für Stahl	Für rostfreien Stahl	Für Titanlegierungen	Für Nickelbasislegierungen	Für Stahl und rostfreien Stahl	Für rostfreien Stahl	Für Nickelbasislegierungen
ISO Anwendungsbereich								
D _h mm	6.00 - 25.00	2.00 - 25.00	6.00 - 25.00	4.00 - 32.00	4.00 - 25.00	2.00 - 25.00	2.00 - 25.00	2.00 - 16.00
D _h Zoll	.250 - .750	.125 - .750	.250 - .750	.188 - 1.250	-	.250 - 1.000	-	-
APMX/DC	2.10 - 2.50	2.10 - 2.50	2.10 - 2.50	2.10 - 2.50	2.10 - 2.50	1.80 - 4.00	1.80 - 3.50	1.90 - 2.40
ZEFP	5	4	4	4, 5, 6	4, 5	4	4	3, 4
RE mm	0.50 - 2.00	0.20 - 2.00	0.50 - 6.35	0.50 - 4.00	0.50 - 6.35	-	0.50 - 4.00	0.20 - 2.00
RE Zoll	.015 - .060	.015 - .060	.015 - .190	.030 - .120	-	-	-	-
CHW mm	0.10 - 0.25	-	0.10 - 0.25	-	-	0.15 - 0.20	0.15 - 0.20	0.10
CHW Zoll	.004 - .010	-	.004 - .010	-	-	.004 - .010	-	-
Schaft	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch Weldon iLock	Zylindrisch Weldon iLock	Zylindrisch Weldon	Zylindrisch	Zylindrisch Weldon
BSG	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANTDIN 6527 L	DIN 6527 L	DIN 6527 L
Sorte	1730	1730	1740	1745	1710	1630, 1740	1640	1725
Innere Kühlschmierstoffzufuhr								
Äußere Kühlschmierstoffzufuhr								
Seite	A40-A43	A44-A47	A48-A52	A59-A62	A63-A64	A54-A56	A57-A58	A78-A80

	Schaftfräser für die High Feed Facemilling Bearbeitung		Schaftfräser für die Hartbearbeitung	Schaftfräser für ISO N		Schaftfräser für die Schlichtbearbeitung		Schaftfräser für die Hochgeschwindigkeitsbearbeitung
								
Werkstoff	Für Stahl und gehärteten Stahl mit Härte ≤ 63 HRC	Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRC	Für gehärteten Stahl mit Härte 43≤ HRC ≤63	Für NE-Metalle	Für NE-Metalle mit Siliziumgehalt > 9%	Für gehärteten Stahl mit Härte 43≤ HRC ≤63	Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRC	Für Nickelbasislegierungen
ISO Anwendungsbereich								
D _h mm	4.00 - 20.00	4.00 - 20.00	2.00 - 16.00	2.00 - 20.00	1.00 - 16.00	3.00 - 20.00	3.00 - 20.00	10.00 - 12.00
D _h Zoll	-	-	.125 - .375	-	-	.250 - .750	.063 - .750	-
APMX/DC	2.25 - 2.75	1.00 - 2.75	1.00	1.00 - 4.10	1.00	1.80 - 4.50	1.90 - 2.80	0.75
ZEFP	4	4	2, 4	1, 2	2, 4	4, 6, 8, 10, 12, 14, 16	4, 5, 6, 8	4, 6
RE mm	0.50 - 2.00	0.50 - 2.00	0.20 - 3.00	0.15 - 2.50	-	0.50 - 2.00	-	1.50 - 6.00
RE Zoll	-	-	.031 - .063	-	-	-	.016 - .125	-
CHW mm	-	-	-	0.10 - 0.15	0.10 - 0.15	0.10 - 0.15	0.10 - 0.15	-
CHW Zoll	-	-	-	-	-	-	-	-
Schaft	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch
BSG	COROMANT	COROMANT DIN 6527 L	COROMANT	COROMANT DIN 6527 L	COROMANT	COROMANT DIN 6527 L	COROMANT DIN 6527 L	COROMANT
Sorte	1610	1620	1610	H10F, 1630	N20C	1610	1620	6060
Innere Kühlschmierstoffzufuhr								
Äußere Kühlschmierstoffzufuhr								
Seite	A66	A67-A68	A82-A84	A86-A91	A92	A100-A101	A103-A104	A140

CoroMill® Plura - Optimiert

	Optimierte Schruppbearbeitung in Multimaterial und bei schwieriger Spanabfuhr					Sonstige Fräsbearbeitungen		
	Schaftfräser für Stabilität und Spanraum		Schaftfräser mit Kordelverzahnung			Schaftfräser für die Mikrobearbeitung	Kugelschaftfräser für die Mikrobearbeitung	
								
Werkstoff	Für Stahl und gehärteten Stahl mit Härte ≤ 63 HRC	Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRC	Für ISO S-Werkstoffe	Für NE-Metalle	Für Stahl mit Härte ≤ 48 HRC	Für Multimaterial-Anwendungen mit Härte ≤ 63 HRC	Für Multimaterial-Anwendungen mit Härte ≤ 63 HRC	Für gehärteten Stahl mit Härte 43 ≤ HRC ≤ 63
ISO Anwendungsbereich								
D _c mm	2.00 - 20.00	2.00 - 25.00	6.00 - 25.00	6.00 - 25.00	6.00 - 25.00	0.40 - 1.00	0.40 - 1.00	0.20 - 2.50
D _c Zoll	.187 - .750	.187 - .750	-	-	-	-	-	-
APMX/DC	1.90 - 3.20	1.90 - 2.00	1.80 - 2.40	1.00 - 2.40	1.00 - 2.40	1.00	1.00	0.60 - 0.90
ZEFP	3, 4	3, 4, 5	4, 5	3	3, 4, 5, 6, 8	2	2	2
RE mm	0.50 - 4.00	0.20 - 6.35	-	-	0.35 - 4.00	-	0.20 - 0.50	0.10 - 1.25
RE Zoll	.016 - .063	.016 - .063	-	-	-	-	-	-
CHW mm	0.10 - 0.15	0.10 - 0.15	0.10 - 0.15	0.45 - 0.90	-	-	-	-
CHW Zoll	-	-	-	-	-	-	-	-
Schaft	Zylindrisch	Zylindrisch Weldon iLock	Weldon	Zylindrisch	Zylindrisch Weldon	Zylindrisch	Zylindrisch	Zylindrisch
BSG	COROMANT	COROMANT DIN 6527 L	DIN 6527 L	COROMANT DIN 6527 L	DIN 6527 K DIN 6527 L	COROMANT	COROMANT	COROMANT
Sorte	1620	1620, 1630, 1640	1620	H10F	1640	1620	1620	1700
Innere Kühlschmierstoffzufuhr	✗	✓	✗	✗	✗	✗	✗	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓	✓	✓	✓
Seite	A70-A71	A72-A77	A94	A95	A96-A97	A106	A108-A109	A110

	Sonstige Fräsbearbeitungen					Gewindefräsen		
	Kugelschaftfräser für die Profilbearbeitung					Schaftfräser zum Besäumen	Schaftfräser für das Gewindefräsen (Innengewinde)	Schaftfräser für das Gewindefräsen (Innen-/ Außengewinde)
								
Werkstoff	Für NE-Metalle	Für NE-Metalle mit Siliziumgehalt > 9%	Für Stahl und gehärteten Stahl mit Härte ≤ 63 HRC	Für gehärteten Stahl mit Härte 43 ≤ HRC ≤ 63	Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRC	Für Verbundwerkstoffe	Gewindeprofile: M 60°, MF 60°, MJ 60°, UN 60°, UNC/UNF 60°, NPT 60°, NPTF 60°	Gewindeform: G
ISO Anwendungsbereich								
D _c mm	2.00 - 16.00	1.00 - 12.00	1.00 - 16.00	1.00 - 16.00	4.00 - 16.00	4.00 - 16.00	1.20 - 25.00	-
D _c Zoll	-	-	.063 - .500	.063 - .500	-	.250 - .625	.053 - .783	.236 - .984
APMX/DC	1.30 - 3.00	1.70 - 3.00	1.00 - 2.00	1.50 - 1.70	1.40 - 10.00	2.50 - 3.00	-	-
ZEFP	2	2	2	2, 4	2, 3, 4	5, 6, 7, 9, 11	3, 4, 5, 6	3, 4, 5
RE mm	1.00 - 8.00	0.50 - 6.00	0.50 - 8.00	0.50 - 8.00	2.00 - 8.00	-	-	-
RE Zoll	-	-	.031 - .250	.031 - .250	-	-	-	-
CHW mm	-	-	-	-	-	-	-	-
CHW Zoll	-	-	-	-	-	-	-	-
Schaft	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch	Zylindrisch Weldon	Weldon
BSG	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT
Sorte	H10F	N20C	1610, 1620, P10	1700, 1610	1620, 1630	O10A, 1630, O12M, O10M	1630, 1620, H07F, 1610	1630
Innere Kühlschmierstoffzufuhr	✗	✗	✗	✗	✗	✗	✓	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓	✓	✓	✓
Seite	A112-A113	A114	A115-A116	A118-A120	A117	A122-A126	A128-A131	A138

CoroMill® Plura - Universell

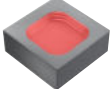
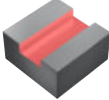
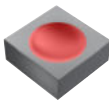
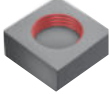
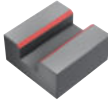
V

Versatile

Erste Wahl für die universelle Schrupp- und Schlichtbearbeitung

					
Nutenfräsen bis zu 1xDc	Nutenfräsen bis zu 0.5xDc	Schweres Eckfräsen	Schlichten		
Werkzeug				Seite	Werkstoff
		Schaftfräser für große Eingriffsbreiten (zwei Spankanäle)		A12-A24	
		Schaftfräser für große Eingriffsbreiten (drei Spankanäle)		A12-A24	
		Schaftfräser für mittlere Eingriffsbreiten (vier Spankanäle)		A27-A28	

Anwendungssymbole

Eckfräsen 	Besäumen 	Taschenfräsen 	Nutenfräsen 	Tauchfräsen 	Auskammern 
Planfräsen 	Profilfräsen 	Gewindefräsen 	Spiralinterpolation 	Fasen innen 	Fasen außen 

CoroMill® Plura - Universell

	Schaftfräser für große Eingriffsbreiten	Schaftfräser für mittlere Eingriffsbreiten	Schaftfräser mit Kordelverzahnung	Kugelschaftfräser für die Profilarbeit	Schaftfräser für das Fasfräsen
					
Werkstoff	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC
ISO Anwendungsbereich					
D_e mm	1.00 - 25.00	2.00 - 25.00	6.00 - 20.00	1.00 - 20.00	1.00 - 8.00
D_e Zoll	.125 - 1.000	.125 - 1.000	.250 - 1.000	.063 - .750	.047 - .248
APMX/DC	1.0 - 4.8	1.4 - 3.7	1.8 - 3.4	1.4 - 3.0	0.1 - 0.8
ZEFP	2, 3, 4	3, 4	4	2, 4	2, 3, 4, 5, 6
RE mm	-	-	-	0.50 - 10.00	-
RE Zoll	-	-	-	.031 - .375	-
CHW mm	0.00 - 0.30	0.00 - 0.20	0.35 - 0.63	-	-
CHW Zoll	.000 - .012	.000 - .010	.014 - .031	-	-
Schaft	Zylindrisch Weldon	Weldon	Zylindrisch Weldon	Zylindrisch	Zylindrisch
BSG	DIN 6527 K DIN 6527 L COROMANT	DIN 6527 L	DIN 6527 L COROMANT	COROMANT	COROMANT
Sorte	1630	1620, 1630	1640	1620, 1630	1620
Innere Kühlschmierstoffzufuhr	✗	✗	✗	✗	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓
Seite	A12-A24	A26-A28	A30	A32-A34	A36-A37

B

C

D

E

B

CoroMill® 316

O

Optimized

Erste Wahl für die Schrupp- und Schlichtbearbeitung

	Nutenfräsen bis zu 1xDc	Nutenfräsen bis zu 0.5xDc	Eckfräser	High Feed-Sidemilling	Schlichten	High Feed-Facemilling	Werkzeug	Seite	Werkstoff
							Fräskopf für die Heavy Duty Bearbeitung	A143-A145	P M
							Fräskopf für Stabilität und Spanraum	A147-A149	P M
							Fräskopf für ISO N	A158	N
							Fräskopf für die High Feed Sidemilling Bearbeitung	A151	S
							Fräskopf für die Schlichtbearbeitung	A165-A166	P M
							Fräskopf für die High Feed Facemilling Bearbeitung	A153-A154	P M
							Keramik-Schaftfräser für die Hochgeschwindigkeitsbearbeitung	A172	S

D

Anwendungssymbole

Eckfräsen	Besäumen	Taschenfräsen	Nutenfräsen	Tauchfräsen	Auskammern
Planfräsen	Profilfräsen	Gewindefräsen	Spiralinterpolation	Fasen innen	Fasen außen

CoroMill® 316

	Fräskopf für die Heavy Duty Bearbeitung	Fräskopf für die High Feed Sidemilling Bearbeitung	Fräskopf für Stabilität und Spanraum	Keramik-Fräskopf für die Hochgeschwindigkeitsbearbeitung	Fräskopf für die High Feed Facemilling Bearbeitung	Fräskopf für die Hartbearbeitung
Werkstoff	Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc	Für Titanlegierungen	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc	Für Nickelbasislegierungen	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc
ISO Anwendungsbereich						
D ₂ mm	10.00 - 25.00	10.00 - 25.00	10.00 - 25.00	10.00 - 12.00	10.00 - 25.00	10.00 - 16.00
D ₂ Zoll	.375 - 1.000	.375 - 1.000	.375 - 1.000	-	.375 - .750	-
APMX/DC	1.20	1.50	0.52 - 0.63	0.58 - 0.70	0.52 - 0.60	0.80 - 0.84
DCX mm	-	-	-	-	-	-
DCX Zoll	-	-	-	-	-	-
CHW mm	0.15 - 0.25	-	-	-	-	-
CHW Zoll	-	-	-	-	-	-
RE mm	0.50 - 4.00	0.50 - 4.00	0.50 - 4.00	2.00	1.50 - 3.00	0.50 - 3.00
RE Zoll	.015 - .250	.030 - .120	.015 - .250	-	.060 - .080	-
ZEFP	4	6	3, 4, 5	4, 6	3, 4, 5	2
KAPR	-	-	-	-	-	-
Schaft	Coromant EH	Coromant EH	Coromant EH	Coromant EH	Coromant EH	Coromant EH
BSG	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT
Sorte	1730	1745	1730	6060	1730	1730
Innere Kühlschmierstoffzufuhr	✗	✗	✓	✗	✓	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓	✓
Seite	A143-A145	A151	A147-A149	A172	A153-A154	A156

	Fräskopf für ISO N	Fräskopf mit Kordelverzahnung	Fräskopf für die Profilbearbeitung	Fräskopf für die Schlichtbearbeitung	Fräskopf für das Fasfräsen
Werkstoff	Für NE-Metalle	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc	Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc
ISO Anwendungsbereich					
D ₂ mm	10.00 - 25.00	10.00 - 25.00	10.00 - 25.00	10.00 - 25.00	1.50 - 8.00
D ₂ Zoll	-	.375 - 1.000	.375 - 1.000	.375 - 1.000	.059 - .276
APMX/DC	0.52 - 0.55	0.52 - 0.56	0.52 - 0.56	0.52 - 0.56	0.52 - 0.56
DCX mm	-	-	-	-	10.00 - 25.00
DCX Zoll	-	-	-	-	.375 - .750
CHW mm	0.10 - 0.15	-	-	0.10 - 0.15	-
CHW Zoll	-	-	-	-	-
RE mm	1.00 - 4.00	0.40	5.00 - 12.50	1.00 - 1.50	-
RE Zoll	-	.016 - .062	.187 - .500	.015 - .062	-
ZEFP	3	4, 5, 6, 8	2, 4	6, 8, 10, 12	2, 4, 6, 8
KAPR	-	-	-	-	15°, 30°, 45°, 49°, 60°
Schaft	Coromant EH	Coromant EH	Coromant EH	Coromant EH	Coromant EH
BSG	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT
Sorte	H10F	1730	1730	1730	1730
Innere Kühlschmierstoffzufuhr	✗	✗	✗	✗	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓
Seite	A158	A160	A162-A163	A165-A166	A168-A170

CoroMill® Plura - Universell

Hochleistungsschaftfräser für hohe Bearbeitungsflexibilität und Kosteneffizienz

Universelle Werkzeuge gewährleisten eine hohe Leistung und optimale Prozesssicherheit bei einer Vielzahl von Werkstoffen, Anwendungen, Bauteilgrößen und -formen bei maximaler Maschinenauslastung.



Anwendungsbereich

- Schwere Schruppbearbeitung
- Mittlere Schruppbearbeitung
- Schrappen mit Spanteiler
- Profilfräsen
- Fasen

ISO-Anwendungsbereich:



Maximale Maschinenauslastung bei der Bearbeitung unterschiedlicher Bauteile und eine flexible Produktion erfordern robuste Werkzeuge von höchster Genauigkeit und Einsatzflexibilität. Wenn Präzision, Stabilität und kosteneffiziente Bearbeitung Priorität haben, ist CoroMill Plura - Universell die erste Wahl.

www.sandvik.coromant.com/coromillplura

Produktangebot

- Ausgewählte, hochwertige Schneidstoffsorten für alle Materialien und Bedingungen
- Robuste, intelligent konzipierte Schneidengeometrien für verschiedene Fräsanwendungen
- Zylinder- und Weldon-Schaft
- Werkzeuge in gerader Ausführung, mit oder ohne Spanteiler
- Kugelschaft- und Fasräser
- Kann bis zu dreimal gemäß Original-Spezifikationen nachgeschliffen werden



E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die schwere Schruppbearbeitung

Einsatzbereich

Zwei oder drei Spankanäle

Keilnut

Spankanalausführung für großen Spanraum

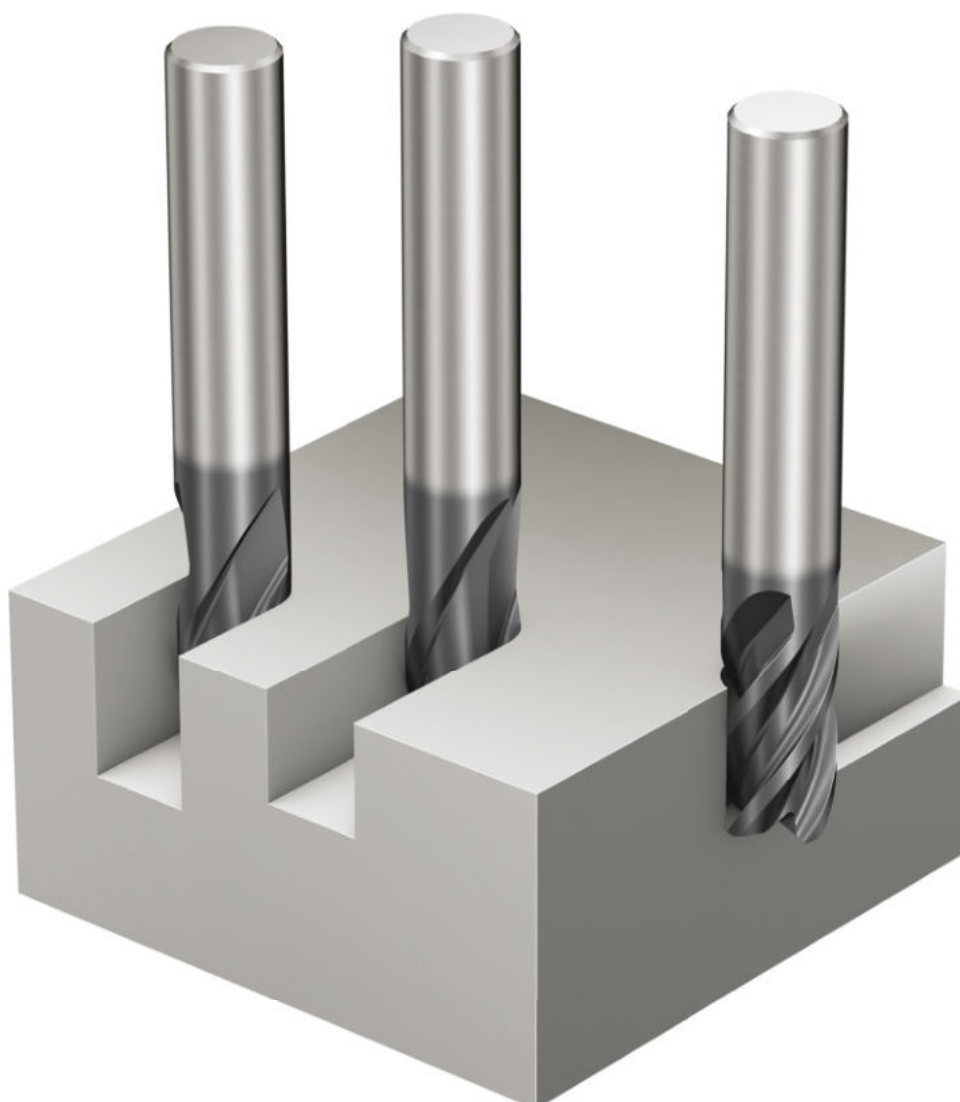
Freistriche für mehr Stabilität

Vier Spankanäle

Mehr Stabilität aufgrund größerem Kerndurchmesser

Optimal zum Eckfräsen

ISO-Werkstoff	P	M	K	N	S
Sorte	1630	1620			
Schaft	Zylindrisch Weldon				

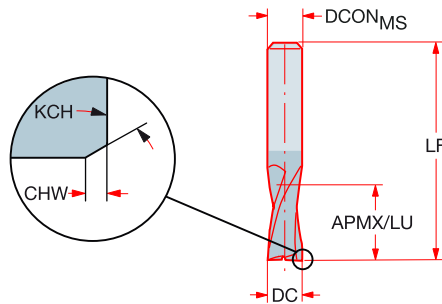


CoroMill® Plura Vollhartmetall-Schaftfräser für die schwere Schruppbearbeitung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDCON

30°
DIN 6527 K
h6



Metrische Ausführung

							Abmessungen, mm			
							P	M	K	S
							1630	1630	1630	1630
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	DCON _{MS}		LF
1.0	3	3.5			3.5	2	1P220-0100-XA	*	*	3.0 38.0
1.5	3	3.5			3.5	2	1P220-0150-XA	*	*	3.0 38.0
1.8	6	3.5			3.5	2	1P220-0180-XA	*	*	6.0 50.0
2.0	6	3.5			3.5	2	1P220-0200-XA	*	*	6.0 50.0
2.5	6	3.5	0.08	45°	3.5	2	1P220-0250-XA	*	*	6.0 50.0
2.8	6	4.5	0.08	45°	4.5	2	1P220-0280-XA	*	*	6.0 50.0
3.0	6	4.5	0.08	45°	4.5	2	1P220-0300-XA	*	*	6.0 50.0
3.5	6	4.5	0.08	45°	4.5	2	1P220-0350-XA	*	*	6.0 50.0
3.8	6	5.5	0.08	45°	5.5	2	1P220-0380-XA	*	*	6.0 54.0
4.0	6	5.5	0.13	45°	5.5	2	1P220-0400-XA	*	*	6.0 54.0
4.5	6	5.5	0.13	45°	5.5	2	1P220-0450-XA	*	*	6.0 54.0
4.8	6	6.5	0.13	45°	6.5	2	1P220-0480-XA	*	*	6.0 54.0
5.0	6	6.5	0.13	45°	6.5	2	1P220-0500-XA	*	*	6.0 54.0
5.8	6	7.5	0.13	45°	7.5	2	1P220-0575-XA	*	*	6.0 54.0
6.0	6	7.5	0.13	45°	7.5	2	1P220-0600-XA	*	*	6.0 54.0
6.8	8	8.5	0.13	45°	8.5	2	1P220-0675-XA	*	*	8.0 58.0
7.0	8	8.5	0.13	45°	8.5	2	1P220-0700-XA	*	*	8.0 58.0
7.8	8	9.5	0.13	45°	9.5	2	1P220-0775-XA	*	*	8.0 58.0
8.0	8	9.5	0.20	45°	9.5	2	1P220-0800-XA	*	*	8.0 58.0
9.0	10	10.5	0.20	45°	10.5	2	1P220-0900-XA	*	*	10.0 66.0
9.7	10	11.5	0.20	45°	11.5	2	1P220-0970-XA	*	*	10.0 66.0
10.0	10	11.5	0.20	45°	11.5	2	1P220-1000-XA	*	*	10.0 66.0
12.0	12	12.5	0.20	45°	12.5	2	1P220-1200-XA	*	*	12.0 73.0
14.0	14	14.5	0.20	45°	14.5	2	1P220-1400-XA	*	*	14.0 75.0
16.0	16	16.5	0.20	45°	16.5	2	1P220-1600-XA	*	*	16.0 82.0
18.0	18	18.5	0.20	45°	18.5	2	1P220-1800-XA	*	*	18.0 84.0
20.0	20	20.5	0.30	45°	20.5	2	1P220-2000-XA	*	*	20.0 92.0

Zoll-Ausführung

							Abmessungen, Zoll			
							P	M	K	S
							1630	1630	1630	1630
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	DCON _{MS}		LF
.125	1/8	.172	.003	45°	.172	2	1P220-0318-XA	*	*	.125 1.500
.188	3/16	.250	.005	45°	.250	2	1P220-0476-XA	*	*	.188 2.000
.250	1/4	.313	.005	45°	.313	2	1P220-0635-XA	*	*	.250 2.000
.375	3/8	.469	.008	45°	.469	2	1P220-0953-XA	*	*	.375 2.500
.500	1/2	.625	.008	45°	.625	2	1P220-1270-XA	*	*	.500 3.000
.625	5/8	.750	.008	45°	.750	2	1P220-1588-XA	*	*	.625 3.000
.750	3/4	1.000	.012	45°	1.000	2	1P220-1905-XA	*	*	.750 4.000
1.000	1	1.250	.012	45°	1.250	2	1P220-2540-XA	*	*	1.000 4.000



A176



A194



E9



E22



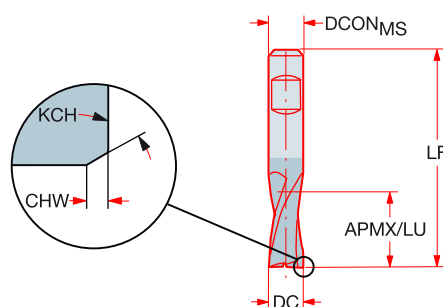
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDCON

30°
DIN 6527 K
h6



Metrische Ausführung

							P M K S				Abmessungen, mm	
							1630	1630	1630	1630	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer					
1.8	6	3.5			3.5	2	1P220-0180-XB	*	*	*	6.0	50.0
2.0	6	3.5			3.5	2	1P220-0200-XB	*	*	*	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	2	1P220-0250-XB	*	*	*	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	2	1P220-0280-XB	*	*	*	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	2	1P220-0300-XB	*	*	*	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	2	1P220-0350-XB	*	*	*	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	2	1P220-0380-XB	*	*	*	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	2	1P220-0400-XB	*	*	*	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	2	1P220-0480-XB	*	*	*	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	2	1P220-0500-XB	*	*	*	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	2	1P220-0575-XB	*	*	*	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	2	1P220-0600-XB	*	*	*	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	2	1P220-0675-XB	*	*	*	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	2	1P220-0700-XB	*	*	*	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	2	1P220-0775-XB	*	*	*	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	2	1P220-0800-XB	*	*	*	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	2	1P220-0900-XB	*	*	*	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	2	1P220-0970-XB	*	*	*	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	2	1P220-1000-XB	*	*	*	10.0	66.0
11.7	12	12.5	0.20	45°	12.5	2	1P220-1170-XB	*	*	*	12.0	73.0
12.0	12	12.5	0.20	45°	12.5	2	1P220-1200-XB	*	*	*	12.0	73.0
13.7	14	14.5	0.20	45°	14.5	2	1P220-1370-XB	*	*	*	14.0	75.0
14.0	14	14.5	0.20	45°	14.5	2	1P220-1400-XB	*	*	*	14.0	75.0
15.7	16	16.5	0.20	45°	16.5	2	1P220-1570-XB	*	*	*	16.0	82.0
16.0	16	16.5	0.20	45°	16.5	2	1P220-1600-XB	*	*	*	16.0	82.0
17.7	18	18.5	0.20	45°	18.5	2	1P220-1770-XB	*	*	*	18.0	84.0
18.0	18	18.5	0.20	45°	18.5	2	1P220-1800-XB	*	*	*	18.0	84.0
19.7	20	20.5	0.30	45°	20.5	2	1P220-1970-XB	*	*	*	20.0	92.0
20.0	20	20.5	0.30	45°	20.5	2	1P220-2000-XB	*	*	*	20.0	92.0



A176



A194



E9



E22



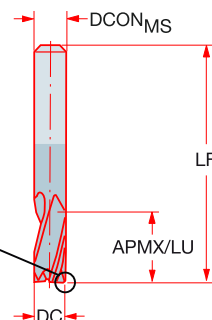
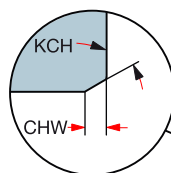
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

30°
DIN 6527 K
e8
h6



Metrische Ausführung

											Abmessungen, mm	
							P	M	K	S		
							1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
1.0	3	3.5			3.5	3	1P221-0100-XA	*	*	*	3.0	38.0
1.5	3	3.5			3.5	3	1P221-0150-XA	*	*	*	3.0	38.0
1.8	6	3.5			3.5	3	1P221-0180-XA	*	*	*	6.0	50.0
2.0	6	3.5			3.5	3	1P221-0200-XA	*	*	*	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	3	1P221-0250-XA	*	*	*	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	3	1P221-0280-XA	*	*	*	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	3	1P221-0300-XA	*	*	*	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	3	1P221-0350-XA	*	*	*	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	3	1P221-0380-XA	*	*	*	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	3	1P221-0400-XA	*	*	*	6.0	54.0
4.5	6	5.5	0.13	45°	5.5	3	1P221-0450-XA	*	*	*	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	3	1P221-0480-XA	*	*	*	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	3	1P221-0500-XA	*	*	*	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	3	1P221-0575-XA	*	*	*	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	3	1P221-0600-XA	*	*	*	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	3	1P221-0675-XA	*	*	*	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	3	1P221-0700-XA	*	*	*	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	3	1P221-0775-XA	*	*	*	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	3	1P221-0800-XA	*	*	*	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	3	1P221-0900-XA	*	*	*	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	3	1P221-0970-XA	*	*	*	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	3	1P221-1000-XA	*	*	*	10.0	66.0
12.0	12	12.5	0.20	45°	12.5	3	1P221-1200-XA	*	*	*	12.0	73.0
14.0	14	14.5	0.20	45°	14.5	3	1P221-1400-XA	*	*	*	14.0	75.0
16.0	16	16.5	0.20	45°	16.5	3	1P221-1600-XA	*	*	*	16.0	82.0
18.0	18	18.5	0.20	45°	18.5	3	1P221-1800-XA	*	*	*	18.0	84.0
20.0	20	20.5	0.30	45°	20.5	3	1P221-2000-XA	*	*	*	20.0	92.0



A176



A194



E9



E22



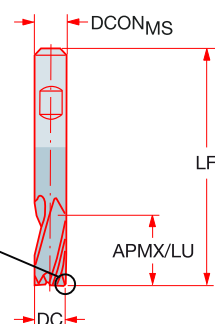
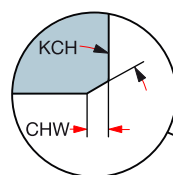
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

30°
DIN 6527 K
e8
h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1630	1630	1630	1630	DCON _{MS}	LF
1.8	6	3.5			3.5	3	1P221-0180-XB	★	★	★	★	6.0	50.0
2.0	6	3.5			3.5	3	1P221-0200-XB	★	★	★	★	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	3	1P221-0250-XB	★	★	★	★	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	3	1P221-0280-XB	★	★	★	★	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	3	1P221-0300-XB	★	★	★	★	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	3	1P221-0350-XB	★	★	★	★	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	3	1P221-0380-XB	★	★	★	★	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	3	1P221-0400-XB	★	★	★	★	6.0	54.0
4.5	6	5.5	0.13	45°	5.5	3	1P221-0450-XB	★	★	★	★	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	3	1P221-0480-XB	★	★	★	★	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	3	1P221-0500-XB	★	★	★	★	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	3	1P221-0575-XB	★	★	★	★	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	3	1P221-0600-XB	★	★	★	★	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	3	1P221-0675-XB	★	★	★	★	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	3	1P221-0700-XB	★	★	★	★	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	3	1P221-0775-XB	★	★	★	★	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	3	1P221-0800-XB	★	★	★	★	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	3	1P221-0900-XB	★	★	★	★	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	3	1P221-0970-XB	★	★	★	★	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	3	1P221-1000-XB	★	★	★	★	10.0	66.0
11.7	12	12.5	0.20	45°	12.5	3	1P221-1170-XB	★	★	★	★	12.0	73.0
12.0	12	12.5	0.20	45°	12.5	3	1P221-1200-XB	★	★	★	★	12.0	73.0
13.7	14	14.5	0.20	45°	14.5	3	1P221-1370-XB	★	★	★	★	14.0	75.0
14.0	14	14.5	0.20	45°	14.5	3	1P221-1400-XB	★	★	★	★	14.0	75.0
15.7	16	16.5	0.20	45°	16.5	3	1P221-1570-XB	★	★	★	★	16.0	82.0
16.0	16	16.5	0.20	45°	16.5	3	1P221-1600-XB	★	★	★	★	16.0	82.0
17.7	18	18.5	0.20	45°	18.5	3	1P221-1770-XB	★	★	★	★	18.0	84.0
18.0	18	18.5	0.20	45°	18.5	3	1P221-1800-XB	★	★	★	★	18.0	84.0
19.7	20	20.5	0.30	45°	20.5	3	1P221-1970-XB	★	★	★	★	20.0	92.0
20.0	20	20.5	0.30	45°	20.5	3	1P221-2000-XB	★	★	★	★	20.0	92.0



A176



A194



E9



E22



E14

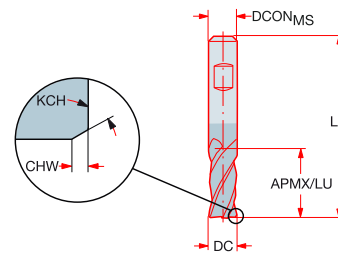
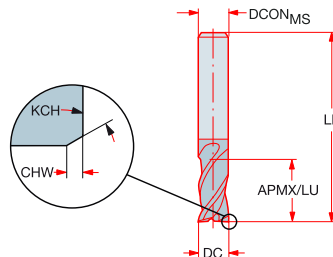
CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

1P222-XA
35°
DIN 6527 K
h10
h6

1P222-XB
35°
DIN 6527 K
h10
h6



Metrische Ausführung

											Abmessungen, mm	
							P	M	K	S		
							1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
2.0	6	4.5			4.5	4	1P222-0200-XB	*	*	*	6.0	50.0
	6	4.5			4.5	4	1P222-0200-XA	*	*	*	6.0	50.0
3.0	6	5.5	0.08	45°	5.0	4	1P222-0300-XB	*	*	*	6.0	50.0
	6	5.5	0.08	45°	5.5	4	1P222-0300-XA	*	*	*	6.0	50.0
4.0	6	8.5	0.13	45°	8.5	4	1P222-0400-XB	*	*	*	6.0	54.0
	6	8.5	0.13	45°	8.5	4	1P222-0400-XA	*	*	*	6.0	54.0
5.0	6	9.5	0.13	45°	9.5	4	1P222-0500-XB	*	*	*	6.0	54.0
	6	9.5	0.13	45°	9.5	4	1P222-0500-XA	*	*	*	6.0	54.0
6.0	6	10.5	0.13	45°	10.5	4	1P222-0600-XB	*	*	*	6.0	54.0
	6	10.5	0.13	45°	10.5	4	1P222-0600-XA	*	*	*	6.0	54.0
7.0	8	11.5	0.13	45°	11.5	4	1P222-0700-XA	*	*	*	8.0	58.0
8.0	8	12.5	0.13	45°	12.5	4	1P222-0800-XB	*	*	*	8.0	58.0
	8	12.5	0.13	45°	12.5	4	1P222-0800-XA	*	*	*	8.0	58.0
10.0	10	14.5	0.20	45°	14.5	4	1P222-1000-XB	*	*	*	10.0	66.0
	10	14.5	0.20	45°	14.5	4	1P222-1000-XA	*	*	*	10.0	66.0
12.0	12	16.5	0.20	45°	16.5	4	1P222-1200-XB	*	*	*	12.0	73.0
	12	16.5	0.20	45°	16.5	4	1P222-1200-XA	*	*	*	12.0	73.0
16.0	16	22.5	0.20	45°	22.5	4	1P222-1600-XB	*	*	*	16.0	82.0
	16	22.5	0.20	45°	22.5	4	1P222-1600-XA	*	*	*	16.0	82.0
20.0	20	26.5	0.30	45°	26.5	4	1P222-2000-XB	*	*	*	20.0	92.0
	20	26.5	0.30	45°	26.5	4	1P222-2000-XA	*	*	*	20.0	92.0
25.0	25	32.5	0.30	45°	32.5	4	1P222-2500-XA	*	*	*	25.0	121.0



A176



A194



E9



E22



E14

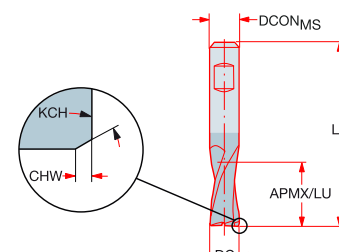
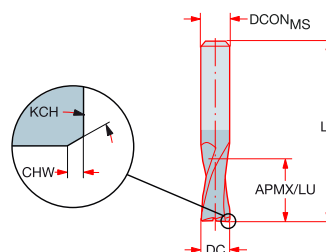
CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDCON

1P230-XA
30°
DIN 6527 L
h6

1P230-XB
30°
DIN 6527 L
h6



Metrische Ausführung

							P M K S				Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
1.0	3	4.5			4.5	2	1P230-0100-XA	*	*	*	3.0	38.0
1.5	3	4.5			4.5	2	1P230-0150-XA	*	*	*	3.0	38.0
2.0	6	6.5			6.5	2	1P230-0200-XB	*	*	*	6.0	57.0
	6	6.5			6.5	2	1P230-0200-XA	*	*	*	6.0	57.0
2.5	6	7.5	0.08	45°	7.5	2	1P230-0250-XB	*	*	*	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0250-XA	*	*	*	6.0	57.0
3.0	6	7.5	0.08	45°	7.5	2	1P230-0300-XB	*	*	*	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0300-XA	*	*	*	6.0	57.0
3.5	6	7.5	0.08	45°	7.5	2	1P230-0350-XB	*	*	*	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0350-XA	*	*	*	6.0	57.0
4.0	6	8.5	0.13	45°	8.5	2	1P230-0400-XB	*	*	*	6.0	57.0
	6	8.5	0.13	45°	8.5	2	1P230-0400-XA	*	*	*	6.0	57.0
4.5	6	8.5	0.13	45°	8.5	2	1P230-0450-XB	*	*	*	6.0	57.0
	6	8.5	0.13	45°	8.5	2	1P230-0450-XA	*	*	*	6.0	57.0
5.0	6	10.5	0.13	45°	10.5	2	1P230-0500-XB	*	*	*	6.0	57.0
	6	10.5	0.13	45°	10.5	2	1P230-0500-XA	*	*	*	6.0	57.0
6.0	6	10.5	0.13	45°	10.5	2	1P230-0600-XB	*	*	*	6.0	57.0
	6	10.5	0.13	45°	10.5	2	1P230-0600-XA	*	*	*	6.0	57.0
7.0	8	13.5	0.13	45°	13.5	2	1P230-0700-XB	*	*	*	8.0	63.0
	8	13.5	0.20	45°	13.5	2	1P230-0700-XA	*	*	*	8.0	63.0
8.0	8	16.5	0.20	45°	16.5	2	1P230-0800-XB	*	*	*	8.0	63.0
	8	16.5	0.20	45°	16.5	2	1P230-0800-XA	*	*	*	8.0	63.0
9.0	10	16.5	0.20	45°	16.5	2	1P230-0900-XB	*	*	*	10.0	72.0
	10	16.5	0.20	45°	16.5	2	1P230-0900-XA	*	*	*	10.0	72.0
10.0	10	19.5	0.20	45°	19.5	2	1P230-1000-XB	*	*	*	10.0	72.0
	10	19.5	0.20	45°	19.5	2	1P230-1000-XA	*	*	*	10.0	72.0
11.0	12	22.5	0.20	45°	22.5	2	1P230-1100-XB	*	*	*	12.0	83.0
	12	22.5	0.20	45°	22.5	2	1P230-1100-XA	*	*	*	12.0	83.0
12.0	12	22.5	0.20	45°	22.5	2	1P230-1200-XB	*	*	*	12.0	83.0
	12	22.5	0.20	45°	22.5	2	1P230-1200-XA	*	*	*	12.0	83.0
14.0	14	22.5	0.20	45°	22.5	2	1P230-1400-XB	*	*	*	14.0	83.0
	14	22.5	0.20	45°	22.5	2	1P230-1400-XA	*	*	*	14.0	83.0
16.0	16	26.5	0.20	45°	26.5	2	1P230-1600-XB	*	*	*	16.0	92.0
	16	26.5	0.20	45°	26.5	2	1P230-1600-XA	*	*	*	16.0	92.0
18.0	18	26.5	0.20	45°	26.5	2	1P230-1800-XB	*	*	*	18.0	92.0
	18	26.5	0.20	45°	26.5	2	1P230-1800-XA	*	*	*	18.0	92.0
20.0	20	32.5	0.30	45°	32.5	2	1P230-2000-XB	*	*	*	20.0	104.0
	20	32.5	0.30	45°	32.5	2	1P230-2000-XA	*	*	*	20.0	104.0



A176



A194



E9



E22



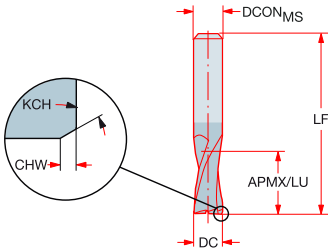
E14

A

CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA 30°
BSG DIN 6527 L
TCDCON h6



B



Zoll-Ausführung

								P	M	K	S	Abmessungen, Zoll	
								1630	1630	1630	1630	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer						
.125	1/8	.313	.003	45°	.313	2	1P230-0318-XA	★	★	★	★	.125	1.500
.188	3/16	.406	.005	45°	.406	2	1P230-0476-XA	★	★	★	★	.188	2.000
.250	1/4	.453	.005	45°	.453	2	1P230-0635-XA	★	★	★	★	.250	2.500
.375	3/8	.687	.008	45°	.687	2	1P230-0953-XA	★	★	★	★	.375	2.500
.500	1/2	.937	.008	45°	.937	2	1P230-1270-XA	★	★	★	★	.500	3.000
.625	5/8	1.125	.008	45°	1.125	2	1P230-1588-XA	★	★	★	★	.625	3.500
.750	3/4	1.219	.012	45°	1.219	2	1P230-1905-XA	★	★	★	★	.750	4.000
1.000	1	1.625	.012	45°	1.625	2	1P230-2540-XA	★	★	★	★	1.000	5.000

C

D

E

A176

A194

E9

E22

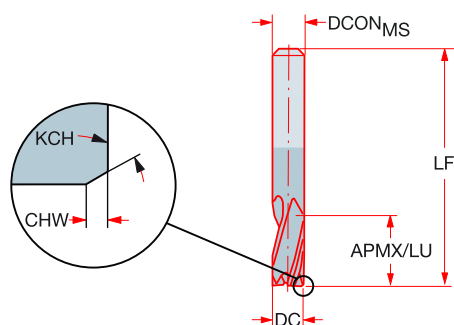
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

FHA
BSG
TCDCON

30°
DIN 6527 L
h6



Metrische Ausführung

											Abmessungen, mm	
							P	M	K	S		
							1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
1.0	3	4.5			4.5	3	1P231-0100-XA	*	*	*	3.0	38.0
1.5	3	4.5			4.5	3	1P231-0150-XA	*	*	*	3.0	38.0
2.0	6	6.5			6.5	3	1P231-0200-XA	*	*	*	6.0	57.0
2.5	6	7.5	0.08	45°	7.5	3	1P231-0250-XA	*	*	*	6.0	57.0
3.0	6	7.5	0.08	45°	7.5	3	1P231-0300-XA	*	*	*	6.0	57.0
3.5	6	7.5	0.08	45°	7.5	3	1P231-0350-XA	*	*	*	6.0	57.0
4.0	6	8.5	0.13	45°	8.5	3	1P231-0400-XA	*	*	*	6.0	57.0
4.5	6	8.5	0.13	45°	8.5	3	1P231-0450-XA	*	*	*	6.0	57.0
5.0	6	10.5	0.13	45°	10.5	3	1P231-0500-XA	*	*	*	6.0	57.0
5.5	6	10.5	0.13	45°	10.5	3	1P231-0550-XA	*	*	*	6.0	57.0
6.0	6	10.5	0.13	45°	10.5	3	1P231-0600-XA	*	*	*	6.0	57.0
6.5	8	13.5	0.13	45°	13.5	3	1P231-0650-XA	*	*	*	8.0	63.0
7.0	8	13.5	0.13	45°	13.5	3	1P231-0700-XA	*	*	*	8.0	63.0
7.5	8	16.5	0.13	45°	16.5	3	1P231-0750-XA	*	*	*	8.0	63.0
8.0	8	16.5	0.20	45°	16.5	3	1P231-0800-XA	*	*	*	8.0	63.0
9.0	10	16.5	0.20	45°	16.5	3	1P231-0900-XA	*	*	*	10.0	72.0
10.0	10	19.5	0.20	45°	19.5	3	1P231-1000-XA	*	*	*	10.0	72.0
11.0	12	22.5	0.20	45°	22.5	3	1P231-1100-XA	*	*	*	12.0	83.0
12.0	12	22.5	0.20	45°	22.5	3	1P231-1200-XA	*	*	*	12.0	83.0
13.0	14	22.5	0.20	45°	22.5	3	1P231-1300-XA	*	*	*	14.0	83.0
14.0	14	22.5	0.20	45°	22.5	3	1P231-1400-XA	*	*	*	14.0	83.0
15.0	16	26.5	0.20	45°	26.5	3	1P231-1500-XA	*	*	*	16.0	92.0
16.0	16	26.5	0.20	45°	26.5	3	1P231-1600-XA	*	*	*	16.0	92.0
18.0	18	26.5	0.20	45°	26.5	3	1P231-1800-XA	*	*	*	18.0	92.0
20.0	20	32.5	0.30	45°	32.5	3	1P231-2000-XA	*	*	*	20.0	104.0

Zoll-Ausführung

											Abmessungen, Zoll	
							P	M	K	S		
							1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
.125	1/8	.313	.003	45°	.313	3	1P231-0318-XA	*	*	*	.125	1.500
.188	3/16	.406	.005	45°	.406	3	1P231-0476-XA	*	*	*	.188	2.000
.250	1/4	.453	.005	45°	.453	3	1P231-0635-XA	*	*	*	.250	2.500
.375	3/8	.687	.008	45°	.687	3	1P231-0953-XA	*	*	*	.375	2.500
.500	1/2	.937	.008	45°	.937	3	1P231-1270-XA	*	*	*	.500	3.000
.625	5/8	1.125	.008	45°	1.125	3	1P231-1588-XA	*	*	*	.625	3.500
.750	3/4	1.219	.012	45°	1.219	3	1P231-1905-XA	*	*	*	.750	4.000
1.000	1	1.625	.012	45°	1.625	3	1P231-2540-XA	*	*	*	1.000	5.000



A176



A194



E9



E22



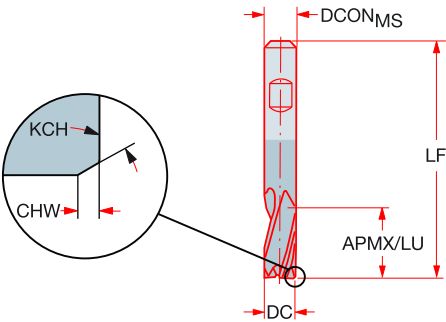
E14

A

CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDCON 30°
DIN 6527 L
h6



Metrische Ausführung

							Abmessungen, mm			
							P	M	K	S
							1630	1630	1630	1630
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	DC	LF	
4.5	6	8.5	0.13	45°	8.5	3	1P231-0450-XB	*	*	*
5.0	6	10.5	0.13	45°	10.5	3	1P231-0500-XB	*	*	*
5.5	6	10.5	0.13	45°	10.5	3	1P231-0550-XB	*	*	*
6.0	6	10.5	0.13	45°	10.5	3	1P231-0600-XB	*	*	*
6.5	8	13.5	0.13	45°	13.5	3	1P231-0650-XB	*	*	*
7.0	8	13.5	0.13	45°	13.5	3	1P231-0700-XB	*	*	*
7.5	8	16.5	0.13	45°	16.5	3	1P231-0750-XB	*	*	*
8.0	8	16.5	0.20	45°	16.5	3	1P231-0800-XB	*	*	*
9.0	10	16.5	0.20	45°	16.5	3	1P231-0900-XB	*	*	*
10.0	10	19.5	0.20	45°	19.5	3	1P231-1000-XB	*	*	*
11.0	12	22.5	0.20	45°	22.5	3	1P231-1100-XB	*	*	*
12.0	12	22.5	0.20	45°	22.5	3	1P231-1200-XB	*	*	*
13.0	14	22.5	0.20	45°	22.5	3	1P231-1300-XB	*	*	*
14.0	14	22.5	0.20	45°	22.5	3	1P231-1400-XB	*	*	*
15.0	16	26.5	0.20	45°	26.5	3	1P231-1500-XB	*	*	*
16.0	16	26.5	0.20	45°	26.5	3	1P231-1600-XB	*	*	*
18.0	18	26.5	0.20	45°	26.5	3	1P231-1800-XB	*	*	*
20.0	20	32.5	0.30	45°	32.5	3	1P231-2000-XB	*	*	*

C

D

E

A176

A194

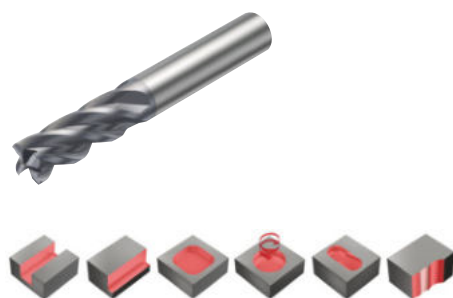
E9

E22

E14

CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

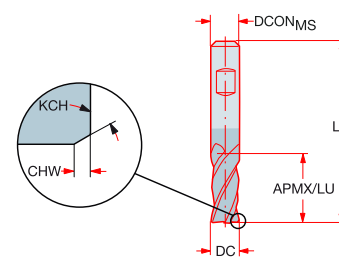
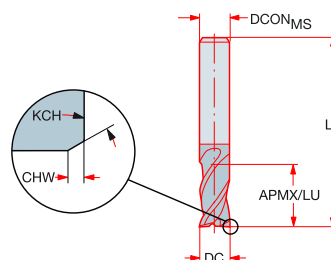
Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC



FHA
BSG
TCDC
TCDCON

1P240-XA
35°
DIN 6527 L
h10
h6

1P240-XB
35°
DIN 6527 L
h10
h6



Metrische Ausführung

											Abmessungen, mm	
							P	M	K	S		
							1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
2.0	6	7.5			7.5	4	1P240-0200-XA	*	*	*	6.0	57.0
3.0	6	8.5	0.08	45°	8.5	4	1P240-0300-XA	*	*	*	6.0	57.0
3.5	6	10.5	0.08	45°	10.5	4	1P240-0350-XA	*	*	*	6.0	57.0
4.0	6	11.5	0.13	45°	11.5	4	1P240-0400-XB	*	*	*	6.0	57.0
	6	11.5	0.13	45°	11.5	4	1P240-0400-XA	*	*	*	6.0	57.0
4.5	6	11.5	0.13	45°	11.5	4	1P240-0450-XB	*	*	*	6.0	57.0
	6	11.5	0.13	45°	11.5	4	1P240-0450-XA	*	*	*	6.0	57.0
5.0	6	13.5	0.13	45°	13.5	4	1P240-0500-XB	*	*	*	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0500-XA	*	*	*	6.0	57.0
5.5	6	13.5	0.13	45°	13.5	4	1P240-0550-XB	*	*	*	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0550-XA	*	*	*	6.0	57.0
6.0	6	13.5	0.13	45°	13.5	4	1P240-0600-XB	*	*	*	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0600-XA	*	*	*	6.0	57.0
6.5	8	16.5	0.13	45°	16.5	4	1P240-0650-XA	*	*	*	8.0	63.0
7.0	8	16.5	0.13	45°	16.5	4	1P240-0700-XB	*	*	*	8.0	63.0
	8	16.5	0.13	45°	16.5	4	1P240-0700-XA	*	*	*	8.0	63.0
8.0	8	19.5	0.13	45°	19.5	4	1P240-0800-XB	*	*	*	8.0	63.0
	8	19.5	0.13	45°	19.5	4	1P240-0800-XA	*	*	*	8.0	63.0
9.0	10	19.5	0.13	45°	19.5	4	1P240-0900-XA	*	*	*	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	4	1P240-1000-XB	*	*	*	10.0	72.0
	10	22.5	0.20	45°	22.5	4	1P240-1000-XA	*	*	*	10.0	72.0
12.0	12	26.5	0.20	45°	26.5	4	1P240-1200-XB	*	*	*	12.0	83.0
	12	26.5	0.20	45°	26.5	4	1P240-1200-XA	*	*	*	12.0	83.0
14.0	14	26.5	0.20	45°	26.5	4	1P240-1400-XB	*	*	*	14.0	83.0
	14	26.5	0.20	45°	26.5	4	1P240-1400-XA	*	*	*	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	4	1P240-1600-XB	*	*	*	16.0	92.0
	16	32.5	0.20	45°	32.5	4	1P240-1600-XA	*	*	*	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	4	1P240-1800-XB	*	*	*	18.0	92.0
	18	32.5	0.20	45°	32.5	4	1P240-1800-XA	*	*	*	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	4	1P240-2000-XB	*	*	*	20.0	104.0
	20	38.5	0.30	45°	38.5	4	1P240-2000-XA	*	*	*	20.0	104.0
25.0	25	45.5	0.30	45°	45.5	4	1P240-2500-XB	*	*	*	25.0	121.0
	25	45.5	0.30	45°	45.5	4	1P240-2500-XA	*	*	*	25.0	121.0

Zoll-Ausführung

											Abmessungen, Zoll	
							P	M	K	S		
							1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
.125	1/8	.359	.003	45°	.359	4	1P240-0318-XA	*	*	*	.125	1.500
.188	3/16	.547	.005	45°	.547	4	1P240-0476-XA	*	*	*	.188	2.000
.250	1/4	.562	.005	45°	.562	4	1P240-0635-XA	*	*	*	.250	2.500
.375	3/8	.844	.008	45°	.844	4	1P240-0953-XA	*	*	*	.375	3.000
.500	1/2	1.125	.008	45°	1.125	4	1P240-1270-XA	*	*	*	.500	3.500
.625	5/8	1.313	.008	45°	1.313	4	1P240-1588-XA	*	*	*	.625	4.000
.750	3/4	1.437	.012	45°	1.437	4	1P240-1905-XA	*	*	*	.750	4.000
1.000	1	1.828	.012	45°	1.828	4	1P240-2540-XA	*	*	*	1.000	5.000



A176



A194



E9



E22



E14

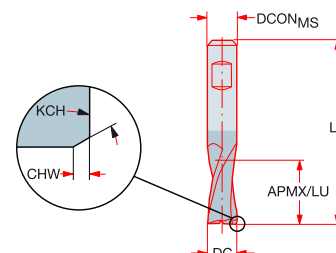
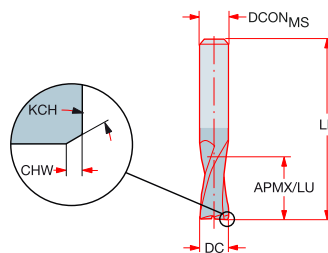
CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

FHA
BSG
TCDCON

1P250-XA
30°
COROMANT
h6

1P250-XB
30°
COROMANT
h6



Metrische Ausführung

											Abmessungen, mm	
							P	M	K	S		
							1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
2.0	6	8.5			8.5	2	1P250-0200-XA	*	*	*	6.0	57.0
2.5	6	12.5	0.08	45°	12.5	2	1P250-0250-XA	*	*	*	6.0	57.0
3.0	6	12.5	0.08	45°	12.5	2	1P250-0300-XA	*	*	*	6.0	57.0
4.0	6	14.5	0.13	45°	14.5	2	1P250-0400-XB	*	*	*	6.0	57.0
	6	14.5	0.13	45°	14.5	2	1P250-0400-XA	*	*	*	6.0	57.0
5.0	6	16.5	0.13	45°	16.5	2	1P250-0500-XB	*	*	*	6.0	57.0
	6	16.5	0.13	45°	16.5	2	1P250-0500-XA	*	*	*	6.0	57.0
6.0	6	19.5	0.13	45°	19.5	2	1P250-0600-XB	*	*	*	6.0	57.0
	6	19.5	0.13	45°	19.5	2	1P250-0600-XA	*	*	*	6.0	57.0
7.0	8	19.5	0.13	45°	19.5	2	1P250-0700-XA	*	*	*	8.0	63.0
8.0	8	19.5	0.20	45°	19.5	2	1P250-0800-XB	*	*	*	8.0	63.0
	8	19.5	0.20	45°	19.5	2	1P250-0800-XA	*	*	*	8.0	63.0
9.0	10	21.5	0.20	45°	21.5	2	1P250-0900-XB	*	*	*	10.0	72.0
	10	21.5	0.20	45°	21.5	2	1P250-0900-XA	*	*	*	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	2	1P250-1000-XB	*	*	*	10.0	72.0
	10	22.5	0.20	45°	22.5	2	1P250-1000-XA	*	*	*	10.0	72.0
12.0	12	25.5	0.20	45°	25.5	2	1P250-1200-XB	*	*	*	12.0	83.0
	12	25.5	0.20	45°	25.5	2	1P250-1200-XA	*	*	*	12.0	83.0
14.0	14	30.5	0.20	45°	30.5	2	1P250-1400-XA	*	*	*	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	2	1P250-1600-XB	*	*	*	16.0	92.0
	16	32.5	0.20	45°	32.5	2	1P250-1600-XA	*	*	*	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	2	1P250-1800-XB	*	*	*	18.0	92.0
	18	32.5	0.20	45°	32.5	2	1P250-1800-XA	*	*	*	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	2	1P250-2000-XB	*	*	*	20.0	104.0
	20	38.5	0.30	45°	38.5	2	1P250-2000-XA	*	*	*	20.0	104.0

Zoll-Ausführung

											Abmessungen, Zoll	
							P	M	K	S		
							1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				DCON _{MS}	LF
.125	1/8	.359	.003	45°	.359	2	1P250-0318-XA	*	*	*	.125	1.500
.188	3/16	.687	.005	45°	.687	2	1P250-0476-XA	*	*	*	.188	2.000
.250	1/4	.813	.005	45°	.813	2	1P250-0635-XA	*	*	*	.250	2.500
.375	3/8	.875	.008	45°	.875	2	1P250-0953-XA	*	*	*	.375	3.000
.500	1/2	1.188	.008	45°	1.188	2	1P250-1270-XA	*	*	*	.500	3.500
.625	5/8	1.484	.008	45°	1.484	2	1P250-1588-XA	*	*	*	.625	4.000
.750	3/4	1.687	.012	45°	1.687	2	1P250-1905-XA	*	*	*	.750	4.000
1.000	1	2.250	.012	45°	2.250	2	1P250-2540-XA	*	*	*	1.000	5.000



A176



A194



E9



E22



E14

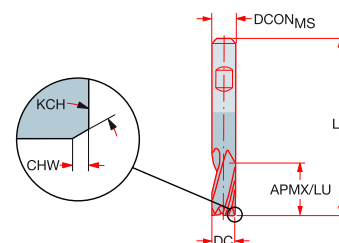
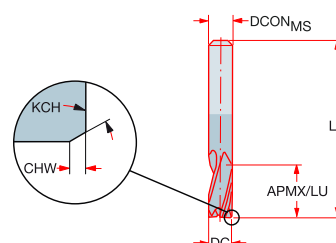
CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

FHA
BSG
TCDCON

1P251-XA
30°
COROMANT
h6

1P251-XB
30°
COROMANT
h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1630	1630	1630	1630	DCON _{MS}	LF
2.0	6	8.5			8.5	3	1P251-0200-XA	★	★	★	★	6.0	57.0
2.5	6	12.5	0.08	45°	12.5	3	1P251-0250-XA	★	★	★	★	6.0	57.0
3.0	6	12.5	0.08	45°	12.5	3	1P251-0300-XA	★	★	★	★	6.0	57.0
4.0	6	14.5	0.13	45°	14.5	3	1P251-0400-XB	★	★	★	★	6.0	57.0
	6	14.5	0.13	45°	14.5	3	1P251-0400-XA	★	★	★	★	6.0	57.0
5.0	6	16.5	0.13	45°	16.5	3	1P251-0500-XB	★	★	★	★	6.0	57.0
	6	16.5	0.13	45°	16.5	3	1P251-0500-XA	★	★	★	★	6.0	57.0
6.0	6	19.5	0.13	45°	19.5	3	1P251-0600-XB	★	★	★	★	6.0	57.0
	6	19.5	0.13	45°	19.5	3	1P251-0600-XA	★	★	★	★	6.0	57.0
7.0	8	19.5	0.13	45°	19.5	3	1P251-0700-XA	★	★	★	★	8.0	63.0
8.0	8	19.5	0.20	45°	19.5	3	1P251-0800-XB	★	★	★	★	8.0	63.0
	8	19.5	0.20	45°	19.5	3	1P251-0800-XA	★	★	★	★	8.0	63.0
9.0	10	21.5	0.20	45°	21.5	3	1P251-0900-XA	★	★	★	★	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	3	1P251-1000-XB	★	★	★	★	10.0	72.0
	10	22.5	0.20	45°	22.5	3	1P251-1000-XA	★	★	★	★	10.0	72.0
12.0	12	25.5	0.20	45°	25.5	3	1P251-1200-XB	★	★	★	★	12.0	83.0
	12	25.5	0.20	45°	25.5	3	1P251-1200-XA	★	★	★	★	12.0	83.0
14.0	14	30.5	0.20	45°	30.5	3	1P251-1400-XA	★	★	★	★	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	3	1P251-1600-XB	★	★	★	★	16.0	92.0
	16	32.5	0.20	45°	32.5	3	1P251-1600-XA	★	★	★	★	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	3	1P251-1800-XB	★	★	★	★	18.0	92.0
	18	32.5	0.20	45°	32.5	3	1P251-1800-XA	★	★	★	★	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	3	1P251-2000-XB	★	★	★	★	20.0	104.0
	20	38.5	0.30	45°	38.5	3	1P251-2000-XA	★	★	★	★	20.0	104.0



A176



A194



E9



E22



E14

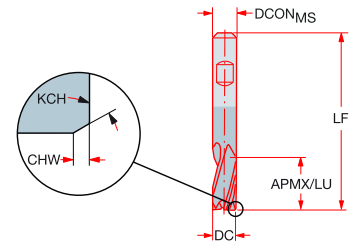
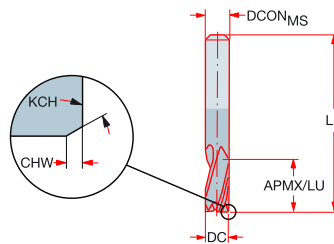
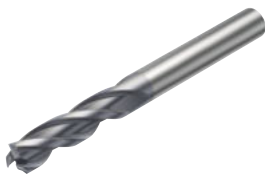
CoroMill® Plura Vollhartmetall-Schaftfräser für große Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

1P260-XA
30°
COROMANT
h10
h6

1P260-XB
30°
COROMANT
h10
h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	DCON _{MS}	LF
1.0	3	4.0			4.0	3	1P260-0100-XA	*	*	*	*	3.0	38.0
1.5	3	6.0			6.0	3	1P260-0150-XA	*	*	*	*	3.0	38.0
2.0	3	8.0			8.0	3	1P260-0200-XA	*	*	*	*	3.0	38.0
3.0	3	12.0			12.0	3	1P260-0300-XA	*	*	*	*	3.0	38.0
4.0	4	14.0			14.0	3	1P260-0400-XA	*	*	*	*	4.0	50.0
5.0	6	16.0			16.0	3	1P260-0500-XB	*	*	*	*	6.0	57.0
	6	16.0			16.0	3	1P260-0500-XA	*	*	*	*	6.0	57.0
6.0	6	22.0			22.0	3	1P260-0600-XB	*	*	*	*	6.0	65.0
	6	22.0			22.0	3	1P260-0600-XA	*	*	*	*	6.0	65.0
8.0	8	28.0			28.0	3	1P260-0800-XB	*	*	*	*	8.0	80.0
	8	28.0			28.0	3	1P260-0800-XA	*	*	*	*	8.0	80.0
10.0	10	32.0	0.10	45°	32.0	3	1P260-1000-XB	*	*	*	*	10.0	100.0
	10	32.0	0.10	45°	32.0	3	1P260-1000-XA	*	*	*	*	10.0	100.0
12.0	12	38.0	0.10	45°	38.0	3	1P260-1200-XB	*	*	*	*	12.0	100.0
	12	38.0	0.10	45°	38.0	3	1P260-1200-XA	*	*	*	*	12.0	100.0
16.0	16	50.0	0.15	45°	50.0	3	1P260-1600-XB	*	*	*	*	16.0	115.0
	16	50.0	0.15	45°	50.0	3	1P260-1600-XA	*	*	*	*	16.0	115.0
20.0	20	50.0	0.15	45°	50.0	3	1P260-2000-XB	*	*	*	*	20.0	125.0
	20	50.0	0.15	45°	50.0	3	1P260-2000-XA	*	*	*	*	20.0	125.0

Zoll-Ausführung

								P	M	K	S	Abmessungen, Zoll	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	DCON _{MS}	LF
.125	1/8	.500			.500	3	1P260-0318-XA	*	*	*	*	.125	2.000
.188	3/16	.625			.625	3	1P260-0476-XA	*	*	*	*	.188	2.000
.250	1/4	.937			.937	3	1P260-0635-XA	*	*	*	*	.250	2.500
.375	3/8	1.219	.004	45°	1.219	3	1P260-0953-XA	*	*	*	*	.375	3.000
.500	1/2	1.594	.004	45°	1.594	3	1P260-1270-XA	*	*	*	*	.500	3.500
.625	5/8	1.938	.006	45°	1.938	3	1P260-1588-XA	*	*	*	*	.625	4.000
.750	3/4	2.313	.006	45°	2.313	3	1P260-1905-XA	*	*	*	*	.750	5.000
1.000	1	2.500	.010	45°	2.500	3	1P260-2540-XA	*	*	*	*	1.000	6.000



A176



A194



E9



E22



E14

CoroMill® Plura Vollhartmetall-Schaftfräser für mittlere Eingriffsbreiten

Einsatzbereich

Wenn ein leichter Schnitt erforderlich ist

Für weiche Werkstoffe dank der optimierten, scharfen Geometrie

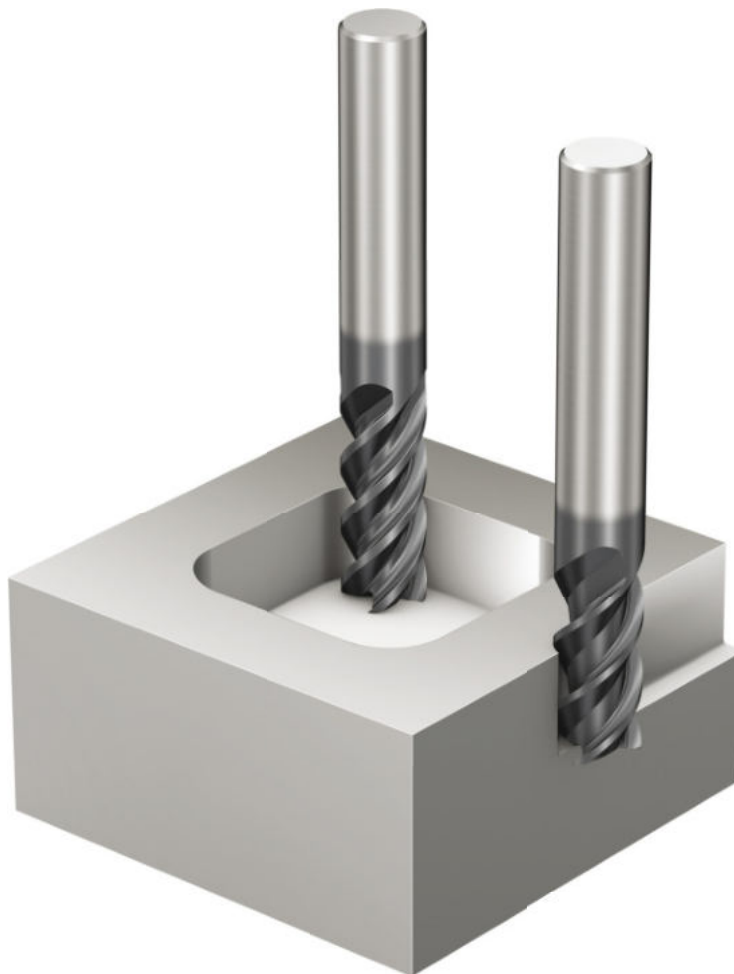
Problemlöser bei Schrägeintauch-Anwendungen

Vier Spankanäle - gut geeignet für Schlichtbearbeitungen

ISO-Werkstoff	P	M	K	S
Sorte	1620	1630		
Schaft	Weldon	Zylindrisch		

Produktbereich

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc



A

CoroMill® Plura Vollhartmetall-Schaftfräser für mittlere Eingriffsbreiten

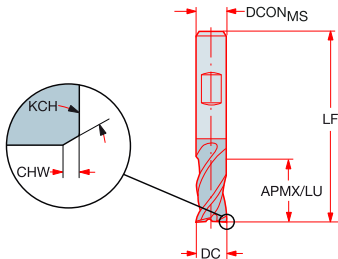
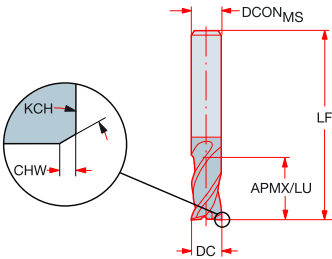
Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

FHA
BSG
TCDC
TCDCON

1P330-XA
45°
DIN 6527 L
h10
h6

1P330-XB
45°
DIN 6527 L
h10
h6

B



Metrische Ausführung

							Abmessungen, mm			
							P	M	K	S
							1620	1620	1620	1620
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	DCON _{MS}	LF	
2.0	6	6.0			6.0	3	1P330-0200-XB	*	*	*
	6	6.0			6.0	3	1P330-0200-XA	*	*	*
3.0	6	7.0			7.0	3	1P330-0300-XB	*	*	*
	6	7.0			7.0	3	1P330-0300-XA	*	*	*
4.0	6	8.0	0.10	45°	8.0	3	1P330-0400-XB	*	*	*
	6	8.0	0.10	45°	8.0	3	1P330-0400-XA	*	*	*
5.0	6	10.0	0.10	45°	10.0	3	1P330-0500-XB	*	*	*
	6	10.0	0.10	45°	10.0	3	1P330-0500-XA	*	*	*
6.0	6	10.0	0.10	45°	10.0	3	1P330-0600-XB	*	*	*
	6	10.0	0.10	45°	10.0	3	1P330-0600-XA	*	*	*
7.0	8	13.0	0.10	45°	13.0	3	1P330-0700-XA	*	*	*
8.0	8	16.0	0.10	45°	16.0	3	1P330-0800-XB	*	*	*
	8	16.0	0.10	45°	16.0	3	1P330-0800-XA	*	*	*
9.0	10	16.0	0.10	45°	16.0	3	1P330-0900-XB	*	*	*
	10	16.0	0.10	45°	16.0	3	1P330-0900-XA	*	*	*
10.0	10	19.0	0.10	45°	19.0	3	1P330-1000-XB	*	*	*
	10	19.0	0.10	45°	19.0	3	1P330-1000-XA	*	*	*
12.0	12	22.0	0.10	45°	22.0	3	1P330-1200-XB	*	*	*
	12	22.0	0.10	45°	22.0	3	1P330-1200-XA	*	*	*
14.0	14	22.0	0.15	45°	22.0	3	1P330-1400-XB	*	*	*
	14	22.0	0.15	45°	22.0	3	1P330-1400-XA	*	*	*
16.0	16	26.0	0.15	45°	26.0	3	1P330-1600-XB	*	*	*
	16	26.0	0.15	45°	26.0	3	1P330-1600-XA	*	*	*
18.0	18	26.0	0.15	45°	26.0	3	1P330-1800-XB	*	*	*
	18	26.0	0.15	45°	26.0	3	1P330-1800-XA	*	*	*
20.0	20	32.0	0.15	45°	32.0	3	1P330-2000-XB	*	*	*
	20	32.0	0.15	45°	32.0	3	1P330-2000-XA	*	*	*

C

D

E



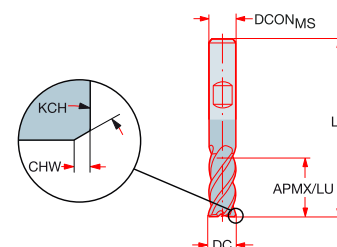
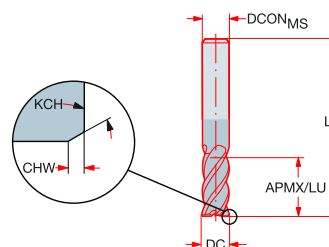
CoroMill® Plura Vollhartmetall-Schaftfräser für mittlere Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

1P341-XA
45°
DIN 6527 L
h10
h6

1P341-XB
45°
DIN 6527 L
h10
h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm			
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1630	1620	1630	1620	1630	DCON _{MS}	LF
2.0	6	7.0			7.0	4	1P341-0200-XA	★	★	★	★	★	★	6.0	57.0
3.0	6	8.0			8.0	4	1P341-0300-XA	★	★	★	★	★	★	6.0	57.0
4.0	6	11.0	0.10	45°	11.0	4	1P341-0400-XA	★	★	★	★	★	★	6.0	57.0
5.0	6	13.0	0.10	45°	13.0	4	1P341-0500-XA	★	★	★	★	★	★	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	4	1P341-0600-XB		★			★	★	6.0	57.0
	6	13.0	0.10	45°	13.0	4	1P341-0600-XA	★	★	★	★	★	★	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	4	1P341-0800-XB		★		★		★	8.0	63.0
	8	19.0	0.10	45°	19.0	4	1P341-0800-XA	★	★	★	★	★	★	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	4	1P341-1000-XB		★		★		★	10.0	72.0
	10	22.0	0.10	45°	22.0	4	1P341-1000-XA	★	★	★	★	★	★	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	4	1P341-1200-XB		★		★		★	12.0	83.0
	12	26.0	0.10	45°	26.0	4	1P341-1200-XA	★	★	★	★	★	★	12.0	83.0
14.0	14	26.0	0.15	45°	26.0	4	1P341-1400-XB		★		★		★	14.0	83.0
	14	26.0	0.15	45°	26.0	4	1P341-1400-XA	★	★	★	★	★	★	14.0	83.0
16.0	16	32.0	0.15	45°	32.0	4	1P341-1600-XB		★		★		★	16.0	92.0
	16	32.0	0.15	45°	32.0	4	1P341-1600-XA	★	★	★	★	★	★	16.0	92.0
18.0	18	32.0	0.15	45°	32.0	5	1P341-1800-XA	★	★	★	★	★	★	18.0	92.0
20.0	20	38.0	0.15	45°	38.0	5	1P341-2000-XB		★		★		★	20.0	104.0
	20	38.0	0.15	45°	38.0	5	1P341-2000-XA	★	★	★	★	★	★	20.0	104.0

Zoll-Ausführung

								P	M	K	S	Abmessungen, Zoll	
								1630	1630	1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer					DCON _{MS}	LF
.125	1/8	.313			.313	4	1P341-0318-XA	*	*	*	*	.125	1.500
.188	3/16	.469	.004	45°	.469	4	1P341-0476-XA	*	*	*	*	.188	2.000
.250	1/4	.531	.004	45°	.531	4	1P341-0635-XA	*	*	*	*	.250	2.500
.375	3/8	.844	.006	45°	.844	4	1P341-0953-XA	*	*	*	*	.375	3.000
.500	1/2	1.094	.006	45°	1.094	4	1P341-1270-XA	*	*	*	*	.500	3.500
.625	5/8	1.313	.010	45°	1.313	5	1P341-1588-XA	*	*	*	*	.625	4.000
.750	3/4	1.563	.010	45°	1.563	5	1P341-1905-XA	*	*	*	*	.750	4.000
1.000	1	2.094	.010	45°	2.094	5	1P341-2540-XA	*	*	*	*	1.000	5.000



A176



A194



E9



E22



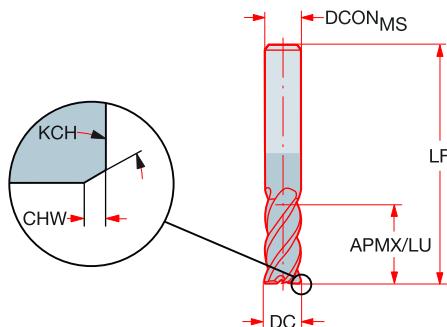
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für mittlere Eingriffsbreiten

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

45°
COROMANT
h10
h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	DCON _{MS}	LF
6.0	6	22.0	0.10	45°	22.0	4	1P360-0600-XA	★	★	★	★	6.0	65.0
8.0	8	28.0	0.10	45°	28.0	4	1P360-0800-XA	★	★	★	★	8.0	80.0
10.0	10	32.0	0.10	45°	32.0	4	1P360-1000-XA	★	★	★	★	10.0	100.0
12.0	12	40.0	0.10	45°	40.0	4	1P360-1200-XA	★	★	★	★	12.0	100.0
14.0	14	50.0	0.15	45°	50.0	4	1P360-1400-XA	★	★	★	★	14.0	104.0
16.0	16	50.0	0.15	45°	50.0	5	1P360-1600-XA	★	★	★	★	16.0	115.0
20.0	20	55.0	0.15	45°	55.0	5	1P360-2000-XA	★	★	★	★	20.0	125.0
	20	75.0	0.15	45°	75.0	6	1P370-2000-XA	★	★	★	★	20.0	145.0
25.0	25	90.0	0.15	45°	90.0	8	1P360-2500-XA	★	★	★	★	25.0	153.0

Zoll-Ausführung

								P	M	K	S	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	DCON _{MS}	LF	
.125	1/8	.500	.004	45°	.500	4	1P360-0318-XA	★	★	★	★	.125	2.000	
.188	3/16	.750	.004	45°	.750	4	1P360-0476-XA	★	★	★	★	.188	2.500	
.250	1/4	.875	.004	45°	.875	4	1P360-0635-XA	★	★	★	★	.250	2.500	
.375	3/8	1.219	.004	45°	1.219	4	1P360-0953-XA	★	★	★	★	.375	4.000	
.500	1/2	1.687	.006	45°	1.687	4	1P360-1270-XA	★	★	★	★	.500	4.000	
.625	5/8	2.000	.006	45°	2.000	5	1P360-1588-XA	★	★	★	★	.625	5.000	
.750	3/4	2.344	.006	45°	2.344	5	1P360-1905-XA	★	★	★	★	.750	5.000	
1.000	1	3.609	.010	45°	3.609	8	1P360-2540-XA	★	★	★	★	1.000	7.000	



A176



A194



E9



E22



E14

CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Einsatzbereich

Wenn eine kleine Spangröße erforderlich ist

Problemlöser bei instabilen Bearbeitungsbedingungen

ISO-Werkstoff



Sorte

1640

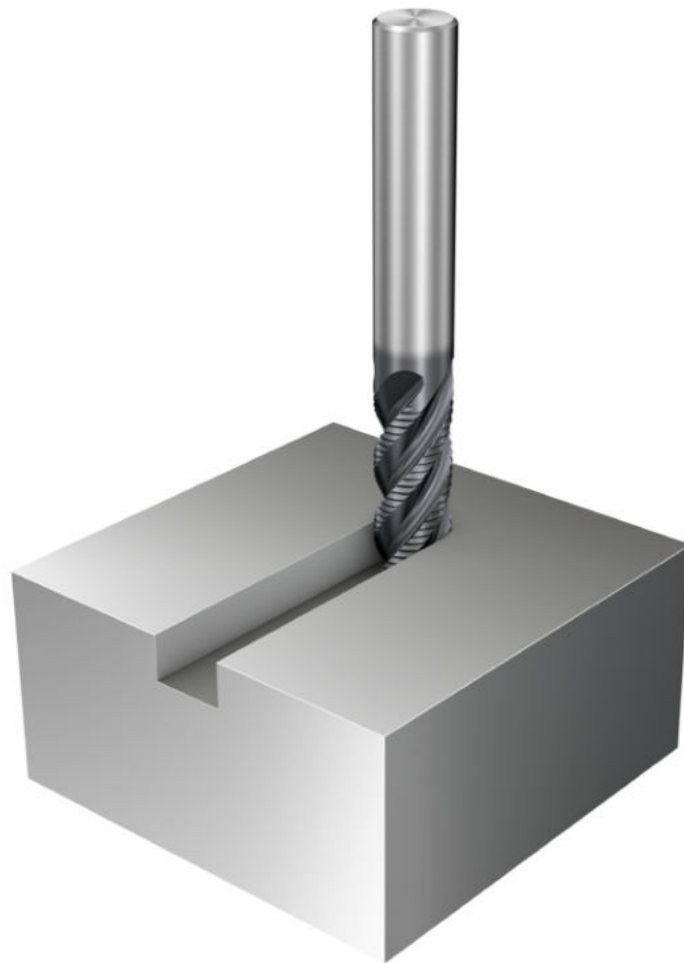
Schaft

Zylindrisch Weldon

Produktbereich

Für Stahl und rostfreien Stahl

Für ISO S-Werkstoffe

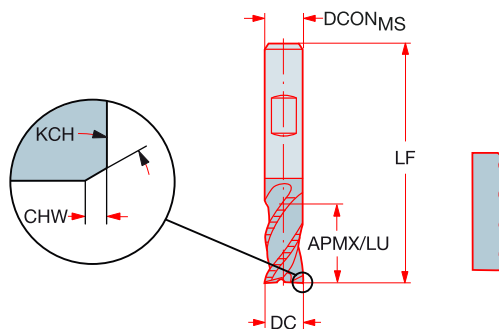


CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

37°
DIN 6527 L
h12
h6

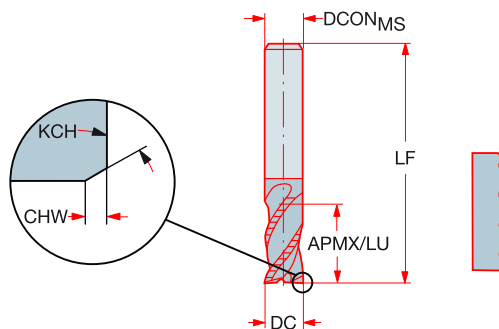


Metrische Ausführung

								P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1640	1640	1640	1640	DCON _{MS}	LF
6.0	6	13.0	0.50	55°	13.0	4	1P340-0600-XB	★	★	★	★	6.0	57.0
8.0	8	19.0	0.64	55°	19.0	4	1P340-0800-XB	★	★	★	★	8.0	63.0
10.0	10	22.0	0.71	55°	22.0	4	1P340-1000-XB	★	★	★	★	10.0	72.0
12.0	12	26.0	0.71	55°	26.0	4	1P340-1200-XB	★	★	★	★	12.0	83.0
14.0	14	26.0	0.71	55°	26.0	4	1P340-1400-XB	★	★	★	★	14.0	83.0
16.0	16	32.0	0.79	55°	32.0	4	1P340-1600-XB	★	★	★	★	16.0	92.0
18.0	18	32.0	0.71	55°	32.0	4	1P340-1800-XB	★	★	★	★	18.0	92.0
20.0	20	38.0	0.89	55°	38.0	4	1P340-2000-XB	★	★	★	★	20.0	104.0

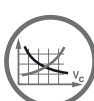
FHA
BSG
TCDC
TCDCON

37°
INTERNAL
h12
h6



Zoll-Ausführung

								P	M	K	S	Abmessungen, Zoll	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1640	1640	1640	1640	DCON _{MS}	LF
.250	1/4	.531	.020	55°	.531	4	1P340-0635-XA	★	★	★	★	.250	2.500
.375	3/8	.844	.026	55°	.844	4	1P340-0953-XA	★	★	★	★	.375	3.000
.500	1/2	1.094	.028	55°	1.094	4	1P340-1270-XA	★	★	★	★	.500	3.500
.625	5/8	1.313	.028	55°	1.313	4	1P340-1588-XA	★	★	★	★	.625	4.000
.750	3/4	1.563	.031	55°	1.563	4	1P340-1905-XA	★	★	★	★	.750	4.000
1.000	1	2.094	.044	55°	2.094	4	1P340-2540-XA	★	★	★	★	1.000	5.000



A176



A194



E9



E22



E14

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung

Einsatzbereich

Profilbearbeitungen in unterschiedlichen Formen: Wählen Sie einfach die richtige Sorte und Form für Ihre Operation

ISO-Werkstoff	P	M	K	S
Sorte	1630	1620		
Schaft	Zylindrisch			

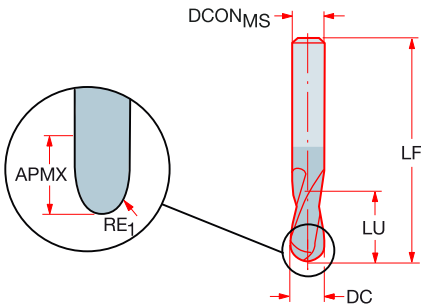


A

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilarbeit

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA 30°
BSG COROMANT
TCDC h7
TCDCON h5
PSIR 0°



Metrische Ausführung

							P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer	1630	1630	1630		DCON _{MS}	LF
1.0	3	3.0	0.50	3.0	2	1B230-0100-XA	*	*	*	*	3.0	38.0
1.5	3	3.0	0.75	3.0	2	1B230-0150-XA	*	*	*	*	3.0	38.0
2.0	3	6.0	1.00	6.0	2	1B230-0200-XA	*	*	*	*	3.0	38.0
2.5	3	7.0	1.25	7.0	2	1B230-0250-XA	*	*	*	*	3.0	38.0
3.0	3	7.0	1.50	7.0	2	1B230-0300-XA	*	*	*	*	3.0	38.0
4.0	6	8.0	2.00	8.0	2	1B230-0400-XA	*	*	*	*	6.0	57.0
5.0	6	10.0	2.50	10.0	2	1B230-0500-XA	*	*	*	*	6.0	57.0
6.0	6	10.0	3.00	10.0	2	1B230-0600-XA	*	*	*	*	6.0	57.0
7.0	8	13.0	3.50	13.0	2	1B230-0700-XA	*	*	*	*	8.0	63.0
8.0	8	16.0	4.00	16.0	2	1B230-0800-XA	*	*	*	*	8.0	63.0
9.0	10	16.0	4.50	16.0	2	1B230-0900-XA	*	*	*	*	10.0	72.0
10.0	10	19.0	5.00	19.0	2	1B230-1000-XA	*	*	*	*	10.0	72.0
12.0	12	22.0	6.00	22.0	2	1B230-1200-XA	*	*	*	*	12.0	83.0
14.0	14	22.0	7.00	22.0	2	1B230-1400-XA	*	*	*	*	14.0	83.0
16.0	16	26.0	8.00	26.0	2	1B230-1600-XA	*	*	*	*	16.0	92.0
18.0	18	26.0	9.00	26.0	2	1B230-1800-XA	*	*	*	*	18.0	92.0
20.0	20	32.0	10.00	32.0	2	1B230-2000-XA	*	*	*	*	20.0	104.0

C

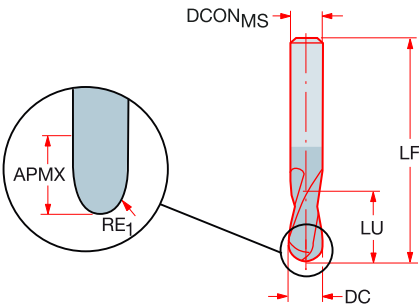
D

E

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilarbeit

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6
PSIR 0°



Zoll-Ausführung

							P	M	K	S	Abmessungen, Zoll	
							1620	1620	1620	1620	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer						
.063	1/4	.125	.031	.125	2	1B231-0159-XA	*	*	*	*	.250	3.000
	1/4	.125	.031	.125	2	1B232-0159-XA	*	*	*	*	.250	2.000
.094	1/4	.188	.047	.188	2	1B231-0238-XA	*	*	*	*	.250	3.000
	1/4	.188	.047	.188	2	1B232-0238-XA	*	*	*	*	.250	2.000
.125	1/4	.250	.063	.250	2	1B231-0318-XA	*	*	*	*	.250	3.000
	1/4	.250	.063	.250	2	1B232-0318-XA	*	*	*	*	.250	2.000
.156	1/4	.313	.078	.313	2	1B231-0397-XA	*	*	*	*	.250	3.000
	1/4	.313	.078	.313	2	1B232-0397-XA	*	*	*	*	.250	2.000
.187	1/4	.375	.094	.375	2	1B231-0476-XA	*	*	*	*	.250	3.000
	1/4	.375	.094	.375	2	1B232-0476-XA	*	*	*	*	.250	2.000
.250	1/4	.500	.125	.500	2	1B231-0635-XA	*	*	*	*	.250	3.000
	1/4	.500	.125	.500	2	1B232-0635-XA	*	*	*	*	.250	2.000
.313	3/8	.625	.156	.625	2	1B231-0794-XA	*	*	*	*	.375	3.500
	3/8	.625	.156	.625	2	1B232-0794-XA	*	*	*	*	.375	2.500
.375	3/8	.750	.188	.750	2	1B231-0953-XA	*	*	*	*	.375	3.500
	3/8	.750	.188	.750	2	1B232-0953-XA	*	*	*	*	.375	2.500
.500	1/2	1.000	.250	1.000	2	1B231-1270-XA	*	*	*	*	.500	4.000
	1/2	1.000	.250	1.000	2	1B232-1270-XA	*	*	*	*	.500	3.000
.625	5/8	1.250	.313	1.250	2	1B232-1588-XA	*	*	*	*	.625	3.500
.750	3/4	1.500	.375	1.500	2	1B232-1905-XA	*	*	*	*	.750	4.000

B

C

D

E

A177

A194

E9

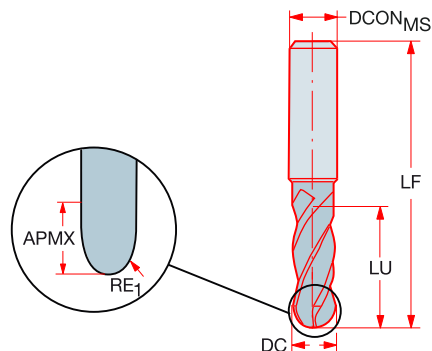
E22

E14

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA 30°
BSG COROMANT
TCDC h8
TCDCON h6
PSIR 0°

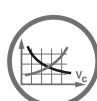


Metrische Ausführung

							P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer	1630	1630	1630	1630	DCON _{MS}	LF
3.0	6	8.0	1.50	8.0	4	1B240-0300-XA	★	★	★	★	6.0	80.0
4.0	6	11.0	2.00	11.0	4	1B240-0400-XA	★	★	★	★	6.0	80.0
5.0	6	13.0	2.50	13.0	4	1B240-0500-XA	★	★	★	★	6.0	80.0
6.0	6	13.0	3.00	13.0	4	1B240-0600-XA	★	★	★	★	6.0	80.0
7.0	8	16.0	3.50	16.0	4	1B240-0700-XA	★	★	★	★	8.0	100.0
8.0	8	19.0	4.00	19.0	4	1B240-0800-XA	★	★	★	★	8.0	100.0
10.0	10	22.0	5.00	22.0	4	1B240-1000-XA	★	★	★	★	10.0	100.0
12.0	12	26.0	6.00	26.0	4	1B240-1200-XA	★	★	★	★	12.0	100.0
16.0	16	32.0	8.00	32.0	4	1B240-1600-XA	★	★	★	★	16.0	100.0
20.0	20	38.0	10.00	38.0	4	1B240-2000-XA	★	★	★	★	20.0	125.0

Zoll-Ausführung

							P	M	K	S	Abmessungen, Zoll	
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer	1630	1630	1630	1630	DCON _{MS}	LF
.063	1/4	.125	.031	.125	4	1B240-0159-XA	★	★	★	★	.250	3.000
.094	1/4	.188	.047	.188	4	1B240-0238-XA	★	★	★	★	.250	3.000
.125	1/4	.250	.063	.250	4	1B240-0318-XA	★	★	★	★	.250	3.000
.156	1/4	.313	.078	.313	4	1B240-0397-XA	★	★	★	★	.250	3.000
.187	1/4	.375	.094	.375	4	1B240-0476-XA	★	★	★	★	.250	3.000
.250	1/4	.500	.125	.500	4	1B240-0635-XA	★	★	★	★	.250	3.000
.313	3/8	.625	.156	.625	4	1B240-0794-XA	★	★	★	★	.375	3.500
.375	3/8	.750	.188	.750	4	1B240-0953-XA	★	★	★	★	.375	3.500
.500	1/2	1.000	.250	1.000	4	1B240-1270-XA	★	★	★	★	.500	4.000



A177



A194



E9



E22



E14

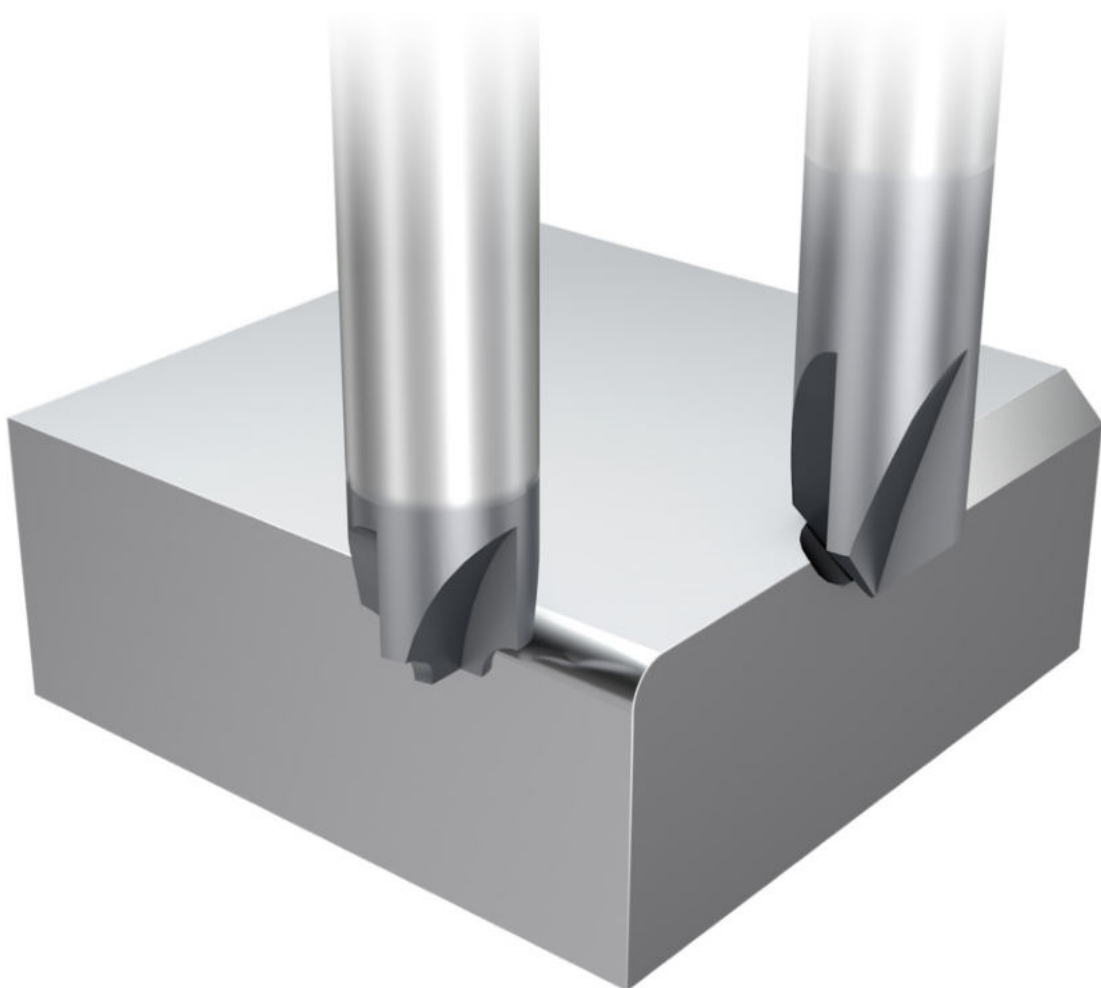
CoroMill® Plura Vollhartmetall-Schaftfräser für das Fasfräsen

Einsatzbereich

Fasfräsen mit ein und demselben Werkzeug in unterschiedlichen Werkstoffen

45° und 60° Faswinkel

ISO-Werkstoff	P	M	K	S	H
Sorte	1620				
Schaft	Zylindrisch Weldon				



A

CoroMill® Plura Vollhartmetall-Schaftfräser für das Fasfräsen

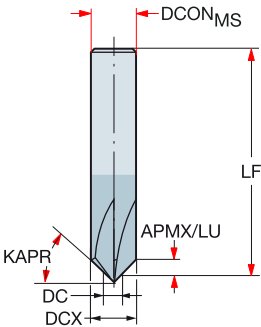
Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

B

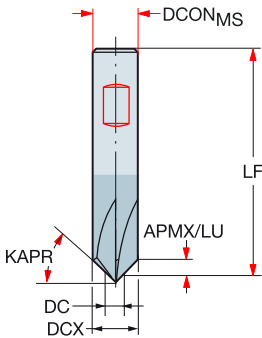


BSG
TCDCON

1C050-XA
COROMANT
h6



1C050-XB
COROMANT
h6



Metrische Ausführung

						P	M	K	S	H	Abmessungen, mm			
					Bestellnummer	1620	1620	1620	1620	1620	DCON _{MS}	DC	DCX	LF
KAPR	CZC _{MS}	APMX	LU	ZEFP										
45°	10.0	4.25	4.25	4	1C050-0150-045-XB	★	★	★	★	★	10.00	1.50	10.0	99.20
45°	12.0	4.50	4.50	6	1C050-0300-045-XB	★	★	★	★	★	12.00	3.00	12.0	81.50
45°	6.0	2.50	2.50	4	1C050-0100-045-XA	★	★	★	★	★	6.00	1.00	6.0	56.50
45°	8.0	3.00	3.00	5	1C050-0200-045-XA	★	★	★	★	★	8.00	2.00	8.0	79.00
45°	10.0	4.25	4.25	4	1C050-0150-045-XA	★	★	★	★	★	10.00	1.50	10.0	99.20
45°	12.0	4.50	4.50	6	1C050-0300-045-XA	★	★	★	★	★	12.00	3.00	12.0	81.50
60°	10.0	7.35	7.35	4	1C050-0150-060-XB	★	★	★	★	★	10.00	1.50	10.0	98.70
60°		7.35	7.35	4	1C050-0150-060-XA	★	★	★	★	★	10.00	1.50	10.0	98.70

C

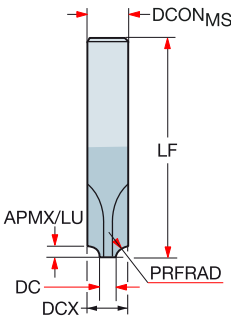
D

E

CoroMill® Plura Vollhartmetall-Schaftfräser für das Fasfräsen

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

BSG
TCDCON COROMANT
h6



Metrische Ausführung

						P	M	K	S	H	Abmessungen, mm			
PRFRAD	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	1620	DCON _{MS}	DC	DCX	LF
0.5	6.0	0.50	0.50	3	1U000-0400-050-XA	★	★	★	★	★	6.00	4.00	6.0	57.00
0.8		0.75	0.75	3	1U000-0400-075-XA	★	★	★	★	★	6.00	4.00	6.0	57.00
1.0	8.0	1.00	1.00	4	1U000-0400-100-XA	★	★	★	★	★	8.00	4.00	8.0	63.00
1.5		1.50	1.50	4	1U000-0400-150-XA	★	★	★	★	★	8.00	4.00	8.0	63.00
2.0	10.0	2.00	2.00	4	1U000-0500-200-XA	★	★	★	★	★	10.00	5.00	10.0	72.00
2.5		2.50	2.50	4	1U000-0500-250-XA	★	★	★	★	★	10.00	5.00	10.0	72.00
3.0	12.0	3.00	3.00	4	1U000-0500-300-XA	★	★	★	★	★	12.00	5.00	12.0	83.00
4.0	14.0	4.00	4.00	4	1U000-0600-400-XA	★	★	★	★	★	14.00	6.00	14.0	83.00
5.0	16.0	5.00	5.00	4	1U000-0600-500-XA	★	★	★	★	★	16.00	6.00	16.0	92.00
6.0	20.0	6.00	6.00	4	1U000-0800-600-XA	★	★	★	★	★	20.00	8.00	20.0	104.00

Zoll-Ausführung

						P	M	K	S	H	Abmessungen, Zoll			
PRFRAD	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	1620	DCON _{MS}	DC	DCX	LF
.031	1/8	.031	.031	2	1U000-0119-079-XA	★	★	★	★	★	.125	.047	.125	1.500
.062	1/4	.062	.062	3	1U000-0160-158-XA	★	★	★	★	★	.250	.063	.250	2.000
.094	3/8	.094	.094	3	1U000-0160-238-XA	★	★	★	★	★	.375	.063	.313	2.500
.125	1/2	.125	.125	4	1U000-0630-318-XA	★	★	★	★	★	.500	.248	.500	3.000
.188	5/8	.188	.188	4	1U000-0630-476-XA	★	★	★	★	★	.625	.248	.625	3.500

CoroMill® Plura - Optimiert

Leistungsstarke Schaftfräser für spezifische Werkstoffe und Anwendungen

Optimierte Werkzeuge mit Geometrien und Sorten für spezifische Werkstoffe und Anwendungen zur Maximierung des Zeitspanvolumens.



Anwendungsbereich

- Heavy Duty Fräsbearbeitung
- High Feed Sidemilling
- Stabiles Fräsen für verschiedene Anwendungen
- Hohe Spanabfuhr
- Hartfräsen
- Fräsen von Verbundwerkstoffen
- Schlichten
- Mikrofräsen
- Planfräsen mit hohen Vorschüben
- Profilfräsen
- Schruppen mit Spanbrecher
- Drehfräsen
- Gewindefräsen



ISO-Anwendungsbereich:



Für die meisten Bauteile, bei denen eine hohe Qualität gefordert wird, sowie bei schwierigen Anwendungen benötigen Sie Werkzeuge von höchster Qualität. Wenn enge Toleranzen und effiziente Zerspanung Priorität haben, ist ein Vollhartmetall-Schaftfräser die richtige Wahl.

www.sandvik.coromant.com/coromillplura

Produktangebot

- Die perfekte Kombination aus einer speziellen, hochwertigen Sorte und ausgereifter Schneidengeometrie für einen spezifischen Werkstoff und eine spezifische Anwendung
- Zylindrische und Weldon-Schäfte
- Gerade und konische Kugelschaftwerkzeuge
- Schruppwerkzeuge mit und ohne Spanteilungsgeometrie
- Mit und ohne Freistich, verkürzte Schäfte erhältlich
- Werkzeuge mit innerer Kühlschmierstoffzufuhr
- Kann bis zu dreimal gemäß Original-Spezifikationen nachgeschliffen werden



CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Einsatzbereich

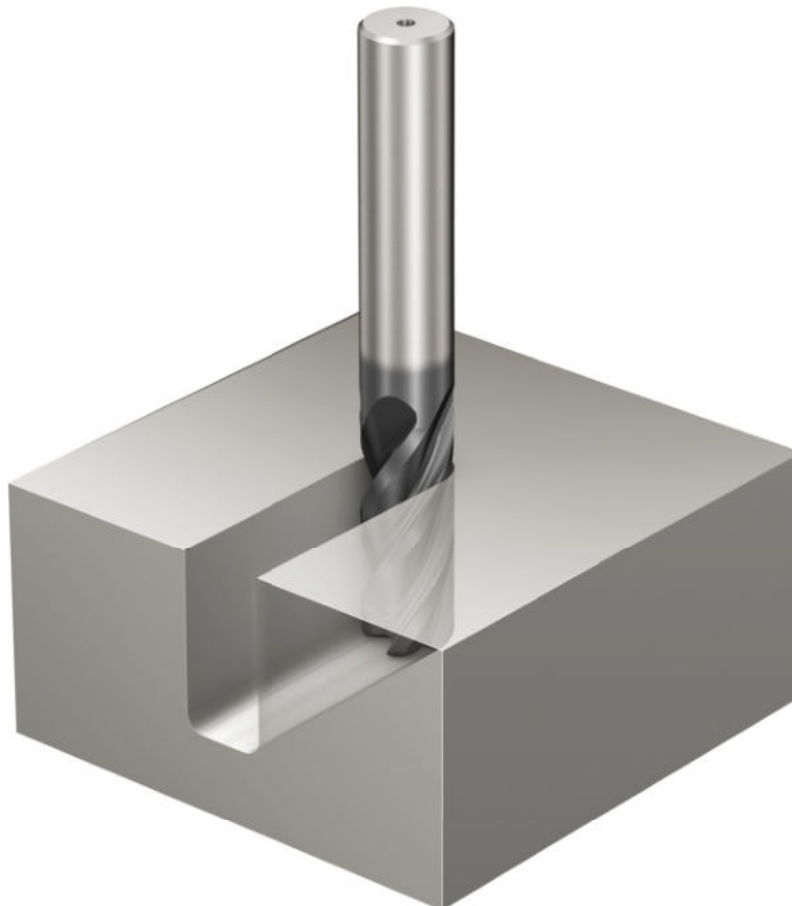
Erste Wahl für höchste Produktivität zum Schrappen in Stahl und rostfreiem Stahl

2×D Vollnutfräsen und exzellente Schrägeintauch-Eigenschaften

ISO-Werkstoff	P	K	M	S
Sorte	1730	1740		
Schaft	Zylindrisch	Weldon		

Produktbereich

Für Stahl und rostfreien Stahl

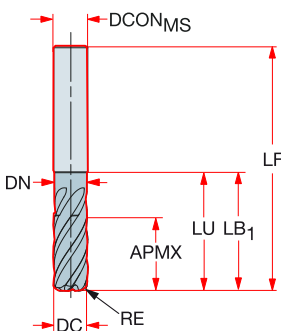


CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für Stahl

FHA
BSG
TCDC
TCDCON

38°
COROMANT
h10
h6

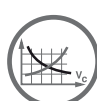


Metrische Ausführung

							P	K	Abmessungen, mm			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS}	LF	DN	LB ₁
6.0	6	13.0	0.50	20.0	5	2F342-0600-050-PC	★	☆	6.0	57.0	5.7	20.0
	6	13.0	1.00	20.0	5	2F342-0600-100-PC	★	☆	6.0	57.0	5.7	20.0
8.0	8	18.0	0.50	25.0	5	2F342-0800-050-PC	★	☆	8.0	63.0	7.6	25.0
	8	18.0	1.00	25.0	5	2F342-0800-100-PC	★	☆	8.0	63.0	7.6	25.0
	8	18.0	2.00	25.0	5	2F342-0800-200-PC	★	☆	8.0	63.0	7.6	25.0
10.0	10	22.0	0.50	30.0	5	2F342-1000-050-PC	★	☆	10.0	72.0	9.5	30.0
	10	22.0	1.00	30.0	5	2F342-1000-100-PC	★	☆	10.0	72.0	9.5	30.0
	10	22.0	2.00	30.0	5	2F342-1000-200-PC	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.50	36.0	5	2F342-1200-050-PC	★	☆	12.0	83.0	11.4	36.0
	12	26.0	1.00	36.0	5	2F342-1200-100-PC	★	☆	12.0	83.0	11.4	36.0
	12	26.0	2.00	36.0	5	2F342-1200-200-PC	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.50	42.0	5	2F342-1600-050-PC	★	☆	16.0	92.0	15.2	42.0
	16	34.0	1.00	42.0	5	2F342-1600-100-PC	★	☆	16.0	92.0	15.2	42.0
	16	34.0	2.00	42.0	5	2F342-1600-200-PC	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	1.00	52.0	5	2F342-2000-100-PC	★	☆	20.0	104.0	19.0	52.0
	20	42.0	2.00	52.0	5	2F342-2000-200-PC	★	☆	20.0	104.0	19.0	52.0

Zoll-Ausführung

						P	K	Abmessungen, Zoll				
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS}	LF	DN	LB ₁
.250	1/4	.626	.015	.937	5	2F342-0635-038-PC	★	☆	.250	2.500	.237	.937
	1/4	.626	.030	.937	5	2F342-0635-076-PC	★	☆	.250	2.500	.237	.937
.313	5/16	.752	.015	1.063	5	2F342-0794-038-PC	★	☆	.313	2.500	.297	1.063
	5/16	.752	.030	1.063	5	2F342-0794-076-PC	★	☆	.313	2.500	.297	1.063
.375	3/8	.878	.015	1.250	5	2F342-0953-038-PC	★	☆	.375	3.000	.356	1.250
	3/8	.878	.030	1.250	5	2F342-0953-076-PC	★	☆	.375	3.000	.356	1.250
.438	7/16	1.000	.015	1.438	5	2F342-1111-038-PC	★	☆	.438	3.500	.416	1.438
	7/16	1.000	.030	1.437	5	2F342-1111-076-PC	★	☆	.438	3.500	.416	1.438
.500	1/2	1.126	.015	1.438	5	2F342-1270-038-PC	★	☆	.500	3.500	.475	1.438
	1/2	1.126	.030	1.438	5	2F342-1270-076-PC	★	☆	.500	3.500	.475	1.438
	1/2	1.126	.060	1.438	5	2F342-1270-152-PC	★	☆	.500	3.500	.475	1.438
.625	5/8	1.315	.030	1.625	5	2F342-1588-076-PC	★	☆	.625	3.500	.594	1.626
	5/8	1.315	.060	1.625	5	2F342-1588-152-PC	★	☆	.625	3.500	.594	1.626
.750	3/4	1.626	.030	1.937	5	2F342-1905-076-PC	★	☆	.750	4.000	.713	1.937
	3/4	1.626	.060	1.937	5	2F342-1905-152-PC	★	☆	.750	4.000	.713	1.937



A179



A194



E9



E22

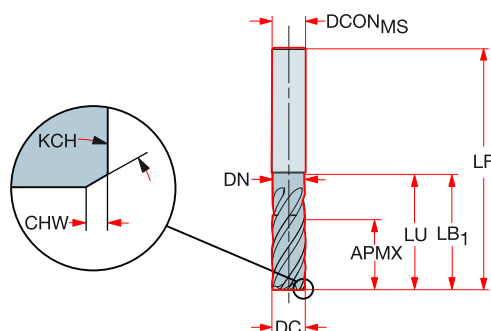


E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für Stahl

FHA 38°
 BSG COROMANT
 TCDC h10
 TCDCON h6



Metrische Ausführung

								P	K	Abmessungen, mm			
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS}	LF	DN	LB ₁
6.0	6	13.0	0.10	45°	20.0	5	2N342-0600-PC	★	☆	6.0	57.0	5.7	20.0
8.0	8	18.0	0.15	45°	25.0	5	2N342-0800-PC	★	☆	8.0	63.0	7.6	25.0
10.0	10	22.0	0.15	45°	30.0	5	2N342-1000-PC	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.15	45°	36.0	5	2N342-1200-PC	★	☆	12.0	83.0	11.4	36.0
14.0	14	30.0	0.15	45°	38.0	5	2N342-1400-PC	★	☆	14.0	83.0	13.3	38.0
16.0	16	34.0	0.25	45°	42.0	5	2N342-1600-PC	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	0.25	45°	52.0	5	2N342-2000-PC	★	☆	20.0	104.0	19.0	52.0
25.0	25	52.0	0.25	45°	63.0	5	2N342-2500-PC	★	☆	25.0	121.0	24.0	63.0

Zoll-Ausführung

								P	K	Abmessungen, Zoll			
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS}	LF	DN	LB ₁
6.4	1/4	15.9	0.10	45°	23.8	5	2N342-0635-PC	★	☆	6.4	63.5	6.0	23.8
7.9	5/16	19.1	0.10	45°	27.0	5	2N342-0794-PC	★	☆	7.9	63.5	7.6	27.0
9.5	3/8	22.3	0.15	45°	31.8	5	2N342-0953-PC	★	☆	9.5	76.2	9.0	31.8
12.7	1/2	28.6	0.15	45°	36.5	5	2N342-1270-PC	★	☆	12.7	88.9	12.1	36.5
15.9	5/8	33.4	0.25	45°	41.3	5	2N342-1588-PC	★	☆	15.9	88.9	15.1	41.3
19.1	3/4	41.3	0.25	45°	49.2	5	2N342-1905-PC	★	☆	19.1	101.6	18.1	49.2



A179



A194



E9



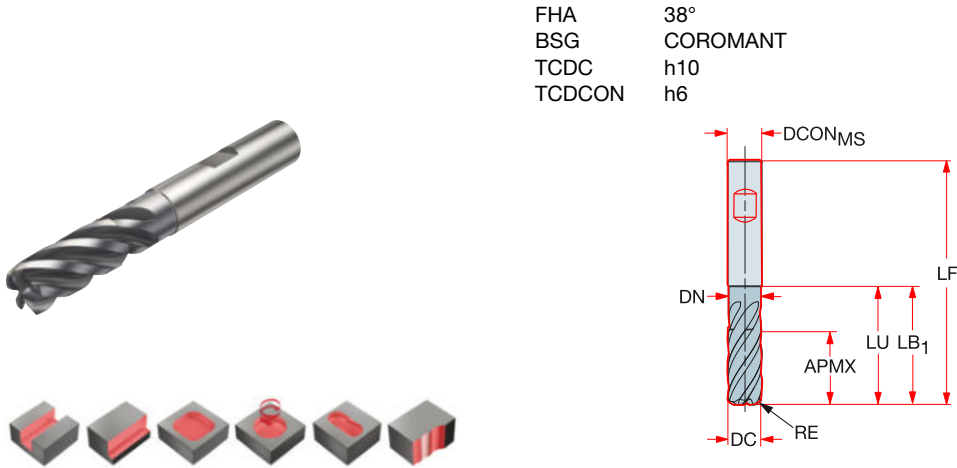
E22



E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für Stahl



Metrische Ausführung

							P	K	Abmessungen, mm			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS}	LF	DN	LB ₁
10.0	10	22.0	0.50	30.0	5	2F342-1000-050-PD	★	☆	10.0	72.0	9.5	30.0
	10	22.0	1.00	30.0	5	2F342-1000-100-PD	★	☆	10.0	72.0	9.5	30.0
	10	22.0	2.00	30.0	5	2F342-1000-200-PD	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.50	36.0	5	2F342-1200-050-PD	★	☆	12.0	83.0	11.4	36.0
	12	26.0	1.00	36.0	5	2F342-1200-100-PD	★	☆	12.0	83.0	11.4	36.0
	12	26.0	2.00	36.0	5	2F342-1200-200-PD	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.50	42.0	5	2F342-1600-050-PD	★	☆	16.0	92.0	15.2	42.0
	16	34.0	1.00	42.0	5	2F342-1600-100-PD	★	☆	16.0	92.0	15.2	42.0
	16	34.0	2.00	42.0	5	2F342-1600-200-PD	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	1.00	52.0	5	2F342-2000-100-PD	★	☆	20.0	104.0	19.0	52.0
	20	42.0	2.00	52.0	5	2F342-2000-200-PD	★	☆	20.0	104.0	19.0	52.0

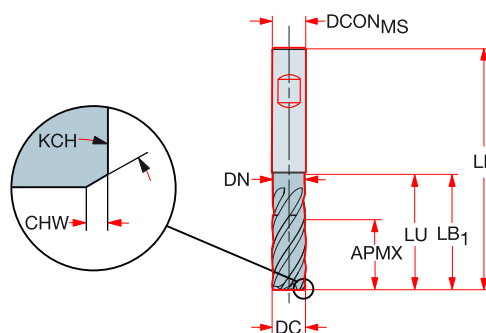
Zoll-Ausführung

						P	K	Abmessungen, Zoll				
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS}	LF	DN	LB ₁
.625	5/8	1.315	.030	1.625	5	2F342-1588-076-PD	★	☆	.625	3.500	.594	1.626
	5/8	1.315	.060	1.625	5	2F342-1588-152-PD	★	☆	.625	3.500	.594	1.626
.750	3/4	1.626	.030	1.937	5	2F342-1905-076-PD	★	☆	.750	4.000	.713	1.937
	3/4	1.626	.060	1.937	5	2F342-1905-152-PD	★	☆	.750	4.000	.713	1.937

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für Stahl

FHA 38°
 BSG COROMANT
 TCDC h10
 TCDCON h6



Metrische Ausführung

								P	K	Abmessungen, mm			
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS}	LF	DN	LB ₁
10.0	10	22.0	0.15	45°	30.0	5	2N342-1000-PD	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.15	45°	36.0	5	2N342-1200-PD	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.25	45°	42.0	5	2N342-1600-PD	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	0.25	45°	52.0	5	2N342-2000-PD	★	☆	20.0	104.0	19.0	52.0
25.0	25	52.0	0.25	45°	63.0	5	2N342-2500-PD	★	☆	25.0	121.0	24.0	63.0

Zoll-Ausführung

								P	K	Abmessungen, Zoll			
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS}	LF	DN	LB ₁
.625	5/8	1.315	.010	45°	1.625	5	2N342-1588-PD	★	☆	.625	3.500	.594	1.625
.750	3/4	1.626	.010	45°	1.937	5	2N342-1905-PD	★	☆	.750	4.000	.713	1.937



A179



A194



E9



E22

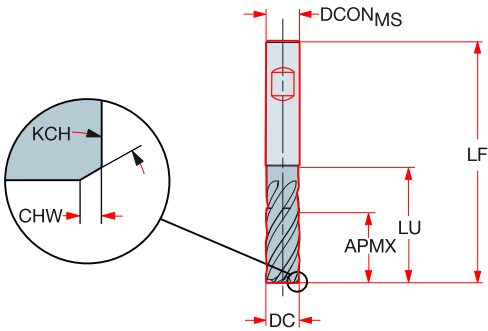


E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für Stahl

FHA42°
BSGCOROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

								P	K	Abmessungen, mm	
								1730	1730	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	★	☆		
10.0	10	22.0	0.15	45°	22.0	4	2P342-1000-PB	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	4	2P342-1200-PB	★	☆	12.0	83.0
16.0	16	34.0	0.25	45°	34.0	4	2P342-1600-PB	★	☆	16.0	97.0
20.0	20	42.0	0.25	45°	42.0	4	2P342-2000-PB	★	☆	20.0	109.6
25.0	25	52.0	0.25	45°	52.0	4	2P342-2500-PB	★	☆	25.0	129.5

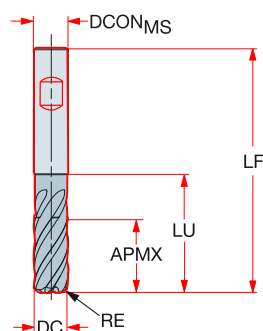
Zoll-Ausführung

								P	K	Abmessungen, Zoll	
								1730	1730	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	★	☆		
.625	5/8	1.313	.010	45°	1.313	4	2P342-1588-PB	★	☆	.625	3.500
.750	3/4	1.625	.010	45°	1.625	4	2P342-1905-PB	★	☆	.750	4.315

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für Stahl

FHA 42°
 BSG COROMANT
 TCDC h10
 TCDCON h6



Metrische Ausführung

						p K		Abmessungen, mm	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS} LF
10.0	10	22.0	0.50	22.0	4	2S342-1000-050-PB	★	☆	10.0 72.0
	10	22.0	1.00	22.0	4	2S342-1000-100-PB	★	☆	10.0 72.0
	10	22.0	2.00	22.0	4	2S342-1000-200-PB	★	☆	10.0 72.0
12.0	12	26.0	0.50	26.0	4	2S342-1200-050-PB	★	☆	12.0 83.0
	12	26.0	1.00	26.0	4	2S342-1200-100-PB	★	☆	12.0 83.0
	12	26.0	2.00	26.0	4	2S342-1200-200-PB	★	☆	12.0 83.0
16.0	16	34.0	0.50	34.0	4	2S342-1600-050-PB	★	☆	16.0 97.0
	16	34.0	1.00	34.0	4	2S342-1600-100-PB	★	☆	16.0 97.0
	16	34.0	2.00	34.0	4	2S342-1600-200-PB	★	☆	16.0 97.0
20.0	20	42.0	1.00	42.0	4	2S342-2000-100-PB	★	☆	20.0 109.6
	20	42.0	2.00	42.0	4	2S342-2000-200-PB	★	☆	20.0 109.6

Zoll-Ausführung

						p K		Abmessungen, Zoll	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1730	1730	DCON _{MS} LF
.625	5/8	1.313	.030	1.313	4	2S342-1588-076-PB	★	☆	.625 3.500
	5/8	1.315	.060	1.315	4	2S342-1588-152-PB	★	☆	.625 3.500
.750	3/4	1.625	.030	1.625	4	2S342-1905-076-PB	★	☆	.750 4.315
	3/4	1.625	.060	1.625	4	2S342-1905-152-PB	★	☆	.750 4.315



A179



A194



E9



E22



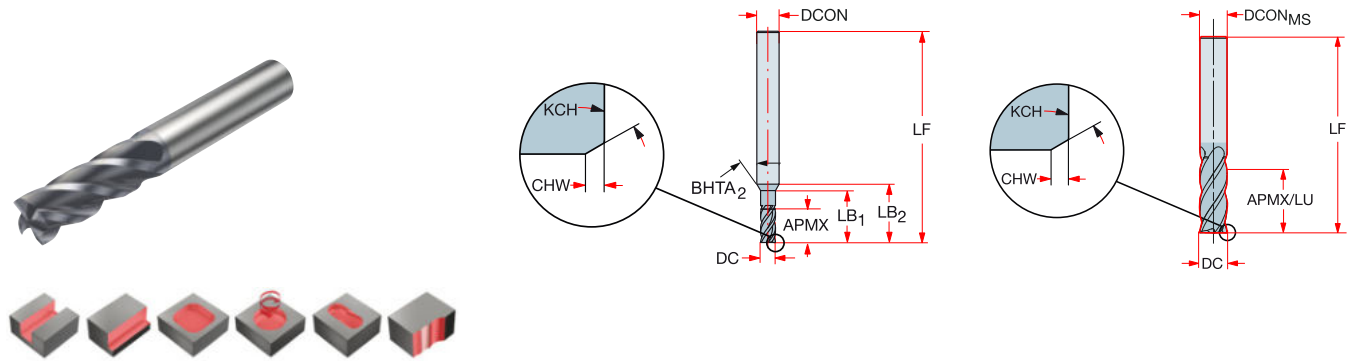
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung
Für Stahl

BSG
TCDC
TCDCON

2P342-PA (1)
COROMANT
h10
h6

2P342-PA (2)
COROMANT
h10
h6



Metrische Ausführung

										P K		Abmessungen, mm				
										1730	1730					
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	FHA	DSGN	Bestellnummer			DCON _{MS}	LF	LB ₁	LB ₂	BHTA ₂
2.0	6	5.0	0.05	45°	5.0	4	38°	1	2P342-0200-PA	★	☆	6.0	57.0	10.0	13.5	30°
3.0	6	7.0	0.10	45°	7.0	4	38°	1	2P342-0300-PA	★	☆	6.0	57.0	13.0	15.6	30°
4.0	6	9.0	0.10	45°	9.0	4	38°	1	2P342-0400-PA	★	☆	6.0	57.0	14.0	15.7	30°
5.0	6	11.0	0.10	45°	11.0	4	38°	1	2P342-0500-PA	★	☆	6.0	57.0	16.0	16.9	30°
6.0	6	13.0	0.10	45°	13.0	4	38°	2	2P342-0600-PA	★	☆	6.0	57.0			
8.0	8	18.0	0.15	45°	18.0	4	38°	2	2P342-0800-PA	★	☆	8.0	63.0			
10.0	10	22.0	0.15	45°	22.0	4	42°	2	2P342-1000-PA	★	☆	10.0	72.0			
12.0	12	26.0	0.15	45°	26.0	4	42°	2	2P342-1200-PA	★	☆	12.0	83.0			
14.0	14	30.0	0.15	45°	30.0	4	42°	2	2P342-1400-PA	★	☆	14.0	83.0			
16.0	16	34.0	0.25	45°	34.0	4	42°	2	2P342-1600-PA	★	☆	16.0	92.0			
20.0	20	42.0	0.25	45°	42.0	4	42°	2	2P342-2000-PA	★	☆	20.0	104.0			
25.0	25	52.0	0.25	45°	52.0	4	42°	2	2P342-2500-PA	★	☆	25.0	121.0			

Zoll-Ausführung

										P K		Abmessungen, Zoll	
										1730	1730		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	FHA	DSGN	Bestellnummer			DCON _{MS}	LF
.125	1/8	.313	.004	45°	.313	4	38°	2	2P342-0318-PA	★	☆	.125	1.500
.187	3/16	.438	.004	45°	.438	4	38°	2	2P342-0476-PA	★	☆	.188	2.000
.250	1/4	.625	.004	45°	.625	4	38°	2	2P342-0635-PA	★	☆	.250	2.500
.313	5/16	.750	.004	45°	.750	4	38°	2	2P342-0794-PA	★	☆	.313	2.500
.375	3/8	.875	.006	45°	.875	4	42°	2	2P342-0953-PA	★	☆	.375	2.500
.500	1/2	1.125	.006	45°	1.125	4	42°	2	2P342-1270-PA	★	☆	.500	3.000
.625	5/8	1.313	.010	45°	1.313	4	42°	2	2P342-1588-PA	★	☆	.625	3.500
.750	3/4	1.625	.010	45°	1.625	4	42°	2	2P342-1905-PA	★	☆	.750	4.000

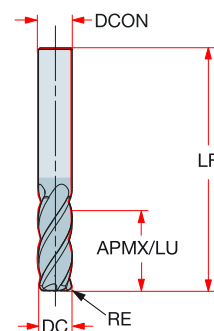
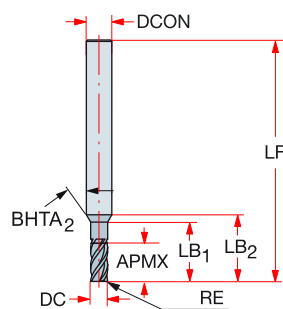
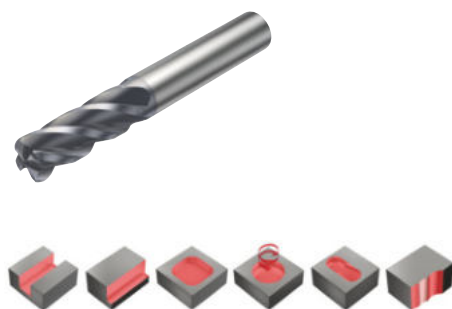
CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für Stahl

BSG
TCDC
TCDCON

2S342-PA (1)
COROMANT
h10
h6

2S342-PA (2)
COROMANT
h10
h6



Metrische Ausführung

										P K		Abmessungen, mm				
DC	CZC _{MS}	APMX	RE	LU	ZEFP	FHA	DSGN	Bestellnummer		1730	1730	DCON _{MS}	LF	LB ₁	LB ₂	BHTA ₂
3.0	6	7.0	0.20	7.0	4	38°	1	2S342-0300-020-PA	★	☆		6.0	57.0	13.0	15.6	30°
	6	7.0	0.50	7.0	4	38°	1	2S342-0300-050-PA	★	☆		6.0	57.0	13.0	15.6	30°
4.0	6	9.0	0.20	9.0	4	38°	1	2S342-0400-020-PA	★	☆		6.0	57.0	14.0	15.7	30°
	6	9.0	0.50	9.0	4	38°	1	2S342-0400-050-PA	★	☆		6.0	57.0	14.0	15.7	30°
5.0	6	11.0	0.50	11.0	4	38°	1	2S342-0500-050-PA	★	☆		6.0	57.0	16.0	16.9	30°
	6	11.0	1.00	11.0	4	38°	1	2S342-0500-100-PA	★	☆		6.0	57.0	16.0	16.9	30°
6.0	6	13.0	0.50	13.0	4	38°	2	2S342-0600-050-PA	★	☆		6.0	57.0			
	6	13.0	1.00	13.0	4	38°	2	2S342-0600-100-PA	★	☆		6.0	57.0			
8.0	8	18.0	0.50	18.0	4	38°	2	2S342-0800-050-PA	★	☆		8.0	63.0			
	8	18.0	1.00	18.0	4	38°	2	2S342-0800-100-PA	★	☆		8.0	63.0			
	8	18.0	2.00	18.0	4	38°	2	2S342-0800-200-PA	★	☆		8.0	63.0			
10.0	10	22.0	0.50	22.0	4	42°	2	2S342-1000-050-PA	★	☆		10.0	72.0			
	10	22.0	1.00	22.0	4	42°	2	2S342-1000-100-PA	★	☆		10.0	72.0			
	10	22.0	2.00	22.0	4	42°	2	2S342-1000-200-PA	★	☆		10.0	72.0			
12.0	12	26.0	0.50	26.0	4	42°	2	2S342-1200-050-PA	★	☆		12.0	83.0			
	12	26.0	1.00	26.0	4	42°	2	2S342-1200-100-PA	★	☆		12.0	83.0			
	12	26.0	2.00	26.0	4	42°	2	2S342-1200-200-PA	★	☆		12.0	83.0			
16.0	16	34.0	0.50	34.0	4	42°	2	2S342-1600-050-PA	★	☆		16.0	92.0			
	16	34.0	1.00	34.0	4	42°	2	2S342-1600-100-PA	★	☆		16.0	92.0			
	16	34.0	2.00	34.0	4	42°	2	2S342-1600-200-PA	★	☆		16.0	92.0			
20.0	20	42.0	1.00	42.0	4	42°	2	2S342-2000-100-PA	★	☆		20.0	104.0			
	20	42.0	2.00	42.0	4	42°	2	2S342-2000-200-PA	★	☆		20.0	104.0			

Zoll-Ausführung

										P K		Abmessungen, Zoll	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	FHA	DSGN	Bestellnummer		1730	1730	DCON _{MS}	LF
.125	1/8	.313	.015	.313	4	38°	2	2S342-0318-038-PA	★	☆		.125	1.500
.187	3/16	.438	.015	.438	4	38°	2	2S342-0476-038-PA	★	☆		.188	2.000
.250	1/4	.625	.015	.625	4	38°	2	2S342-0635-038-PA	★	☆		.250	2.500
	1/4	.625	.030	.625	4	38°	2	2S342-0635-076-PA	★	☆		.250	2.500
.313	5/16	.750	.015	.750	4	38°	2	2S342-0794-038-PA	★	☆		.313	2.500
	5/16	.750	.030	.750	4	38°	2	2S342-0794-076-PA	★	☆		.313	2.500
.375	3/8	.875	.015	.875	4	42°	2	2S342-0953-038-PA	★	☆		.375	2.500
	3/8	.875	.030	.875	4	42°	2	2S342-0953-076-PA	★	☆		.375	2.500
.438	7/16	1.000	.015	1.000	4	42°	2	2S342-1111-038-PA	★	☆		.438	2.750
	7/16	1.000	.030	1.000	4	42°	2	2S342-1111-076-PA	★	☆		.438	2.750
.500	1/2	1.125	.015	1.125	4	42°	2	2S342-1270-038-PA	★	☆		.500	3.000
	1/2	1.125	.030	1.125	4	42°	2	2S342-1270-076-PA	★	☆		.500	3.000
	1/2	1.125	.060	1.125	4	42°	2	2S342-1270-152-PA	★	☆		.500	3.000
.625	5/8	1.313	.030	1.313	4	42°	2	2S342-1588-076-PA	★	☆		.625	3.500
	5/8	1.315	.060	1.315	4	42°	2	2S342-1588-152-PA	★	☆		.625	3.500
.750	3/4	1.625	.030	1.625	4	42°	2	2S342-1905-076-PA	★	☆		.750	4.000
	3/4	1.625	.060	1.625	4	42°	2	2S342-1905-152-PA	★	☆		.750	4.000



A179



A194



E9



E22



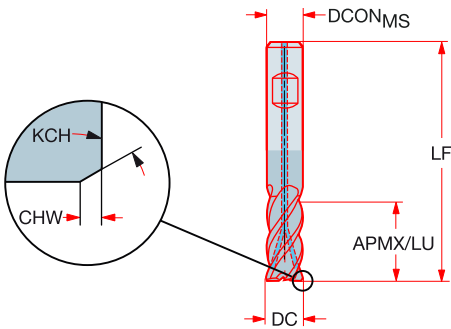
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für rostfreien Stahl

FHA
BSG
TCDC
TCDCON

38°
COROMANT
h10
h6

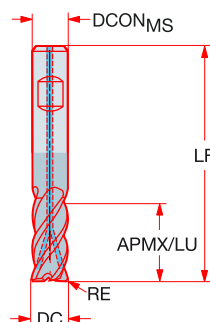


Metrische Ausführung

									M	S	Abmessungen, mm	
									1740	1740	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	CXSC	ZEFP	Bestellnummer	★	☆		
10.0	10	22.0	0.15	45°	22.0	3	4	2P342-1000-CMB	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	3	4	2P342-1200-CMB	★	☆	12.0	83.0
16.0	16	34.0	0.25	45°	34.0	3	4	2P342-1600-CMB	★	☆	16.0	97.0
20.0	20	42.0	0.25	45°	42.0	3	4	2P342-2000-CMB	★	☆	20.0	109.6
25.0	25	52.0	0.25	45°	52.0	3	4	2P342-2500-CMB	★	☆	25.0	129.5

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für rostfreien Stahl

BSG
TCDC
TCDCONCOROMANT
h10
h6

Metrische Ausführung

										M S		Abmessungen, mm	
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	FHA	Bestellnummer	1740	1740	DCON _{MS}	LF
10.0	10	22.0	0.50	22.0	1	4	4	38°	2S342-1000-050CMB	★	☆	10.0	72.0
	10	22.0	1.00	22.0	1	4	4	38°	2S342-1000-100CMB	★	☆	10.0	72.0
	10	22.0	1.50	22.0	1	4	4	38°	2S342-1000-150CMB	★	☆	10.0	72.0
	10	22.0	2.00	22.0	1	4	4	38°	2S342-1000-200CMB	★	☆	10.0	72.0
	10	22.0	3.00	22.0	1	4	4	38°	2S342-1000-300CMB	★	☆	10.0	72.0
12.0	12	26.0	0.50	26.0	1	4	4	38°	2S342-1200-050CMB	★	☆	12.0	83.0
	12	26.0	1.00	26.0	1	4	4	38°	2S342-1200-100CMB	★	☆	12.0	83.0
	12	26.0	1.50	26.0	1	4	4	38°	2S342-1200-150CMB	★	☆	12.0	83.0
	12	26.0	2.00	26.0	1	4	4	38°	2S342-1200-200CMB	★	☆	12.0	83.0
	12	26.0	3.00	26.0	1	4	4	38°	2S342-1200-300CMB	★	☆	12.0	83.0
16.0	16	34.0	0.50	34.0	1	4	4	38°	2S342-1600-050CMB	★	☆	16.0	97.0
	16	34.0	1.00	34.0	1	4	4	38°	2S342-1600-100CMB	★	☆	16.0	97.0
	16	34.0	2.00	34.0	1	4	4	42°	2S342-1600-200CMB	★	☆	16.0	97.0
	16	34.0	3.00	34.0	1	4	4	38°	2S342-1600-300CMB	★	☆	16.0	97.0
	16	34.0	4.00	34.0	1	4	4	38°	2S342-1600-400CMB	★	☆	16.0	97.0
20.0	20	42.0	1.00	42.0	1	4	4	38°	2S342-2000-100CMB	★	☆	20.0	109.6
	20	42.0	2.00	42.0	1	4	4	38°	2S342-2000-200CMB	★	☆	20.0	109.6
	20	42.0	3.00	42.0	1	4	4	38°	2S342-2000-300CMB	★	☆	20.0	109.6
	20	42.0	4.00	42.0	1	4	4	38°	2S342-2000-400CMB	★	☆	20.0	109.6
	20	42.0	5.00	42.0	1	4	4	38°	2S342-2000-500CMB	★	☆	20.0	109.6
	20	42.0	6.35	42.0	1	4	4	38°	2S342-2000-635CMB	★	☆	20.0	109.6

Zoll-Ausführung

										M S		Abmessungen, Zoll	
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	FHA	Bestellnummer	1740	1740	DCON _{MS}	LF
.625	5/8	1.313	.030	1.313	1	4	4	38°	2S342-1588-076CMB	★	☆	.625	3.780
	5/8	1.313	.060	1.313	1	4	4	38°	2S342-1588-152CMB	★	☆	.625	3.780
	5/8	1.313	.090	1.313	1	4	4	38°	2S342-1588-229CMB	★	☆	.625	3.780
	5/8	1.313	.120	1.313	1	4	4	38°	2S342-1588-305CMB	★	☆	.625	3.780
.750	3/4	1.625	.030	1.625	1	4	4	38°	2S342-1905-076CMB	★	☆	.750	4.315
	3/4	1.625	.060	1.625	1	4	4	38°	2S342-1905-152CMB	★	☆	.750	4.315
	3/4	1.625	.090	1.625	1	4	4	38°	2S342-1905-229CMB	★	☆	.750	4.315
	3/4	1.625	.120	1.625	1	4	4	38°	2S342-1905-305CMB	★	☆	.750	4.315
	3/4	1.625	.190	1.625	1	4	4	38°	2S342-1905-483CMB	★	☆	.750	4.315



A179



A194



E9



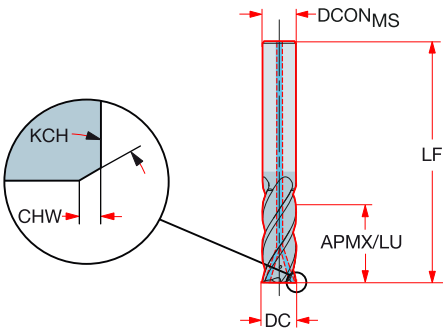
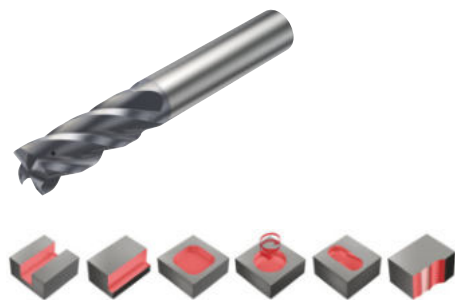
E22



E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung
Für rostfreien Stahl

FHA 38°
BSG COROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

										M	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Bestellnummer	1740	1740	DCON _{MS}	LF
6.0	6	13.0	0.10	45°	13.0	1	3	4	2P342-0600-CMA	★	☆	6.0	57.0
8.0	8	18.0	0.15	45°	18.0	1	3	4	2P342-0800-CMA	★	☆	8.0	63.0
10.0	10	22.0	0.15	45°	22.0	1	3	4	2P342-1000-CMA	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	1	3	4	2P342-1200-CMA	★	☆	12.0	83.0
16.0	16	34.0	0.25	45°	34.0	1	3	4	2P342-1600-CMA	★	☆	16.0	92.0
20.0	20	42.0	0.25	45°	42.0	1	3	4	2P342-2000-CMA	★	☆	20.0	104.0
25.0	25	52.0	0.25	45°	52.0	1	3	4	2P342-2500-CMA	★	☆	25.0	121.0

Zoll-Ausführung

										M	S	Abmessungen, Zoll	
DC	CZC _{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Bestellnummer	1740	1740	DCON _{MS}	LF
.250	1/4	.625	.004	45°	.625	1	3	4	2P342-0635-CMA	★	☆	.250	2.500
.313	5/16	.750	.004	45°	.750	1	3	4	2P342-0794-CMA	★	☆	.313	2.500
.375	3/8	.875	.006	45°	.875	1	3	4	2P342-0953-CMA	★	☆	.375	2.500
.500	1/2	1.125	.006	45°	1.125	1	3	4	2P342-1270-CMA	★	☆	.500	3.000
.625	5/8	1.313	.010	45°	1.313	1	3	4	2P342-1588-CMA	★	☆	.625	3.500
.750	3/4	1.625	.010	45°	1.625	1	3	4	2P342-1905-CMA	★	☆	.750	4.000

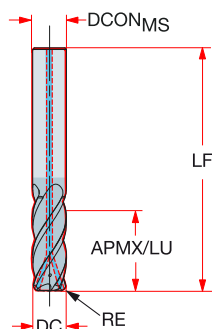
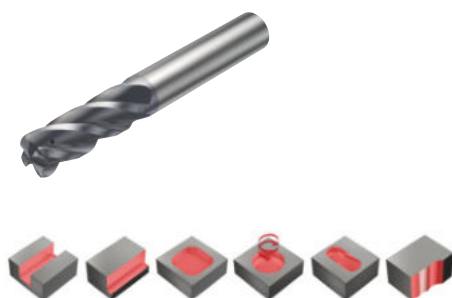


CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung

Für rostfreien Stahl

FHA
BSG
TCDC
TCDCON

38°
COROMANT
h10
h6



Metrische Ausführung

								M S		Abmessungen, mm	
								1740	1740	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer			
6.0	6	13.0	0.50	13.0	1	3	4	2S342-0600-050CMA		★ ☆	6.0 57.0
	6	13.0	1.00	13.0	1	3	4	2S342-0600-100CMA		★ ☆	6.0 57.0
8.0	8	18.0	0.50	18.0	1	3	4	2S342-0800-050CMA		★ ☆	8.0 63.0
	8	18.0	1.00	18.0	1	3	4	2S342-0800-100CMA		★ ☆	8.0 63.0
8.0	8	18.0	1.50	18.0	1	3	4	2S342-0800-150CMA		★ ☆	8.0 63.0
	8	18.0	2.00	18.0	1	3	4	2S342-0800-200CMA		★ ☆	8.0 63.0
10.0	10	22.0	0.50	22.0	1	3	4	2S342-1000-050CMA		★ ☆	10.0 72.0
	10	22.0	1.00	22.0	1	3	4	2S342-1000-100CMA		★ ☆	10.0 72.0
10.0	10	22.0	1.50	22.0	1	3	4	2S342-1000-150CMA		★ ☆	10.0 72.0
	10	22.0	2.00	22.0	1	3	4	2S342-1000-200CMA		★ ☆	10.0 72.0
10.0	10	22.0	3.00	22.0	1	3	4	2S342-1000-300CMA		★ ☆	10.0 72.0
12.0	12	26.0	0.50	26.0	1	3	4	2S342-1200-050CMA		★ ☆	12.0 83.0
	12	26.0	1.00	26.0	1	3	4	2S342-1200-100CMA		★ ☆	12.0 83.0
12.0	12	26.0	1.50	26.0	1	3	4	2S342-1200-150CMA		★ ☆	12.0 83.0
	12	26.0	2.00	26.0	1	3	4	2S342-1200-200CMA		★ ☆	12.0 83.0
12.0	12	26.0	3.00	26.0	1	3	4	2S342-1200-300CMA		★ ☆	12.0 83.0
16.0	16	34.0	0.50	34.0	1	3	4	2S342-1600-050CMA		★ ☆	16.0 92.0
	16	34.0	1.00	34.0	1	3	4	2S342-1600-100CMA		★ ☆	16.0 92.0
16.0	16	34.0	2.00	34.0	1	3	4	2S342-1600-200CMA		★ ☆	16.0 92.0
	16	34.0	3.00	34.0	1	3	4	2S342-1600-300CMA		★ ☆	16.0 92.0
16.0	16	34.0	4.00	34.0	1	3	4	2S342-1600-400CMA		★ ☆	16.0 92.0
	16	34.0	5.00	34.0	1	3	4	2S342-1600-500CMA		★ ☆	16.0 92.0
20.0	20	42.0	1.00	42.0	1	3	4	2S342-2000-100CMA		★ ☆	20.0 104.0
	20	42.0	2.00	42.0	1	3	4	2S342-2000-200CMA		★ ☆	20.0 104.0
20.0	20	42.0	3.00	42.0	1	3	4	2S342-2000-300CMA		★ ☆	20.0 104.0
	20	42.0	4.00	42.0	1	3	4	2S342-2000-400CMA		★ ☆	20.0 104.0
20.0	20	42.0	5.00	42.0	1	3	4	2S342-2000-500CMA		★ ☆	20.0 104.0
	20	42.0	6.35	42.0	1	3	4	2S342-2000-635CMA		★ ☆	20.0 104.0



A179



A194



E9



E22



E28

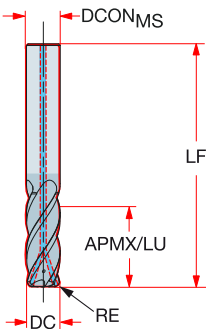
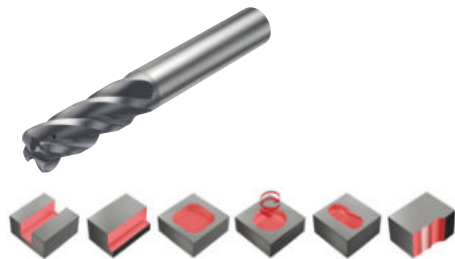


E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Bearbeitung
Für rostfreien Stahl

FHA
BSG
TCDC
TCDCON

38°
COROMANT
h10
h6



Zoll-Ausführung

								M S		Abmessungen, Zoll	
								1740	1740	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer			
.250	1/4	.625	.015	.625	1	3	4	2S342-0635-038CMA	★ ☆	.250	2.500
	1/4	.625	.030	.625	1	3	4	2S342-0635-076CMA	★ ☆	.250	2.500
.313	5/16	.750	.015	.750	1	3	4	2S342-0794-038CMA	★ ☆	.313	2.500
.375	3/8	.875	.015	.875	1	3	4	2S342-0953-038CMA	★ ☆	.375	2.500
	3/8	.875	.030	.875	1	3	4	2S342-0953-076CMA	★ ☆	.375	2.500
	3/8	.875	.060	.875	1	3	4	2S342-0953-152CMA	★ ☆	.375	2.500
.500	1/2	1.125	.015	1.125	1	3	4	2S342-1270-038CMA	★ ☆	.500	3.000
	1/2	1.125	.030	1.125	1	3	4	2S342-1270-076CMA	★ ☆	.500	3.000
	1/2	1.125	.060	1.125	1	3	4	2S342-1270-152CMA	★ ☆	.500	3.000
	1/2	1.125	.090	1.125	1	3	4	2S342-1270-229CMA	★ ☆	.500	3.000
	1/2	1.125	.120	1.125	1	3	4	2S342-1270-305CMA	★ ☆	.500	3.000
.625	5/8	1.313	.030	1.313	1	3	4	2S342-1588-076CMA	★ ☆	.625	3.500
	5/8	1.313	.060	1.313	1	3	4	2S342-1588-152CMA	★ ☆	.625	3.500
	5/8	1.313	.090	1.313	1	3	4	2S342-1588-229CMA	★ ☆	.625	3.500
	5/8	1.313	.120	1.313	1	3	4	2S342-1588-305CMA	★ ☆	.625	3.500
.750	3/4	1.625	.030	1.625	1	3	4	2S342-1905-076CMA	★ ☆	.750	4.000
	3/4	1.625	.060	1.625	1	3	4	2S342-1905-152CMA	★ ☆	.750	4.000
	3/4	1.625	.090	1.625	1	3	4	2S342-1905-229CMA	★ ☆	.750	4.000
	3/4	1.625	.120	1.625	1	3	4	2S342-1905-305CMA	★ ☆	.750	4.000
	3/4	1.625	.190	1.625	1	3	4	2S342-1905-483CMA	★ ☆	.750	4.000

C

D

E



CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung

Einsatzbereich

Eine exzellente Lösung für die Schruppbearbeitung, wenn eine hohe Oberflächengüte erforderlich ist

Erste Wahl für CAM-unterstützte Strategien zum High Feed- Sidemilling

ISO-Werkstoff	P	K	M	S	
Sorte	1630	1640	1740	1745	1710
Schaft	Zylindrisch		Weldon		

Produktbereich

Für Stahl und rostfreien Stahl

Für Titanlegierungen

Für Nickelbasislegierungen

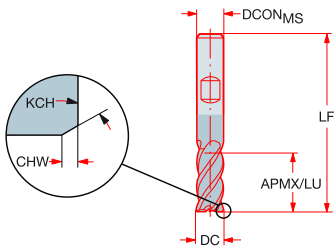
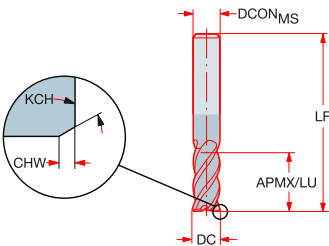


CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung
Für Stahl mit Härte ≤ 48 HRC

FHA
BSG
TCDC
TCDCON

2P340-PA
37°
DIN 6527 L
h10
h6

2P340-PB
37°
DIN 6527 L
h10
h6



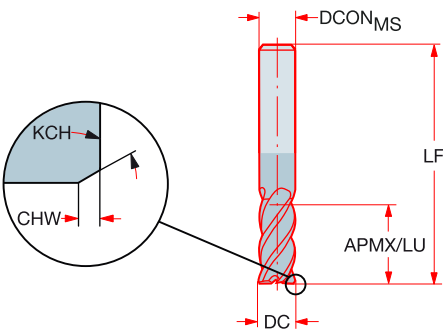
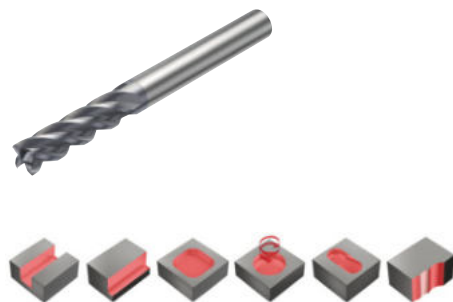
Metrische Ausführung

							P K		Abmessungen, mm	
							1630	1630		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer		DCON _{MS}	LF
2.0	6	7.0	0.15	45°	7.0	4	2P340-0200-PB	★ ☆	6.0	57.0
	6	7.0	0.15	45°	7.0	4	2P340-0200-PA	★ ☆	6.0	57.0
2.5	6	8.0	0.15	45°	8.0	4	2P340-0250-PB	★ ☆	6.0	57.0
	6	8.0	0.15	45°	8.0	4	2P340-0250-PA	★ ☆	6.0	57.0
3.0	6	8.0	0.15	45°	8.0	4	2P340-0300-PB	★ ☆	6.0	57.0
	6	8.0	0.15	45°	8.0	4	2P340-0300-PA	★ ☆	6.0	57.0
3.5	6	10.0	0.13	45°	10.0	4	2P340-0350-PB	★ ☆	6.0	57.0
	6	10.0	0.13	45°	10.0	4	2P340-0350-PA	★ ☆	6.0	57.0
4.0	6	11.0	0.13	45°	11.0	4	2P340-0400-PB	★ ☆	6.0	57.0
	6	11.0	0.13	45°	11.0	4	2P340-0400-PA	★ ☆	6.0	57.0
5.0	6	13.0	0.13	45°	13.0	4	2P340-0500-PB	★ ☆	6.0	57.0
	6	13.0	0.13	45°	13.0	4	2P340-0500-PA	★ ☆	6.0	57.0
6.0	6	13.0	0.15	45°	13.0	4	2P340-0600-PB	★ ☆	6.0	57.0
	6	13.0	0.15	45°	13.0	4	2P340-0600-PA	★ ☆	6.0	57.0
7.0	8	16.0	0.15	45°	16.0	4	2P340-0700-PB	★ ☆	8.0	63.0
	8	16.0	0.15	45°	16.0	4	2P340-0700-PA	★ ☆	8.0	63.0
8.0	8	19.0	0.15	45°	19.0	4	2P340-0800-PB	★ ☆	8.0	63.0
	8	19.0	0.15	45°	19.0	4	2P340-0800-PA	★ ☆	8.0	63.0
9.0	10	19.0	0.15	45°	19.0	4	2P340-0900-PA	★ ☆	10.0	72.0
10.0	10	22.0	0.15	45°	22.0	4	2P340-1000-PB	★ ☆	10.0	72.0
	10	22.0	0.15	45°	22.0	4	2P340-1000-PA	★ ☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	4	2P340-1200-PB	★ ☆	12.0	83.0
	12	26.0	0.15	45°	26.0	4	2P340-1200-PA	★ ☆	12.0	83.0
14.0	14	26.0	0.20	45°	26.0	4	2P340-1400-PB	★ ☆	14.0	83.0
	14	26.0	0.20	45°	26.0	4	2P340-1400-PA	★ ☆	14.0	83.0
16.0	16	32.0	0.20	45°	32.0	4	2P340-1600-PB	★ ☆	16.0	92.0
	16	32.0	0.20	45°	32.0	4	2P340-1600-PA	★ ☆	16.0	92.0
18.0	18	32.0	0.20	45°	32.0	4	2P340-1800-PB	★ ☆	18.0	92.0
	18	32.0	0.20	45°	32.0	4	2P340-1800-PA	★ ☆	18.0	92.0
20.0	20	38.0	0.20	45°	38.0	4	2P340-2000-PB	★ ☆	20.0	104.0
	20	38.0	0.20	45°	38.0	4	2P340-2000-PA	★ ☆	20.0	104.0
25.0	25	45.0	0.20	45°	45.0	4	2P340-2500-PB	★ ☆	25.0	121.0
	25	45.0	0.20	45°	45.0	4	2P340-2500-PA	★ ☆	25.0	121.0

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA 37°
BSG COROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1630	1630	1630	1630	DCON _{MS}	LF
6.0	6	22.0	0.15	45°	22.0	4	2P360-0600-PA	★	★	☆	☆	6.0	65.0
8.0	8	28.0	0.15	45°	28.0	4	2P360-0800-PA	★	★	☆	☆	8.0	80.0
10.0	10	32.0	0.15	45°	32.0	4	2P360-1000-PA	★	★	☆	☆	10.0	100.0
12.0	12	40.0	0.15	45°	40.0	4	2P360-1200-PA	★	★	☆	☆	12.0	100.0
14.0	14	50.0	0.20	45°	50.0	4	2P360-1400-PA	★	★	☆	☆	14.0	104.0
16.0	16	60.0	0.15	45°	60.0	4	2P360-1600-PA	★	★	☆	☆	16.0	124.0
20.0	20	70.0	0.20	45°	70.0	4	2P360-2000-PA	★	★	☆	☆	20.0	155.0

A181

A194

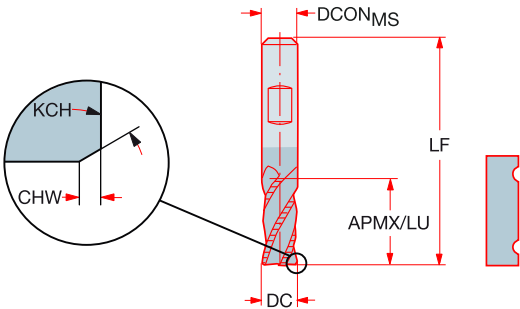
E9

E22

E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung
Für rostfreien Stahl und Stahl mit Härte ≤ 30 HRc

FHA 37°
TCDC h10
TCDCON h6



Metrische Ausführung

							Abmessungen, mm			
							P	M	K	S
							1740	1740	1740	1740
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	DCON _{MS}	LF	
6.0	6	24.0	0.10	45°	24.0	4	2P370-0600-PB	★	★	★
8.0	8	32.0	0.10	45°	32.0	4	2P370-0800-PB	★	★	★
10.0	10	40.0	0.15	45°	40.0	4	2P370-1000-PB	★	★	★
12.0	12	48.0	0.15	45°	48.0	4	2P370-1200-PB	★	★	★
16.0	16	64.0	0.20	45°	64.0	4	2P370-1600-PB	★	★	★
20.0	20	80.0	0.25	45°	80.0	4	2P370-2000-PB	★	★	★
25.0	25	100.0	0.25	45°	100.0	4	2P370-2500-PB	★	★	★

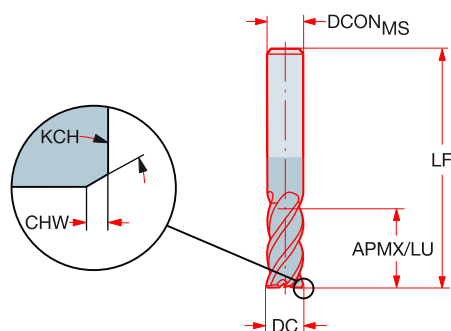
Zoll-Ausführung

							Abmessungen, Zoll			
							P	M	K	S
							1740	1740	1740	1740
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	DCON _{MS}	LF	
.250	1/4	1.000	.004	45°	1.000	4	2P370-0635-PB	★	★	★
.313	5/16	1.250	.004	45°	1.250	4	2P370-0794-PB	★	★	★
.375	3/8	1.500	.006	45°	1.500	4	2P370-0953-PB	★	★	★
.500	1/2	2.000	.006	45°	2.000	4	2P370-1270-PB	★	★	★
.625	5/8	2.500	.008	45°	2.500	4	2P370-1588-PB	★	★	★
.750	3/4	3.000	.010	45°	3.000	4	2P370-1905-PB	★	★	★
1.000	1	4.000	.010	45°	4.000	4	2P370-2540-PB	★	★	★

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung

Für rostfreien Stahl

FHA 41°
 BSG DIN 6527 L
 TCDC h10
 TCDCON h6



Metrische Ausführung

							M S		Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer		DCON _{MS}	LF
2.0	6	7.0	0.15	45°	7.0	4	2P341-0200-MA	★ ☆	6.0	57.0
3.0	6	8.0	0.15	45°	8.0	4	2P341-0300-MA	★ ☆	6.0	57.0
4.0	6	11.0	0.15	45°	11.0	4	2P341-0400-MA	★ ☆	6.0	57.0
5.0	6	13.0	0.15	45°	13.0	4	2P341-0500-MA	★ ☆	6.0	57.0
6.0	6	13.0	0.15	45°	13.0	4	2P341-0600-MA	★ ☆	6.0	57.0
8.0	8	19.0	0.15	45°	19.0	4	2P341-0800-MA	★ ☆	8.0	63.0
10.0	10	22.0	0.15	45°	22.0	4	2P341-1000-MA	★ ☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	4	2P341-1200-MA	★ ☆	12.0	83.0
14.0	14	26.0	0.20	45°	26.0	4	2P341-1400-MA	★ ☆	14.0	83.0
16.0	16	32.0	0.20	45°	32.0	4	2P341-1600-MA	★ ☆	16.0	92.0
20.0	20	38.0	0.20	45°	38.0	4	2P341-2000-MA	★ ☆	20.0	104.0
25.0	25	45.0	0.20	45°	45.0	4	2P341-2500-MA	★ ☆	25.0	121.0



A181



A194



E9



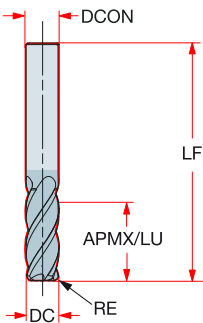
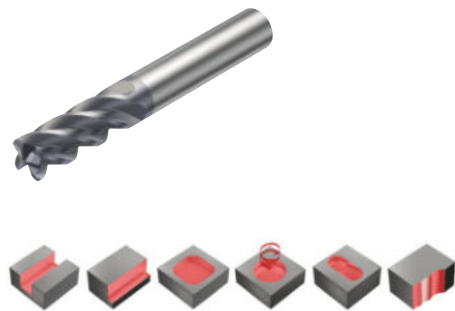
E22



E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung
Für rostfreien Stahl

FHA 41°
BSG DIN 6527 L
TCDC h10
TCDCON h6



Metrische Ausführung

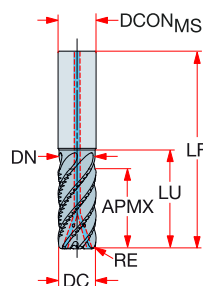
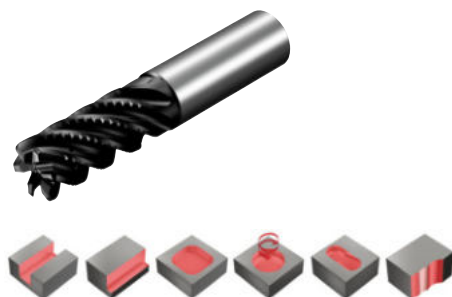
							M	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1640	1640	DCON _{MS}	LF
4.0	6	11.0	0.50	11.0	4	2S340-0400-050-MA	★	☆	6.0	57.0
	6	11.0	1.00	11.0	4	2S340-0400-100-MA	★	☆	6.0	57.0
5.0	6	13.0	0.50	13.0	4	2S340-0500-050-MA	★	☆	6.0	57.0
	6	13.0	1.00	13.0	4	2S340-0500-100-MA	★	☆	6.0	57.0
6.0	6	13.0	0.50	13.0	4	2S340-0600-050-MA	★	☆	6.0	57.0
	6	13.0	1.00	13.0	4	2S340-0600-100-MA	★	☆	6.0	57.0
8.0	8	19.0	0.50	19.0	4	2S340-0800-050-MA	★	☆	8.0	63.0
	8	19.0	1.00	19.0	4	2S340-0800-100-MA	★	☆	8.0	63.0
	8	19.0	1.50	19.0	4	2S340-0800-150-MA	★	☆	8.0	63.0
	8	19.0	2.00	19.0	4	2S340-0800-200-MA	★	☆	8.0	63.0
10.0	10	22.0	0.50	22.0	4	2S340-1000-050-MA	★	☆	10.0	72.0
	10	22.0	1.00	22.0	4	2S340-1000-100-MA	★	☆	10.0	72.0
	10	22.0	1.50	22.0	4	2S340-1000-150-MA	★	☆	10.0	72.0
	10	22.0	2.00	22.0	4	2S340-1000-200-MA	★	☆	10.0	72.0
12.0	12	26.0	1.00	26.0	4	2S340-1200-100-MA	★	☆	12.0	83.0
	12	26.0	1.50	26.0	4	2S340-1200-150-MA	★	☆	12.0	83.0
	12	26.0	2.00	26.0	4	2S340-1200-200-MA	★	☆	12.0	83.0
	12	26.0	3.00	26.0	4	2S340-1200-300-MA	★	☆	12.0	83.0
16.0	16	32.0	1.50	32.0	4	2S340-1600-150-MA	★	☆	16.0	92.0
	16	32.0	2.00	32.0	4	2S340-1600-200-MA	★	☆	16.0	92.0
	16	32.0	3.00	32.0	4	2S340-1600-300-MA	★	☆	16.0	92.0
	16	32.0	4.00	32.0	4	2S340-1600-400-MA	★	☆	16.0	92.0
20.0	20	38.0	1.50	38.0	4	2S340-2000-150-MA	★	☆	20.0	104.0
	20	38.0	2.00	38.0	4	2S340-2000-200-MA	★	☆	20.0	104.0
	20	38.0	3.00	38.0	4	2S340-2000-300-MA	★	☆	20.0	104.0
	20	38.0	4.00	38.0	4	2S340-2000-400-MA	★	☆	20.0	104.0

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung

Für Titanlegierungen

FHA
BSG
TCDC
TCDCON

42°
COROMANT
h10
h6



Metrische Ausführung

									s	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer	1745	DCON _{MS}	LF	DN
10.0	10	22.0	1.00	30.0	1	3	6	2F340-1000-100CSC	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	1	3	6	2F340-1000-200CSC	★	10.0	72.0	9.5
12.0	12	26.0	1.00	36.0	1	3	6	2F340-1200-100CSC	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	1	3	6	2F340-1200-200CSC	★	12.0	83.0	11.4
16.0	16	34.0	2.00	42.0	1	3	6	2F340-1600-200CSC	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	1	3	6	2F340-1600-300CSC	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	1	3	6	2F340-2000-300CSC	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	1	3	6	2F340-2500-400CSC	★	25.0	121.0	23.8
32.0	32	66.0	4.00	82.0	1	3	6	2F340-3200-400CSC	★	32.0	150.0	30.4

Zoll-Ausführung

									s	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer	1745	DCON _{MS}	LF	DN
.375	3/8	.781	.030	1.156	1	3	6	2F340-0953-076CSC	★	.375	2.750	.356
	3/8	.781	.060	1.156	1	3	6	2F340-0953-152CSC	★	.375	2.750	.356
.500	1/2	1.125	.060	1.438	1	3	6	2F340-1270-152CSC	★	.500	3.500	.475
	1/2	1.125	.090	1.438	1	3	6	2F340-1270-228CSC	★	.500	3.500	.475
.625	5/8	1.125	.060	1.563	1	3	6	2F340-1588-152CSC	★	.625	3.500	.594
	5/8	1.313	.090	1.563	1	3	6	2F340-1588-228CSC	★	.625	3.500	.594
.750	3/4	1.625	.090	1.563	1	3	6	2F340-1905-228CSC	★	.750	4.000	.713
	3/4	1.625	.120	1.937	1	3	6	2F340-1905-304CSC	★	.750	4.000	.713
1.000	1	2.125	.120	2.656	1	3	6	2F340-2540-304CSC	★	1.000	5.000	.951
1.250	1 1/4	2.625	.120	3.250	1	3	6	2F340-3175-304CSC	★	1.250	6.000	1.187



A181



A194



E9



E22



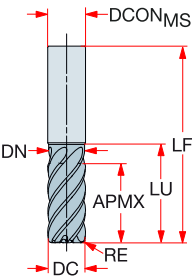
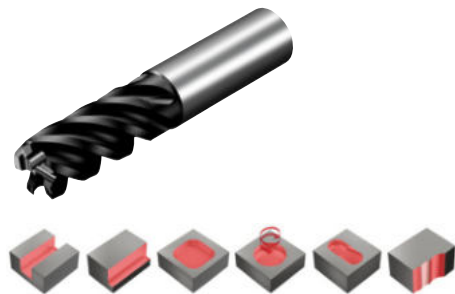
E28



E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung
Für Titanlegierungen

FHA 42°
BSG COROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

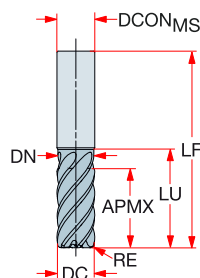
							S	Abmessungen, mm		
							1745			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer		DCON _{MS}	LF	DN
4.0	6	9.0	0.50	14.5	4	2F340-0400-050-SC	★	6.0	57.0	3.8
5.0	6	11.0	0.50	16.5	4	2F340-0500-050-SC	★	6.0	57.0	4.8
6.0	6	13.0	0.50	20.0	5	2F340-0600-050-SC	★	6.0	57.0	5.7
	6	13.0	1.00	20.0	5	2F340-0600-100-SC	★	6.0	57.0	5.7
8.0	8	18.0	0.50	25.0	5	2F340-0800-050-SC	★	8.0	63.0	7.6
	8	18.0	1.00	25.0	5	2F340-0800-100-SC	★	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	6	2F340-1000-050-SC	★	10.0	72.0	9.5
	10	22.0	1.00	30.0	6	2F340-1000-100-SC	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	6	2F340-1000-200-SC	★	10.0	72.0	9.5
12.0	12	26.0	1.00	36.0	6	2F340-1200-100-SC	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	6	2F340-1200-200-SC	★	12.0	83.0	11.4
	12	26.0	2.50	36.0	6	2F340-1200-250-SC	★	12.0	83.0	11.4
	12	26.0	3.00	36.0	6	2F340-1200-300-SC	★	12.0	83.0	11.4
16.0	16	34.0	2.00	42.0	6	2F340-1600-200-SC	★	16.0	92.0	15.2
	16	34.0	2.50	42.0	6	2F340-1600-250-SC	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	6	2F340-1600-300-SC	★	16.0	92.0	15.2
	16	34.0	4.00	42.0	6	2F340-1600-400-SC	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	6	2F340-2000-300-SC	★	20.0	104.0	19.0
	20	42.0	4.00	52.0	6	2F340-2000-400-SC	★	20.0	104.0	19.0
	20	42.0	6.35	52.0	6	2F340-2000-635-SC	★	20.0	104.0	19.0
25.0	25	52.0	3.00	63.0	6	2F340-2500-300-SC	★	25.0	121.0	23.8
	25	52.0	4.00	63.0	6	2F340-2500-400-SC	★	25.0	121.0	23.8
	25	52.0	6.35	63.0	6	2F340-2500-635-SC	★	25.0	121.0	23.8
32.0	32	66.0	4.00	82.0	6	2F340-3200-400-SC	★	32.0	150.0	30.4

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung

Für Titanbasislegierungen

FHA
BSG
TCDC
TCDCON

42°
COROMANT
h10
h6



Zoll-Ausführung

						s Abmessungen, Zoll			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1745	DCON _{MS}	LF DN
.188	3/16	.438	.030	.625	4	2F340-0476-076-SC	★	.188	2.000 .178
.250	1/4	.625	.030	.875	5	2F340-0635-076-SC	★	.250	2.500 .237
	1/4	.625	.060	.875	5	2F340-0635-152-SC	★	.250	2.500 .237
.375	3/8	.781	.030	1.156	6	2F340-0953-076-SC	★	.375	2.750 .356
	3/8	.781	.060	1.156	6	2F340-0953-152-SC	★	.375	2.750 .356
	3/8	.781	.090	1.156	6	2F340-0953-228-SC	★	.375	2.750 .356
.500	1/2	1.125	.030	1.438	6	2F340-1270-076-SC	★	.500	3.500 .475
	1/2	1.125	.060	1.438	6	2F340-1270-152-SC	★	.500	3.500 .475
	1/2	1.125	.090	1.438	6	2F340-1270-228-SC	★	.500	3.500 .475
	1/2	1.125	.120	1.438	6	2F340-1270-304-SC	★	.500	3.500 .475
.625	5/8	1.313	.030	1.563	6	2F340-1588-076-SC	★	.625	3.500 .594
	5/8	1.313	.060	1.563	6	2F340-1588-152-SC	★	.625	3.500 .594
	5/8	1.313	.090	1.563	6	2F340-1588-228-SC	★	.625	3.500 .594
	5/8	1.313	.120	1.563	6	2F340-1588-304-SC	★	.625	3.500 .594
.750	3/4	1.625	.030	1.937	6	2F340-1905-076-SC	★	.750	4.000 .713
	3/4	1.625	.060	1.937	6	2F340-1905-152-SC	★	.750	4.000 .713
	3/4	1.625	.090	1.937	6	2F340-1905-228-SC	★	.750	4.000 .713
	3/4	1.625	.120	1.937	6	2F340-1905-304-SC	★	.750	4.000 .713
1.000	1	2.125	.030	2.656	6	2F340-2540-076-SC	★	1.000	5.000 .951
	1	2.125	.060	2.656	6	2F340-2540-152-SC	★	1.000	5.000 .951
	1	2.125	.090	2.656	6	2F340-2540-228-SC	★	1.000	5.000 .951
	1	2.125	.120	2.656	6	2F340-2540-304-SC	★	1.000	5.000 .951
1.250	1 1/4	2.625	.030	3.250	6	2F340-3175-076-SC	★	1.250	6.000 1.187
	1 1/4	2.625	.060	3.250	6	2F340-3175-152-SC	★	1.250	6.000 1.187
	1 1/4	2.625	.090	3.250	6	2F340-3175-228-SC	★	1.250	6.000 1.187
	1 1/4	2.625	.120	3.250	6	2F340-3175-304-SC	★	1.250	6.000 1.187



A181



A194



E9



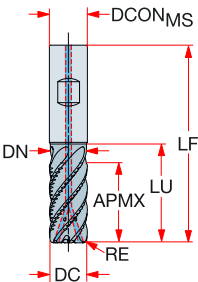
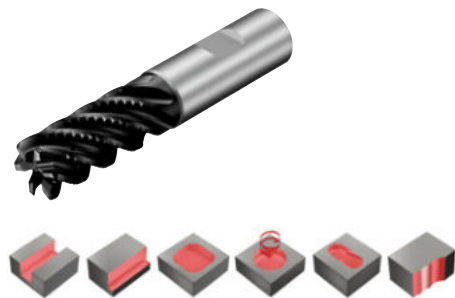
E22



E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung
Für Titanbasislegierungen

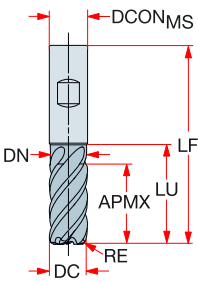
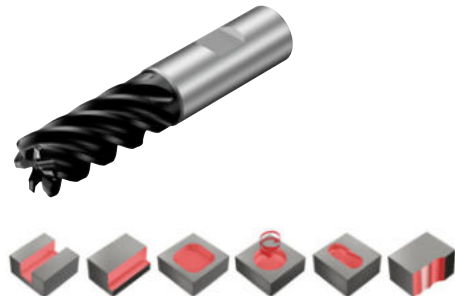
FHA 42°
BSG COROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

									s	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer		DCON _{MS}	LF	DN
16.0	16	34.0	2.00	42.0	1	3	6	2F340-1600-200CSD	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	1	3	6	2F340-1600-300CSD	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	1	3	6	2F340-2000-300CSD	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	1	3	6	2F340-2500-400CSD	★	25.0	121.0	23.8

FHA 42°
BSG COROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

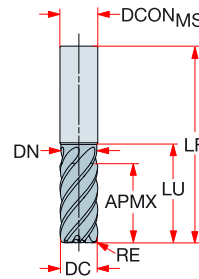
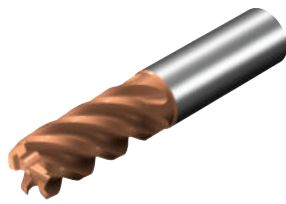
									s	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer				DCON _{MS}	LF	DN
16.0	16	34.0	2.00	42.0	6	2F340-1600-200-SD		★	16.0	92.0	15.2	
	16	34.0	3.00	42.0	6	2F340-1600-300-SD		★	16.0	92.0	15.2	
20.0	20	42.0	3.00	52.0	6	2F340-2000-300-SD		★	20.0	104.0	19.0	
	20	42.0	4.00	52.0	6	2F340-2000-400-SD		★	20.0	104.0	19.0	
25.0	25	52.0	4.00	63.0	6	2F340-2500-400-SD		★	25.0	121.0	23.8	



CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung

Für Nickelbasislegierungen

FHA 42°
 BSG COROMANT
 TCDC h10
 TCDCON h6



Metrische Ausführung

						s	Abmessungen, mm			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1710	DCON _{MS}	LF	DN
4.0	6	9.0	0.50	14.5	4	2F341-0400-050-SC	★	6.0	57.0	3.8
5.0	6	11.0	0.50	16.5	4	2F341-0500-050-SC	★	6.0	57.0	4.8
6.0	6	13.0	0.50	20.0	5	2F341-0600-050-SC	★	6.0	57.0	5.7
	6	13.0	1.00	20.0	5	2F341-0600-100-SC	★	6.0	57.0	5.7
8.0	8	18.0	0.50	25.0	5	2F341-0800-050-SC	★	8.0	63.0	7.6
	8	18.0	1.00	25.0	5	2F341-0800-100-SC	★	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	5	2F341-1000-050-SC	★	10.0	72.0	9.5
	10	22.0	1.00	30.0	5	2F341-1000-100-SC	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	5	2F341-1000-200-SC	★	10.0	72.0	9.5
12.0	12	26.0	1.00	36.0	5	2F341-1200-100-SC	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	5	2F341-1200-200-SC	★	12.0	83.0	11.4
	12	26.0	2.50	36.0	5	2F341-1200-250-SC	★	12.0	83.0	11.4
	12	26.0	3.00	36.0	5	2F341-1200-300-SC	★	12.0	83.0	11.4
16.0	16	34.0	2.00	42.0	5	2F341-1600-200-SC	★	16.0	92.0	15.2
	16	34.0	2.50	42.0	5	2F341-1600-250-SC	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	5	2F341-1600-300-SC	★	16.0	92.0	15.2
	16	34.0	4.00	42.0	5	2F341-1600-400-SC	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	5	2F341-2000-300-SC	★	20.0	104.0	19.0
	20	42.0	4.00	52.0	5	2F341-2000-400-SC	★	20.0	104.0	19.0
	20	42.0	6.35	52.0	5	2F341-2000-635-SC	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	5	2F341-2500-400-SC	★	25.0	121.0	23.8
	25	52.0	6.35	63.0	5	2F341-2500-635-SC	★	25.0	121.0	23.8



A181



A194



E9



E22

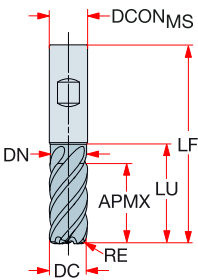
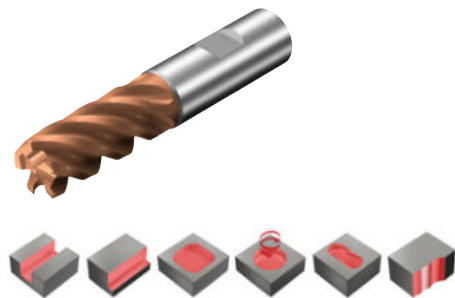


E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung

Für Nickelbasislegierungen

FHA42°
BSGCOROMANT
TCDCh10
TCDCONh6



Metrische Ausführung

						S	Abmessungen, mm			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1710	DCON _{MS}	LF	DN
16.0	16	34.0	3.00	42.0	5	2F341-1600-300-SD	★	16.0	92.0	15.2
	16	34.0	4.00	42.0	5	2F341-1600-400-SD	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	5	2F341-2000-300-SD	★	20.0	104.0	19.0
	20	42.0	4.00	52.0	5	2F341-2000-400-SD	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	5	2F341-2500-400-SD	★	25.0	121.0	23.8

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Facemilling Bearbeitung

Einsatzbereich

Schrupp-Planfräsen

Schruppen von 3D-Formen mit hohen Vorschüben

ISO-Werkstoff

P

M

K

S

H

Sorte

1610

1620

Schaft

Zylindrisch

Produktbereich

Für gehärteten Stahl mit Härte $43 \leq \text{HRc} \leq 63$

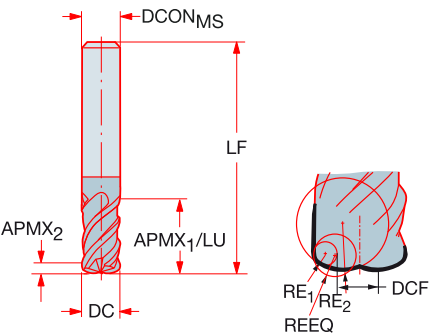
Für rostfreien Stahl und Stahl mit Härte $\leq 48 \text{ HRc}$



CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Facemilling Bearbeitung

Für Stahl und gehärteten Stahl mit Härte ≤ 63 HRc

FHA50°
BSGCOROMANT
TDCDCh9
TCDCONh8



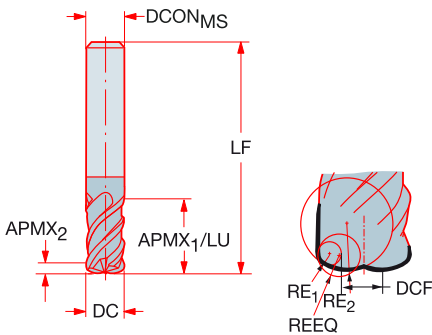
Metrische Ausführung

								P	H	Abmessungen, mm			
								1610	1610				
DC	CZC _{MS}	APMX ₁	APMX ₂	RE ₁	RE ₂	LU	ZEP	Bestellnummer		DCON _{MS}	DCF	LF	REEQ
4.0	6	11.0	0.1	0.5	4.0	15.0	4	R215.H4-04050BAC01H		6.0	1.2	57.0	0.62
6.0	6	15.0	0.2	0.5	9.0	15.0	4	R215.H4-06050BAC02H		6.0	1.4	57.0	0.69
8.0	8	20.0	0.2	1.0	12.0	20.0	4	R215.H4-08050CAC02H		8.0	6.4	63.0	1.23
10.0	10	26.0	0.3	1.5	15.0	26.0	4	R215.H4-10050DAC03H		10.0	1.6	72.0	1.77
12.0	12	30.0	0.4	1.5	18.0	30.0	4	R215.H4-12050DAC04H		12.0	2.0	83.0	1.88
16.0	16	36.0	0.5	2.0	24.0	36.0	4	R215.H4-16050EAC05H		16.0	3.0	92.0	2.46
20.0	20	45.0	0.6	2.0	30.0	45.0	4	R215.H4-20050EAC06H		20.0	4.4	104.0	2.61

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Facemilling Bearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA 50°
BSG COROMANT
TCDC h9
TCDCON h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm			
DC	CZC _{MS}	APMX ₁	APMX ₂	RE ₁	RE ₂	LU	ZEFP	Bestellnummer	1620	1620	1620	DCON _{MS}	DCF	LF	REEQ
6.0	6	15.0	0.2	0.5	3.0	15.0	4	R215.H4-06050BAK02P	★	★	☆	6.0	2.8	100.0	0.75
8.0	8	20.0	0.3	1.0	4.0	20.0	4	R215.H4-08050CAK02P	★	★	☆	8.0	3.1	120.0	1.38
10.0	10	26.0	0.7	1.5	5.0	26.0	4	R215.H4-10050DAK03P	★	★	☆	10.0	3.4	150.0	1.99
12.0	12	12.0	0.7	1.5	6.0	12.0	4	R215.H4-12050DAK08P	★	★	☆	12.0	4.5	93.0	2.10
16.0	16	16.0	1.0	2.0	8.0	16.0	4	R215.H4-16050EAK10P	★	★	☆	16.0	6.2	112.0	2.75
20.0	20	20.0	1.3	2.0	10.0	20.0	4	R215.H4-20050EAK13P	★	★	☆	20.0	8.0	130.0	3.07



A183



A194



E9



E22



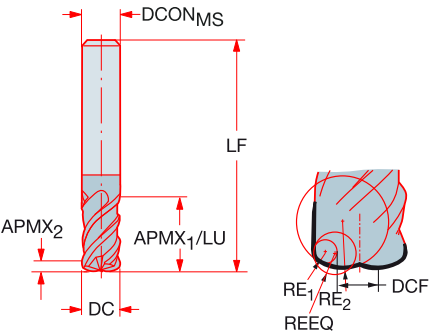
E14

GER

CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Facemilling Bearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA50°
BSGDIN 6527 L
TCDCh9
TCDCONh6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm			
DC	CZC _{MS}	APMX ₁	APMX ₂	RE ₁	RE ₂	LU	ZEP	Bestellnummer	1620	1620	1620	DCON _{MS}	DCF	LF	REEQ
4.0	6	11.0	0.2	0.5	2.0	11.0	4	R215.H4-04050BAC02P	★	★	☆	6.0	1.6	57.0	0.67
6.0	6	15.0	0.3	0.5	3.0	15.0	4	R215.H4-06050BAC03P	★	★	☆	6.0	2.8	57.0	0.75
8.0	8	20.0	0.5	1.0	4.0	20.0	4	R215.H4-08050CAC05P	★	★	☆	8.0	3.1	63.0	1.38
10.0	10	26.0	0.7	1.5	5.0	26.0	4	R215.H4-10050DAC07P	★	★	☆	10.0	3.4	72.0	1.99
12.0	12	30.0	0.8	1.5	6.0	30.0	4	R215.H4-12050DAC08P	★	★	☆	12.0	4.5	83.0	2.10
16.0	16	36.0	1.0	2.0	8.0	36.0	4	R215.H4-16050EAC10P	★	★	☆	16.0	6.2	92.0	2.75
20.0	20	45.0	1.3	2.0	10.0	45.0	4	R215.H4-20050EAC13P	★	★	☆	20.0	8.0	104.0	3.07

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Einsatzbereich

Vielseitiges Konzept mit guter Leistung in den meisten Operation und Anwendungen

Exzellente Wahl für Spiralinterpolation

ISO-Werkstoff



Sorte

1620 1630 1640

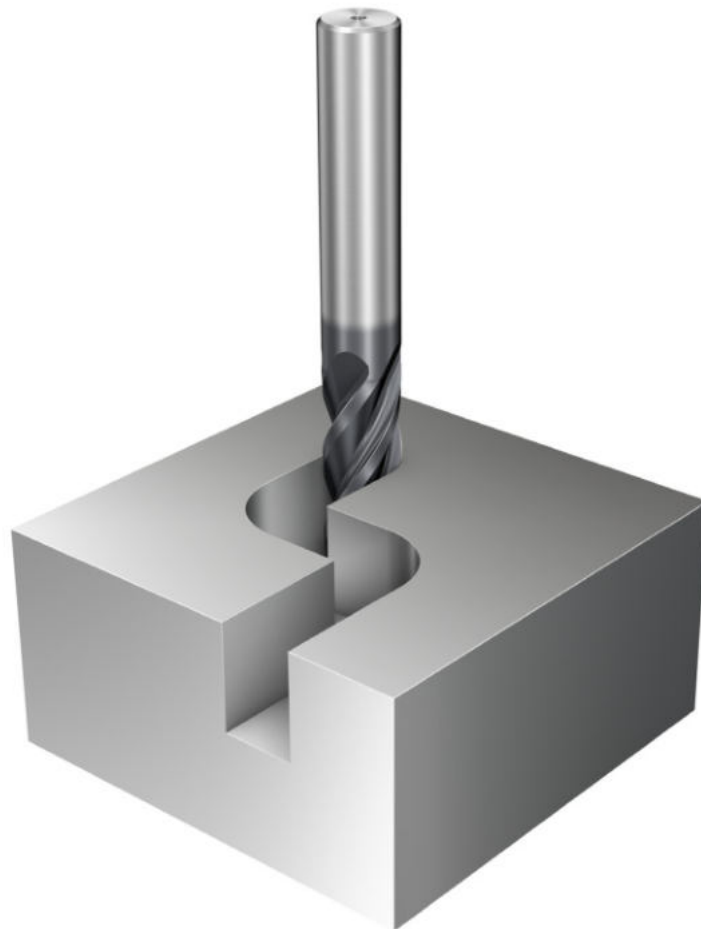
Schaft

Zylindrisch Weldon

Produktbereich

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRC

Für rostfreien Stahl und Stahl mit Härte ≤ 63 HRC

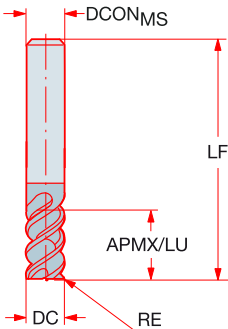
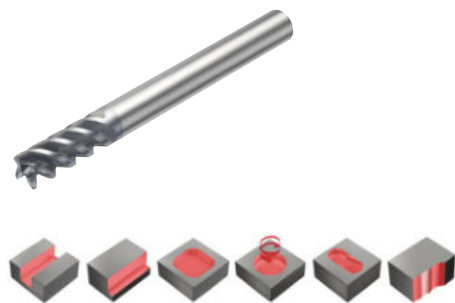


CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für Stahl und gehärteten Stahl mit Härte ≤ 63 HRc

FHA
BSG
TCDC
TCDCON

50°
COROMANT
h9
h6



Metrische Ausführung

							P	H	Abmessungen, mm	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1620	1620	DCON _{MS}	LF
2.0	6	7.0	0.50	7.0	3	R216.23-02050BAK70H	☆	★	6.0	57.0
3.0	6	8.0	0.50	8.0	3	R216.23-03050BAK08H	☆	★	6.0	57.0
4.0	6	11.0	1.00	11.0	3	R216.23-04050CAK11H	☆	★	6.0	57.0
5.0	6	13.0	1.00	13.0	3	R216.23-05050CAK13H	☆	★	6.0	57.0
6.0	6	13.0	1.00	13.0	4	R216.24-06050CAK13H	☆	★	6.0	65.0
8.0	8	19.0	2.00	19.0	4	R216.24-08050EAK19H	☆	★	8.0	80.0
10.0	10	22.0	2.00	22.0	4	R216.24-10050EAK22H	☆	★	10.0	100.0
12.0	12	26.0	3.00	26.0	4	R216.24-12050GAK26H	☆	★	12.0	100.0
14.0	14	26.0	3.00	26.0	4	R216.24-14050GAK26H	☆	★	14.0	104.0
16.0	16	32.0	4.00	32.0	4	R216.24-16050IAK32H	☆	★	16.0	115.0
20.0	20	38.0	4.00	38.0	4	R216.24-20050IAK38H	☆	★	20.0	125.0

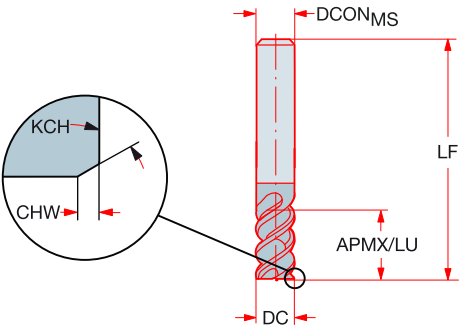
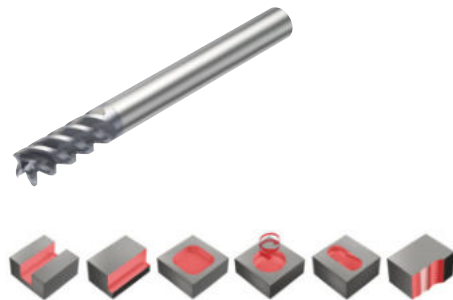
Zoll-Ausführung

							P	H	Abmessungen, Zoll	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1620	1620	DCON _{MS}	LF
.187	1/4	.375	.016	.375	3	RA216.23-1250AAK06H	☆	★	.250	3.000
	1/4	.375	.031	.375	3	RA216.23-1250BAK06H	☆	★	.250	3.000
.250	1/4	.500	.016	.500	4	RA216.24-1650AAK08H	☆	★	.250	3.000
	1/4	.500	.031	.500	4	RA216.24-1650BAK08H	☆	★	.250	3.000
.313	3/8	.625	.016	.625	4	RA216.24-2050AAK10H	☆	★	.375	3.500
	3/8	.625	.031	.625	4	RA216.24-2050BAK10H	☆	★	.375	3.500
.375	3/8	.750	.016	.750	4	RA216.24-2450AAK12H	☆	★	.375	3.500
	3/8	.750	.031	.750	4	RA216.24-2450BAK12H	☆	★	.375	3.500
.500	1/2	1.000	.031	1.000	4	RA216.24-3250BAK16H	☆	★	.500	4.000
	1/2	1.000	.063	1.000	4	RA216.24-3250DAK16H	☆	★	.500	4.000
.625	5/8	1.250	.063	1.250	4	RA216.24-4050DAK20H	☆	★	.625	4.500
.750	3/4	1.500	.063	1.500	4	RA216.24-4850DAK24H	☆	★	.750	5.000

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für Stahl und gehärteten Stahl mit Härte ≤ 63 HRc

FHA 50°
BSG COROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

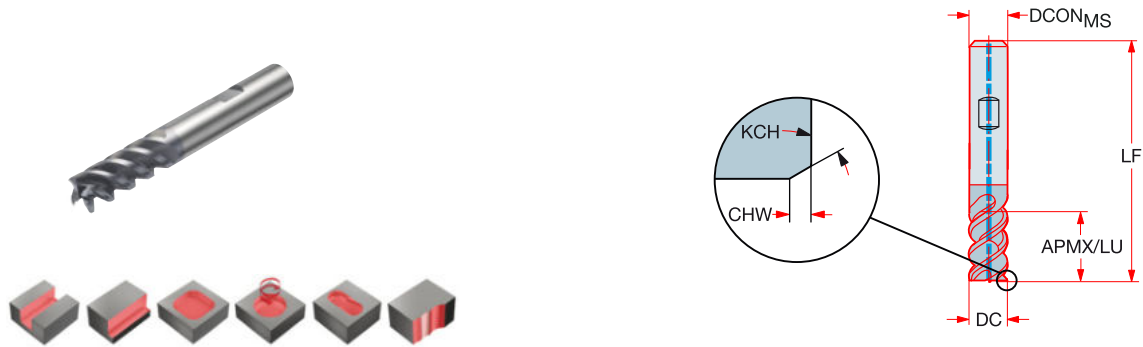
							P	H	Abmessungen, mm	
							1620	1620	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer			
2.0	6	7.0	0.10	45°	7.0	3	R216.33-02050-AK70H		☆	★
3.0	6	8.0	0.10	45°	8.0	3	R216.33-03050-AK08H		☆	★
4.0	6	11.0	0.10	45°	11.0	3	R216.33-04050-AK11H		☆	★
5.0	6	13.0	0.10	45°	13.0	3	R216.33-05050-AK13H		☆	★
6.0	6	13.0	0.10	45°	13.0	4	R216.34-06050-AK13H		☆	★
8.0	8	19.0	0.10	45°	19.0	4	R216.34-08050-AK19H		☆	★
10.0	10	22.0	0.10	45°	22.0	4	R216.34-10050-AK22H		☆	★
12.0	12	26.0	0.10	45°	26.0	4	R216.34-12050-AK26H		☆	★
14.0	14	26.0	0.15	45°	26.0	4	R216.34-14050-AK26H		☆	★
16.0	16	32.0	0.15	45°	32.0	4	R216.34-16050-AK32H		☆	★
20.0	20	38.0	0.15	45°	38.0	4	R216.34-20050-AK38H		☆	★



CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA50°
BSGCOROMANT
TDCDh10
TCDCONh6



Metrische Ausführung

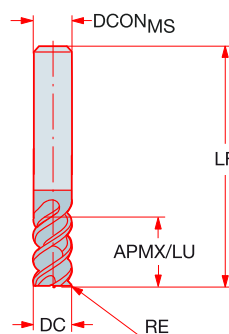
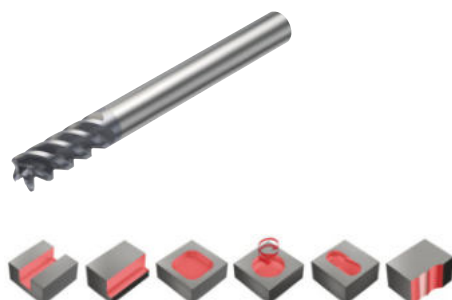
										P	M	K	S	Abmessungen, mm	
										1640	1640	1640	1640	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Bestellnummer	☆	★	☆	★		
6.0	6	13.0	0.10	45°	13.0	1	1	4	R215.34C06050-BC13P	☆	★	☆	★	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	1	1	4	R215.34C08050-BC19P	☆	★	☆	★	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	1	1	4	R215.34C10050-BC22P	☆	★	☆	★	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	1	1	4	R215.34C12050-BC26P	☆	★	☆	★	12.0	83.0
16.0	16	32.0	0.15	45°	32.0	1	1	4	R215.34C16050-BC32P	☆	★	☆	★	16.0	92.0
20.0	20	38.0	0.15	45°	38.0	1	1	4	R215.34C20050-BC38P	☆	★	☆	★	20.0	104.0

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

50°
COROMANT
h9
h6



Metrische Ausführung

							P	M	K	S	Abmessungen, mm				
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1620	1630	1620	1630	1620	1630	DCON _{MS}	LF	
4.0	6	11.0	1.00	11.0	3	R216.23-04050CAK11P	☆	★	☆	☆	☆	★	☆	6.0	57.0
5.0	6	13.0	1.00	13.0	3	R216.23-05050CAK13P	☆	★	☆	☆	☆	★	☆	6.0	57.0
6.0	6	13.0	1.00	13.0	4	R216.24-06050CAK13P	☆	★	☆	☆	☆	★	☆	6.0	65.0
8.0	8	19.0	2.00	19.0	4	R216.24-08050EAK19P	☆	★	☆	☆	☆	★	☆	8.0	80.0
10.0	10	22.0	2.00	22.0	4	R216.24-10050EAK22P	☆	★	☆	☆	☆	★	☆	10.0	100.0
12.0	12	26.0	3.00	26.0	4	R216.24-12050GAK26P	☆	★	☆	☆	☆	★	☆	12.0	100.0
14.0	14	26.0	3.00	26.0	4	R216.24-14050GAK26P	☆	★	☆	☆	☆	★	☆	14.0	104.0
16.0	16	32.0	4.00	32.0	4	R216.24-16050IAK32P	☆	★	☆	☆	☆	★	☆	16.0	115.0
20.0	20	38.0	4.00	38.0	4	R216.24-20050IAK38P	☆	★	☆	☆	☆	★	☆	20.0	125.0

Zoll-Ausführung

							P	M	K	S	Abmessungen, Zoll					
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1620	1630	1620	1630	1620	1630	1620	1630	DCON _{MS}	LF
.187	1/4	.375	.016	.375	3	RA216.23-1250AAK06P	★	★		★		☆		☆	.250	3.000
	1/4	.562	.016	.562	3	RA216.23-1250AAK09P	★		★		☆		☆		.250	3.000
	1/4	.562	.031	.562	3	RA216.23-1250BAK09P	★		★		☆		☆		.250	3.000
.250	1/4	.750	.016	.750	4	RA216.24-1650AAK12P	★		★		☆		☆		.250	3.000
	1/4	.500	.016	.500	4	RA216.24-1650AAK08P		★		★		☆		☆	.250	3.000
	1/4	.750	.031	.750	4	RA216.24-1650BAK12P	★		★		☆		☆		.250	3.000
.313	3/8	1.000	.016	1.000	4	RA216.24-2050AAK15P	★		★		☆		☆		.375	3.500
	3/8	.625	.016	.625	4	RA216.24-2050AAK10P		★		★		☆		☆	.375	3.500
	3/8	1.000	.031	1.000	4	RA216.24-2050BAK15P	★		★		☆		☆		.375	3.500
.375	3/8	.750	.016	.750	4	RA216.24-2450AAK12P		★		★		☆		☆	.375	3.500
	3/8	1.125	.016	1.125	4	RA216.24-2450AAK18P	★		★		☆		☆		.375	3.500
	3/8	1.125	.031	1.125	4	RA216.24-2450BAK18P	★		★		☆		☆		.375	3.500
.500	1/2	1.000	.031	1.000	4	RA216.24-3250BAK16P		★		★		☆		☆	.500	4.000
	1/2	1.500	.031	1.500	4	RA216.24-3250BAK24P	★		★		☆		☆		.500	4.000
	1/2	1.500	.063	1.500	4	RA216.24-3250DAK24P	★		★		☆		☆		.500	4.000
.625	5/8	1.250	.031	1.250	4	RA216.24-4050BAK20P		★		★		☆		☆	.625	4.500
	5/8	1.875	.063	1.875	4	RA216.24-4050DAK30P	★		★		☆		☆		.625	4.500
.750	3/4	1.500	.031	1.500	4	RA216.24-4850BAK24P		★		★		☆		☆	.750	5.000
	3/4	2.250	.063	2.250	4	RA216.24-4850DAK36P	★		★		☆		☆		.750	5.000



A184



A194



E9



E22



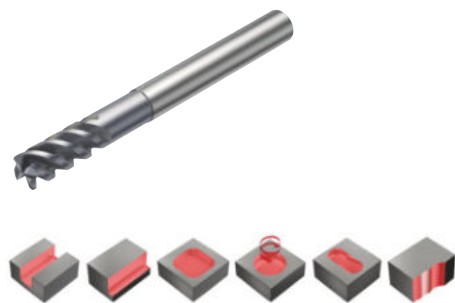
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

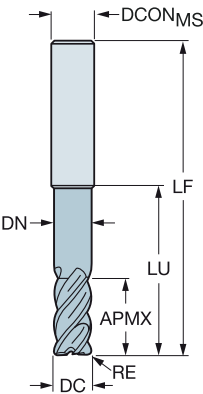
Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRC

FHA
BSG
TCDC
TCDCON

50°
COROMANT
h9
h6



Metrische Ausführung

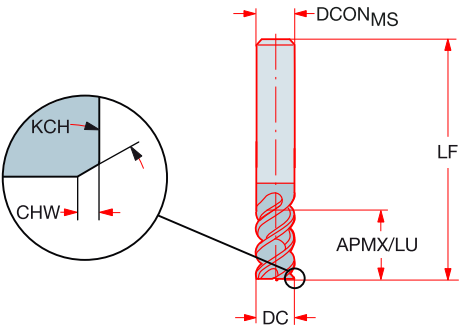
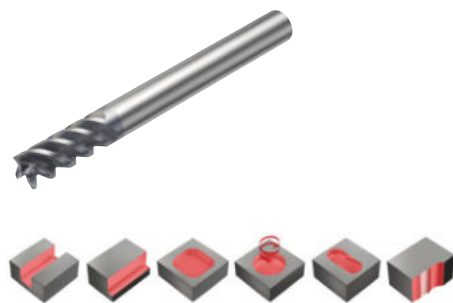


						P	M	K	S	Abmessungen, mm			
						1620	1620	1620	1620				
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer				DCON _{MS}	LF	DN	
10.0	10	22.0	1.00	42.0	4	R216.24-10050CCK22P	★	★	☆	10.0	100.0	9.5	
	10	22.0	1.50	42.0	4	R216.24-10050DCK22P	★	★	☆	10.0	100.0	9.5	
	10	22.0	2.00	42.0	4	R216.24-10050ECK22P	★	★	☆	10.0	100.0	9.5	
	10	22.0	2.50	42.0	4	R216.24-10050FCK22P	★	★	☆	10.0	100.0	9.5	
	10	22.0	3.00	42.0	4	R216.24-10050GCK22P	★	★	☆	10.0	100.0	9.5	
12.0	12	26.0	1.00	53.0	4	R216.24-12050CCK26P	★	★	☆	12.0	100.0	11.4	
	12	26.0	1.50	53.0	4	R216.24-12050DCK26P	★	★	☆	12.0	100.0	11.4	
	12	26.0	2.00	53.0	4	R216.24-12050ECK26P	★	★	☆	12.0	100.0	11.4	
	12	26.0	2.50	53.0	4	R216.24-12050FCK26P	★	★	☆	12.0	100.0	11.4	
	12	26.0	3.00	53.0	4	R216.24-12050GCK26P	★	★	☆	12.0	100.0	11.4	
	12	26.0	3.00	60.0	4	R216.24-12050GCL26P	★	★	☆	12.0	105.0	11.4	
	12	26.0	4.00	53.0	4	R216.24-12050ICK26P	★	★	☆	12.0	100.0	11.4	
16.0	16	36.0	1.00	65.0	4	R216.24-16050CCK36P	★	★	☆	16.0	115.0	15.2	
	16	36.0	1.50	65.0	4	R216.24-16050DCK36P	★	★	☆	16.0	115.0	15.2	
	16	36.0	2.00	65.0	4	R216.24-16050ECK36P	★	★	☆	16.0	115.0	15.2	
	16	36.0	2.50	65.0	4	R216.24-16050FCK36P	★	★	☆	16.0	115.0	15.2	
	16	36.0	3.00	65.0	4	R216.24-16050GCK36P	★	★	☆	16.0	115.0	15.2	
	16	36.0	3.00	80.0	4	R216.24-16050GCL36P	★	★	☆	16.0	128.0	15.2	
	16	36.0	4.00	65.0	4	R216.24-16050ICK36P	★	★	☆	16.0	115.0	15.2	
	16	36.0	6.35	67.0	4	R216.24-16050OCK36P	★	★	☆	16.0	115.0	15.2	
	16	36.0	6.35	80.0	4	R216.24-16050OCL36P	★	★	☆	16.0	128.0	15.2	
20.0	20	44.0	2.50	80.0	4	R216.24-20050FCK44P	★	★	☆	20.0	145.0	19.0	
	20	44.0	3.00	80.0	4	R216.24-20050GCK44P	★	★	☆	20.0	145.0	19.0	
	20	44.0	3.00	100.0	4	R216.24-20050GCL44P	★	★	☆	20.0	150.0	19.0	
	20	44.0	4.00	80.0	4	R216.24-20050ICK44P	★	★	☆	20.0	145.0	19.0	
	20	44.0	6.35	80.0	4	R216.24-20050OCK44P	★	★	☆	20.0	145.0	19.0	
25.0	25	54.0	3.00	98.0	5	R216.25-25050GCK54P	★	★	☆	25.0	155.0	24.0	
	25	54.0	3.00	125.0	5	R216.25-25050GCL54P	★	★	☆	25.0	181.0	23.8	
	25	54.0	4.00	99.0	5	R216.25-25050ICK54P	★	★	☆	25.0	156.0	24.0	
	25	54.0	6.35	99.0	5	R216.25-25050OCK54P	★	★	☆	25.0	156.0	24.0	
	25	54.0	6.35	125.0	5	R216.25-25050OCL54P	★	★	☆	25.0	181.0	24.0	

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA 50°
BSG COROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm			
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1630	1620	1630	1620	1630	DCON _{MS}	LF
4.0	6	11.0	0.10	45°	11.0	3	R216.33-04050-AK11P	★	★	★	★	☆	☆	6.0	57.0
5.0	6	13.0	0.10	45°	13.0	3	R216.33-05050-AK13P	★	★	★	★	☆	☆	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	4	R216.34-06050-AK13P	★	★	★	★	☆	☆	6.0	65.0
8.0	8	19.0	0.10	45°	19.0	4	R216.34-08050-AK19P	★	★	★	★	☆	☆	8.0	80.0
10.0	10	22.0	0.10	45°	22.0	4	R216.34-10050-AK22P	★	★	★	★	☆	☆	10.0	100.0
12.0	12	26.0	0.10	45°	26.0	4	R216.34-12050-AK26P	★	★	★	★	☆	☆	12.0	100.0
14.0	14	26.0	0.15	45°	26.0	4	R216.34-14050-AK26P	★	★	★	★	☆	☆	14.0	104.0
16.0	16	32.0	0.15	45°	32.0	4	R216.34-16050-AK32P	★	★	★	★	☆	☆	16.0	115.0
20.0	20	38.0	0.15	45°	38.0	4	R216.34-20050-AK38P	★	★	★	★	☆	☆	20.0	125.0

A184

A194

E9

E22

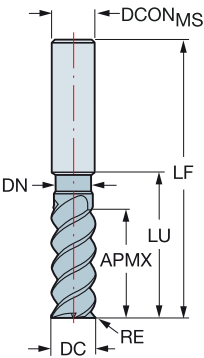
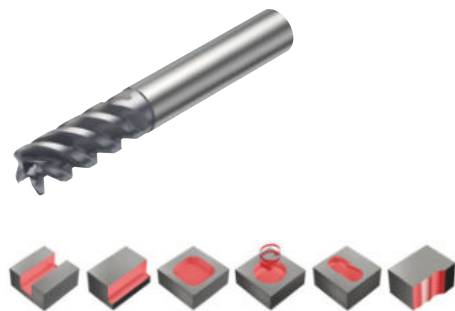
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

50°
COROMANT
h9
h6



Metrische Ausführung

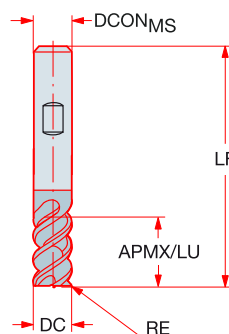
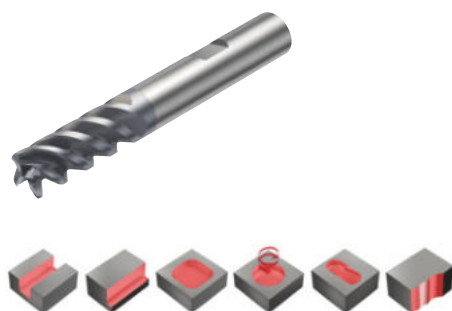
							P	M	K	S	Abmessungen, mm		
							1620	1620	1620	1620	DCON _{MS}	LF	DN
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer							
2.0	6	7.0	0.20	9.5	3	R216.23-02050ACC07P	★	★	☆	☆	6.0	57.0	1.9
3.0	6	8.0	0.30	10.0	3	R216.23-03050ACC08P	★	★	☆	☆	6.0	57.0	2.9
4.0	6	11.0	0.50	15.0	3	R216.23-04050BCC11P	★	★	☆	☆	6.0	57.0	3.8
5.0	6	13.0	0.50	16.0	3	R216.23-05050BCC13P	★	★	☆	☆	6.0	57.0	4.8
6.0	6	13.0	0.50	19.0	4	R216.24-06050BCC13P	★	★	☆	☆	6.0	57.0	5.7
	6	13.0	1.00	19.0	4	R216.24-06050CCC13P	★	★	☆	☆	6.0	57.0	5.7
8.0	8	19.0	0.50	25.0	4	R216.24-08050BCC19P	★	★	☆	☆	8.0	63.0	7.6
	8	19.0	1.00	25.0	4	R216.24-08050CCC19P	★	★	☆	☆	8.0	63.0	7.6
	8	19.0	1.50	25.0	4	R216.24-08050DCC19P	★	★	☆	☆	8.0	63.0	7.6
	8	19.0	2.00	25.0	4	R216.24-08050ECC19P	★	★	☆	☆	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	4	R216.24-10050BCC22P	★	★	☆	☆	10.0	72.0	9.5
	10	22.0	1.00	30.0	4	R216.24-10050CCC22P	★	★	☆	☆	10.0	72.0	9.5
	10	22.0	1.50	30.0	4	R216.24-10050DCC22P	★	★	☆	☆	10.0	72.0	9.5
	10	22.0	2.00	30.0	4	R216.24-10050ECC22P	★	★	☆	☆	10.0	72.0	9.5
12.0	12	26.0	0.50	36.0	4	R216.24-12050BCC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	1.00	36.0	4	R216.24-12050CCC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	1.50	36.0	4	R216.24-12050DCC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	2.00	36.0	4	R216.24-12050ECC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	2.50	36.0	4	R216.24-12050FCC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	3.00	36.0	4	R216.24-12050GCC26P	★	★	☆	☆	12.0	83.0	11.4
16.0	16	32.0	0.50	42.0	4	R216.24-16050BCC32P	★	★	☆	☆	16.0	92.0	15.2
	16	32.0	1.00	42.0	4	R216.24-16050CCC32P	★	★	☆	☆	16.0	92.0	15.2
	16	32.0	2.00	42.0	4	R216.24-16050ECC32P	★	★	☆	☆	16.0	92.0	15.2
	16	32.0	2.50	42.0	4	R216.24-16050FCC32P	★	★	☆	☆	16.0	92.0	15.2
	16	32.0	4.00	42.0	4	R216.24-16050ICC32P	★	★	☆	☆	16.0	92.0	15.2
20.0	20	38.0	1.00	52.0	4	R216.24-20050CCC38P	★	★	☆	☆	20.0	104.0	19.0
	20	38.0	2.00	52.0	4	R216.24-20050ECC38P	★	★	☆	☆	20.0	104.0	19.0
	20	44.0	2.50	80.0	4	R216.24-20050FCC44P	★	★	☆	☆	20.0	130.0	19.0
	20	38.0	2.50	52.0	4	R216.24-20050FCC38P	★	★	☆	☆	20.0	104.0	19.0
	20	44.0	3.00	80.0	4	R216.24-20050GCC44P	★	★	☆	☆	20.0	130.0	19.0
	20	38.0	3.00	52.0	4	R216.24-20050GCC38P	★	★	☆	☆	20.0	104.0	19.0
	20	44.0	4.00	80.0	4	R216.24-20050ICC44P	★	★	☆	☆	20.0	130.0	19.0
	20	38.0	4.00	52.0	4	R216.24-20050ICC38P	★	★	☆	☆	20.0	104.0	19.0
	20	44.0	6.35	80.0	4	R216.24-20050OCC44P	★	★	☆	☆	20.0	104.0	19.0

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

50°
DIN 6527 L
h9
h6

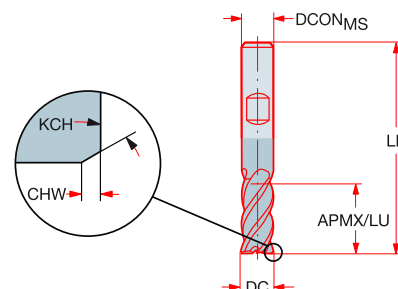
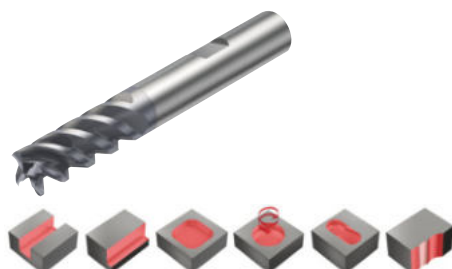


Metrische Ausführung

								P	M	K	S	Abmessungen, mm				
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1620	1630	1620	1630	1620	1630	1620	1630	DCON _{MS}	LF
6.0	6	13.0	1.00	13.0	4	R216.24-06050CBC13P	☆	★	★	☆	★	★	☆	☆	6.0	57.0
8.0	8	19.0	2.00	19.0	4	R216.24-08050EBC19P	☆	★	★	☆	★	★	☆	☆	8.0	63.0
10.0	10	22.0	2.00	22.0	4	R216.24-10050EBC22P	☆	★	★	☆	★	★	☆	☆	10.0	72.0
12.0	12	26.0	3.00	26.0	4	R216.24-12050GBC26P	☆	★	★	☆	★	★	☆	☆	12.0	83.0
14.0	14	26.0	3.00	26.0	4	R216.24-14050GBC26P		★		☆	★		☆		14.0	83.0
16.0	16	32.0	4.00	32.0	4	R216.24-16050IBC32P	☆	★	★	☆	★	★	☆	☆	16.0	92.0
20.0	20	38.0	4.00	38.0	4	R216.24-20050IBC38P	☆	★	★	☆	★	★	☆	☆	20.0	104.0

FHA
BSG
TCDC
TCDCON

50°
DIN 6527 L
h10
h6



Metrische Ausführung

								P			M		K		S		Abmessungen, mm				
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1630	1640	1620	1630	1640	1620	1630	1640	1620	1630	1640	DCON _{MS}	LF
6.0	6	13.0	0.10	45°	13.0	4	R216.34-06050-BC13P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	4	R216.34-08050-BC19P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	4	R216.34-10050-BC22P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	4	R216.34-12050-BC26P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	12.0	83.0
14.0	14	26.0	0.15	45°	26.0	4	R216.34-14050-BC26P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	14.0	83.0
16.0	16	32.0	0.15	45°	32.0	4	R216.34-16050-BC32P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	16.0	92.0
20.0	20	38.0	0.15	45°	38.0	4	R216.34-20050-BC38P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	20.0	104.0



A184



A194



E9



E22



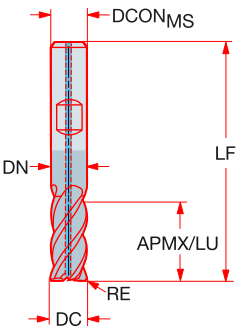
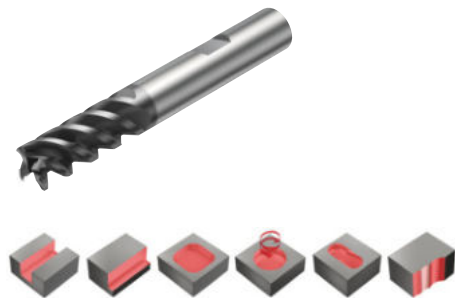
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für Nickelbasislegierungen

FHA
BSG
TCDC
TCDCON

50°
DIN 6527 L
h9
h6



Metrische Ausführung

									S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer		1725	DCON _{MS}	LF
6.0	6	13.0	0.50	19.0	1	1	4	2F440-0600-050ASD	★	6.0	57.0	5.7
	6	13.0	1.00	19.0	1	1	4	2F440-0600-100ASD	★	6.0	57.0	5.7
8.0	8	19.0	0.50	25.0	1	1	4	2F440-0800-050ASD	★	8.0	63.0	7.6
	8	19.0	1.00	25.0	1	1	4	2F440-0800-100ASD	★	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	1	1	4	2F440-1000-050ASD	★	10.0	72.0	9.5
	10	22.0	1.00	30.0	1	1	4	2F440-1000-100ASD	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	1	1	4	2F440-1000-200ASD	★	10.0	72.0	9.5
12.0	12	26.0	0.50	36.0	1	1	4	2F440-1200-050ASD	★	12.0	83.0	11.4
	12	26.0	1.00	36.0	1	1	4	2F440-1200-100ASD	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	1	1	4	2F440-1200-200ASD	★	12.0	83.0	11.4
16.0	16	32.0	2.00	42.0	1	1	4	2F440-1600-200ASD	★	16.0	92.0	15.2
	16	32.0	3.00	42.0	1	1	4	2F440-1600-300ASD	★	16.0	92.0	15.2
	16	32.0	4.00	42.0	1	1	4	2F440-1600-400ASD	★	16.0	92.0	15.2
20.0	20	38.0	3.00	52.0	1	1	4	2F440-2000-300ASD	★	20.0	104.0	19.0
	20	38.0	4.00	52.0	1	1	4	2F440-2000-400ASD	★	20.0	104.0	19.0
	20	38.0	6.35	52.0	1	1	4	2F440-2000-635ASD	★	20.0	104.0	19.0

Zoll-Ausführung

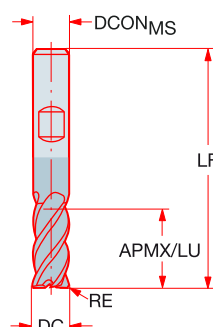
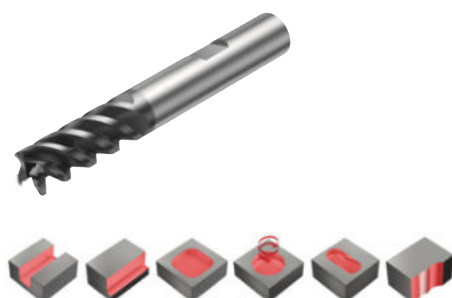
									S	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer	1725	DCON _{MS}	LF	DN
.250	1/4	.625	.030	.875	1	1	4	2F440-0635-076ASD	★	.250	2.500	.237
	1/4	.625	.060	.875	1	1	4	2F440-0635-152ASD	★	.250	2.500	.237
.375	3/8	.781	.030	1.156	1	1	4	2F440-0953-076ASD	★	.375	3.000	.356
	3/8	.781	.060	1.156	1	1	4	2F440-0953-152ASD	★	.375	3.000	.356
	3/8	.781	.090	1.156	1	1	4	2F440-0953-228ASD	★	.375	3.000	.356
.500	1/2	1.125	.030	1.438	1	1	4	2F440-1270-076ASD	★	.500	3.500	.475
	1/2	1.125	.060	1.438	1	1	4	2F440-1270-152ASD	★	.500	3.500	.475
	1/2	1.125	.090	1.438	1	1	4	2F440-1270-228ASD	★	.500	3.500	.475
	1/2	1.125	.120	1.438	1	1	4	2F440-1270-304ASD	★	.500	3.500	.475
.625	5/8	1.313	.030	1.563	1	1	4	2F440-1588-076ASD	★	.625	3.750	.594
	5/8	1.313	.060	1.563	1	1	4	2F440-1588-152ASD	★	.625	3.750	.594
	5/8	1.313	.090	1.563	1	1	4	2F440-1588-228ASD	★	.625	3.750	.594
	5/8	1.313	.120	1.563	1	1	4	2F440-1588-304ASD	★	.625	3.750	.594
.750	3/4	1.625	.030	1.937	1	1	4	2F440-1905-076ASD	★	.750	4.250	.713
	3/4	1.625	.060	1.937	1	1	4	2F440-1905-152ASD	★	.750	4.250	.713
	3/4	1.625	.090	1.937	1	1	4	2F440-1905-228ASD	★	.750	4.250	.713
	3/4	1.625	.120	1.937	1	1	4	2F440-1905-304ASD	★	.750	4.250	.713

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für Nickelbasislegierungen

FHA
BSG
TCDC
TCDCON

50°
DIN 6527 L
h9
h6



Metrische Ausführung

						s Abmessungen, mm	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1725
2.0	6	7.0	0.20	9.5	3	2S440-0200-020-SD	★
3.0	6	8.0	0.30	10.0	3	2S440-0300-030-SD	★
4.0	6	11.0	0.50	15.0	3	2S440-0400-050-SD	★
5.0	6	13.0	0.50	16.0	3	2S440-0500-050-SD	★
6.0	6	13.0	0.50	19.0	4	2S440-0600-050-SD	★
	6	13.0	1.00	19.0	4	2S440-0600-100-SD	★
8.0	8	19.0	0.50	25.0	4	2S440-0800-050-SD	★
	8	19.0	1.00	25.0	4	2S440-0800-100-SD	★
10.0	10	22.0	0.50	30.0	4	2S440-1000-050-SD	★
	10	22.0	1.00	30.0	4	2S440-1000-100-SD	★
	10	22.0	2.00	30.0	4	2S440-1000-200-SD	★
12.0	12	26.0	0.50	36.0	4	2S440-1200-050-SD	★
	12	26.0	1.00	36.0	4	2S440-1200-100-SD	★
	12	26.0	2.00	36.0	4	2S440-1200-200-SD	★
16.0	16	32.0	2.00	42.0	4	2S440-1600-200-SD	★
	16	32.0	3.00	42.0	4	2S440-1600-300-SD	★
	16	32.0	4.00	42.0	4	2S440-1600-400-SD	★
20.0	20	38.0	3.00	52.0	4	2S440-2000-300-SD	★
	20	38.0	4.00	52.0	4	2S440-2000-400-SD	★
	20	38.0	6.35	52.0	4	2S440-2000-635-SD	★

Zoll-Ausführung

						s Abmessungen, Zoll	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1725
.250	1/4	.625	.030	.875	4	2S440-0635-076-SD	★
	1/4	.625	.060	.875	4	2S440-0635-152-SD	★
.375	3/8	.781	.030	1.156	4	2S440-0953-076-SD	★
	3/8	.781	.060	1.156	4	2S440-0953-152-SD	★
	3/8	.781	.090	1.156	4	2S440-0953-228-SD	★
.500	1/2	1.125	.030	1.438	4	2S440-1270-076-SD	★
	1/2	1.125	.060	1.438	4	2S440-1270-152-SD	★
	1/2	1.125	.090	1.438	4	2S440-1270-228-SD	★
	1/2	1.125	.120	1.438	4	2S440-1270-304-SD	★
.625	5/8	1.313	.030	1.563	4	2S440-1588-076-SD	★
	5/8	1.313	.060	1.563	4	2S440-1588-152-SD	★
	5/8	1.313	.090	1.563	4	2S440-1588-228-SD	★
	5/8	1.313	.120	1.563	4	2S440-1588-304-SD	★
.750	3/4	1.625	.030	1.937	4	2S440-1905-076-SD	★
	3/4	1.625	.060	1.937	4	2S440-1905-152-SD	★
	3/4	1.625	.090	1.937	4	2S440-1905-228-SD	★
	3/4	1.625	.120	1.937	4	2S440-1905-304-SD	★



A184



A194



E9



E22

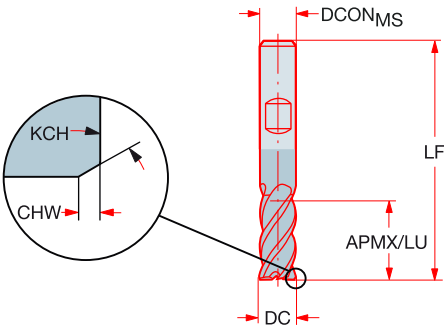
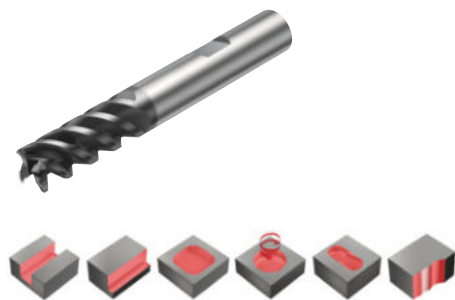


E14

CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Für Nickelbasislegierungen

FHA50°
BSGDIN 6527 L
TCDC h9
TCDCON h6



Metrische Ausführung

								s	Abmessungen, mm	
								1725	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer			
6.0	6	13.0	0.10	45°	19.0	4	2P440-0600-SD	★	6.0	57.0
8.0	8	19.0	0.10	45°	25.0	4	2P440-0800-SD	★	8.0	63.0
10.0	10	22.0	0.10	45°	30.0	4	2P440-1000-SD	★	10.0	72.0
12.0	12	26.0	0.10	45°	36.0	4	2P440-1200-SD	★	12.0	83.0
16.0	16	32.0	0.15	45°	42.0	4	2P440-1600-SD	★	16.0	92.0
20.0	20	38.0	0.15	45°	52.0	4	2P440-2000-SD	★	20.0	104.0

CoroMill® Plura Vollhartmetall-Schaftfräser für die Hartbearbeitung

Einsatzbereich

Erste Wahl zum Schrappen bis Vorschlichten in gehärteten Werkstoffen bei stabilen Bedingungen

Einsatz für die Trockenbearbeitung

ISO-Werkstoff



Sorte

1610

Schaft

Zylindrisch

Produktbereich

Für gehärteten Stahl mit Härte $43 \leq \text{HRc} \leq 63$

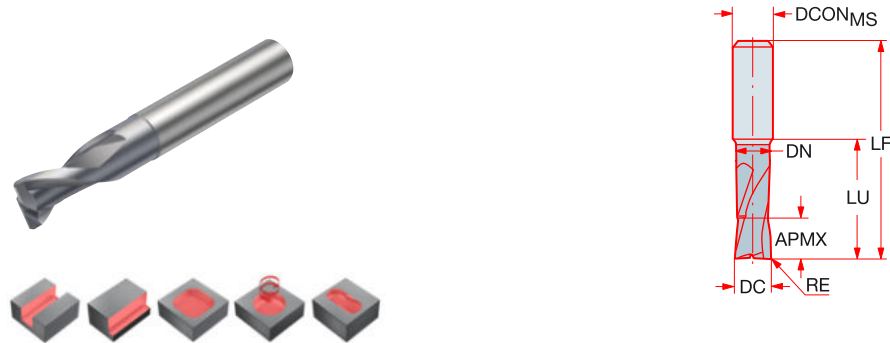


CoroMill® Plura Vollhartmetall-Schaftfräser für die Hartbearbeitung

Für gehärteten Stahl mit Härte 43≤ HRc ≤63

FHA
BSG
TCDC
TCDCON

30°
COROMANT
h9
h6



Metrische Ausführung

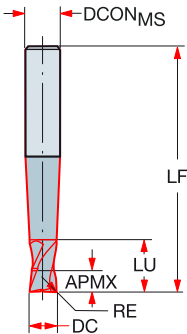
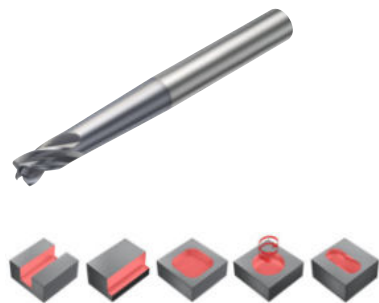
							P	H	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1610	1610	DCON _{MS}	LF	DN
2.0	6	2.0	0.20	2.0	2	R216.22-02030AAI20G	☆	★	6.0	57.0	
	6	2.0	0.20	20.0	2	R216.22-02030AAJ20G	☆	★	6.0	75.0	1.9
3.0	6	3.0	0.30	20.0	2	R216.22-03030AAJ03G	☆	★	6.0	72.0	2.9
	6	3.0	0.50	3.0	2	R216.22-03030BAI03G	☆	★	6.0	57.0	
4.0	6	4.0	0.40	20.0	4	R216.24-04030AAJ04G	☆	★	6.0	72.0	3.8
	6	4.0	0.50	4.0	2	R216.22-04030BAI04G	☆	★	6.0	57.0	
5.0	6	5.0	0.50	20.0	2	R216.22-05030BAI05G	☆	★	6.0	57.0	4.9
	6	5.0	0.50	20.0	4	R216.24-05030BAJ05G	☆	★	6.0	72.0	4.8
6.0	6	6.0	0.50	24.0	4	R216.24-06030BAJ06G	☆	★	6.0	72.0	5.7
	6	6.0	1.00	21.0	2	R216.22-06030CAI06G	☆	★	6.0	63.0	5.7
	6	6.0	1.00	21.0	4	R216.24-06030CAI06G	☆	★	6.0	57.0	5.7
8.0	8	8.0	0.50	29.0	4	R216.24-08030BAJ08G	☆	★	8.0	80.0	7.9
	8	8.0	1.00	27.0	2	R216.22-08030CAI08G	☆	★	8.0	72.0	7.7
	8	8.0	1.00	27.0	4	R216.24-08030CAI08G	☆	★	8.0	63.0	7.7
	8	8.0	1.00	29.0	4	R216.24-08030CAJ08G	☆	★	8.0	80.0	7.9
	8	8.0	1.50	29.0	4	R216.24-08030DAJ08G	☆	★	8.0	80.0	7.9
10.0	10	10.0	0.50	35.0	4	R216.24-10030BAJ10G	☆	★	10.0	100.0	9.9
	10	10.0	1.00	35.0	4	R216.24-10030CAJ10G	☆	★	10.0	100.0	9.9
	10	10.0	1.50	32.0	2	R216.22-10030DAH10G	☆	★	10.0	72.0	9.7
	10	10.0	1.50	32.0	4	R216.24-10030DAH10G	☆	★	10.0	72.0	9.7
12.0	12	12.0	0.50	36.0	4	R216.24-12030BAJ12G	☆	★	12.0	100.0	11.8
	12	12.0	1.00	36.0	4	R216.24-12030CAJ12G	☆	★	12.0	100.0	11.8
	12	12.0	1.50	36.0	2	R216.22-12030DAH12G	☆	★	12.0	83.0	11.8
	12	12.0	1.50	36.0	4	R216.24-12030DAH12G	☆	★	12.0	83.0	11.8
	12	12.0	2.00	36.0	4	R216.24-12030EAJ12G	☆	★	12.0	100.0	11.8
16.0	16	16.0	2.00	42.0	4	R216.24-16030EAI16G	☆	★	16.0	92.0	15.8

CoroMill® Plura Vollhartmetall-Schaftfräser für die Hartbearbeitung

Für gehärteten Stahl mit Härte 43≤ HRc ≤63

FHA
BSG
TCDC
TCDCON

30°
COROMANT
h9
h6



Metrische Ausführung

							P	H	Abmessungen, mm	
							1610	1610	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	☆	★		
3.0	6	3.0	0.50	4.0	2	R216.22-03030BAP03G	☆	★	6.0	80.0
4.0	6	4.0	0.50	5.0	2	R216.22-04030BAP04G	☆	★	6.0	90.0
6.0	8	6.0	0.50	7.0	2	R216.22-06030BAP06G	☆	★	8.0	100.0
	8	6.0	1.00	7.0	4	R216.24-06030CAP06G	☆	★	8.0	100.0
8.0	10	8.0	1.00	10.0	4	R216.24-08030CAP08G	☆	★	10.0	100.0
10.0	12	10.0	1.00	15.0	4	R216.24-10030CAP10G	☆	★	12.0	125.0
	12	10.0	3.00	12.0	4	R216.24-10030GAP10G	☆	★	12.0	125.0
12.0	14	12.0	1.00	14.0	4	R216.24-12030CAP12G	☆	★	14.0	140.0
16.0	16	16.0	1.00	16.0	4	R216.24-16030CAP16G	☆	★	16.0	150.0
	16	16.0	3.00	16.0	4	R216.24-16030GAP16G	☆	★	16.0	150.0

A185

A194

E9

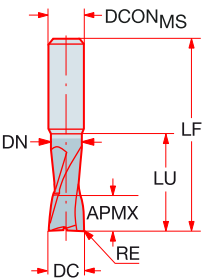
E22

E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Hartbearbeitung

Für gehärteten Stahl mit Härte 43≤ HRc ≤63

FHA30°
BSGCOROMANT
TCDC h9
TCDCON h6



Zoll-Ausführung

						P	H	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer		DCON _{MS}	LF	DN
.125	1/4	.125	.031	.750	4	RA216.24-0830BAK02G	☆★	.250	3.000	.121
.156	1/4	.156	.031	.750	4	RA216.24-1030BAK02G	☆★	.250	3.000	.137
.188	1/4	.188	.063	.750	4	RA216.24-1230DAK03G	☆★	.250	3.000	.183
.250	1/4	.250	.063	1.000	4	RA216.24-1630DAK04G	☆★	.250	3.000	.246
.375	3/8	.375	.063	1.250	4	RA216.24-2430DAK06G	☆★	.375	3.500	.369

CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N

Einsatzbereich

Erste Wahl zum Schruppen in Aluminium, Graphit und bei der Bearbeitung von Thermoplast

Produktbereich

Für NE-Metalle

Für NE-Metalle mit Siliziumgehalt > 9%

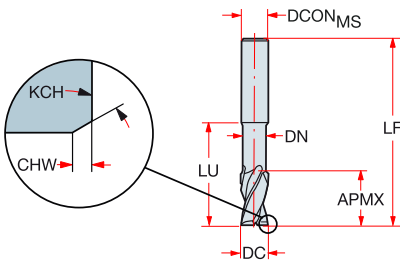
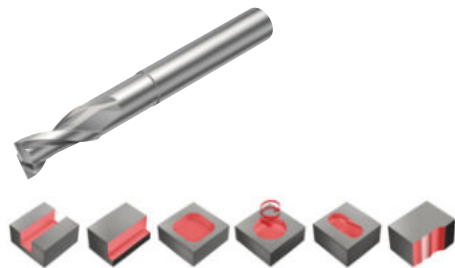
ISO-Werkstoff	N	O
Sorte	H10F	N20C
Schaft	Zylindrisch	Reduziert



CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N
Für NE-Metalle

FHA
BSG
TCDC
TCDCON

25°
COROMANT
h10
h6

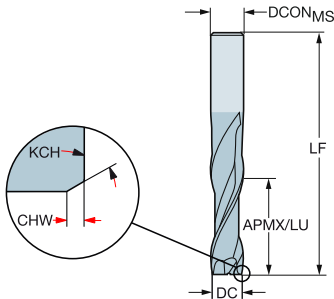
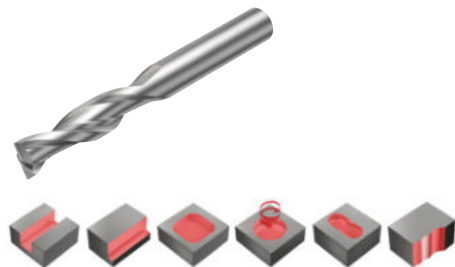


Metrische Ausführung

								N	Abmessungen, mm		
								H10F			
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer		DCON _{MS}	LF	DN
2.0	3	3.0			9.0	2	2P120-0200-NC	★	3.0	38.0	1.9
3.0	3	4.0			12.0	2	2P120-0300-NC	★	3.0	38.0	2.9
4.0	4	6.0			14.0	2	2P120-0400-NC	★	4.0	50.0	3.8
5.0	6	8.0			16.0	2	2P120-0500-NC	★	6.0	57.0	4.8
6.0	6	10.0			28.0	2	2P120-0600-NC	★	6.0	65.0	5.7
8.0	8	12.0			35.0	2	2P120-0800-NC	★	8.0	80.0	7.6
10.0	10	14.0	0.10	45°	45.0	2	2P120-1000-NC	★	10.0	90.0	9.5
12.0	12	16.0	0.10	45°	50.0	2	2P120-1200-NC	★	12.0	100.0	11.4
16.0	16	20.0	0.15	45°	63.0	2	2P120-1600-NC	★	16.0	115.0	15.2
20.0	20	20.0	0.15	45°	70.0	2	2P120-2000-NC	★	20.0	125.0	19.0

FHA
BSG
TCDC
TCDCON

25°
COROMANT
h10
h6



Metrische Ausführung

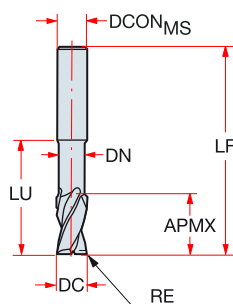
								N	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	H _{10F}	DCON _{MS}	LF
2.0	3	8.0			8.0	2	2P160-0200-NA	★	3.0	38.0
3.0	3	12.0			12.0	2	2P160-0300-NA	★	3.0	38.0
4.0	4	14.0			14.0	2	2P160-0400-NA	★	4.0	50.0
5.0	6	16.0			16.0	2	2P160-0500-NA	★	6.0	57.0
6.0	6	22.0			22.0	2	2P160-0600-NA	★	6.0	65.0
8.0	8	28.0			28.0	2	2P160-0800-NA	★	8.0	80.0
10.0	10	32.0	0.10	45°	32.0	2	2P160-1000-NA	★	10.0	90.0
12.0	12	38.0	0.10	45°	38.0	2	2P160-1200-NA	★	12.0	100.0

CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N

Für NE-Metalle

FHA
BSG
TCDC
TCDCON

25°
COROMANT
h10
h6



Metrische Ausführung

						N	Abmessungen, mm		
						H10F	DCON _{MS}	LF	DN
2.0	3	3.0	0.15	5.0	2	★	3.0	38.0	1.8
	3	3.0	0.15	8.0	2	★	3.0	50.0	1.8
3.0	3	4.5	0.15	9.0	2	★	3.0	38.0	2.7
	3	4.5	0.15	12.0	2	★	3.0	50.0	2.7
4.0	4	6.0	0.15	12.0	2	★	4.0	50.0	3.7
	4	6.0	0.15	16.0	2	★	4.0	60.0	3.7
5.0	5	7.5	0.15	15.0	2	★	5.0	50.0	4.7
	5	7.5	0.15	20.0	2	★	5.0	60.0	4.6
6.0	6	9.0	0.15	18.0	2	★	6.0	57.0	5.7
	6	9.0	0.15	24.0	2	★	6.0	65.0	5.5
8.0	8	12.0	0.15	24.0	2	★	8.0	63.0	7.7
	8	12.0	0.15	32.0	2	★	8.0	80.0	7.4
10.0	10	15.0	0.15	30.0	2	★	10.0	72.0	9.7
	10	15.0	0.15	40.0	2	★	10.0	89.0	9.2
12.0	12	18.0	0.15	36.0	2	★	12.0	83.0	11.7
	12	18.0	0.15	48.0	2	★	12.0	100.0	11.0
14.0	14	21.0	0.15	42.0	2	★	14.0	83.0	13.7
16.0	16	24.0	0.15	48.0	2	★	16.0	92.0	15.7
	16	24.0	0.15	64.0	2	★	16.0	120.0	15.0
20.0	20	30.0	0.15	60.0	2	★	20.0	104.0	19.7
	20	30.0	0.15	80.0	2	★	20.0	150.0	19.0



A187



A194



E9



E22

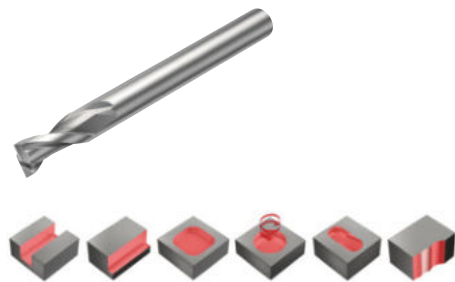


E14

CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N

Für NE-Metalle

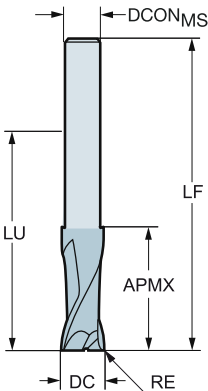
B



Metrische Ausführung

FHA
BSG
TCDC
TCDCON

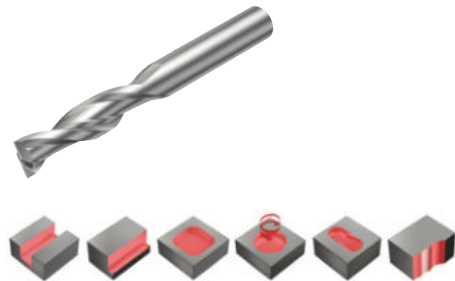
25°
COROMANT
h10
h6



C

							N	Abmessungen, mm	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	ISO	DCON _{MS}	LF
3.0	2	4.0	0.15	32.0	2	2P123-0300-NG	★	2.9	60.0
4.0	3	5.0	0.15	32.0	2	2P123-0400-NG	★	3.8	60.0
5.0	4	8.0	0.15	42.0	2	2P123-0500-NG	★	4.8	70.0
6.0	5	9.0	0.15	64.0	2	2P123-0600-NG	★	5.8	100.0
8.0	7	11.0	0.15	64.0	2	2P123-0800-NG	★	7.8	100.0
10.0	9	15.0	0.15	60.0	2	2P123-1000-NG	★	9.7	100.0
12.0	11	17.0	0.15	80.0	2	2P123-1200-NG	★	11.7	125.0
16.0	15	23.0	0.15	77.0	2	2P123-1600-NG	★	15.7	125.0
20.0	19	26.0	0.15	100.0	2	2P123-2000-NG	★	19.7	150.0

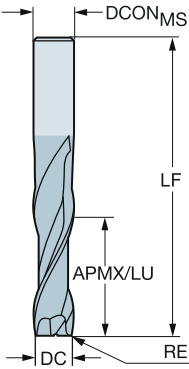
D



Metrische Ausführung

FHA
BSG
TCDC
TCDCON

25°
COROMANT
h10
h6



E

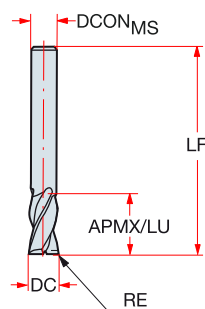
							N	Abmessungen, mm	
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	ISO	DCON _{MS}	LF
2.0	3	8.0	0.15	8.0	2	2P170-0200-NA	★	3.0	50.0
3.0	3	12.0	0.15	12.0	2	2P170-0300-NA	★	3.0	50.0
4.0	4	16.0	0.15	16.0	2	2P170-0400-NA	★	4.0	60.0
5.0	5	20.0	0.15	20.0	2	2P170-0500-NA	★	5.0	60.0
6.0	6	24.0	0.15	24.0	2	2P170-0600-NA	★	6.0	65.0
7.0	7	28.0	0.15	28.0	2	2P170-0700-NA	★	7.0	79.0
8.0	8	32.0	0.15	32.0	2	2P170-0800-NA	★	8.0	79.0
9.0	9	36.0	0.15	36.0	2	2P170-0900-NA	★	9.0	88.0
10.0	10	40.0	0.15	40.0	2	2P170-1000-NA	★	10.0	88.0
12.0	12	48.0	0.15	48.0	2	2P170-1200-NA	★	12.0	99.0
14.0	14	56.0	0.15	56.0	2	2P170-1400-NA	★	14.0	105.0
16.0	16	64.0	0.15	64.0	2	2P170-1600-NA	★	16.0	120.0
20.0	20	80.0	0.15	80.0	2	2P170-2000-NA	★	20.0	150.0

CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N

Für NE-Metalle

FHA
BSG
TCDC
TCDCON

30°
COROMANT
h10
h6



Metrische Ausführung

						N	Abmessungen, mm	
						H10F	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer		
2.0	3	4.0	0.15	4.0	2	2P232-0200-NA	★	3.0 38.0
3.0	3	5.0	0.15	5.0	2	2P232-0300-NA	★	3.0 38.0
4.0	4	7.0	0.15	7.0	2	2P232-0400-NA	★	4.0 50.0
5.0	5	9.0	0.15	9.0	2	2P232-0500-NA	★	5.0 50.0
6.0	6	18.0	0.15	18.0	2	2P232-0600-NA	★	6.0 57.0
7.0	7	18.0	0.15	18.0	2	2P232-0700-NA	★	7.0 60.0
8.0	8	18.0	0.15	18.0	2	2P232-0800-NA	★	8.0 63.0
9.0	9	20.0	0.15	20.0	2	2P232-0900-NA	★	9.0 67.0
10.0	10	22.0	0.15	22.0	2	2P232-1000-NA	★	10.0 72.0
12.0	12	22.0	0.15	22.0	2	2P232-1200-NA	★	12.0 83.0
14.0	14	25.0	0.15	25.0	2	2P232-1400-NA	★	14.0 83.0
16.0	16	29.0	0.15	29.0	2	2P232-1600-NA	★	16.0 92.0
18.0	18	33.0	0.15	33.0	2	2P232-1800-NA	★	18.0 92.0
20.0	20	36.0	0.15	36.0	2	2P232-2000-NA	★	20.0 104.0



A187



A194



E9



E22



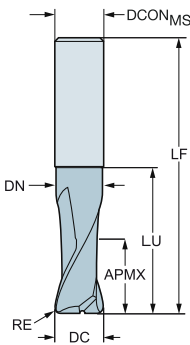
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N

Für NE-Metalle

FHA
BSG
TCDC
TCDCON

30°
COROMANT
h10
h6

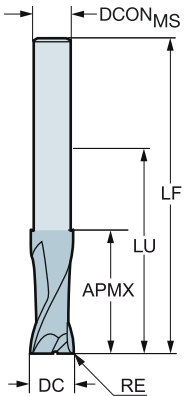


Metrische Ausführung

							N	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	H _{10F}	DCON _{MS}	LF	DN
3.0	3	4.5	0.20	8.0	2	2S220-0300-020-NC	★	3.0	38.0	2.7
4.0	4	6.0	0.30	11.0	2	2S220-0400-030-NC	★	4.0	50.0	3.7
5.0	5	7.5	0.50	14.0	2	2S220-0500-050-NC	★	5.0	50.0	4.7
6.0	6	9.0	1.00	17.0	2	2S220-0600-100-NC	★	6.0	57.0	5.7
8.0	8	12.0	1.00	23.0	2	2S220-0800-100-NC	★	8.0	63.0	7.7
10.0	10	15.0	1.50	29.0	2	2S220-1000-150-NC	★	10.0	72.0	9.7
12.0	12	18.0	1.50	35.0	2	2S220-1200-150-NC	★	12.0	83.0	11.7
16.0	16	24.0	2.00	47.0	2	2S220-1600-200-NC	★	16.0	92.0	15.7

FHA
BSG
TCDC
TCDCON

30°
COROMANT
h10
h6

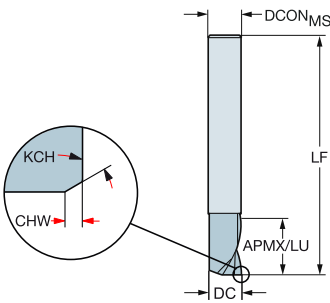
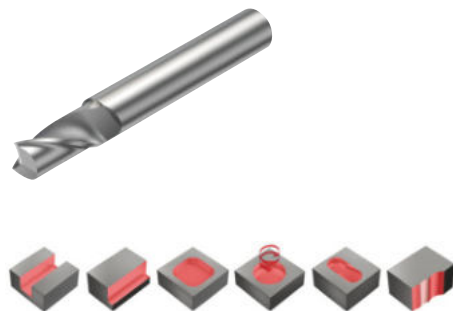


Metrische Ausführung

						N	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	H ₁₀	DCON _{MS}	LF
3.0	2	4.0	0.20	32.0	2	2S221-0300-020-NG	★	2.9	60.0
4.0	3	5.0	0.30	32.0	2	2S221-0400-030-NG	★	3.8	60.0
5.0	4	8.0	0.50	42.0	2	2S221-0500-050-NG	★	4.8	70.0
6.0	5	9.0	1.00	64.0	2	2S221-0600-100-NG	★	5.8	100.0
8.0	7	13.0	1.00	64.0	2	2S221-0800-100-NG	★	7.8	100.0
10.0	9	15.0	1.50	60.0	2	2S221-1000-150-NG	★	9.7	100.0
12.0	11	17.0	1.50	80.0	2	2S221-1200-150-NG	★	11.7	125.0
16.0	15	23.0	2.00	77.0	2	2S221-1600-200-NG	★	15.7	125.0
20.0	19	26.0	2.50	100.0	2	2S221-2000-250-NG	★	19.7	150.0

CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N
Für NE-Metalle

FHA 30°
BSG DIN 6527 L
TCDC h10
TCDCON h6



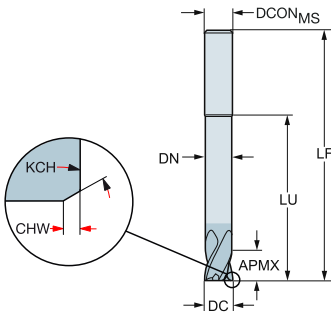
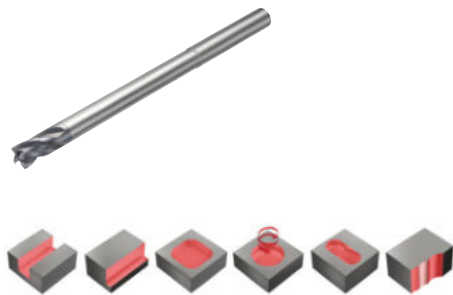
Metrische Ausführung

							N		Abmessungen, mm	
							1630	H10F	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer			
3.0	6	7.0			7.0	1	2P230-0300-NA		★	6.0 57.0
	6	7.0			7.0	1	2P231-0300-NA		★	6.0 57.0
4.0	6	8.0			8.0	1	2P230-0400-NA		★	6.0 57.0
	6	8.0			8.0	1	2P231-0400-NA		★	6.0 57.0
5.0	6	10.0			10.0	1	2P230-0500-NA		★	6.0 57.0
	6	10.0			10.0	1	2P231-0500-NA		★	6.0 57.0
6.0	6	10.0			10.0	1	2P230-0600-NA		★	6.0 57.0
	6	10.0			10.0	1	2P231-0600-NA		★	6.0 57.0
8.0	8	16.0			16.0	1	2P230-0800-NA		★	8.0 63.0
	8	16.0			16.0	1	2P231-0800-NA		★	8.0 63.0
10.0	10	19.0	0.10	45°	19.0	1	2P230-1000-NA		★	10.0 72.0
	10	19.0	0.10	45°	19.0	1	2P231-1000-NA		★	10.0 72.0

CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N

Für NE-Metalle mit Siliziumgehalt > 9%

FHA30°
BSGCOROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

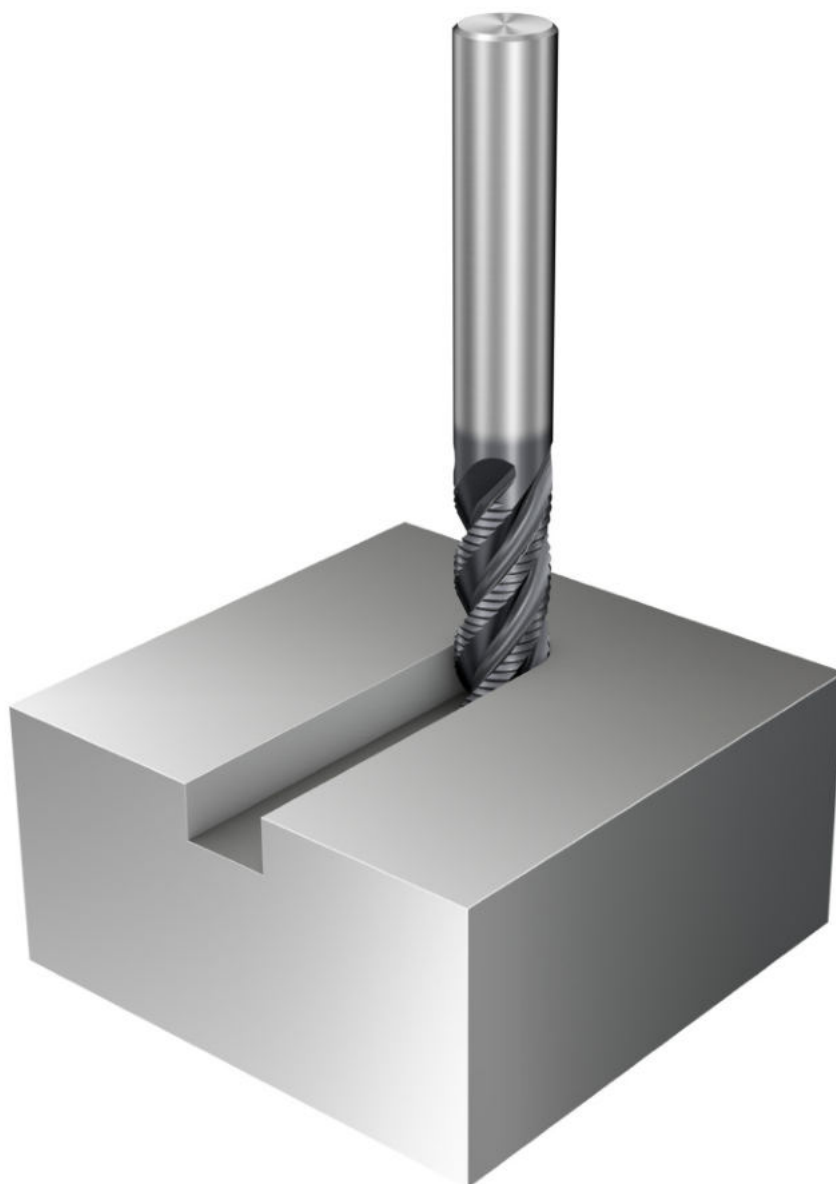
							N O		Abmessungen, mm		
							N20C	N20C	DCON _{MS}	LF	DN
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer				
1.0	3	1.0			2.0	2	2P210-0100-NC		★	☆	3.0 50.0
1.5	3	1.5			1.5	2	2P210-0150-NC		★	☆	3.0 50.0
2.0	3	2.0			2.0	2	2P210-0200-NC		★	☆	3.0 50.0
3.0	6	3.0			3.0	2	2P210-0300-NC		★	☆	6.0 80.0
4.0	6	4.0			40.0	2	2P210-0400-NC		★	☆	6.0 100.0 3.8
5.0	6	5.0			50.0	2	2P210-0500-NC		★	☆	6.0 100.0 4.8
6.0	6	6.0			60.0	4	2P210-0600-NC		★	☆	6.0 100.0 5.7
8.0	8	8.0			80.0	4	2P210-0800-NC		★	☆	8.0 120.0 7.6
10.0	10	10.0	0.10	45°	100.0	4	2P210-1000-NC		★	☆	10.0 150.0 9.5
12.0	12	12.0	0.10	45°	100.0	4	2P210-1200-NC		★	☆	12.0 150.0 11.4
16.0	16	16.0	0.15	45°	100.0	4	2P210-1600-NC		★	☆	16.0 150.0 15.2

CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Einsatzbereich

Erste Wahl zum Schruppen in Aluminium, Graphit und bei der Bearbeitung

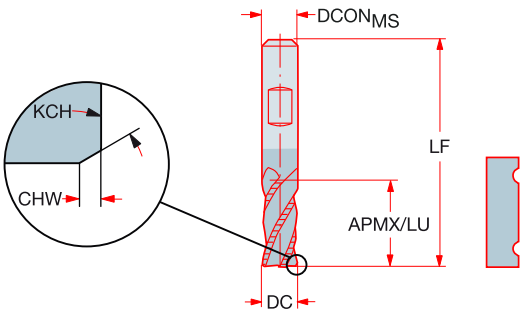
ISO-Werkstoff	P	M	K	S	N
Sorte	H10F	1620	1640		
Schaft	Zylindrisch Weldon				



CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Für ISO S-Werkstoffe

FHA 30°
BSG DIN 6527 L
TCDC h10
TCDCON h6



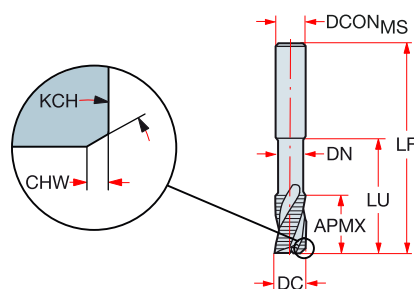
Metrische Ausführung

							M	S	Abmessungen, mm	
							1620	1620	DCON _{MS}	LF
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer			
6.0	6	13.0			13.0	4	R216.34-06030-BC13B		6.0	57.0
8.0	8	19.0			19.0	4	R216.34-08030-BC19B		8.0	63.0
10.0	10	22.0	0.10	45°	22.0	4	R216.34-10030-BC22B		10.0	72.0
12.0	12	26.0	0.10	45°	26.0	4	R216.34-12030-BC26B		12.0	83.0
16.0	16	32.0	0.15	45°	32.0	4	R216.34-16030-BC32B		16.0	92.0
18.0	18	32.0	0.15	45°	32.0	4	R216.34-18030-BC32B		18.0	92.0
20.0	20	38.0	0.15	45°	38.0	4	R216.34-20030-BC38B		20.0	104.0
25.0	25	45.0	0.15	45°	45.0	5	R216.35-25030-BC45B		25.0	121.0

CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Für NE-Metalle

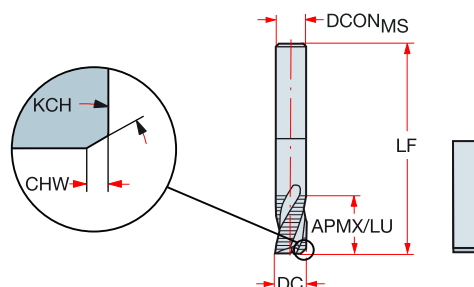
FHA 40°
BSG COROMANT
TCDC h12
TCDCON h5



Metrische Ausführung

								N	Abmessungen, mm		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	H10F	DCON _{MS}	LF	DN
6.0	8	10.0	0.64	55°	24.0	3	R216.33-06040-AJ10U	★	8.0	63.0	5.5
8.0	10	12.0	0.64	55°	29.0	3	R216.33-08040-AJ12U	★	10.0	72.0	7.5
10.0	12	14.0	0.83	55°	35.0	3	R216.33-10040-AJ14U	★	12.0	83.0	9.5
12.0	12	16.0	0.83	55°	50.0	3	R216.33-12040-AJ16U	★	12.0	100.0	11.4
16.0	16	20.0	1.00	55°	63.0	3	R216.33-16040-AJ20U	★	16.0	115.0	15.2
20.0	20	20.0	1.00	55°	70.0	3	R216.33-20040-AJ20U	★	20.0	125.0	19.0
25.0	25	25.0	1.29	55°	75.0	3	R216.33-25040-AJ25U	★	25.0	135.0	23.8

FHA 40°
BSG DIN 6527 L
TCDC h12
TCDCON h5



Metrische Ausführung

							N	Abmessungen, mm		
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	H10F	DCON _{MS}	LF
6.0	6	13.0	0.64	55°	13.0	3	R216.33-06040-AC13U	★	6.0	57.0
8.0	8	19.0	0.64	55°	19.0	3	R216.33-08040-AC19U	★	8.0	63.0
10.0	10	22.0	0.83	55°	22.0	3	R216.33-10040-AC22U	★	10.0	72.0
12.0	12	26.0	0.83	55°	26.0	3	R216.33-12040-AC26U	★	12.0	83.0
14.0	14	26.0	1.00	55°	26.0	3	R216.33-14040-AC26U	★	14.0	83.0
16.0	16	32.0	1.00	55°	32.0	3	R216.33-16040-AC32U	★	16.0	92.0
20.0	20	38.0	1.00	55°	38.0	3	R216.33-20040-AC38U	★	20.0	104.0



A188



A194



E9



E22



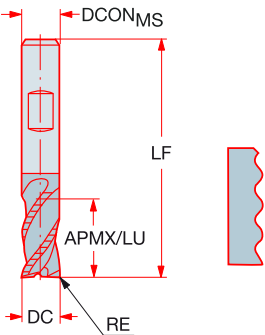
E14

CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Für Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

30°
DIN 6527 K
h12
h6

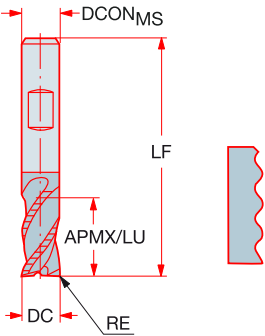


Metrische Ausführung

						P	M	K	Abmessungen, mm	
						1640	1640	1640	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer				
6.0	6	7.0	0.35	7.0	3	R216.33-06030-BS07K	★	☆	★	6.0 54.0
8.0	8	9.0	0.40	9.0	3	R216.33-08030-BS09K	★	☆	★	8.0 58.0
10.0	10	11.0	0.40	11.0	3	R216.33-10030-BS11K	★	☆	★	10.0 66.0
12.0	12	12.0	0.40	12.0	3	R216.33-12030-BS12K	★	☆	★	12.0 73.0
14.0	14	14.0	0.40	14.0	3	R216.33-14030-BS14K	★	☆	★	14.0 75.0
16.0	16	16.0	0.40	16.0	3	R216.33-16030-BS16K	★	☆	★	16.0 82.0
20.0	20	20.0	0.40	20.0	3	R216.33-20030-BS20K	★	☆	★	20.0 92.0

FHA
BSG
TCDC
TCDCON

40°
DIN 6527 L
h12
h6



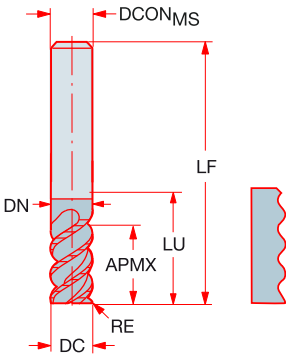
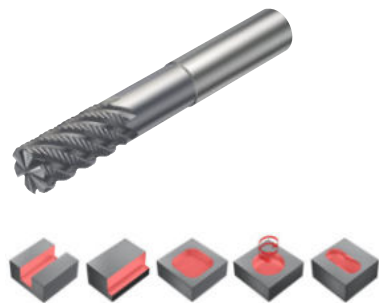
Metrische Ausführung

						P	M	K	Abmessungen, mm	
						1640	1640	1640	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer				
6.0	6	13.0	0.35	13.0	4	R216.34-06040-BC13K	★	☆	★	6.0 57.0
8.0	8	19.0	0.35	19.0	4	R216.34-08040-BC19K	★	☆	★	8.0 63.0
10.0	10	22.0	0.40	22.0	4	R216.34-10040-BC22K	★	☆	★	10.0 72.0
12.0	12	26.0	0.40	26.0	4	R216.34-12040-BC26K	★	☆	★	12.0 83.0
14.0	14	26.0	0.40	26.0	4	R216.34-14040-BC26K	★	☆	★	14.0 83.0
16.0	16	32.0	0.40	32.0	4	R216.34-16040-BC32K	★	☆	★	16.0 92.0
18.0	18	32.0	0.40	32.0	4	R216.34-18040-BC32K	★	☆	★	18.0 92.0
20.0	20	38.0	0.40	38.0	4	R216.34-20040-BC38K	★	☆	★	20.0 104.0

CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Für Stahl mit Härte ≤ 48 HRc

FHA 45°
BSG DIN 6527 L
TCDC h12
TCDCON h6



Metrische Ausführung

							P	M	K	S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer	1640	1640	1640	1640	DCON _{MS}	LF	DN
16.0	16	32.0	4.00	44.0	6	R216.36-16045IC32K	★	☆	☆	☆	16.0	92.0	15.2
	16	32.0	4.00	64.0	6	R216.36-16045ICK32K	★	☆	☆	☆	16.0	112.0	15.2
20.0	20	38.0	4.00	54.0	6	R216.36-20045IC38K	★	☆	☆	☆	20.0	104.0	19.0
	20	38.0	4.00	80.0	6	R216.36-20045ICK38K	★	☆	☆	☆	20.0	130.0	19.0
25.0	25	45.0	4.00	65.0	8	R216.38-25045IC45K	★	☆	☆	☆	25.0	121.0	23.8
	25	45.0	4.00	100.0	8	R216.38-25045ICK45K	★	☆	☆	☆	25.0	156.0	23.8

CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Für Stahl und rostfreien Stahl

FHA 40°
BSG DIN 6527 K
TCDC h12
TCDCON h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer	1640	1640	1640	DCON _{MS}	LF	DN
6.0	6	7.0	0.35	16.0	1	1	4	R215.34C06040-DS07K	★	★	☆	6.0	54.0	5.5
8.0	8	9.0	0.40	20.0	1	1	4	R215.34C08040-DS09K	★	★	☆	8.0	58.0	7.5
10.0	10	11.0	0.40	24.0	1	1	4	R215.34C10040-DS11K	★	★	☆	10.0	66.0	9.5
12.0	12	12.0	0.40	26.0	1	1	4	R215.34C12040-DS12K	★	★	☆	12.0	73.0	11.4
16.0	16	16.0	0.40	32.0	1	1	4	R215.34C16040-DS16K	★	★	☆	16.0	82.0	15.2
20.0	20	20.0	0.40	40.0	1	1	4	R215.34C20040-DS20K	★	★	☆	20.0	92.0	19.0

FHA 40°
BSG DIN 6527 L
TCDC h12
TCDCON h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Bestellnummer	1640	1640	1640	DCON _{MS}	LF	DN
6.0	6	13.0	0.35	19.0	1	1	4	R215.34C06040-DC13K	★	★	☆	6.0	57.0	5.5
8.0	8	19.0	0.40	25.0	1	1	4	R215.34C08040-DC19K	★	★	☆	8.0	63.0	7.5
10.0	10	22.0	0.40	30.0	1	1	4	R215.34C10040-DC22K	★	★	☆	10.0	72.0	9.5
12.0	12	26.0	0.40	36.0	1	1	4	R215.34C12040-DC26K	★	★	☆	12.0	83.0	11.4
16.0	16	32.0	0.40	42.0	1	1	4	R215.34C16040-DC32K	★	★	☆	16.0	92.0	15.2
20.0	20	38.0	0.40	52.0	1	1	4	R215.34C20040-DC38K	★	★	☆	20.0	104.0	19.0



CoroMill® Plura Vollhartmetall-Schaftfräser für die Schlichtbearbeitung

Einsatzbereich

Erste Wahl für die Schlichtbearbeitung in Eckfräsanwendungen

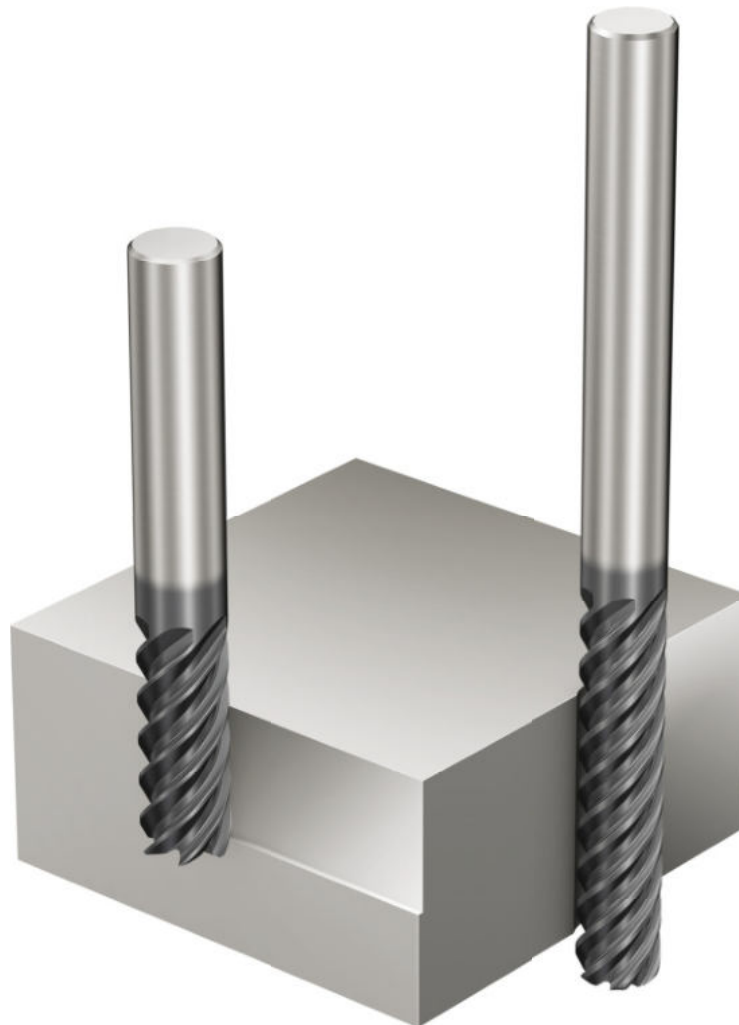
Kann bei Schrappoperationen mit geringem radialen Eingriff eingesetzt werden, wenn hohe Vorschübe erforderlich sind (Trochoid-Strategie)

ISO-Werkstoff	P	M	K	S	H
Sorte	1610	1620			
Schaft	Zylindrisch				

Produktbereich

Für gehärteten Stahl mit Härte $43 \leq \text{HRc} \leq 63$

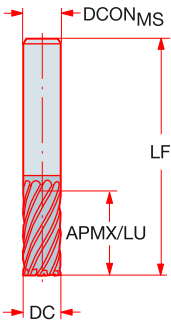
Für rostfreien Stahl und Stahl mit Härte $\leq 48 \text{ HRc}$



CoroMill® Plura Vollhartmetall-Schaftfräser für die Schlichtbearbeitung

Für gehärteten Stahl mit Härte 43≤ HRc ≤63

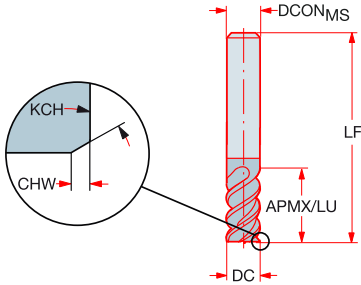
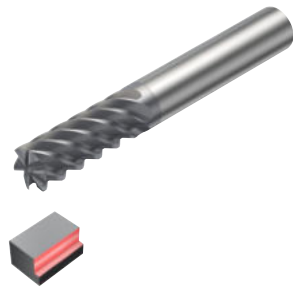
FHA 30°
BSG DIN 6527 L
TCDC h10
TCDCON h6



Metrische Ausführung

							P	H	Abmessungen, mm	
							1610	1610	DCONMS	LF
DC	CZCMS	APMX	LU	ZEFP	Bestellnummer					
5.0	6	13.0	13.0	6	R215.36-05030-AC13H	☆	★		6.0	57.0
6.0	6	13.0	13.0	6	R215.36-06030-AC13H	☆	★		6.0	57.0
8.0	8	19.0	19.0	8	R215.38-08030-AC19H	☆	★		8.0	63.0
10.0	10	22.0	22.0	10	R215.3A-10030-AC22H	☆	★		10.0	72.0
12.0	12	26.0	26.0	12	R215.3C-12030-AC26H	☆	★		12.0	83.0
14.0	14	26.0	26.0	14	R215.3E-14030-AC26H	☆	★		14.0	83.0
16.0	16	32.0	32.0	16	R215.3G-16030-AC32H	☆	★		16.0	92.0
20.0	20	38.0	38.0	16	R215.3G-20030-AC38H	☆	★		20.0	104.0

FHA 50°
BSG DIN 6527 L
TCDC h10
TCDCON h6



Metrische Ausführung

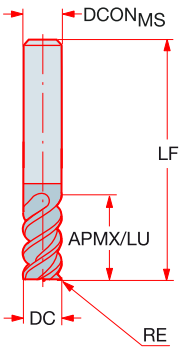
							P	H	Abmessungen, mm	
							1610	1610	DCONMS	LF
DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Bestellnummer			
3.0	6	8.0	0.10	45°	8.0	4	R215.34-03050-AC08H	☆	★	6.0 57.0
4.0	6	11.0	0.10	45°	11.0	4	R215.34-04050-AC11H	☆	★	6.0 57.0
6.0	6	13.0	0.10	45°	13.0	6	R215.36-06050-AC13H	☆	★	6.0 57.0
8.0	8	19.0	0.10	45°	19.0	6	R215.36-08050-AC19H	☆	★	8.0 63.0
10.0	10	22.0	0.10	45°	22.0	6	R215.36-10050-AC22H	☆	★	10.0 72.0
12.0	12	26.0	0.10	45°	26.0	6	R215.36-12050-AC26H	☆	★	12.0 83.0
16.0	16	32.0	0.15	45°	32.0	6	R215.36-16050-AC32H	☆	★	16.0 92.0
20.0	20	38.0	0.15	45°	38.0	8	R215.38-20050-AC38H	☆	★	20.0 104.0

CoroMill® Plura Vollhartmetall-Schaftfräser für die Schlichtbearbeitung

Für gehärteten Stahl mit Härte 43≤ HRc ≤63

FHA
BSG
TCDC
TCDCON

50°
DIN 6527 L
h9
h5



Metrische Ausführung

						P H		Abmessungen, mm	
						1610	1610		
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer		DCON _{MS}	LF
3.0	6	8.0	0.50	8.0	4	R215.24-03050BAC08H		6.0	57.0
4.0	6	11.0	0.50	11.0	4	R215.24-04050BAC11H		6.0	57.0
6.0	6	13.0	0.50	13.0	6	R215.26-06050BAC13H		6.0	57.0
8.0	8	19.0	0.50	19.0	6	R215.26-08050BAC19H		8.0	63.0
10.0	10	22.0	1.00	22.0	6	R215.26-10050CAC22H		10.0	72.0
	10	22.0	1.50	22.0	6	R215.26-10050DAC22H		10.0	72.0
	10	22.0	2.00	22.0	6	R215.26-10050EAC22H		10.0	72.0
12.0	12	26.0	1.00	26.0	6	R215.26-12050CAC26H		12.0	83.0
16.0	16	32.0	1.50	32.0	6	R215.26-16050DAC32H		16.0	92.0
20.0	20	38.0	1.50	38.0	8	R215.28-20050DAC38H		20.0	104.0



A189



A194



E9



E22



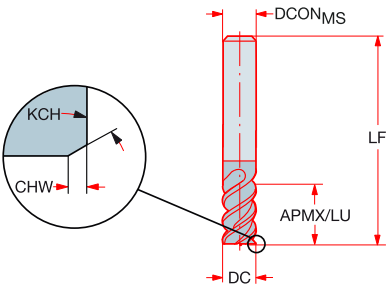
E14



CoroMill® Plura Vollhartmetall-Schaftfräser für die Schlichtbearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA50°
BSGDIN 6527 L
TCDC h10
TCDCON h6



Metrische Ausführung

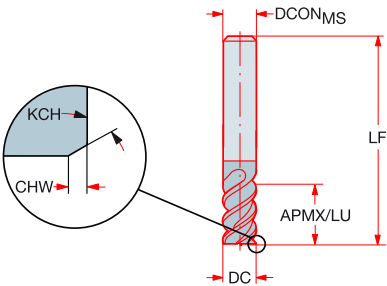
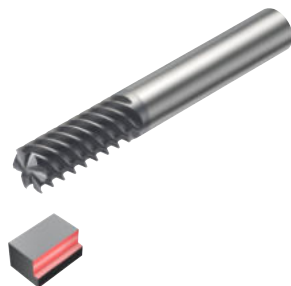
								P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	DCON _{MS}	LF
3.0	6	8.0	0.10	45°	8.0	4	R215.34-03050-AC08L	★	★	☆	☆	6.0	57.0
4.0	6	11.0	0.10	45°	11.0	4	R215.34-04050-AC11L	★	★	☆	☆	6.0	57.0
5.0	6	13.0	0.10	45°	13.0	5	R215.35-05050-AC13L	★	★	☆	☆	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	6	R215.36-06050-AC13L	★	★	☆	☆	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	6	R215.36-08050-AC19L	★	★	☆	☆	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	6	R215.36-10050-AC22L	★	★	☆	☆	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	6	R215.36-12050-AC26L	★	★	☆	☆	12.0	83.0
16.0	16	32.0	0.15	45°	32.0	6	R215.36-16050-AC32L	★	★	☆	☆	16.0	92.0
20.0	20	38.0	0.15	45°	38.0	8	R215.38-20050-AC38L	★	★	☆	☆	20.0	104.0

CoroMill® Plura Vollhartmetall-Schaftfräser für die Schlichtbearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

60°
DIN 6527 L
h10
h6



Metrische Ausführung

								P	M	K	S	Abmessungen, mm	
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	DCON _{MS}	LF
6.0	6	13.0	0.10	45°	13.0	6	R215.36-06060-AC13L	★	★	☆	☆	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	6	R215.36-08060-AC19L	★	★	☆	☆	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	6	R215.36-10060-AC22L	★	★	☆	☆	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	6	R215.36-12060-AC26L	★	★	☆	☆	12.0	83.0
14.0	14	26.0	0.15	45°	26.0	6	R215.36-14060-AC26L	★	★	☆	☆	14.0	83.0
16.0	16	32.0	0.15	45°	32.0	6	R215.36-16060-AC32L	★	★	☆	☆	16.0	92.0
18.0	18	32.0	0.15	45°	32.0	6	R215.36-18060-AC32L	★	★	☆	☆	18.0	92.0
20.0	20	38.0	0.15	45°	38.0	6	R215.36-20060-AC38L	★	★	☆	☆	20.0	104.0

A189

A194

E9

E22

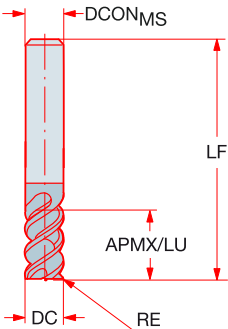
E14

CoroMill® Plura Vollhartmetall-Schaftfräser für die Schlichtbearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC
TCDCON

50°
COROMANT
h9
h6



Zoll-Ausführung

						P	M	K	S	Abmessungen, Zoll	
						1/620	1/620	1/620	1/620	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer					
.063	1/4	.188	.016	.188	4	RA215.24-0450AAK13L	★	★	★	.250	3.000
.094	1/4	.281	.016	.281	4	RA215.24-0650AAK18L	★	★	★	.250	3.000
	1/4	.281	.031	.281	4	RA215.24-0650BAK18L	★	★	★	.250	3.000
.125	1/4	.375	.016	.375	4	RA215.24-0850AAK06L	★	★	★	.250	3.000
	1/4	.375	.031	.375	4	RA215.24-0850BAK06L	★	★	★	.250	3.000
.156	1/4	.500	.016	.500	4	RA215.24-1050AAK08L	★	★	★	.250	3.000
	1/4	.500	.031	.500	4	RA215.24-1050BAK08L	★	★	★	.250	3.000
.188	1/4	.571	.016	.563	6	RA215.26-1250AAK09L	★	★	★	.250	3.000
	1/4	.571	.031	.563	6	RA215.26-1250BAK09L	★	★	★	.250	3.000
.250	1/4	.750	.016	.750	6	RA215.26-1650AAK12L	★	★	★	.250	3.000
	1/4	.750	.031	.750	6	RA215.26-1650BAK12L	★	★	★	.250	3.000
	1/4	1.125	.031	1.125	6	RA215.26-1650BAL18L	★	★	★	.250	4.000
.313	3/8	1.000	.016	1.000	6	RA215.26-2050AAK15L	★	★	★	.375	3.500
	3/8	1.400	.031	1.406	6	RA215.26-2050BAL23L	★	★	★	.375	4.500
	3/8	1.000	.031	1.000	6	RA215.26-2050BAK15L	★	★	★	.375	3.500
.375	3/8	1.125	.031	1.125	6	RA215.26-2450BAK18L	★	★	★	.375	3.500
	3/8	1.666	.063	1.688	6	RA215.26-2450DAL27L	★	★	★	.375	4.500
	3/8	1.125	.063	1.125	6	RA215.26-2450DAK18L	★	★	★	.375	3.500
.500	1/2	1.500	.031	1.500	6	RA215.26-3250BAK24L	★	★	★	.500	4.000
	1/2	1.500	.063	1.500	6	RA215.26-3250DAK24L	★	★	★	.500	4.000
	1/2	2.250	.063	2.250	6	RA215.26-3250DAL36L	★	★	★	.500	5.000
.625	5/8	1.875	.063	1.875	6	RA215.26-4050DAK30L	★	★	★	.625	4.500
	5/8	2.813	.125	2.813	6	RA215.26-4050HAL45L	★	★	★	.625	5.500
.750	3/4	2.250	.063	2.250	8	RA215.28-4850DAK36L	★	★	★	.750	5.000
	3/4	3.375	.125	3.375	8	RA215.28-4850HAL54L	★	★	★	.750	6.000

CoroMill® Plura Vollhartmetall-Schaftfräser zum Mikrofräsen

Einsatzbereich

Ein ausgezeichnetes Werkzeug speziell für die Schruppbearbeitung in der Kleinteilfertigung

Produktbereich

Für Multimaterial-Anwendungen mit Härte ≤ 63 HRc

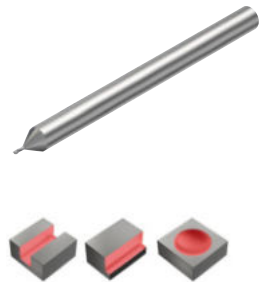
ISO-Werkstoff	P M K N S H
Sorte	1620
Schaft	Zylindrisch



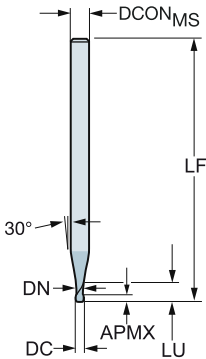
CoroMill® Plura Vollhartmetall-Schaftfräser zum Mikrofräsen

Für Multimaterial-Anwendungen mit Härte ≤ 63 HRc

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6

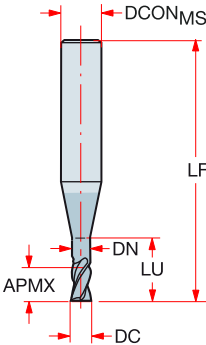
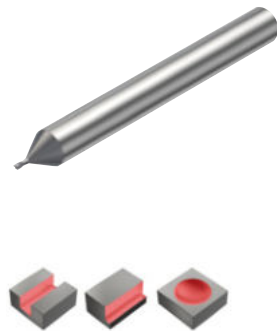


Metrische Ausführung



						P	M	K	N	S	H	Abmessungen, mm		
DC	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	1620	1620	DCON _{MS}	LF	DN
0.4	3	0.4	1.3	2	2P211-0040-PC	★	★	★	★	★	★	3.0	38.0	0.4
0.5	3	0.5	1.5	2	2P211-0050-PC	★	★	★	★	★	★	3.0	38.0	0.5
	3	0.5	2.5	2	2P212-0050-PC	★	★	★	★	★	★	3.0	60.0	0.5
0.6	3	0.6	1.8	2	2P211-0060-PC	★	★	★	★	★	★	3.0	38.0	0.6
	3	0.6	3.0	2	2P212-0060-PC	★	★	★	★	★	★	3.0	60.0	0.6
0.8	3	0.8	2.0	2	2P211-0080-PC	★	★	★	★	★	★	3.0	38.0	0.8
	3	0.8	4.0	2	2P212-0080-PC	★	★	★	★	★	★	3.0	60.0	0.8
1.0	3	1.0	2.5	2	2P211-0100-PC	★	★	★	★	★	★	3.0	38.0	1.0
	3	1.0	5.0	2	2P212-0100-PC	★	★	★	★	★	★	3.0	60.0	1.0

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6



						P	M	K	N	S	H	Abmessungen, mm		
DC	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1620	1620	1620	1620	1620	1620	DCON _{MS}	LF	DN
0.4	6	0.4	1.0	2	R216.32-00430-AE04G	★	★	★	★	★	★	6.0	54.0	0.4
0.5	6	0.5	1.2	2	R216.32-00530-AE05G	★	★	★	★	★	★	6.0	54.0	0.5
	6	0.5	2.5	2	R216.32-00530-AI05G	★	★	★	★	★	★	6.0	57.0	0.5
	6	0.5	5.0	2	R216.32-00530-AJ05G	★	★	★	★	★	★	6.0	57.0	0.5
0.6	6	0.6	1.5	2	R216.32-00630-AE06G	★	★	★	★	★	★	6.0	54.0	0.6
	6	0.6	3.0	2	R216.32-00630-AI06G	★	★	★	★	★	★	6.0	57.0	0.6
	6	0.6	6.0	2	R216.32-00630-AJ06G	★	★	★	★	★	★	6.0	57.0	0.6
0.8	6	0.8	2.0	2	R216.32-00830-AE08G	★	★	★	★	★	★	6.0	54.0	0.8
	6	0.8	4.0	2	R216.32-00830-AI08G	★	★	★	★	★	★	6.0	57.0	0.8
	6	0.8	8.0	2	R216.32-00830-AJ08G	★	★	★	★	★	★	6.0	57.0	0.8
1.0	6	1.0	2.5	2	R216.32-01030-AE10G	★	★	★	★	★	★	6.0	54.0	1.0
	6	1.0	5.0	2	R216.32-01030-AI10G	★	★	★	★	★	★	6.0	57.0	1.0
	6	1.0	10.0	2	R216.32-01030-AJ10G	★	★	★	★	★	★	6.0	57.0	1.0

CoroMill® Plura Vollhartmetall-Kugelschaftfräser zum Mikrofräsen

Einsatzbereich

Speziell für Profilbearbeitung in der Kleinteilfertigung

ISO-Werkstoff	P M K N S H
Sorte	1620 1700
Schaft	Zylindrisch

Produktbereich

Für Multimaterial mit Härte ≤ 63 HRc

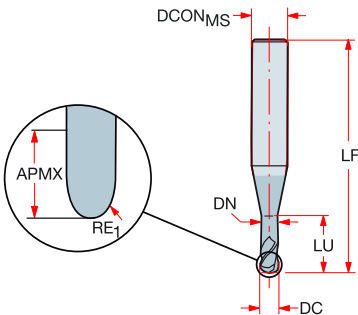
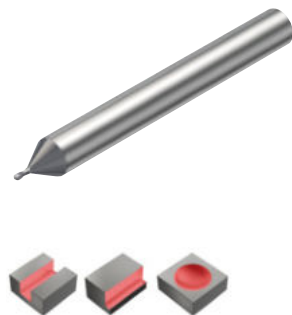
Für gehärteten Stahl mit Härte $43 \leq \text{HRc} \leq 63$



CoroMill® Plura Vollhartmetall-Kugelschaftfräser zum Mikrofräsen

Für Multimaterial-Anwendungen mit Härte ≤ 63 HRc

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6
PSIR 0°

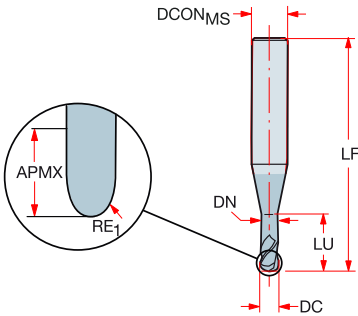
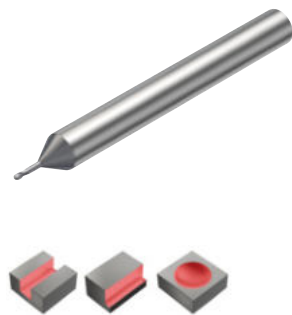


B

Metrische Ausführung

							P	M	K	N	S	H	Abmessungen, mm		
						Bestellnummer	1620	1620	1620	1620	1620	1620	DCON _{MS}	LF	DN
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP										
0.4	6	0.4	0.20	1.0	2	R216.42-00430-AE04G	*	*	*	*	*	*	6.0	54.0	0.4
0.5	6	0.5	0.25	1.2	2	R216.42-00530-AE05G	*	*	*	*	*	*	6.0	54.0	0.5
0.6	6	0.6	0.30	1.5	2	R216.42-00630-AE06G	*	*	*	*	*	*	6.0	54.0	0.6
0.8	6	0.8	0.40	2.0	2	R216.42-00830-AE08G	*	*	*	*	*	*	6.0	54.0	0.8
1.0	6	1.0	0.50	2.5	2	R216.42-01030-AE10G	*	*	*	*	*	*	6.0	54.0	1.0

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6
PSIR 0°



C

Metrische Ausführung

							P	M	K	N	S	H	Abmessungen, mm		
						Bestellnummer	1620	1620	1620	1620	1620	1620	DCON _{MS}	LF	DN
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP										
0.5	6	0.5	0.25	2.5	2	R216.42-00530-AO05G	*	*	*	*	*	*	6.0	57.0	0.5
0.6	6	0.6	0.30	3.0	2	R216.42-00630-AO06G	*	*	*	*	*	*	6.0	57.0	0.6
0.8	6	0.8	0.40	4.0	2	R216.42-00830-AO08G	*	*	*	*	*	*	6.0	57.0	0.8
1.0	6	1.0	0.50	5.0	2	R216.42-01030-AO10G	*	*	*	*	*	*	6.0	57.0	1.0

CoroMill® Plura Vollhartmetall-Kugelschaftfräser zum Mikrofräsen

Für Multimaterial-Anwendungen mit Härte ≤ 63 HRC

- FHA

BSG

TCDC

TCDCON

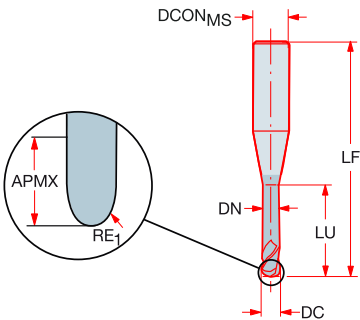
PSIR
- 30°

COROMANT

h9

h6

0°



Metrische Ausführung

							P	M	K	N	S	H	Abmessungen, mm		
							1620	1620	1620	1620	1620	1620			
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer							DCON _{MS}	LF	DN
0.5	6	0.5	0.25	5.0	2	R216.42-00530-AJ05G	*	*	*	*	*	*	6.0	57.0	0.5
0.6	6	0.6	0.30	6.0	2	R216.42-00630-AJ06G	*	*	*	*	*	*	6.0	57.0	0.6
0.8	6	0.8	0.40	8.0	2	R216.42-00830-AJ08G	*	*	*	*	*	*	6.0	57.0	0.8
1.0	6	1.0	0.50	10.0	2	R216.42-01030-AJ10G	*	*	*	*	*	*	6.0	57.0	1.0

A190

A194

E9

E22

E14

SANDVIK

Coromant

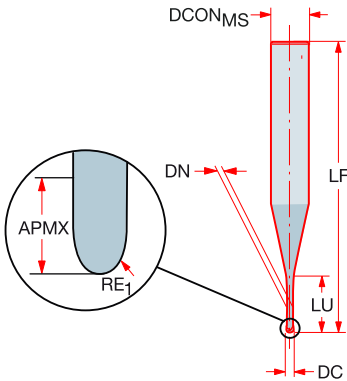
CoroMill® Plura Vollhartmetall-Kugelschaftfräser zum Mikrofräsen

Für gehärteten Stahl mit Härte 43≤ HRC ≤63

FHA 30°
BSG COROMANT
TCDC h8
TCDCON h5
PSIR 0°



Metrische Ausführung



							H	Abmessungen, mm		
							1700	DCON _{MS}	LF	DN
0.2	4	0.2	0.10	0.3	2	R216.42-00230-EC02G	★	4.0	45.0	0.2
	4	0.2	0.10	2.0	2	R216.42-00230-IC02G	★	4.0	45.0	0.2
0.3	4	0.3	0.15	0.5	2	R216.42-00330-EC03G	★	4.0	45.0	0.3
	4	0.3	0.15	0.9	2	R216.42-00330-FC03G	★	4.0	45.0	0.3
	4	0.3	0.15	1.5	2	R216.42-00330-GC03G	★	4.0	45.0	0.3
	4	0.3	0.15	2.0	2	R216.42-00330-HC03G	★	4.0	45.0	0.3
	4	0.3	0.15	3.0	2	R216.42-00330-JC03G	★	4.0	45.0	0.3
0.4	4	0.3	0.20	0.6	2	R216.42-00430-EC04G	★	4.0	45.0	0.4
	4	0.3	0.20	1.2	2	R216.42-00430-FC04G	★	4.0	45.0	0.4
	4	0.3	0.20	2.0	2	R216.42-00430-GC04G	★	4.0	45.0	0.4
	4	0.3	0.20	4.0	2	R216.42-00430-JC04G	★	4.0	45.0	0.4
0.5	4	0.4	0.25	0.8	2	R216.42-00530-EC05G	★	4.0	45.0	0.5
	4	0.4	0.25	1.5	2	R216.42-00530-FC05G	★	4.0	45.0	0.5
	4	0.4	0.25	3.0	2	R216.42-00530-HC05G	★	4.0	45.0	0.5
	4	0.4	0.25	5.0	2	R216.42-00530-JC05G	★	4.0	45.0	0.5
0.8	4	0.5	0.40	1.2	2	R216.42-00830-EC08G	★	4.0	45.0	0.8
	4	0.5	0.40	2.4	2	R216.42-00830-FC08G	★	4.0	45.0	0.8
1.0	6	0.8	0.50	1.5	2	R216.42-01030-EC10G	★	6.0	45.0	1.0
	6	0.8	0.50	3.0	2	R216.42-01030-FC10G	★	6.0	45.0	1.0
	6	0.8	0.50	6.0	2	R216.42-01030-HC10G	★	6.0	45.0	1.0
	6	0.8	0.50	10.0	2	R216.42-01030-JC10G	★	6.0	50.0	1.0
1.2	6	1.1	0.60	3.6	2	R216.42-01230-FC12G	★	6.0	45.0	1.2
	6	1.4	0.75	2.3	2	R216.42-01530-EC15G	★	6.0	45.0	1.4
	6	1.4	0.75	4.5	2	R216.42-01530-FC15G	★	6.0	45.0	1.4
	6	1.4	0.75	8.0	2	R216.42-01530-GC15G	★	6.0	45.0	1.4
	6	1.4	0.75	12.0	2	R216.42-01530-IC15G	★	6.0	50.0	1.4
2.0	6	1.7	1.00	3.0	2	R216.42-02030-EC20G	★	6.0	45.0	1.9
	6	1.7	1.00	6.0	2	R216.42-02030-FC20G	★	6.0	45.0	1.9
	6	1.7	1.00	8.0	2	R216.42-02030-GC20G	★	6.0	45.0	1.9
	6	1.7	1.00	12.0	2	R216.42-02030-HC20G	★	6.0	50.0	1.9
	6	1.7	1.00	16.0	2	R216.42-02030-IC20G	★	6.0	50.0	1.9
	6	1.7	1.00	20.0	2	R216.42-02030-JC20G	★	6.0	55.0	1.9
2.5	6	2.0	1.25	15.0	2	R216.42-02530-HC25G	★	6.0	50.0	2.4
	6	2.0	1.25	20.0	2	R216.42-02530-IC25G	★	6.0	55.0	2.4

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung

Einsatzbereich

Profilbearbeitung in unterschiedlichen Werkstoffen

ISO-Werkstoff	P	M	K	N	S	O
Sorte	1620	1630				
Schaft	Zylindrisch					

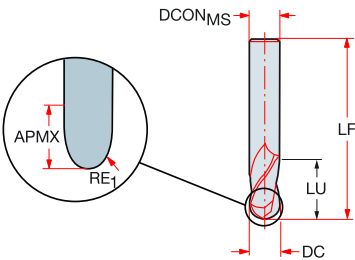
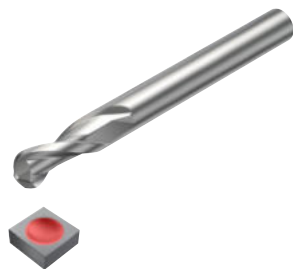
Produktangebot

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc



CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung
Für NE-Metalle

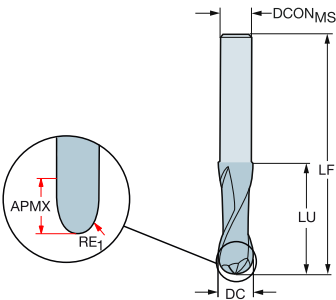
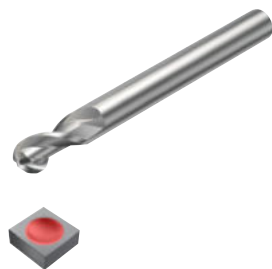
FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6
PSIR 0°



Metrische Ausführung

						N	Abmessungen, mm	
						H9/f8	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer		
2.0	6	6.0	1.00	6.0	2	R216.42-02030-AK60A	★	6.0 57.0
3.0	6	7.0	1.50	7.0	2	R216.42-03030-AK07A	★	6.0 80.0
4.0	6	8.0	2.00	8.0	2	R216.42-04030-AK08A	★	6.0 80.0
5.0	6	10.0	2.50	10.0	2	R216.42-05030-AK10A	★	6.0 80.0
6.0	6	10.0	3.00	10.0	2	R216.42-06030-AK10A	★	6.0 80.0
8.0	8	16.0	4.00	16.0	2	R216.42-08030-AK16A	★	8.0 100.0
10.0	10	19.0	5.00	19.0	2	R216.42-10030-AK19A	★	10.0 100.0
12.0	12	22.0	6.00	22.0	2	R216.42-12030-AK22A	★	12.0 100.0
16.0	16	26.0	8.00	26.0	2	R216.42-16030-AK26A	★	16.0 100.0

FHA 40°
BSG COROMANT
TCDC h10
TCDCON h6
PSIR 0°



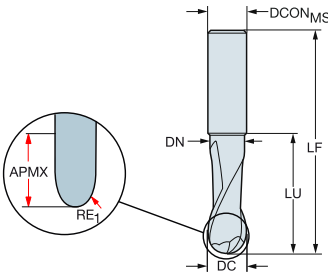
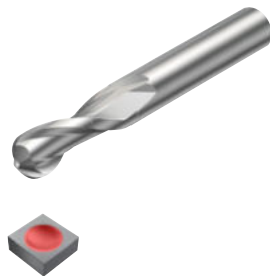
Metrische Ausführung

						N	Abmessungen, mm	
						H9/f8	DCON _{MS}	LF
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer		
3.0	2	4.0	1.50	32.0	2	2B320-0300-NG	★	2.9 60.0
4.0	3	5.0	2.00	32.0	2	2B320-0400-NG	★	3.8 60.0
5.0	4	8.0	2.50	42.0	2	2B320-0500-NG	★	4.8 70.0
6.0	5	9.0	3.00	64.0	2	2B320-0600-NG	★	5.8 100.0
8.0	7	13.0	4.00	64.0	2	2B320-0800-NG	★	7.8 100.0
10.0	9	15.0	5.00	60.0	2	2B320-1000-NG	★	9.7 100.0
12.0	11	17.0	6.00	80.0	2	2B320-1200-NG	★	11.7 125.0
16.0	15	23.0	8.00	77.0	2	2B320-1600-NG	★	15.7 125.0

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung

Für NE-Metalle

FHA 40°
BSG COROMANT
TCDC h10
TCDCON h8
PSIR 0°



Metrische Ausführung

							N	Abmessungen, mm		
							H ₀ F			
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer		DCON _{MS}	LF	DN
3.0	3	5.0	1.50	8.8	2	2B330-0300-NC	★	3.0	38.0	2.7
4.0	4	7.0	2.00	11.8	2	2B330-0400-NC	★	4.0	50.0	3.7
5.0	5	10.0	2.50	14.8	2	2B330-0500-NC	★	5.0	50.0	4.7
6.0	6	11.0	3.00	17.8	2	2B330-0600-NC	★	6.0	57.0	5.7
8.0	8	14.0	4.00	23.8	2	2B330-0800-NC	★	8.0	63.0	7.7
10.0	10	18.0	5.00	29.8	2	2B330-1000-NC	★	10.0	73.0	9.7
12.0	12	22.0	6.00	35.8	2	2B330-1200-NC	★	12.0	83.0	11.7
16.0	16	29.0	8.00	47.8	2	2B330-1600-NC	★	16.0	92.0	15.7

A192

A194

E9

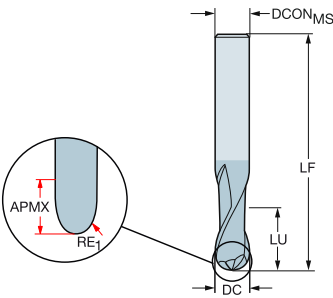
E22

E14

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung

Für NE-Metalle mit Siliziumgehalt > 9%

FHA30°
BSGCOROMANT
TCDC h9
TCDCON h8
PSIR 0°



Metrische Ausführung

						N O		Abmessungen, mm	
						N20C	O20C	DCON_Ms	LF
DC	CZC_Ms	APMX	RE1	LU	ZEFP	Bestellnummer			
1.0	3	3.0	0.50	3.0	2	2B230-0100-NA		3.0	38.0
1.5	3	3.0	0.75	3.0	2	2B230-0150-NA		3.0	38.0
2.0	3	6.0	1.00	6.0	2	2B230-0200-NA		3.0	38.0
3.0	3	7.0	1.50	7.0	2	2B230-0300-NA		3.0	38.0
4.0	6	8.0	2.00	8.0	2	2B230-0400-NA		6.0	57.0
6.0	6	10.0	3.00	10.0	2	2B230-0600-NA		6.0	57.0
8.0	8	16.0	4.00	16.0	2	2B230-0800-NA		8.0	63.0
10.0	10	19.0	5.00	19.0	2	2B230-1000-NA		10.0	72.0
12.0	12	22.0	6.00	22.0	2	2B230-1200-NA		12.0	83.0

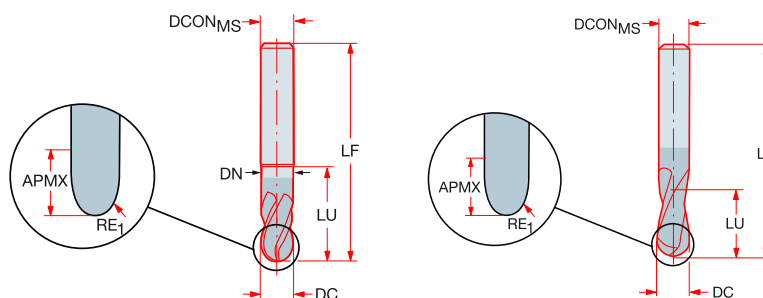
CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilarbeit

Für Stahl und gehärteten Stahl mit Härte ≤ 63 HRC

FHA
BSG
TCDC
TDCON
PSIR

R216.42..30-AI..G
30°
COROMANT
h9
h6
0°

R216.4x..30-AK..G
30°
COROMANT
h9
h6
0°



Metrische Ausführung

							P	M	K	S	H	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE _i	LU	ZEFP	Bestellnummer	1610	1620	1620	1620	1610	DCON _{MS}	LF	DN
1.0	6	1.0	0.50	1.0	2	R216.42-01030-AI10G	☆	★	★	☆	★	6.0	57.0	
	6	1.5	0.50	1.5	2	R216.42-01030-AK15G	★	★	★	☆	★	6.0	57.0	
1.5	6	1.5	0.75	2.0	2	R216.42-01530-AI15G	☆				★	6.0	57.0	
	6	2.0	0.75	2.0	2	R216.42-01530-AK20G	★	★	★	☆	★	6.0	57.0	
2.0	6	2.0	1.00	2.0	2	R216.42-02030-AI20G	☆	★	★	☆	★	6.0	57.0	
	6	3.0	1.00	3.0	2	R216.42-02030-AK30G	★	★	★	☆	★	6.0	57.0	
2.5	6	2.5	1.25	2.0	2	R216.42-02530-AI25G	☆				★	6.0	57.0	
	6	3.0	1.25	3.0	2	R216.42-02530-AK30G	★	★	★	☆	★	6.0	57.0	
3.0	6	3.0	1.50	3.0	2	R216.42-03030-AI03G	☆	★	★	☆	★	6.0	57.0	
	6	4.0	1.50	4.0	2	R216.42-03030-AK04G	★	★	★	☆	★	6.0	57.0	
4.0	6	4.0	2.00	4.0	2	R216.42-04030-AI04G	☆	★	★	☆	★	6.0	57.0	
	6	5.0	2.00	5.0	2	R216.42-04030-AK05G	★	★	★	☆	★	6.0	80.0	
5.0	6	5.0	2.50	20.0	2	R216.42-05030-AI05G	☆	★	★	☆	★	6.0	57.0	4.9
	6	6.0	2.50	6.0	2	R216.42-05030-AK06G	★	★	★	☆	★	6.0	80.0	
6.0	6	6.0	3.00	21.0	2	R216.42-06030-AI06G	☆	★	★	☆	★	6.0	63.0	5.7
	6	10.0	3.00	10.0	2	R216.42-06030-AK10G	★	★	★	☆	★	6.0	80.0	
8.0	8	8.0	4.00	27.0	2	R216.42-08030-AI08G	☆	★	★	☆	★	8.0	63.0	7.7
	8	16.0	4.00	16.0	2	R216.42-08030-AK16G	★	★	★	☆	★	8.0	100.0	
10.0	10	10.0	5.00	32.0	2	R216.42-10030-AI10G	☆	★	★	☆	★	10.0	72.0	9.7
	10	19.0	5.00	19.0	2	R216.42-10030-AK19G	★	★	★	☆	★	10.0	100.0	
12.0	12	12.0	6.00	36.0	2	R216.42-12030-AI12G	☆	★	★	☆	★	12.0	83.0	11.4
	12	22.0	6.00	22.0	2	R216.42-12030-AK22G	★	★	★	☆	★	12.0	100.0	
16.0	16	32.0	8.00	32.0	2	R216.42-16030-AK32G	★	★	★	☆	★	16.0	125.0	



A192



A194



E9



E22

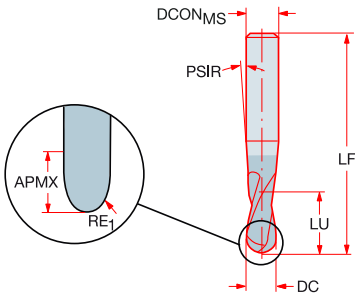
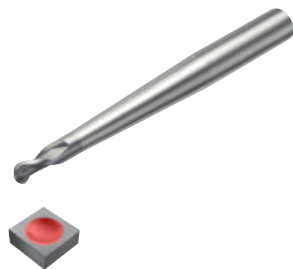


E14

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung

Für Stahl und gehärteten Stahl mit Härte ≤ 63 HRc

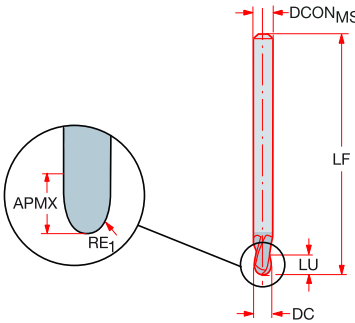
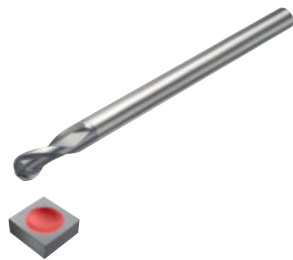
FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6
PSIR 0°



Metrische Ausführung

						P	M	K	S	H	Abmessungen, mm		
						1610	1620	1620	1620	1610			
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer					DCON _{MS}	LF	PSIR
1.0	6	1.0	0.50	1.0	2	R216.42-01030-AP10G					6.0	80.0	0°
2.0	6	2.0	1.00	2.0	2	R216.42-02030-AP20G					6.0	80.0	0°
3.0	6	3.0	1.50	3.0	2	R216.42-03030-AP03G					6.0	80.0	0°
4.0	8	4.0	2.00	4.0	2	R216.42-04030-AP04G					8.0	90.0	0°
5.0	8	5.0	2.50	5.0	2	R216.42-05030-AP05G					8.0	100.0	0°
6.0	10	6.0	3.00	6.0	2	R216.42-06030-AP06G					10.0	100.0	0°
8.0	12	8.0	4.00	8.0	2	R216.42-08030-AP08G					12.0	100.0	0°
10.0	14	10.0	5.00	10.0	2	R216.42-10030-AP10G					14.0	125.0	0°
12.0	16	12.0	6.00	12.0	2	R216.42-12030-AP12G					16.0	140.0	0°

FHA 30°
BSG COROMANT
TCDC h7
TCDCON h6
PSIR 0°



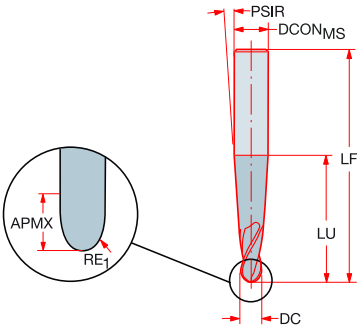
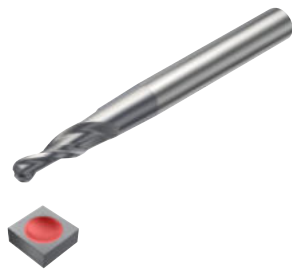
Metrische Ausführung

						P	M	K	S	H	Abmessungen, mm	
						1610	1610	1610	1610	1610		
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer					DCON _{MS}	LF
3.0	3	5.0	1.50	5.0	2	R216.42-03030-AQ05G					3.0	100.0
4.0	4	6.0	2.00	6.0	2	R216.42-04030-AQ06G					4.0	100.0
6.0	6	9.0	3.00	9.0	2	R216.42-06030-AQ09G					6.0	125.0
8.0	8	12.0	4.00	12.0	2	R216.42-08030-AQ12G					8.0	150.0
10.0	10	15.0	5.00	15.0	2	R216.42-10030-AQ15G					10.0	150.0
12.0	12	18.0	6.00	18.0	2	R216.42-12030-AQ18G					12.0	150.0

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilmbearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA 40°
BSG COROMANT
TCDCON h6
PSIR 3°



Metrische Ausführung

							P	M	K	N	S	H	Abmessungen, mm				
							1620	1630	1620	1630	1620	1630	1620	1630	1620	1630	
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer	1620	1630	1620	1630	1620	1630	1620	1630	1620	1630	
4.0	8	40.0	2.00	40.0	3	R216.53-04040RAL40G	☆	★	☆	★	☆	★	☆	★	8.0 _{MS}	80.0	3°
	8	10.0	2.00	10.0	2	R216.52-04040RAL10G		★	☆	★	☆	★	☆	★	8.0	80.0	3°
6.0	10	12.0	3.00	12.0	2	R216.52-06040RAL12G		★	☆	★	☆	★	☆	★	10.0	100.0	3°
	10	40.0	3.00	40.0	4	R216.54-06040RAL40G	☆	★	☆	★	☆	★	☆	★	10.0	100.0	3°
8.0	12	15.0	4.00	15.0	3	R216.53-08040RAL15G		★	☆	★	☆	★	☆	★	12.0	100.0	3°
	12	40.0	4.00	40.0	4	R216.54-08040RAL40G	☆	★	☆	★	☆	★	☆	★	12.0	100.0	3°
10.0	14	40.0	5.00	40.0	4	R216.54-10040RAL40G	☆	★	☆	★	☆	★	☆	★	14.0	115.0	3°
12.0	16	42.0	6.00	42.0	4	R216.54-12040RAL42G	☆	★	☆	★	☆	★	☆	★	16.0	115.0	3°
16.0	20	45.0	8.00	45.0	4	R216.54-16040RAL45G	☆	★	☆	★	☆	★	☆	★	20.0	125.0	3°
							P	M	K	N	S	H					

A192

A194

E9

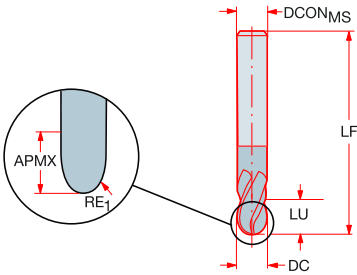
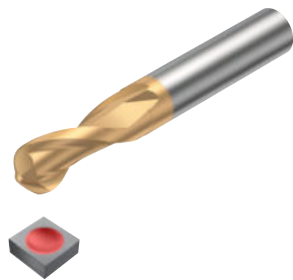
E22

E14

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung

Für gehärteten Stahl mit Härte 43≤ HRC ≤63

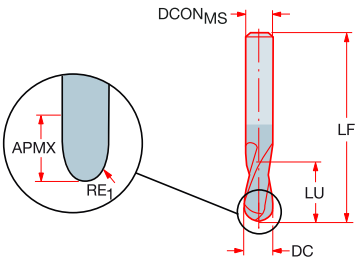
FHA 30°
BSG COROMANT
TCDCON h6
PSIR 0°



Metrische Ausführung

							H	Abmessungen, mm	
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer	1700	DCON _{MS}	LF
3.0	6	4.5	1.50	10.0	2	R216.42-03030-AL04G	★	6.0	70.0
	6	4.5	1.50	5.0	2	R216.42-03030-AS04G	★	6.0	57.0
4.0	6	6.0	2.00	6.0	2	R216.42-04030-AC06G	★	6.0	70.0
	6	6.0	2.00	6.0	2	R216.42-04030-AS06G	★	6.0	57.0
5.0	6	7.5	2.50	8.0	2	R216.42-05030-AC07G	★	6.0	80.0
	6	7.5	2.50	8.0	2	R216.42-05030-AS07G	★	6.0	57.0
6.0	6	9.0	3.00	9.0	2	R216.42-06030-AC09G	★	6.0	90.0
	6	9.0	3.00	9.0	2	R216.42-06030-AS09G	★	6.0	57.0
8.0	8	12.0	4.00	12.0	2	R216.42-08030-AC12G	★	8.0	100.0
	8	12.0	4.00	12.0	2	R216.42-08030-AS12G	★	8.0	63.0
10.0	10	15.0	5.00	15.0	2	R216.42-10030-AC15G	★	10.0	100.0
	10	15.0	5.00	15.0	2	R216.42-10030-AS15G	★	10.0	72.0
12.0	12	18.0	6.00	18.0	2	R216.42-12030-AS18G	★	12.0	83.0

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6
PSIR 0°



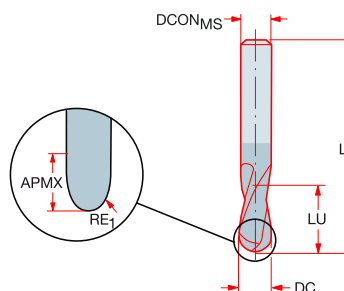
Metrische Ausführung

							P	H	Abmessungen, mm	
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer	1610	1610	DCON _{MS}	LF
6.0	6	6.0	3.00	21.0	4	R216.44-06030-AI06G	☆	★	6.0	57.0
8.0	8	8.0	4.00	27.0	4	R216.44-08030-AI08G	☆	★	8.0	63.0
10.0	10	10.0	5.00	32.0	4	R216.44-10030-AI10G	☆	★	10.0	72.0
12.0	12	12.0	6.00	36.0	4	R216.44-12030-AI12G	☆	★	12.0	83.0
16.0	16	16.0	8.00	42.0	4	R216.44-16030-AI16G	☆	★	16.0	92.0

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilarbeitung

Für gehärteten Stahl mit Härte $43 \leq \text{HRC} \leq 63$

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6
PSIR 0°



Metrische Ausführung

						P	H	Abmessungen, mm	
						1610	1610		
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer		DCON _{MS}	LF
1.0	6	1.5	0.50	1.5	2	R216.42-01030-AC15G		6.0	57.0
2.0	6	3.0	1.00	3.0	2	R216.42-02030-AC30G		6.0	57.0
3.0	6	4.0	1.50	4.0	2	R216.42-03030-AC04G		6.0	21.0
4.0	6	5.0	2.00	5.0	2	R216.42-04030-AC05G		6.0	57.0
5.0	6	6.0	2.50	6.0	2	R216.42-05030-AC06G		6.0	57.0
6.0	6	10.0	3.00	10.0	2	R216.42-06030-AC10G		6.0	57.0
8.0	8	16.0	4.00	16.0	2	R216.42-08030-AC16G		8.0	63.0
10.0	10	19.0	5.00	19.0	2	R216.42-10030-AC19G		10.0	72.0
12.0	12	22.0	6.00	22.0	2	R216.42-12030-AC22G		12.0	83.0

Zoll-Ausführung

						P	H	Abmessungen, Zoll	
						1610	1610		
DC	CZC _{MS}	APMX	RE ₁	LU	ZEFP	Bestellnummer		DCON _{MS}	LF
.063	1/4	.125	.031	.125	2	RA216.42-0430-AK08G		.250	3.000
.094	1/4	.188	.047	.188	2	RA216.42-0630-AK12G		.250	3.000
.125	1/4	.250	.063	.250	2	RA216.42-0830-AK04G		.250	3.000
.187	1/4	.375	.094	.375	2	RA216.42-1230-AK06G		.250	3.000
.250	1/4	.500	.125	.500	2	RA216.42-1630-AK08G		.250	3.000
.313	3/8	.625	.156	.625	2	RA216.42-2030-AK10G		.375	3.500
.375	3/8	.750	.188	.750	2	RA216.42-2430-AK12G		.375	3.500
.500	1/2	1.000	.250	1.000	2	RA216.42-3230-AK16G		.500	4.000



A192



A194



E9



E22

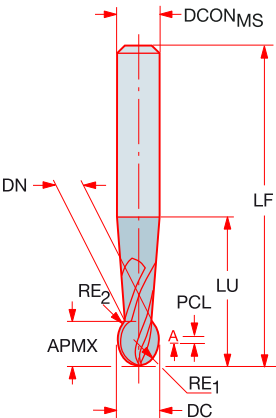
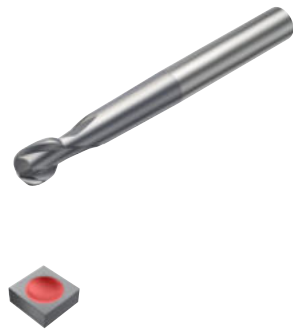


E14

CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilarbeit

Für gehärteten Stahl mit Härte 43≤ HRc ≤63

FHA 30°
BSG COROMANT
TCDC h7
TCDCON h5
PSIR 0°



Metrische Ausführung

							P H		Abmessungen, mm			
							160	160				
DC	CZC _{MS}	APMX	RE ₁	RE ₂	LU	ZEFP	Bestellnummer		DCON _{MS}	LF	PCL	DN
1.0	6	2.0	0.50		4.0	2	R216.62-01030-AO20G		6.0	75.0	1.5	1.0
2.0	6	3.0	1.00	1.00	11.0	2	R216.62-02030-AO30G		6.0	75.0	1.5	1.7
3.0	6	4.0	1.50	1.50	16.1	2	R216.62-03030-AO04G		6.0	80.0	1.7	2.5
4.0	6	5.0	2.00	2.00	21.2	2	R216.62-04030-AO05G		6.0	80.0	1.9	3.3
5.0	6	7.0	2.50	2.50	43.0	2	R216.62-05030-AO07G		6.0	80.0	3.1	4.1
	6	7.0	2.50	2.50	43.0	4	R216.64-05030-AO07G		6.0	80.0	3.1	4.1
6.0	6	7.0	3.00	3.00	30.0	2	R216.62-06030-AO07G		6.0	100.0	2.1	4.7
	6	7.0	3.00	3.00	30.0	4	R216.64-06030-AO07G		6.0	100.0	2.1	4.7
8.0	8	9.0	4.00	4.00	36.0	2	R216.62-08030-AO09G		8.0	100.0	2.7	6.5
	8	9.0	4.00	4.00	36.0	4	R216.64-08030-AO09G		8.0	100.0	2.7	6.5
10.0	10	11.0	5.00	5.00	43.0	2	R216.62-10030-AO11G		10.0	100.0	3.1	8.2
	10	11.0	5.00	5.00	43.0	4	R216.64-10030-AO11G		10.0	100.0	3.1	8.2
12.0	12	13.0	6.00	6.00	52.0	2	R216.62-12030-AO13G		12.0	100.0	3.5	9.8
	12	13.0	6.00	6.00	52.0	4	R216.64-12030-AO13G		12.0	100.0	3.5	9.8
16.0	16	15.0	8.00	8.00	61.0	2	R216.62-16030-AO15G		16.0	150.0	2.6	13.4
	16	15.0	8.00	8.00	61.0	4	R216.64-16030-AO15G		16.0	150.0	2.6	13.4

CoroMill® Plura Vollhartmetall-Schaftfräser zum Besäumen

Einsatzbereich

Beim Formen von Harz-Metall-Materialien; einschließlich CFK, GFK und Aramid und anderer Verbundwerkstoffe

Produktangebot

Für Verbundwerkstoffe

ISO-Werkstoff

O

Sorte

1630 O10A 012M 010M

Schaft

Zylindrisch

B

C

D

E



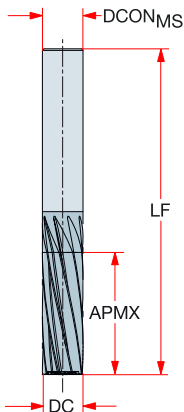
CoroMill® Plura Vollhartmetall-Schaftfräser zum Besäumen

Für CFK-Werkstoffe



FHA
TCDCON

-4°
h6



Metrische Ausführung

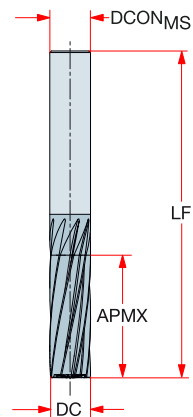
					0	Abmessungen, mm	
					010A		
DC	CZC _{MS}	APMX	ZEFP	Bestellnummer		DCON _{MS}	LF
4.0	4	12.0	5	2P051-0400-OA	★	4.0	40.0
6.0	6	18.0	7	2P051-0600-OA	★	6.0	60.0
8.0	8	20.0	9	2P051-0800-OA	★	8.0	70.0
10.0	10	30.0	9	2P051-1000-OA	★	10.0	80.0
12.0	12	31.8	11	2P051-1200-OA	★	12.0	82.5

Zoll-Ausführung

					0	Abmessungen, Zoll	
					010A		
DC	CZC _{MS}	APMX	ZEFP	Bestellnummer		DCON _{MS}	LF
.250	1/4	.752	7	2P051-0635-OA	★	.250	2.500
.313	5/16	.752	7	2P051-0794-OA	★	.313	2.500
.375	3/8	1.122	9	2P051-0953-OA	★	.375	3.000
.500	1/2	1.252	11	2P051-1270-OA	★	.500	3.248

CoroMill® Plura Vollhartmetall-Schaftfräser zum Besäumen

Für CFK-Werkstoffe

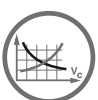
FHA
TCDCON 4°
h6

Metrische Ausführung

					0	Abmessungen, mm	
					010A		
DC	CZC _{MS}	APMX	ZEFP	Bestellnummer		DCON _{MS}	LF
4.0	4	12.0	5	2P050-0400-OA	★	4.0	40.0
6.0	6	18.0	7	2P050-0600-OA	★	6.0	60.0
8.0	8	20.0	9	2P050-0800-OA	★	8.0	70.0
10.0	10	30.0	9	2P050-1000-OA	★	10.0	80.0
12.0	12	31.8	11	2P050-1200-OA	★	12.0	82.5

Zoll-Ausführung

					0	Abmessungen, Zoll	
					010A		
DC	CZC _{MS}	APMX	ZEFP	Bestellnummer		DCON _{MS}	LF
.250	1/4	.752	7	2P050-0635-OA	★	.250	2.500
.313	5/16	.752	7	2P050-0794-OA	★	.313	2.500
.375	3/8	1.122	9	2P050-0953-OA	★	.375	3.000
.500	1/2	1.252	11	2P050-1270-OA	★	.500	3.248



A192



A194



E9



E22



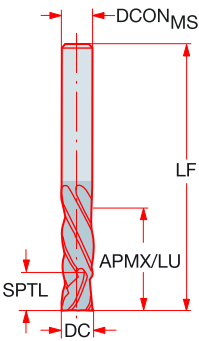
E14

CoroMill® Plura Vollhartmetall-Schaftfräser zum Besäumen

Für CFK-Werkstoffe



FHA30°
BSGCOROMANT
TCDC h10
TCDCON h6



Metrische Ausführung

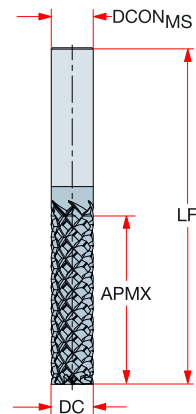
						0	Abmessungen, mm		
						1630			
DC	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer		DCON _{MS}	LF	SPTL
6.0	6	26.0	26.0	6	2P460-0600-NA	★	6.0	76.0	6.0
8.0	8	26.0	26.0	6	2P460-0800-NA	★	8.0	76.0	8.0
10.0	10	30.0	30.0	6	2P460-1000-NA	★	10.0	76.0	10.0
12.0	12	38.0	38.0	6	2P460-1200-NA	★	12.0	100.0	12.0
16.0	16	38.0	38.0	6	2P460-1600-NA	★	16.0	100.0	16.0

Zoll-Ausführung

						0	Abmessungen, Zoll		
						1630			
DC	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer		DCON _{MS}	LF	SPTL
.250	1/4	1.000	1.000	6	2P460-0635-NA	★	.250	3.000	.250
.313	5/16	1.000	1.000	6	2P460-0794-NA	★	.313	3.000	.313
.375	3/8	1.250	1.250	6	2P460-0952-NA	★	.375	3.000	.375
.500	1/2	1.500	1.500	6	2P460-1270-NA	★	.500	4.000	.500
.625	5/8	1.500	1.500	6	2P460-1588-NA	★	.625	4.000	.625

CoroMill® Plura Vollhartmetall-Schaftfräser zum Besäumen

Für CFK-Werkstoffe

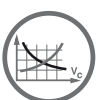
FHA
TCDCON 40°
h6

Metrische Ausführung

					0	Abmessungen, mm	
					O12M		
DC	CZC _{MS}	APMX	ZEFP	Bestellnummer		DCON _{MS}	LF
6.0	6	18.0	5	2P350-0600-OA	★	6.0	60.0
8.0	8	20.0	6	2P350-0800-OA	★	8.0	70.0
10.0	10	30.0	6	2P350-1000-OA	★	10.0	80.0
12.0	12	31.8	6	2P350-1200-OA	★	12.0	82.5

Zoll-Ausführung

					0	Abmessungen, Zoll	
					O12M		
DC	CZC _{MS}	APMX	ZEFP	Bestellnummer		DCON _{MS}	LF
.250	1/4	.750	5	2P350-0635-OA	★	.250	2.500
.313	5/16	.750	6	2P350-0794-OA	★	.313	2.500
.375	3/8	1.122	6	2P350-0953-OA	★	.375	3.000
.500	1/2	1.252	6	2P350-1270-OA	★	.500	3.248



A192



A194



E9



E22



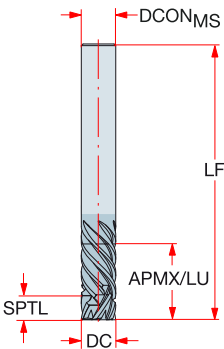
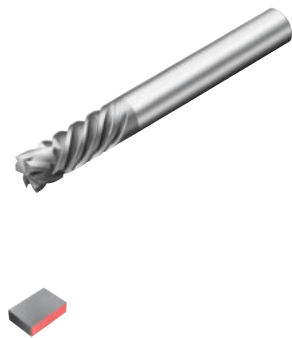
E14

CoroMill® Plura Vollhartmetall-Schaftfräser zum Besäumen

Für CFK-Werkstoffe

FHA40°

TCDCONh6



Metrische Ausführung

						Abmessungen, mm		
						DC	DCON _{MS}	LF
DC	CZC _{MS}	APMX	ZEFP	Bestellnummer	OTOM			
6.0	6	18.0	6	2P460-0600-OA	★	6.0	60.0	5.0
8.0	8	20.0	6	2P460-0800-OA	★	8.0	70.0	5.0
10.0	10	30.0	6	2P460-1000-OA	★	10.0	80.0	5.0
12.0	12	31.8	6	2P460-1200-OA	★	12.0	82.5	10.0
16.0	16	38.1	6	2P460-1600-OA	★	16.0	100.0	10.0

Zoll-Ausführung

						Abmessungen, Zoll		
						DC	DCON _{MS}	LF
DC	CZC _{MS}	APMX	ZEFP	Bestellnummer	OTOM			
.250	1/4	.752	6	2P460-0635-OA	★	.250	2.500	.197
.313	5/16	.752	6	2P460-0794-OA	★	.313	2.500	.197
.375	3/8	1.122	6	2P460-0953-OA	★	.375	3.000	.197
.500	1/2	1.252	6	2P460-1270-OA	★	.500	3.248	.394
.625	5/8	1.500	6	2P460-1588-OA	★	.625	4.000	.394

CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

ISO-Werkstoff

P

M

K

N

S

H

O

Sorte

1610 1620 H07F

Schaft

Zylindrisch

Weldon

B

C

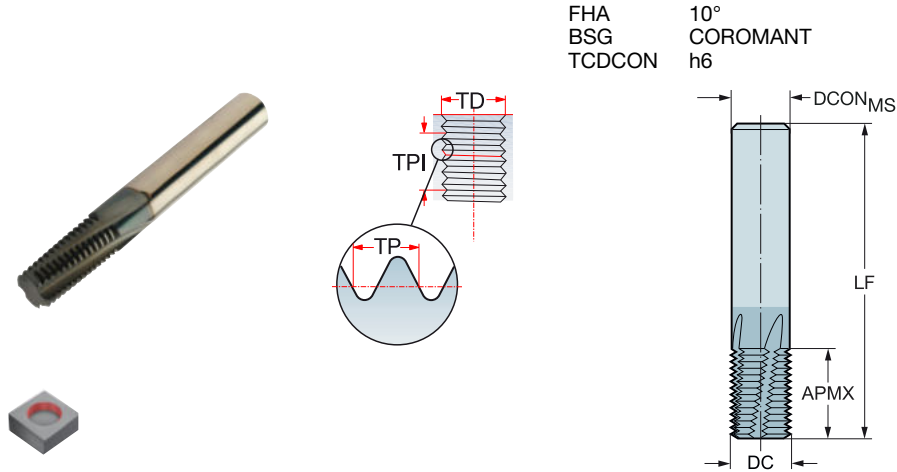
D

E



CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Multimaterial-Anwendungen
Innengewinde



Metrisch/Metrisch Fein, 60°

									P	M	K	N	S	H	Abmessungen, mm	
								Bestellnummer	1630	1630	1630	1630	1630	1630	DCON _{MS}	LF
FTDZ	TP	DC	CZC _{MS}	APMX	CNSC	CXSC	ZEFP									
M4X0.7	0.70	3.20	6.0	8.40	0	0	3	R217.13-032070AC08N	*	*	*	*	*	*	6.00	57.00
M5X0.8	0.80	4.10	6.0	11.20	0	0	3	R217.13-041080AC11N	*	*	*	*	*	*	6.00	57.00
M6X0.5	0.50	4.80	6.0	10.00	1	1	3	R217.13C048050AC10N	*	*	*	*	*	*	6.00	57.00
M8X0.75	0.75	6.00	6.0	12.00	1	1	3	R217.13C060075AC12N	*	*	*	*	*	*	6.00	57.00
M6X1.0	1.00	4.50	6.0	13.00	1	1	4	R217.14C045100AC13N	*	*	*	*	*	*	6.00	57.00
M8X1.25	1.25	6.00	6.0	17.50	1	1	4	R217.14C060125AK17N	*	*	*	*	*	*	6.00	65.00
M10X1.5	1.50	7.50	8.0	21.00	1	1	4	R217.14C075150AK21N	*	*	*	*	*	*	8.00	72.00
M10X1.0	1.00	8.00	8.0	16.00	1	1	4	R217.14C080100AC16N	*	*	*	*	*	*	8.00	63.00
M12X1.75	1.75	9.50	10.0	26.25	1	1	4	R217.14C095175AK26N	*	*	*	*	*	*	10.00	80.00
M14X2.0	2.00	10.00	10.0	30.00	1	1	5	R217.15C100200AK30N	*	*	*	*	*	*	10.00	83.00
M14X1.5	1.50	12.00	12.0	22.50	1	1	4	R217.14C120150AC22N	*	*	*	*	*	*	12.00	83.00
M16X2.0	2.00	12.00	12.0	34.00	1	1	5	R217.15C120200AK34N	*	*	*	*	*	*	12.00	92.00
M18X1.5	1.50	16.00	16.0	30.00	1	1	5	R217.15C160150AC30N	*	*	*	*	*	*	16.00	92.00
M20X2.5	2.50	16.00	16.0	42.50	1	1	5	R217.15C160250AK42N	*	*	*	*	*	*	16.00	105.00
M24X3.0	3.00	19.00	20.0	50.00	1	1	5	R217.15C190300AK50N	*	*	*	*	*	*	20.00	125.00

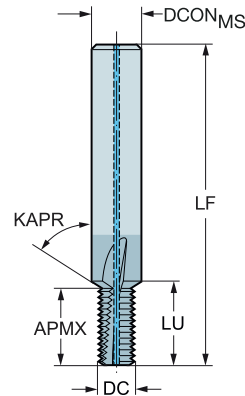
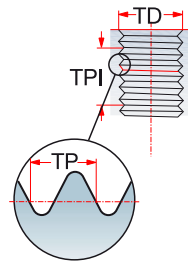
CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Multimaterial-Anwendungen

Innengewinde

FHA
BSG
TCDCON

10°
COROMANT
h6



Metrisch/Metrisch Fein, 60°

										P	M	K	N	S	H	Abmessungen, mm	
FTDZ	TP	DC	CZC _{MS}	APMX	LU	CNSC	CXSC	ZEFP	Bestellnummer	1630	1630	1630	1630	1630	1630	DCON _{MS}	LF
M3X0.5	0.50	2.30	6.0	5.00	6.00	0	0	3	R217.13-023050CC06K	*	*	*	*	*	*	6.00	57.0
M4X0.70	0.70	3.20	6.0	8.80	9.50	1	1	3	R217.13C032070CC08K	*	*	*	*	*	*	6.00	57.0
M5X0.80	0.80	4.10	6.0	10.72	11.67	1	1	3	R217.13C041080CC11K	*	*	*	*	*	*	6.00	57.0
M6X1.0	1.00	4.80	8.0	12.78	13.58	1	1	3	R217.13C048100CC13K	*	*	*	*	*	*	8.00	63.0
M8X1.25	1.25	6.50	10.0	17.35	18.24	1	1	3	R217.13C065125CC17K	*	*	*	*	*	*	10.00	72.0
M10X1.5	1.50	8.20	12.0	22.41	23.41	1	1	3	R217.13C082150CC21K	*	*	*	*	*	*	12.00	83.0
M12X1.75	1.75	9.90	14.0	26.00	27.00	1	1	4	R217.14C099175CC26K	*	*	*	*	*	*	14.00	83.0
M14X2.0	2.00	11.60	16.0	31.30	32.40	1	1	4	R217.14C116200CC30K	*	*	*	*	*	*	16.00	92.0
M16X2.0	2.00	13.60	18.0	33.30	34.40	1	1	4	R217.14C136200CC34K	*	*	*	*	*	*	18.00	92.0



A193



A194



E9



E26



E28

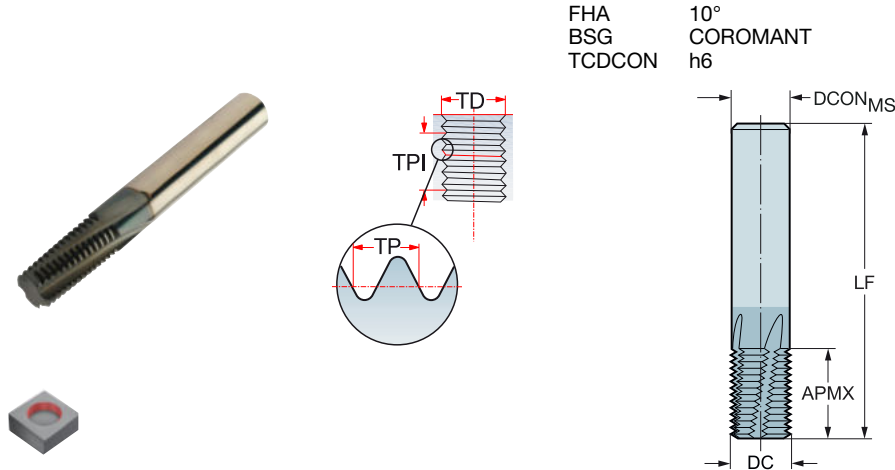


E14

CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Multimaterial-Anwendungen

Innengewinde



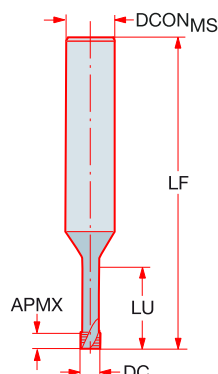
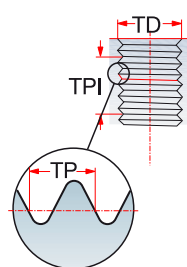
CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Multimaterial-Anwendungen

Innengewinde

FHA
BSG
TCDCON

15°
COROMANT
h6



Metrisch/Metrisch Fein, 60°

								P	M	K	N	S	H	O	Abmessungen, mm				
FTDZ	TP	DC	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1620	H07F	1620	H07F	1620	H07F	1620	H07F	1620	H07F	DCON _{MS}	LF
M 1.6	0.35	1.20	3.0	0.53	5.33	3	R217.13-012035AC05P	*	*	*	*	*	*	*	*	*	*	3.00	37.8
M 1.6	0.35	1.20	6.0	0.53	3.73	3	R217.13-012035AC03P	*	*	*	*	*	*	*	*	*	*	6.00	37.8
M 2	0.40	1.55	6.0	1.00	4.60	3	R217.13-015040AC04P	*	*	*	*	*	*	*	*	*	*	6.00	56.8
M 2	0.40	1.55	6.0	1.00	6.60	3	R217.13-015040AC06P	*	*	*	*	*	*	*	*	*	*	6.00	56.8
M 2.5	0.45	1.95	6.0	1.13	5.68	3	R217.13-019045AC05P	*	*	*	*	*	*	*	*	*	*	6.00	56.8
M 2.5	0.45	1.95	6.0	1.13	8.18	3	R217.13-019045AC07P	*	*	*	*	*	*	*	*	*	*	6.00	56.8
M 3	0.50	2.30	6.0	1.25	6.75	3	R217.13-023050AC06P	*	*	*	*	*	*	*	*	*	*	6.00	56.8
M 3	0.50	2.30	6.0	1.25	9.75	3	R217.13-023050AC09P	*	*	*	*	*	*	*	*	*	*	6.00	56.8
M 4	0.70	3.10	6.0	1.75	9.05	3	R217.13-031070AC08P	*	*	*	*	*	*	*	*	*	*	6.00	56.7
M 4	0.70	3.10	6.0	1.75	13.05	3	R217.13-031070AC12P	*	*	*	*	*	*	*	*	*	*	6.00	56.7
M 5	0.80	4.00	6.0	2.00	11.20	3	R217.13-040080AC10P	*	*	*	*	*	*	*	*	*	*	6.00	56.6
M 5	0.80	4.00	6.0	2.00	16.20	3	R217.13-040080AC15P	*	*	*	*	*	*	*	*	*	*	6.00	56.6
M 6	1.00	4.80	6.0	2.50	13.50	3	R217.13-048100AC12P	*	*	*	*	*	*	*	*	*	*	6.00	56.5
M 6	1.00	4.80	6.0	2.50	19.50	3	R217.13-048100AC18P	*	*	*	*	*	*	*	*	*	*	6.00	59.5
M 8	1.25	6.40	8.0	3.13	17.90	3	R217.13-064125AC16P	*	*	*	*	*	*	*	*	*	*	8.00	63.0
M 8	1.25	6.40	8.0	3.13	25.88	3	R217.13-064125AC24P	*	*	*	*	*	*	*	*	*	*	8.00	67.4
M 10	1.50	8.20	10.0	3.75	22.30	4	R217.14-082150AC20P	*	*	*	*	*	*	*	*	*	*	10.00	71.3
M 12	1.75	9.50	10.0	4.38	26.70	5	R217.15-095175AC24P	*	*	*	*	*	*	*	*	*	*	10.00	71.1



A193



A194



E9



E26

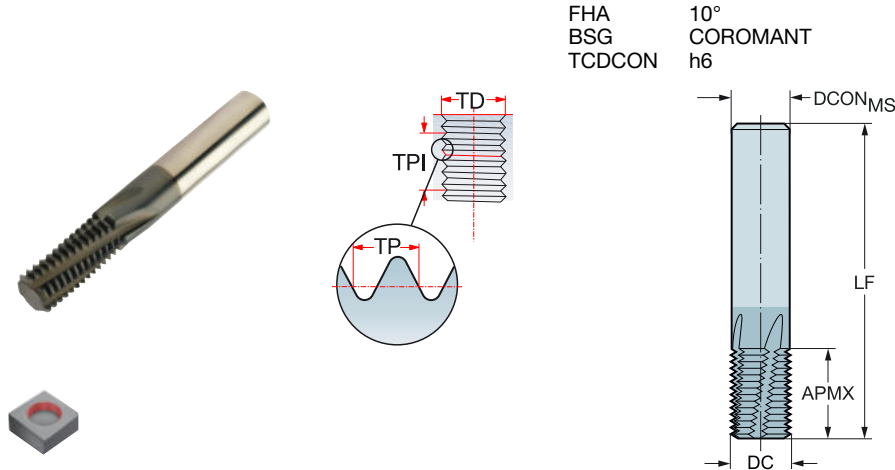


E14

CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Nickelbasislegierungen und gehärteten Stahl

Innengewinde



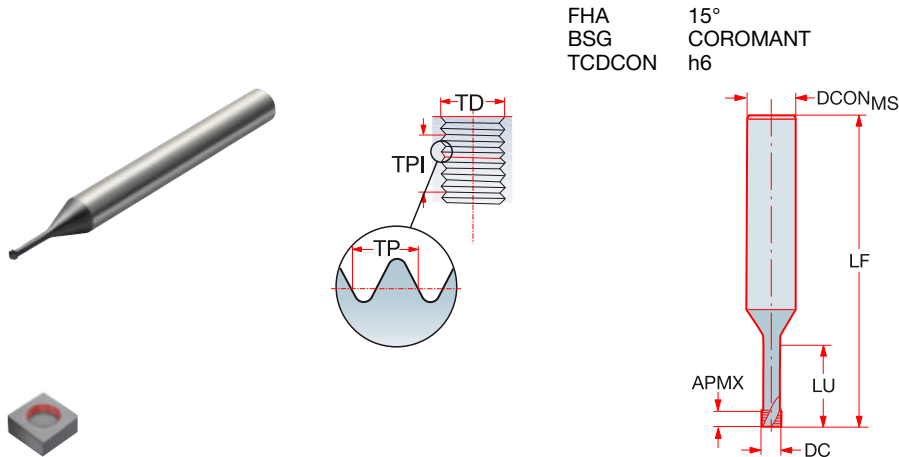
Metrisch/Metrisch Fein, 60°

							S	H	Abmessungen, mm	
FTDZ	TP	DC	CZC _{MS}	APMX	ZEFP	Bestellnummer	1620	1620	DCON _{MS}	LF
M6X1.0	1.00	4.50	6.0	10.00	4	R217.14-045100AC10M	★	★	6.00	57.00
M8X1.25	1.25	6.00	6.0	12.50	5	R217.15-060125AC12M	★	★	6.00	57.00
M10X1.5	1.50	8.00	8.0	16.50	5	R217.15-080150AC16M	★	★	8.00	63.00
M12X1.75	1.75	9.00	10.0	19.25	5	R217.15-090175AC19M	★	★	10.00	72.00
MF12X1	1.00	10.00	10.0	20.00	5	R217.15-100100AC20M	★	★	10.00	72.00
M14X2.0	2.00	12.00	12.0	26.00	5	R217.15-120200AC26M	★	★	12.00	83.00
MF14X1.5	1.50	12.00	12.0	27.00	6	R217.16-120150AC27M	★	★	12.00	83.00

CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Nickelbasislegierungen und gehärteten Stahl

Innengewinde



Metrisch/Metrisch Fein, 60°

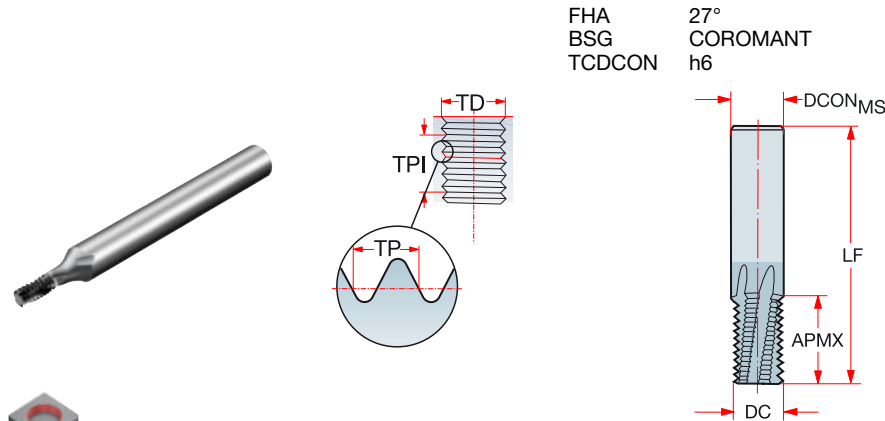
							S H		Abmessungen, mm	
FTDZ	TP	DC	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer		16/0	16/0
M 2	0.40	1.50	6.0	0.60	4.60	3	R217.13-015040AC04S		★ ★	DCON _{MS} LF
M 2.5	0.45	1.95	6.0	0.68	5.68	3	R217.13-019045AC05S		★ ★	6.00 56.8
M 3	0.50	2.30	6.0	0.75	6.75	3	R217.13-023050AC06S		★ ★	6.00 56.8
M 4	0.70	3.10	6.0	1.05	9.05	3	R217.13-031070AC08S		★ ★	6.00 56.7
M 5	0.80	4.00	6.0	1.20	11.20	4	R217.14-040080AC10S		★ ★	6.00 56.6
M 6	1.00	4.80	6.0	1.50	13.50	4	R217.14-048100AC12S		★ ★	6.00 56.5



CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Multimaterial-Anwendungen

Innengewinde



MJ 60°

								P	M	K	N	S	H	Abmessungen, mm	
FTDZ	TP	DC	CZC _{MS}	APMX	CNSC	CXSC	ZEFP	Bestellnummer	1630	1630	1630	1630	1630	DCON _{MS}	LF
MJ4X0.7	0.70	3.00	6.0	6.30	0	0	3	R217.13-030070AC6H	★	★	★	★	★	6.00	54.00
MJ5X0.8	0.80	3.90	6.0	8.00	0	0	3	R217.13-039080AC8H	★	★	★	★	★	6.00	54.00
MJ6X1	1.00	4.80	6.0	9.00	0	0	3	R217.13-048100AC9H	★	★	★	★	★	6.00	54.00
MJ8X1.25	1.25	6.30	8.0	12.50	1	1	4	R217.14C063125AC12H	★	★	★	★	★	8.00	58.00
MJ10X1.5	1.50	7.50	8.0	15.00	1	1	4	R217.14C075150AC15H	★	★	★	★	★	8.00	58.00
MJ12X1.75	1.75	9.50	10.0	19.25	1	1	4	R217.14C095175AC19H	★	★	★	★	★	10.00	72.00

C

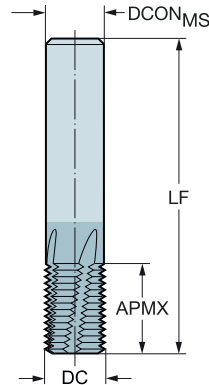
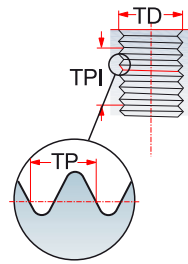
D

E

CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Multimaterial-Anwendungen

Innengewinde

FHA
BSG
TCDCON10°
COROMANT
h6

UN 60°

								P	M	K	N	S	H	Abmessungen, Zoll	
FTDZ	TPI	DC	CZC _{MS}	APMX	CNSC	CXSC	ZEFP	Bestellnummer	1630	1630	1630	1630	1630	DCON _{MS}	LF
1/4-20 UNC	20.0	.189	6.0	.551	1	1	3	R217.33C048200AC13N	★	★	★	★	★	.236	2.244
5/16-18 UNC	18.0	.217	6.0	.556	1	1	3	R217.33C055180AC14N	★	★	★	★	★	.236	2.244
3/8-16 UNC	16.0	.295	8.0	.750	1	1	4	R217.34C075160AC19N	★	★	★	★	★	.315	2.480
7/16-14 UNC	14.0	.315	8.0	.785	1	1	4	R217.34C080140AC19N	★	★	★	★	★	.315	2.480
1/2-13 UNC	13.0	.394	10.0	.846	1	1	4	R217.34C100130AC21N	★	★	★	★	★	.394	2.835
9/16-12 UNC	12.0	.394	10.0	.833	1	1	4	R217.34C100120AC21N	★	★	★	★	★	.394	2.835
5/8-11 UNC	11.0	.472	12.0	1.000	1	1	4	R217.34C120110AC25N	★	★	★	★	★	.472	3.268
3/4-10 UNC	10.0	.551	14.0	1.300	1	1	5	R217.35C140100AC33N	★	★	★	★	★	.551	3.268

UNC / UNF, 60°

								P	M	K	N	S	H	Abmessungen, Zoll	
FTDZ	TPI	DC	CZC _{MS}	APMX	CNSC	CXSC	ZEFP	Bestellnummer	1630	1630	1630	1630	1630	DCON _{MS}	LF
1/4-28 UNF	28.0	.189	6.0	.536	1	1	3	R217.33C048280AC13N	★	★	★	★	★	.236	2.244
5/16-24 UNF	24.0	.236	6.0	.541	1	1	3	R217.33C060240AC13N	★	★	★	★	★	.236	2.244
7/16-20 UNF	20.0	.315	8.0	.750	1	1	4	R217.34C080200AC19N	★	★	★	★	★	.315	2.480
9/16-18 UNF	18.0	.394	10.0	.889	1	1	4	R217.34C100180AC22N	★	★	★	★	★	.394	2.835
3/4-16 UNF	16.0	.551	14.0	1.250	1	1	5	R217.35C140160AC31N	★	★	★	★	★	.551	3.268



A193



A194



E9



E26



E28



E14

A

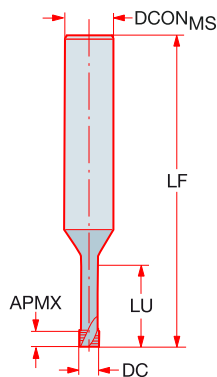
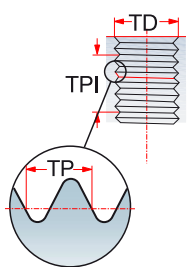
FRÄSEN

Optimiert

CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Multimaterial-Anwendungen

Innengewinde

FHA
BSG
TCDCON15°
COROMANT
h6

B



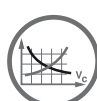
UNC / UNF, 60°

C

								P	M	K	N	S	H	O	Abmessungen, Zoll		
								1620	1620	1620	1620	1620	1620	1620			
FTDZ	TPI	DC ₁	DC ₂	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer							DCON _{MS}	LF ₁	LF ₂
UNC # 1-64	64.0	.053	.027	6.0	.023	.244	3	R217.33-013640AC05P							.236	2.236	2.244
UNF #2-64	64.0	.067	.033	6.0	.016	.281	3	R217.33-017640AC06P							.236	2.236	2.244
UNC #2-56	56.0	.063	.027	6.0	.027	.285	3	R217.33-016560AC06P							.236	2.235	2.244
UNF #3-56	56.0	.077	.041	6.0	.009	.325	3	R217.33-019560AC07P							.236	2.235	2.244
UNC #3-48	48.0	.077	.038	6.0	.052	.329	3	R217.33-019480AC07P							.236	2.223	2.244
UNF #4-48	48.0	.083	.046	6.0	.031	.368	3	R217.33-021480AC08P							.236	2.223	2.244
UNC #4-40	40.0	.083	.041	6.0	.062	.374	3	R217.33-021400AC08P							.236	2.219	2.244
UNF #6-40	40.0	.108	.059	6.0	.037	.453	3	R217.33-027400AC10P							.236	2.230	2.244
UNC #6-32	32.0	.102	.051	6.0	.078	.463	3	R217.33-026320AC10P							.236	2.228	2.244
UNC #8-32	32.0	.128	.064	6.0	.078	.539	3	R217.33-032320AC12P							.236	2.228	2.244
UNF #10-32	32.0	.152	.076	6.0	.047	.618	3	R217.33-038320AC14P							.236	2.228	2.244
UNF 1/4	28.0	.207	.112	6.0	.054	.805	3	R217.33-052280AC19P							.236	2.226	2.244
UNC #10-24	24.0	.140	.070	6.0	.104	.634	3	R217.33-035240AC14P							.236	2.223	2.244
UNF 5/16	24.0	.258	.140	8.0	.062	1.000	3	R217.33-065240AC24P							.315	2.459	2.480
UNC 1/4	20.0	.191	.095	6.0	.125	.827	3	R217.33-048200AC19P							.236	2.219	2.244
UNC 5/16	18.0	.244	.122	8.0	.139	1.022	3	R217.33-062180AC24P							.315	2.453	2.480

D

E



A193



A194



E9



E26



E14

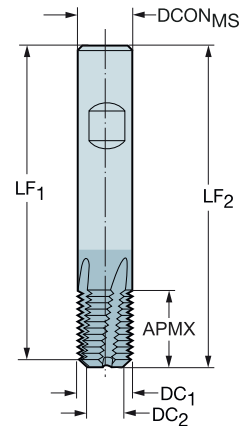
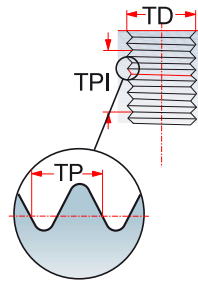
CoroMill® Plura Vollhartmetall-Schaftfräser zum Gewindefräsen

Für Multimaterial-Anwendungen

Innengewinde

FHA
TCD CON 10°
h6

NPT 60°



							P	M	K	N	S	H	Abmessungen, Zoll		
TPI	DC ₁	DC ₂	CZC _{MS}	APMX	ZEFP	Bestellnummer	1630	1630	1630	1630	1630	1630	DCON _{MS}	LF ₁	LF ₂
27.0	.311	.150	8.0	.453	3	R217.53-079270AC11N	*	*	*	*	*	*	.315	2.243	2.283
18.0	.390	.189	10.0	.627	3	R217.53-099180AC15N	*	*	*	*	*	*	.394	2.548	2.598
14.0	.626	.313	16.0	.806	4	R217.54-159140AC20N	*	*	*	*	*	*	.630	3.150	3.228
11.5	.783	.386	20.0	1.068	5	R217.55-199115AC27N	*	*	*	*	*	*	.787	3.523	3.622

NPTF 60°

							P	M	K	N	S	H	Abmessungen, Zoll		
TPI	DC ₁	DC ₂	CZC _{MS}	APMX	ZEFP	Bestellnummer	1630	1630	1630	1630	1630	1630	DCON _{MS}	LF ₁	LF ₂
27.0	.311	.150	8.0	.453	3	R217.73-079270AC11N	*	*	*	*	*	*	.315	2.243	2.283
18.0	.390	.189	10.0	.627	3	R217.73-099180AC15N	*	*	*	*	*	*	.394	2.548	2.598
14.0	.626	.313	16.0	.806	4	R217.74-159140AC20N	*	*	*	*	*	*	.630	3.150	3.228
11.5	.783	.386	20.0	1.068	5	R217.75-199115AC27N	*	*	*	*	*	*	.787	3.523	3.622



A193



A194



E9

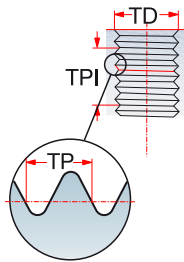
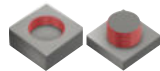


E26

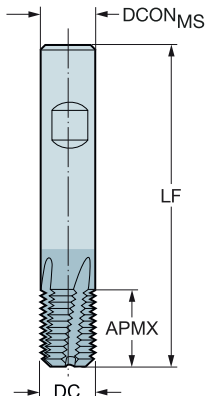


E14

Innen und außen



10°
COROMANT
h6



							P	M	K	N	S	H	Abmessungen, Zoll		
							1630	1630	1630	1630	1630	1630			
FTDZ	TPI	DC	CZC _{MS}	APMX	ZEFP	Bestellnummer							DCON _{MS}	LF	
G1/8	28.0	.236	6.0	.606	3	R217.93-060280BC15N	★	★	★	★	★	★	.236	2.244	
G1/4	19.0	.394	10.0	.787	4	R217.94-100190BC20N	★	★	★	★	★	★	.394	2.835	
G3/8	19.0	.551	14.0	1.051	5	R217.95-140190BC26N	★	★	★	★	★	★	.551	3.268	
G1/2 5/8	14.0	.630	16.0	1.213	5	R217.95-160140BC30N	★	★	★	★	★	★	.630	3.622	
G5/8 3/4 7/8	14.0	.787	20.0	1.425	4	R217.95-200140BC35N	★	★	★	★	★	★	.787	4.094	
G1"-3"	11.0	.984	25.0	1.817	5	R217.95-250110BC45N	★	★	★	★	★	★	.984	4.764	

CoroMill® Plura Keramik-Schaftfräser zum Hochgeschwindigkeitsschruppen

Einsatzbereich

Optimiert für das Eck- und Planfräsen von Nickelbasislegierungen

Eine produktive und stabile Lösung für die Triebwerksbearbeitung in der Luftfahrt

ISO-Werkstoff

S

Sorte

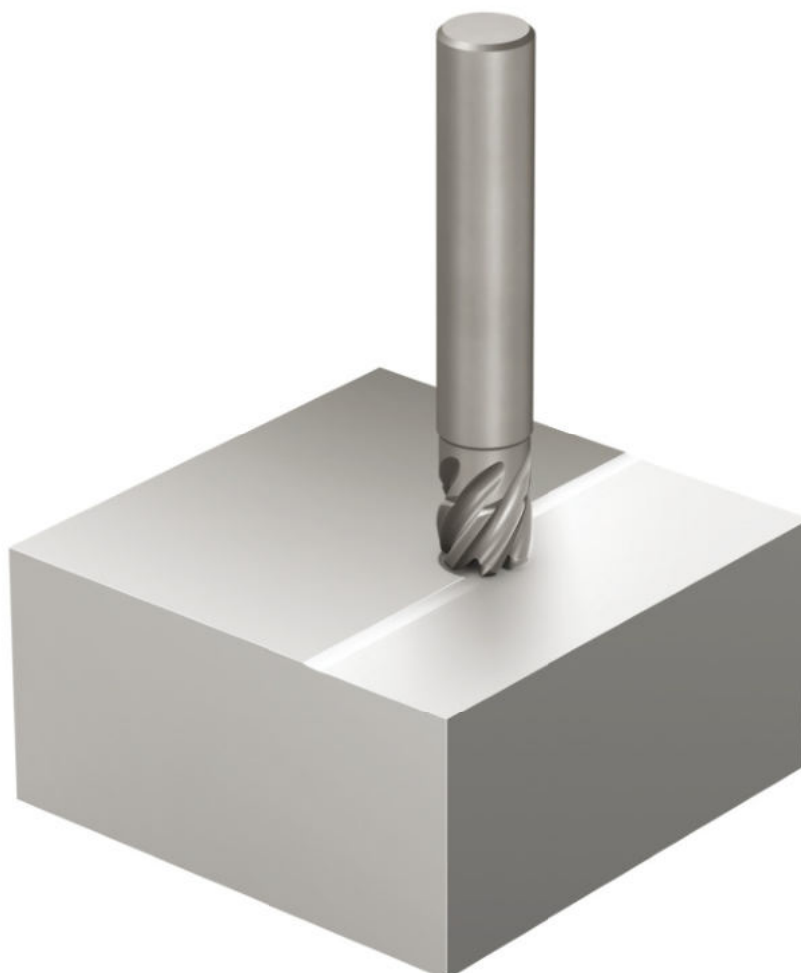
CG6060

Schaft

Zylindrisch

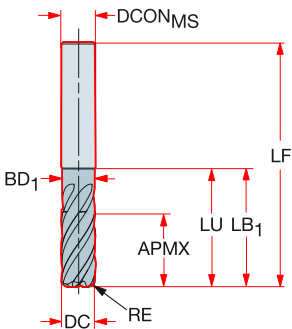
Produktangebot

Optimiert für das Besäumen und Planfräsen von Nickelbasislegierungen



CoroMill® Plura Keramik-Schaftfräser für die Hochgeschwindigkeitsbearbeitung
Für Nickelbasislegierungen

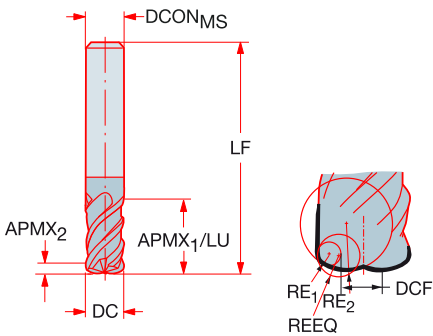
FHA 35°
BSG COROMANT
TCDC h9
TCDCON h6



Metrische Ausführung

								s	Abmessungen, mm			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Bestellnummer		6000	DCON _{MS}	LF	BD ₁	LB ₁
10.0	10	7.5	2.00	15.0	6	2F210-1000-200-SC		★	10.0	60.0	9.5	15.0
12.0	12	9.0	2.00	18.0	6	2F210-1200-200-SC		★	12.0	65.0	11.4	18.0

FHA 38°
BSG COROMANT
TCDC h9
TCDCON h6



Metrische Ausführung

								s	Abmessungen, mm			
DC	CZC _{MS}	APMX ₁	APMX ₂	RE ₁	RE ₂	LU	ZEFP	6000	DCON	DCF	LF	REEQ
10.0	10	15.0	0.7	1.5	5.0	15.0	4	★	10.0	3.4	60.0	1.99
12.0	12	18.0	0.8	1.5	6.0	18.0	4	★	12.0	4.5	65.0	2.10



CoroMill® 316

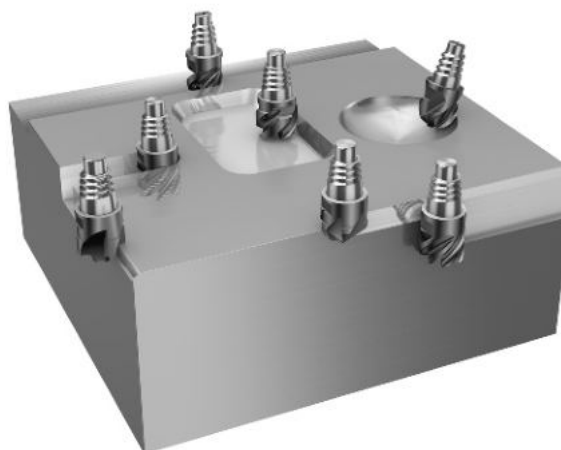
Schruppen bis Schlichten

Anwendungsbereich

- Nutenfräsen
- Spiralinterpolation
- Eckfräsen
- Profilfräsen
- Planfräsen mit hohen Vorschüben
- Fasen



ISO Anwendungsbereich



www.sandvik.coromant.com/coromill316

Produktangebot

- Werkzeuge mit hohem Vorschubpotential
- Spanbrecher-Geometrie
- Werkzeuge mit innerer Kühlschmierstoffzufuhr
- Geometrien zum Schrappen bis zum Feinstschlichten
- Breite Angebotspalette an Schäften und integrierten Maschinenadaptern

Coromant EH-Schnittstelle

Die Coromant EH-Kupplung ist eine zuverlässige und hoch präzise Schnittstelle zwischen Schneidkopf und Schaft. Sie ist einfach zu handhaben und der Schneidkopf lässt sich in wenigen Sekunden auswechseln.



Bestellung, siehe Katalog Rotierende Werkzeuge.

GER

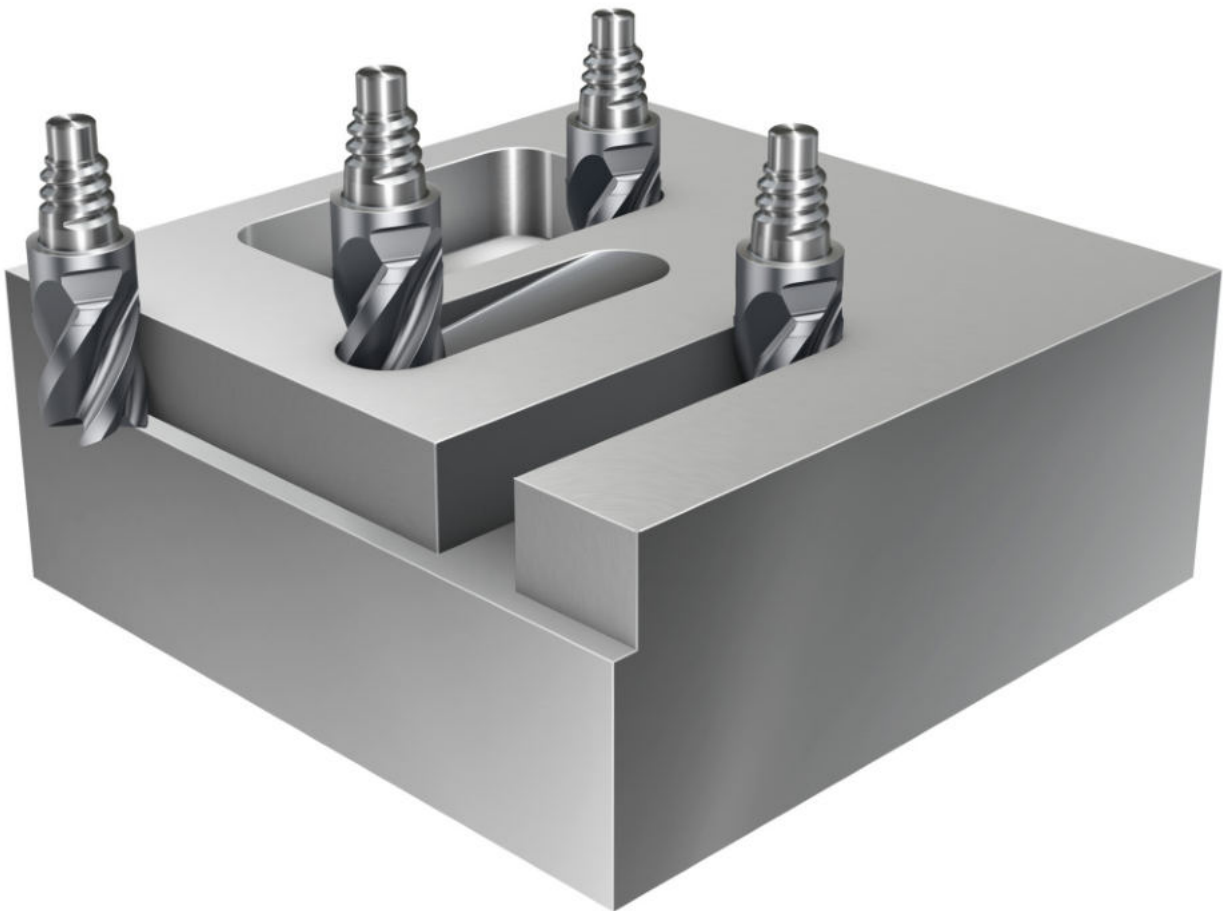
CoroMill® 316 Vollhartmetall-Schneidkopf für die Heavy Duty Fräsbearbeitung

B

Einsatzbereich

Erste Wahl zum Schrappen von ISO P- und ISO M-Werkstoffen

ISO-Werkstoff	P K M S
Sorte	1730
Schaft	Coromant EH

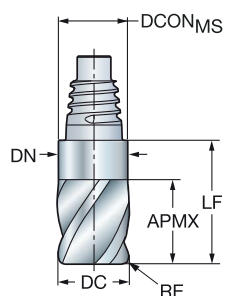


CoroMill® 316 Vollhartmetall-Fräskopf für die Heavy Duty Bearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC

42°
COROMANT
h10



Metrische Ausführung

						P	M	K	S	Abmessungen, mm		
						1730	1730	1730	1730			
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer	★	★	★	★	DCON _{MS}	LF	DN
10.0	E10	12.0	0.50	4	316-10SL442-10005P	★	★	★	★	9.7	18.5	9.7
	E10	12.0	1.00	4	316-10SL442-10010P	★	★	★	★	9.7	18.5	9.7
	E10	12.0	1.50	4	316-10SL442-10015P	★	★	★	★	9.7	18.5	9.7
	E10	12.0	2.00	4	316-10SL442-10020P	★	★	★	★	9.7	18.5	9.7
	E10	12.0	3.00	4	316-10SL442-10030P	★	★	★	★	9.7	18.5	9.7
12.0	E12	14.4	0.50	4	316-12SL442-12005P	★	★	★	★	11.7	22.0	11.7
	E12	14.4	1.00	4	316-12SL442-12010P	★	★	★	★	11.7	22.0	11.7
	E12	14.4	1.50	4	316-12SL442-12015P	★	★	★	★	11.7	22.0	11.7
	E12	14.4	2.00	4	316-12SL442-12020P	★	★	★	★	11.7	22.0	11.7
	E12	14.4	3.00	4	316-12SL442-12030P	★	★	★	★	11.7	22.0	11.7
	E12	14.4	4.00	4	316-12SL442-12040P	★	★	★	★	11.7	22.0	11.7
16.0	E16	19.2	0.50	4	316-16SL442-16005P	★	★	★	★	15.5	29.1	15.5
	E16	19.2	1.00	4	316-16SL442-16010P	★	★	★	★	15.5	29.1	15.5
	E16	19.2	1.50	4	316-16SL442-16015P	★	★	★	★	15.5	29.1	15.5
	E16	19.2	2.00	4	316-16SL442-16020P	★	★	★	★	15.5	29.1	15.5
	E16	19.2	3.00	4	316-16SL442-16030P	★	★	★	★	15.5	29.1	15.5
	E16	19.2	4.00	4	316-16SL442-16040P	★	★	★	★	15.5	29.1	15.5
20.0	E20	24.0	0.50	4	316-20SL442-20005P	★	★	★	★	19.3	34.2	19.3
	E20	24.0	1.00	4	316-20SL442-20010P	★	★	★	★	19.3	34.2	19.3
	E20	24.0	2.00	4	316-20SL442-20020P	★	★	★	★	19.3	34.2	19.3
	E20	24.0	3.00	4	316-20SL442-20030P	★	★	★	★	19.3	34.2	19.3
	E20	24.0	4.00	4	316-20SL442-20040P	★	★	★	★	19.3	34.2	19.3
25.0	E25	30.0	0.50	4	316-25SL442-25005P	★	★	★	★	24.2	41.9	24.2
	E25	30.0	1.00	4	316-25SL442-25010P	★	★	★	★	24.2	41.9	24.2
	E25	30.0	1.50	4	316-25SL442-25015P	★	★	★	★	24.2	41.9	24.2
	E25	30.0	2.00	4	316-25SL442-25020P	★	★	★	★	24.2	41.9	24.2
	E25	30.0	3.00	4	316-25SL442-25030P	★	★	★	★	24.2	41.9	24.2
	E25	30.0	4.00	4	316-25SL442-25040P	★	★	★	★	24.2	41.9	24.2



A179



A194



E9



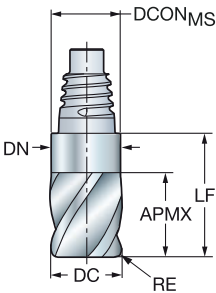
E25

CoroMill® 316 Vollhartmetall-Fräskopf für die Heavy Duty Bearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC

42°
COROMANT
h10



Zoll-Ausführung

						P	M	K	S	Abmessungen, Zoll		
						1730	1730	1730	1730	DCON _{MS}	LF	DN
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer							
.375	E10	.453	.015	4	A316-10SL442-03704P	★	★	☆	☆	.364	.713	.364
	E10	.453	.030	4	A316-10SL442-03708P	★	★	☆	☆	.364	.713	.364
	E10	.453	.060	4	A316-10SL442-03715P	★	★	☆	☆	.364	.713	.364
.500	E12	.602	.015	4	A316-12SL442-05004P	★	★	☆	☆	.484	.898	.484
	E12	.602	.030	4	A316-12SL442-05008P	★	★	☆	☆	.484	.898	.484
	E12	.602	.060	4	A316-12SL442-05015P	★	★	☆	☆	.484	.898	.484
	E12	.602	.090	4	A316-12SL442-05023P	★	★	☆	☆	.484	.898	.484
	E12	.602	.120	4	A316-12SL442-05031P	★	★	☆	☆	.484	.898	.484
.625	E16	.752	.015	4	A316-16SL442-06204P	★	★	☆	☆	.610	1.146	.610
	E16	.752	.030	4	A316-16SL442-06208P	★	★	☆	☆	.610	1.146	.610
	E16	.752	.060	4	A316-16SL442-06215P	★	★	☆	☆	.610	1.146	.610
	E16	.752	.090	4	A316-16SL442-06223P	★	★	☆	☆	.610	1.146	.610
	E16	.752	.120	4	A316-16SL442-06231P	★	★	☆	☆	.610	1.146	.610
.750	E20	.902	.015	4	A316-20SL442-07504P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.030	4	A316-20SL442-07508P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.060	4	A316-20SL442-07515P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.090	4	A316-20SL442-07523P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.120	4	A316-20SL442-07531P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.190	4	A316-20SL442-07548P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.250	4	A316-20SL442-07563P	★	★	☆	☆	.728	1.291	.728
1.000	E25	1.201	.060	4	A316-25SL442-10015P	★	★	☆	☆	.965	1.665	.965
	E25	1.201	.120	4	A316-25SL442-10031P	★	★	☆	☆	.965	1.665	.965
	E25	1.201	.190	4	A316-25SL442-10048P	★	★	☆	☆	.965	1.665	.965
	E25	1.201	.250	4	A316-25SL442-10063P	★	★	☆	☆	.965	1.665	.965

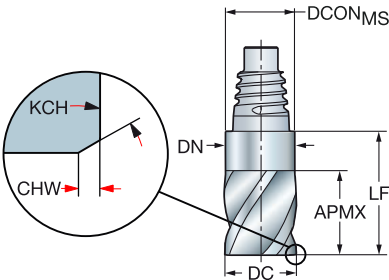
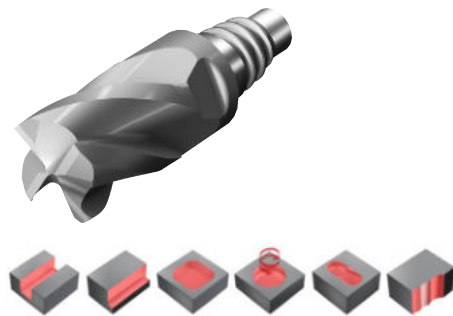


CoroMill® 316 Vollhartmetall-Fräskopf für die Heavy Duty Bearbeitung

Für rostfreien Stahl und Stahl mit Härte ≤ 48 HRc

FHA
BSG
TCDC

42°
COROMANT
h10



Metrische Ausführung

							P	M	K	S	Abmessungen, mm		
DC	CZC _{MS}	APMX	CHW	KCH	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	LF	DN
10.0	E10	12.0	0.15	45°	4	316-10SL442-10000P	★	★	☆	☆	9.7	18.5	9.7
12.0	E12	14.4	0.15	45°	4	316-12SL442-12000P	★	★	☆	☆	11.7	22.0	11.7
16.0	E16	19.2	0.25	45°	4	316-16SL442-16000P	★	★	☆	☆	15.5	29.1	15.5
20.0	E20	24.0	0.25	45°	4	316-20SL442-20000P	★	★	☆	☆	19.3	34.2	19.3
25.0	E25	30.0	0.25	45°	4	316-25SL442-25000P	★	★	☆	☆	24.2	41.9	24.2



GER

CoroMill® 316 Vollhartmetall-Fräskopf für Stabilität und Spanraum

B

Einsatzbereich

Bei Anforderungen an optimale Schruppleistung in zahlreichen unterschiedlichen Anwendungen und Werkstoffen

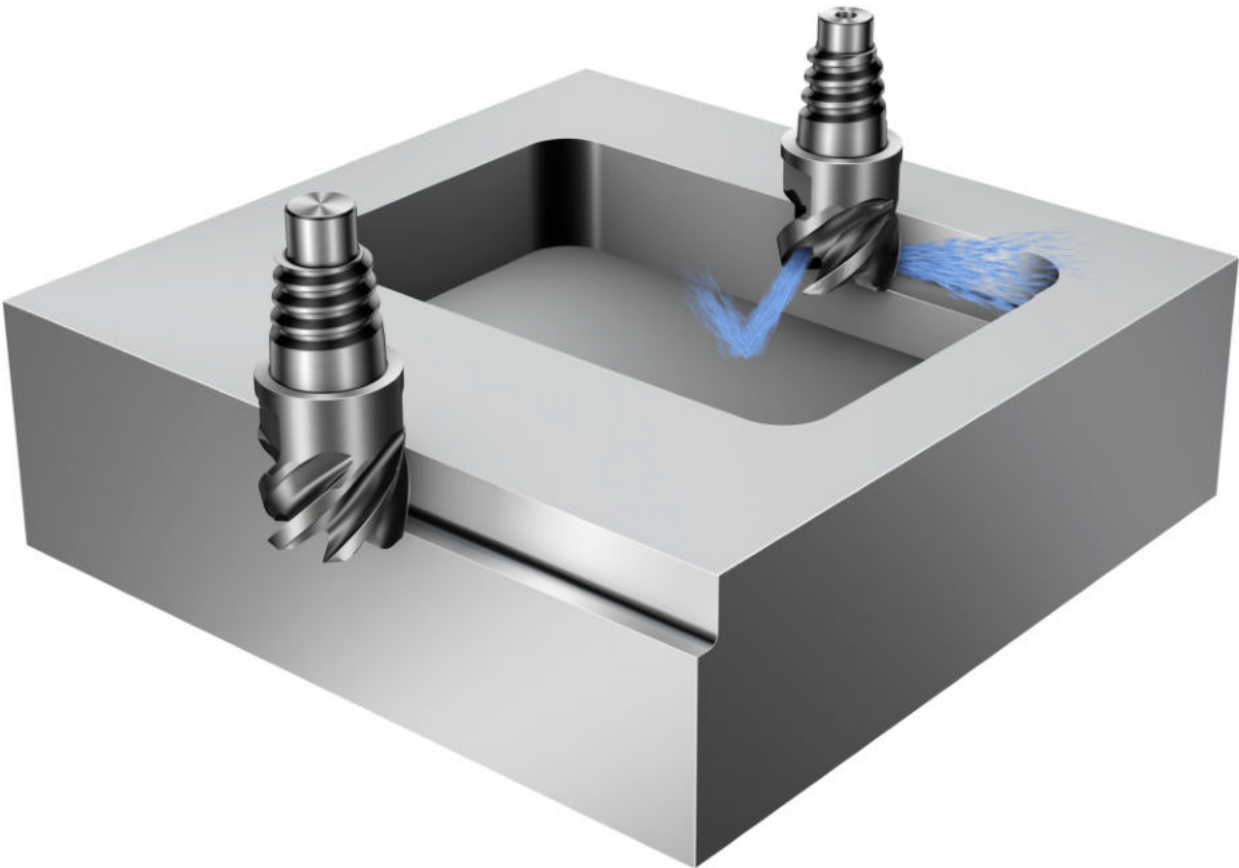
Erste Wahl für allgemeine Fräsbearbeitungen

ISO-Werkstoff	P K M S
Sorte	1730
Schaft	Coromant EH

C

Produktangebot

Differentialteilung reduziert Vibrationen

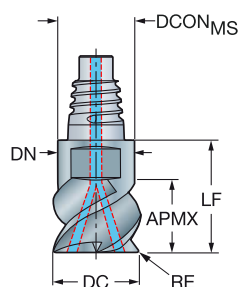


CoroMill® 316 Vollhartmetall-Fräskopf für Stabilität und Spanraum

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

FHA
BSG
TCDC

50°
COROMANT
h9



Metrische Ausführung

								P	M	K	S	Abmessungen, mm		
								1730	1730	1730				
DC	CZC _{MS}	APMX	RE	CNSC	CXSC	ZEFP	Bestellnummer					DCON _{MS}	LF	DN
10.0	E10	6.0	0.50	1	2	4	316-10SM450C10005P	★	★	★	☆	9.7	12.4	9.7
	E10	6.0	1.00	1	2	4	316-10SM450C10010P	★	★	★	☆	9.7	12.4	9.7
	E10	6.0	1.50	1	2	4	316-10SM450C10015P	★	★	★	☆	9.7	12.4	9.7
	E10	6.0	2.00	1	2	4	316-10SM450C10020P	★	★	★	☆	9.7	12.4	9.7
	E10	6.0	3.00	1	2	4	316-10SM450C10030P	★	★	★	☆	9.7	12.4	9.7
12.0	E12	7.5	0.50	1	2	4	316-12SM450C12005P	★	★	★	☆	11.7	14.5	11.7
	E12	7.5	1.00	1	2	4	316-12SM450C12010P	★	★	★	☆	11.7	14.5	11.7
	E12	7.5	2.00	1	2	4	316-12SM450C12020P	★	★	★	☆	11.7	14.5	11.7
	E12	7.5	3.00	1	2	4	316-12SM450C12030P	★	★	★	☆	11.7	14.5	11.7
	E12	7.5	4.00	1	2	4	316-12SM450C12040P	★	★	★	☆	11.7	14.5	11.7
16.0	E16	10.0	0.50	1	3	4	316-16SM450C16005P	★	★	★	☆	15.5	18.7	15.5
	E16	10.0	1.00	1	2	4	316-16SM450C16010P	★	★	★	☆	15.5	18.7	15.5
	E16	10.0	1.50	1	2	4	316-16SM450C16015P	★	★	★	☆	15.5	18.7	15.5
	E16	10.0	2.00	1	2	4	316-16SM450C16020P	★	★	★	☆	15.5	18.7	15.5
	E16	10.0	3.00	1	2	4	316-16SM450C16030P	★	★	★	☆	15.5	18.7	15.5
20.0	E16	10.0	4.00	1	2	4	316-16SM450C16040P	★	★	★	☆	15.5	18.7	15.5
	E20	12.0	0.50	1	3	4	316-20SM450C20005P	★	★	★	☆	19.3	21.3	19.3
	E20	12.0	1.00	1	2	4	316-20SM450C20010P	★	★	★	☆	19.3	21.3	19.3
	E20	12.0	1.50	1	2	4	316-20SM450C20015P	★	★	★	☆	19.3	21.3	19.3
	E20	12.0	2.00	1	2	4	316-20SM450C20020P	★	★	★	☆	19.3	21.3	19.3
25.0	E20	12.0	3.00	1	2	4	316-20SM450C20030P	★	★	★	☆	19.3	21.3	19.3
	E20	12.0	4.00	1	2	4	316-20SM450C20040P	★	★	★	☆	19.3	21.3	19.3
	E25	15.0	1.00	1	2	5	316-25SM550C25010P	★	★	★	☆	24.2	25.6	24.2
	E25	15.0	1.50	1	2	5	316-25SM550C25015P	★	★	★	☆	24.2	25.6	24.2
	E25	15.0	2.00	1	2	5	316-25SM550C25020P	★	★	★	☆	24.2	25.6	24.2

Zoll-Ausführung

								P	M	K	S	Abmessungen, Zoll			
DC	CZC _{MS}	APMX	RE	CNSC	CXSC	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	LF	DN	
.375	E10	.236	.015	1	3	4	A316-10SM450C03704P	★	★	★	★	.364	.488	.364	
	E10	.236	.031	1	3	4	A316-10SM450C03708P	★	★	★	★	.364	.488	.364	
.500	E12	.315	.015	1	3	4	A316-12SM450C05004P	★	★	★	★	.484	.571	.484	
	E12	.315	.031	1	3	4	A316-12SM450C05008P	★	★	★	★	.484	.571	.484	
	E12	.315	.062	1	3	4	A316-12SM450C05015P	★	★	★	★	.484	.571	.484	
.625	E16	.394	.031	1	3	4	A316-16SM450C06208P	★	★	★	★	.610	.736	.610	
	E16	.394	.062	1	3	4	A316-16SM450C06215P	★	★	★	★	.610	.736	.610	
.750	E20	.453	.031	1	3	4	A316-20SM450C07508P	★	★	★	★	.728	.839	.728	
	E20	.453	.062	1	3	4	A316-20SM450C07515P	★	★	★	★	.728	.839	.728	
	E20	.453	.125	1	3	4	A316-20SM450C07532P	★	★	★	★	.728	.839	.728	
	E20	.453	.250	1	3	4	A316-20SM450C07563P	★	★	★	★	.728	.839	.728	
1.000	E25	.610	.125	1	3	5	A316-25SM550C10032P	★	★	★	★	.965	1.008	.965	
	E25	.610	.188	1	3	5	A316-25SM550C10047P	★	★	★	★	.965	1.008	.965	
	E25	.610	.250	1	3	5	A316-25SM550C10063P	★	★	★	★	.965	1.008	.965	



A184



A194



E9



E25



E28

A

FRÄSEN

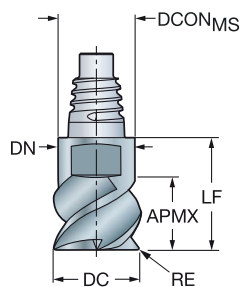
Optimiert

CoroMill® 316 Vollhartmetall-Fräskopf für Stabilität und Spanraum

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC

50°
COROMANT
h9



B



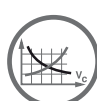
Metrische Ausführung

						P	M	K	S	Abmessungen, mm		
						1730	1730	1730	1730			
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer					DCON _{MS}	LF	DN
10.0	E10	5.5	0.50	3	316-10SM350-10005P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	0.50	4	316-10SM450-10005P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	1.00	3	316-10SM350-10010P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	1.00	4	316-10SM450-10010P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	1.50	4	316-10SM450-10015P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	2.00	4	316-10SM450-10020P	★	★	☆	☆	9.7	12.4	9.7
12.0	E10	5.5	3.00	4	316-10SM450-10030P	★	★	☆	☆	9.7	12.4	9.7
	E12	6.5	0.50	4	316-12SM450-12005P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	0.50	3	316-12SM350-12005P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	1.00	3	316-12SM350-12010P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	1.00	4	316-12SM450-12010P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	1.50	4	316-12SM450-12015P	★	★	☆	☆	11.7	14.5	11.7
16.0	E12	6.5	2.00	4	316-12SM450-12020P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	3.00	4	316-12SM450-12030P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	4.00	4	316-12SM450-12040P	★	★	☆	☆	11.7	14.5	11.7
	E16	8.5	0.50	4	316-16SM450-16005P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	0.50	3	316-16SM350-16005P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	1.00	4	316-16SM450-16010P	★	★	☆	☆	15.5	18.7	15.5
20.0	E16	8.5	1.00	3	316-16SM350-16010P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	1.50	4	316-16SM450-16015P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	2.00	4	316-16SM450-16020P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	3.00	4	316-16SM450-16030P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	4.00	4	316-16SM450-16040P	★	★	☆	☆	15.5	18.7	15.5
	E20	11.0	0.50	4	316-20SM450-20005P	★	★	☆	☆	19.3	21.3	19.3
25.0	E20	11.0	0.50	3	316-20SM350-20005P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	1.00	4	316-20SM450-20010P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	1.00	3	316-20SM350-20010P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	1.50	4	316-20SM450-20015P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	2.00	4	316-20SM450-20020P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	3.00	4	316-20SM450-20030P	★	★	☆	☆	19.3	21.3	19.3
25.0	E20	11.0	4.00	4	316-20SM450-20040P	★	★	☆	☆	19.3	21.3	19.3
	E25	13.5	1.00	5	316-25SM550-25010P	★	★	☆	☆	24.2	25.6	24.2
	E25	13.5	1.50	5	316-25SM550-25015P	★	★	☆	☆	24.2	25.6	24.2
25.0	E25	13.5	2.00	5	316-25SM550-25020P	★	★	☆	☆	24.2	25.6	24.2
	E25	13.5	2.00	5	316-25SM550-25020P	★	★	☆	☆	24.2	25.6	24.2

C

D

E



A184



A194



E9



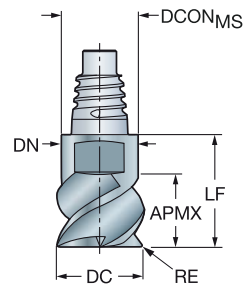
E25

CoroMill® 316 Vollhartmetall-Fräskopf für Stabilität und Spanraum

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

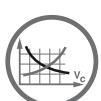
FHA
BSG
TCDC

50°
COROMANT
h9



Zoll-Ausführung

						P	M	K	S	Abmessungen, Zoll		
						1730	1730	1730	1730	DCON _{MS}	LF	DN
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer							
.375	E10	.209	.015	4	A316-10SM450-03704P	★	★	☆	☆	.364	.488	.364
	E10	.209	.015	3	A316-10SM350-03704P	★	★	☆	☆	.364	.488	.364
	E10	.209	.031	4	A316-10SM450-03708P	★	★	☆	☆	.364	.488	.364
	E10	.209	.031	3	A316-10SM350-03708P	★	★	☆	☆	.364	.488	.364
	E10	.209	.062	4	A316-10SM450-03715P	★	★	☆	☆	.364	.488	.364
	E10	.209	.062	3	A316-10SM350-03715P	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.015	4	A316-12SM450-05004P	★	★	☆	☆	.484	.575	.484
	E12	.276	.015	3	A316-12SM350-05004P	★	★	☆	☆	.484	.575	.484
	E12	.276	.031	4	A316-12SM450-05008P	★	★	☆	☆	.484	.575	.484
	E12	.276	.031	3	A316-12SM350-05008P	★	★	☆	☆	.484	.575	.484
	E12	.276	.062	3	A316-12SM350-05015P	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.015	3	A316-16SM350-06204P	★	★	☆	☆	.610	.736	.610
	E16	.335	.031	4	A316-16SM450-06208P	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.031	4	A316-20SM450-07508P	★	★	☆	☆	.728	.839	.728
	E20	.413	.031	3	A316-20SM350-07508P	★	★	☆	☆	.728	.839	.728
	E20	.413	.125	4	A316-20SM450-07532P	★	★	☆	☆	.728	.839	.728
	E20	.413	.250	4	A316-20SM450-07563P	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.062	5	A316-25SM550-10015P	★	★	☆	☆	.965	1.008	.965
	E25	.551	.125	5	A316-25SM550-10032P	★	★	☆	☆	.965	1.008	.965
	E25	.551	.188	5	A316-25SM550-10047P	★	★	☆	☆	.965	1.008	.965
	E25	.551	.250	5	A316-25SM550-10063P	★	★	☆	☆	.965	1.008	.965



A184



A194



E9



E25

GER

CoroMill® 316 Vollhartmetall-Fräskopf für die High Feed Sidemilling

B

Einsatzbereich

Erste Wahl zum High Feed Sidemilling von Titanbasislegierungen

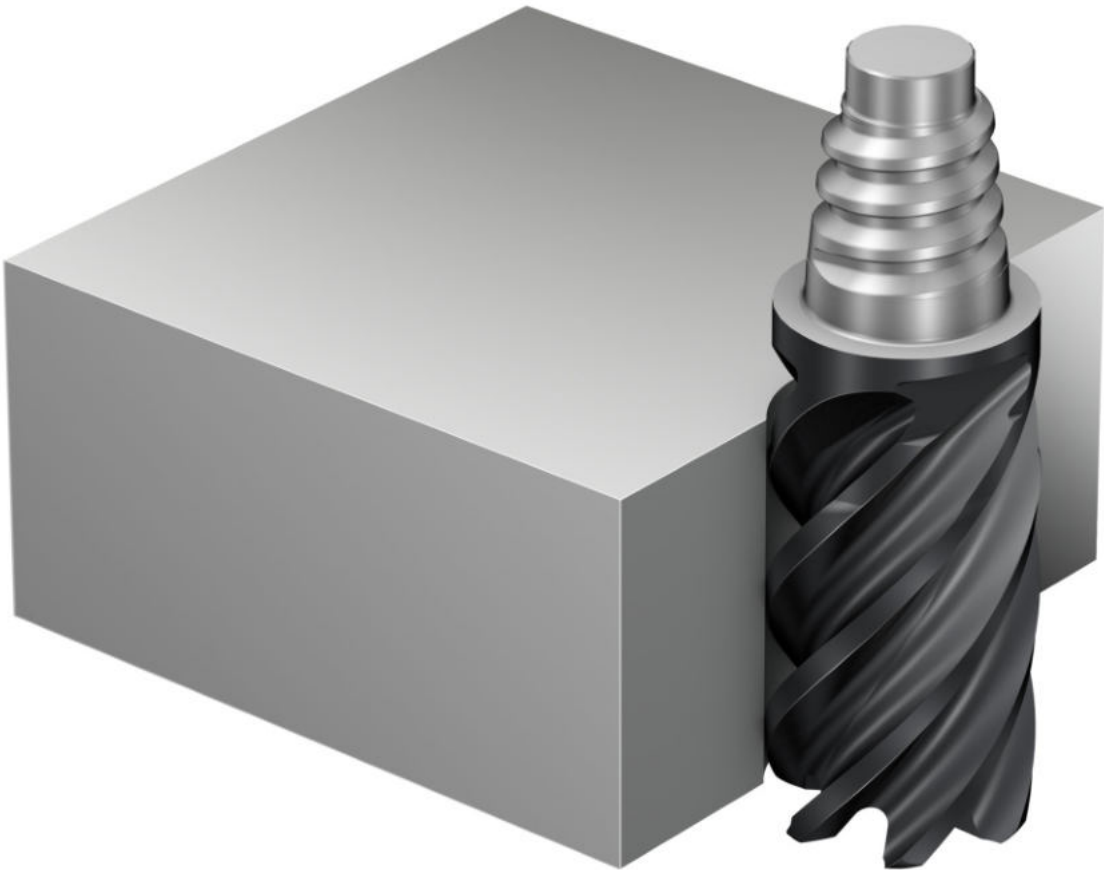
Hervorragende Leistungen bei mittleren Bedingungen (ae bis 10% Dc), wenn eine gute Oberflächengüte erforderlich ist

ISO-Werkstoff	S
Sorte	1745
Schaft	Coromant EH

C

Produktangebot

Einsatzbezogene Sorte für Titanbasislegierungen

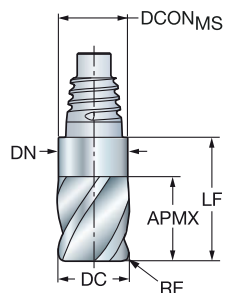


CoroMill® 316 Vollhartmetall-Fräskopf für die High Feed Sidemilling Bearbeitung

Für Titanbasislegierungen

FHA
BSG
TCDC

42°
COROMANT
h10



Metrische Ausführung

						S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer	1745	DCON _{MS}	LF	DN
10.0	E10	15.0	0.50	6	316-10FL642-10005L	★	9.7	23.3	9.7
	E10	15.0	1.00	6	316-10FL642-10010L	★	9.7	23.3	9.7
	E10	15.0	2.00	6	316-10FL642-10020L	★	9.7	23.3	9.7
12.0	E12	18.0	0.50	6	316-12FL642-12005L	★	11.7	27.4	11.7
	E12	18.0	1.00	6	316-12FL642-12010L	★	11.7	27.4	11.7
	E12	18.0	2.00	6	316-12FL642-12020L	★	11.7	27.4	11.7
	E12	18.0	3.00	6	316-12FL642-12030L	★	11.7	27.4	11.7
16.0	E16	24.0	0.50	6	316-16FL642-16005L	★	15.5	35.6	15.5
	E16	24.0	1.00	6	316-16FL642-16010L	★	15.5	35.6	15.5
	E16	24.0	2.00	6	316-16FL642-16020L	★	15.5	35.6	15.5
	E16	24.0	3.00	6	316-16FL642-16030L	★	15.5	35.6	15.5
	E16	24.0	4.00	6	316-16FL642-16040L	★	15.5	35.6	15.5
20.0	E20	30.0	1.00	6	316-20FL642-20010L	★	19.3	41.7	19.3
	E20	30.0	2.00	6	316-20FL642-20020L	★	19.3	41.7	19.3
	E20	30.0	3.00	6	316-20FL642-20030L	★	19.3	41.7	19.3
	E20	30.0	4.00	6	316-20FL642-20040L	★	19.3	41.7	19.3
25.0	E25	37.5	1.00	6	316-25FL642-25010L	★	24.2	51.0	24.2
	E25	37.5	2.00	6	316-25FL642-25020L	★	24.2	51.0	24.2
	E25	37.5	3.00	6	316-25FL642-25030L	★	24.2	51.0	24.2

Zoll-Ausführung

						S	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer	1745	DCON _{MS}	LF	DN
.375	E10	.563	.030	6	A316-10FL642-03708L	★	.364	.890	.362
	E10	.563	.060	6	A316-10FL642-03715L	★	.364	.890	.362
.500	E12	.750	.030	6	A316-12FL642-05008L	★	.484	1.122	.500
	E12	.750	.060	6	A316-12FL642-05015L	★	.484	1.122	.500
	E12	.750	.090	6	A316-12FL642-05023L	★	.484	1.122	.500
	E12	.750	.120	6	A316-12FL642-05031L	★	.484	1.122	.500
.625	E16	.937	.030	6	A316-16FL642-06208L	★	.610	1.402	.610
	E16	.937	.060	6	A316-16FL642-06215L	★	.610	1.402	.610
	E16	.937	.090	6	A316-16FL642-06223L	★	.610	1.402	.610
	E16	.937	.120	6	A316-16FL642-06231L	★	.610	1.402	.610
.750	E20	1.125	.030	6	A316-20FL642-07508L	★	.728	1.587	.728
	E20	1.125	.060	6	A316-20FL642-07515L	★	.728	1.587	.728
	E20	1.125	.090	6	A316-20FL642-07523L	★	.728	1.587	.728
	E20	1.125	.120	6	A316-20FL642-07531L	★	.728	1.587	.728
1.000	E25	1.500	.030	6	A316-25FL642-10008L	★	.965	2.032	.965
	E25	1.500	.060	6	A316-25FL642-10015L	★	.965	2.032	.965
	E25	1.500	.090	6	A316-25FL642-10023L	★	.965	2.032	.965
	E25	1.500	.120	6	A316-25FL642-10031L	★	.965	2.032	.965



A181



E9

GER

CoroMill® 316 Vollhartmetall-Fräskopf für die High Feed Facemilling
Bearbeitung

B

Einsatzbereich

Planfräsen mit hohen Vorschüben
Schruppen von 3D-Formen mit hohen Vorschüben

ISO-Werkstoff	P M K S
Sorte	1730
Schaft	Coromant EH

C

Produktangebot

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

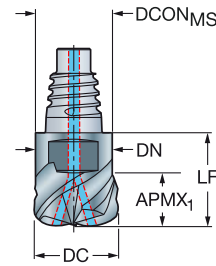
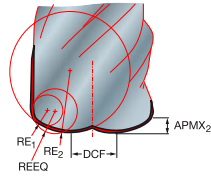


CoroMill® 316 Vollhartmetall-Fräskopf für die High Feed Facemilling Bearbeitung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

BSG
TCDC

COROMANT
h9

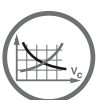


Metrische Ausführung

											P	M	K	S	Abmessungen, mm					
DC	CZC _{MS}	APMX ₁	APMX ₂	RE ₁	RE ₂	CNSC	CXSC	ZEFP	FHA	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DCF	LF	DN	REEQ	
10.0	E10	6.0	0.7	1.5	5.0	1	2	4	50°	316-10HM450C10015P	★	★	☆	☆	9.7	3.4	12.4	9.7	1.99	
12.0	E12	7.5	0.8	1.5	6.0	1	2	4	50°	316-12HM450C12015P	★	★	☆	☆	11.7	4.5	14.5	11.7	2.10	
16.0	E16	10.0	1.0	2.0	8.0	1	2	4	50°	316-16HM450C16020P	★	★	☆	☆	15.5	6.2	18.7	15.5	2.75	
20.0	E20	12.0	1.3	2.0	10.0	1	2	4	50°	316-20HM450C20020P	★	★	☆	☆	19.3	8.0	21.3	19.3	3.07	
25.0	E25	13.0	1.6	3.0	12.0	1	3	5	50°	316-25HM550C25030P	★	★	☆	☆	24.2	10.0	25.6	24.2	4.21	

Zoll-Ausführung

										Abmessungen, Zoll									
										P	M	K	S						
DC	CZC _{MS}	APMX ₁	APMX ₂	RE ₁	RE ₂	CNSC	CXSC	ZEFP	FHA	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DCF	LF	DN	REEQ
.375	E10	.236	.024	.060	.181	1	3	4	50°	A316-10HM450C03715P	★	★	☆	☆	.364	.134	.488	.364	.076
.500	E12	.315	.033	.060	.236	1	3	4	50°	A316-12HM450C05015P	★	★	☆	☆	.484	.197	.571	.484	.086
.625	E16	.394	.039	.080	.315	1	3	4	50°	A316-16HM450C06220P	★	★	☆	☆	.610	.236	.736	.610	.110
.750	E20	.453	.047	.080	.354	1	3	4	50°	A316-20HM450C07520P	★	★	☆	☆	.728	.315	.839	.728	.117



A183



A194



E9

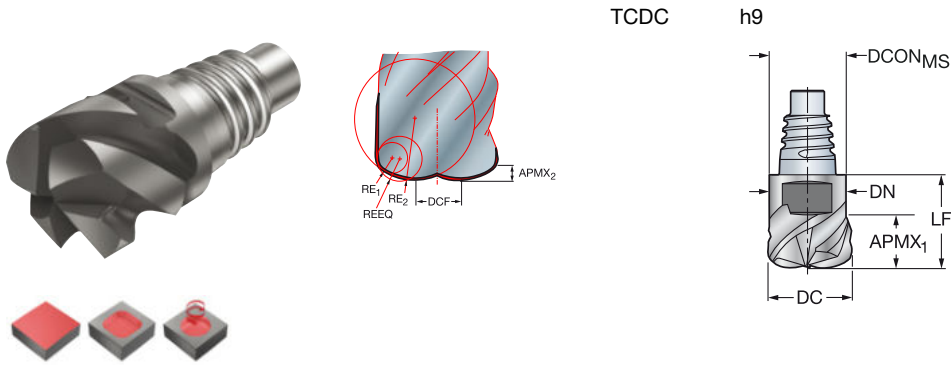


E25



E28

CoroMill® 316 Vollhartmetall-Fräskopf für die High Feed Facemilling Bearbeitung
Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc



B Metrische Ausführung

									P	M	K	S	Abmessungen, mm				
DC	CZC _{MS}	APMX ₁	APMX ₂	RE ₁	RE ₂	ZEFP	FHA	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DCF	LF	DN	REEQ
10.0	E10	5.5	0.7	1.5	5.0	3	50°	316-10HM350-10015P	★	★	☆	☆	9.7	3.4	12.4	9.7	1.99
	E10	5.5	0.7	1.5	5.0	4	50°	316-10HM450-10015P	★	★	☆	☆	9.7	3.4	12.4	9.7	1.99
12.0	E12	6.5	0.8	1.5	6.0	3	50°	316-12HM350-12015P	★	★	☆	☆	11.7	4.5	14.5	11.7	2.10
	E12	6.5	0.8	1.5	6.0	4	50°	316-12HM450-12015P	★	★	☆	☆	11.7	4.5	14.5	11.7	2.10
16.0	E16	8.5	1.0	2.0	8.0	3	50°	316-16HM350-16020P	★	★	☆	☆	15.5	6.2	18.7	15.5	2.75
	E16	8.5	1.0	2.0	8.0	4	50°	316-16HM450-16020P	★	★	☆	☆	15.5	6.2	18.7	15.5	2.75
20.0	E20	11.0	1.3	2.0	10.0	4	50°	316-20HM450-20020P	★	★	☆	☆	19.3	8.0	21.3	19.3	3.07
25.0	E25	13.5	1.6	3.0	12.0	4	50°	316-25HM450-25030P	★	★	☆	☆	24.2	10.0	25.6	24.2	4.21

C Zoll-Ausführung

									P	M	K	S	Abmessungen, Zoll				
DC	CZC _{MS}	APMX ₁	APMX ₂	RE ₁	RE ₂	ZEFP	FHA	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DCF	LF	DN	REEQ
.375	E10	.209	.024	.060	.181	4	50°	A316-10HM450-03715P	★	★	☆	☆	.364	.134	.488	.364	.076
.500	E12	.276	.033	.060	.236	4	50°	A316-12HM450-05015P	★	★	☆	☆	.484	.197	.575	.484	.086
.625	E16	.335	.039	.080	.315	4	50°	A316-16HM450-06220P	★	★	☆	☆	.610	.236	.736	.610	.110
.750	E20	.413	.047	.080	.354	4	50°	A316-20HM450-07520P	★	★	☆	☆	.728	.315	.839	.728	.117

A183

A194

E9

E25

E28

CoroMill® 316 Vollhartmetall-Fräskopf für die Hartbearbeitung

Einsatzbereich

Wenn großer Spanraum erforderlich ist (z.B. Vollnutfräsen)
Gute Ramp- und Eintauchfähigkeit

ISO-Werkstoff

P

M

K

S

Sorte

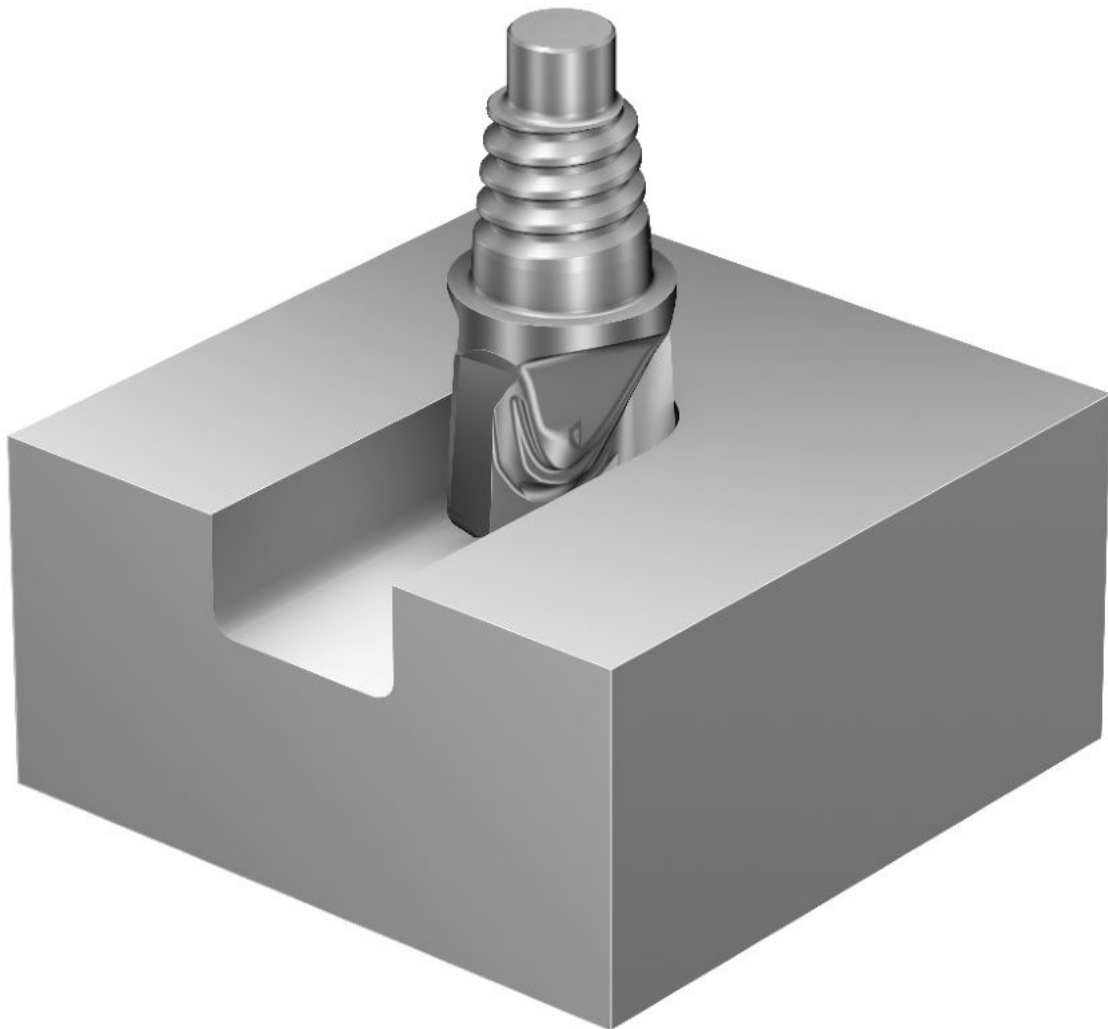
1730

Schaft

Coromant EH

Produktangebot

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

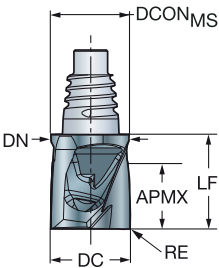


CoroMill® 316 Vollhartmetall-Fräskopf für die Hartbearbeitung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

FHA
BSG
TCDC

10°
COROMANT
h10



Metrische Ausführung

						P	M	K	S	Abmessungen, mm		
						1730	1730	1730	1730			
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer					DCON _{MS}	LF	DN
10.0	E10	8.0	0.50	2	316-10SM210-10005P	★	★	☆	☆	9.7	11.8	9.7
	E10	8.0	0.80	2	316-10SM210-10008P	★	★	☆	☆	9.7	11.8	9.7
	E10	8.0	1.00	2	316-10SM210-10010P	★	★	☆	☆	9.7	11.8	9.7
12.0	E12	10.0	0.50	2	316-12SM210-12005P	★	★	☆	☆	11.7	14.0	11.7
	E12	10.0	0.80	2	316-12SM210-12008P	★	★	☆	☆	11.7	14.0	11.7
16.0	E16	13.0	0.50	2	316-16SM210-16005P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	0.80	2	316-16SM210-16008P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	1.00	2	316-16SM210-16010P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	3.00	2	316-16SM210-16030P	★	★	☆	☆	15.5	18.1	15.5



CoroMill® 316 Vollhartmetall-Fräskopf für die Hartbearbeitung

Einsatzbereich

Erste Wahl zur Bearbeitung von Aluminium und Thermoplastik

ISO-Werkstoff

N

Sorte

H10F

Schaft

Coromant EH

Produktangebot

Für NE-Metalle



CoroMill® 316 Vollhartmetall-Fräskopf für die Hartbearbeitung
Für NE-Metalle

FHA
BSG
TCDC

45°
COROMANT
h9

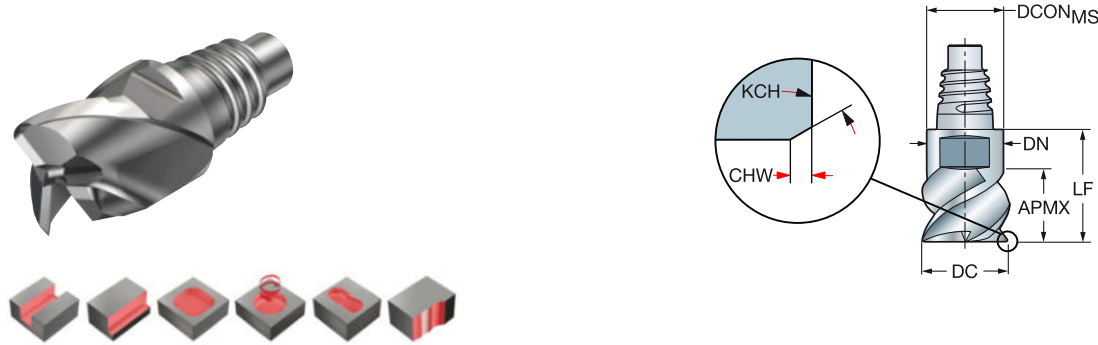


Metrische Ausführung

						N	Abmessungen, mm		
						H9/f8	DCON _{MS}	LF	DN
10.0	E10	5.5	1.00	3	316-10SM345-10010A	★	9.7	12.4	9.7
	E10	5.5	2.50	3	316-10SM345-10025A	★	9.7	12.4	9.7
12.0	E12	6.5	1.00	3	316-12SM345-12010A	★	11.7	14.5	11.7
	E12	6.5	2.50	3	316-12SM345-12025A	★	11.7	14.5	11.7
	E12	6.5	4.00	3	316-12SM345-12040A	★	11.7	14.5	11.7
16.0	E16	8.5	1.50	3	316-16SM345-16015A	★	15.5	18.7	15.5
	E16	8.5	2.50	3	316-16SM345-16025A	★	15.5	18.7	15.5
	E16	8.5	4.00	3	316-16SM345-16040A	★	15.5	18.7	15.5
20.0	E20	11.0	2.50	3	316-20SM345-20025A	★	19.3	21.3	19.3
	E20	11.0	4.00	3	316-20SM345-20040A	★	19.3	21.3	19.3
25.0	E25	13.5	4.00	3	316-25SM345-25040A	★	24.2	25.6	24.2

FHA
BSG
TCDC

45°
COROMANT
h9



Metrische Ausführung

						N	Abmessungen, mm			
						H9/f8				
DC	CZC _{MS}	APMX	CHW	KCH	ZEFP	Bestellnummer	DCON _{MS}	LF	DN	
10.0	E10	5.5	0.10	45°	3	316-10SM345-10000A	★	9.7	12.4	9.7
12.0	E12	6.5	0.10	45°	3	316-12SM345-12000A	★	11.7	14.5	11.7
16.0	E16	8.5	0.15	45°	3	316-16SM345-16000A	★	15.5	18.7	15.5
20.0	E20	11.0	0.15	45°	3	316-20SM345-20000A	★	19.3	21.3	19.3
25.0	E25	13.5	0.15	45°	3	316-25SM345-25000A	★	24.2	25.6	24.2



CoroMill® 316 Vollhartmetall-Fräskopf mit Kordelverzahnung

Einsatzbereich

Wenn kleinere Späne erforderlich sind
Problemlöser bei instabilen Bearbeitungsbedingungen

ISO-Werkstoff

P

M

K

S

Sorte

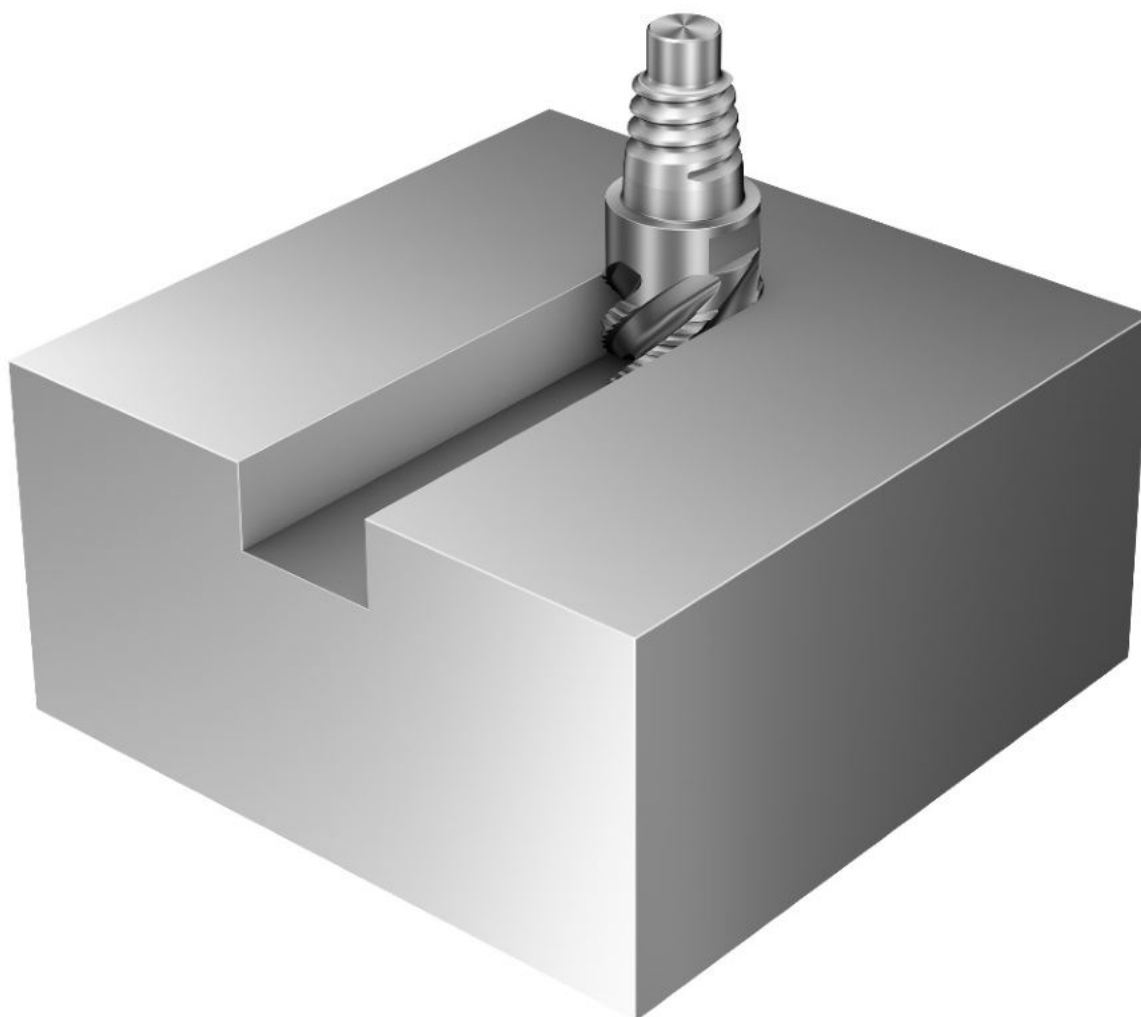
1730

Schaft

Coromant EH

Produktangebot

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc



A

CoroMill® 316 Vollhartmetall-Fräskopf mit Kordelverzahnung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC

45°
COROMANT
h12



B

Metrische Ausführung

						P	M	K	S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	LF	DN
10.0	E10	5.5	0.40	4	316-10SM440-10004K	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	0.40	5	316-10SM545-10004K	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	0.40	5	316-12SM545-12004K	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	0.40	4	316-12SM440-12004K	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	0.40	6	316-16SM645-16004K	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	0.40	4	316-16SM440-16004K	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	0.40	6	316-20SM645-20004K	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	0.40	8	316-25SM845-25004K	★	★	☆	☆	24.2	25.6	24.2

C

Zoll-Ausführung

						P	M	K	S	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	LF	DN
.375	E10	.209	.016	4	A316-10SM440-03704K	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.016	4	A316-12SM440-05004K	★	★	☆	☆	.484	.575	.484
	E12	.276	.062	4	A316-12SM440-05015K	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.062	4	A316-16SM440-06215K	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.015	4	A316-20SM440-07504K	★	★	☆	☆	.728	.839	.728
	E20	.413	.016	6	A316-20SM645-07504K	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.016	8	A316-25SM845-10004K	★	★	☆	☆	.965	1.008	.965

D

E



CoroMill® 316 Vollhartmetall-Fräskopf für die Profilfräsbearbeitung

Einsatzbereich

Profilfräsen mit demselben Werkzeug in unterschiedlichen Werkstoffen

ISO-Werkstoff

P

M

K

N

S

Sorte

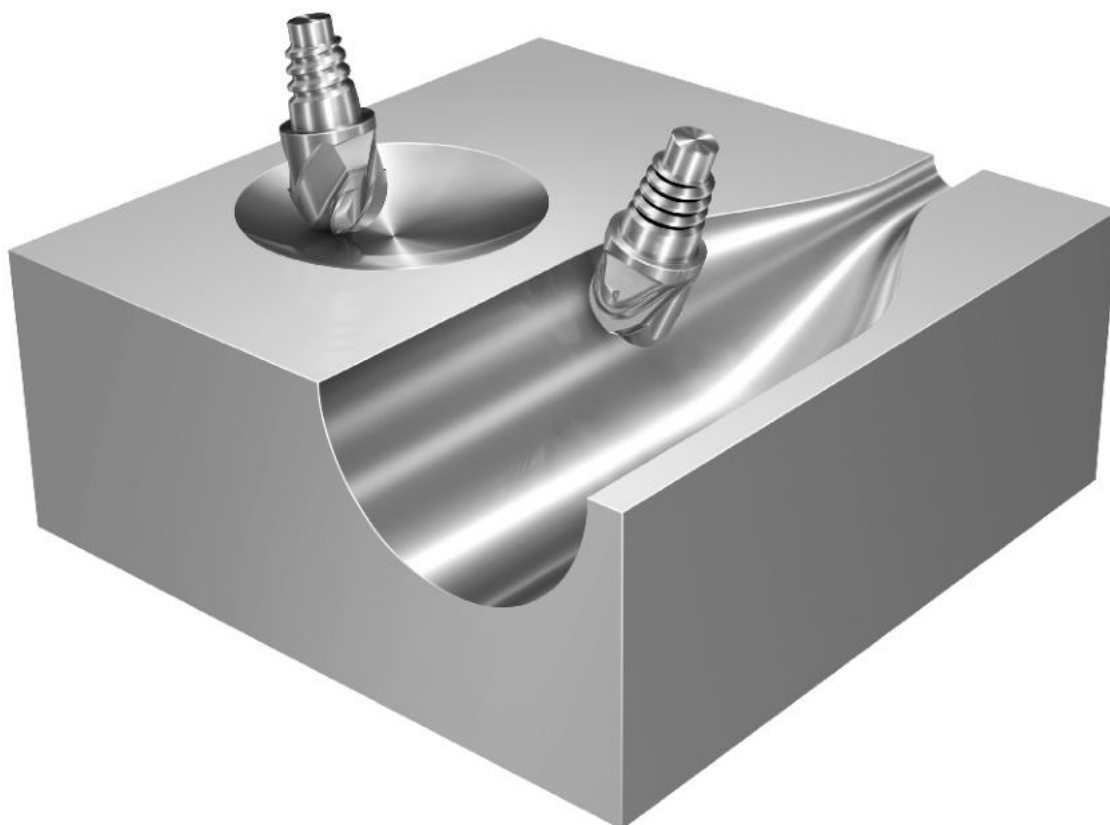
1730

Schaft

Coromant EH

Produktangebot

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

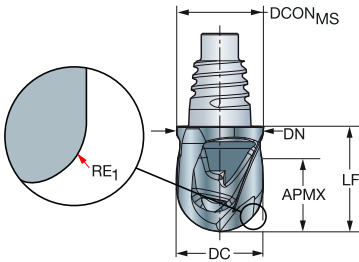


CoroMill® 316 Vollhartmetall-Fräskopf für die Profilfräsbearbeitung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

BSG
TCDC
PSIR

COROMANT
h9
0°



Metrische Ausführung

						P	M	K	S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE ₁	ZEFP	FHA	Bestellnummer				DCON _{MS}	LF	DN
10.0	E10	8.0	5.00	2	10°	316-10BM210-10050G	★	★	☆	9.7	11.8	9.7
12.0	E12	10.0	6.00	2	10°	316-12BM210-12060G	★	★	☆	11.7	14.0	11.7
16.0	E16	13.0	8.00	2	10°	316-16BM210-16080G	★	★	☆	15.5	18.1	15.5

Zoll-Ausführung

						P	M	K	S	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	RE ₁	ZEFP	FHA	Bestellnummer				DCON _{MS}	LF	DN
.375	E10	.315	.188	2	10°	A316-10BM210-03750G	★	★	☆	.364	.465	.382
.500	E12	.413	.250	2	10°	A316-12BM210-05060G	★	★	☆	.484	.551	.461
.625	E16	.512	.313	2	10°	A316-16BM210-06280G	★	★	☆	.610	.713	.610

A192

A194

E9

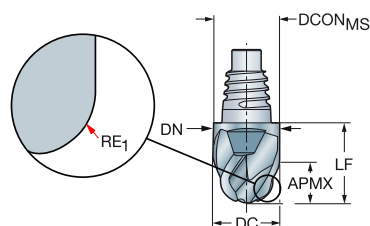
E25

CoroMill® 316 Vollhartmetall-Fräskopf für die Profilfräsbearbeitung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

BSG
TCDC
PSIR

COROMANT
h9
0°



Metrische Ausführung

						P	M	K	S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE ₁	ZEFP	FHA	Bestellnummer				DCON _{MS}	LF	DN
10.0	E10	5.5	5.00	4	40°	316-10BM440-10050G	★	★	☆	9.7	12.4	9.7
12.0	E12	6.5	6.00	4	40°	316-12BM440-12060G	★	★	☆	11.7	14.5	11.7
16.0	E16	8.5	8.00	4	40°	316-16BM440-16080G	★	★	☆	15.5	18.7	15.5
20.0	E20	11.0	10.00	2	40°	316-20BM240-200AG	★	★	☆	19.3	21.3	19.3
	E20	11.0	10.00	4	40°	316-20BM440-200AG	★	★	☆	19.3	21.3	19.3
25.0	E25	13.5	12.50	4	40°	316-25BM440-250DG	★	★	☆	24.2	25.6	24.2

Zoll-Ausführung

						P	M	K	S	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	RE ₁	ZEFP	FHA	Bestellnummer				DCON _{MS}	LF	DN
.375	E10	.209	.188	4	40°	A316-10BM440-03750G	★	★	☆	.364	.488	.364
.500	E12	.276	.250	4	40°	A316-12BM440-05060G	★	★	☆	.484	.575	.484
.625	E16	.335	.313	4	40°	A316-16BM440-06280G	★	★	☆	.610	.736	.610
.750	E20	.413	.375	4	40°	A316-20BM440-075AG	★	★	☆	.728	.839	.728
1.000	E25	.551	.500	4	40°	A316-25BM440-100CG	★	★	☆	.965	1.008	.965



A192



A194



E9



E25

GER

CoroMill® 316 Vollhartmetall-Fräskopf für die Schlichtbearbeitung

B

Einsatzbereich

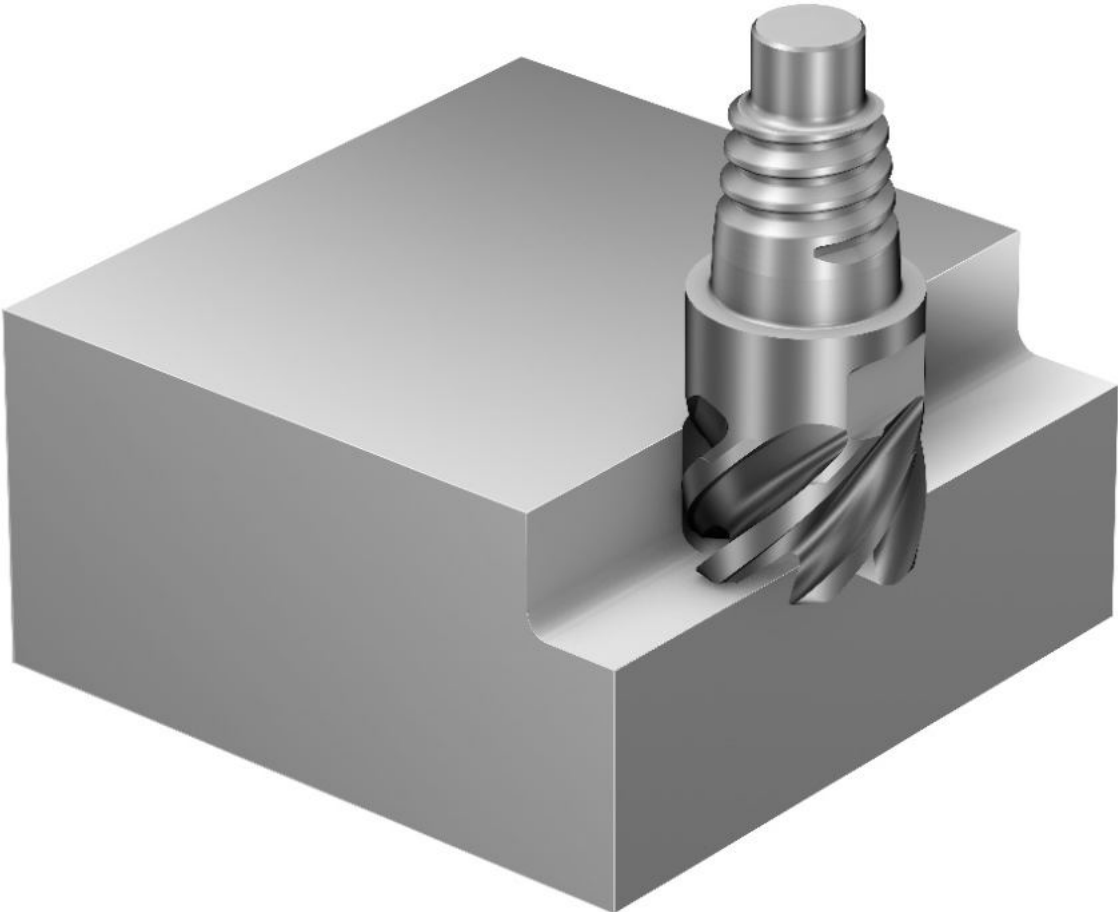
Erste Wahl für die Schlichtbearbeitung beim Eckfräsen
Kann bei Schrappoperationen mit geringem radialen Eingriff eingesetzt werden, wenn hohe Vorschübe erforderlich sind (Trochoid-Strategie)

ISO-Werkstoff	P M K S
Sorte	1730
Schaft	Coromant EH

C

Produktangebot

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

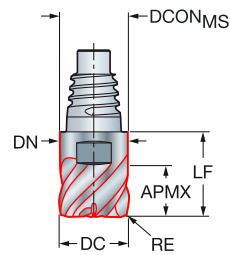


CoroMill® 316 Vollhartmetall-Fräskopf für die Schlichtbearbeitung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC

50°
COROMANT
h9

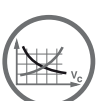


Metrische Ausführung

						P	M	K	S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	LF	DN
10.0	E10	5.5	1.00	6	316-10FM650-10010L	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	1.00	6	316-12FM650-12010L	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	1.50	6	316-16FM650-16015L	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	1.50	8	316-20FM850-20015L	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	1.00	8	316-25FM850-25010L	★	★	☆	☆	24.2	25.6	24.2

Zoll-Ausführung

						P	M	K	S	Abmessungen, Zoll		
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	LF	DN
.375	E10	.209	.015	6	A316-10FM650-03704L	★	★	☆	☆	.364	.488	.364
	E10	.209	.031	6	A316-10FM650-03708L	★	★	☆	☆	.364	.488	.364
	E10	.209	.062	6	A316-10FM650-03715L	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.015	6	A316-12FM650-05004L	★	★	☆	☆	.484	.575	.484
	E12	.276	.062	6	A316-12FM650-05015L	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.031	6	A316-16FM650-06208L	★	★	☆	☆	.610	.736	.610
	E16	.335	.031	8	A316-16FM850-06208L	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.031	8	A316-20FM850-07508L	★	★	☆	☆	.728	.839	.728
	E20	.413	.031	10	A316-20FMA50-07508L	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.062	10	A316-25FMA50-10015L	★	★	☆	☆	.965	1.008	.965
	E25	.551	.062	12	A316-25FMC50-10015L	★	★	☆	☆	.965	1.008	.965



A189



A194



E9



E25

CoroMill® 316 Vollhartmetall-Fräskopf für die Schlichtbearbeitung

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

FHA
BSG
TCDC

50°
COROMANT
h10



Metrische Ausführung

						P	M	K	S	Abmessungen, mm		
						1730	1730	1730	1730			
DC	CZC _{MS}	APMX	CHW	KCH	ZEFP	Bestellnummer	★	★	☆	DCON _{MS}	LF	DN
10.0	E10	5.5	0.10	45°	6	316-10FM650-10000L	★	★	☆	9.7	12.4	9.7
12.0	E12	6.5	0.10	45°	6	316-12FM650-12000L	★	★	☆	11.7	14.5	11.7
16.0	E16	8.5	0.15	45°	6	316-16FM650-16000L	★	★	☆	15.5	18.7	15.5
20.0	E20	11.0	0.15	45°	8	316-20FM850-20000L	★	★	☆	19.3	21.3	19.3



CoroMill® 316 Vollhartmetall-Fräskopf für das Fasfräsen

Einsatzbereich

Fasfräsen mit ein und demselben Werkzeug in unterschiedlichen Werkstoffen

Bei Erstellung konvexer Radien

Fräskopf mit zwei Spankanälen, geeignet zum Anbohren

ISO-Werkstoff

P

M

K

S

Sorte

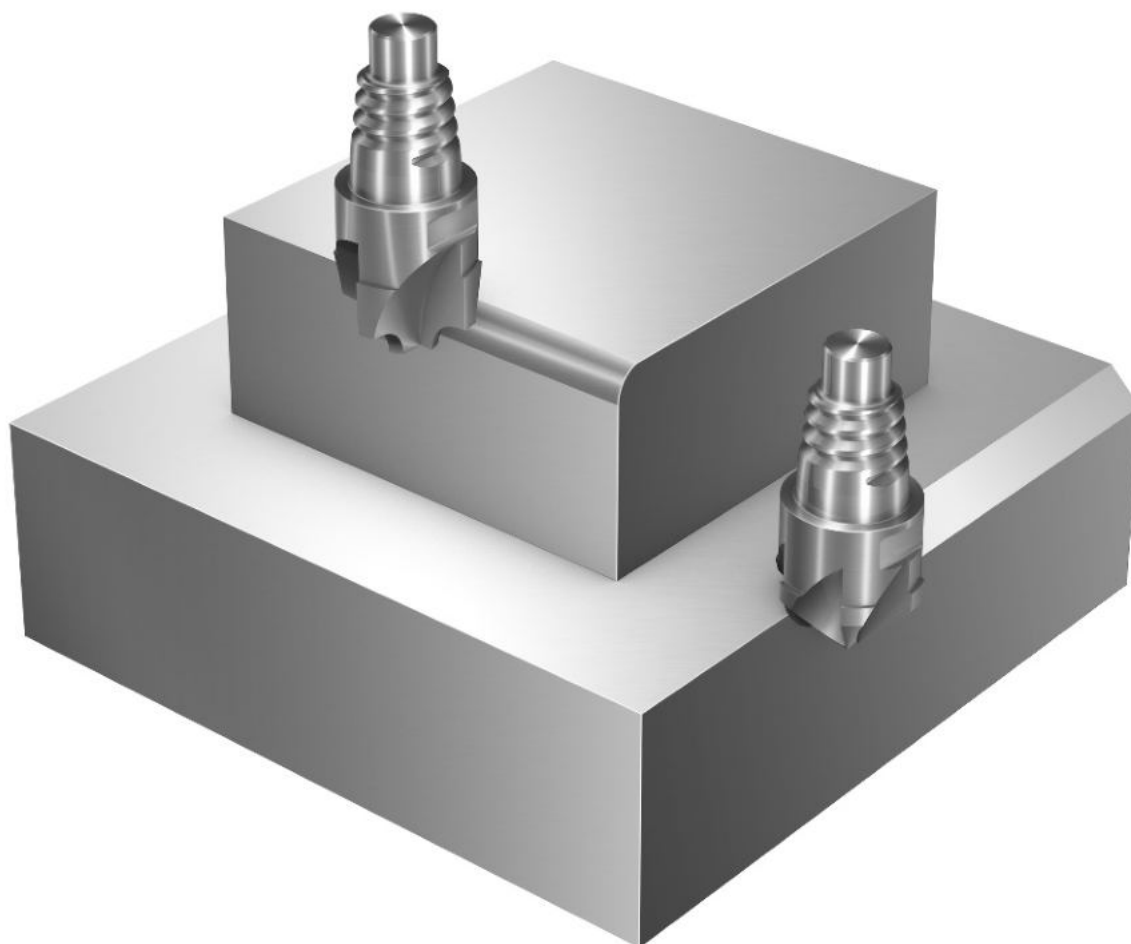
1730

Schaft

Coromant EH

Produktangebot

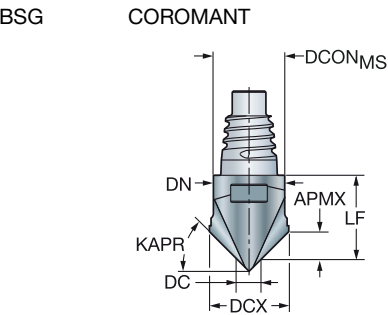
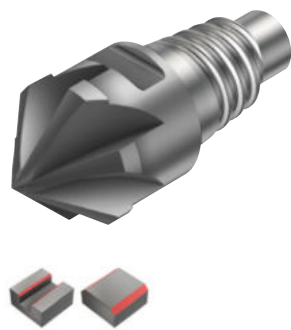
Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc



CoroMill® 316 Vollhartmetall-Fräskopf für das Fasfräsen

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

B



Metrische Ausführung

					P	M	K	S	Abmessungen, mm				
KAPR	CZC _{MS}	APMX	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DC	DCX	LF	DN
15°	E12	1.20	6	316-12CM600-12015G	★	★	☆	☆	11.70	3.00	12.0	14.50	11.7
30°		2.60	6	316-12CM600-12030G	★	★	☆	☆	11.70	3.00	12.0	13.60	11.7
45°	E10	4.25	4	316-10CM400-10045G	★	★	☆	☆	9.70	1.50	10.0	11.66	9.7
45°	E12	4.50	6	316-12CM600-12045G	★	★	☆	☆	11.70	3.00	12.0	13.00	11.7
45°	E16	6.00	8	316-16CM800-16045G	★	★	☆	☆	15.50	4.00	16.0	16.70	15.5
60°	E10	5.60	4	316-10CM400-10060G	★	★	☆	☆	9.70	3.50	10.0	12.40	9.7
60°	E12	6.50	6	316-12CM600-12060G	★	★	☆	☆	11.70	4.50	12.0	14.50	11.7

Zoll-Ausführung

					P	M	K	S	Abmessungen, Zoll				
KAPR	CZC _{MS}	APMX	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DC	DCX	LF	DN
30°	E10	.073	4	A316-10CM400-03730G	★	★	☆	☆	.364	.118	.375	.454	.364
30°	E12	.110	6	A316-12CM600-05030G	★	★	☆	☆	.484	.118	.500	.541	.484
30°	E16	.146	8	A316-16CM800-06230G	★	★	☆	☆	.610	.118	.625	.702	.610
45°	E10	.128	4	A316-10CM400-03745G	★	★	☆	☆	.364	.118	.375	.429	.364
45°	E12	.191	6	A316-12CM600-05045G	★	★	☆	☆	.484	.118	.500	.516	.484
45°	E16	.256	8	A316-16CM800-06245G	★	★	☆	☆	.610	.256	.625	.736	.610
49°	E12	.220	6	A316-12CM600-05049G	★	★	☆	☆	.484	.118	.500	.575	.484
49°	E16	.291	8	A316-16CM800-06249G	★	★	☆	☆	.610	.118	.625	.736	.610
60°	E10	.222	4	A316-10CM400-03760G	★	★	☆	☆	.364	.118	.375	.488	.364
60°	E12	.280	6	A316-12CM600-05060G	★	★	☆	☆	.484	.177	.500	.575	.484
60°	E16	.303	8	A316-16CM800-06260G	★	★	☆	☆	.610	.276	.625	.736	.610

D

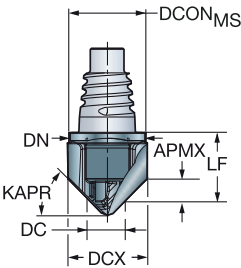
E



CoroMill® 316 Vollhartmetall-Fräskopf für das Fasfräsen

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRC

BSG COROMANT

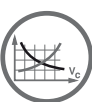


Metrische Ausführung

					P	M	K	S	Abmessungen, mm				
KAPR	CZC _{MS}	APMX	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DC	DCX	LF	DN
15°	E12	1.33	2	316-12CM210-12015G	★	★	☆	☆	11.70	1.50	12.0	13.70	11.7
30°		3.03	2	316-12CM210-12030G	★	★	☆	☆	11.70	1.50	12.0	13.73	11.7
45°	E10	4.23	2	316-10CM210-10045G	★	★	☆	☆	9.70	1.50	10.0	11.53	9.7
45°	E12	5.23	2	316-12CM210-12045G	★	★	☆	☆	11.70	1.50	12.0	13.27	11.7
45°	E16	7.23	2	316-16CM210-16045G	★	★	☆	☆	15.50	1.50	16.0	17.83	15.5
60°	E10	7.50	2	316-10CM210-10060G	★	★	☆	☆	9.70	1.50	10.0	11.53	9.7
60°	E12	7.73	2	316-12CM210-12060G	★	★	☆	☆	11.70	1.50	12.0	13.27	11.7

Zoll-Ausführung

					P	M	K	S	Abmessungen, Zoll				
KAPR	CZC _{MS}	APMX	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DC	DCX	LF	DN
45°	E10	4.29	2	A316-10CM210-03745G	★	★	☆	☆	9.25	1.50	9.5	11.53	9.3
45°	E12	5.85	2	A316-12CM210-05045G	★	★	☆	☆	12.30	1.50	12.7	13.80	12.3
45°	E16	7.45	2	A316-16CM210-06245G	★	★	☆	☆	15.50	1.50	15.9	17.83	15.5



A178



A194



E9



E25



CoroMill® 316 Vollhartmetall-Fräskopf für das Fasfräsen

Für Multimaterial-Anwendungen mit Härte ≤ 48 HRc

B



Metrische Ausführung

					P	M	K	S	Abmessungen, mm					
PRFRAD	CZC _{MS}	APMX	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DC	DCX	LF	DN	
1.5	E10	1.50	4	316-10UM400-10015G	★	★	☆	☆	9.70	5.00	10.0	12.40	9.7	
3.0		3.00	4	316-10UM400-10030G	★	★	☆	☆	9.70	4.00	10.0	12.40	9.7	
3.0	E12	3.00	4	316-12UM400-12030G	★	★	☆	☆	11.70	5.00	12.0	14.50	11.7	
4.0		4.00	4	316-12UM400-12040G	★	★	☆	☆	11.70	4.00	12.0	14.50	11.7	
4.0	E16	4.00	4	316-16UM400-16040G	★	★	☆	☆	15.50	6.00	16.0	18.70	15.5	
5.0		5.00	4	316-16UM400-16050G	★	★	☆	☆	15.50	6.00	16.0	18.70	15.5	
6.0	E20	6.00	4	316-20UM400-20060G	★	★	☆	☆	19.30	8.00	20.0	21.30	19.3	
8.0	E25	8.00	4	316-25UM400-25080G	★	★	☆	☆	24.20	8.00	25.0	25.60	24.2	

Zoll-Ausführung

					P	M	K	S	Abmessungen, Zoll					
PRFRAD	CZC _{MS}	APMX	ZEFP	Bestellnummer	1730	1730	1730	1730	DCON _{MS}	DC	DCX	LF	DN	
.062	E10	.062	4	A316-10UM400-03715G	★	★	☆	☆	.364	.236	.375	.488	.364	
.125		.125	4	A316-10UM400-03732G	★	★	☆	☆	.364	.118	.375	.488	.364	
.188	E16	.188	4	A316-16UM400-06247G	★	★	☆	☆	.610	.236	.625	.736	.610	
.250	E20	.250	4	A316-20UM400-07563G	★	★	☆	☆	.728	.236	.750	.839	.728	

D

E



CoroMill® 316 Keramik-Fräskopf für die Hochgeschwindigkeitsbearbeitung

Einsatzbereich

Für höchste Produktivität beim Fräsen von Nickelbasislegierungen

ISO-Werkstoff

S

Sorte

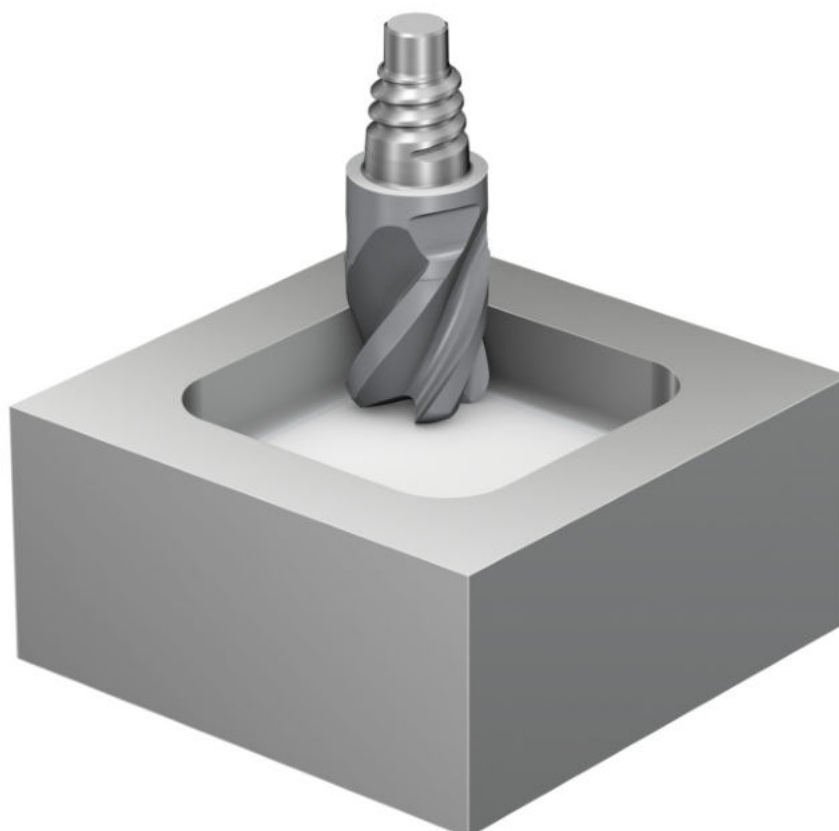
6060

Schaft

Coromant EH

Produktangebot

Für Nickelbasislegierungen



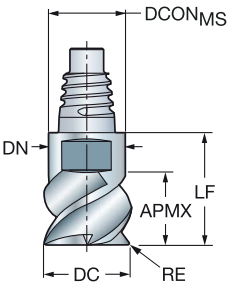
CoroMill® 316 Keramik-Fräskopf für die Hochgeschwindigkeitsbearbeitung

Für Nickelbasislegierungen

Optimiert

FHA
BSG
TCDC

35°
COROMANT
h9



B

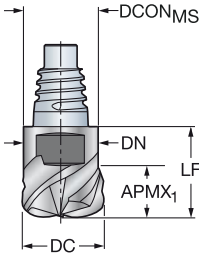
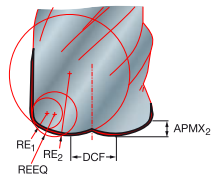
Metrische Ausführung

						S	Abmessungen, mm		
DC	CZC _{MS}	APMX	RE	ZEFP	Bestellnummer	6060	DCON _{MS}	LF	DN
10.0	E10	7.0	2.00	6	316-10FM635-10020D	★	9.7	15.9	9.7
12.0	E12	7.0	2.00	6	316-12FM635-12020D	★	11.7	18.5	11.7

C

FHA
BSG
TCDC

38°
COROMANT
h9



D

Metrische Ausführung

						S	Abmessungen, mm				
DC	CZC _{MS}	APMX ₂	RE ₁	RE ₂	ZEFP	Bestellnummer	0099	DCON	DCF	LF	DN
10.0	E10	0.7	1.5	5.0	4	316-10HM438-10015D	★	9.7	3.4	15.9	9.7
12.0	E12	0.8	1.5	6.0	4	316-12HM438-12015D	★	11.7	4.5	18.5	11.7



CoroMill® 326

Innengewindefräsen und Anfasen von kleinen Bohrungen

Anwendungsbereich

- Innengewindefräsen
- Fasen

O

ISO-Anwendungsbereich:

P M K N S H O

Merkmale und Vorteile

- Drei Schneiden für hohe Produktivität
- Stirnseitiges und rückwärtiges Anfasen von Bohrungen mit nur einem Werkzeug
- Sehr hohe Präzision und niedrige Schnittkräfte
- Dasselbe Werkzeug für unterschiedliche Teilungen
- Eine Sorte für alle Werkstoffe
- Teilgewindeprofile für Flexibilität



Fasen



Gewindefräsen

www.sandvik.coromant.com/coromill326

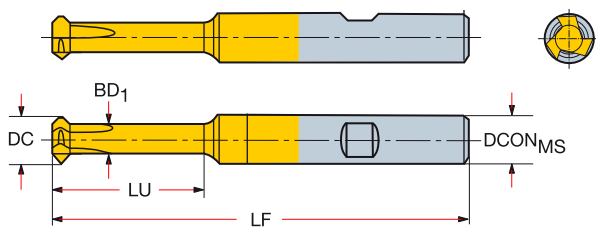
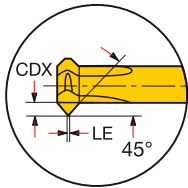
Empfehlungen

Einsatz mit CoroChuck 930 für optimale Stabilität und Präzision.
Stets mit zylindrischen Spannzangen für CoroChuck 930 verwenden.



CoroMill® 326 Vollhartmetall-Schaftfräser für das Fasfräsen
Für Multimaterial-Anwendungen

TCDCON h6



B Metrische Ausführung

					P	M	K	N	S	H	O	Abmessungen, mm				
CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1025	1025	1025	1025	1025	1025	1025	DCON _{MS}	DC	BD ₁	LF	RPMX
6.0	0.60	15.00	3	326R06-B1502006-CH	★	★	★	★	★	★	★	6.00	4.6	4.2	58.00	80000
	0.60	25.00	3	326R06-B2502006-CH	★	★	★	★	★	★	★	6.00	4.6	4.2	68.00	80000
8.0	1.20	25.00	3	326R08-B2502012-CH	★	★	★	★	★	★	★	8.00	5.5	5.0	68.00	80000
	1.20	35.00	3	326R08-B3502012-CH	★	★	★	★	★	★	★	8.00	5.5	5.0	78.00	80000

C Zoll-Ausführung

					P	M	K	N	S	H	O	Abmessungen, Zoll				
CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1025	1025	1025	1025	1025	1025	1025	DCON _{MS}	DC	BD ₁	LF	RPMX
1/4	.024	.591	3	A326R06-M1502006-CH	★	★	★	★	★	★	★	.250	.181	.165	2.283	80000
	.024	.984	3	A326R06-M2502006-CH	★	★	★	★	★	★	★	.250	.181	.165	2.677	80000
5/16	.047	.984	3	A326R08-M2502012-CH	★	★	★	★	★	★	★	.313	.217	.197	2.677	80000
	.047	1.378	3	A326R08-M3502012-CH	★	★	★	★	★	★	★	.313	.217	.197	3.071	80000

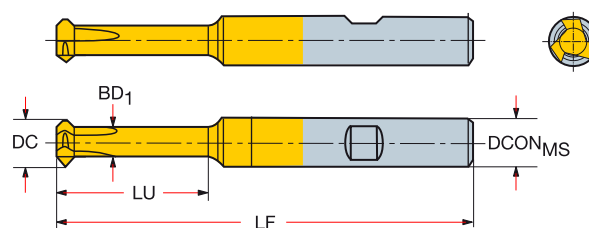
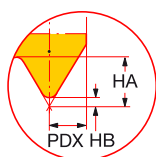


CoroMill® 326 Vollhartmetallfräser für das Gewindefräsen

Für Multimaterial-Anwendungen

FHA
BSG
TCDCON

0°
COROMANT
h6



Metrische Ausführung

										P	M	K	N	S	H	Abmessungen, mm					
TPN	TPX	TPIN	TPIX	DC	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1025	1025	1025	1025	1025	1025	DCON _{MS}	BD ₁	CF	HA	HB	LF
0.5	1.5	16.0	50.0	5.80	6.0	1.94	15.00	3	326R06-B15050VM-TH	★	★	★	★	★	★	6.00	3.5	0.1	0.97	0.06	58.00
0.5	1.5	16.0	50.0	7.80	8.0	1.94	25.00	3	326R08-B25050VM-TH	★	★	★	★	★	★	8.00	5.5	0.1	0.97	0.06	68.00
1.0	2.0	12.0	24.0	7.80	8.0	2.62	25.00	3	326R08-B25100VM-TH	★	★	★	★	★	★	8.00	5.0	0.1	1.31	0.12	68.00

Zoll-Ausführung

										P	M	K	N	S	H	Abmessungen, Zoll					
TPN	TPX	TPIN	TPIX	DC	CZC _{MS}	APMX	LU	ZEFP	Bestellnummer	1025	1025	1025	1025	1025	1025	DCON _{MS}	BD ₁	CF	HA	HB	LF
.020	.059	16.0	50.0	.228	1/4	.076	.591	3	A326R06-M15050VM-TH	★	★	★	★	★	★	.250	.138	.002	.038	.002	2.283
.020	.059	16.0	50.0	.307	5/16	.076	.984	3	A326R08-M25050VM-TH	★	★	★	★	★	★	.313	.217	.002	.038	.002	2.677
.039	.079	12.0	24.0	.307	5/16	.103	.984	3	A326R08-M25100VM-TH	★	★	★	★	★	★	.313	.197	.005	.052	.005	2.677



A193



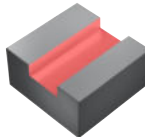
A194



E9

Schnittgeschwindigkeitsempfehlungen

Universell – CoroMill® Plura Vollhartmetall-Schaftfräser zum Schruppen mit großer Eingriffsbreite
Universell – CoroMill® Plura Vollhartmetall-Schaftfräser zum Schruppen mit mittlerer Eingriffsbreite
Universell – CoroMill® Plura Vollhartmetall-Schaftfräser zum Schruppen mit Spanteiler

													
					$a_e = 1.0 \times DC$ $a_p = 0.5 \times DC$			$a_e = 0.5 \times DC$ $a_p = 1.0 \times DC$			$a_e = 0.1 \times DC$ $a_p = 1.5 \times DC$		
ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	A04	145	476	A02	175	574	A06	290	951
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	A04	110	361	A02	135	443	A06	200	656
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	A04	80	262	A02	100	328	A06	170	558
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	A04	65	213	A02	80	262	A06	150	492
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	A03	65	213	A01	80	262	A05	120	394
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	A03	55	180	A01	70	230	A05	90	295
K	K1.1.C.NS	07.2	Temperguss	200	A04	140	459	A02	165	541	A06	150	492
	K2.1.C.UT	08.2	Grauguss	180	A04	130	427	A02	150	492	A06	200	656
	K3.2.C.UT	09.2	Kugelgraphitguss	215	A04	125	410	A02	145	476	A06	155	509
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	A03	30	98	A01	40	131	A05	50	164
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	A03	30	98	A01	40	131	A05	60	197
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	A03	40	131	A01	50	164	A05	100	328

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

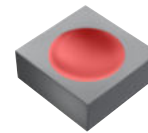
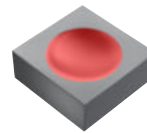
Vorschubempfehlungen

mm/Zahn
Zoll/Zahn

D_z	1.000	2.000	3.000	4.000	6.000	6.350	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
f_z	0.039	0.079	0.118	0.157	0.236	0.250	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.709	0.750	0.787	0.984	1.000
A01	0.001	0.003	0.005	0.008	0.013	0.013	0.020	0.027	0.027	0.035	0.035	0.040	0.050	0.050	0.055	0.060	0.060	0.080	0.080
	.0001	.0001	.0002	.0003	.0005	.0005	.0008	.0011	.0011	.0014	.0014	.0016	.0020	.0020	.0022	.0024	.0024	.0031	.0031
A02	0.002	0.004	0.008	0.012	0.020	0.020	0.030	0.040	0.040	0.050	0.050	0.060	0.070	0.070	0.080	0.090	0.090	0.115	0.115
	.0002	.0002	.0003	.0005	.0008	.0008	.0012	.0016	.0016	.0020	.0020	.0024	.0028	.0028	.0031	.0035	.0035	.0045	.0045
A03	0.002	0.005	0.009	0.013	0.020	0.020	0.023	0.035	0.035	0.040	0.040	0.050	0.055	0.055	0.060	0.070	0.070	0.080	0.080
	.0002	.0002	.0004	.0005	.0008	.0008	.0009	.0014	.0014	.0016	.0016	.0020	.0022	.0022	.0024	.0028	.0028	.0031	.0031
A04	0.003	0.007	0.013	0.020	0.030	0.030	0.040	0.050	0.050	0.060	0.060	0.070	0.080	0.080	0.090	0.100	0.100	0.110	0.110
	.0001	.0003	.0005	.0008	.0012	.0012	.0016	.0020	.0020	.0024	.0024	.0028	.0031	.0031	.0035	.0039	.0039	.0043	.0043
A05	0.002	0.006	0.010	0.016	0.027	0.027	0.041	0.055	0.055	0.072	0.072	0.082	0.103	0.103	0.113	0.123	0.123	0.164	0.164
	.0002	.0002	.0004	.0006	.0010	.0010	.0016	.0022	.0022	.0028	.0028	.0032	.0040	.0040	.0044	.0048	.0048	.0065	.0065
A06	0.004	0.008	0.016	0.025	0.041	0.041	0.062	0.082	0.082	0.103	0.103	0.123	0.144	0.144	0.164	0.185	0.185	0.236	0.236
	.0002	.0003	.0006	.0010	.0016	.0016	.0024	.0032	.0032	.0040	.0040	.0048	.0056	.0056	.0065	.0073	.0073	.0093	.0093

Schnittgeschwindigkeitsempfehlungen

Universell – CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Profilbearbeitung



$a_p = 0.05 \times DC$

$a_p = 0.01 \times DC$

ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	B01	245	804	B03	295	968
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	B01	180	591	B03	215	705
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	B01	120	394	B03	140	459
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	B01	100	328	B03	110	361
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	B02	90	295	B04	110	361
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	B02	80	262	B04	90	295
K	K1.1.C.NS	07.2	Temperguss	200	B01	180	591	B03	215	705
	K2.1.C.UT	08.2	Grauguss	180	B01	205	673	B03	245	804
	K3.2.C.UT	09.2	Kugelgraphitguss	215	B01	165	541	B03	200	656
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	B02	50	164	B04	70	230
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	B02	40	131	B04	55	180
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	B02	80	262	B04	105	344

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

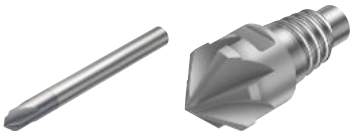
Zoll/Zahn

D_c	1.000	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000
f_z	0.039	0.079	0.118	0.157	0.236	0.250	0.313	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.709	0.750	0.787
B01	0.020 0.0008	0.030 0.0012	0.050 0.0020	0.060 0.0024	0.080 0.0031	0.080 0.0031	0.120 0.0047	0.120 0.0047	0.150 0.0059	0.150 0.0059	0.150 0.0059	0.150 0.0059	0.150 0.0059	0.160 0.0063	0.160 0.0063	0.180 0.0071	0.200 0.0079	0.200 0.0079
B02	0.020 0.0008	0.030 0.0012	0.040 0.0016	0.050 0.0020	0.060 0.0024	0.060 0.0024	0.100 0.0039	0.100 0.0039	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.140 0.0055	0.140 0.0055	0.150 0.0059	0.160 0.0063	0.160 0.0063
B03	0.030 0.0012	0.050 0.0020	0.080 0.0031	0.100 0.0039	0.120 0.0047	0.120 0.0047	0.150 0.0059	0.150 0.0059	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.250 0.0098	0.250 0.0098
B04	0.020 0.0008	0.040 0.0016	0.065 0.0026	0.080 0.0031	0.100 0.0039	0.100 0.0039	0.120 0.0047	0.120 0.0047	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.200 0.0079	0.200 0.0079

Schnittgeschwindigkeitsempfehlungen

Universell – CoroMill® Plura Vollhartmetall-Schaftfräser für das Fasfräsen

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf für das Fasfräsen



$a_e = 0.1 \times DC$

$a_p = 0.1 \times DC$

ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	C01	320	1050
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	C01	220	722
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	C01	130	427
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	C01	90	295
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	C02	110	361
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	C02	70	230
K	K1.1.C.NS	07.2	Temperguss	200	C01	240	787
	K2.1.C.UT	08.2	Grauguss	180	C01	240	787
	K3.2.C.UT	09.2	Kugelgraphitguss	215	C01	215	705
N	N1.2.Z.AG	30.12	Aluminiumbasislegierungen	100	C03	2300	7546
	N1.3.C.UT	30.21	Aluminiumbasislegierungen	75	C03	370	1214
	N1.4.C.NS	30.42	Aluminiumbasislegierungen	130	C03	240	787
	N3.2.C.UT	33.2	Kupfer und Kupferlegierungen	90	C03	680	2231
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	C02	50	164
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	C02	50	164
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	C02	90	295
H	H1.1.Z.HA	04.1	Stahl - Härtegrad 50	50HRC	C02	70	230

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

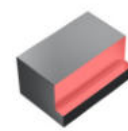
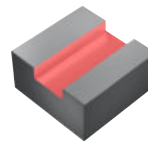
mm/Zahn

Zoll/Zahn

D_ϕ	1	2	3	4	6	6.35	8	9.525	10	12	12.7	14	15.875	16	20
f_z	0.039	0.079	0.118	0.157	0.236	0.250	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.787
C01	0.020	0.030	0.040	0.050	0.070	0.070	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.200
	0.0008	0.0012	0.0016	0.0020	0.0028	0.0028	0.0039	0.0047	0.0047	0.0047	0.0047	0.0047	0.0047	0.0047	0.0079
C02	0.020	0.020	0.030	0.040	0.060	0.060	0.080	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.160
	0.0008	0.0008	0.0012	0.0016	0.0024	0.0024	0.0031	0.0039	0.0039	0.0039	0.0039	0.0039	0.0039	0.0047	0.0063
C03	0.040	0.070	0.070	0.110	0.150	0.150	0.200	0.260	0.260	0.260	0.260	0.260	0.260	0.260	0.440
	0.0016	0.0028	0.0028	0.0043	0.0059	0.0059	0.0079	0.0102	0.0102	0.0102	0.0102	0.0102	0.0102	0.0102	0.0173

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für die Heavy Duty Fräsbearbeitung



ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	$a_e = 1.0 \times DC$ $a_p = 1.0 \times DC$			$a_e = 0.5 \times DC$ $a_p = 1.0 \times DC$			$a_e = 0.25 \times DC$ $a_p = 1.0 \times DC$		
					f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	D01	150	492	D02	180	590	D03	250	820
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	D04	120	394	D02	145	475	D03	200	656
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	D04	80	262	D02	95	311	D03	135	442
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	D04	115	377	D02	140	459	D03	195	639
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	D04	80	262	D05	100	328	D06	140	459
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	D04	80	262	D08	95	311	D09	135	442
K	K1.1.C.NS	07.2	Temperguss	200	D01	150	492	D02	180	590	D03	250	820
	K2.1.C.UT	08.2	Grauguss	180	D01	150	492	D02	180	590	D03	250	820
	K3.2.C.UT	09.2	Kugelgraphitguss	215	D01	160	525	D02	190	623	D03	270	885
S	S2.0.Z.AG	20.22	Nickelbasisuperlegierungen	350	D07	20	148	D08	25	180	D09	32	246
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	D07	40	262	D08	50	311	D09	60	442

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

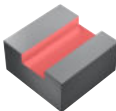
Zoll/Zahn

D_c	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	19.050	20.000	25.000
f_z	0.079	0.118	0.157	0.236	0.250	0.313	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.750	0.787	0.984
D01	0.020 0.0008	0.024 0.0009	0.028 0.0011	0.035 0.0014	0.036 0.0014	0.042 0.0017	0.043 0.0017	0.048 0.0019	0.050 0.0020	0.057 0.0022	0.059 0.0023	0.063 0.0025	0.070 0.0027	0.070 0.0028	0.080 0.0032	0.083 0.0033	0.100 0.0039
D02	0.024 0.0009	0.030 0.0012	0.036 0.0014	0.047 0.0019	0.049 0.0019	0.058 0.0023	0.059 0.0023	0.067 0.0026	0.070 0.0028	0.080 0.0031	0.084 0.0033	0.090 0.0035	0.099 0.0039	0.100 0.0039	0.115 0.0045	0.120 0.0047	0.145 0.0057
D03	0.028 0.0011	0.035 0.0014	0.041 0.0016	0.054 0.0021	0.056 0.0022	0.067 0.0026	0.067 0.0026	0.077 0.0030	0.080 0.0031	0.093 0.0037	0.098 0.0039	0.107 0.0042	0.119 0.0047	0.120 0.0047	0.140 0.0055	0.147 0.0058	0.180 0.0071
D04	0.020 0.0008	0.023 0.0009	0.025 0.0010	0.030 0.0012	0.031 0.0012	0.035 0.0014	0.035 0.0014	0.039 0.0015	0.040 0.0016	0.047 0.0018	0.049 0.0019	0.053 0.0021	0.060 0.0023	0.060 0.0024	0.070 0.0028	0.073 0.0029	0.090 0.0035
D05	0.020 0.0008	0.023 0.0009	0.025 0.0010	0.037 0.0015	0.040 0.0016	0.051 0.0020	0.052 0.0020	0.063 0.0025	0.067 0.0026	0.076 0.0030	0.079 0.0031	0.084 0.0033	0.093 0.0037	0.093 0.0037	0.107 0.0042	0.111 0.0044	0.133 0.0052
D06	0.020 0.0008	0.023 0.0009	0.026 0.0010	0.044 0.0017	0.047 0.0019	0.061 0.0024	0.062 0.0024	0.076 0.0030	0.080 0.0031	0.090 0.0035	0.094 0.0037	0.100 0.0039	0.109 0.0043	0.110 0.0043	0.125 0.0049	0.130 0.0051	0.200 0.0079
D07	0.020 0.0008	0.020 0.0008	0.020 0.0008	0.020 0.0008	0.021 0.0008	0.027 0.0011	0.028 0.0011	0.033 0.0013	0.035 0.0014	0.038 0.0015	0.040 0.0016	0.042 0.0016	0.045 0.0018	0.045 0.0018	0.050 0.0020	0.052 0.0020	0.060 0.0024
D08	0.024 0.0009	0.026 0.0010	0.029 0.0011	0.033 0.0013	0.034 0.0013	0.037 0.0015	0.038 0.0015	0.041 0.0016	0.042 0.0017	0.048 0.0019	0.050 0.0020	0.054 0.0021	0.060 0.0023	0.060 0.0024	0.069 0.0027	0.072 0.0028	0.087 0.0034
D09	0.030 0.0012	0.033 0.0013	0.035 0.0014	0.040 0.0016	0.041 0.0016	0.045 0.0018	0.045 0.0018	0.049 0.0019	0.050 0.0020	0.070 0.0028	0.077 0.0030	0.091 0.0036	0.110 0.0043	0.111 0.0044	0.142 0.0056	0.152 0.0060	0.203 0.0080

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf für die Heavy Duty Fräsbearbeitung



													
					$a_e = 1.0 \times DC$	$a_e = 0.5 \times DC$	$a_e = 0.1 \times DC$						
					$a_p = 0.5 \times DC$	$a_p = 0.5 \times DC$	$a_p = 1.0 \times DC$						
ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	E01	150	476	E02	180	640	E03	250	951
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	E04	120	361	E02	145	492	E03	200	738
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	E04	80	180	E02	75	246	E03	135	377
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	E04	80	246	E02	100	328	E03	150	492
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	E04	70	197	E05	85	279	E06	125	410
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	E07	65	246	E08	80	328	E09	120	492
K	K1.1.C.NS	07.2	Temperguss	200	E01	150	459	E02	160	607	E03	220	919
	K2.1.C.UT	08.2	Grauguss	180	E01	150	246	E02	160	344	E03	220	509
	K3.2.C.UT	09.2	Kugelgraphitguss	215	E01	130	361	E02	140	492	E03	200	722
S	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	E07	20	49	E08	25	82	E09	35	115
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	E07	40	82	E08	35	115	E09	50	164

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn
Zoll/Zahn

D_f	9.525	10.000	12.000	12.700	15.875	16.000	19.050	20.000	25.000	25.400
f_z	0.375	0.394	0.472	0.500	0.625	0.630	0.750	0.787	0.984	1.000
E01	0.048	0.050	0.057	0.059	0.070	0.070	0.080	0.083	0.100	0.100
	0.0019	0.0020	0.0022	0.0023	0.0027	0.0028	0.0032	0.0033	0.0039	0.0039
E02	0.067	0.070	0.080	0.084	0.099	0.100	0.115	0.120	0.145	0.145
	0.0026	0.0028	0.0031	0.0033	0.0039	0.0039	0.0045	0.0047	0.0057	0.0057
E03	0.077	0.080	0.093	0.098	0.119	0.120	0.140	0.147	0.180	0.180
	0.0030	0.0031	0.0037	0.0039	0.0047	0.0047	0.0055	0.0058	0.0071	0.0071
E04	0.039	0.040	0.047	0.049	0.060	0.060	0.070	0.073	0.090	0.090
	0.0015	0.0016	0.0018	0.0019	0.0023	0.0024	0.0028	0.0029	0.0035	0.0035
E05	0.063	0.067	0.076	0.079	0.093	0.093	0.107	0.111	0.133	0.133
	0.0025	0.0026	0.0030	0.0031	0.0037	0.0037	0.0042	0.0044	0.0052	0.0052
E06	0.076	0.080	0.090	0.094	0.109	0.110	0.125	0.130	0.200	0.200
	0.0030	0.0031	0.0035	0.0037	0.0043	0.0043	0.0049	0.0051	0.0079	0.0079
E07	0.033	0.035	0.038	0.040	0.045	0.045	0.050	0.052	0.060	0.060
	0.0013	0.0014	0.0015	0.0016	0.0018	0.0018	0.0020	0.0020	0.0024	0.0024
E08	0.041	0.042	0.048	0.050	0.060	0.060	0.069	0.072	0.087	0.087
	0.0016	0.0017	0.0019	0.0020	0.0023	0.0024	0.0027	0.0028	0.0034	0.0034
E09	0.049	0.050	0.070	0.077	0.110	0.111	0.142	0.152	0.203	0.203
	0.0019	0.0020	0.0028	0.0030	0.0043	0.0044	0.0056	0.0060	0.0080	0.0080

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung



											
a_e = je nach Material				a_e = je nach Material				a_e = je nach Material			
a_p = 2.0 x DC				a_p = 3.0 x DC				a_p = 4.0 x DC			
a_e	f_t	v_c m/min	v_c Fuß/min	a_e	f_t	v_c m/min	v_c Fuß/min	a_e	f_t	v_c m/min	v_c Fuß/min
0.12 x DC	F01	250	820	0.10 x DC	F04	250	820	0.10 x DC	F07	230	755
0.10 x DC	F01	240	787	0.10 x DC	F04	240	787	0.10 x DC	F07	220	722
0.08 x DC	F01	140	459	0.08 x DC	F04	140	459	0.05 x DC	F07	120	394
0.08 x DC	F01	120	394	0.08 x DC	F04	120	394	0.05 x DC	F07	110	361
0.10 x DC	F02	150	492	0.10 x DC	F05	140	459	0.10 x DC	F08	125	410
0.08 x DC	F02	130	427	0.08 x DC	F05	130	427	0.08 x DC	F08	110	361
0.12 x DC	F01	235	771	0.10 x DC	F04	235	771	0.10 x DC	F07	215	705
0.12 x DC	F01	240	787	0.10 x DC	F04	240	787	0.10 x DC	F07	220	722
0.12 x DC	F01	245	804	0.10 x DC	F04	245	804	0.10 x DC	F07	225	738
0.05 x DC	F03	65	213	0.05 x DC	F06	65	213	0.05 x DC	F09	60	197
0.05 x DC	F03	55	180	0.05 x DC	F06	55	180	0.05 x DC	F09	50	164
0.05 x DC	F03	120	394	0.05 x DC	F06	115	377	0.05 x DC	F09	105	344

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

Zoll/Zahn

D_z	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
f_z	0.079	0.118	0.157	0.236	0.250	0.313	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.709	0.750	0.787	0.984	1.000
F01	0.016	0.024	0.032	0.072	0.076	0.095	0.096	0.143	0.150	0.180	0.191	0.210	0.238	0.240	0.270	0.286	0.300	0.375	0.375
	0.0006	0.0009	0.0013	0.0028	0.0030	0.0038	0.0038	0.0056	0.0059	0.0071	0.0075	0.0083	0.0094	0.0094	0.0106	0.0113	0.0118	0.0148	0.0148
F02	0.012	0.018	0.024	0.060	0.064	0.079	0.080	0.124	0.130	0.156	0.165	0.182	0.206	0.208	0.234	0.248	0.260	0.325	0.325
	0.0005	0.0007	0.0009	0.0024	0.0025	0.0031	0.0031	0.0049	0.0051	0.0061	0.0065	0.0072	0.0081	0.0082	0.0092	0.0098	0.0102	0.0128	0.0128
F03	0.008	0.012	0.016	0.036	0.038	0.048	0.048	0.071	0.075	0.090	0.095	0.105	0.119	0.120	0.135	0.143	0.150	0.188	0.188
	0.0003	0.0005	0.0006	0.0014	0.0015	0.0019	0.0019	0.0028	0.0030	0.0035	0.0038	0.0041	0.0047	0.0047	0.0053	0.0056	0.0059	0.0074	0.0074
F04	-	-	-	0.072	0.076	0.086	0.086	0.114	0.120	0.144	0.152	0.168	0.191	0.192	0.216	0.229	0.240	-	-
	-	-	-	0.0028	0.0030	0.0034	0.0034	0.0045	0.0047	0.0057	0.0060	0.0066	0.0075	0.0076	0.0085	0.0090	0.0094	-	-
F05	-	-	-	0.060	0.064	0.071	0.072	0.099	0.104	0.125	0.132	0.146	0.165	0.166	0.187	0.198	0.208	-	-
	-	-	-	0.0024	0.0025	0.0028	0.0028	0.0039	0.0041	0.0049	0.0052	0.0057	0.0065	0.0066	0.0074	0.0078	0.0082	-	-
F06	-	-	-	0.036	0.038	0.048	0.048	0.057	0.060	0.072	0.076	0.084	0.095	0.096	0.108	0.114	0.120	-	-
	-	-	-	0.0014	0.0015	0.0019	0.0019	0.0023	0.0024	0.0028	0.0030	0.0033	0.0038	0.0038	0.0043	0.0045	0.0047	-	-
F07	-	-	-	0.070	0.070	0.080	0.080	0.080	0.080	0.090	0.090	0.100	0.100	0.100	0.150	0.150	0.160	0.190	0.190
	-	-	-	0.0028	0.0028	0.0031	0.0031	0.0031	0.0031	0.0035	0.0035	0.0039	0.0039	0.0039	0.0059	0.0059	0.0063	0.0075	0.0075
F08	-	-	-	0.060	0.060	0.060	0.060	0.070	0.070	0.070	0.070	0.080	0.080	0.080	0.130	0.130	0.140	0.160	0.160
	-	-	-	0.0024	0.0024	0.0024	0.0024	0.0028	0.0028	0.0028	0.0028	0.0031	0.0031	0.0031	0.0051	0.0051	0.0055	0.0063	0.0063
F09	-	-	-	0.040	0.040	0.050	0.050	0.050	0.050	0.060	0.060	0.070	0.070	0.070	0.120	0.120	0.130	0.150	0.150
	-	-	-	0.0016	0.0016	0.0020	0.0020	0.0020	0.0020	0.0024	0.0024	0.0028	0.0028	0.0028	0.0047	0.0047	0.0051	0.0059	0.0059

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Sidemilling Bearbeitung



$a_e = 0.5 \times DC$			$a_e = 0.25 \times DC$		
$a_p = 1.0 \times DC$			$a_p = 1.5 \times DC$		
f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
F11	220	804	F13	235	902
F11	175	574	F13	200	656
F11	150	574	F13	175	656
F11	115	574	F13	130	656
F10	120	410	F12	135	463
F10	110	377	F12	125	427
F11	165	541	F13	185	607
F11	275	902	F13	310	1017
F11	165	541	F13	185	607
F10	35	115	F12	45	148
F10	35	115	F12	45	148
F10	80	272	F12	95	305

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn
Zoll/Zahn

D_c f_z	2.000 0.079	3.000 0.118	4.000 0.157	6.000 0.236	6.350 0.250	7.938 0.313	8.000 0.315	9.525 0.375	10.000 0.394	12.000 0.472	12.700 0.500	14.000 0.551	15.875 0.625	16.000 0.630	18.000 0.709	19.050 0.750	20.000 0.787	25.000 0.984	25.400 1.000
F10	0.003 0.0001	0.005 0.0002	0.008 0.0003	0.013 0.0005	0.013 0.0005	0.020 0.0008	0.020 0.0008	0.027 0.0011	0.027 0.0011	0.035 0.0014	0.035 0.0014	0.040 0.0016	0.050 0.0020	0.050 0.0020	0.055 0.0022	0.060 0.0024	0.060 0.0024	0.080 0.0031	0.080 0.0031
F11	0.004 0.0002	0.008 0.0003	0.012 0.0005	0.020 0.0008	0.020 0.0008	0.030 0.0012	0.030 0.0012	0.040 0.0016	0.040 0.0016	0.050 0.0020	0.050 0.0020	0.060 0.0024	0.070 0.0028	0.070 0.0028	0.080 0.0031	0.090 0.0035	0.090 0.0035	0.115 0.0045	0.115 0.0045
F12	0.004 0.0002	0.007 0.0003	0.011 0.0004	0.017 0.0007	0.017 0.0007	0.027 0.0011	0.027 0.0011	0.036 0.0014	0.036 0.0014	0.047 0.0019	0.047 0.0019	0.053 0.0021	0.067 0.0026	0.067 0.0026	0.073 0.0029	0.080 0.0031	0.080 0.0031	0.106 0.0042	0.106 0.0042
F13	0.005 0.0002	0.011 0.0004	0.016 0.0006	0.027 0.0010	0.027 0.0010	0.040 0.0016	0.040 0.0016	0.053 0.0021	0.053 0.0021	0.067 0.0026	0.067 0.0026	0.080 0.0031	0.093 0.0037	0.093 0.0037	0.111 0.0044	0.120 0.0047	0.120 0.0047	0.153 0.0060	0.153 0.0060



$a_e = 0.1 \times DC$			$a_e = 0.4 \times DC$		
$a_p = 2.0 \times DC$			$a_p = 1.0 \times DC$		
f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
F14	35	115	F15	20	66
F16	50	164	F17	30	98
F18	110	361	F19	44	144
F18	50	164	F19	30	98

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

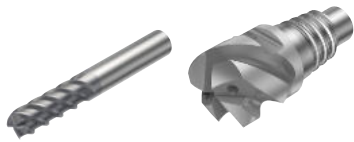
mm/Zahn
Zoll/Zahn

D_c f_z	4.000 0.157	4.765 0.188	5.000 0.197	6.000 0.236	6.350 0.250	8.000 0.315	9.525 0.375	10.000 0.394	12.000 0.472	12.700 0.500	14.000 0.551	15.875 0.625	16.000 0.630	18.000 0.709	19.050 0.750	20.000 0.787	25.000 0.984	25.400 1.000	31.750 1.250	32.000 1.260
F14	0.020 0.0008	0.024 0.0009	0.025 0.001	0.030 0.0012	0.030 0.0013	0.040 0.0016	0.048 0.0019	0.050 0.0020	0.060 0.0024	0.064 0.0025	0.070 0.0028	0.079 0.0031	0.080 0.0031	0.090 0.0035	0.090 0.0038	0.100 0.0039	0.103 0.0049			
F15	0.013 0.0005	0.015 0.0006	0.016 0.0006	0.019 0.0007	0.020 0.0008	0.025 0.0010	0.030 0.0012	0.031 0.0012	0.038 0.0015	0.040 0.0016	0.044 0.0017	0.050 0.0020	0.050 0.0020	0.056 0.0022	0.060 0.0023	0.063 0.0025	0.078 0.0031			
F16	0.026 0.0010	0.031 0.0012	0.033 0.0013	0.039 0.0015	0.041 0.0016	0.052 0.0020	0.062 0.0024	0.065 0.0026	0.078 0.0031	0.083 0.0033	0.091 0.0036	0.103 0.0041	0.103 0.0041	0.117 0.0046	0.124 0.0049	0.130 0.0051	0.163 0.0064			
F17	0.016 0.0006	0.019 0.0008	0.02 0.0008	0.024 0.0010	0.026 0.0010	0.033 0.0013	0.039 0.0015	0.041 0.0016	0.049 0.0019	0.052 0.0020	0.057 0.0022	0.064 0.0025	0.065 0.0026	0.073 0.0029	0.077 0.0030	0.081 0.0032	0.102 0.0040			
F18	0.028 0.0011	0.033 0.0013	0.034 0.0014	0.041 0.0016	0.044 0.0017	0.055 0.0022	0.065 0.0026	0.069 0.0027	0.083 0.0032	0.087 0.0034	0.096 0.0038	0.109 0.0043	0.111 0.0043	0.124 0.0049	0.131 0.0052	0.138 0.0054	0.172 0.0068	0.175 0.0069	0.218 0.0086	0.22 0.0087
F19	0.015 0.0006	0.018 0.0007	0.019 0.0007	0.023 0.0009	0.024 0.0009	0.030 0.0012	0.036 0.0014	0.038 0.0015	0.048 0.0018	0.048 0.0019	0.053 0.0021	0.060 0.0023	0.060 0.0024	0.068 0.0027	0.071 0.0028	0.075 0.0030	0.094 0.0037	0.095 0.0038	0.119 0.0047	0.12 0.0047

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für die High Feed Facemilling Bearbeitung

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf für die High Feed Facemilling Bearbeitung



$$a_e = 0.5 \times DC$$

$$a_p = 0.1 \times DC$$

ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	G01	110	361
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	G01	100	328
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	G01	60	197
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	G01	50	164
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	G01	60	197
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	G01	50	164
K	K1.1.C.NS	07.2	Temperguss	200	G01	120	394
	K2.1.C.UT	08.2	Grauguss	180	G01	120	394
	K3.2.C.UT	09.2	Kugelgraphitguss	215	G01	110	361
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	G01	50	165
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	G01	35	115
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	G01	75	246
H	H1.1.Z.HA	04.1	Stahl - Härtegrad 50	50HRC	G02	110	361
	H1.2.Z.HA	04.1	Stahl - Härtegrad 55	55HRC	G02	110	361
	H1.3.Z.HA	04.1	Stahl - Härtegrad 60	60HRC	G02	60	197

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

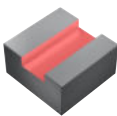
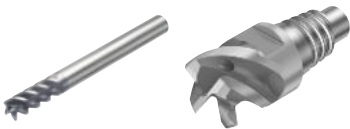
Zoll/Zahn

D_c	4.000	6.000	6.000	10.000	12.000	16.000	20.000
f_z	0.157	0.236	0.236	0.394	0.472	0.630	0.787
G01	0.100	0.160	0.250	0.300	0.350	0.500	0.700
	0.0039	0.0063	0.0098	0.0118	0.0138	0.0197	0.0276
G02	0.080	0.130	0.200	0.240	0.280	0.400	0.560
	0.0031	0.0051	0.0079	0.0094	0.0110	0.0157	0.0220

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für Stabilität und Spanraum

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf für Stabilität und Spanraum



a_e = 1.0 x DC

a_e = 0.5 x DC

a_e = 0.1 x DC

a_p = 0.5 x DC

a_p = 1.0 x DC

a_p = 1.5 x DC

ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	ℓ _t	v _c m/min	v _c Fuß/min	ℓ _t	v _c m/min	v _c Fuß/min	ℓ _t	v _c m/min	v _c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	K01	165	541	K02	215	705	K03	305	1001
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	K01	125	410	K02	160	525	K03	220	722
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	K01	75	246	K02	95	312	K03	130	427
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	K01	45	148	K02	65	213	K03	85	279
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	K05	60	197	K06	75	246	K07	110	361
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	K05	45	148	K06	65	213	K07	85	279
K	K1.1.C.NS	07.2	Temperguss	200	K01	135	443	K02	170	558	K03	240	787
	K2.1.C.UT	08.2	Grauguss	180	K01	135	443	K02	165	541	K03	240	787
	K3.2.C.UT	09.2	Kugelgraphitguss	215	K01	125	410	K02	150	492	K03	215	705
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	K05	25	82	K06	35	115	K07	60	197
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	K08	25	82	K08	35	115	K08	60	197
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	K05	40	131	K06	55	180	K07	95	312
H	H1.1.Z.HA	04.1	Stahl - Härtegrad 50	50HRC	K05	50	164	K06	80	262	K07	90	295
	H1.2.Z.HA	04.1	Stahl - Härtegrad 55	55HRC	K05	50	164	K06	80	262	K07	90	295
	H1.3.Z.HA	04.1	Stahl - Härtegrad 60	60HRC	K05	30	98	K06	50	164	K07	50	164

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

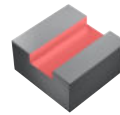
Vorschubempfehlungen

mm/Zahn
Zoll/Zahn

D _c	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	19.050	20.000	25.000	25.400
ℓ _t	0.079	0.118	0.157	0.236	0.250	0.313	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.750	0.787	0.984	1
K01	0.020 0.0008	0.020 0.0008	0.020 0.0008	0.030 0.0012	0.030 0.0012	0.050 0.0020	0.050 0.0020	0.060 0.0024	0.060 0.0024	0.070 0.0028	0.070 0.0028	0.080 0.0031	0.090 0.0035	0.090 0.0035	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.100 0.0039
K02	0.02 0.0008	0.030 0.0012	0.030 0.0012	0.040 0.0016	0.040 0.0016	0.070 0.0028	0.070 0.0028	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.140 0.0055	0.160 0.0063	0.160 0.0063
K03	0.03 0.0012	0.040 0.0016	0.050 0.0020	0.070 0.0028	0.070 0.0028	0.100 0.0039	0.100 0.0039	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.180 0.0071	0.200 0.0079	0.200 0.0079	0.200 0.0079
K04	0.02 0.0008	0.020 0.0008	0.020 0.0008	0.020 0.0008	0.020 0.0008	0.040 0.0016	0.040 0.0016	0.050 0.0020	0.050 0.0020	0.060 0.0024	0.060 0.0024	0.060 0.0024	0.070 0.0028	0.070 0.0028	0.080 0.0031	0.080 0.0031	0.080 0.0031	0.080 0.0031
K05	0.02 0.0008	0.020 0.0008	0.020 0.0008	0.040 0.0016	0.040 0.0016	0.060 0.0024	0.060 0.0024	0.080 0.0031	0.080 0.0031	0.080 0.0031	0.080 0.0031	0.080 0.0031	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.110 0.0043	0.130 0.0051	0.130 0.0051
K06	0.02 0.0008	0.030 0.0012	0.040 0.0016	0.060 0.0024	0.060 0.0024	0.080 0.0031	0.080 0.0031	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.100 0.0039	0.120 0.0047	0.140 0.0055	0.160 0.0063	0.160 0.0063	0.160 0.0063
K07	0.015 0.0006	0.015 0.0006	0.02 0.0008	0.02 0.0008	0.02 0.0008	0.025 0.0010	0.025 0.0010	0.03 0.0012	0.031 0.0012	0.038 0.0015	0.040 0.0016	0.045 0.0018	0.050 0.0020	0.050 0.0020	0.060 0.0024	0.063 0.0025	0.078 0.0031	0.078 0.0031

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für die Hartbearbeitung



$$a_e = 1.0 \times DC$$



$$a_e = 0.1 \times DC$$



$$a_e = 0.05 \times DC$$

ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
P	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	H01	140	459	H02	225	738	H03	250	820
H	H1.1.Z.HA	04.1	Stahl - Härtegrad 50	50HRC	H04	110	361	H05	185	607	H06	205	673
	H1.2.Z.HA	04.1	Stahl - Härtegrad 55	55HRC	H04	125	410	H05	215	705	H06	245	804
	H1.3.Z.HA	04.1	Stahl - Härtegrad 60	60HRC	H04	75	246	H05	130	427	H06	145	476

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

Zoll/Zahn

D_c	2.000	3.000	4.000	6.000	6.350	8.000	9.525	10.000	12.000	16.000
f_z	0.079	0.118	0.157	0.236	0.250	0.315	0.375	0.394	0.472	0.630
H01	0.020	0.020	0.020	0.030	0.030	0.050	0.060	0.060	0.070	0.090
H02	0.030	0.040	0.050	0.070	0.070	0.100	0.120	0.120	0.120	0.120
H03	0.030	0.050	0.060	0.080	0.080	0.120	0.150	0.150	0.150	0.160
H04	0.020	0.020	0.020	0.020	0.020	0.040	0.050	0.050	0.060	0.070
H05	0.020	0.030	0.040	0.060	0.060	0.080	0.100	0.100	0.100	0.120
H06	0.030	0.040	0.050	0.060	0.060	0.100	0.120	0.120	0.120	0.140

B

C

D

E

Schnittgeschwindigkeitsempfehlungen

CoroMill® Plura Keramik-Schaftfräser für die Hochgeschwindigkeitsbearbeitung

CoroMill® 316 Keramik-Fräskopf für die Hochgeschwindigkeitsbearbeitung

											
						$a_e = 0.1 \times DC$			$a_e = 0.075 \times DC$		
						$a_p = 1.5 \times DC$ Überhang 4 x d			$a_p = 1.5 \times DC$ Überhang 6 x d		
ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	ZEFP	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
S	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	4	P02	600-1000	1698-3280	P01	600-700	1968-2296
					6	P01	600-1000	1698-3280	P01	600-700	1968-2296

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn
Zoll/Zahn

D_c	10	12
f_z	0.394	0.472
P01	0.02	0.02
	0.0008	0.0008
P02	0.07	0.09
	0.0028	0.0035

CoroMill® 316 Keramik-Fräskopf für die High Feed Sidemilling Bearbeitung

										
					$a_e = 0.1 \times DC$			$a_e = 0.075 \times DC$		
					$a_p = 1.5 \times DC$ Überhang 4 x d			$a_p = 1.5 \times DC$ Überhang 6 x d		
ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
S	S4.3.Z.AN		Titanbasislegierungen	320	Q01	100	328	Q01	90	295
	S4.4.Z.AN		Titanbasislegierungen	410	Q01	50	164	Q01	45	145

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn
Zoll/Zahn

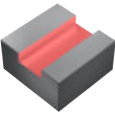
D_c	9.525	10	12	12.7	15.875	16	19.05	20	25	25.4
f_z	0.375	0.394	0.472	0.50	0.625	0.630	0.75	0.787	0.984	1.00
Q01	0.057	0.057	0.066	0.066	0.076	0.076	0.095	0.095	0.123	0.123
	0.0022	0.0022	0.0026	0.0026	0.003	0.003	0.0037	0.0037	0.0049	0.0049

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für ISO N

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf für ISO N



								
$a_e = 1.0 \times DC$			$a_e = 0.5 \times DC$			$a_e = 0.1 \times DC$		
$a_p = 0.5 \times DC$			$a_p = 1.0 \times DC$			$a_p = 1.5 \times DC$		
f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
I01	800	2625	I02	980	3215	I03	1120	3675
I01	270	886	I02	360	1181	I03	480	1575
I01	100	328	I02	130	427	I03	190	623
I01	150	492	I02	200	656	I03	290	951
-	-	-	I04	450	1476	I05	500	1640

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

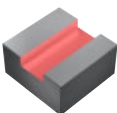
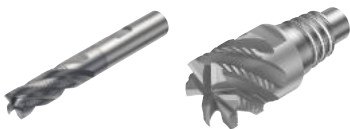
Zoll/Zahn

D_c	1.000	2.000	3.000	4.000	6.000	8.000	10.000	12.000	14.000	16.000	18.000	18.000
f_z	0.039	0.079	0.118	0.157	0.236	0.315	0.394	0.472	0.551	0.630	0.709	0.709
I01	0.020	0.040	0.040	0.040	0.072	0.110	0.130	0.150	0.180	0.200	0.220	0.220
	0.0008	0.0016	0.0016	0.0016	0.0028	0.0043	0.0051	0.0059	0.0071	0.0079	0.0087	0.0087
I02	0.030	0.060	0.070	0.070	0.100	0.170	0.220	0.220	0.220	0.260	0.260	0.310
	0.0012	0.0024	0.0028	0.0028	0.0039	0.0067	0.0087	0.0087	0.0087	0.0102	0.0102	0.0122
I03	0.040	0.070	0.070	0.110	0.150	0.200	0.260	0.260	0.260	0.260	0.330	0.440
	0.0016	0.0028	0.0028	0.0043	0.0059	0.0079	0.0102	0.0102	0.0102	0.0102	0.0130	0.0173
I04	0.010	0.010	0.010	0.020	0.020	0.030	0.040	0.050	0.060	0.070	-	-
	0.0004	0.0004	0.0004	0.0008	0.0008	0.0012	0.0016	0.0020	0.0024	0.0028	-	-
I05	0.010	0.020	0.020	0.030	0.040	0.060	0.080	0.100	0.120	0.140	-	-
	0.0004	0.0008	0.0008	0.0012	0.0016	0.0024	0.0031	0.0039	0.0047	0.0055	-	-

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser mit Kordelverzahnung

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf mit Kordelverzahnung



$a_e = 1.0 \times DC$

$a_e = 0.5 \times DC$

$a_e = 0.1 \times DC$

$a_p = 0.5 \times DC$

$a_p = 1.0 \times DC$

$a_p = 1.5 \times DC$

ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	L01	170	558	L02	220	722	L03	315	1033
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	L01	120	394	L02	160	525	L03	230	755
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	L01	80	262	L02	100	328	L03	140	459
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	L01	50	164	L02	65	213	L03	95	312
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	L04	60	197	L05	75	246	L06	115	377
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	L04	50	164	L05	65	213	L06	95	312
K	K1.1.C.NS	07.2	Temperguss	200	L01	130	427	L02	170	558	L03	245	804
	K2.1.C.UT	08.2	Grauguss	180	L01	130	427	L02	170	558	L03	245	804
	K3.2.C.UT	09.2	Kugelgraphitguss	215	L01	115	377	L02	155	509	L03	220	722
N	N1.2.Z.AG	30.12	Aluminiumbasislegierungen	100	L08	1270	4167	L09	1610	5282	L07	2150	7054
	N1.3.C.UT	30.21	Aluminiumbasislegierungen	75	L08	310	1017	L09	380	1247	L07	540	1772
	N1.4.C.NS	30.42	Aluminiumbasislegierungen	130	L08	110	361	L09	150	492	L07	220	722
	N3.2.C.UT	33.2	Kupfer und Kupferlegierungen	90	L08	170	558	L09	230	755	L07	320	1050
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	L04	20	66	L05	30	98	L06	50	164
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	L04	20	66	L05	30	98	L06	50	164
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	L04	50	164	L05	80	262	L06	130	427

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

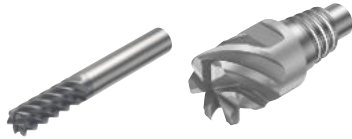
mm/Zahn
Zoll/Zahn

D_c	6	8	9.525	10	12	12.7	14	15.875	16	18	20	25	25.4
f_z	0.236	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.709	0.787	0.984	1.000
L01	0.030	0.050	0.060	0.060	0.070	0.070	0.080	0.090	0.090	0.100	0.100	0.100	0.100
	0.0012	0.0020	0.0024	0.0024	0.0028	0.0028	0.0031	0.0035	0.0035	0.0039	0.0039	0.0039	0.0039
L02	0.040	0.070	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.120	0.140	0.160	0.160
	0.0016	0.0028	0.0039	0.0039	0.0039	0.0039	0.0039	0.0047	0.0047	0.0047	0.0055	0.0063	0.0063
L03	0.070	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.150	0.200	0.200	0.200
	0.0028	0.0039	0.0047	0.0047	0.0047	0.0047	0.0047	0.0047	0.0047	0.0059	0.0079	0.0079	0.0079
L04	0.020	0.040	0.050	0.050	0.060	0.060	0.060	0.070	0.070	0.080	0.080	0.080	0.080
	0.0008	0.0016	0.0020	0.0020	0.0024	0.0024	0.0024	0.0028	0.0028	0.0031	0.0031	0.0031	0.0031
L05	0.040	0.060	0.080	0.080	0.080	0.080	0.080	0.100	0.100	0.100	0.110	0.130	0.130
	0.0016	0.0024	0.0031	0.0031	0.0031	0.0031	0.0031	0.0039	0.0039	0.0039	0.0043	0.0051	0.0051
L06	0.060	0.080	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.160	0.160	0.160
	0.0024	0.0031	0.0039	0.0039	0.0039	0.0039	0.0039	0.0039	0.0047	0.0047	0.0063	0.0063	0.0063
L07	0.150	0.200	0.260	0.260	0.260	0.260	0.260	0.260	0.260	0.330	0.440	0.440	0.440
	0.0059	0.0079	0.0102	0.0102	0.0102	0.0102	0.0102	0.0102	0.0102	0.0130	0.0173	0.0173	0.0173
L08	0.070	0.110	0.130	0.130	0.150	0.150	0.180	0.200	0.200	0.220	0.220	0.220	0.220
	0.0028	0.0043	0.0051	0.0051	0.0059	0.0059	0.0071	0.0079	0.0079	0.0087	0.0087	0.0087	0.0087
L09	0.100	0.160	0.220	0.220	0.220	0.220	0.220	0.260	0.260	0.260	0.310	0.350	0.350
	0.0039	0.0063	0.0087	0.0087	0.0087	0.0087	0.0087	0.0102	0.0102	0.0102	0.0122	0.0138	0.0138

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für die Schlichtbearbeitung

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf für die Schlichtbearbeitung



$$a_e = 0.1 \times DC$$



$$a_e = 0.05 \times DC$$

$$a_p = 1.0 \times DC$$

$$a_p = 1.5 \times DC$$

ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	J01	280	919	J02	330	1083
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	J01	205	673	J02	240	787
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	J01	120	394	J02	140	459
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	J01	80	262	J02	95	312
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	J03	100	328	J04	115	377
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	J03	80	262	J04	95	312
K	K1.1.C.NS	07.2	Temperguss	200	J01	220	722	J04	255	837
	K2.1.C.UT	08.2	Grauguss	180	J01	220	722	J02	255	837
	K3.2.C.UT	09.2	Kugelgraphitguss	215	J01	140	459	J02	165	541
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	J03	50	164	J04	60	197
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	J03	50	164	J04	60	197
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	J03	80	262	J04	95	312
H	H1.1.Z.HA	04.1	Stahl - Härtegrad 50	50HRC	J03	120	394	J04	140	459
	H1.2.Z.HA	04.1	Stahl - Härtegrad 55	55HRC	J03	120	394	J04	140	459
	H1.3.Z.HA	04.1	Stahl - Härtegrad 60	60HRC	J03	70	230	J04	80	262

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

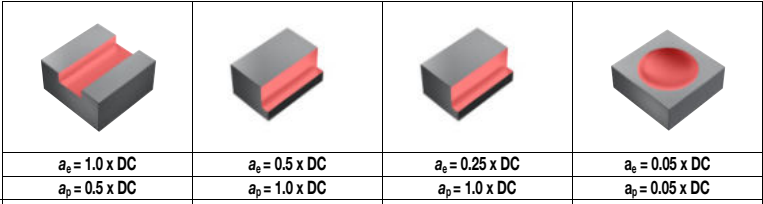
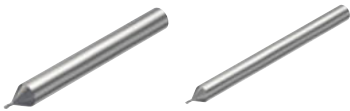
Zoll/Zahn

D_z	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
f_z	0.118	0.157	0.236	0.250	0.313	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.709	0.750	0.787	0.984	1.000
J01	0.040	0.050	0.070	0.070	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.150	0.180	0.200	0.200	0.200
	0.0016	0.0020	0.0028	0.0028	0.0039	0.0039	0.0047	0.0047	0.0047	0.0047	0.0047	0.0047	0.0047	0.0059	0.0071	0.0079	0.0079	0.0079
J02	0.050	0.060	0.080	0.080	0.120	0.120	0.150	0.150	0.150	0.150	0.150	0.160	0.160	0.180	0.200	0.200	0.250	0.250
	0.0020	0.0024	0.0031	0.0031	0.0047	0.0047	0.0059	0.0059	0.0059	0.0059	0.0059	0.0063	0.0063	0.0071	0.0079	0.0079	0.0098	0.0098
J03	0.030	0.040	0.060	0.060	0.080	0.080	0.100	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.140	0.160	0.160
	0.0012	0.0016	0.0024	0.0024	0.0031	0.0031	0.0039	0.0039	0.0039	0.0039	0.0039	0.0039	0.0039	0.0047	0.0047	0.0055	0.0063	0.0063
J04	0.040	0.050	0.060	0.060	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.140	0.140	0.150	0.160	0.160	0.200	0.200
	0.0016	0.0020	0.0024	0.0024	0.0039	0.0039	0.0047	0.0047	0.0047	0.0047	0.0047	0.0055	0.0055	0.0059	0.0063	0.0063	0.0079	0.0079

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für die Mikrobearbeitung

Optimiert – CoroMill® Plura Vollhartmetall-Kugelschaftfräser für die Mikrobearbeitung



ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f _z	v _c m/min	v _c Fuß/min	f _z	v _c m/min	v _c Fuß/min	f _z	v _c m/min	v _c Fuß/min	f _z	v _c m/min	v _c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	M01	140	459	M02	195	640	M08	215	705	M03	330	1083
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	M01	115	377	M02	160	525	M08	175	574	M03	240	787
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	M01	80	262	M02	90	295	M08	100	328	M03	140	459
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	M01	70	230	M02	80	262	M08	90	295	M03	100	328
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	M04	90	295	M05	110	361	M11	120	394	M06	120	394
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	M04	70	230	M05	75	246	M11	85	279	M06	100	328
K	K1.1.C.NS	07.2	Temperguss	200	M01	155	509	M02	170	558	M08	185	607	M03	270	886
	K2.1.C.UT	08.2	Grauguss	180	M01	160	525	M02	175	574	M08	195	640	M03	270	886
	K3.2.C.UT	09.2	Kugelgraphitguss	215	M01	165	541	M02	180	591	M08	200	656	M03	240	787
N	N1.2.Z.AG	30.12	Aluminiumbasislegierungen	100	M09	800	2625	M10	1040	3412	M12	1145	3757	M07	1450	4757
	N1.3.C.UT	30.21	Aluminiumbasislegierungen	75	M09	640	2100	M10	830	2723	M12	915	3002	M07	1030	3379
	N1.4.C.NS	30.42	Aluminiumbasislegierungen	130	M09	200	656	M10	240	787	M12	265	869	M07	360	1181
	N3.2.C.UT	33.2	Kupfer und Kupferlegierungen	90	M09	320	1050	M10	385	1263	M12	425	1394	M07	740	2428
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	M04	30	98	M05	40	131	M11	45	148	M06	60	197
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	M04	30	98	M05	40	131	M11	45	148	M06	60	197
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	M04	65	213	M05	85	279	M11	95	312	M06	110	361
H	H1.1.Z.HA	04.1	Stahl - Härtegrad 50	50HRC	M04	40	131	M05	45	148	M11	50	164	M06	140	459
	H1.2.Z.HA	04.1	Stahl - Härtegrad 55	55HRC	M04	20	66	M05	25	82	M11	25	82	M06	140	459
	H1.3.Z.HA	04.1	Stahl - Härtegrad 60	60HRC	M04	10	33	M05	15	49	M11	15	49	M06	80	262

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

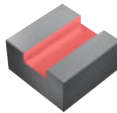
Zoll/Zahn

D _z	0.500	1.000	2.000
f _z	0.020	0.039	0.079
M01	0.010	0.010	0.020
	0.0004	0.0004	0.0008
M02	0.010	0.010	0.020
	0.0004	0.0004	0.0008
M03	0.010	0.020	0.030
	0.0004	0.0008	0.0012
M04	0.010	0.010	0.020
	0.0004	0.0004	0.0008
M05	0.010	0.010	0.020
	0.0004	0.0004	0.0008
M06	0.015	0.020	0.030
	0.0006	0.0008	0.0012
M07	0.035	0.060	0.080
	0.0014	0.0024	0.0031
M08	0.010	0.010	0.020
	0.0004	0.0004	0.0008
M09	0.020	0.020	0.040
	0.0008	0.0008	0.0016
M10	0.020	0.030	0.060
	0.0008	0.0012	0.0024
M11	0.020	0.010	0.020
	0.0008	0.0004	0.0008
M12	-	0.030	0.060
	-	0.0012	0.0024

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf für die Hartbearbeitung



								
$a_e = 1.0 \times DC$			$a_e = 0.5 \times DC$			$a_e = 0.1 \times DC$		
$a_p = 0.5 \times DC$			$a_p = 0.5 \times DC$			$a_p = 0.75 \times DC$		
f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
O01	145	476	O02	195	640	O03	290	951
O01	110	361	O02	150	492	O03	225	738
O01	55	180	O02	75	246	O03	115	377
O01	75	246	O02	100	328	O03	150	492
O06	60	197	O05	85	279	O04	125	410
O06	75	246	O05	100	328	O04	150	492
O01	140	459	O02	185	607	O03	280	919
O01	75	246	O02	105	344	O03	155	509
O01	110	361	O02	150	492	O03	220	722
O06	20	66	O05	25	82	O04	40	131
O06	15	49	O05	25	82	O04	35	115
O06	25	82	O05	35	115	O04	50	164

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

mm/Zahn

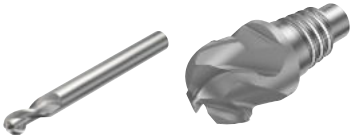
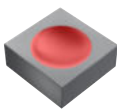
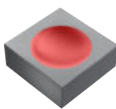
Zoll/Zahn

D_c	10.000	12.000	16.000
f_z	0.394	0.472	0.630
O01	0.070 0.0028	0.080 0.0031	0.110 0.0043
O02	0.120 0.0047	0.120 0.0047	0.140 0.0055
O03	0.140 0.0055	0.140 0.0055	0.140 0.0055
O04	0.120 0.0047	0.120 0.0047	0.120 0.0047
O05	0.075 0.0030	0.090 0.0035	0.120 0.0047
O06	0.050 0.0020	0.060 0.0024	0.070 0.0028

Schnittgeschwindigkeitsempfehlungen

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser für die Profilarbeit

Optimiert – CoroMill® 316 Vollhartmetall-Fräskopf für die Profilarbeit

										
					$a_e = 0.05 \times DC$			$a_e = 0.01 \times DC$		
ISO	MC-Nr.	CMC-Nr.	Werkstoff	HB	f_z	v_c m/min	v_c Fuß/min	f_z	v_c m/min	v_c Fuß/min
P	P1.2.Z.AN	01.2	Unlegierter Stahl	190	N01	300	984	N04	360	1181
	P2.2.Z.AN	02.2	Niedriglegierter Stahl	240	N01	220	722	N04	265	869
	P3.0.Z.HT	03.21	Hochlegierter Stahl	380	N01	130	427	N04	150	492
M	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	N01	90	295	N05	100	328
	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl	200	N02	110	361	N05	130	427
	M3.2.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	N02	90	295	N04	100	328
K	K1.1.C.NS	07.2	Temperguss	200	N01	240	787	N04	290	951
	K2.1.C.UT	08.2	Grauguss	180	N01	240	787	N04	290	951
	K3.2.C.UT	09.2	Kugelgraphitguss	215	N01	215	705	N04	255	837
N	N1.2.Z.AG	30.12	Aluminiumbasislegierungen	100	N03	1765	5791	N06	1765	5791
	N1.3.C.UT	30.21	Aluminiumbasislegierungen	75	N03	755	2477	N06	910	2986
	N1.4.C.NS	30.42	Aluminiumbasislegierungen	130	N03	280	919	N06	335	1099
	N3.2.C.UT	33.2	Kupfer und Kupferlegierungen	90	N03	505	1657	N06	615	2018
S	S1.0.U.AG	20.12	Eisenbasissuperlegierungen	280	N02	50	164	N05	70	230
	S2.0.Z.AG	20.22	Nickelbasissuperlegierungen	350	N02	50	164	N05	70	230
	S4.2.Z.AN	23.22	Titanbasislegierungen	320	N02	100	328	N05	130	427
H	H1.1.Z.HA	04.1	Stahl - Härtegrad 50	50HRC	N02	145	476	N05	175	574
	H1.2.Z.HA	04.1	Stahl - Härtegrad 55	55HRC	N02	145	476	N05	175	574
	H1.3.Z.HA	04.1	Stahl - Härtegrad 60	60HRC	N02	85	279	N05	100	328
O	O7.0.S.UT		Graphit		N03	800	2625	N06	850	2789

Für optimierte Schnittdaten, siehe CoroPlus® ToolGuide.

Vorschubempfehlungen

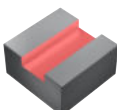
mm/Zahn

Zoll/Zahn

D_c	1.000	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	16.000	20.000	25.000	25.400
f_z	0.039	0.079	0.118	0.157	0.236	0.250	0.313	0.315	0.375	0.394	0.472	0.500	0.630	0.787	0.984	1.000
N01	0.020 0.0008	0.030 0.0012	0.050 0.0020	0.060 0.0024	0.080 0.0031	0.080 0.0031	0.120 0.0047	0.120 0.0047	0.150 0.0059	0.150 0.0059	0.150 0.0059	0.150 0.0059	0.160 0.0063	0.020 0.0079	0.025 0.0098	0.025 0.0098
N02	0.020 0.0008	0.030 0.0012	0.040 0.0016	0.050 0.0020	0.060 0.0024	0.060 0.0024	0.100 0.0039	0.100 0.0039	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.120 0.0047	0.140 0.0055	0.016 0.00630	0.020 0.0079	0.020 0.0090
N03	0.060 0.0024	0.080 0.0031	0.100 0.0039	0.130 0.0051	0.180 0.0071	0.180 0.0071	0.260 0.0102	0.260 0.0102	0.330 0.0130	0.330 0.0130	0.330 0.0130	0.330 0.0130	0.380 0.0150	0.440 0.0173	0.500 0.0197	0.500 0.0197
N04	0.030 0.0012	0.050 0.0020	0.080 0.0031	0.100 0.0039	0.120 0.0047	0.120 0.0047	0.150 0.0059	0.150 0.0059	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.200 0.0079	0.250 0.0098	0.250 0.0098	0.250 0.0098
N05	0.020 0.0008	0.040 0.0016	0.065 0.0026	0.080 0.0031	0.100 0.0039	0.100 0.0039	0.120 0.0047	0.120 0.0047	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.160 0.0063	0.200 0.0079	0.200 0.0079	0.200 0.0079
N06	0.070 0.0028	0.110 0.0043	0.175 0.0069	0.220 0.0087	0.260 0.0102	0.260 0.0102	0.330 0.0130	0.330 0.0130	0.440 0.0173	0.440 0.0173	0.440 0.0173	0.440 0.0173	0.440 0.0173	0.500 0.0197	0.500 0.0197	0.500 0.0197

Optimiert – CoroMill® Plura Vollhartmetall-Schaftfräser zum Besäumen

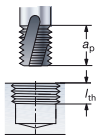
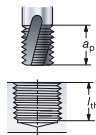
Für Verbundwerkstoffe

							
$a_p \times a_e > DC$				$a_p \times a_e > DC$			
f_z mm/Zahn*		v_c m/min		f_z mm/Zahn*		v_c m/min	
2P460		0.03		100		0.08	
2P350		0.03		130		0.03	
2P050		0.06		100		0.05	

Gleicher Vorschub für alle Durchmesser.

Schnittdaten CoroMill® Plura Gewindefräser

Schnittgeschwindigkeits- und Vorschubempfehlungen

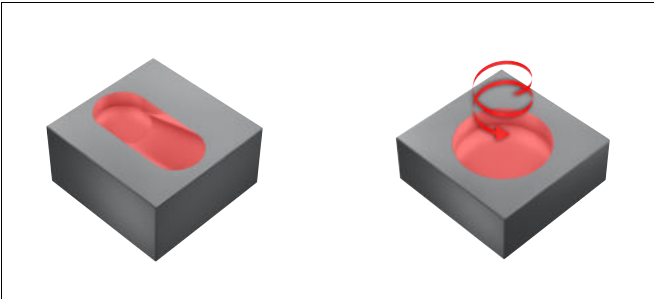
ISO	Werkstoff			Gewinde- fräser	Abmessungen, mm, Zoll			 $f_{Th} = 0.5 \times a_p$		 $f_{Th} = a_p$					
	MC	Härte HB	HRC		Gewinde	DC	DC"	ZEFP	Schnittgeschwin- digkeit v_c m/min ft/min	Vorschub pro Zahn, f_z mm Zoll	Schnittgeschwin- digkeit v_c m/min ft/min	Vorschub pro Zahn, f_z mm Zoll			
P	Unlegierter Stahl P1.1.Z.AN 125			M2	1.55	.061	3	127	417	0.027	.0011	120	396	0.020	.0008
				M4	3.2	.126	3	152	500	0.030	.0012	141	465	0.018	.0007
				M10	8.2	.323	4	132	435	0.052	.0020	124	410	0.029	.0012
				M20	16	.630	5	141	465	0.130	.0051	131	430	0.069	.0028
	Niedriglegierter Stahl P2.5.Z.HT 300			M2	1.55	.061	3	84	276	0.018	.0007	80	263	0.016	.0006
				M4	3.2	.126	3	147	485	0.012	.0005	137	440	0.006	.0003
				M10	8.2	.323	4	164	540	0.086	.0034	153	500	0.050	.0020
				M20	16	.630	5	173	570	0.089	.0036	162	535	0.118	.0046
	Hochlegierter Stahl P3.0.Z.HT 450			M2	1.55	.061	3	73	240	0.005	.0002	70	231	0.0045	.0002
				M4	3.2	.126	3	163	540	0.035	.0014	151	500	0.015	.0006
				M10	8.2	.323	4	164	550	0.061	.0024	153	520	0.049	.0020
				M20	16	.630	5	173	570	0.102	.0005	162	540	0.118	.0046
M	Rostfreier Stahl P5.0.Z.AN 200			M2	1.55	.061	3	37	121	0.01	.0004	35	114	0.009	.00035
				M4	3.2	.126	3	81	265	0.024	.0010	75	245	0.009	.0004
				M10	8.2	.323	4	82	270	0.052	.0020	76	250	0.036	.0014
				M20	16	.630	5	86	280	0.089	.0036	93	310	0.089	.0036
	M1.0.Z.AQ 200			M2	1.55	.061	3	52	170	0.009	.00035	50	164	0.0085	.00035
				M4	3.2	.126	3	53	175	0.018	.0007	49	160	0.007	.0007
				M10	8.2	.323	4	53	175	0.052	.0020	50	165	0.027	.0012
				M20	16	.630	5	56	185	0.089	.0036	53	175	0.072	.0029
	M3.1.Z.AQ 230			M2	1.55	.061	3	42	137	0.0045	.0002	40	131	0.0042	.00015
				M4	3.2	.126	3	53	175	0.018	.0008	49	160	0.007	.0003
				M10	8.2	.323	4	53	175	0.052	.0020	50	165	0.027	.0012
				M20	16	.630	5	56	185	0.131	.0052	53	175	0.074	.0030
K	Temperguss K1.1.C.NS			M2	1.55	.061	3	97	318	0.0289	.0012	92	301	0.025	.001
				M4	3.2	.126	3	80	265	0.020	.0008	77	260	0.016	.0006
				M10	8.2	.323	4	89	290	0.061	.0022	83	275	0.036	.0014
				M20	16	.630	5	82	270	0.084	.0032	83	275	0.089	.0036
	Grauguss K2.2.C.UT			M2	1.55	.061	3	82	269	0.018	.0007	80	262	0.016	.0006
				M4	3.2	.126	3	76	260	0.018	.0007	73	250	0.014	.0006
				M10	8.2	.323	4	86	310	0.038	.0014	79	285	0.034	.0013
				M20	16	.630	5	79	285	0.075	.0030	80	290	0.080	.0032
	Kugelgraphitguss K3.1.C.UT			M2	1.55	.061	3	97	318	0.04	.0015	94	308	0.035	.0014
				M4	3.2	.126	3	101	340	0.027	.0012	97	330	0.020	.0008
				M10	8.2	.323	4	104	345	0.047	.0020	105	340	0.048	.0020
				M20	16	.630	5	104	345	0.089	.0036	97	330	0.067	.0026
N	Aluminium N1.2.Z.UT 60			M2	1.55	.061	3	390	1280	0.06	.0023	375	1230	0.055	.0022
				M4	3.2	.126	3	503	1660	0.040	.0016	503	1660	0.035	.0014
				M10	8.2	.323	4	1120	3700	0.089	.0036	1060	3500	0.061	.0024
				M20	16	.630	5	1130	3750	0.089	.0036	1060	3500	0.089	.0036
	N1.3.C.UT 95			M2	1.55	.061	3	377	1237	0.058	.0022	365	1198	0.054	.0022
				M4	3.2	.126	3	434	1430	0.040	.0016	404	1330	0.018	.0007
				M10	8.2	.323	4	461	1520	0.061	.0025	432	1420	0.061	.0034
				M20	16	.630	5	467	1540	0.089	.0036	436	1445	0.089	.0036
	150			M2	1.55	.061	3	125	410	0.056	.0022	123	404	0.054	.0022
				M4	3.2	.126	3	273	900	0.028	.0011	262	890	0.021	.0009
				M10	8.2	.323	4	278	920	0.053	.0021	260	870	0.026	.0012
				M20	16	.630	5	282	930	0.089	.0036	263	880	0.071	.0028
S	Warmfeste Legierungen S1.0.U.AN 200			M2	1.55	.061	3	27	89	0.011	.0004	25	82	0.01	.0004
				M4	3.2	.126	3	35	115	0.006	.0002	35	115	0.003	.0001
				M10	8.2	.323	4	37	120	0.023	.0011	35	115	0.013	.0006
				M20	16	.630	5	38	125	0.066	.0026	38	125	0.063	.0025
	Titanlegierungen S2.0.Z.AG 300			M2	1.55	.061	3	16	53	0.007	.0003	15	49	0.0065	.00025
				M4	3.2	.126	3	30	100	0.008	.0004	29	100	0.004	.0002
				M10	8.2	.323	4	32	105	0.013	.0006	30	100	0.007	.0003
				M20	16	.630	5	32	105	0.037	.0015	30	100	0.018	.0007
	S4.2.Z.AN 300			M2	1.55	.061	3	25	82	0.01	.0004	23	75	0.009	.00035
				M4	3.2	.126	3	55	180	0.012	.0005	51	165	0.006	.0011
				M10	8.2	.323	4	58	190	0.037	.0015	54	175	0.020	.0008
				M20	12	.472	6	59	195	0.089	.0036	55	180	0.051	.0022
H	H1.3.Z.HA 55			M2	1.55	.061	3	20	66	0.002	.00008	18	59	0.002	.00008
				M4	4.5	.177	4	43	140	0.010	.0004	40	130	0.005	.0002
				M10	8.2	.323	5	42	135	0.022	.0010	45	150	0.018	.0007
				M20	12	.472	5	45	150	0.042	.0017	42	135	0.021	.0009
	H1.3.Z.HA 60			M2	1.55	.061	3	17	56	0.002	.00008	15	49	0.002	.00008
				M4	4.5	.177	4	30	100	0.005	.0002	30	100	0.003	.0001
				M10	8.2	.323	5	29	100	0.011	.0005	28	100	0.006	.0002
				M20	12	.472	5	30	100	0.022	.0010	28	100	0.010	.0004

Eintauchwinkel, max.

CoroMill® Plura - Optimiert

CoroMill® Plura - Universell

CoroMill® 316



		Anzahl Schneiden (ZEFP)				
ISO	Werkstoff	≤ 2	3	4	5	≥ 6
P	Stahl (Härte <300HB)	9	7	5	5	≤ 4
	Stahl (Härte >300HB)	7	5	4	3	≤ 3
M	Rostfreier Stahl	5	5	5	4	≤ 4
K	Grauguss	10	10	8	6	≤ 5
N	NE-Metalle	15	12	10	10	≤ 10
S	Superlegierungen und Titan	5	5	4	4	≤ 3
H	Hartstoffe	2	2	1.5	1.5	≤ 1.5
O	Nicht ISO	15	12	10	10	≤ 10

Sorten zum Fräsen

	P	M	K	N	S	H	O	Nass	Trocken	Bezeichnung
1610	+					++		✗	✓	Ultra-feinkörniges Substrat und CIL-Beschichtung. Geeignet zum Schlichten und Vorschlichten von ISO H (und harten ISO P) Werkstoffen. Nicht für hohe a _{ap} geeignet. Für stabile Bedingungen.
1620	+	++	+		+	+		✓	✓	Vielseitige Sorte, ähnlich der GC1630. Für den Einsatz in den meisten Werkstoffen. Hohe Verschleißfestigkeit. Zeigt im Vergleich zu GC1630 bessere Leistung in ISO S und ISO M.
1630	++	+	++		+		+	✓	✓	Vielseitige Sorte, ähnlich der GC1620. Für den Einsatz in den meisten Werkstoffen. Zeigt im Vergleich zu GC1620 bessere Leistung in ISO P und ISO K. Vorzugsweise Trockenbearbeitung.
1640	+	++	+		++			✓	✓	Sehr zähe Sorte für hohes Spanvolumen (hoher a _p). Für den Einsatz in den meisten Werkstoffen. Zeigt gute Leistung bei nassen Bedingungen. Geeignet für instabile Bedingungen.
H10F				++			+	✓	✗	Unbeschichtete Sorte zur Bearbeitung von ISO N und einigen ISO O Werkstoffen (z.B. Thermoplaste).
N20C				+			++	✓	✓	Diamant beschichtete Sorte für Graphit- und Verbundwerkstoffe sowie für ISO N mit hohem Siliziumgehalt. (zirka>9%).
1700						++		✗	✓	Sehr zähe Sorte zur Bearbeitung von ISO H Werkstoffen.
1710					++			✓	✗	Hartes, verschleißfestes, feinkörniges Substrat. Neue Beschichtung für mit haftmindernden Eigenschaften. Spezielle Sorte für Nickelbasislegierungen.
1730	++	+	++		+			✓	✓	Sorte der nächsten Generation von GC1730. Vielseitige Sorte mit höherer Zähigkeit und breitetem Anwendungsbereich im Vergleich zu GC1630. Vorzugsweise Trockenbearbeitung.
1740	+	++	+		++			✓	✓	Sorte der nächsten Generation von GC1740. Neues Submikron-Substrat und TiAlN-Beschichtung für erhöhte Zähigkeit und einen breiteren Anwendungsbereich im Vergleich zu GC1640. Hervorragend bei nassen Bedingungen.
1745					++			✓	✗	Zähes, feinstkörniges Substrat mit neuer Siliziumbeschichtung. Anwenendungsspezifische Sorte für Titanlegierungen.
P10	+	+	+		+	+		✓	✓	Diese Sorte hat nur eine Werkzeugausführung. Langer Kugelschaftfräser. Sorte ist der GC1620 sehr ähnlich.

Bohren



Universell

CoroDrill® 460
Bohrer für Multimaterial-Anwendungen

B3



Optimiert

CoroDrill® 860
Bohrer für Multimaterial
Bohrer für Stahl
Bohrer für rostfreien Stahl
Bohrer für Aluminium
Bohrer für hochwarmfeste Legierungen

B18
B28
B36
B41
B45

CoroDrill® 861
Bohrer für tiefe Bohrungen in Multimaterial

B50

CoroDrill® 862
Bohrer für Präzisionsbohrungen mit kleinem Durchmesser

B56

CoroDrill® 863
Bohrer für CNC-, ADU- und Robotersysteme Luftfahrt-Strukturbauteile

B58

CoroDrill® 452
Werkzeuiglösung für portable, handgeführte Maschinen und Verbundwerkstoffe

B62

CoroDrill® 400
Bohrer für Aluminium

B66

CoroDrill® 430
Bohrer für Aluminium

B66



Kundenspezifisch

E5

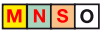
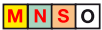
B

C

D

E

	460	860-GM	860-PM	860-MM	860-NM	860-SM
						
ISO Anwendungsbereich						
Durchmesser, mm	3.00 - 20.00	3.00 - 16.00	3.00 - 20.00	3.00 - 15.80	3.00 - 17.50	3.00 - 15.87
Durchmesser, Zoll	.118 - .787	.118 - .630	.118 - .787	.118 - .622	.118 - .689	.118 - .625
Werkzeugtoleranz	m7	m7	m7	m7	m7	m7
TCHA	H9	H9	H8	H8	H9	H9
Innere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓	✓
Außere Kühlschmierstoffzufuhr	✓	✓	✗	✗	✗	✗
ULDR	2-8xØ	2-8xØ	2-8xØ	3-8xØ	3-8xØ	2-5xØ
						
Seite	B18	B18	B28	B36	B41	B45

	861	862	863	452	400/430
					
ISO Anwendungsbereich					
Durchmesser, mm	3.00 - 16.00	1.85 - 2.95	3.30 - 11.14	2.50 - 7.94	5.00 - 12.50
Durchmesser, Zoll	.118 - .630	.073 - .116	.130 - .439	.098 - .313	.197 - .492
Werkzeugtoleranz	m7	m7	m7	m7	m7
TCHA	H9	H9	H9	H9	H9
Innere Kühlschmierstoffzufuhr	✓	✓	✓	✗	✓
Außere Kühlschmierstoffzufuhr	✗	✗	✓	✓	✗
ULDR	12-30xØ	7-12xØ	1.5-12-5xØ	2-15xØ	6-7xØ
					
Seite	B50	B56	B58	B62	B66

CoroDrill® 460

Vielseitig einsetzbarer leistungsstarker Vollhartmetallbohrer

Anwendungsbereich

- Für einen breiten Werkstoffbereich in allen Industriesegumenten, wie z.B. im allgemeinen Maschinenbau, im Formen- und Gesenkbau, in der Automobilindustrie sowie bei der Energie- und Stromerzeugung
- Innere und äußere Kühlschmierstoffzufuhr

V

C

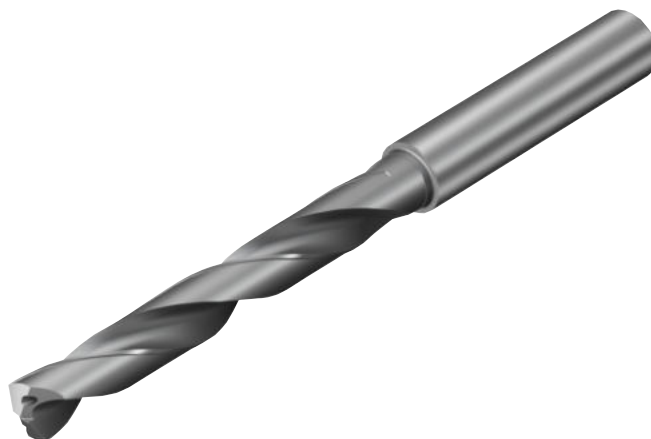
B

ISO-Anwendungsbereich:



Merkmale und Vorteile

- Hohe Produktivität und vorhersagbare Standzeit
- Großer Nutzen ohne Qualitätseinbußen
- Ausgezeichnete Bohrungsqualität
- Verminderte Werkzeugkosten
- Kann bis zu drei Mal nachgeschliffen werden, wodurch die Standzeit sogar noch weiter erhöht wird
- Kühlschmierstoffdruck 20 bar



C

www.sandvik.coromant.com/corodrigill460

Empfehlungen

Wir empfehlen die Verwendung von hydraulischen Präzisionsspannfuttern.

Es wird eine innere Kühlschmierstoffzufuhr mit einem Mindestdruck von 20 bar empfohlen

D

Für Spannfutter, siehe Katalog Rotierende Werkzeuge.



E



E14

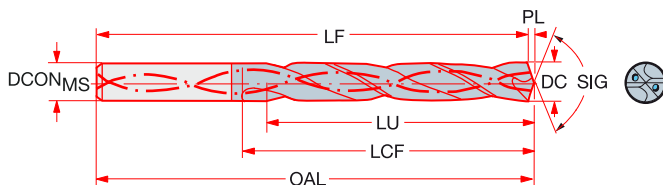
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



B

C

D

E

							P	M	K	N	S	H	Abmessungen, mm, Zoll														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG		
3.00	.118	9.4	.370	3	6	460.1-0300-009A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K		
3.00	.118	15.4	.606	5	6	460.1-0300-015A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	20	290	DIN 6537 L		
3.00	.118	24.4	.961	8	6	460.1-0300-023A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016	20	290	COROMANT		
3.05	.120	15.7	.618	5	6	460.1-0305-015A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	20	290	DIN 6537 L		
3.10	.122	9.7	.382	3	6	460.1-0310-009A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K		
3.10	.122	15.9	.626	5	6	460.1-0310-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	20	290	DIN 6537 L		
3.10	.122	25.2	.992	8	6	460.1-0310-023A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016	20	290	COROMANT		
3.18	.125	10.0	.394	3	6	460.1-0318-010A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.18	.125	16.3	.642	5	6	460.1-0318-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.18	.125	25.9	1.020	8	6	460.1-0318-024A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT		
3.20	.126	10.1	.398	3	6	460.1-0320-010A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.20	.126	16.5	.650	5	6	460.1-0320-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.20	.126	26.1	1.028	8	6	460.1-0320-024A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT		
3.26	.128	16.8	.661	5	6	460.1-0326-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.30	.130	10.4	.409	3	6	460.1-0330-010A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.30	.130	17.0	.669	5	6	460.1-0330-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.30	.130	26.9	1.059	8	6	460.1-0330-025A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT		
3.35	.132	17.2	.677	5	6	460.1-0335-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.40	.134	10.7	.421	3	6	460.1-0340-010A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.40	.134	17.5	.689	5	6	460.1-0340-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.40	.134	27.7	1.091	8	6	460.1-0340-026A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT		
3.50	.138	11.0	.433	3	6	460.1-0350-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.50	.138	18.0	.709	5	6	460.1-0350-018A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.50	.138	28.5	1.122	8	6	460.1-0350-026A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT		
3.57	.141	11.2	.441	3	6	460.1-0357-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.57	.141	29.1	1.146	8	6	460.1-0357-027A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT		
3.60	.142	11.3	.445	3	6	460.1-0360-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.60	.142	18.5	.728	5	6	460.1-0360-018A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.70	.146	11.6	.457	3	6	460.1-0370-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.70	.146	19.0	.748	5	6	460.1-0370-019A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.70	.146	28.9	1.138	7	6	460.1-0370-028A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT		
3.80	.150	11.9	.469	3	6	460.1-0380-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K		
3.80	.150	19.5	.768	5	6	460.1-0380-019A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.5	2.894	36	1.417	0.5	.020	20	290	DIN 6537 L		
3.80	.150	30.9	1.217	8	6	460.1-0380-029A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.5	3.524	48	1.890	0.5	.020	20	290	COROMANT		
3.90	.154	12.3	.484	3	6	460.1-0390-012A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K		
3.90	.154	20.1	.791	5	6	460.1-0390-020A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L		
3.97	.156	20.4	.803	5	6	460.1-0397-020A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L		
3.97	.156	32.3	1.272	8	6	460.1-0397-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT		
4.00	.157	12.6	.496	3	6	460.1-0400-012A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K		
4.00	.157	20.6	.811	5	6	460.1-0400-020A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L		
4.00	.157	32.6	1.283	8	6	460.1-0400-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT		
4.05	.159	12.7	.500	3	6	460.1-0405-012A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K		
4.05	.159	20.8	.819	5	6	460.1-0405-020A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L		
4.10	.161	12.9	.508	3	6	460.1-0410-012A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K		
4.10	.161	21.1	.831	5	6	460.1-0410-021A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L		
4.10	.161	33.4	1.315	8	6	460.1-0410-031A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT		
4.20	.165	13.2	.520	3	6	460.1-0420-013A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K		
4.20	.165	21.6	.850	5	6	460.1-0420-021A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L		
4.20	.165	34.2	1.346	8	6	460.1-0420-032A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT		
4.22	.																										

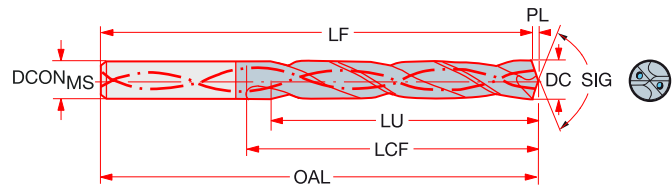
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



							P	M	K	N	S	H	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG	
4.30	.169	13.5	.531	3	6	460.1-0430-013A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K	
4.30	.169	22.1	.870	5	6	460.1-0430-022A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L	
4.30	.169	35.0	1.378	8	6	460.1-0430-032A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT	
4.37	.172	13.7	.539	3	6	460.1-0437-013A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K	
4.37	.172	22.5	.886	5	6	460.1-0437-022A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L	
4.37	.172	35.6	1.402	8	6	460.1-0437-033A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT	
4.40	.173	13.8	.543	3	6	460.1-0440-013A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K	
4.40	.173	22.6	.890	5	6	460.1-0440-022A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L	
4.50	.177	14.2	.559	3	6	460.1-0450-014A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K	
4.50	.177	23.2	.913	5	6	460.1-0450-023A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L	
4.50	.177	36.7	1.445	8	6	460.1-0450-034A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	20	290	COROMANT	
4.60	.181	14.5	.571	3	6	460.1-0460-014A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K	
4.60	.181	23.7	.933	5	6	460.1-0460-023A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L	
4.60	.181	37.5	1.476	8	6	460.1-0460-035A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	20	290	COROMANT	
4.70	.185	14.6	.575	3	6	460.1-0470-014A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K	
4.70	.185	24.2	.953	5	6	460.1-0470-024A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L	
4.70	.185	38.3	1.508	8	6	460.1-0470-035A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	20	290	COROMANT	
4.76	.187	15.0	.591	3	6	460.1-0476-014A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
4.76	.187	24.5	.965	5	6	460.1-0476-024A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L	
4.76	.187	38.8	1.528	8	6	460.1-0476-036A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	20	290	COROMANT	
4.80	.189	15.1	.594	3	6	460.1-0480-014A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
4.80	.189	24.7	.972	5	6	460.1-0480-024A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L	
4.80	.189	39.1	1.539	8	6	460.1-0480-036A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	20	290	COROMANT	
4.85	.191	25.0	.984	5	6	460.1-0485-024A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L	
4.90	.193	15.4	.606	3	6	460.1-0490-015A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
4.90	.193	25.2	.992	5	6	460.1-0490-025A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L	
5.00	.197	15.7	.618	3	6	460.1-0500-015A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
5.00	.197	25.7	1.012	5	6	460.1-0500-025A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L	
5.00	.197	40.7	1.602	8	6	460.1-0500-038A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	20	290	COROMANT	
5.05	.199	15.9	.626	3	6	460.1-0505-015A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
5.05	.199	26.0	1.024	5	6	460.1-0505-025A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L	
5.10	.201	16.0	.630	3	6	460.1-0510-015A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
5.10	.201	26.2	1.032	5	6	460.1-0510-026A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L	
5.10	.201	41.5	1.634	8	6	460.1-0510-038A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	20	290	COROMANT	
5.16	.203	16.2	.638	3	6	460.1-0516-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K	
5.16	.203	26.5	1.043	5	6	460.1-0516-026A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L	
5.16	.203	42.0	1.654	8	6	460.1-0516-039A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT	
5.20	.205	16.4	.646	3	6	460.1-0520-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K	
5.20	.205	26.8	1.055	5	6	460.1-0520-026A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L	
5.20	.205	42.4	1.669	8	6	460.1-0520-039A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT	
5.25	.207	27.0	1.063	5	6	460.1-0525-026A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L	
5.31	.209	27.3	1.075	5	6	460.1-0531-027A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L	
5.41	.213	27.8	1.094	5	6	460.1-0541-027A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L	
5.50	.217	17.3	.681	3	6	460.1-0550-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K	
5.50	.217	28.3	1.114	5	6	460.1-0550-028A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L	
5.50	.217	44.8	1.764	8	6	460.1-0550-041A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT	
5.56	.219	17.5	.689	3	6	460.1-0556-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K	
5.56	.219	28.6	1.126	5	6	460.1-0556-028A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L	
5.56	.219	45.3	1.783	8	6	460.1-0556-042A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT	
5.60	.220	17.6	.693	3	6	460.1-0560-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102						

Schnittdaten: www.sandvik.coromant.com



E9



E28



E14



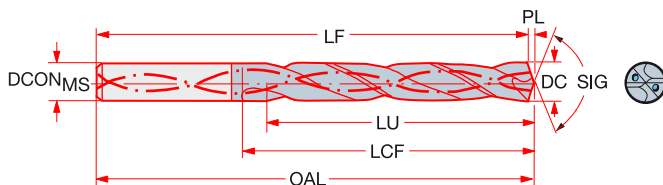
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



B

C

D

E

							P	M	K	N	S	H	Abmessungen, mm, Zoll														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34		DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG		
5.70	.224	17.7	.697	3	6	460.1-0570-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K		
5.70	.224	29.3	1.154	5	6	460.1-0570-029A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L		
5.70	.224	46.4	1.827	8	6	460.1-0570-043A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT		
5.75	.226	29.6	1.165	5	6	460.1-0575-029A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L		
5.80	.228	17.6	.693	3	6	460.1-0580-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K		
5.80	.228	29.9	1.177	5	6	460.1-0580-029A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L		
5.80	.228	47.3	1.862	8	6	460.1-0580-044A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	20	290	COROMANT		
5.90	.232	30.4	1.197	5	6	460.1-0590-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L		
5.95	.234	17.3	.681	2	6	460.1-0595-018A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K		
5.95	.234	30.6	1.205	5	6	460.1-0595-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L		
5.95	.234	48.5	1.909	8	6	460.1-0595-045A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	20	290	COROMANT		
6.00	.236	18.9	.744	3	6	460.1-0600-018A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K		
6.00	.236	30.9	1.217	5	6	460.1-0600-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L		
6.00	.236	48.9	1.925	8	6	460.1-0600-045A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	20	290	COROMANT		
6.05	.238	19.0	.748	3	8	460.1-0605-018A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K		
6.05	.238	31.1	1.224	5	8	460.1-0605-030A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L		
6.10	.240	19.2	.756	3	8	460.1-0610-018A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K		
6.10	.240	31.4	1.236	5	8	460.1-0610-031A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L		
6.10	.240	49.7	1.957	8	8	460.1-0610-046A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	20	290	COROMANT		
6.15	.242	31.7	1.248	5	8	460.1-0615-031A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L		
6.20	.244	19.5	.768	3	8	460.1-0620-019A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K		
6.20	.244	31.9	1.256	5	8	460.1-0620-031A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L		
6.20	.244	50.5	1.988	8	8	460.1-0620-047A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	20	290	COROMANT		
6.25	.246	32.2	1.268	5	8	460.1-0625-031A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L		
6.30	.248	19.8	.780	3	8	460.1-0630-019A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K		
6.30	.248	32.4	1.276	5	8	460.1-0630-032A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L		
6.35	.250	20.0	.787	3	8	460.1-0635-019A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K		
6.35	.250	32.7	1.287	5	8	460.1-0635-032A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L		
6.35	.250	51.7	2.035	8	8	460.1-0635-048A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	20	290	COROMANT		
6.40	.252	20.1	.791	3	8	460.1-0640-019A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K		
6.40	.252	32.9	1.295	5	8	460.1-0640-032A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L		
6.50	.256	20.5	.807	3	8	460.1-0650-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K		
6.50	.256	33.5	1.319	5	8	460.1-0650-033A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
6.50	.256	53.0	2.087	8	8	460.1-0650-049A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT		
6.53	.257	33.6	1.323	5	8	460.1-0653-033A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
6.60	.260	20.8	.819	3	8	460.1-0660-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K		
6.60	.260	34.0	1.339	5	8	460.1-0660-033A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
6.60	.260	53.8	2.118	8	8	460.1-0660-050A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT		
6.70	.264	21.1	.831	3	8	460.1-0670-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K		
6.70	.264	34.5	1.358	5	8	460.1-0670-034A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
6.70	.264	54.6	2.150	8	8	460.1-0670-050A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT		
6.75	.266	21.2	.835	3	8	460.1-0675-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K		
6.75	.266	34.7	1.366	5	8	460.1-0675-034A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
6.75	.266	55.0	2.165	8	8	460.1-0675-051A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT		
6.80	.268	21.4	.843	3	8	460.1-0680-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K		
6.80	.268	35.0	1.378	5	8	460.1-0680-034A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
6.80	.268	55.4	2.181	8	8	460.1-0680-051A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT		
6.85	.270	35.3	1.390	5	8	460.1-0685-034A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
6.90	.272	21.7	.854	3	8	460.1-0690-021A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315													

CoroDrill® 460 Vollhartmetallbohrer

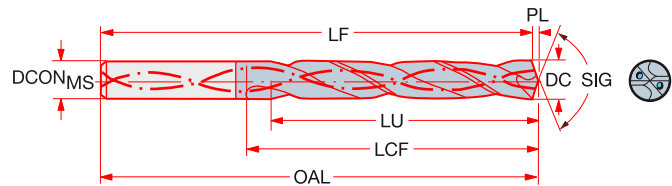
Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr



TCHA
SIG

H9
140°



							P	M	K	N	S	H	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG		
7.00	.276	22.0	.866	3	8	460.1-0700-021A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K		
7.00	.276	36.0	1.417	5	8	460.1-0700-035A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
7.00	.276	57.0	2.244	8	8	460.1-0700-053A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT		
7.04	.277	36.2	1.425	5	8	460.1-0704-035A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
7.10	.280	22.3	.878	3	8	460.1-0710-021A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K		
7.10	.280	36.5	1.437	5	8	460.1-0710-036A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L		
7.14	.281	22.5	.886	3	8	460.1-0714-021A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K		
7.14	.281	36.8	1.449	5	8	460.1-0714-036A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.14	.281	58.2	2.291	8	8	460.1-0714-054A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT		
7.20	.283	37.1	1.461	5	8	460.1-0720-036A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.20	.283	58.7	2.311	8	8	460.1-0720-054A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT		
7.30	.287	23.0	.906	3	8	460.1-0730-022A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K		
7.30	.287	37.6	1.480	5	8	460.1-0730-037A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.40	.291	23.3	.917	3	8	460.1-0740-022A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K		
7.40	.291	38.1	1.500	5	8	460.1-0740-037A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.40	.291	60.3	2.374	8	8	460.1-0740-056A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT		
7.45	.293	38.3	1.508	5	8	460.1-0745-037A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.50	.295	23.6	.929	3	8	460.1-0750-023A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K		
7.50	.295	38.6	1.520	5	8	460.1-0750-038A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.50	.295	61.1	2.406	8	8	460.1-0750-056A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT		
7.54	.297	23.7	.933	3	8	460.1-0754-023A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K		
7.54	.297	38.8	1.528	5	8	460.1-0754-038A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.60	.299	23.9	.941	3	8	460.1-0760-023A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K		
7.60	.299	39.1	1.539	5	8	460.1-0760-038A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.60	.299	61.9	2.437	8	8	460.1-0760-057A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT		
7.70	.303	24.2	.953	3	8	460.1-0770-023A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K		
7.70	.303	39.6	1.559	5	8	460.1-0770-039A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L		
7.70	.303	62.7	2.469	8	8	460.1-0770-058A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT		
7.80	.307	24.6	.969	3	8	460.1-0780-023A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K		
7.80	.307	40.2	1.583	5	8	460.1-0780-039A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L		
7.80	.307	63.6	2.504	8	8	460.1-0780-059A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	20	290	COROMANT		
7.90	.311	24.9	.980	3	8	460.1-0790-024A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K		
7.90	.311	40.7	1.602	5	8	460.1-0790-040A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L		
7.94	.313	25.0	.984	3	8	460.1-0794-024A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K		
7.94	.313	40.9	1.610	5	8	460.1-0794-040A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L		
7.94	.313	64.7	2.547	8	8	460.1-0794-060A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	20	290	COROMANT		
8.00	.315	25.2	.992	3	8	460.1-0800-024A1-XM	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K		
8.00	.315	41.2	1.622	5	8	460.1-0800-040A1-XM	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L		
8.00	.315	65.2	2.567	8	8	460.1-0800-060A1-XM	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	20	290	COROMANT		
8.03	.316	41.3	1.626	5	10	460.1-0803-040A1-XM	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.05	.317	25.3	.996	3	10	460.1-0805-024A1-XM	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K		
8.05	.317	41.4	1.630	5	10	460.1-0805-040A1-XM	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.10	.319	25.5	1.004	3	10	460.1-0810-024A1-XM	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K		
8.10	.319	41.7	1.642	5	10	460.1-0810-041A1-XM	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.10	.319	66.0	2.598	8	10	460.1-0810-061A1-XM	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	20	290	COROMANT		
8.15	.321	42.0	1.654	5	10	460.1-0815-041A1-XM	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.20	.323	25.8	1.016	3	10	460.1-0820-025A1-XM	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K		
8.20	.323	42.2	1.661	5	10	460.1-0820-041A1-XM	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.20	.323	66.8	2.630	8	10	460.1-0820-062A1-XM	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	20	290	COROMANT		
8.25	.325	42.5	1.673	5	10	460.1-0825-041A1-XM	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.30	.327	42.7	1.681	5	10	460.1-0830-042A1-XM	☆	☆	☆</																	

Schnittdaten: www.sandvik.coromant.com



E9



E28



E14



CoroDrill® 460 Vollhartmetallbohrer

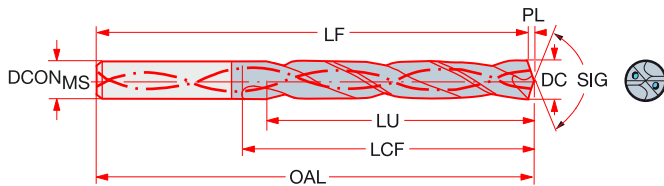
Für Multimaterial-Anwendungen
Innere Kühlschmierstoffzufuhr

B



TCHA
SIG

H9
140°



C

D

E

							P	M	K	N	S	H	Abmessungen, mm, Zoll														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG		
8.33	.328	26.2	1.032	3	10	460.1-0833-025A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K		
8.33	.328	42.9	1.689	5	10	460.1-0833-042A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.33	.328	67.9	2.673	8	10	460.1-0833-062A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	20	290	COROMANT		
8.40	.331	26.4	1.039	3	10	460.1-0840-025A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K		
8.40	.331	43.2	1.701	5	10	460.1-0840-042A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.40	.331	68.4	2.693	8	10	460.1-0840-063A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	20	290	COROMANT		
8.43	.332	43.4	1.709	5	10	460.1-0843-042A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L		
8.50	.335	26.8	1.055	3	10	460.1-0850-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
8.50	.335	43.8	1.724	5	10	460.1-0850-043A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.50	.335	69.3	2.728	8	10	460.1-0850-064A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT		
8.55	.337	44.0	1.732	5	10	460.1-0855-043A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.60	.339	27.1	1.067	3	10	460.1-0860-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
8.60	.339	44.3	1.744	5	10	460.1-0860-043A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.60	.339	70.1	2.760	8	10	460.1-0860-065A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT		
8.70	.343	27.4	1.079	3	10	460.1-0870-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
8.70	.343	44.8	1.764	5	10	460.1-0870-044A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.70	.343	70.9	2.791	8	10	460.1-0870-065A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT		
8.73	.344	27.5	1.083	3	10	460.1-0873-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
8.73	.344	44.9	1.768	5	10	460.1-0873-044A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.73	.344	71.1	2.799	8	10	460.1-0873-065A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT		
8.80	.346	27.7	1.091	3	10	460.1-0880-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
8.80	.346	45.3	1.783	5	10	460.1-0880-044A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.80	.346	71.7	2.823	8	10	460.1-0880-066A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT		
8.84	.348	45.5	1.791	5	10	460.1-0884-044A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.90	.350	28.0	1.102	3	10	460.1-0890-027A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
8.90	.350	45.8	1.803	5	10	460.1-0890-045A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
9.00	.354	28.3	1.114	3	10	460.1-0900-027A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
9.00	.354	46.3	1.823	5	10	460.1-0900-045A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
9.00	.354	73.3	2.886	8	10	460.1-0900-068A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT		
9.10	.358	28.6	1.126	3	10	460.1-0910-027A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
9.10	.358	46.8	1.843	5	10	460.1-0910-046A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
9.13	.359	28.7	1.130	3	10	460.1-0913-027A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
9.13	.359	47.0	1.850	5	10	460.1-0913-046A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
9.13	.359	74.4	2.929	8	10	460.1-0913-068A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	20	290	COROMANT		
9.20	.362	47.4	1.866	5	10	460.1-0920-046A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
9.30	.366	29.3	1.154	3	10	460.1-0930-028A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
9.30	.366	47.9	1.886	5	10	460.1-0930-047A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
9.30	.366	75.8	2.984	8	10	460.1-0930-070A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	20	290	COROMANT		
9.35	.368	48.1	1.894	5	10	460.1-0935-047A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
9.40	.370	29.6	1.165	3	10	460.1-0940-028A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
9.40	.370	48.4	1.906	5	10	460.1-0940-047A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
9.50	.374	29.9	1.177	3	10	460.1-0950-029A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
9.50	.374	48.7	1.917	5	10	460.1-0950-048A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
9.50	.374	77.4	3.047	8	10	460.1-0950-071A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	20	290	COROMANT		
9.53	.375	30.0	1.181	3	10	460.1-0953-029A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
9.53	.375	48.6	1.913	5	10	460.1-0953-048A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
9.53	.375	77.6	3.055	8	10	460.1-0953-071A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	20	290	COROMANT		
9.60	.378	30.2	1.189	3	10	460.1-0960-029A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47								

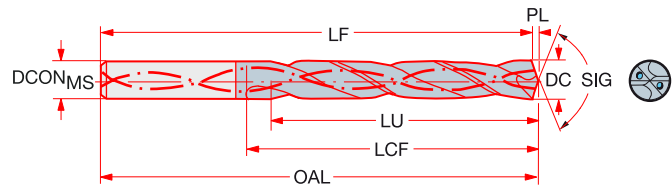
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



							P	M	K	N	S	H	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG	
9.80	.386	30.9	1.217	3	10	460.1-0980-029A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.80	.386	48.3	1.902	4	10	460.1-0980-049A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.80	.386	79.9	3.146	8	10	460.1-0980-074A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	20	290	COROMANT	
9.90	.390	31.2	1.228	3	10	460.1-0990-030A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.90	.390	48.1	1.894	4	10	460.1-0990-050A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.90	.390	80.7	3.177	8	10	460.1-0990-074A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	20	290	COROMANT	
9.92	.391	31.2	1.228	3	10	460.1-0992-030A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.92	.391	48.1	1.894	4	10	460.1-0992-050A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.92	.391	80.8	3.181	8	10	460.1-0992-074A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	20	290	COROMANT	
10.00	.394	31.5	1.240	3	10	460.1-1000-030A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
10.00	.394	48.0	1.890	4	10	460.1-1000-050A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
10.00	.394	81.5	3.209	8	10	460.1-1000-075A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	20	290	COROMANT	
10.05	.396	31.6	1.244	3	12	460.1-1005-030A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
10.05	.396	51.7	2.035	5	12	460.1-1005-050A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L	
10.10	.398	31.8	1.252	3	12	460.1-1010-030A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
10.10	.398	52.0	2.047	5	12	460.1-1010-051A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L	
10.20	.402	32.1	1.264	3	12	460.1-1020-031A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
10.20	.402	52.5	2.067	5	12	460.1-1020-051A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L	
10.20	.402	83.1	3.272	8	12	460.1-1020-077A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	20	290	COROMANT	
10.26	.404	52.8	2.079	5	12	460.1-1026-051A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L	
10.30	.406	32.4	1.276	3	12	460.1-1030-031A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
10.30	.406	53.0	2.087	5	12	460.1-1030-052A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L	
10.30	.406	83.9	3.303	8	12	460.1-1030-077A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	20	290	COROMANT	
10.32	.406	32.5	1.280	3	12	460.1-1032-031A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
10.32	.406	53.1	2.091	5	12	460.1-1032-052A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L	
10.32	.406	84.1	3.311	8	12	460.1-1032-077A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	20	290	COROMANT	
10.40	.409	32.7	1.287	3	12	460.1-1040-031A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
10.40	.409	53.5	2.106	5	12	460.1-1040-052A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L	
10.40	.409	84.7	3.335	8	12	460.1-1040-078A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	20	290	COROMANT	
10.50	.413	33.1	1.303	3	12	460.1-1050-032A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K	
10.50	.413	54.1	2.130	5	12	460.1-1050-053A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L	
10.50	.413	85.6	3.370	8	12	460.1-1050-079A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	20	290	COROMANT	
10.60	.417	33.4	1.315	3	12	460.1-1060-032A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K	
10.60	.417	54.6	2.150	5	12	460.1-1060-053A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L	
10.70	.421	55.1	2.169	5	12	460.1-1070-054A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L	
10.72	.422	33.7	1.327	3	12	460.1-1072-032A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K	
10.72	.422	55.2	2.173	5	12	460.1-1072-054A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L	
10.72	.422	87.3	3.437	8	12	460.1-1072-080A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	20	290	COROMANT	
10.75	.423	55.3	2.177	5	12	460.1-1075-054A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L	
10.90	.429	56.1	2.209	5	12	460.1-1090-055A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L	
11.00	.433	34.6	1.362	3	12	460.1-1100-033A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K	
11.00	.433	56.6	2.228	5	12	460.1-1100-055A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L	
11.00	.433	89.6	3.528	8	12	460.1-1100-083A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	20	290	COROMANT	
11.11	.437	35.0	1.378	3	12	460.1-1111-033A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K	
11.11	.437	57.2	2.252	5	12	460.1-1111-056A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	
11.11	.437	90.5	3.563	8	12	460.1-1111-083A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	20	290	COROMANT	
11.20	.441	35.3	1.390	3	12	460.1-1120-0																				

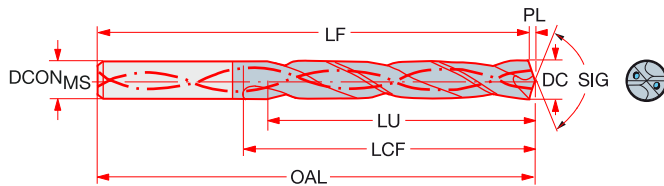
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



B

C

D

E

							P	M	K	N	S	H	Abmessungen, mm, Zoll													
							GC34	GC34	GC34	GC34	GC34	GC34														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG		
11.50	.453	36.2	1.425	3	12	460.1-1150-035A1-XM	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K		
11.50	.453	57.2	2.252	4	12	460.1-1150-058A1-XM	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L		
11.50	.453	93.7	3.689	8	12	460.1-1150-086A1-XM	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	20	290	COROMANT		
11.51	.453	36.2	1.425	3	12	460.1-1151-035A1-XM	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K		
11.51	.453	57.2	2.252	4	12	460.1-1151-058A1-XM	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L		
11.51	.453	93.8	3.693	8	12	460.1-1151-086A1-XM	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	20	290	COROMANT		
11.60	.457	36.5	1.437	3	12	460.1-1160-035A1-XM	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K		
11.60	.457	57.1	2.248	4	12	460.1-1160-058A1-XM	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L		
11.70	.461	57.0	2.244	4	12	460.1-1170-059A1-XM	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L		
11.80	.465	37.2	1.465	3	12	460.1-1180-035A1-XM	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K		
11.80	.465	56.8	2.236	4	12	460.1-1180-059A1-XM	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L		
11.80	.465	96.2	3.787	8	12	460.1-1180-089A1-XM	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	20	290	COROMANT		
11.91	.469	37.5	1.476	3	12	460.1-1191-036A1-XM	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K		
11.91	.469	56.7	2.232	4	12	460.1-1191-060A1-XM	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L		
11.91	.469	97.0	3.819	8	12	460.1-1191-089A1-XM	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	20	290	COROMANT		
12.00	.472	37.8	1.488	3	12	460.1-1200-036A1-XM	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K		
12.00	.472	56.6	2.228	4	12	460.1-1200-060A1-XM	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L		
12.00	.472	97.8	3.850	8	12	460.1-1200-090A1-XM	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	20	290	COROMANT		
12.05	.474	37.9	1.492	3	14	460.1-1205-036A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K		
12.05	.474	62.0	2.441	5	14	460.1-1205-060A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L		
12.10	.476	38.1	1.500	3	14	460.1-1210-036A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K		
12.20	.480	38.4	1.512	3	14	460.1-1220-037A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K		
12.20	.480	62.4	2.457	5	14	460.1-1220-061A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L		
12.20	.480	99.4	3.913	8	14	460.1-1220-092A1-XM	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.2	7.882	151	5.945	1.8	.071	20	290	COROMANT		
12.25	.482	62.3	2.453	5	14	460.1-1225-061A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L		
12.30	.484	38.7	1.524	3	14	460.1-1230-037A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K		
12.30	.484	62.2	2.449	5	14	460.1-1230-062A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L		
12.30	.484	100.3	3.949	8	14	460.1-1230-092A1-XM	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.2	7.882	151	5.945	1.8	.071	20	290	COROMANT		
12.40	.488	62.1	2.445	5	14	460.1-1240-062A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L		
12.50	.492	39.4	1.551	3	14	460.1-1250-038A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K		
12.50	.492	62.0	2.441	4	14	460.1-1250-063A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L		
12.50	.492	101.9	4.012	8	14	460.1-1250-094A1-XM	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	20	290	COROMANT		
12.60	.496	61.9	2.437	4	14	460.1-1260-063A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L		
12.70	.500	40.0	1.575	3	14	460.1-1270-038A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K		
12.70	.500	61.8	2.433	4	14	460.1-1270-064A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L		
12.70	.500	103.5	4.075	8	14	460.1-1270-095A1-XM	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	20	290	COROMANT		
12.80	.504	40.3	1.587	3	14	460.1-1280-038A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K		
12.80	.504	61.6	2.425	4	14	460.1-1280-064A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L		
12.80	.504	104.3	4.106	8	14	460.1-1280-096A1-XM	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	20	290	COROMANT		
12.90	.508	61.5	2.421	4	14	460.1-1290-065A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L		
13.00	.512	40.9	1.610	3	14	460.1-1300-039A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K		
13.00	.512	61.4	2.417	4	14	460.1-1300-065A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L		
13.00	.512	105.9	4.169	8	14	460.1-1300-098A1-XM	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	20	290	COROMANT		
13.10	.516	41.2	1.622	3	14	460.1-1310-039A1-XM	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K		
13.10	.516	61.3	2.413	4	14	460.1-1310-066A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L		
13.10	.516	106.7	4.201	8	14	460.1-1310-098A1-XM	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	20	290	COROMANT		
13.25	.522	61.1	2.406	4	14	460.1-1325-066A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L		
13.40	.528	60.9	2.398	4	14	460.1-1340-067A1-XM	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L		

Schnittdaten: www.sandvik.coromant.com



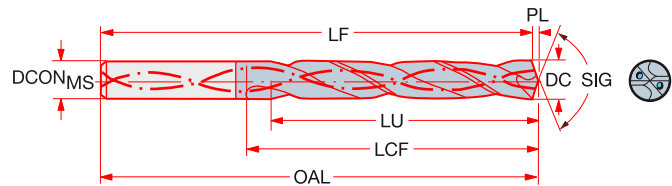
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



							P	M	K	N	S	H	Abmessungen, mm, Zoll														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG		
13.49	.531	42.5	1.673	3	14	460.1-1349-041A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K		
13.49	.531	60.8	2.394	4	14	460.1-1349-061A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L		
13.49	.531	110.0	4.331	8	14	460.1-1349-101A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	20	290	COROMANT		
13.50	.531	42.5	1.673	3	14	460.1-1350-041A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K		
13.50	.531	60.8	2.394	4	14	460.1-1350-061A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L		
13.50	.531	110.0	4.331	8	14	460.1-1350-101A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	20	290	COROMANT		
13.65	.537	60.6	2.386	4	14	460.1-1365-061A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L		
13.70	.539	111.6	4.394	8	14	460.1-1370-103A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	20	290	COROMANT		
13.80	.543	43.4	1.709	3	14	460.1-1380-041A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K		
13.80	.543	60.4	2.378	4	14	460.1-1380-062A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L		
13.89	.547	43.3	1.705	3	14	460.1-1389-042A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K		
13.89	.547	60.3	2.374	4	14	460.1-1389-063A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L		
14.00	.551	44.1	1.736	3	14	460.1-1400-042A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K		
14.00	.551	63.0	2.480	4	14	460.1-1400-063A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L		
14.00	.551	114.1	4.492	8	14	460.1-1400-105A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	199.9	7.870	151	5.945	2.1	.083	20	290	COROMANT		
14.10	.555	68.9	2.713	4	16	460.1-1410-063A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	20	290	DIN 6537 L		
14.20	.559	115.7	4.555	8	16	460.1-1420-107A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	20	290	COROMANT		
14.25	.561	44.9	1.768	3	16	460.1-1425-043A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	20	290	DIN 6537 K		
14.25	.561	68.8	2.709	4	16	460.1-1425-071A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	20	290	DIN 6537 L		
14.25	.561	116.1	4.571	8	16	460.1-1425-107A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	20	290	COROMANT		
14.29	.563	45.0	1.772	3	16	460.1-1429-043A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	20	290	DIN 6537 K		
14.29	.563	68.7	2.705	4	16	460.1-1429-072A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	20	290	DIN 6537 L		
14.29	.563	116.4	4.583	8	16	460.1-1429-107A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	20	290	COROMANT		
14.30	.563	68.7	2.705	4	16	460.1-1430-072A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	20	290	DIN 6537 L		
14.50	.571	45.7	1.799	3	16	460.1-1450-044A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K		
14.50	.571	68.5	2.697	4	16	460.1-1450-073A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L		
14.50	.571	118.2	4.654	8	16	460.1-1450-109A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	20	290	COROMANT		
14.60	.575	68.4	2.693	4	16	460.1-1460-073A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L		
14.68	.578	46.2	1.819	3	16	460.1-1468-044A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K		
14.68	.578	68.3	2.689	4	16	460.1-1468-073A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L		
14.70	.579	119.8	4.717	8	16	460.1-1470-110A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	20	290	COROMANT		
14.75	.581	68.3	2.689	4	16	460.1-1475-066A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L		
14.80	.583	46.6	1.835	3	16	460.1-1480-044A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K		
14.80	.583	68.2	2.685	4	16	460.1-1480-067A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L		
15.00	.591	47.2	1.858	3	16	460.1-1500-045A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K		
15.00	.591	68.0	2.677	4	16	460.1-1500-068A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L		
15.00	.591	122.2	4.811	8	16	460.1-1500-113A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	20	290	COROMANT		
15.08	.594	47.5	1.870	3	16	460.1-1508-045A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K		
15.08	.594	67.9	2.673	4	16	460.1-1508-068A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L		
15.08	.594	122.9	4.839	8	16	460.1-1508-113A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	20	290	COROMANT		
15.10	.594	47.6	1.874	3	16	460.1-1510-045A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K		
15.10	.594	67.9	2.673	4	16	460.1-1510-068A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L		
15.10	.594	123.1	4.846	8	16	460.1-1510-113A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.7	8.846	172	6.772	2.3	.091	20	290	COROMANT		
15.25	.600	67.8	2.669	4	16	460.1-1525-069A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L		
15.30	.602	67.7	2.665	4	16	460.1-1530-069A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L		
15.50	.610	48.8	1.921	3	16	460.1-1550-047A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN		

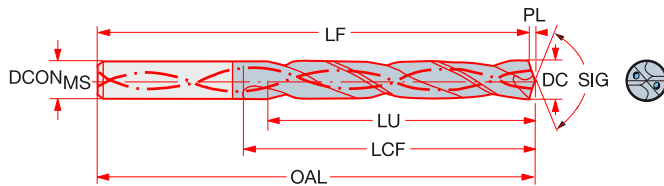
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



B

C

D

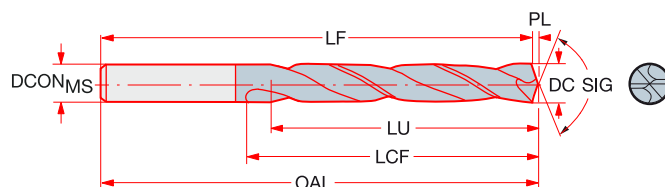
E

											Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG
15.88	.625	49.1	1.933	3	16	460.1-1588-048A1-XM	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	20	290	DIN 6537 K
15.88	.625	67.1	2.642	4	16	460.1-1588-071A1-XM	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L
15.88	.625	129.4	5.094	8	16	460.1-1588-119A1-XM	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.6	8.843	172	6.772	2.4	.094	20	290	COROMANT
16.00	.630	49.0	1.929	3	16	460.1-1600-048A1-XM	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	20	290	DIN 6537 K
16.00	.630	67.0	2.638	4	16	460.1-1600-072A1-XM	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L
16.00	.630	130.4	5.134	8	16	460.1-1600-120A1-XM	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.6	8.843	172	6.772	2.4	.094	20	290	COROMANT
16.10	.634	76.9	3.028	4	18	460.1-1610-072A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	20	290	DIN 6537 L
16.27	.641	51.2	2.016	3	18	460.1-1627-049A1-XM	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.6	4.748	73	2.874	2.4	.094	20	290	DIN 6537 K
16.27	.641	76.7	3.020	4	18	460.1-1627-081A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	20	290	DIN 6537 L
16.50	.650	52.0	2.047	3	18	460.1-1650-050A1-XM	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	20	290	DIN 6537 K
16.50	.650	76.5	3.012	4	18	460.1-1650-074A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
16.67	.656	52.5	2.067	3	18	460.1-1667-050A1-XM	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	20	290	DIN 6537 K
16.67	.656	76.3	3.004	4	18	460.1-1667-075A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
16.80	.661	76.2	3.000	4	18	460.1-1680-076A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
17.00	.669	53.5	2.106	3	18	460.1-1700-051A1-XM	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	20	290	DIN 6537 K
17.00	.669	76.0	2.992	4	18	460.1-1700-077A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
17.00	.669	138.5	5.453	8	18	460.1-1700-128A1-XM	☆	☆	☆	☆	☆	18.0	.709	246	9.685	243.5	9.587	194	7.638	2.5	.098	20	290	COROMANT
17.07	.672	53.7	2.114	3	18	460.1-1707-051A1-XM	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	20	290	DIN 6537 K
17.07	.672	75.9	2.988	4	18	460.1-1707-077A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
17.46	.687	75.5	2.972	4	18	460.1-1746-079A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	20	290	DIN 6537 L
17.50	.689	55.1	2.169	3	18	460.1-1750-053A1-XM	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	20	290	DIN 6537 K
17.50	.689	75.5	2.972	4	18	460.1-1750-079A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	20	290	DIN 6537 L
17.50	.689	142.6	5.614	8	18	460.1-1750-131A1-XM	☆	☆	☆	☆	☆	18.0	.709	246	9.685	243.4	9.583	194	7.638	2.6	.102	20	290	COROMANT
17.80	.701	75.2	2.961	4	18	460.1-1780-080A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	20	290	DIN 6537 L
17.86	.703	55.1	2.169	3	18	460.1-1786-054A1-XM	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	20	290	DIN 6537 K
18.00	.709	56.7	2.232	3	18	460.1-1800-054A1-XM	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	20	290	DIN 6537 K
18.00	.709	78.6	3.094	4	18	460.1-1800-081A1-XM	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	20	290	DIN 6537 L
18.00	.709	146.7	5.776	8	18	460.1-1800-135A1-XM	☆	☆	☆	☆	☆	18.0	.709	246	9.685	243.3	9.579	194	7.638	2.7	.106	20	290	COROMANT
18.26	.719	57.5	2.264	3	20	460.1-1826-055A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.3	5.051	79	3.110	2.7	.106	20	290	DIN 6537 K
18.26	.719	86.4	3.402	4	20	460.1-1826-082A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.3	5.917	101	3.976	2.7	.106	20	290	DIN 6537 L
18.50	.728	58.3	2.295	3	20	460.1-1850-056A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
18.50	.728	86.2	3.394	4	20	460.1-1850-083A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	20	290	DIN 6537 L
18.65	.734	58.7	2.311	3	20	460.1-1865-056A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
18.65	.734	86.1	3.390	4	20	460.1-1865-084A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	20	290	DIN 6537 L
18.80	.740	59.2	2.331	3	20	460.1-1880-056A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
19.00	.748	59.8	2.354	3	20	460.1-1900-057A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
19.00	.748	85.8	3.378	4	20	460.1-1900-086A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	20	290	DIN 6537 L
19.00	.748	154.8	6.094	8	20	460.1-1900-143A1-XM	☆	☆	☆	☆	☆	20.0	.787	269	10.591	266.2	10.480	215	8.465	2.8	.110	20	290	COROMANT
19.05	.750	60.0	2.362	3	20	460.1-1905-057A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
19.05	.750	85.8	3.378	4	20	460.1-1905-086A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	20	290	DIN 6537 L
19.25	.758	85.6	3.370	4	20	460.1-1925-087A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	20	290	DIN 6537 L
19.50	.768	61.4	2.417	3	20	460.1-1950-059A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	20	290	DIN 6537 K
19.50	.768	85.4	3.362	4	20	460.1-1950-088A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	20	290	DIN 6537 L
19.50	.768	158.9	6.256	8	20	460.1-1950-146A1-XM	☆	☆	☆	☆	☆	20.0	.787	269	10.591	266.1	10.476	215	8.465	2.9	.114	20	290	COROMANT
19.80	.780	62.4	2.457	3	20	460.1-1980-059A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	20	290	DIN 6537 K
19.80	.780	85.2	3.354	4	20	460.1-1980-089A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	20	290	DIN 6537 L
20.00	.787	63.0	2.480	3	20	460.1-2000-060A1-XM	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	20	290	DIN 6537 K
20.00	.787	85.0	3.346	4	20	460.1-2000-090A1-XM	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	20	290	DIN 6537 L
20.00	.787	163.0	6.417	8	20	460.1-2000-150A1-XM	☆	☆	☆	☆	☆	20.0	.787	269	10.591	266.0	10.472	215	8.465	3.0	.118	20	290	COROMANT

CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Äußere Kühlschmierstoffzufuhr

TCHA
SIGH9
140°

							P	M	K	N	S	H	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BSG		
3.00	.118	9.4	.370	3	6	460.1-0300-009A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	DIN 6537 K		
3.00	.118	15.4	.606	5	6	460.1-0300-015A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L		
3.10	.122	9.7	.382	3	6	460.1-0310-009A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	DIN 6537 K		
3.10	.122	15.9	.626	5	6	460.1-0310-016A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L		
3.18	.125	10.0	.394	3	6	460.1-0318-010A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K		
3.18	.125	16.3	.642	5	6	460.1-0318-016A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L		
3.20	.126	10.1	.398	3	6	460.1-0320-010A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K		
3.20	.126	16.5	.650	5	6	460.1-0320-016A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L		
3.30	.130	10.4	.409	3	6	460.1-0330-010A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K		
3.30	.130	17.0	.669	5	6	460.1-0330-017A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L		
3.40	.134	10.7	.421	3	6	460.1-0340-010A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K		
3.40	.134	17.5	.689	5	6	460.1-0340-017A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L		
3.50	.138	11.0	.433	3	6	460.1-0350-011A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K		
3.50	.138	18.0	.709	5	6	460.1-0350-018A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L		
3.57	.141	11.2	.441	3	6	460.1-0357-011A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K		
3.60	.142	11.3	.445	3	6	460.1-0360-011A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K		
3.70	.146	11.6	.457	3	6	460.1-0370-011A0-XM	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K		
3.70	.146	19.0	.748	5	6	460.1-0370-019A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L		
3.80	.150	11.9	.469	3	6	460.1-0380-011A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	DIN 6537 K		
3.80	.150	19.5	.768	5	6	460.1-0380-019A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.5	2.894	36	1.417	0.5	.020	DIN 6537 L		
3.90	.154	12.3	.484	3	6	460.1-0390-012A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K		
3.97	.156	12.5	.492	3	6	460.1-0397-012A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K		
3.97	.156	20.4	.803	5	6	460.1-0397-020A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L		
4.00	.157	12.6	.496	3	6	460.1-0400-012A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K		
4.00	.157	20.6	.811	5	6	460.1-0400-020A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L		
4.10	.161	12.9	.508	3	6	460.1-0410-012A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K		
4.10	.161	21.1	.831	5	6	460.1-0410-021A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L		
4.20	.165	13.2	.520	3	6	460.1-0420-013A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K		
4.20	.165	21.6	.850	5	6	460.1-0420-021A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L		
4.30	.169	13.5	.531	3	6	460.1-0430-013A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K		
4.30	.169	22.1	.870	5	6	460.1-0430-022A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L		
4.37	.172	13.7	.539	3	6	460.1-0437-013A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K		
4.37	.172	22.5	.886	5	6	460.1-0437-022A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L		
4.40	.173	13.8	.543	3	6	460.1-0440-013A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K		
4.40	.173	22.6	.890	5	6	460.1-0440-022A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L		
4.50	.177	14.2	.559	3	6	460.1-0450-014A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K		
4.50	.177	23.2	.913	5	6	460.1-0450-023A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L		
4.60	.181	14.5	.571	3	6	460.1-0460-014A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K		
4.60	.181	23.7	.933	5	6	460.1-0460-023A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L		
4.70	.185	14.6	.575	3	6	460.1-0470-014A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K		
4.70	.185	24.2	.953	5	6	460.1-0470-024A0-XM	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L		
4.76	.187	15.0	.591	3	6	460.1-0476-014A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K		
4.76	.187	24.5	.965	5	6	460.1-0476-024A0-XM	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L		
4.80	.189	15.1	.594	3	6	460.1-0480-014A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K		
4.80	.189	24.7	.972	5	6	460.1-0480-024A0-XM	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L		
4.90	.193	15.4	.606	3	6	460.1-0490-015A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K		
4.90	.193	25.2	.992	5	6	460.1-0490-025A0-XM	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L		
5.00	.197	15.7	.618	3	6	460.1-0500-015A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K		
5.00	.197	25.7	1.012	5	6	460.1-0500-025A0-XM	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L		
5.10	.201	16.0	.630	3	6	460.1-0510-015A0-XM	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K		
5.10	.201	26.2	1.032	5	6	460.1-0510-026A0-XM	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L		

Schnittdaten: www.sandvik.coromant.com

E9



E14



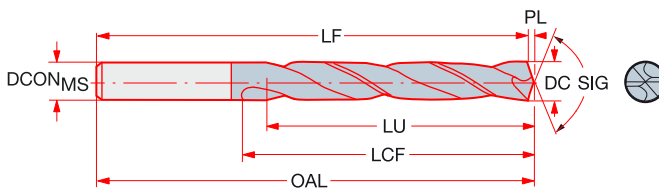
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Äußere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



B

C

D

E

							P	M	K	N	S	H	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34		DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BSG	
5.16	.203	16.2	.638	3	6	460.1-0516-016A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K	
5.16	.203	26.5	1.043	5	6	460.1-0516-026A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L	
5.20	.205	16.4	.646	3	6	460.1-0520-016A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K	
5.20	.205	26.8	1.055	5	6	460.1-0520-026A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L	
5.50	.217	17.3	.681	3	6	460.1-0550-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K	
5.50	.217	28.3	1.114	5	6	460.1-0550-028A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L	
5.56	.219	17.5	.689	3	6	460.1-0556-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K	
5.56	.219	28.6	1.126	5	6	460.1-0556-028A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L	
5.60	.220	17.6	.693	3	6	460.1-0560-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K	
5.60	.220	28.8	1.134	5	6	460.1-0560-028A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L	
5.80	.228	17.6	.693	3	6	460.1-0580-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K	
5.80	.228	29.9	1.177	5	6	460.1-0580-029A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L	
5.95	.234	17.3	.681	2	6	460.1-0595-018A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K	
5.95	.234	30.6	1.205	5	6	460.1-0595-030A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L	
6.00	.236	18.9	.744	3	6	460.1-0600-018A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K	
6.00	.236	30.9	1.217	5	6	460.1-0600-030A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L	
6.10	.240	19.2	.756	3	8	460.1-0610-018A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K	
6.10	.240	31.4	1.236	5	8	460.1-0610-031A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L	
6.20	.244	19.5	.768	3	8	460.1-0620-019A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K	
6.20	.244	31.9	1.256	5	8	460.1-0620-031A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L	
6.30	.248	19.8	.780	3	8	460.1-0630-019A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K	
6.35	.250	20.0	.787	3	8	460.1-0635-019A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K	
6.35	.250	32.7	1.287	5	8	460.1-0635-032A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L	
6.40	.252	20.1	.791	3	8	460.1-0640-019A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K	
6.50	.256	20.5	.807	3	8	460.1-0650-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K	
6.50	.256	33.5	1.319	5	8	460.1-0650-033A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L	
6.60	.260	20.8	.819	3	8	460.1-0660-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K	
6.60	.260	34.0	1.339	5	8	460.1-0660-033A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L	
6.70	.264	21.1	.831	3	8	460.1-0670-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K	
6.70	.264	34.5	1.358	5	8	460.1-0670-034A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L	
6.75	.266	21.2	.835	3	8	460.1-0675-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K	
6.75	.266	34.7	1.366	5	8	460.1-0675-034A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L	
6.80	.268	21.4	.843	3	8	460.1-0680-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K	
6.80	.268	35.0	1.378	5	8	460.1-0680-034A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L	
6.90	.272	21.7	.854	3	8	460.1-0690-021A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K	
6.90	.272	35.5	1.398	5	8	460.1-0690-035A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L	
7.00	.276	22.0	.866	3	8	460.1-0700-021A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K	
7.00	.276	36.0	1.417	5	8	460.1-0700-035A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L	
7.10	.280	22.3	.878	3	8	460.1-0710-021A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	DIN 6537 K	
7.14	.281	22.5	.886	3	8	460.1-0714-021A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K	
7.14	.281	36.8	1.449	5	8	460.1-0714-036A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L	
7.30	.287	23.0	.906	3	8	460.1-0730-022A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K	
7.30	.287	37.6	1.480	5	8	460.1-0730-037A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L	
7.40	.291	23.3	.917	3	8	460.1-0740-022A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K	
7.40	.291	38.1	1.500	5	8	460.1-0740-037A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L	
7.50	.295	23.6	.929	3	8	460.1-0750-023A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K	
7.50	.295	38.6	1.520	5	8	460.1-0750-038A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L	
7.54	.297	23.7	.933	3	8	460.1-0754-023A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K	
7.54	.297	38.8	1.528	5	8	460.1-0754-038A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L	
7.70	.303	24.2	.953	3	8	460.1-0770-023A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K	
7.80	.307	24.6	.969	3	8	460.1-0780-023A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K	
7.80	.307	40.2	1.583	5	8	460.1-0780-039A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L	

Schnittdaten: www.sandvik.coromant.com

E9

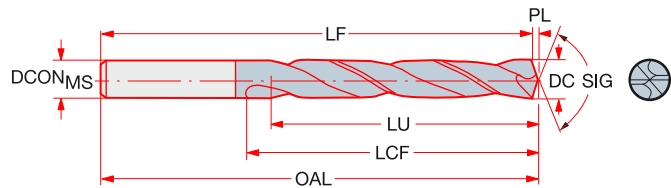
E14



CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Äußere Kühlschmierstoffzufuhr

TCHA
SIGH9
140°

							P	M	K	N	S	H	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BSG	
7.90	.311	24.9	.980	3	8	460.1-0790-024A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K	
7.90	.311	40.7	1.602	5	8	460.1-0790-040A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L	
7.94	.313	25.0	.984	3	8	460.1-0794-024A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K	
7.94	.313	40.9	1.610	5	8	460.1-0794-040A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L	
8.00	.315	25.2	.992	3	8	460.1-0800-024A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K	
8.00	.315	41.2	1.622	5	8	460.1-0800-040A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L	
8.10	.319	25.5	1.004	3	10	460.1-0810-024A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K	
8.10	.319	41.7	1.642	5	10	460.1-0810-041A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L	
8.20	.323	25.8	1.016	3	10	460.1-0820-025A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K	
8.20	.323	42.2	1.661	5	10	460.1-0820-041A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L	
8.33	.328	26.2	1.032	3	10	460.1-0833-025A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K	
8.40	.331	26.4	1.039	3	10	460.1-0840-025A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K	
8.40	.331	43.2	1.701	5	10	460.1-0840-042A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L	
8.50	.335	26.8	1.055	3	10	460.1-0850-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K	
8.50	.335	43.8	1.724	5	10	460.1-0850-043A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L	
8.60	.339	27.1	1.067	3	10	460.1-0860-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K	
8.60	.339	44.3	1.744	5	10	460.1-0860-043A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L	
8.70	.343	27.4	1.079	3	10	460.1-0870-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K	
8.70	.343	44.8	1.764	5	10	460.1-0870-044A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L	
8.73	.344	27.5	1.083	3	10	460.1-0873-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K	
8.73	.344	44.9	1.768	5	10	460.1-0873-044A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L	
8.80	.346	27.7	1.091	3	10	460.1-0880-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K	
8.80	.346	45.3	1.783	5	10	460.1-0880-044A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L	
8.90	.350	45.8	1.803	5	10	460.1-0890-045A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L	
9.00	.354	28.3	1.114	3	10	460.1-0900-027A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K	
9.00	.354	46.3	1.823	5	10	460.1-0900-045A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L	
9.10	.358	46.8	1.843	5	10	460.1-0910-046A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L	
9.30	.366	29.3	1.154	3	10	460.1-0930-028A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K	
9.30	.366	47.9	1.886	5	10	460.1-0930-047A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L	
9.40	.370	29.6	1.165	3	10	460.1-0940-028A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K	
9.40	.370	48.4	1.906	5	10	460.1-0940-047A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L	
9.50	.374	29.9	1.177	3	10	460.1-0950-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K	
9.50	.374	48.7	1.917	5	10	460.1-0950-048A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L	
9.53	.375	30.0	1.181	3	10	460.1-0953-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K	
9.53	.375	48.6	1.913	5	10	460.1-0953-048A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L	
9.60	.378	30.2	1.189	3	10	460.1-0960-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K	
9.60	.378	48.5	1.909	5	10	460.1-0960-048A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L	
9.70	.382	30.5	1.201	3	10	460.1-0970-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K	
9.70	.382	48.4	1.906	4	10	460.1-0970-049A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L	
9.80	.386	30.9	1.217	3	10	460.1-0980-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K	
9.80	.386	48.3	1.902	4	10	460.1-0980-049A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L	
9.92	.391	48.1	1.894	4	10	460.1-0992-050A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L	
10.00	.394	31.5	1.240	3	10	460.1-1000-030A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K	
10.00	.394	48.0	1.890	4	10	460.1-1000-050A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L	
10.10	.398	31.8	1.252	3	12	460.1-1010-030A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K	
10.10	.398	52.0	2.047	5	12	460.1-1010-051A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L	
10.20	.402	32.1	1.264	3	12	460.1-1020-031A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K	
10.20	.402	52.5	2.067	5	12	460.1-1020-051A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L	
10.30	.406	32.4	1.276	3	12	460.1-1030-031A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K	
10.30	.406	53.0	2.087	5	12	460.1-1030-052A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L	
10.32	.406	53.1	2.091	5	12	460.1-1032-052A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L	

Schnittdaten: www.sandvik.coromant.com

E9



E14



CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

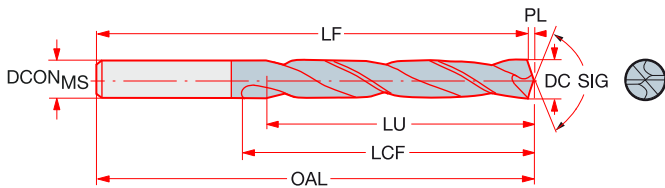
Äußere Kühlschmierstoffzufuhr

B



TCHA
SIG

H9
140°



C

D

E

							P	M	K	N	S	H	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BSG	
10.40	.409	32.7	1.287	3	12	460.1-1040-031A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K	
10.40	.409	53.5	2.106	5	12	460.1-1040-052A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L	
10.50	.413	33.1	1.303	3	12	460.1-1050-032A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K	
10.50	.413	54.1	2.130	5	12	460.1-1050-053A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L	
10.60	.417	33.4	1.315	3	12	460.1-1060-032A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K	
10.72	.422	33.7	1.327	3	12	460.1-1072-032A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K	
10.72	.422	55.2	2.173	5	12	460.1-1072-054A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L	
10.80	.425	34.0	1.339	3	12	460.1-1080-032A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K	
11.00	.433	34.6	1.362	3	12	460.1-1100-033A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K	
11.00	.433	56.6	2.228	5	12	460.1-1100-055A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L	
11.11	.437	35.0	1.378	3	12	460.1-1111-033A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K	
11.11	.437	57.2	2.252	5	12	460.1-1111-056A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L	
11.20	.441	35.3	1.390	3	12	460.1-1120-034A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K	
11.20	.441	57.6	2.268	5	12	460.1-1120-056A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L	
11.40	.449	35.9	1.413	3	12	460.1-1140-034A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K	
11.40	.449	57.3	2.256	5	12	460.1-1140-057A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L	
11.50	.453	36.2	1.425	3	12	460.1-1150-035A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K	
11.50	.453	57.2	2.252	4	12	460.1-1150-058A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L	
11.60	.457	36.5	1.437	3	12	460.1-1160-035A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K	
11.60	.457	57.1	2.248	4	12	460.1-1160-058A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L	
11.80	.465	37.2	1.465	3	12	460.1-1180-035A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K	
11.80	.465	56.8	2.236	4	12	460.1-1180-059A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L	
11.91	.469	56.7	2.232	4	12	460.1-1191-060A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L	
12.00	.472	37.8	1.488	3	12	460.1-1200-036A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K	
12.00	.472	56.6	2.228	4	12	460.1-1200-060A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L	
12.10	.476	38.1	1.500	3	14	460.1-1210-036A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K	
12.10	.476	62.3	2.453	5	14	460.1-1210-061A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L	
12.20	.480	38.4	1.512	3	14	460.1-1220-037A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K	
12.20	.480	62.4	2.457	5	14	460.1-1220-061A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L	
12.30	.484	38.7	1.524	3	14	460.1-1230-037A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K	
12.50	.492	39.4	1.551	3	14	460.1-1250-038A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K	
12.50	.492	62.0	2.441	4	14	460.1-1250-063A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L	
12.70	.500	40.0	1.575	3	14	460.1-1270-038A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K	
12.70	.500	61.8	2.433	4	14	460.1-1270-064A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L	
12.80	.504	40.3	1.587	3	14	460.1-1280-038A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K	
12.80	.504	61.6	2.425	4	14	460.1-1280-064A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L	
13.00	.512	40.9	1.610	3	14	460.1-1300-039A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K	
13.00	.512	61.4	2.417	4	14	460.1-1300-065A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L	
13.10	.516	41.2	1.622	3	14	460.1-1310-039A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K	
13.10	.516	61.3	2.413	4	14	460.1-1310-066A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L	
13.49	.531	42.5	1.673	3	14	460.1-1349-041A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K	
13.49	.531	60.8	2.394	4	14	460.1-1349-061A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L	
13.50	.531	42.5	1.673	3	14	460.1-1350-041A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K	
13.50	.531	60.8	2.394	4	14	460.1-1350-061A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L	
13.80	.543	43.4	1.709	3	14	460.1-1380-041A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K	
14.00	.551	44.1	1.736	3	14	460.1-1400-042A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K	
14.00	.551	63.0	2.480	4	14	460.1-1400-063A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	DIN 6537 L	
14.25	.561	44.9	1.768	3	16	460.1-1425-043A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	DIN 6537 K	
14.25	.561	68.8	2.709	4	16	460.1-1425-071A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L	
14.29	.563	45.0	1.772	3	16	460.1-1429-043A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	DIN 6537 K	
14.29	.563	68.7	2.705	4	16	460.1-1429-072A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L	

Schnittdaten: www.sandvik.coromant.com



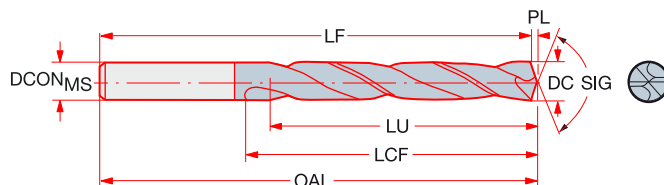
CoroDrill® 460 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Äußere Kühlschmierstoffzufuhr

TCHA
SIG

H9
140°



						P	M	K	N	S	H	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BSG
14.50	.571	45.7	1.799	3	16	460.1-1450-044A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.50	.571	68.5	2.697	4	16	460.1-1450-073A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.68	.578	46.2	1.819	3	16	460.1-1468-044A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.80	.583	46.6	1.835	3	16	460.1-1480-044A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
15.00	.591	47.2	1.858	3	16	460.1-1500-045A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
15.00	.591	68.0	2.677	4	16	460.1-1500-068A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
15.10	.594	47.6	1.874	3	16	460.1-1510-045A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.50	.610	48.8	1.921	3	16	460.1-1550-047A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.50	.610	67.5	2.657	4	16	460.1-1550-070A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.80	.622	49.2	1.937	3	16	460.1-1580-047A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
15.80	.622	67.2	2.646	4	16	460.1-1580-071A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
15.88	.625	49.1	1.933	3	16	460.1-1588-047A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
16.00	.630	49.0	1.929	3	16	460.1-1600-048A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
16.00	.630	67.0	2.638	4	16	460.1-1600-072A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
16.27	.641	51.2	2.016	3	18	460.1-1627-049A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.6	4.748	73	2.874	2.4	.094	DIN 6537 K
16.50	.650	52.0	2.047	3	18	460.1-1650-050A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
16.50	.650	76.5	3.012	4	18	460.1-1650-074A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
16.67	.656	52.5	2.067	3	18	460.1-1667-050A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
16.67	.656	76.3	3.004	4	18	460.1-1667-075A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.00	.669	53.5	2.106	3	18	460.1-1700-051A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
17.00	.669	76.0	2.992	4	18	460.1-1700-077A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.07	.672	53.7	2.114	3	18	460.1-1707-051A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
17.46	.687	75.5	2.972	4	18	460.1-1746-079A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.50	.689	55.1	2.169	3	18	460.1-1750-053A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	DIN 6537 K
17.50	.689	75.5	2.972	4	18	460.1-1750-079A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.80	.701	55.2	2.173	3	18	460.1-1780-053A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
18.00	.709	56.7	2.232	3	18	460.1-1800-054A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
18.00	.709	78.6	3.094	4	18	460.1-1800-081A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
18.50	.728	58.3	2.295	3	20	460.1-1850-056A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
19.00	.748	59.8	2.354	3	20	460.1-1900-057A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
19.00	.748	85.8	3.378	4	20	460.1-1900-086A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
19.50	.768	61.4	2.417	3	20	460.1-1950-059A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	DIN 6537 K
19.50	.768	85.4	3.362	4	20	460.1-1950-088A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	DIN 6537 L
19.80	.780	85.2	3.354	4	20	460.1-1980-089A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	DIN 6537 L
20.00	.787	63.0	2.480	3	20	460.1-2000-060A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	DIN 6537 K
20.00	.787	85.0	3.346	4	20	460.1-2000-090A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	DIN 6537 L

Schnittdaten: www.sandvik.coromant.com



E9



E14



CoroDrill® 860-GM

Für Multimaterial optimierter Hochleistungsbohrer

Anwendungsbereich

- Für einen breiten Werkstoffbereich in allen Industrie-segmenten, wie z.B. im allgemeinen Maschinenbau, im Formen- und Gesenkbau, in der Automobilindustrie sowie bei der Energie- und Stromerzeugung
- Innere und äußere Kühlschmierstoffzufuhr

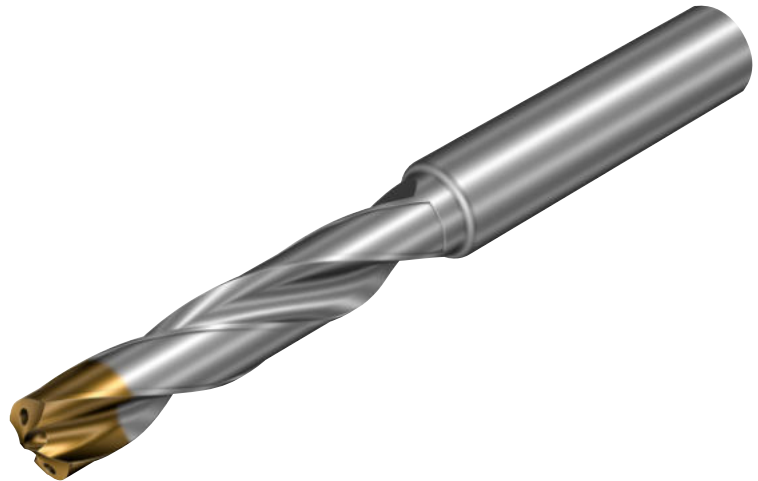


ISO-Anwendungsbereich:



Merkmale und Vorteile

- Polierte Spankanäle für effiziente Spanabfuhr
- Hohe Produktivität und gleichmäßige Standzeit
- Großer Nutzen ohne Qualitätseinbußen
- Ausgezeichnete Bohrungsqualität
- Hohe Vorschubgeschwindigkeiten
- Niedrige Schnittkräfte



www.sandvik.coromant.com/corodrigill860

Empfehlungen

Wir empfehlen die Verwendung von hydraulischen Präzisionsspannfuttern.

Es wird eine innere Kühlschmierstoffzufuhr mit einem Mindestdruck von 20 bar empfohlen

Für Spannfutter, siehe Katalog Rotierende Werkzeuge.



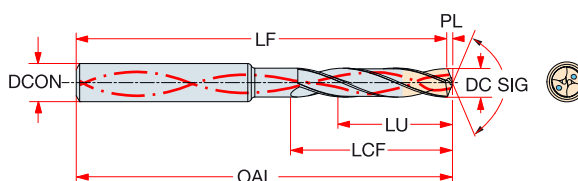
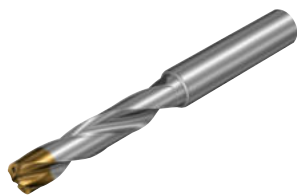
E14

CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°



						P M K N S H						Abmessungen, mm, Zoll									
DC	DC*	LU	LU*	ULDR	CZGMS	Bestellnummer	X1BM	X1BM	X1BM	X1BM	X1BM	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*
3.00	.118	9.5	.374	3	6	860.1-0300-009A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.00	.118	15.5	.610	5	6	860.1-0300-015A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.00	.118	24.5	.965	8	6	860.1-0300-024A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016
3.10	.122	9.8	.386	3	6	860.1-0310-009A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.10	.122	16.0	.630	5	6	860.1-0310-016A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.10	.122	25.3	.996	8	6	860.1-0310-025A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016
3.17	.125	10.0	.394	3	6	860.1-0317-010A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.17	.125	16.4	.646	5	6	860.1-0317-016A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.18	.125	26.0	1.024	8	6	860.1-0318-026A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.20	.126	10.1	.398	3	6	860.1-0320-010A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.20	.126	16.5	.650	5	6	860.1-0320-016A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.20	.126	26.1	1.028	8	6	860.1-0320-026A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.30	.130	10.5	.413	3	6	860.1-0330-010A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.30	.130	17.1	.673	5	6	860.1-0330-017A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.30	.130	27.0	1.063	8	6	860.1-0330-027A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.40	.134	10.8	.425	3	6	860.1-0340-010A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.40	.134	17.6	.693	5	6	860.1-0340-017A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.40	.134	27.8	1.094	8	6	860.1-0340-027A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.45	.136	11.0	.433	3	6	860.1-0345-010A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.45	.136	17.8	.701	5	6	860.1-0345-017A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	11.1	.437	3	6	860.1-0350-011A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.50	.138	18.1	.713	5	6	860.1-0350-018A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	28.6	1.126	8	6	860.1-0350-028A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.57	.141	11.3	.445	3	6	860.1-0357-011A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.57	.141	18.5	.728	5	6	860.1-0357-018A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.57	.141	29.2	1.150	8	6	860.1-0357-028A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.60	.142	11.4	.449	3	6	860.1-0360-011A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.60	.142	18.6	.732	5	6	860.1-0360-018A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	11.7	.461	3	6	860.1-0370-011A1-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.70	.146	19.1	.752	5	6	860.1-0370-019A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	30.2	1.189	8	6	860.1-0370-028A1-GM	★	★	★	★	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.80	.150	12.0	.472	3	6	860.1-0380-012A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024
3.80	.150	19.6	.772	5	6	860.1-0380-019A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024
3.80	.150	31.0	1.220	8	6	860.1-0380-031A1-GM	★	★	★	★	★	6.0	.236	90	3.543	89.5	3.524	48	1.890	0.5	.020
3.90	.154	12.4	.488	3	6	860.1-0390-012A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
3.90	.154	20.2	.795	5	6	860.1-0390-020A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
3.97	.156	20.5	.807	5	6	860.1-0397-020A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
3.97	.156	32.4	1.276	8	6	860.1-0397-032A1-GM	★	★	★	★	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.00	.157	12.7	.500	3	6	860.1-0400-012A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.00	.157	20.7	.815	5	6	860.1-0400-020A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.00	.157	32.7	1.287	8	6	860.1-0400-032A1-GM	★	★	★	★	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.10	.161	13.0	.512	3	6	860.1-0410-013A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.10	.161	21.2	.835	5	6	860.1-0410-021A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.10	.161	33.5	1.319	8	6	860.1-0410-033A1-GM	★	★	★	★	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.20	.165	13.3	.524	3	6	860.1-0420-013A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.20	.165	21.7	.854	5	6	860.1-0420-021A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.20	.165	34.3	1.350	8	6	860.1-0420-034A1-GM	★	★	★	★	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.30	.169	13.6	.535	3	6	860.1-0430-013A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.30	.169	22.2	.874	5	6	860.1-0430-022A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.30	.169	35.1	1.382	8	6	860.1-0430-035A1-GM	★	★	★	★	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.36	.172	13.8	.543	3	6	860.1-0436-013A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.36	.172	22.5	.886	5	6	860.1-0436-022A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.37	.172	35.7	1.406	8	6	860.1-0437-035A1-GM	★	★	★	★	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.40	.173	14.0	.551	3	6	860.1-0440-014A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.40	.173	22.8	.898	5	6	860.1-0440-022A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.50	.177	14.3	.563	3	6	860.1-0450-014A1-GM	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.50	.177	23.3	.917	5	6	860.1-0450-023A1-GM	★	★	★	★	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.50	.177	36.8	1.449	8	6	860.1-0450-036A1-GM	★	★	★	★	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028



B76



E9



E28



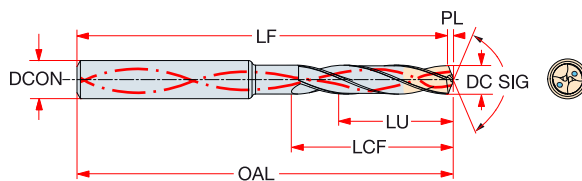
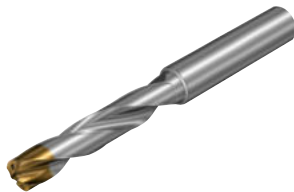
E14



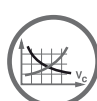
CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

							P	M	K	N	S	H	Abmessungen, mm, Zoll									
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*
4.55	.179	14.4	.567	3	6	860.1-0455-014A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.60	.181	14.6	.575	3	6	860.1-0460-014A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.60	.181	23.8	.937	5	6	860.1-0460-023A1-GM	★	★	★	★	★	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.60	.181	37.6	1.480	8	6	860.1-0460-037A1-GM	★	★	★	★	★	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028
4.70	.185	14.9	.587	3	6	860.1-0470-014A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.70	.185	24.3	.957	5	6	860.1-0470-024A1-GM	★	★	★	★	★	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.70	.185	38.4	1.512	8	6	860.1-0470-038A1-GM	★	★	★	★	★	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028
4.76	.187	15.1	.594	3	6	860.1-0476-015A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.76	.187	24.6	.969	5	6	860.1-0476-024A1-GM	★	★	★	★	★	★	6.0	.236	74	2.913	73.2	2.882	44	1.732	0.8	.031
4.76	.187	38.9	1.532	8	6	860.1-0476-038A1-GM	★	★	★	★	★	★	6.0	.236	90	3.543	89.3	3.516	62	2.441	0.7	.028
4.80	.189	15.2	.598	3	6	860.1-0480-015A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.80	.189	24.8	.976	5	6	860.1-0480-024A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
4.80	.189	39.2	1.543	8	6	860.1-0480-039A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028
4.90	.193	15.5	.610	3	6	860.1-0490-015A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.90	.193	25.3	.996	5	6	860.1-0490-025A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.00	.197	15.9	.626	3	6	860.1-0500-015A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	25.9	1.020	5	6	860.1-0500-025A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.00	.197	40.9	1.610	8	6	860.1-0500-040A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031
5.10	.201	16.2	.638	3	6	860.1-0510-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.10	.201	26.4	1.039	5	6	860.1-0510-026A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.10	.201	41.7	1.642	8	6	860.1-0510-041A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.16	.203	16.4	.646	3	6	860.1-0516-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.16	.203	26.7	1.051	5	6	860.1-0516-026A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.20	.205	16.5	.650	3	6	860.1-0520-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.20	.205	26.9	1.059	5	6	860.1-0520-026A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.20	.205	42.5	1.673	8	6	860.1-0520-042A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.25	.207	27.4	1.079	5	6	860.1-0525-027A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.30	.209	16.8	.661	3	6	860.1-0530-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.30	.209	27.4	1.079	5	6	860.1-0530-027A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.30	.209	43.3	1.705	8	6	860.1-0530-043A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.40	.213	17.1	.673	3	6	860.1-0540-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.40	.213	28.0	1.102	5	6	860.1-0540-027A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.40	.213	44.1	1.736	8	6	860.1-0540-044A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.50	.217	17.5	.689	3	6	860.1-0550-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.50	.217	28.5	1.122	5	6	860.1-0550-028A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.50	.217	45.4	1.787	8	6	860.1-0550-045A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.55	.219	28.8	1.134	5	6	860.1-0555-028A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.56	.219	17.6	.693	3	6	860.1-0556-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.56	.219	28.8	1.134	5	6	860.1-0556-028A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.56	.219	45.4	1.787	8	6	860.1-0556-045A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.60	.220	17.8	.701	3	6	860.1-0560-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.60	.220	29.0	1.142	5	6	860.1-0560-029A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
5.60	.220	45.8	1.803	8	6	860.1-0560-045A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039
5.70	.224	18.1	.713	3	6	860.1-0570-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.70	.224	29.5	1.161	5	6	860.1-0570-029A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
5.70	.224	46.6	1.835	8	6	860.1-0570-046A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039
5.80	.228	18.4	.724	3	6	860.1-0580-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.80	.228	30.0	1.181	5	6	860.1-0580-030A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	80.9	3.187	44	1.732	1.1	.042
5.80	.228	47.4	1.866	8	6	860.1-0580-047A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039
5.90	.232	18.7	.736	3	6	860.1-0590-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.90	.232	48.2	1.898	8	6	860.1-0590-048A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039
5.95	.234	18.9	.744	3	6	860.1-0595-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	64.9	2.556	28	1.102	1.1	.043
6.00	.236	19.0	.748	3	6	860.1-0600-016A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	64.9	2.555	28	1.102	1.1	.043
6.00	.236	31.0	1.220	5	6	860.1-0600-031A1-GM	★	★	★	★	★	★	6.0	.236	82	3.228	80.9	3.185	44	1.732	1.1	.043
6.00	.236	49.0	1.929	8	6	860.1-0600-049A1-GM	★	★	★	★	★	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039



B76



E9



E28

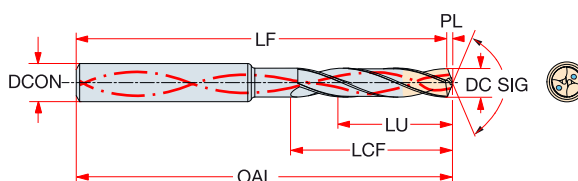
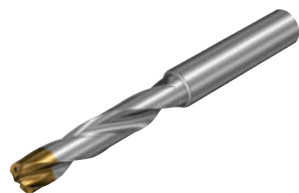


E14

CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

							P	M	K	N	S	H	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZG _{MS}	Bestellnummer	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*		
6.10	.240	19.4	.764	3	8	860.1-0610-019A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.044		
6.10	.240	31.6	1.244	5	8	860.1-0610-031A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.044		
6.10	.240	49.9	1.965	8	8	860.1-0610-049A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039		
6.20	.244	19.7	.776	3	8	860.1-0620-019A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.9	3.066	34	1.339	1.1	.044		
6.20	.244	32.1	1.264	5	8	860.1-0620-032A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.9	3.538	53	2.087	1.1	.044		
6.20	.244	50.7	1.996	8	8	860.1-0620-050A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043		
6.30	.248	20.0	.787	3	8	860.1-0630-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.9	3.065	34	1.339	1.1	.045		
6.30	.248	32.6	1.283	5	8	860.1-0630-032A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.9	3.538	53	2.087	1.1	.045		
6.30	.248	51.5	2.028	8	8	860.1-0630-051A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043		
6.35	.250	20.2	.795	3	8	860.1-0635-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.065	34	1.339	1.2	.045		
6.35	.250	32.9	1.295	5	8	860.1-0635-032A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.537	53	2.087	1.2	.045		
6.35	.250	52.0	2.047	8	8	860.1-0635-051A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043		
6.40	.252	20.3	.799	3	8	860.1-0640-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.064	34	1.339	1.2	.046		
6.40	.252	33.1	1.303	5	8	860.1-0640-033A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.537	53	2.087	1.2	.046		
6.40	.252	52.3	2.059	8	8	860.1-0640-052A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043		
6.50	.256	20.6	.811	3	8	860.1-0650-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.064	34	1.339	1.2	.047		
6.50	.256	33.6	1.323	5	8	860.1-0650-033A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.536	53	2.087	1.2	.047		
6.50	.256	53.1	2.091	8	8	860.1-0650-053A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043		
6.60	.260	21.0	.827	3	8	860.1-0660-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.2	.047		
6.60	.260	34.2	1.346	5	8	860.1-0660-034A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047		
6.60	.260	54.0	2.126	8	8	860.1-0660-054A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043		
6.70	.264	21.3	.839	3	8	860.1-0670-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.062	34	1.339	1.2	.048		
6.70	.264	34.7	1.366	5	8	860.1-0670-034A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.048		
6.70	.264	54.8	2.157	8	8	860.1-0670-054A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043		
6.75	.266	21.4	.843	3	8	860.1-0675-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.062	34	1.339	1.2	.048		
6.75	.266	35.0	1.378	5	8	860.1-0675-034A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.534	53	2.087	1.2	.048		
6.80	.268	21.6	.850	3	8	860.1-0680-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.062	34	1.339	1.2	.049		
6.80	.268	35.2	1.386	5	8	860.1-0680-035A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.534	53	2.087	1.2	.049		
6.80	.268	55.6	2.189	8	8	860.1-0680-055A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047		
6.90	.272	21.9	.862	3	8	860.1-0690-020A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.7	3.061	34	1.339	1.3	.049		
6.90	.272	35.7	1.406	5	8	860.1-0690-035A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.7	3.533	53	2.087	1.3	.049		
6.90	.272	56.4	2.220	8	8	860.1-0690-056A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047		
7.00	.276	22.2	.874	3	8	860.1-0700-022A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.7	3.060	41	1.614	1.3	.050		
7.00	.276	36.2	1.425	5	8	860.1-0700-036A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.7	3.533	53	2.087	1.3	.050		
7.00	.276	57.2	2.252	8	8	860.1-0700-057A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047		
7.10	.280	22.5	.886	3	8	860.1-0710-022A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051		
7.10	.280	36.7	1.445	5	8	860.1-0710-036A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051		
7.10	.280	58.0	2.283	8	8	860.1-0710-058A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047		
7.14	.281	22.7	.894	3	8	860.1-0714-022A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051		
7.14	.281	58.4	2.299	8	8	860.1-0714-058A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047		
7.20	.283	22.9	.902	3	8	860.1-0720-022A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.052		
7.20	.283	37.3	1.469	5	8	860.1-0720-037A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.7	3.531	53	2.087	1.3	.052		
7.30	.287	23.2	.913	3	8	860.1-0730-023A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.7	3.058	41	1.614	1.3	.052		
7.30	.287	37.8	1.488	5	8	860.1-0730-037A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.7	3.530	53	2.087	1.3	.052		
7.40	.291	23.5	.925	3	8	860.1-0740-023A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.7	3.057	41	1.614	1.3	.053		
7.40	.291	38.3	1.508	5	8	860.1-0740-038A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.7	3.530	53	2.087	1.3	.053		
7.40	.291	60.5	2.382	8	8	860.1-0740-060A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.7	4.909	84	3.307	1.3	.051		
7.50	.295	23.8	.937	3	8	860.1-0750-023A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.057	41	1.614	1.4	.054		
7.50	.295	38.8	1.528	5	8	860.1-0750-038A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.6	3.529	53	2.087	1.4	.054		
7.50	.295	61.3	2.413	8	8	860.1-0750-061A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.7	4.909	84	3.307	1.3	.051		
7.54	.297	24.0	.945	3	8	860.1-0754-023A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.056	41	1.614	1.4	.054		
7.60	.299	24.1	.949	3	8	860.1-0760-024A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.056	41	1.614	1.4	.054		
7.60	.299	39.3	1.547	5	8	860.1-0760-038A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.6	3.528	53	2.087	1.4	.054		
7.70	.303	24.5	.965	3	8	860.1-0770-024A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.055	41	1.614	1.4	.055		
7.70	.303	39.9	1.571	5	8	860.1-0770-038A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.6	3.528	53	2.087	1.4	.055		
7.70	.303	63.0	2.480	8	8	860.1-0770-063A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.7	4.909	84	3.307	1.3	.051		



B76



E9



E28



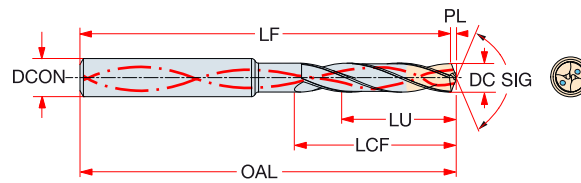
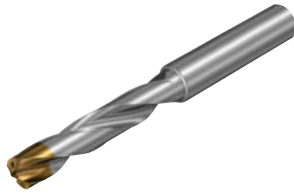
E14



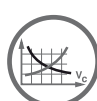
CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

							P	M	K	N	S	H	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*		
7.80	.307	24.8	.976	3	8	860.1-0780-024A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.054	41	1.614	1.4	.056		
7.80	.307	40.4	1.591	5	8	860.1-0780-038A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.6	3.527	53	2.087	1.4	.056		
7.80	.307	63.8	2.512	8	8	860.1-0780-063A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.7	4.909	84	3.307	1.3	.051		
7.90	.311	25.1	.988	3	8	860.1-0790-025A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.054	41	1.614	1.4	.057		
7.90	.311	64.6	2.543	8	8	860.1-0790-064A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.6	4.906	84	3.307	1.4	.055		
7.94	.313	25.2	.992	3	8	860.1-0794-025A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.053	41	1.614	1.4	.057		
7.94	.313	41.1	1.618	5	8	860.1-0794-038A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.6	3.526	53	2.087	1.4	.057		
7.94	.313	65.0	2.559	8	8	860.1-0794-064A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.6	4.906	84	3.307	1.4	.055		
8.00	.315	25.4	1.000	3	8	860.1-0800-025A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	77.5	3.053	41	1.614	1.5	.057		
8.00	.315	41.4	1.630	5	8	860.1-0800-038A1-GM	★	★	★	★	★	★	8.0	.315	91	3.583	89.5	3.525	53	2.087	1.5	.057		
8.00	.315	65.4	2.575	8	8	860.1-0800-065A1-GM	★	★	★	★	★	★	8.0	.315	126	4.961	124.6	4.906	84	3.307	1.4	.055		
8.10	.319	25.7	1.012	3	10	860.1-0810-025A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.5	.058		
8.10	.319	42.0	1.654	5	10	860.1-0810-041A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.5	3.997	61	2.402	1.5	.058		
8.10	.319	66.2	2.606	8	10	860.1-0810-066A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055		
8.20	.323	26.0	1.024	3	10	860.1-0820-026A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059		
8.20	.323	42.4	1.669	5	10	860.1-0820-042A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059		
8.20	.323	67.0	2.638	8	10	860.1-0820-067A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055		
8.30	.327	26.4	1.039	3	10	860.1-0830-026A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.059		
8.30	.327	43.3	1.705	5	10	860.1-0830-043A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059		
8.30	.327	67.9	2.673	8	10	860.1-0830-067A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055		
8.40	.331	26.7	1.051	3	10	860.1-0840-026A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.060		
8.40	.331	43.5	1.713	5	10	860.1-0840-043A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.5	3.995	61	2.402	1.5	.060		
8.50	.335	27.0	1.063	3	10	860.1-0850-027A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.443	47	1.850	1.5	.061		
8.50	.335	44.0	1.732	5	10	860.1-0850-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.5	3.994	61	2.402	1.5	.061		
8.50	.335	69.5	2.736	8	10	860.1-0850-069A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059		
8.60	.339	27.3	1.075	3	10	860.1-0860-027A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062		
8.60	.339	44.5	1.752	5	10	860.1-0860-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.4	3.994	61	2.402	1.6	.062		
8.60	.339	70.3	2.768	8	10	860.1-0860-070A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059		
8.70	.343	27.6	1.087	3	10	860.1-0870-027A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062		
8.70	.343	45.0	1.772	5	10	860.1-0870-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.4	3.993	61	2.402	1.6	.062		
8.70	.343	71.1	2.799	8	10	860.1-0870-071A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059		
8.73	.344	27.7	1.091	3	10	860.1-0873-027A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063		
8.73	.344	71.4	2.811	8	10	860.1-0873-071A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.4	5.922	106	4.173	1.6	.063		
8.80	.346	28.0	1.102	3	10	860.1-0880-028A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063		
8.80	.346	45.6	1.795	5	10	860.1-0880-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063		
8.90	.350	28.3	1.114	3	10	860.1-0890-028A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.440	47	1.850	1.6	.064		
9.00	.354	28.6	1.126	3	10	860.1-0900-028A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.439	47	1.850	1.6	.064		
9.00	.354	46.6	1.835	5	10	860.1-0900-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.4	3.991	61	2.402	1.6	.064		
9.00	.354	73.6	2.898	8	10	860.1-0900-073A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.4	5.920	106	4.173	1.6	.064		
9.13	.359	29.0	1.142	3	10	860.1-0913-029A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.3	3.439	47	1.850	1.7	.065		
9.20	.362	29.2	1.150	3	10	860.1-0920-029A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.3	3.438	47	1.850	1.7	.066		
9.30	.366	29.5	1.161	3	10	860.1-0930-029A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.7	.067		
9.30	.366	49.0	1.929	5	10	860.1-0930-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.3	3.989	61	2.402	1.7	.067		
9.40	.370	49.0	1.929	5	10	860.1-0940-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.3	3.988	61	2.402	1.7	.067		
9.40	.370	76.9	3.028	8	10	860.1-0940-076A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.3	5.917	106	4.173	1.7	.067		
9.50	.374	30.2	1.189	3	10	860.1-0950-030A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068		
9.50	.374	49.0	1.929	5	10	860.1-0950-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.3	3.987	61	2.402	1.7	.068		
9.50	.374	77.7	3.059	8	10	860.1-0950-077A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.3	5.916	106	4.173	1.7	.068		
9.52	.375	30.2	1.189	3	10	860.1-0952-030A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068		
9.52	.375	49.0	1.929	5	10	860.1-0952-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.3	3.987	61	2.402	1.7	.068		
9.52	.375	77.8	3.063	8	10	860.1-0952-077A1-GM	★	★	★	★	★	★	10.0	.394	152	5.984	150.3	5.916	106	4.173	1.7	.068		
9.60	.378	30.5	1.201	3	10	860.1-0960-030A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.3	3.435	47	1.850	1.7	.069		
9.60	.378	49.0	1.929	5	10	860.1-0960-044A1-GM	★	★	★	★	★	★	10.0	.394	103	4.055	101.3	3.986	61	2.402	1.7	.069		
9.70	.382	30.8	1.213	3	10	860.1-0970-030A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.2	3.434	47	1.850	1.8	.069		
9.70	.382	49.0	1.929	5	10	860.																		



B76



E9



E28

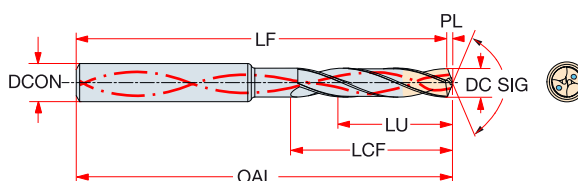
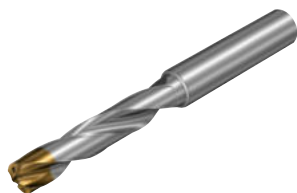


E14

CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

							P	M	K	N	S	H	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZG _{MS}	Bestellnummer	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			
9.80	.386	31.1	1.224	3	10	860.1-0980-030A1-GM	★	★	★	★	★	10.0	.394	89	3.504	87.2	3.434	47	1.850	1.8	.070			
9.80	.386	49.0	1.929	5	10	860.1-0980-044A1-GM	★	★	★	★	★	10.0	.394	103	4.055	101.2	3.985	61	2.402	1.8	.070			
9.80	.386	80.1	3.154	8	10	860.1-0980-080A1-GM	★	★	★	★	★	10.0	.394	152	5.984	150.2	5.914	106	4.173	1.8	.070			
9.90	.390	31.5	1.240	3	10	860.1-0990-029A1-GM	★	★	★	★	★	10.0	.394	89	3.504	87.2	3.433	47	1.850	1.8	.071			
9.90	.390	49.0	1.929	4	10	860.1-0990-043A1-GM	★	★	★	★	★	10.0	.394	103	4.055	101.2	3.984	61	2.402	1.8	.071			
9.92	.391	31.5	1.240	3	10	860.1-0992-029A1-GM	★	★	★	★	★	10.0	.394	89	3.504	87.2	3.433	47	1.850	1.8	.071			
9.92	.391	81.1	3.193	8	10	860.1-0992-081A1-GM	★	★	★	★	★	10.0	.394	152	5.984	150.2	5.913	106	4.173	1.8	.071			
10.00	.394	31.8	1.252	3	10	860.1-1000-029A1-GM	★	★	★	★	★	10.0	.394	89	3.504	87.2	3.432	47	1.850	1.8	.072			
10.00	.394	50.0	1.969	5	10	860.1-1000-043A1-GM	★	★	★	★	★	10.0	.394	103	4.055	101.2	3.983	61	2.402	1.8	.072			
10.00	.394	81.8	3.220	8	10	860.1-1000-081A1-GM	★	★	★	★	★	10.0	.394	152	5.984	150.2	5.913	106	4.173	1.8	.072			
10.10	.398	32.1	1.264	3	12	860.1-1010-032A1-GM	★	★	★	★	★	12.0	.472	89	3.504	87.2	3.432	55	2.165	1.8	.072			
10.10	.398	52.3	2.059	5	12	860.1-1010-052A1-GM	★	★	★	★	★	12.0	.472	103	4.055	101.2	3.983	71	2.795	1.8	.072			
10.10	.398	82.6	3.252	8	12	860.1-1010-082A1-GM	★	★	★	★	★	12.0	.472	152	5.984	150.2	5.912	128	5.039	1.8	.072			
10.20	.402	32.4	1.276	3	12	860.1-1020-032A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.943	55	2.165	1.9	.073			
10.20	.402	52.8	2.079	5	12	860.1-1020-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.573	71	2.795	1.9	.073			
10.20	.402	83.4	3.283	8	12	860.1-1020-083A1-GM	★	★	★	★	★	12.0	.472	180	7.087	178.1	7.014	128	5.039	1.9	.073			
10.30	.406	32.7	1.287	3	12	860.1-1030-032A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.942	55	2.165	1.9	.074			
10.30	.406	53.3	2.098	5	12	860.1-1030-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.572	71	2.795	1.9	.074			
10.30	.406	84.2	3.315	8	12	860.1-1030-084A1-GM	★	★	★	★	★	12.0	.472	180	7.087	178.1	7.013	128	5.039	1.9	.074			
10.32	.406	32.8	1.291	3	12	860.1-1032-032A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.942	55	2.165	1.9	.074			
10.32	.406	53.4	2.102	5	12	860.1-1032-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.572	71	2.795	1.9	.074			
10.40	.409	33.0	1.299	3	12	860.1-1040-033A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075			
10.40	.409	53.8	2.118	5	12	860.1-1040-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075			
10.50	.413	33.4	1.315	3	12	860.1-1050-033A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075			
10.50	.413	54.4	2.142	5	12	860.1-1050-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.570	71	2.795	1.9	.075			
10.50	.413	85.9	3.382	8	12	860.1-1050-085A1-GM	★	★	★	★	★	12.0	.472	180	7.087	178.1	7.011	128	5.039	1.9	.075			
10.60	.417	33.7	1.327	3	12	860.1-1060-033A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.940	55	2.165	1.9	.076			
10.70	.421	34.0	1.339	3	12	860.1-1070-034A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.939	55	2.165	1.9	.077			
10.70	.421	56.0	2.205	5	12	860.1-1070-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.569	71	2.795	1.9	.077			
10.71	.422	34.0	1.339	3	12	860.1-1071-034A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.939	55	2.165	1.9	.077			
10.71	.422	56.0	2.205	5	12	860.1-1071-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.569	71	2.795	1.9	.077			
10.80	.425	34.3	1.350	3	12	860.1-1080-034A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.0	3.938	55	2.165	2.0	.077			
10.80	.425	56.0	2.205	5	12	860.1-1080-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.0	4.568	71	2.795	2.0	.077			
10.80	.425	88.3	3.476	8	12	860.1-1080-088A1-GM	★	★	★	★	★	12.0	.472	180	7.087	178.0	7.009	128	5.039	2.0	.077			
11.00	.433	35.0	1.378	3	12	860.1-1100-035A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079			
11.00	.433	56.0	2.205	5	12	860.1-1100-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079			
11.00	.433	90.0	3.543	8	12	860.1-1100-090A1-GM	★	★	★	★	★	12.0	.472	180	7.087	178.0	7.008	128	5.039	2.0	.079			
11.10	.437	35.3	1.390	3	12	860.1-1110-035A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.0	3.936	55	2.165	2.0	.080			
11.10	.437	56.0	2.205	5	12	860.1-1110-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.0	4.566	71	2.795	2.0	.080			
11.10	.437	90.8	3.575	8	12	860.1-1110-090A1-GM	★	★	★	★	★	12.0	.472	180	7.087	178.0	7.007	128	5.039	2.0	.080			
11.11	.437	35.3	1.390	3	12	860.1-1111-035A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.0	3.936	55	2.165	2.0	.080			
11.11	.437	56.0	2.205	5	12	860.1-1111-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.0	4.566	71	2.795	2.0	.080			
11.20	.441	35.6	1.402	3	12	860.1-1120-035A1-GM	★	★	★	★	★	12.0	.472	102	4.016	100.0	3.936	55	2.165	2.0	.080			
11.20	.441	56.0	2.205	5	12	860.1-1120-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	116.0	4.565	71	2.795	2.0	.080			
11.30	.445	56.5	2.224	5	12	860.1-1130-052A1-GM	★	★	★	★	★	12.0	.472	118	4.646	115.9	4.565	71	2.795	2.1	.081			
11.50	.453	36.5	1.437	3	12	860.1-1150-035A1-GM	★	★	★	★	★	12.0	.472	102	4.016	99.9	3.933	55	2.165	2.1	.082			
11.50	.453	56.0	2.205	4	12	860.1-1150-051A1-GM	★	★	★	★	★	12.0	.472	118	4.646	115.9	4.563	71	2.795	2.1	.082			
11.50	.453	94.0	3.701	8	12	860.1-1150-094A1-GM	★	★	★	★	★	12.0	.472	180	7.087	177.9	7.004	128	5.039	2.1	.082			
11.60	.457	36.9	1.453	3	12	860.1-1160-035A1-GM	★	★	★	★	★	12.0	.472	102	4.016	99.9	3.933	55	2.165	2.1	.083			
11.70	.461	37.2	1.465	3	12	860.1-1170-035A1-GM	★	★	★	★	★	12.0	.472	102	4.016	99.9	3.932	55	2.165	2.1	.084			
11.80	.465	37.5	1.476	3	12	860.1-1180-035A1-GM	★	★	★	★	★	12.0	.472	102	4.016	99.9	3.931	55	2.165	2.1	.085			
11.80	.465	56.0	2.205	4	12	860.1-1180-051A1-GM	★	★	★	★	★	12.0	.472	118	4.646	115.9	4.561	71	2.795	2.1	.085			
11.80	.465	96.5	3.799	8	12	860.1-1180-096A1-GM	★	★	★	★	★	12.0	.472	180	7.087	177.9	7.002	128	5.039	2.1	.085			
11.90	.469	56.0	2.205	4	12	860.1-1190-051A1-GM	★	★	★	★	★	12.0	.472	118	4.646	115.8	4.560	71	2.795	2.2	.085			
11.90	.469	97.3	3.831	8	12	860.1-1190-097A1-GM																		



B76



E9

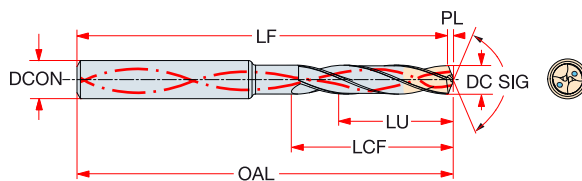
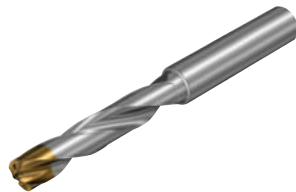


CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°



							P	M	K	N	S	H	Abmessungen, mm, Zoll									
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	X _{IBM}	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*
12.10	.476	60.5	2.382	5	14	860.1-1210-056A1-GM	★	★	★	★	★	★	14.0	.551	118	4.646	115.8	4.559	77	3.032	2.2	.087
12.20	.480	38.8	1.528	3	14	860.1-1220-038A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.8	4.125	60	2.362	2.2	.087
12.20	.480	61.0	2.402	5	14	860.1-1220-056A1-GM	★	★	★	★	★	★	14.0	.551	124	4.882	121.8	4.794	77	3.032	2.2	.087
12.30	.484	39.1	1.539	3	14	860.1-1230-039A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.8	4.124	60	2.362	2.2	.088
12.30	.484	100.6	3.961	8	14	860.1-1230-100A1-GM	★	★	★	★	★	★	14.0	.551	202	7.953	199.8	7.865	151	5.945	2.2	.088
12.40	.488	39.4	1.551	3	14	860.1-1240-039A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.7	4.124	60	2.362	2.3	.089
12.50	.492	39.7	1.563	3	14	860.1-1250-039A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.7	4.123	60	2.362	2.3	.090
12.50	.492	62.0	2.441	4	14	860.1-1250-056A1-GM	★	★	★	★	★	★	14.0	.551	124	4.882	121.7	4.792	77	3.032	2.3	.090
12.50	.492	102.3	4.028	8	14	860.1-1250-102A1-GM	★	★	★	★	★	★	14.0	.551	202	7.953	199.7	7.863	151	5.945	2.3	.090
12.70	.500	40.4	1.591	3	14	860.1-1270-039A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.091
12.70	.500	60.0	2.362	4	14	860.1-1270-056A1-GM	★	★	★	★	★	★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.3	.091
12.70	.500	103.9	4.091	8	14	860.1-1270-103A1-GM	★	★	★	★	★	★	14.0	.551	202	7.953	199.7	7.862	151	5.945	2.3	.091
12.80	.504	104.7	4.122	8	14	860.1-1280-104A1-GM	★	★	★	★	★	★	14.0	.551	202	7.953	199.7	7.861	151	5.945	2.3	.092
13.00	.512	43.0	1.693	3	14	860.1-1300-038A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.6	4.119	60	2.362	2.4	.093
13.00	.512	60.0	2.362	4	14	860.1-1300-055A1-GM	★	★	★	★	★	★	14.0	.551	124	4.882	121.6	4.789	77	3.032	2.4	.093
13.00	.512	106.3	4.185	8	14	860.1-1300-106A1-GM	★	★	★	★	★	★	14.0	.551	202	7.953	199.6	7.860	151	5.945	2.4	.093
13.10	.516	60.0	2.362	4	14	860.1-1310-055A1-GM	★	★	★	★	★	★	14.0	.551	124	4.882	121.6	4.788	77	3.032	2.4	.094
13.25	.522	43.0	1.693	3	14	860.1-1325-038A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.6	4.118	60	2.362	2.4	.095
13.30	.524	43.0	1.693	3	14	860.1-1330-036A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.6	4.118	60	2.362	2.4	.095
13.50	.531	43.0	1.693	3	14	860.1-1350-038A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.5	4.116	60	2.362	2.5	.097
13.50	.531	60.0	2.362	4	14	860.1-1350-055A1-GM	★	★	★	★	★	★	14.0	.551	124	4.882	121.5	4.785	77	3.032	2.5	.097
13.50	.531	110.4	4.346	8	14	860.1-1350-110A1-GM	★	★	★	★	★	★	14.0	.551	202	7.953	199.5	7.856	151	5.945	2.5	.097
13.75	.541	43.0	1.693	3	14	860.1-1375-038A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.5	4.114	60	2.362	2.5	.099
13.80	.543	112.9	4.445	8	14	860.1-1380-112A1-GM	★	★	★	★	★	★	14.0	.551	202	7.953	199.5	7.854	151	5.945	2.5	.099
14.00	.551	43.0	1.693	3	14	860.1-1400-038A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	104.5	4.112	60	2.362	2.5	.100
14.00	.551	60.0	2.362	4	14	860.1-1400-055A1-GM	★	★	★	★	★	★	14.0	.551	124	4.882	121.5	4.782	77	3.032	2.5	.100
14.00	.551	114.5	4.508	8	14	860.1-1400-114A1-GM	★	★	★	★	★	★	14.0	.551	202	7.953	199.5	7.852	151	5.945	2.5	.100
14.25	.561	45.3	1.783	3	16	860.1-1425-042A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.4	4.425	65	2.559	2.6	.102
14.25	.561	63.4	2.496	4	16	860.1-1425-060A1-GM	★	★	★	★	★	★	16.0	.630	133	5.236	130.4	5.134	83	3.268	2.6	.102
14.29	.563	45.4	1.787	3	16	860.1-1429-042A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.4	4.425	65	2.559	2.6	.102
14.50	.571	45.2	1.780	3	16	860.1-1450-042A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.4	4.424	65	2.559	2.6	.104
14.50	.571	63.2	2.488	4	16	860.1-1450-060A1-GM	★	★	★	★	★	★	16.0	.630	133	5.236	130.4	5.132	83	3.268	2.6	.104
15.00	.591	45.0	1.772	3	16	860.1-1500-041A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.3	4.420	65	2.559	2.7	.107
15.00	.591	63.0	2.480	4	16	860.1-1500-059A1-GM	★	★	★	★	★	★	16.0	.630	133	5.236	130.3	5.129	83	3.268	2.7	.107
15.50	.610	45.0	1.772	2	16	860.1-1550-041A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.2	4.417	65	2.559	2.8	.111
15.87	.625	45.0	1.772	2	16	860.1-1587-041A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.1	4.414	65	2.559	2.9	.114
15.87	.625	63.0	2.480	3	16	860.1-1587-059A1-GM	★	★	★	★	★	★	16.0	.630	133	5.236	130.1	5.123	83	3.268	2.9	.114
16.00	.630	48.0	1.890	3	16	860.1-1600-041A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.1	4.413	65	2.559	2.9	.115
16.00	.630	63.0	2.480	3	16	860.1-1600-059A1-GM	★	★	★	★	★	★	16.0	.630	133	5.236	130.1	5.122	83	3.268	2.9	.115
16.00	.630	130.9	5.154	8	16	860.1-1600-130A1-GM	★	★	★	★	★	★	16.0	.630	227	8.937	224.1	8.822	172	6.772	2.9	.115



B76



E9



E28

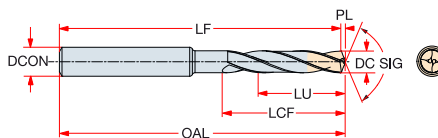
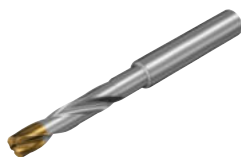


E14

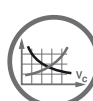
CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Äußere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

												Abmessungen, mm, Zoll									
						P	M	K	N	S	H										
DC	DC*	LU	LU*	ULDR	CZG _{MS}	Bestellnummer	X1BM	X1BM	X1BM	X1BM	X1BM	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*
3.00	.118	9.5	.374	3	6	860.1-0300-009A0-GM	★	★	★	★	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.00	.118	15.5	.610	5	6	860.1-0300-015A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.10	.122	9.8	.386	3	6	860.1-0310-009A0-GM	★	★	★	★	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.10	.122	16.0	.630	5	6	860.1-0310-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.20	.126	10.1	.398	3	6	860.1-0320-010A0-GM	★	★	★	★	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.20	.126	16.5	.650	5	6	860.1-0320-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.30	.130	10.5	.413	3	6	860.1-0330-010A0-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.30	.130	17.1	.673	5	6	860.1-0330-017A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.38	.133	17.5	.689	5	6	860.1-0338-017A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.40	.134	10.8	.425	3	6	860.1-0340-010A0-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.40	.134	17.6	.693	5	6	860.1-0340-017A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	11.1	.437	3	6	860.1-0350-011A0-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.50	.138	18.1	.713	5	6	860.1-0350-018A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.60	.142	11.4	.449	3	6	860.1-0360-011A0-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.60	.142	18.6	.732	5	6	860.1-0360-018A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	11.7	.461	3	6	860.1-0370-011A0-GM	★	★	★	★	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.70	.146	19.1	.752	5	6	860.1-0370-019A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.80	.150	12.0	.472	3	6	860.1-0380-012A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024
3.80	.150	19.6	.772	5	6	860.1-0380-019A0-GM	★	★	★	★	★	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024
3.90	.154	12.4	.488	3	6	860.1-0390-012A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
3.90	.154	20.2	.795	5	6	860.1-0390-020A0-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.00	.157	12.7	.500	3	6	860.1-0400-012A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.00	.157	20.7	.815	5	6	860.1-0400-020A0-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.10	.161	13.0	.512	3	6	860.1-0410-013A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.10	.161	21.2	.835	5	6	860.1-0410-021A0-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.20	.165	13.3	.524	3	6	860.1-0420-013A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.20	.165	21.7	.854	5	6	860.1-0420-021A0-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.30	.169	13.6	.535	3	6	860.1-0430-013A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.30	.169	22.2	.874	5	6	860.1-0430-022A0-GM	★	★	★	★	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.40	.173	14.0	.551	3	6	860.1-0440-014A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.50	.177	14.3	.563	3	6	860.1-0450-014A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.50	.177	23.3	.917	5	6	860.1-0450-023A0-GM	★	★	★	★	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.60	.181	14.6	.575	3	6	860.1-0460-014A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.60	.181	23.8	.937	5	6	860.1-0460-023A0-GM	★	★	★	★	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.70	.185	14.9	.587	3	6	860.1-0470-014A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.80	.189	15.2	.598	3	6	860.1-0480-015A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.80	.189	24.8	.976	5	6	860.1-0480-024A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
4.90	.193	15.5	.610	3	6	860.1-0490-015A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	15.9	.626	3	6	860.1-0500-015A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	25.9	1.020	5	6	860.1-0500-025A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.10	.201	16.2	.638	3	6	860.1-0510-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.10	.201	26.4	1.039	5	6	860.1-0510-026A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.20	.205	16.5	.650	3	6	860.1-0520-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.20	.205	26.9	1.059	5	6	860.1-0520-026A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.30	.209	16.8	.661	3	6	860.1-0530-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.30	.209	27.4	1.079	5	6	860.1-0530-027A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.40	.213	17.1	.673	3	6	860.1-0540-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.50	.217	17.5	.689	3	6	860.1-0550-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.50	.217	28.5	1.122	5	6	860.1-0550-028A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.60	.220	17.8	.701	3	6	860.1-0560-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.60	.220	29.0	1.142	5	6	860.1-0560-029A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
5.80	.228	18.4	.724	3	6	860.1-0580-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.90	.232	30.5	1.201	5	6	860.1-0590-030A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
6.00	.236	19.0	.748	3	6	860.1-0600-016A0-GM	★	★	★	★	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
6.00	.236	31.0	1.220	5	6	860.1-0600-031A0-GM	★	★	★	★	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
6.10	.240	19.4	.764	3	8	860.1-0610-019A0-GM	★	★	★	★	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039
6.10	.240	31.6	1.244	5	8	860.1-0610-031A0-GM	★	★	★	★	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039
6.20	.244	19.7	.776	3	8	860.1-0620-019A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.20	.244	32.1	1.264	5	8	860.1-0620-032A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043



B76



E9

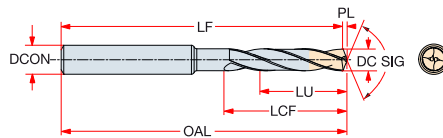


E28

CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Äußere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

						P	M	K	N	S	H	Abmessungen, mm, Zoll									
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	X1BM	X1BM	X1BM	X1BM	X1BM	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*
6.30	.248	20.0	.787	3	8	860.1-0630-020A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.30	.248	32.6	1.283	5	8	860.1-0630-032A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.40	.252	33.1	1.303	5	8	860.1-0640-033A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.50	.256	20.6	.811	3	8	860.1-0650-020A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.50	.256	33.6	1.323	5	8	860.1-0650-033A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.60	.260	21.0	.827	3	8	860.1-0660-020A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.70	.264	21.3	.839	3	8	860.1-0670-020A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.70	.264	34.7	1.366	5	8	860.1-0670-034A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.80	.268	21.6	.850	3	8	860.1-0680-020A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.2	.047
6.80	.268	35.2	1.386	5	8	860.1-0680-035A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
6.90	.272	35.7	1.406	5	8	860.1-0690-035A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
7.00	.276	22.2	.874	3	8	860.1-0700-022A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047
7.00	.276	36.2	1.425	5	8	860.1-0700-036A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
7.10	.280	22.5	.886	3	8	860.1-0710-022A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047
7.20	.283	22.9	.902	3	8	860.1-0720-022A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.052
7.50	.295	38.8	1.528	5	8	860.1-0750-038A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051
7.70	.303	24.5	.965	3	8	860.1-0770-024A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.055	41	1.614	1.4	.055
7.80	.307	24.8	.976	3	8	860.1-0780-024A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.6	3.054	41	1.614	1.4	.056
8.00	.315	25.4	1.000	3	8	860.1-0800-025A0-GM	★	★	★	★	★	8.0	.315	79	3.110	77.5	3.053	41	1.614	1.5	.057
8.00	.315	41.4	1.630	5	8	860.1-0800-038A0-GM	★	★	★	★	★	8.0	.315	91	3.583	89.6	3.528	53	2.087	1.4	.055
8.10	.319	25.7	1.012	3	10	860.1-0810-025A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.5	.058
8.20	.323	26.0	1.024	3	10	860.1-0820-026A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059
8.30	.327	26.4	1.039	3	10	860.1-0830-026A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.059
8.30	.327	43.0	1.693	5	10	860.1-0830-043A0-GM	★	★	★	★	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055
8.40	.331	26.7	1.051	3	10	860.1-0840-026A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.060
8.50	.335	27.0	1.063	3	10	860.1-0850-027A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.5	3.443	47	1.850	1.5	.061
8.50	.335	44.0	1.732	5	10	860.1-0850-044A0-GM	★	★	★	★	★	10.0	.394	103	4.055	101.5	3.994	61	2.402	1.5	.061
8.60	.339	27.3	1.075	3	10	860.1-0860-027A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062
8.60	.339	44.5	1.752	5	10	860.1-0860-044A0-GM	★	★	★	★	★	10.0	.394	103	4.055	101.4	3.994	61	2.402	1.6	.062
8.70	.343	27.6	1.087	3	10	860.1-0870-027A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062
8.70	.343	45.0	1.772	5	10	860.1-0870-044A0-GM	★	★	★	★	★	10.0	.394	103	4.055	101.4	3.993	61	2.402	1.6	.062
8.80	.346	28.0	1.102	3	10	860.1-0880-028A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063
8.80	.346	45.6	1.795	5	10	860.1-0880-044A0-GM	★	★	★	★	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063
9.00	.354	28.6	1.126	3	10	860.1-0900-028A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.4	3.439	47	1.850	1.6	.064
9.00	.354	46.6	1.835	5	10	860.1-0900-044A0-GM	★	★	★	★	★	10.0	.394	103	4.055	101.4	3.991	61	2.402	1.6	.064
9.30	.366	29.5	1.161	3	10	860.1-0930-029A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.7	.067
9.50	.374	30.2	1.189	3	10	860.1-0950-030A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068
9.50	.374	49.0	1.929	5	10	860.1-0950-044A0-GM	★	★	★	★	★	10.0	.394	103	4.055	101.3	3.987	61	2.402	1.7	.068
9.80	.386	31.1	1.224	3	10	860.1-0980-030A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.2	3.434	47	1.850	1.8	.070
10.00	.394	31.8	1.252	3	10	860.1-1000-029A0-GM	★	★	★	★	★	10.0	.394	89	3.504	87.2	3.432	47	1.850	1.8	.072
10.00	.394	50.0	1.969	5	10	860.1-1000-043A0-GM	★	★	★	★	★	10.0	.394	103	4.055	101.2	3.983	61	2.402	1.8	.072
10.20	.402	32.4	1.276	3	12	860.1-1020-032A0-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.943	55	2.165	1.9	.073
10.20	.402	52.8	2.079	5	12	860.1-1020-052A0-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.573	71	2.795	1.9	.073
10.30	.406	53.3	2.098	5	12	860.1-1030-052A0-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.572	71	2.795	1.9	.074
10.40	.409	33.0	1.299	3	12	860.1-1040-033A0-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075
10.40	.409	53.8	2.118	5	12	860.1-1040-052A0-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075
10.50	.413	33.4	1.315	3	12	860.1-1050-033A0-GM	★	★	★	★	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075
10.50	.413	54.4	2.142	5	12	860.1-1050-052A0-GM	★	★	★	★	★	12.0	.472	118	4.646	116.1	4.570	71	2.795	1.9	.075
10.80	.425	56.0	2.205	5	12	860.1-1080-052A0-GM	★	★	★	★	★	12.0	.472	118	4.646	116.0	4.568	71	2.795	2.0	.077
11.00	.433	35.0	1.378	3	12	860.1-1100-035A0-GM	★	★	★	★	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079
11.00	.433	56.0	2.205	5	12	860.1-1100-052A0-GM	★	★	★	★	★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079
12.00	.472	38.1	1.500	3	12	860.1-1200-035A0-GM	★	★	★	★	★	12.0	.472	102	4.016	99.8	3.930	55	2.165	2.2	.086
12.00	.472	56.0	2.205	4	12	860.1-1200-051A0-GM	★	★	★	★	★	12.0	.472	118	4.646	115.8	4.560	71	2.795	2.2	.086
12.50	.492	39.7	1.563	3	14	860.1-1250-039A0-GM	★	★	★	★	★	14.0	.551	107	4.213	104.7	4.123	60	2.362	2.3	.090
12.60	.496	40.0	1.575	3	14	860.1-1260-039A0-GM	★	★	★	★	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.090
13.00	.512	43.0	1.693	3	14	860.1-1300-038A0-GM	★	★	★	★	★	14.0	.551	107	4.213	104.6	4.119	60	2.362	2.4	.093
14.00	.551	43.0	1.693	3	14	860.1-1400-038A0-GM	★	★	★	★	★	14.0	.551	107	4.213	104.5	4.112	60	2.362	2.5	.100
14.00	.551	60.0	2.362	4	14	860.1-1400-055A0-GM	★	★	★	★	★	14.0	.551	124	4.882	121.5	4.782	77	3.032	2.5	.100



B76



E9



E28



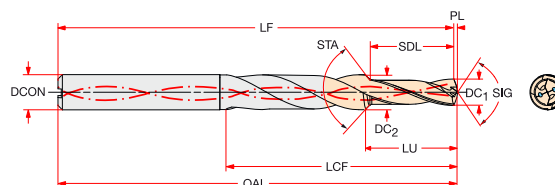
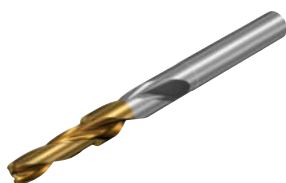
E14

CoroDrill® 860 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°



Fas- und Stufenbohrer

											P	M	K	N	S	H	Abmessungen, mm, Zoll									
DC ₁	DC ₁ [°]	DC ₂	DC ₂ [°]	SDL	SDL [°]	STA	LU	LU [°]	CZC _{MS}	Bestellnummer	X _{TBM}	X _{TBM}	X _{TBM}	X _{TBM}	X _{TBM}	X _{TBM}	DCON _{MS}	DCON _{MS} [°]	OAL	OAL [°]	LF	LF [°]	LCF	LCF [°]	PL	PL [°]
3.35	.132	4.50	.177	10.10	.398	90°	11.3	.445	6	860.2-0335-011A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	61.4	2.417	19	.748	0.6	.024
3.40	.134	4.60	.181	10.20	.402	90°	11.4	.449	6	860.2-0340-011A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	19	.748	0.6	.024
4.25	.167	5.70	.224	12.80	.504	90°	14.3	.563	6	860.2-0425-014A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	23	.906	0.7	.028
4.30	.169	5.80	.228	13.00	.512	90°	14.5	.571	6	860.2-0430-014A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	23	.906	0.7	.028
4.65	.183	5.90	.232	14.00	.551	90°	15.5	.610	6	860.2-0465-015A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	23	.906	0.8	.031
5.00	.197	6.80	.268	15.00	.591	90°	16.8	.661	8	860.2-0500-016A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	28	1.102	0.8	.031
5.10	.201	6.90	.272	15.30	.602	90°	17.1	.673	8	860.2-0510-017A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
5.50	.217	7.40	.291	16.60	.654	90°	18.6	.732	8	860.2-0550-018A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
5.55	.219	7.50	.295	16.70	.657	90°	18.7	.736	8	860.2-0555-018A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
6.60	.260	8.90	.350	19.90	.783	90°	22.3	.878	10	860.2-0660-022A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.9	3.461	37	1.457	1.1	.043
6.75	.266	9.10	.358	20.30	.799	90°	22.7	.894	10	860.2-0675-022A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
6.85	.270	9.20	.362	20.60	.811	90°	23.0	.906	10	860.2-0685-023A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
6.90	.272	9.30	.366	20.70	.815	90°	23.2	.913	10	860.2-0690-023A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
7.00	.276	9.50	.374	21.10	.831	90°	23.6	.929	10	860.2-0700-023A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
7.40	.291	9.80	.386	22.20	.874	90°	24.7	.972	10	860.2-0740-024A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.7	3.453	37	1.457	1.3	.051
8.00	.315	10.80	.425	24.00	.945	90°	26.9	1.059	12	860.2-0800-026A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.6	3.961	42	1.654	1.4	.055
8.50	.335	11.50	.453	25.50	1.004	90°	28.5	1.122	12	860.2-0850-028A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
8.60	.339	11.60	.457	25.80	1.016	90°	28.9	1.138	12	860.2-0860-028A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
8.70	.343	11.70	.461	26.10	1.028	90°	29.2	1.150	12	860.2-0870-029A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
9.00	.354	11.80	.465	27.00	1.063	90°	30.0	1.181	12	860.2-0900-030A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
10.25	.404	13.80	.543	30.80	1.213	90°	34.4	1.354	14	860.2-1025-034A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.30	.406	13.80	.543	31.00	1.220	90°	34.6	1.362	14	860.2-1030-034A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.40	.409	13.80	.543	31.20	1.228	90°	34.8	1.370	14	860.2-1040-034A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.50	.413	13.80	.543	31.60	1.244	90°	35.2	1.386	14	860.2-1050-035A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
12.00	.472	15.80	.622	36.00	1.417	90°	40.1	1.579	16	860.2-1200-040A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.9	4.445	59	2.323	2.1	.083
14.00	.551	18.90	.744	42.10	1.657	90°	47.1	1.854	20	860.2-1400-047A1-GM	★	★	★	★	★	★	20.0	.787	131	5.157	128.6	5.063	78	3.071	2.4	.094



B76



E9



E28



E14

CoroDrill® 860

Für Stahl optimierter Hochleistungsbohrer

Anwendungsbereich

860-PM: Lang und kurz spanende Stahlwerkstoffe wie unlegierte Stähle, Stähle mit niedrigem Kohlenstoffgehalt, niedriglegierte Stähle, hoch legierte Stähle und Stahlguss

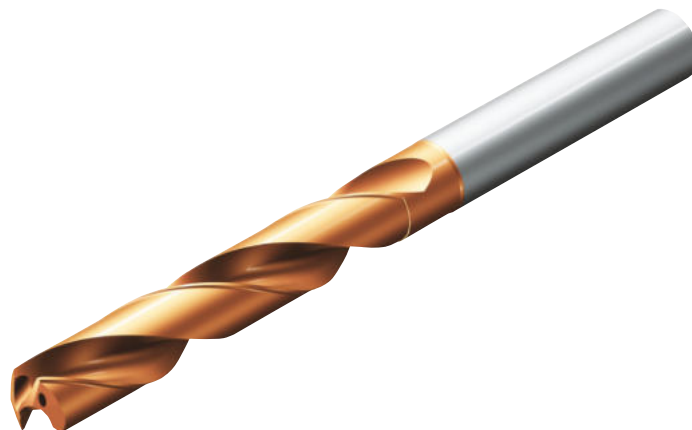


ISO-Anwendungsbereich:



Merkmale und Vorteile

- Verbesserte Schnittdaten
- Geringe Kosten pro Bohrung
- Zuverlässigere Leistung
- Optimale Spanabfuhr
- Hohe Standzeit, kontrollierter Verschleiß
- Konstante Bohrungstoleranz
- Kann bis zu dreimal gemäß Originalspezifikation nachgeschliffen werden



www.sandvik.coromant.com/corodril860

Empfehlungen

Wir empfehlen die Verwendung von hydraulischen Präzisionsspannfuttern.

Es wird eine innere Kühlschmierstoffzufuhr mit einem Mindestdruck von 20 bar empfohlen.

Für Spannfutter, siehe Katalog Rotierende Werkzeuge.

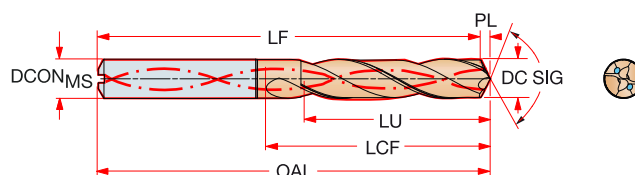


E14

CoroDrill® 860 Vollhartmetallbohrer

Für Stahl

Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 147°

							p	Abmessungen, mm, Zoll												
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	4234	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG
3.00	.118	9.5	.374	3	6	860.1-0300-016A1-PM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.00	.118	15.5	.610	5	6	860.1-0300-021A1-PM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.00	.118	24.5	.965	8	6	860.1-0300-029A1-PM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.10	.122	9.8	.386	3	6	860.1-0310-016A1-PM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.10	.122	16.0	.630	5	6	860.1-0310-021A1-PM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.10	.122	25.3	.996	8	6	860.1-0310-029A1-PM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.17	.125	10.0	.394	3	6	860.1-0317-016A1-PM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.17	.125	16.4	.646	5	6	860.1-0317-021A1-PM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.17	.125	25.9	1.020	8	6	860.1-0317-029A1-PM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.20	.126	10.1	.398	3	6	860.1-0320-016A1-PM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.20	.126	16.5	.650	5	6	860.1-0320-021A1-PM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.20	.126	26.1	1.028	8	6	860.1-0320-029A1-PM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.30	.130	10.5	.413	3	6	860.1-0330-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.30	.130	17.1	.673	5	6	860.1-0330-021A1-PM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.30	.130	27.0	1.063	8	6	860.1-0330-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.40	.134	10.8	.425	3	6	860.1-0340-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.40	.134	17.6	.693	5	6	860.1-0340-021A1-PM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.40	.134	27.5	1.083	8	6	860.1-0340-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.45	.136	27.4	1.079	7	6	860.1-0345-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.50	.138	11.1	.437	3	6	860.1-0350-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.50	.138	18.1	.713	5	6	860.1-0350-021A1-PM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.50	.138	27.3	1.075	7	6	860.1-0350-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.55	.140	11.2	.441	3	6	860.1-0355-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.57	.141	27.1	1.067	7	6	860.1-0357-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.60	.142	27.1	1.067	7	6	860.1-0360-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.70	.146	11.7	.461	3	6	860.1-0370-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.70	.146	19.1	.752	5	6	860.1-0370-021A1-PM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.70	.146	27.9	1.098	7	6	860.1-0370-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	COROMANT
3.80	.150	12.1	.476	3	6	860.1-0380-018A1-PM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
3.80	.150	31.1	1.224	8	6	860.1-0380-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
3.90	.154	20.2	.795	5	6	860.1-0390-027A1-PM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
3.90	.154	31.9	1.256	8	6	860.1-0390-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
3.97	.156	32.4	1.276	8	6	860.1-0397-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
4.00	.157	12.7	.500	3	6	860.1-0400-018A1-PM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.00	.157	20.7	.815	5	6	860.1-0400-027A1-PM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.00	.157	32.7	1.287	8	6	860.1-0400-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
4.10	.161	13.0	.512	3	6	860.1-0410-018A1-PM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.10	.161	21.2	.835	5	6	860.1-0410-027A1-PM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.10	.161	33.5	1.319	8	6	860.1-0410-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT
4.20	.165	13.3	.524	3	6	860.1-0420-018A1-PM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.20	.165	21.7	.854	5	6	860.1-0420-027A1-PM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.20	.165	34.3	1.350	8	6	860.1-0420-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT
4.30	.169	13.7	.539	3	6	860.1-0430-018A1-PM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031	20	290	DIN 6537 K
4.30	.169	22.3	.878	5	6	860.1-0430-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.30	.169	35.2	1.386	8	6	860.1-0430-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	45	1.772	0.8	.031	20	290	COROMANT
4.40	.173	22.8	.898	5	6	860.1-0440-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.40	.173	36.0	1.417	8	6	860.1-0440-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	45	1.772	0.8	.031	20	290	COROMANT
4.50	.177	14.3	.563	3	6	860.1-0450-018A1-PM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031	20	290	DIN 6537 K
4.50	.177	23.3	.917	5	6	860.1-0450-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.50	.177	36.8	1.449	8	6	860.1-0450-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	46	1.811	0.8	.031	20	290	COROMANT
4.55	.179	23.5	.925	5	6	860.1-0455-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L



B76



E9



E28



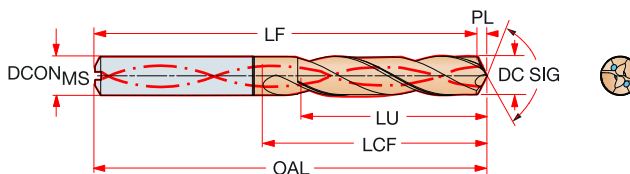
E14



CoroDrill® 860 Vollhartmetallbohrer

Für Stahl

Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 147°

							p	Abmessungen, mm, Zoll												
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	4234	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG
4.60	.181	14.6	.575	3	6	860.1-0460-018A1-PM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031	20	290	DIN 6537 K
4.60	.181	23.8	.937	5	6	860.1-0460-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.60	.181	36.8	1.449	8	6	860.1-0460-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	46	1.811	0.8	.031	20	290	COROMANT
4.70	.185	36.6	1.441	7	6	860.1-0470-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	46	1.811	0.8	.031	20	290	COROMANT
4.76	.187	15.0	.591	3	6	860.1-0476-019A1-PM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
4.76	.187	36.5	1.437	7	6	860.1-0476-037A1-PM	★	6.0	.236	97	3.819	96.2	3.787	46	1.811	0.8	.031	20	290	COROMANT
4.76	.187	38.8	1.528	8	6	860.1-0476-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	56	2.205	0.8	.031	20	290	COROMANT
4.80	.189	15.2	.598	3	6	860.1-0480-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
4.80	.189	24.8	.976	5	6	860.1-0480-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
4.80	.189	39.2	1.543	8	6	860.1-0480-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	56	2.205	0.8	.031	20	290	COROMANT
4.90	.193	15.5	.610	3	6	860.1-0490-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
4.90	.193	25.3	.996	5	6	860.1-0490-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
4.90	.193	40.0	1.575	8	6	860.1-0490-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	56	2.205	0.8	.031	20	290	COROMANT
5.00	.197	15.8	.622	3	6	860.1-0500-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.00	.197	25.8	1.016	5	6	860.1-0500-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.00	.197	40.8	1.606	8	6	860.1-0500-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.10	.201	16.1	.634	3	6	860.1-0510-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.10	.201	26.3	1.035	5	6	860.1-0510-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.10	.201	41.6	1.638	8	6	860.1-0510-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.16	.203	26.6	1.047	5	6	860.1-0516-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.16	.203	42.1	1.657	8	6	860.1-0516-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.20	.205	16.4	.646	3	6	860.1-0520-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.20	.205	26.8	1.055	5	6	860.1-0520-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.20	.205	42.4	1.669	8	6	860.1-0520-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.30	.209	16.7	.657	3	6	860.1-0530-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.30	.209	27.3	1.075	5	6	860.1-0530-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.40	.213	17.0	.669	3	6	860.1-0540-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.40	.213	27.8	1.094	5	6	860.1-0540-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.40	.213	44.0	1.732	8	6	860.1-0540-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.50	.217	17.4	.685	3	6	860.1-0550-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.50	.217	28.4	1.118	5	6	860.1-0550-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.50	.217	44.9	1.768	8	6	860.1-0550-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	57	2.244	0.9	.035	20	290	COROMANT
5.56	.219	28.7	1.130	5	6	860.1-0555-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.56	.219	17.5	.689	3	6	860.1-0556-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.56	.219	28.7	1.130	5	6	860.1-0556-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.56	.219	45.3	1.783	8	6	860.1-0556-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.60	.220	17.7	.697	3	6	860.1-0560-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.60	.220	28.9	1.138	5	6	860.1-0560-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.60	.220	45.7	1.799	8	6	860.1-0560-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.70	.224	29.4	1.157	5	6	860.1-0570-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.70	.224	46.5	1.831	8	6	860.1-0570-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.80	.228	17.6	.693	3	6	860.1-0580-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.80	.228	29.9	1.177	5	6	860.1-0580-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.80	.228	47.3	1.862	8	6	860.1-0580-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.90	.232	17.4	.685	2	6	860.1-0590-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.90	.232	30.4	1.197	5	6	860.1-0590-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.90	.232	47.4	1.866	8	6	860.1-0590-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.95	.234	17.3	.681	2	6	860.1-0595-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.95	.234	30.7	1.209	5	6	860.1-0595-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
6.00	.236	18.9	.744	3	6	860.1-0600-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
6.00	.236	30.9	1.217	5	6	860.1-0600-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
6.00	.236	48.9	1.925	8	6	860.1-0600-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT



B76



E9



E28

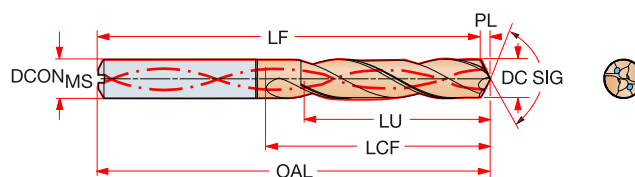


E14

CoroDrill® 860 Vollhartmetallbohrer

Für Stahl

Innere Kühlschmierstoffzufuhr

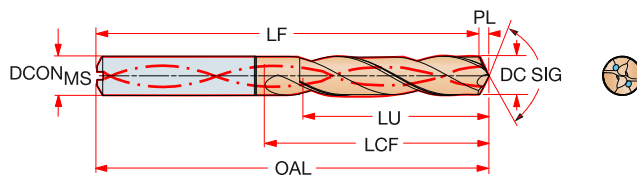
TCHA H8
SIG 147°

							p	Abmessungen, mm, Zoll												
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	4234	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG
6.10	.240	19.3	.760	3	8	860.1-0610-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.10	.240	31.5	1.240	5	8	860.1-0610-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.10	.240	49.8	1.961	8	8	860.1-0610-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	66	2.598	1.0	.039	20	290	COROMANT
6.20	.244	19.6	.772	3	8	860.1-0620-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.20	.244	32.0	1.260	5	8	860.1-0620-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.20	.244	50.6	1.992	8	8	860.1-0620-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.30	.248	19.9	.783	3	8	860.1-0630-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.30	.248	32.5	1.280	5	8	860.1-0630-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.30	.248	51.4	2.024	8	8	860.1-0630-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.35	.250	20.1	.791	3	8	860.1-0635-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.35	.250	32.8	1.291	5	8	860.1-0635-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.35	.250	51.8	2.039	8	8	860.1-0635-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.40	.252	20.2	.795	3	8	860.1-0640-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.40	.252	33.0	1.299	5	8	860.1-0640-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.40	.252	52.2	2.055	8	8	860.1-0640-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.50	.256	20.6	.811	3	8	860.1-0650-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.50	.256	33.6	1.323	5	8	860.1-0650-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.50	.256	53.1	2.091	8	8	860.1-0650-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.60	.260	20.9	.823	3	8	860.1-0660-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.60	.260	34.1	1.343	5	8	860.1-0660-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.60	.260	53.9	2.122	8	8	860.1-0660-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.70	.264	21.2	.835	3	8	860.1-0670-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.70	.264	34.6	1.362	5	8	860.1-0670-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.70	.264	54.7	2.154	8	8	860.1-0670-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.75	.266	21.3	.839	3	8	860.1-0675-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.75	.266	34.8	1.370	5	8	860.1-0675-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.75	.266	55.1	2.169	8	8	860.1-0675-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.80	.268	21.5	.846	3	8	860.1-0680-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.80	.268	35.1	1.382	5	8	860.1-0680-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.80	.268	55.5	2.185	8	8	860.1-0680-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.90	.272	21.8	.858	3	8	860.1-0690-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.90	.272	35.6	1.402	5	8	860.1-0690-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.90	.272	56.3	2.217	8	8	860.1-0690-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	68	2.677	1.1	.043	20	290	COROMANT
7.00	.276	22.1	.870	3	8	860.1-0700-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
7.00	.276	36.1	1.421	5	8	860.1-0700-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.00	.276	57.1	2.248	8	8	860.1-0700-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	68	2.677	1.1	.043	20	290	COROMANT
7.10	.280	22.4	.882	3	8	860.1-0710-028A1-PM	★	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.10	.280	36.6	1.441	5	8	860.1-0710-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.14	.281	22.6	.890	3	8	860.1-0714-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.14	.281	36.9	1.453	5	8	860.1-0714-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.14	.281	58.3	2.295	8	8	860.1-0714-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.20	.283	22.8	.898	3	8	860.1-0720-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.20	.283	37.2	1.465	5	8	860.1-0720-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.30	.287	37.7	1.484	5	8	860.1-0730-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.30	.287	59.6	2.346	8	8	860.1-0730-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.40	.291	23.4	.921	3	8	860.1-0740-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.40	.291	38.2	1.504	5	8	860.1-0740-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.40	.291	60.4	2.378	8	8	860.1-0740-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.50	.295	23.7	.933	3	8	860.1-0750-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.50	.295	38.7	1.524	5	8	860.1-0750-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.50	.295	61.2	2.409	8	8	860.1-0750-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.54	.297	38.9	1.532	5	8	860.1-0754-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L

CoroDrill® 860 Vollhartmetallbohrer

Für Stahl

Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 147°

						p Abmessungen, mm, Zoll																
						Bestellnummer	4234															
DC	DC*	LU	LU*	ULDR	CZC _{MS}			DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG		
7.60	.299	24.0	.945	3	8	860.1-0760-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K		
7.60	.299	62.0	2.441	8	8	860.1-0760-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT		
7.70	.303	24.3	.957	3	8	860.1-0770-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K		
7.70	.303	39.7	1.563	5	8	860.1-0770-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L		
7.70	.303	62.8	2.472	8	8	860.1-0770-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	78	3.071	1.2	.047	20	290	COROMANT		
7.80	.307	24.7	.972	3	8	860.1-0780-028A1-PM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K		
7.80	.307	40.3	1.587	5	8	860.1-0780-040A1-PM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L		
7.80	.307	63.7	2.508	8	8	860.1-0780-064A1-PM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT		
7.90	.311	25.0	.984	3	8	860.1-0790-028A1-PM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K		
7.90	.311	40.8	1.606	5	8	860.1-0790-040A1-PM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L		
7.94	.313	25.1	.988	3	8	860.1-0794-028A1-PM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K		
7.94	.313	41.0	1.614	5	8	860.1-0794-040A1-PM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L		
7.94	.313	64.8	2.551	8	8	860.1-0794-064A1-PM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT		
8.00	.315	25.3	.996	3	8	860.1-0800-028A1-PM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K		
8.00	.315	41.3	1.626	5	8	860.1-0800-040A1-PM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L		
8.00	.315	65.3	2.571	8	8	860.1-0800-064A1-PM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT		
8.10	.319	25.6	1.008	3	10	860.1-0810-031A1-PM	★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
8.10	.319	41.8	1.646	5	10	860.1-0810-045A1-PM	★	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.10	.319	66.1	2.602	8	10	860.1-0810-080A1-PM	★	10.0	.394	139	5.472	137.7	5.421	94	3.701	1.3	.051	20	290	COROMANT		
8.15	.321	42.1	1.657	5	10	860.1-0815-045A1-PM	★	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.20	.323	25.9	1.020	3	10	860.1-0820-031A1-PM	★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K		
8.20	.323	42.3	1.665	5	10	860.1-0820-045A1-PM	★	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L		
8.20	.323	66.9	2.634	8	10	860.1-0820-080A1-PM	★	10.0	.394	139	5.472	137.7	5.421	94	3.701	1.3	.051	20	290	COROMANT		
8.30	.327	26.3	1.035	3	10	860.1-0830-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
8.30	.327	42.9	1.689	5	10	860.1-0830-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
8.30	.327	67.8	2.669	8	10	860.1-0830-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	94	3.701	1.4	.055	20	290	COROMANT		
8.33	.328	43.0	1.693	5	10	860.1-0833-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
8.40	.331	26.6	1.047	3	10	860.1-0840-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
8.40	.331	43.4	1.709	5	10	860.1-0840-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
8.40	.331	68.6	2.701	8	10	860.1-0840-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	94	3.701	1.4	.055	20	290	COROMANT		
8.50	.335	26.9	1.059	3	10	860.1-0850-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
8.50	.335	43.9	1.728	5	10	860.1-0850-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
8.50	.335	69.4	2.732	8	10	860.1-0850-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT		
8.60	.339	27.2	1.071	3	10	860.1-0860-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
8.60	.339	44.4	1.748	5	10	860.1-0860-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
8.60	.339	70.2	2.764	8	10	860.1-0860-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT		
8.70	.343	27.5	1.083	3	10	860.1-0870-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
8.70	.343	44.9	1.768	5	10	860.1-0870-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
8.70	.343	71.0	2.795	8	10	860.1-0870-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT		
8.73	.344	27.6	1.087	3	10	860.1-0873-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
8.73	.344	45.1	1.776	5	10	860.1-0873-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
8.73	.344	71.3	2.807	8	10	860.1-0873-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT		
8.80	.346	27.8	1.094	3	10	860.1-0880-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K		
8.80	.346	45.4	1.787	5	10	860.1-0880-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
8.80	.346	71.8	2.827	8	10	860.1-0880-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT		
8.90	.350	45.9	1.807	5	10	860.1-0890-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L		
9.00	.354	28.5	1.122	3	10	860.1-0900-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K		
9.00	.354	46.5	1.831	5	10	860.1-0900-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L		
9.00	.354	73.5	2.894	8	10	860.1-0900-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT		
9.10	.358	28.8	1.134	3	10	860.1-0910-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K		
9.10	.358	47.0	1.850	5	10	860.1-0910-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L		
9.10	.358	74.3	2.925	8	10	860.1-0910-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT		



B76



E9



E28

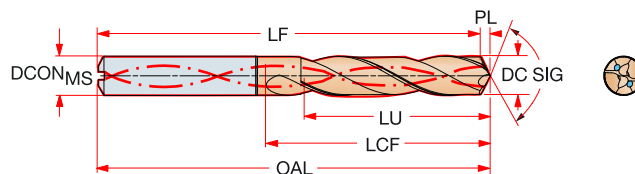


E14

CoroDrill® 860 Vollhartmetallbohrer

Für Stahl

Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 147°

							p	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	4234	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG	
9.20	.362	29.1	1.146	3	10	860.1-0920-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.20	.362	47.5	1.870	5	10	860.1-0920-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.20	.362	75.1	2.957	8	10	860.1-0920-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT	
9.30	.366	29.4	1.157	3	10	860.1-0930-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.30	.366	48.0	1.890	5	10	860.1-0930-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.30	.366	75.9	2.988	8	10	860.1-0930-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT	
9.40	.370	29.7	1.169	3	10	860.1-0940-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.40	.370	48.5	1.909	5	10	860.1-0940-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.40	.370	76.7	3.020	8	10	860.1-0940-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT	
9.50	.374	30.0	1.181	3	10	860.1-0950-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.50	.374	48.7	1.917	5	10	860.1-0950-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.50	.374	77.5	3.051	8	10	860.1-0950-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT	
9.52	.375	30.1	1.185	3	10	860.1-0952-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.52	.375	48.6	1.913	5	10	860.1-0952-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.52	.375	77.7	3.059	8	10	860.1-0952-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT	
9.55	.376	48.6	1.913	5	10	860.1-0955-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.60	.378	30.3	1.193	3	10	860.1-0960-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K	
9.60	.378	48.5	1.909	5	10	860.1-0960-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L	
9.60	.378	78.3	3.083	8	10	860.1-0960-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT	
9.70	.382	30.7	1.209	3	10	860.1-0970-031A1-PM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K	
9.70	.382	79.2	3.118	8	10	860.1-0970-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT	
9.80	.386	31.0	1.220	3	10	860.1-0980-031A1-PM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K	
9.80	.386	48.3	1.902	4	10	860.1-0980-045A1-PM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L	
9.80	.386	80.0	3.150	8	10	860.1-0980-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT	
9.90	.390	31.3	1.232	3	10	860.1-0990-031A1-PM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K	
9.90	.390	48.1	1.894	4	10	860.1-0990-045A1-PM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L	
9.90	.390	80.8	3.181	8	10	860.1-0990-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT	
9.92	.391	81.0	3.189	8	10	860.1-0992-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT	
10.00	.394	31.6	1.244	3	10	860.1-1000-031A1-PM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K	
10.00	.394	48.0	1.890	4	10	860.1-1000-045A1-PM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L	
10.00	.394	81.6	3.213	8	10	860.1-1000-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT	
10.10	.398	31.9	1.256	3	12	860.1-1010-037A1-PM	★	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K	
10.10	.398	52.1	2.051	5	12	860.1-1010-053A1-PM	★	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L	
10.10	.398	82.4	3.244	8	12	860.1-1010-098A1-PM	★	12.0	.472	163	6.417	161.4	6.354	114	4.488	1.6	.063	20	290	COROMANT	
10.20	.402	32.3	1.272	3	12	860.1-1020-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K	
10.20	.402	52.7	2.075	5	12	860.1-1020-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	
10.20	.402	83.3	3.280	8	12	860.1-1020-098A1-PM	★	12.0	.472	163	6.417	161.3	6.350	114	4.488	1.7	.067	20	290	COROMANT	
10.30	.406	32.6	1.283	3	12	860.1-1030-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K	
10.30	.406	53.2	2.094	5	12	860.1-1030-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	
10.30	.406	84.1	3.311	8	12	860.1-1030-098A1-PM	★	12.0	.472	163	6.417	161.3	6.350	114	4.488	1.7	.067	20	290	COROMANT	
10.32	.406	32.6	1.283	3	12	860.1-1032-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K	
10.32	.406	53.3	2.098	5	12	860.1-1032-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	
10.40	.409	32.9	1.295	3	12	860.1-1040-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K	
10.40	.409	53.7	2.114	5	12	860.1-1040-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	
10.40	.409	84.9	3.343	8	12	860.1-1040-098A1-PM	★	12.0	.472	163	6.417	161.3	6.350	115	4.528	1.7	.067	20	290	COROMANT	
10.50	.413	33.2	1.307	3	12	860.1-1050-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K	
10.50	.413	54.2	2.134	5	12	860.1-1050-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	
10.50	.413	85.7	3.374	8	12	860.1-1050-098A1-PM	★	12.0	.472	163	6.417	161.3	6.350	115	4.528	1.7	.067	20	290	COROMANT	
10.60	.417	54.7	2.154	5	12	860.1-1060-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	
10.70	.421	33.8	1.331	3	12	860.1-1070-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K	
10.70	.421	55.2	2.173	5	12	860.1-1070-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	
10.71	.422	55.3	2.177	5	12	860.1-1071-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L	



B76



E9



E28



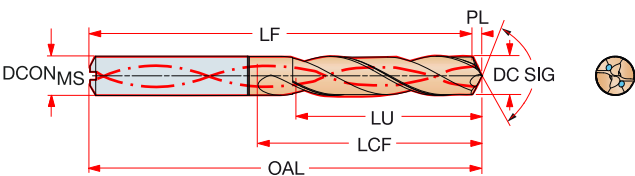
E14



CoroDrill® 860 Vollhartmetallbohrer

Für Stahl
Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 147°



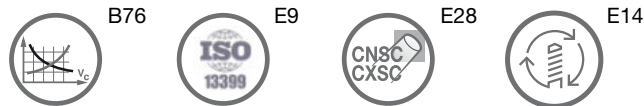
B

							p Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	4234	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG
10.80	.425	34.2	1.346	3	12	860.1-1080-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
10.80	.425	55.8	2.197	5	12	860.1-1080-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
10.80	.425	88.2	3.472	8	12	860.1-1080-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
10.90	.429	56.3	2.217	5	12	860.1-1090-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.00	.433	34.8	1.370	3	12	860.1-1100-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.00	.433	56.8	2.236	5	12	860.1-1100-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.00	.433	89.8	3.535	8	12	860.1-1100-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.10	.437	35.1	1.382	3	12	860.1-1110-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.10	.437	57.3	2.256	5	12	860.1-1110-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.10	.437	90.6	3.567	8	12	860.1-1110-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.11	.437	35.1	1.382	3	12	860.1-1111-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.11	.437	90.7	3.571	8	12	860.1-1111-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.20	.441	35.4	1.394	3	12	860.1-1120-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.20	.441	57.6	2.268	5	12	860.1-1120-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.20	.441	91.4	3.598	8	12	860.1-1120-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.30	.445	35.7	1.406	3	12	860.1-1130-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.30	.445	57.4	2.260	5	12	860.1-1130-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.30	.445	92.2	3.630	8	12	860.1-1130-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.40	.449	36.1	1.421	3	12	860.1-1140-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.50	.453	36.4	1.433	3	12	860.1-1150-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.50	.453	57.2	2.252	4	12	860.1-1150-053A1-PM	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.50	.453	93.9	3.697	8	12	860.1-1150-098A1-PM	★	12.0	.472	163	6.417	161.1	6.343	116	4.567	1.9	.075	20	290	COROMANT
11.60	.457	36.7	1.445	3	12	860.1-1160-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.70	.461	37.0	1.457	3	12	860.1-1170-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.70	.461	57.0	2.244	4	12	860.1-1170-053A1-PM	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.80	.465	37.3	1.469	3	12	860.1-1180-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.80	.465	56.8	2.236	4	12	860.1-1180-053A1-PM	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.80	.465	96.3	3.791	8	12	860.1-1180-098A1-PM	★	12.0	.472	163	6.417	161.1	6.343	116	4.567	1.9	.075	20	290	COROMANT
11.90	.469	37.6	1.480	3	12	860.1-1190-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.90	.469	97.1	3.823	8	12	860.1-1190-098A1-PM	★	12.0	.472	163	6.417	161.1	6.343	116	4.567	1.9	.075	20	290	COROMANT
12.00	.472	38.0	1.496	3	12	860.1-1200-037A1-PM	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079	20	290	DIN 6537 K
12.00	.472	56.6	2.228	4	12	860.1-1200-053A1-PM	★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079	20	290	DIN 6537 L
12.00	.472	98.0	3.858	8	12	860.1-1200-098A1-PM	★	12.0	.472	163	6.417	161.0	6.339	116	4.567	2.0	.079	20	290	COROMANT
12.10	.476	38.3	1.508	3	14	860.1-1210-040A1-PM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.10	.476	62.5	2.461	5	14	860.1-1210-057A1-PM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.10	.476	98.8	3.890	8	14	860.1-1210-115A1-PM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.20	.480	38.6	1.520	3	14	860.1-1220-040A1-PM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.20	.480	62.4	2.457	5	14	860.1-1220-057A1-PM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.20	.480	99.6	3.921	8	14	860.1-1220-115A1-PM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.30	.484	38.9	1.532	3	14	860.1-1230-040A1-PM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.30	.484	62.2	2.449	5	14	860.1-1230-057A1-PM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.30	.484	100.4	3.953	8	14	860.1-1230-115A1-PM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.50	.492	39.5	1.555	3	14	860.1-1250-040A1-PM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.50	.492	62.0	2.441	4	14	860.1-1250-057A1-PM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.50	.492	102.0	4.016	8	14	860.1-1250-115A1-PM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.60	.496	39.9	1.571	3	14	860.1-1260-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
12.70	.500	40.2	1.583	3	14	860.1-1270-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
12.70	.500	61.8	2.433	4	14	860.1-1270-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
12.70	.500	103.7	4.083	8	14	860.1-1270-115A1-PM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT
12.80	.504	40.5	1.594	3	14	860.1-1280-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
12.80	.504	61.6	2.425	4	14	860.1-1280-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
12.80	.504	104.5	4.114	8	14	860.1-1280-115A1-PM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT

C

D

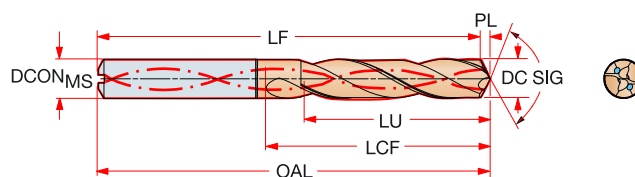
E



CoroDrill® 860 Vollhartmetallbohrer

Für Stahl

Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 147°

									p Abmessungen, mm, Zoll												
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	4234	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG	
13.00	.512	41.1	1.618	3	14	860.1-1300-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K	
13.00	.512	61.4	2.417	4	14	860.1-1300-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L	
13.00	.512	106.1	4.177	8	14	860.1-1300-115A1-PM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT	
13.10	.516	41.4	1.630	3	14	860.1-1310-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K	
13.10	.516	61.3	2.413	4	14	860.1-1310-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L	
13.10	.516	106.9	4.209	8	14	860.1-1310-115A1-PM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT	
13.25	.522	61.1	2.406	4	14	860.1-1325-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L	
13.50	.531	42.7	1.681	3	14	860.1-1350-040A1-PM	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.2	.087	20	290	DIN 6537 K	
13.50	.531	60.8	2.394	4	14	860.1-1350-057A1-PM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L	
13.50	.531	110.2	4.339	8	14	860.1-1350-115A1-PM	★	14.0	.551	182	7.165	179.8	7.079	134	5.276	2.2	.087	20	290	COROMANT	
13.75	.541	60.5	2.382	4	14	860.1-1375-057A1-PM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L	
13.80	.543	43.4	1.709	3	14	860.1-1380-040A1-PM	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.2	.087	20	290	DIN 6537 K	
13.80	.543	60.4	2.378	4	14	860.1-1380-057A1-PM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L	
13.80	.543	112.6	4.433	8	14	860.1-1380-115A1-PM	★	14.0	.551	182	7.165	179.8	7.079	134	5.276	2.2	.087	20	290	COROMANT	
13.89	.547	60.3	2.374	4	14	860.1-1389-057A1-PM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L	
14.00	.551	44.3	1.744	3	14	860.1-1400-040A1-PM	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.091	20	290	DIN 6537 K	
14.00	.551	63.0	2.480	4	14	860.1-1400-057A1-PM	★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.3	.091	20	290	DIN 6537 L	
14.00	.551	114.3	4.500	8	14	860.1-1400-115A1-PM	★	14.0	.551	182	7.165	179.7	7.075	134	5.276	2.3	.091	20	290	COROMANT	
14.25	.561	45.0	1.772	3	16	860.1-1425-044A1-PM	★	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K	
14.25	.561	68.8	2.709	4	16	860.1-1425-062A1-PM	★	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L	
14.29	.563	45.2	1.780	3	16	860.1-1429-044A1-PM	★	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K	
14.29	.563	68.7	2.705	4	16	860.1-1429-062A1-PM	★	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L	
14.50	.571	45.8	1.803	3	16	860.1-1450-044A1-PM	★	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K	
14.50	.571	68.5	2.697	4	16	860.1-1450-062A1-PM	★	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L	
14.69	.578	46.4	1.827	3	16	860.1-1469-044A1-PM	★	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K	
14.80	.583	68.2	2.685	4	16	860.1-1480-062A1-PM	★	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L	
15.00	.591	47.4	1.866	3	16	860.1-1500-044A1-PM	★	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	20	290	DIN 6537 K	
15.00	.591	68.0	2.677	4	16	860.1-1500-062A1-PM	★	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L	
15.50	.610	49.0	1.929	3	16	860.1-1550-044A1-PM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K	
15.50	.610	67.5	2.657	4	16	860.1-1550-062A1-PM	★	16.0	.630	133	5.236	130.5	5.138	83	3.268	2.5	.098	20	290	DIN 6537 L	
15.80	.622	49.2	1.937	3	16	860.1-1580-044A1-PM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K	
15.80	.622	67.2	2.646	4	16	860.1-1580-062A1-PM	★	16.0	.630	133	5.236	130.5	5.138	83	3.268	2.5	.098	20	290	DIN 6537 L	
15.87	.625	49.1	1.933	3	16	860.1-1587-044A1-PM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K	
16.00	.630	49.0	1.929	3	16	860.1-1600-044A1-PM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K	
16.00	.630	67.0	2.638	4	16	860.1-1600-062A1-PM	★	16.0	.630	133	5.236	130.5	5.138	83	3.268	2.5	.098	20	290	DIN 6537 L	
16.00	.630	130.5	5.138	8	16	860.1-1600-133A1-PM	★	16.0	.630	204	8.032	201.5	7.933	154	6.063	2.5	.098	20	290	COROMANT	
16.50	.650	52.1	2.051	3	18	860.1-1650-050A1-PM	★	18.0	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	20	290	DIN 6537 K	
16.50	.650	76.5	3.012	4	18	860.1-1650-070A1-PM	★	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	20	290	DIN 6537 L	
16.80	.661	53.0	2.087	3	18	860.1-1680-050A1-PM	★	18.0	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	20	290	DIN 6537 K	
17.00	.669	76.0	2.992	4	18	860.1-1700-070A1-PM	★	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	20	290	DIN 6537 L	
17.50	.689	55.2	2.173	3	18	860.1-1750-050A1-PM	★	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	20	290	DIN 6537 K	
17.50	.689	75.5	2.972	4	18	860.1-1750-070A1-PM	★	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	20	290	DIN 6537 L	
17.80	.701	75.2	2.961	4	18	860.1-1780-070A1-PM	★	18.0	.709	143	5.630	140.2	5.520	93	3.661	2.8	.110	20	290	DIN 6537 L	
18.00	.709	56.8	2.236	3	18	860.1-1800-050A1-PM	★	18.0	.709	123	4.843	120.2	4.732	73	2.874	2.8	.110	20	290	DIN 6537 K	
18.00	.709	78.6	3.094	4	18	860.1-1800-070A1-PM	★	18.0	.709	143	5.630	140.2	5.520	93	3.661	2.8	.110	20	290	DIN 6537 L	
18.50	.728	58.4	2.299	3	20	860.1-1850-055A1-PM	★	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	20	290	DIN 6537 K	
18.80	.740	59.3	2.335	3	20	860.1-1880-055A1-PM	★	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	20	290	DIN 6537 K	
18.80	.740	86.0	3.386	4	20	860.1-1880-077A1-PM	★	20.0	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	20	290	DIN 6537 L	
19.00	.748	59.9	2.358	3	20	860.1-1900-055A1-PM	★	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	20	290	DIN 6537 K	
20.00	.787	63.0	2.480	3	20	860.1-2000-055A1-PM	★	20.0	.787	131	5.157	127.9	5.035	79	3.110	3.1	.122	20	290	DIN 6537 K	



B76



E9



E28



E14



CoroDrill® 860

Für rostfreien Stahl optimierter Hochleistungsbohrer

B Anwendungsbereich

860-MM: Lang spanende rostfreie Stähle wie austenitische, super austenitische, ferritische und rostfreie Duplex-Stähle



C ISO-Anwendungsbereich:



C Merkmale und Vorteile

- Verbesserte Schnittdaten
- Geringe Kosten pro Bohrung
- Zuverlässigere Leistung
- Optimale Spanabfuhr
- Hohe Standzeit, kontrollierter Verschleiß
- Konstante Bohrungstoleranz
- Kann bis zu dreimal gemäß Originalspezifikation nachgeschliffen werden



www.sandvik.coromant.com/corodril860

D Empfehlungen

Wir empfehlen die Verwendung von hydraulischen Präzisionsspannfuttern.
Es wird eine innere Kühlschmierstoffzufuhr mit einem Mindestdruck von 20 bar empfohlen.

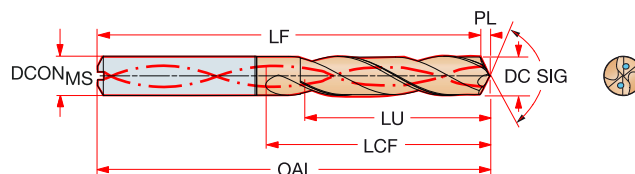
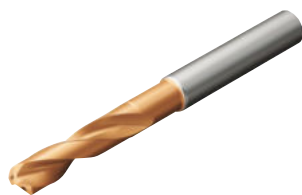
Für Spannfutter, siehe Katalog Rotierende Werkzeuge.



CoroDrill® 860 Vollhartmetallbohrer

Für rostfreien Stahl

Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 140°

							M	Abmessungen, mm, Zoll														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	2214	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG		
3.00	.118	9.5	.374	3	6	860.1-0300-009A1-MM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.00	.118	15.5	.610	5	6	860.1-0300-015A1-MM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.00	.118	24.0	.945	8	6	860.1-0300-024A1-MM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT		
3.10	.122	9.8	.386	3	6	860.1-0310-009A1-MM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.10	.122	25.0	.984	8	6	860.1-0310-025A1-MM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT		
3.18	.125	16.4	.646	5	6	860.1-0318-016A1-MM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.20	.126	16.5	.650	5	6	860.1-0320-016A1-MM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.30	.130	10.4	.409	3	6	860.1-0330-010A1-MM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K		
3.30	.130	17.0	.669	5	6	860.1-0330-017A1-MM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L		
3.30	.130	26.0	1.024	7	6	860.1-0330-026A1-MM	★	6.0	.236	74	2.913	73.5	2.894	35	1.378	0.5	.020	20	290	COROMANT		
3.40	.134	27.0	1.063	7	6	860.1-0340-027A1-MM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT		
3.50	.138	11.1	.437	3	6	860.1-0350-011A1-MM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K		
3.50	.138	18.1	.713	5	6	860.1-0350-018A1-MM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L		
3.50	.138	28.0	1.102	8	6	860.1-0350-028A1-MM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT		
3.60	.142	11.4	.449	3	6	860.1-0360-011A1-MM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K		
3.70	.146	19.1	.752	5	6	860.1-0370-019A1-MM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L		
3.70	.146	30.0	1.181	8	6	860.1-0370-030A1-MM	★	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	COROMANT		
3.80	.150	12.0	.472	3	6	860.1-0380-011A1-MM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K		
3.80	.150	19.6	.772	5	6	860.1-0380-019A1-MM	★	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L		
3.80	.150	30.0	1.181	7	6	860.1-0380-030A1-MM	★	6.0	.236	85	3.346	84.4	3.323	44	1.732	0.6	.024	20	290	COROMANT		
4.00	.157	12.7	.500	3	6	860.1-0400-012A1-MM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K		
4.00	.157	20.7	.815	5	6	860.1-0400-020A1-MM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L		
4.00	.157	32.0	1.260	8	6	860.1-0400-032A1-MM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT		
4.20	.165	13.3	.524	3	6	860.1-0420-013A1-MM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K		
4.20	.165	21.7	.854	5	6	860.1-0420-021A1-MM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L		
4.20	.165	34.0	1.339	8	6	860.1-0420-034A1-MM	★	6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT		
4.30	.169	13.6	.535	3	6	860.1-0430-013A1-MM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K		
4.30	.169	22.2	.874	5	6	860.1-0430-022A1-MM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L		
4.30	.169	34.0	1.339	7	6	860.1-0430-034A1-MM	★	6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT		
4.37	.172	13.8	.543	3	6	860.1-0437-013A1-MM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K		
4.37	.172	22.5	.886	5	6	860.1-0437-022A1-MM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L		
4.40	.173	13.9	.547	3	6	860.1-0440-013A1-MM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K		
4.40	.173	22.7	.894	5	6	860.1-0440-022A1-MM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L		
4.40	.173	35.0	1.378	7	6	860.1-0440-035A1-MM	★	6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT		
4.50	.177	14.2	.559	3	6	860.1-0450-014A1-MM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K		
4.50	.177	23.2	.913	5	6	860.1-0450-023A1-MM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L		
4.50	.177	36.0	1.417	8	6	860.1-0450-036A1-MM	★	6.0	.236	85	3.346	84.3	3.319	46	1.811	0.7	.028	20	290	COROMANT		
4.60	.181	23.8	.937	5	6	860.1-0460-023A1-MM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L		
4.60	.181	37.0	1.457	8	6	860.1-0460-037A1-MM	★	6.0	.236	85	3.346	84.2	3.315	46	1.811	0.8	.031	20	290	COROMANT		
4.70	.185	24.3	.957	5	6	860.1-0470-024A1-MM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L		
4.76	.187	15.1	.594	3	6	860.1-0476-014A1-MM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K		
4.80	.189	15.2	.598	3	6	860.1-0480-014A1-MM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K		
4.80	.189	38.0	1.496	7	6	860.1-0480-038A1-MM	★	6.0	.236	97	3.819	96.2	3.787	56	2.205	0.8	.031	20	290	COROMANT		
4.90	.193	25.3	.996	5	6	860.1-0490-025A1-MM	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L		
5.00	.197	15.8	.622	3	6	860.1-0500-015A1-MM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K		
5.00	.197	25.8	1.016	5	6	860.1-0500-025A1-MM	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L		
5.00	.197	40.0	1.575	8	6	860.1-0500-040A1-MM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT		
5.10	.201	16.1	.634	3	6	860.1-0510-015A1-MM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K		
5.10	.201	26.3	1.035	5	6	860.1-0510-026A1-MM	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L		
5.16	.203	16.3	.642	3	6	860.1-0516-016A1-MM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K		
5.20	.205	16.5	.650	3	6	860.1-0520-016A1-MM	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K		



B81



E9



E28

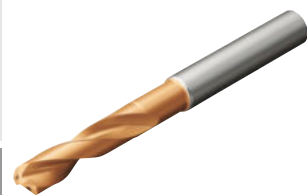
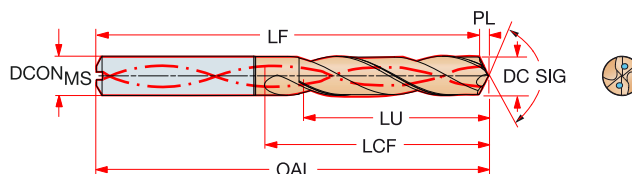


E14

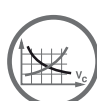
CoroDrill® 860 Vollhartmetallbohrer

Für rostfreien Stahl

Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 140°

											M Abmessungen, mm, Zoll										
											2014										
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer		DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG	
5.20	.205	26.9	1.059	5	6	860.1-0520-026A1-MM	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L	
5.30	.209	27.4	1.079	5	6	860.1-0530-027A1-MM	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L	
5.50	.217	17.4	.685	3	6	860.1-0550-017A1-MM	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K	
5.50	.217	28.4	1.118	5	6	860.1-0550-028A1-MM	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L	
5.50	.217	44.0	1.732	8	6	860.1-0550-044A1-MM	★	6.0	.236	97	3.819	96.1	3.783	57	2.244	0.9	.035	20	290	COROMANT	
5.56	.219	17.6	.693	3	6	860.1-0556-017A1-MM	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K	
5.80	.228	17.6	.693	3	6	860.1-0580-017A1-MM	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039	20	290	DIN 6537 K	
5.80	.228	46.0	1.811	7	6	860.1-0580-046A1-MM	★	6.0	.236	97	3.819	96.0	3.780	58	2.283	1.0	.039	20	290	COROMANT	
5.90	.232	30.5	1.201	5	6	860.1-0590-030A1-MM	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039	20	290	DIN 6537 L	
6.00	.236	19.0	.748	3	6	860.1-0600-018A1-MM	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039	20	290	DIN 6537 K	
6.00	.236	31.0	1.220	5	6	860.1-0600-030A1-MM	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039	20	290	DIN 6537 L	
6.00	.236	48.0	1.890	8	6	860.1-0600-048A1-MM	★	6.0	.236	97	3.819	96.0	3.780	58	2.283	1.0	.039	20	290	COROMANT	
6.10	.240	31.5	1.240	5	8	860.1-0610-031A1-MM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L	
6.10	.240	49.0	1.929	8	8	860.1-0610-049A1-MM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT	
6.20	.244	32.0	1.260	5	8	860.1-0620-031A1-MM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L	
6.20	.244	50.0	1.969	8	8	860.1-0620-050A1-MM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT	
6.35	.250	20.1	.791	3	8	860.1-0635-019A1-MM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K	
6.35	.250	32.8	1.291	5	8	860.1-0635-032A1-MM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L	
6.35	.250	51.0	2.008	8	8	860.1-0635-051A1-MM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT	
6.50	.256	20.6	.811	3	8	860.1-0650-020A1-MM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K	
6.50	.256	33.6	1.323	5	8	860.1-0650-033A1-MM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L	
6.50	.256	52.0	2.047	8	8	860.1-0650-052A1-MM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT	
6.60	.260	20.9	.823	3	8	860.1-0660-020A1-MM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K	
6.60	.260	34.1	1.343	5	8	860.1-0660-033A1-MM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L	
6.70	.264	34.6	1.362	5	8	860.1-0670-034A1-MM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L	
6.75	.266	21.3	.839	3	8	860.1-0675-020A1-MM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K	
6.80	.268	21.5	.846	3	8	860.1-0680-020A1-MM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K	
6.80	.268	35.1	1.382	5	8	860.1-0680-034A1-MM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L	
6.80	.268	54.0	2.126	7	8	860.1-0680-054A1-MM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT	
6.90	.272	21.8	.858	3	8	860.1-0690-021A1-MM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K	
6.90	.272	35.6	1.402	5	8	860.1-0690-035A1-MM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L	
6.90	.272	55.0	2.165	7	8	860.1-0690-055A1-MM	★	8.0	.315	106	4.173	104.9	4.130	68	2.677	1.1	.043	20	290	COROMANT	
7.00	.276	22.1	.870	3	8	860.1-0700-021A1-MM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K	
7.00	.276	36.1	1.421	5	8	860.1-0700-035A1-MM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L	
7.00	.276	56.0	2.205	8	8	860.1-0700-056A1-MM	★	8.0	.315	106	4.173	104.9	4.130	68	2.677	1.1	.043	20	290	COROMANT	
7.10	.280	57.0	2.244	8	8	860.1-0710-057A1-MM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT	
7.14	.281	22.6	.890	3	8	860.1-0714-021A1-MM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K	
7.14	.281	57.0	2.244	7	8	860.1-0714-057A1-MM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT	
7.40	.291	23.4	.921	3	8	860.1-0740-022A1-MM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K	
7.50	.295	23.7	.933	3	8	860.1-0750-023A1-MM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K	
7.50	.295	38.7	1.524	5	8	860.1-0750-038A1-MM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L	
7.80	.307	24.7	.972	3	8	860.1-0780-023A1-MM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K	
7.80	.307	40.3	1.587	5	8	860.1-0780-039A1-MM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L	
7.80	.307	62.0	2.441	7	8	860.1-0780-062A1-MM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT	
7.94	.313	64.0	2.520	8	8	860.1-0794-064A1-MM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT	
8.00	.315	25.3	.996	3	8	860.1-0800-024A1-MM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K	
8.00	.315	41.3	1.626	5	8	860.1-0800-040A1-MM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L	
8.00	.315	64.0	2.520	8	8	860.1-0800-064A1-MM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT	
8.10	.319	25.6	1.008	3	10	860.1-0810-024A1-MM	★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K	
8.10	.319	65.0	2.559	8	10	860.1-0810-065A1-MM	★	10.0	.394	139	5.472	137.7	5.421	94	3.701	1.3	.051	20	290	COROMANT	
8.20	.323	25.9	1.020	3	10	860.1-0820-025A1-MM	★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K	



B81



E9



E28

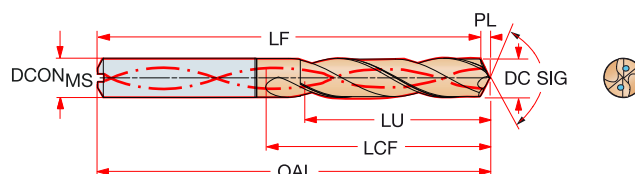
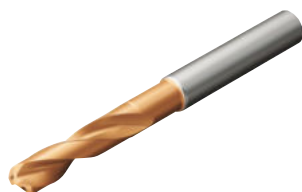


E14

CoroDrill® 860 Vollhartmetallbohrer

Für rostfreien Stahl

Innere Kühlschmierstoffzufuhr

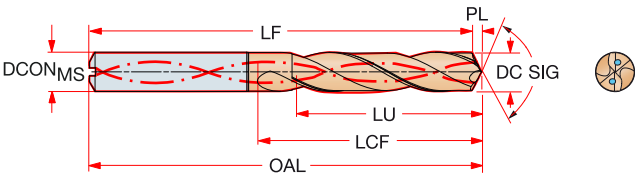
TCHA H8
SIG 140°

							M	Abmessungen, mm, Zoll												
							2214													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer		DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG
8.20	.323	42.3	1.665	5	10	860.1-0820-041A1-MM	★	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.40	.331	43.4	1.709	5	10	860.1-0840-042A1-MM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.50	.335	26.9	1.059	3	10	860.1-0850-026A1-MM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.50	.335	43.9	1.728	5	10	860.1-0850-043A1-MM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.50	.335	68.0	2.677	8	10	860.1-0850-068A1-MM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.60	.339	27.2	1.071	3	10	860.1-0860-026A1-MM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.60	.339	44.4	1.748	5	10	860.1-0860-043A1-MM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.60	.339	69.0	2.717	8	10	860.1-0860-069A1-MM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.70	.343	27.5	1.083	3	10	860.1-0870-026A1-MM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.70	.343	44.9	1.768	5	10	860.1-0870-044A1-MM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.70	.343	70.0	2.756	8	10	860.1-0870-070A1-MM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.80	.346	27.8	1.094	3	10	860.1-0880-026A1-MM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.80	.346	70.0	2.756	7	10	860.1-0880-070A1-MM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
9.00	.354	28.5	1.122	3	10	860.1-0900-027A1-MM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.00	.354	46.5	1.831	5	10	860.1-0900-045A1-MM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.00	.354	72.0	2.835	8	10	860.1-0900-072A1-MM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT
9.10	.358	73.0	2.874	8	10	860.1-0910-073A1-MM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT
9.30	.366	29.4	1.157	3	10	860.1-0930-028A1-MM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.30	.366	48.0	1.890	5	10	860.1-0930-047A1-MM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.40	.370	75.0	2.953	7	10	860.1-0940-075A1-MM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT
9.50	.374	30.1	1.185	3	10	860.1-0950-029A1-MM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.50	.374	48.7	1.917	5	10	860.1-0950-048A1-MM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
9.50	.374	76.0	2.992	8	10	860.1-0950-076A1-MM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.53	.375	76.0	2.992	7	10	860.1-0953-076A1-MM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.60	.378	30.4	1.197	3	10	860.1-0960-029A1-MM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.60	.378	77.0	3.032	8	10	860.1-0960-077A1-MM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.80	.386	31.0	1.220	3	10	860.1-0980-029A1-MM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.80	.386	48.3	1.902	4	10	860.1-0980-049A1-MM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
10.00	.394	31.6	1.244	3	10	860.1-1000-030A1-MM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
10.00	.394	48.0	1.890	4	10	860.1-1000-050A1-MM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
10.00	.394	80.0	3.150	8	10	860.1-1000-080A1-MM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
10.10	.398	52.2	2.055	5	12	860.1-1010-051A1-MM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.20	.402	32.3	1.272	3	12	860.1-1020-031A1-MM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.20	.402	52.7	2.075	5	12	860.1-1020-051A1-MM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.30	.406	32.6	1.283	3	12	860.1-1030-031A1-MM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.30	.406	53.2	2.094	5	12	860.1-1030-052A1-MM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.30	.406	82.0	3.228	7	12	860.1-1030-082A1-MM	★	12.0	.472	163	6.417	161.3	6.350	114	4.488	1.7	.067	20	290	COROMANT
10.50	.413	33.2	1.307	3	12	860.1-1050-032A1-MM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.50	.413	54.2	2.134	5	12	860.1-1050-053A1-MM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.50	.413	84.0	3.307	8	12	860.1-1050-084A1-MM	★	12.0	.472	163	6.417	161.3	6.350	115	4.528	1.7	.067	20	290	COROMANT
10.80	.425	34.2	1.346	3	12	860.1-1080-032A1-MM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.00	.433	34.8	1.370	3	12	860.1-1100-033A1-MM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.00	.433	56.8	2.236	5	12	860.1-1100-055A1-MM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.00	.433	88.0	3.465	8	12	860.1-1100-088A1-MM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.10	.437	35.1	1.382	3	12	860.1-1110-033A1-MM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.11	.437	89.0	3.504	8	12	860.1-1111-089A1-MM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.20	.441	57.6	2.268	5	12	860.1-1120-056A1-MM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.50	.453	36.4	1.433	3	12	860.1-1150-035A1-MM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.50	.453	57.2	2.252	4	12	860.1-1150-058A1-MM	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.70	.461	37.0	1.457	3	12	860.1-1170-035A1-MM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K

CoroDrill® 860 Vollhartmetallbohrer

Für rostfreien Stahl
Innere Kühlschmierstoffzufuhr

TCHA H8
SIG 140°



B

						M	Abmessungen, mm, Zoll																
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	2214	DCON _{MS}	DCON _{MS} [*]	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG			
11.80	.465	37.3	1.469	3	12	860.1-1180-035A1-MM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K			
11.80	.465	56.8	2.236	4	12	860.1-1180-059A1-MM	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L			
11.80	.465	94.0	3.701	7	12	860.1-1180-094A1-MM	★	12.0	.472	163	6.417	161.1	6.343	116	4.567	1.9	.075	20	290	COROMANT			
12.00	.472	38.0	1.496	3	12	860.1-1200-036A1-MM	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079	20	290	DIN 6537 K			
12.00	.472	56.6	2.228	4	12	860.1-1200-060A1-MM	★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079	20	290	DIN 6537 L			
12.00	.472	96.0	3.780	8	12	860.1-1200-096A1-MM	★	12.0	.472	163	6.417	161.0	6.339	116	4.567	2.0	.079	20	290	COROMANT			
12.20	.480	38.6	1.520	3	14	860.1-1220-037A1-MM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K			
12.50	.492	62.0	2.441	4	14	860.1-1250-063A1-MM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L			
12.50	.492	100.0	3.937	8	14	860.1-1250-100A1-MM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT			
12.70	.500	40.2	1.583	3	14	860.1-1270-038A1-MM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K			
12.70	.500	61.8	2.433	4	14	860.1-1270-064A1-MM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L			
12.80	.504	40.5	1.594	3	14	860.1-1280-038A1-MM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K			
13.00	.512	41.1	1.618	3	14	860.1-1300-039A1-MM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K			
13.00	.512	61.4	2.417	4	14	860.1-1300-065A1-MM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L			
13.00	.512	104.0	4.094	8	14	860.1-1300-104A1-MM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT			
13.50	.531	60.8	2.394	4	14	860.1-1350-061A1-MM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L			
13.50	.531	108.0	4.252	8	14	860.1-1350-108A1-MM	★	14.0	.551	182	7.165	179.8	7.079	134	5.276	2.2	.087	20	290	COROMANT			
14.00	.551	44.3	1.744	3	14	860.1-1400-042A1-MM	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.091	20	290	DIN 6537 K			
14.00	.551	63.0	2.480	4	14	860.1-1400-063A1-MM	★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.3	.091	20	290	DIN 6537 L			
14.00	.551	112.0	4.409	8	14	860.1-1400-112A1-MM	★	14.0	.551	182	7.165	179.7	7.075	134	5.276	2.3	.091	20	290	COROMANT			
14.25	.561	68.8	2.709	4	16	860.1-1425-071A1-MM	★	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L			
14.25	.561	114.0	4.488	8	16	860.1-1425-114A1-MM	★	16.0	.630	204	8.032	201.7	7.941	154	6.063	2.3	.091	20	290	COROMANT			
14.50	.571	68.5	2.697	4	16	860.1-1450-073A1-MM	★	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L			
14.68	.578	68.3	2.689	4	16	860.1-1468-073A1-MM	★	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L			
15.00	.591	47.5	1.870	3	16	860.1-1500-045A1-MM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K			
15.00	.591	68.0	2.677	4	16	860.1-1500-068A1-MM	★	16.0	.630	133	5.236	130.5	5.138	83	3.268	2.5	.098	20	290	DIN 6537 L			
15.80	.622	126.0	4.961	7	16	860.1-1580-126A1-MM	★	16.0	.630	204	8.032	201.4	7.929	154	6.063	2.6	.102	20	290	COROMANT			

D

E



CoroDrill® 860

Für Aluminium optimierter Hochleistungsbohrer

Anwendungsbereich

860-NM: Nichteisenmetalle, wie zum Beispiel Aluminiumlegierungen, Magnesium- und Kupferbasislegierungen einschließlich Bronze



ISO-Anwendungsbereich:

N

Merkmale und Vorteile

- Verbesserte Schnittdaten
- Geringe Kosten pro Bohrung
- Zuverlässigere Leistung
- Optimale Spanabfuhr
- Hohe Standzeit, kontrollierter Verschleiß
- Konstante Bohrungstoleranz
- Kann bis zu dreimal gemäß Originalspezifikation nachgeschliffen werden



www.sandvik.coromant.com/corodril860

Empfehlungen

Wir empfehlen die Verwendung von hydraulischen Präzisionsspannfuttern.

Es wird eine innere Kühlschmierstoffzufuhr mit einem Mindestdruck von 20 bar empfohlen.

Für Spannfutter, siehe Katalog Rotierende Werkzeuge.

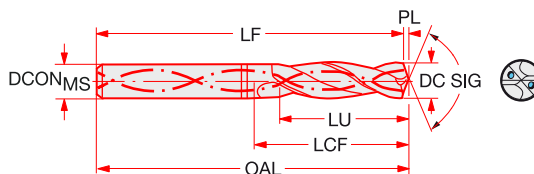


E14

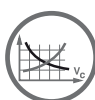
CoroDrill® 860 Vollhartmetallbohrer

Für Aluminium

Innere Kühlschmierstoffzufuhr

TCHA H7
SIG 130°

							N	Abmessungen, mm, Zoll																BSG
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer		ISO	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI				
3.00	.118	9.4	.370	3	6	860.1-0300-009A1-NM	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K				
3.00	.118	24.4	.961	8	6	860.1-0300-024A1-NM	★	6.0	.236	77	3.032	76.6	3.016	36	1.417	0.4	.016	20	290	COROMANT				
3.18	.125	10.0	.394	3	6	860.1-0318-010A1-NM	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K				
3.18	.125	25.8	1.016	8	6	860.1-0318-025A1-NM	★	6.0	.236	77	3.032	76.6	3.016	36	1.417	0.4	.016	20	290	COROMANT				
3.20	.126	10.0	.394	3	6	860.1-0320-010A1-NM	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K				
3.20	.126	26.0	1.024	8	6	860.1-0320-026A1-NM	★	6.0	.236	77	3.032	76.6	3.016	36	1.417	0.4	.016	20	290	COROMANT				
3.30	.130	10.3	.406	3	6	860.1-0330-010A1-NM	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K				
3.30	.130	26.8	1.055	8	6	860.1-0330-026A1-NM	★	6.0	.236	77	3.032	76.6	3.016	36	1.417	0.4	.016	20	290	COROMANT				
3.50	.138	28.3	1.114	8	6	860.1-0350-028A1-NM	★	6.0	.236	77	3.032	76.5	3.012	36	1.417	0.5	.020	20	290	COROMANT				
3.57	.141	28.1	1.106	7	6	860.1-0357-029A1-NM	★	6.0	.236	77	3.032	76.5	3.012	36	1.417	0.5	.020	20	290	COROMANT				
3.70	.146	27.9	1.098	7	6	860.1-0370-030A1-NM	★	6.0	.236	77	3.032	76.5	3.012	36	1.417	0.5	.020	20	290	COROMANT				
4.00	.157	12.5	.492	3	6	860.1-0400-012A1-NM	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K				
4.00	.157	32.5	1.280	8	6	860.1-0400-032A1-NM	★	6.0	.236	86	3.386	85.5	3.366	47	1.850	0.5	.020	20	290	COROMANT				
4.10	.161	33.3	1.311	8	6	860.1-0410-033A1-NM	★	6.0	.236	86	3.386	85.5	3.366	47	1.850	0.5	.020	20	290	COROMANT				
4.20	.165	13.2	.520	3	6	860.1-0420-013A1-NM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K				
4.20	.165	34.2	1.346	8	6	860.1-0420-034A1-NM	★	6.0	.236	86	3.386	85.4	3.362	47	1.850	0.6	.024	20	290	COROMANT				
4.37	.172	13.7	.539	3	6	860.1-0437-013A1-NM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K				
4.37	.172	35.5	1.398	8	6	860.1-0437-035A1-NM	★	6.0	.236	86	3.386	85.4	3.362	47	1.850	0.6	.024	20	290	COROMANT				
4.50	.177	14.1	.555	3	6	860.1-0450-014A1-NM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K				
4.50	.177	36.6	1.441	8	6	860.1-0450-036A1-NM	★	6.0	.236	86	3.386	85.4	3.362	47	1.850	0.6	.024	20	290	COROMANT				
4.60	.181	14.4	.567	3	6	860.1-0460-014A1-NM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K				
4.60	.181	37.4	1.472	8	6	860.1-0460-037A1-NM	★	6.0	.236	86	3.386	85.4	3.362	47	1.850	0.6	.024	20	290	COROMANT				
4.76	.187	38.7	1.524	8	6	860.1-0476-038A1-NM	★	6.0	.236	99	3.898	98.4	3.874	60	2.362	0.6	.024	20	290	COROMANT				
5.00	.197	15.7	.618	3	6	860.1-0500-015A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K				
5.00	.197	40.7	1.602	8	6	860.1-0500-040A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT				
5.10	.201	16.0	.630	3	6	860.1-0510-015A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K				
5.10	.201	41.5	1.634	8	6	860.1-0510-041A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT				
5.16	.203	42.0	1.654	8	6	860.1-0516-041A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT				
5.20	.205	16.3	.642	3	6	860.1-0520-016A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K				
5.20	.205	42.3	1.665	8	6	860.1-0520-042A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT				
5.50	.217	17.2	.677	3	6	860.1-0550-017A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K				
5.50	.217	44.7	1.760	8	6	860.1-0550-044A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT				
5.56	.219	17.4	.685	3	6	860.1-0556-017A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K				
5.56	.219	45.2	1.780	8	6	860.1-0556-044A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT				
5.80	.228	17.6	.693	3	6	860.1-0580-017A1-NM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K				
5.80	.228	47.2	1.858	8	6	860.1-0580-046A1-NM	★	6.0	.236	99	3.898	98.2	3.866	60	2.362	0.8	.031	20	290	COROMANT				
6.00	.236	18.8	.740	3	6	860.1-0600-018A1-NM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K				
6.00	.236	48.8	1.921	8	6	860.1-0600-048A1-NM	★	6.0	.236	99	3.898	98.2	3.866	60	2.362	0.8	.031	20	290	COROMANT				
6.30	.248	19.7	.776	3	8	860.1-0630-019A1-NM	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K				
6.30	.248	51.2	2.016	8	8	860.1-0630-050A1-NM	★	8.0	.315	121	4.764	120.2	4.732	80	3.150	0.8	.031	20	290	COROMANT				
6.35	.250	19.9	.783	3	8	860.1-0635-019A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K				
6.35	.250	51.7	2.035	8	8	860.1-0635-051A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT				
6.50	.256	20.4	.803	3	8	860.1-0650-020A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K				
6.50	.256	52.9	2.083	8	8	860.1-0650-052A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT				
6.60	.260	20.7	.815	3	8	860.1-0660-020A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K				
6.60	.260	53.7	2.114	8	8	860.1-0660-053A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT				
6.75	.266	21.1	.831	3	8	860.1-0675-020A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K				
6.75	.266	54.9	2.161	8	8	860.1-0675-054A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT				
6.80	.268	21.3	.839	3	8	860.1-0680-020A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K				
6.80	.268	55.3	2.177	8	8	860.1-0680-054A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT				
7.00	.276	21.9	.862	3	8	860.1-0700-021A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K				
7.00	.276	56.9	2.240	8	8	860.1-0700-056A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT				



B76



E9



E28

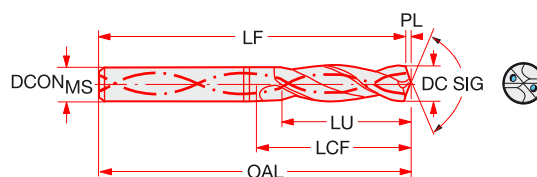


E14

CoroDrill® 860 Vollhartmetallbohrer

Für Aluminium

Innere Kühlschmierstoffzufuhr

TCHA H7
SIG 130°

										N	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer					DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG	
7.14	.281	22.4	.882	3	8	860.1-0714-021A1-NM	★				8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K	
7.30	.287	22.9	.902	3	8	860.1-0730-022A1-NM	★				8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K	
7.30	.287	59.4	2.339	8	8	860.1-0730-058A1-NM	★				8.0	.315	121	4.764	120.0	4.724	80	3.150	1.0	.039	20	290	COROMANT	
7.40	.291	23.2	.913	3	8	860.1-0740-022A1-NM	★				8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K	
7.40	.291	60.2	2.370	8	8	860.1-0740-059A1-NM	★				8.0	.315	121	4.764	120.0	4.724	80	3.150	1.0	.039	20	290	COROMANT	
7.50	.295	23.5	.925	3	8	860.1-0750-023A1-NM	★				8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K	
7.50	.295	61.0	2.402	8	8	860.1-0750-060A1-NM	★				8.0	.315	121	4.764	120.0	4.724	80	3.150	1.0	.039	20	290	COROMANT	
7.94	.313	24.9	.980	3	8	860.1-0794-024A1-NM	★				8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K	
7.94	.313	64.6	2.543	8	8	860.1-0794-064A1-NM	★				8.0	.315	121	4.764	119.9	4.720	80	3.150	1.1	.043	20	290	COROMANT	
8.00	.315	25.1	.988	3	8	860.1-0800-024A1-NM	★				8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K	
8.00	.315	65.1	2.563	8	8	860.1-0800-064A1-NM	★				8.0	.315	121	4.764	119.9	4.720	80	3.150	1.1	.043	20	290	COROMANT	
8.33	.328	26.1	1.028	3	10	860.1-0833-025A1-NM	★				10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K	
8.33	.328	67.8	2.669	8	10	860.1-0833-067A1-NM	★				10.0	.394	145	5.709	143.9	5.665	100	3.937	1.1	.043	20	290	COROMANT	
8.50	.335	26.6	1.047	3	10	860.1-0850-026A1-NM	★				10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K	
8.50	.335	69.1	2.720	8	10	860.1-0850-068A1-NM	★				10.0	.394	145	5.709	143.9	5.665	100	3.937	1.1	.043	20	290	COROMANT	
8.60	.339	27.0	1.063	3	10	860.1-0860-026A1-NM	★				10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K	
8.60	.339	70.0	2.756	8	10	860.1-0860-069A1-NM	★				10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT	
8.70	.343	70.8	2.787	8	10	860.1-0870-070A1-NM	★				10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT	
8.80	.346	27.6	1.087	3	10	860.1-0880-026A1-NM	★				10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K	
8.80	.346	71.6	2.819	8	10	860.1-0880-070A1-NM	★				10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT	
9.00	.354	28.2	1.110	3	10	860.1-0900-027A1-NM	★				10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K	
9.00	.354	73.2	2.882	8	10	860.1-0900-072A1-NM	★				10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT	
9.13	.359	74.2	2.921	8	10	860.1-0913-073A1-NM	★				10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT	
9.30	.366	29.1	1.146	3	10	860.1-0930-028A1-NM	★				10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K	
9.30	.366	75.6	2.976	8	10	860.1-0930-074A1-NM	★				10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT	
9.50	.374	29.8	1.173	3	10	860.1-0950-029A1-NM	★				10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K	
9.50	.374	77.3	3.043	8	10	860.1-0950-076A1-NM	★				10.0	.394	145	5.709	143.7	5.657	100	3.937	1.3	.051	20	290	COROMANT	
9.53	.375	29.9	1.177	3	10	860.1-0953-029A1-NM	★				10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K	
9.53	.375	77.5	3.051	8	10	860.1-0953-076A1-NM	★				10.0	.394	145	5.709	143.7	5.657	100	3.937	1.3	.051	20	290	COROMANT	
9.92	.391	80.7	3.177	8	10	860.1-0992-079A1-NM	★				10.0	.394	145	5.709	143.7	5.657	100	3.937	1.3	.051	20	290	COROMANT	
10.00	.394	31.3	1.232	3	10	860.1-1000-030A1-NM	★				10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K	
10.00	.394	81.3	3.201	8	10	860.1-1000-080A1-NM	★				10.0	.394	145	5.709	143.7	5.657	100	3.937	1.3	.051	20	290	COROMANT	
10.20	.402	32.0	1.260	3	12	860.1-1020-031A1-NM	★				12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K	
10.20	.402	83.0	3.268	8	12	860.1-1020-082A1-NM	★				12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT	
10.30	.406	32.3	1.272	3	12	860.1-1030-031A1-NM	★				12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K	
10.30	.406	83.8	3.299	8	12	860.1-1030-082A1-NM	★				12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT	
10.50	.413	32.9	1.295	3	12	860.1-1050-032A1-NM	★				12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K	
10.50	.413	85.4	3.362	8	12	860.1-1050-084A1-NM	★				12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT	
10.72	.422	33.6	1.323	3	12	860.1-1072-032A1-NM	★				12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K	
10.72	.422	87.2	3.433	8	12	860.1-1072-086A1-NM	★				12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT	
10.80	.425	87.8	3.457	8	12	860.1-1080-086A1-NM	★				12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT	
11.00	.433	34.5	1.358	3	12	860.1-1100-033A1-NM	★				12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
11.00	.433	89.5	3.524	8	12	860.1-1100-088A1-NM	★				12.0	.472	171	6.732	169.5	6.673	120	4.724	1.5	.059	20	290	COROMANT	
11.10	.437	34.8	1.370	3	12	860.1-1110-033A1-NM	★				12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
11.10	.437	90.3	3.555	8	12	860.1-1110-089A1-NM	★				12.0	.472	171	6.732	169.5	6.673	120	4.724	1.5	.059	20	290	COROMANT	
11.11	.437	34.8	1.370	3	12	860.1-1111-033A1-NM	★				12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
11.20	.441	35.1	1.382	3	12	860.1-1120-034A1-NM	★				12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K	
11.20	.441	91.1	3.587	8	12	860.1-1120-090A1-NM	★				12.0	.472	171	6.732	169.5	6.673	120	4.724	1.5	.059	20	290	COROMANT	
11.50	.453	93.5	3.681	8	12	860.1-1150-092A1-NM	★				12.0	.472	171	6.732	169.5	6.673	120	4.724	1.5	.059	20	290	COROMANT	
11.80	.465	37.0	1.457	3	12	860.1-1180-035A1-NM	★				12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K	
11.80	.465	96.0	3.780	8	12	860.1-1180-094A1-NM	★				12.0	.472	171	6.732	169.4	6.669	120	4.724	1.6	.063	20	290	COROMANT	



B76



E9



E28



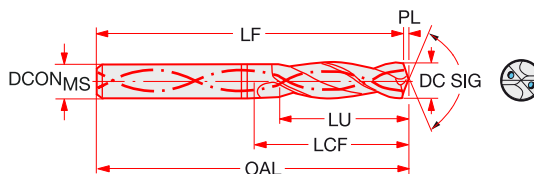
E14



CoroDrill® 860 Vollhartmetallbohrer

Für Aluminium

Innere Kühlschmierstoffzufuhr

TCHA H7
SIG 130°

						N	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	至底	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG
12.00	.472	37.6	1.480	3	12	860.1-1200-036A1-NM	★	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K
12.00	.472	97.6	3.843	8	12	860.1-1200-096A1-NM	★	12.0	.472	171	6.732	169.4	6.669	120	4.724	1.6	.063	20	290	COROMANT
12.10	.476	37.9	1.492	3	14	860.1-1210-036A1-NM	★	14.0	.551	107	4.213	105.4	4.150	60	2.362	1.6	.063	20	290	DIN 6537 K
12.30	.484	100.1	3.941	8	14	860.1-1230-098A1-NM	★	14.0	.551	190	7.480	188.4	7.417	140	5.512	1.6	.063	20	290	COROMANT
12.50	.492	39.2	1.543	3	14	860.1-1250-038A1-NM	★	14.0	.551	107	4.213	105.3	4.146	60	2.362	1.7	.067	20	290	DIN 6537 K
12.50	.492	101.7	4.004	8	14	860.1-1250-100A1-NM	★	14.0	.551	190	7.480	188.3	7.413	140	5.512	1.7	.067	20	290	COROMANT
12.70	.500	39.8	1.567	3	14	860.1-1270-038A1-NM	★	14.0	.551	107	4.213	105.3	4.146	60	2.362	1.7	.067	20	290	DIN 6537 K
12.70	.500	103.3	4.067	8	14	860.1-1270-102A1-NM	★	14.0	.551	190	7.480	188.3	7.413	140	5.512	1.7	.067	20	290	COROMANT
13.00	.512	40.7	1.602	3	14	860.1-1300-039A1-NM	★	14.0	.551	107	4.213	105.3	4.146	60	2.362	1.7	.067	20	290	DIN 6537 K
13.00	.512	105.7	4.161	8	14	860.1-1300-104A1-NM	★	14.0	.551	190	7.480	188.3	7.413	140	5.512	1.7	.067	20	290	COROMANT
13.10	.516	41.0	1.614	3	14	860.1-1310-039A1-NM	★	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K
13.10	.516	106.5	4.193	8	14	860.1-1310-105A1-NM	★	14.0	.551	190	7.480	188.2	7.409	140	5.512	1.8	.071	20	290	COROMANT
13.50	.531	42.3	1.665	3	14	860.1-1350-041A1-NM	★	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K
13.50	.531	109.8	4.323	8	14	860.1-1350-108A1-NM	★	14.0	.551	190	7.480	188.2	7.409	140	5.512	1.8	.071	20	290	COROMANT
13.89	.547	43.3	1.705	3	14	860.1-1389-042A1-NM	★	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K
14.00	.551	43.9	1.728	3	14	860.1-1400-042A1-NM	★	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K
14.00	.551	113.9	4.484	8	14	860.1-1400-112A1-NM	★	14.0	.551	190	7.480	188.1	7.406	140	5.512	1.9	.075	20	290	COROMANT
14.20	.559	44.5	1.752	3	16	860.1-1420-043A1-NM	★	16.0	.630	115	4.528	113.1	4.453	65	2.559	1.9	.075	20	290	DIN 6537 K
14.29	.563	44.8	1.764	3	16	860.1-1429-043A1-NM	★	16.0	.630	115	4.528	113.1	4.453	65	2.559	1.9	.075	20	290	DIN 6537 K
14.50	.571	45.4	1.787	3	16	860.1-1450-044A1-NM	★	16.0	.630	115	4.528	113.1	4.453	65	2.559	1.9	.075	20	290	DIN 6537 K
14.50	.571	117.9	4.642	8	16	860.1-1450-116A1-NM	★	16.0	.630	213	8.386	211.1	8.311	160	6.299	1.9	.075	20	290	COROMANT
14.68	.578	119.4	4.701	8	16	860.1-1468-117A1-NM	★	16.0	.630	213	8.386	211.0	8.307	160	6.299	2.0	.079	20	290	COROMANT
14.75	.581	46.2	1.819	3	16	860.1-1475-044A1-NM	★	16.0	.630	115	4.528	113.0	4.449	65	2.559	2.0	.079	20	290	DIN 6537 K
15.00	.591	47.0	1.850	3	16	860.1-1500-045A1-NM	★	16.0	.630	115	4.528	113.0	4.449	65	2.559	2.0	.079	20	290	DIN 6537 K
15.00	.591	122.0	4.803	8	16	860.1-1500-120A1-NM	★	16.0	.630	213	8.386	211.0	8.307	160	6.299	2.0	.079	20	290	COROMANT
15.50	.610	48.6	1.913	3	16	860.1-1550-047A1-NM	★	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	20	290	DIN 6537 K
15.50	.610	126.1	4.965	8	16	860.1-1550-124A1-NM	★	16.0	.630	213	8.386	210.9	8.303	160	6.299	2.1	.083	20	290	COROMANT
16.00	.630	49.0	1.929	3	16	860.1-1600-048A1-NM	★	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	20	290	DIN 6537 K
16.00	.630	130.1	5.122	8	16	860.1-1600-128A1-NM	★	16.0	.630	213	8.386	210.9	8.303	160	6.299	2.1	.083	20	290	COROMANT
17.00	.669	53.3	2.098	3	18	860.1-1700-051A1-NM	★	18.0	.709	123	4.843	120.7	4.752	73	2.874	2.3	.091	20	290	DIN 6537 K
17.00	.669	138.3	5.445	8	18	860.1-1700-136A1-NM	★	18.0	.709	234	9.213	231.7	9.122	180	7.087	2.3	.091	20	290	COROMANT
17.50	.689	54.8	2.157	3	18	860.1-1750-053A1-NM	★	18.0	.709	123	4.843	120.7	4.752	73	2.874	2.3	.091	20	290	DIN 6537 K



B76



E9



E28



E14

CoroDrill® 860-SM

Optimiertes Bohren in Nickel- und Titanbasislegierungen

Anwendungsbereich

- Bohrwerkzeuge für Kobaltchrom-, Nickel- und Titanbasislegierungen
- Bis zu 5 x Durchmesser
- Bohrungstoleranz: H9
- Optimiert für Hochleistungsanwendungen



ISO-Anwendungsbereich:

S

Merkmale und Vorteile

- Zuverlässigkeit und Prozesssicherheit
- Vorhersagbare Standzeiten
- Ausgezeichnete Wiederholgenauigkeit
- Ein industriezertifiziertes Produkt inklusive Wiederaufbereitungsservice höchster Qualität
- Einzigartige Geometrie für ISO S-Werkstoffe liefert sichere Spankontrolle



www.sandvik.coromant.com/corodrillr860

Empfehlungen

Stabile Werkzeugspannung mit CoroChuck™ 930
Kühlschmierstoffdruck optimalerweise 20 bar oder höher
Stabile Werkstückspannung

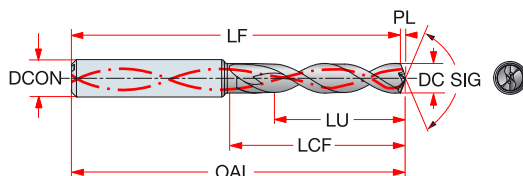
Für Spannfutter, siehe Katalog Rotierende Werkzeuge.



CoroDrill® 860 Vollhartmetallbohrer

Für warmfeste Superlegierungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

							s	Abmessungen, mm, Zoll													
							12/10														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer		DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG	
3.00	.118	9.5	.374	3	6	860.1-0300-009A1-SM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.6	.022	20	290	DIN 6537 K	
3.00	.118	15.5	.610	5	6	860.1-0300-015A1-SM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.6	.022	20	290	DIN 6537 L	
3.10	.122	9.9	.390	3	6	860.1-0310-009A1-SM	★	6.0	.236	62	2.441	61.5	2.420	20	.787	0.6	.022	20	290	DIN 6537 K	
3.17	.125	16.4	.646	5	6	860.1-0317-016A1-SM	★	6.0	.236	66	2.598	65.5	2.578	28	1.102	0.6	.023	20	290	DIN 6537 L	
3.18	.125	10.1	.398	3	6	860.1-0318-010A1-SM	★	6.0	.236	62	2.441	61.5	2.420	20	.787	0.6	.023	20	290	DIN 6537 K	
3.20	.126	10.2	.402	3	6	860.1-0320-010A1-SM	★	6.0	.236	62	2.441	61.5	2.420	20	.787	0.6	.023	20	290	DIN 6537 K	
3.20	.126	16.6	.654	5	6	860.1-0320-016A1-SM	★	6.0	.236	66	2.598	65.5	2.577	28	1.102	0.6	.023	20	290	DIN 6537 L	
3.30	.130	10.5	.413	3	6	860.1-0330-010A1-SM	★	6.0	.236	62	2.441	61.5	2.419	20	.787	0.6	.024	20	290	DIN 6537 K	
3.30	.130	17.1	.673	5	6	860.1-0330-017A1-SM	★	6.0	.236	66	2.598	65.5	2.577	28	1.102	0.6	.024	20	290	DIN 6537 L	
3.40	.134	10.8	.425	3	6	860.1-0340-010A1-SM	★	6.0	.236	62	2.441	61.4	2.419	20	.787	0.6	.024	20	290	DIN 6537 K	
3.50	.138	11.1	.437	3	6	860.1-0350-011A1-SM	★	6.0	.236	62	2.441	61.4	2.418	20	.787	0.6	.025	20	290	DIN 6537 K	
3.50	.138	18.1	.713	5	6	860.1-0350-018A1-SM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.025	20	290	DIN 6537 L	
3.57	.141	11.4	.449	3	6	860.1-0357-011A1-SM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.7	.026	20	290	DIN 6537 K	
3.60	.142	11.5	.453	3	6	860.1-0360-011A1-SM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.7	.026	20	290	DIN 6537 K	
3.70	.146	11.8	.465	3	6	860.1-0370-011A1-SM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.7	.026	20	290	DIN 6537 K	
3.70	.146	19.2	.756	5	6	860.1-0370-019A1-SM	★	6.0	.236	66	2.598	65.4	2.574	28	1.102	0.7	.026	20	290	DIN 6537 L	
3.80	.150	11.7	.461	3	6	860.1-0380-011A1-SM	★	6.0	.236	66	2.598	65.4	2.573	20	.787	0.7	.027	20	290	DIN 6537 K	
3.90	.154	11.6	.457	2	6	860.1-0390-011A1-SM	★	6.0	.236	66	2.598	65.4	2.573	20	.787	0.7	.028	20	290	DIN 6537 K	
3.90	.154	19.6	.772	5	6	860.1-0390-019A1-SM	★	6.0	.236	74	2.913	73.4	2.888	28	1.102	0.7	.028	20	290	DIN 6537 L	
4.00	.157	12.7	.500	3	6	860.1-0400-012A1-SM	★	6.0	.236	66	2.598	65.3	2.572	24	.945	0.7	.029	20	290	DIN 6537 K	
4.00	.157	20.7	.815	5	6	860.1-0400-020A1-SM	★	6.0	.236	74	2.913	73.3	2.887	36	1.417	0.7	.029	20	290	DIN 6537 L	
4.10	.161	13.0	.512	3	6	860.1-0410-013A1-SM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.8	.030	20	290	DIN 6537 K	
4.15	.163	21.5	.846	5	6	860.1-0415-021A1-SM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.8	.030	20	290	DIN 6537 L	
4.20	.165	13.4	.528	3	6	860.1-0420-013A1-SM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.8	.030	20	290	DIN 6537 K	
4.20	.165	21.8	.858	5	6	860.1-0420-021A1-SM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.8	.030	20	290	DIN 6537 L	
4.30	.169	13.7	.539	3	6	860.1-0430-013A1-SM	★	6.0	.236	66	2.598	65.3	2.570	24	.945	0.8	.031	20	290	DIN 6537 K	
4.37	.172	13.9	.547	3	6	860.1-0437-013A1-SM	★	6.0	.236	66	2.598	65.3	2.570	24	.945	0.8	.031	20	290	DIN 6537 K	
4.40	.173	22.8	.898	5	6	860.1-0440-022A1-SM	★	6.0	.236	74	2.913	73.3	2.884	36	1.417	0.8	.031	20	290	DIN 6537 L	
4.50	.177	14.3	.563	3	6	860.1-0450-014A1-SM	★	6.0	.236	66	2.598	65.3	2.569	24	.945	0.8	.032	20	290	DIN 6537 K	
4.50	.177	23.3	.917	5	6	860.1-0450-023A1-SM	★	6.0	.236	74	2.913	73.3	2.884	36	1.417	0.8	.032	20	290	DIN 6537 L	
4.60	.181	14.6	.575	3	6	860.1-0460-014A1-SM	★	6.0	.236	66	2.598	65.2	2.568	24	.945	0.8	.033	20	290	DIN 6537 K	
4.60	.181	23.8	.937	5	6	860.1-0460-023A1-SM	★	6.0	.236	74	2.913	73.2	2.883	36	1.417	0.8	.033	20	290	DIN 6537 L	
4.70	.185	15.0	.591	3	6	860.1-0470-014A1-SM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.9	.034	20	290	DIN 6537 K	
4.70	.185	24.4	.961	5	6	860.1-0470-024A1-SM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.9	.034	20	290	DIN 6537 L	
4.76	.187	13.6	.535	2	6	860.1-0476-013A1-SM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.9	.034	20	290	DIN 6537 K	
4.76	.187	24.7	.972	5	6	860.1-0476-024A1-SM	★	6.0	.236	82	3.228	81.2	3.197	36	1.417	0.9	.034	20	290	DIN 6537 L	
4.80	.189	15.3	.602	3	6	860.1-0480-015A1-SM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.9	.034	20	290	DIN 6537 K	
4.80	.189	24.9	.980	5	6	860.1-0480-024A1-SM	★	6.0	.236	82	3.228	81.2	3.197	36	1.417	0.9	.034	20	290	DIN 6537 L	
4.90	.193	15.6	.614	3	6	860.1-0490-015A1-SM	★	6.0	.236	66	2.598	65.2	2.566	28	1.102	0.9	.035	20	290	DIN 6537 K	
4.90	.193	25.4	1.000	5	6	860.1-0490-025A1-SM	★	6.0	.236	82	3.228	81.2	3.196	44	1.732	0.9	.035	20	290	DIN 6537 L	
5.00	.197	15.9	.626	3	6	860.1-0500-015A1-SM	★	6.0	.236	66	2.598	65.2	2.565	28	1.102	0.9	.036	20	290	DIN 6537 K	
5.00	.197	25.9	1.020	5	6	860.1-0500-025A1-SM	★	6.0	.236	82	3.228	81.2	3.195	44	1.732	0.9	.036	20	290	DIN 6537 L	
5.10	.201	16.2	.638	3	6	860.1-0510-016A1-SM	★	6.0	.236	66	2.598	65.2	2.565	28	1.102	0.9	.037	20	290	DIN 6537 K	
5.10	.201	26.4	1.039	5	6	860.1-0510-026A1-SM	★	6.0	.236	82	3.228	81.2	3.195	44	1.732	0.9	.037	20	290	DIN 6537 L	
5.16	.203	16.4	.646	3	6	860.1-0516-016A1-SM	★	6.0	.236	66	2.598	65.1	2.565	28	1.102	0.9	.037	20	290	DIN 6537 K	
5.20	.205	16.5	.650	3	6	860.1-0520-016A1-SM	★	6.0	.236	66	2.598	65.1	2.564	28	1.102	1.0	.037	20	290	DIN 6537 K	
5.25	.207	16.7	.657	3	6	860.1-0525-016A1-SM	★	6.0	.236	66	2.598	65.1	2.564	28	1.102	1.0	.038	20	290	DIN 6537 K	
5.30	.209	16.9	.665	3	6	860.1-0530-016A1-SM	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	1.0	.038	20	290	DIN 6537 K	
5.30	.209	27.5	1.083	5	6	860.1-0530-027A1-SM	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	1.0	.038	20	290	DIN 6537 L	
5.40	.213	17.2	.677	3	6	860.1-0540-017A1-SM	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	1.0	.039	20	290	DIN 6537 K	
5.50	.217	17.5	.689	3	6	860.1-0550-017A1-SM	★	6.0	.236	66	2.598	65.1	2.562	28	1.102	1.0	.039	20	290	DIN 6537 K	
5.50	.217	28.5	1.122	5	6	860.1-0550-028A1-SM	★	6.0	.236	82	3.228	81.1	3.192	44	1.732	1.0	.039	20	290	DIN 6537 L	



B76



E9



E28



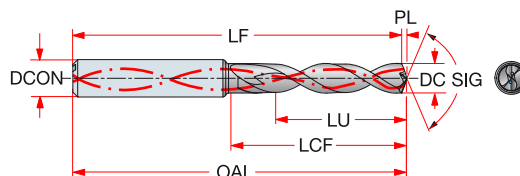
E14

CoroDrill® 860 Vollhartmetallbohrer

Für warmfeste Superlegierungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°



							S	Abmessungen, mm, Zoll													
							12/10														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer		DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG	
5.55	.219	17.6	.693	3	6	860.1-0555-017A1-SM	★	6.0	.236	66	2.598	65.1	2.562	28	1.102	1.0	.040	20	290	DIN 6537 K	
5.56	.219	17.6	.693	3	6	860.1-0556-017A1-SM	★	6.0	.236	66	2.598	65.1	2.562	28	1.102	1.0	.040	20	290	DIN 6537 K	
5.56	.219	28.8	1.134	5	6	860.1-0556-028A1-SM	★	6.0	.236	82	3.228	81.1	3.192	44	1.732	1.0	.040	20	290	DIN 6537 L	
5.60	.220	17.6	.693	3	6	860.1-0560-017A1-SM	★	6.0	.236	66	2.598	65.1	2.561	28	1.102	1.0	.040	20	290	DIN 6537 K	
5.60	.220	29.0	1.142	5	6	860.1-0560-029A1-SM	★	6.0	.236	82	3.228	81.1	3.191	44	1.732	1.0	.040	20	290	DIN 6537 L	
5.70	.224	17.6	.693	3	6	860.1-0570-017A1-SM	★	6.0	.236	66	2.598	65.1	2.561	28	1.102	1.0	.041	20	290	DIN 6537 K	
5.70	.224	29.5	1.161	5	6	860.1-0570-029A1-SM	★	6.0	.236	82	3.228	81.1	3.191	44	1.732	1.0	.041	20	290	DIN 6537 L	
5.80	.228	17.7	.697	3	6	860.1-0580-017A1-SM	★	6.0	.236	66	2.598	65.0	2.560	28	1.102	1.1	.042	20	290	DIN 6537 K	
5.80	.228	30.1	1.185	5	6	860.1-0580-030A1-SM	★	6.0	.236	82	3.228	81.0	3.190	60	2.362	1.1	.042	20	290	DIN 6537 L	
5.95	.234	17.7	.697	2	6	860.1-0595-017A1-SM	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.1	.043	20	290	DIN 6537 K	
6.00	.236	19.1	.752	3	6	860.1-0600-019A1-SM	★	6.0	.236	66	2.598	65.0	2.559	34	1.339	1.1	.043	20	290	DIN 6537 K	
6.00	.236	31.1	1.224	5	6	860.1-0600-031A1-SM	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.1	.043	20	290	DIN 6537 L	
6.10	.240	19.4	.764	3	8	860.1-0610-019A1-SM	★	8.0	.315	79	3.110	78.0	3.070	34	1.339	1.1	.044	20	290	DIN 6537 K	
6.10	.240	31.6	1.244	5	8	860.1-0610-031A1-SM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.1	.044	20	290	DIN 6537 L	
6.20	.244	19.7	.776	3	8	860.1-0620-019A1-SM	★	8.0	.315	79	3.110	78.0	3.069	34	1.339	1.1	.044	20	290	DIN 6537 K	
6.20	.244	32.1	1.264	5	8	860.1-0620-032A1-SM	★	8.0	.315	91	3.583	90.0	3.542	53	2.087	1.1	.044	20	290	DIN 6537 L	
6.35	.250	20.2	.795	3	8	860.1-0635-020A1-SM	★	8.0	.315	79	3.110	77.9	3.069	34	1.339	1.2	.046	20	290	DIN 6537 K	
6.35	.250	32.9	1.295	5	8	860.1-0635-032A1-SM	★	8.0	.315	91	3.583	89.9	3.541	53	2.087	1.2	.046	20	290	DIN 6537 L	
6.40	.252	20.4	.803	3	8	860.1-0640-020A1-SM	★	8.0	.315	79	3.110	77.9	3.068	34	1.339	1.2	.046	20	290	DIN 6537 K	
6.40	.252	33.2	1.307	5	8	860.1-0640-033A1-SM	★	8.0	.315	91	3.583	89.9	3.541	53	2.087	1.2	.046	20	290	DIN 6537 L	
6.50	.256	20.7	.815	3	8	860.1-0650-020A1-SM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.046	20	290	DIN 6537 K	
6.50	.256	33.7	1.327	5	8	860.1-0650-033A1-SM	★	8.0	.315	91	3.583	89.9	3.540	53	2.087	1.2	.046	20	290	DIN 6537 L	
6.60	.260	21.0	.827	3	8	860.1-0660-021A1-SM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.047	20	290	DIN 6537 K	
6.60	.260	34.2	1.346	5	8	860.1-0660-034A1-SM	★	8.0	.315	91	3.583	89.9	3.539	44	1.732	1.2	.047	20	290	DIN 6537 L	
6.70	.264	21.3	.839	3	8	860.1-0670-021A1-SM	★	8.0	.315	79	3.110	77.9	3.066	34	1.339	1.2	.048	20	290	DIN 6537 K	
6.70	.264	34.7	1.366	5	8	860.1-0670-034A1-SM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.2	.048	20	290	DIN 6537 L	
6.80	.268	21.6	.850	3	8	860.1-0680-021A1-SM	★	8.0	.315	79	3.110	77.9	3.065	34	1.339	1.2	.049	20	290	DIN 6537 K	
6.80	.268	35.2	1.386	5	8	860.1-0680-035A1-SM	★	8.0	.315	91	3.583	89.9	3.538	53	2.087	1.2	.049	20	290	DIN 6537 L	
6.90	.272	21.6	.850	3	8	860.1-0690-021A1-SM	★	8.0	.315	79	3.110	77.8	3.065	34	1.339	1.3	.050	20	290	DIN 6537 K	
6.90	.272	35.8	1.409	5	8	860.1-0690-035A1-SM	★	8.0	.315	91	3.583	89.8	3.537	53	2.087	1.3	.050	20	290	DIN 6537 L	
7.00	.276	21.6	.850	3	8	860.1-0700-021A1-SM	★	8.0	.315	79	3.110	77.8	3.064	34	1.339	1.3	.050	20	290	DIN 6537 K	
7.00	.276	36.3	1.429	5	8	860.1-0700-036A1-SM	★	8.0	.315	91	3.583	89.8	3.537	53	2.087	1.3	.050	20	290	DIN 6537 L	
7.10	.280	22.6	.890	3	8	860.1-0710-022A1-SM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.051	20	290	DIN 6537 K	
7.10	.280	36.8	1.449	5	8	860.1-0710-036A1-SM	★	8.0	.315	91	3.583	89.8	3.536	53	2.087	1.3	.051	20	290	DIN 6537 L	
7.14	.281	22.7	.894	3	8	860.1-0714-022A1-SM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.051	20	290	DIN 6537 K	
7.14	.281	37.0	1.457	5	8	860.1-0714-036A1-SM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.051	20	290	DIN 6537 L	
7.20	.283	22.9	.902	3	8	860.1-0720-022A1-SM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.052	20	290	DIN 6537 K	
7.20	.283	37.3	1.469	5	8	860.1-0720-037A1-SM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.052	20	290	DIN 6537 L	
7.30	.287	23.2	.913	3	8	860.1-0730-023A1-SM	★	8.0	.315	79	3.110	77.8	3.062	41	1.614	1.3	.052	20	290	DIN 6537 K	
7.30	.287	37.8	1.488	5	8	860.1-0730-037A1-SM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.052	20	290	DIN 6537 L	
7.40	.291	23.5	.925	3	8	860.1-0740-023A1-SM	★	8.0	.315	79	3.110	77.8	3.061	41	1.614	1.4	.053	20	290	DIN 6537 K	
7.40	.291	38.3	1.508	5	8	860.1-0740-038A1-SM	★	8.0	.315	91	3.583	89.8	3.534	53	2.087	1.4	.053	20	290	DIN 6537 L	
7.50	.295	23.9	.941	3	8	860.1-0750-023A1-SM	★	8.0	.315	79	3.110	77.7	3.061	41	1.614	1.4	.054	20	290	DIN 6537 K	
7.50	.295	38.9	1.532	5	8	860.1-0750-038A1-SM	★	8.0	.315	91	3.583	89.7	3.533	53	2.087	1.4	.054	20	290	DIN 6537 L	
7.60	.299	24.1	.949	3	8	860.1-0760-023A1-SM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K	
7.70	.303	24.5	.965	3	8	860.1-0770-024A1-SM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.055	20	290	DIN 6537 K	
7.80	.307	24.8	.976	3	8	860.1-0780-024A1-SM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.056	20	290	DIN 6537 K	
7.94	.313	25.3	.996	3	8	860.1-0794-025A1-SM	★	8.0	.315	79	3.110	77.7	3.058	41	1.614	1.4	.057	20	290	DIN 6537 K	
8.00	.315	25.5	1.004	3	8	860.1-0800-025A1-SM	★	8.0	.315	79	3.110	77.7	3.057	41	1.614	1.5	.057	20	290	DIN 6537 K	
8.00	.315	40.9	1.610	5	8	860.1-0800-040A1-SM	★	8.0	.315	91	3.583	89.7	3.530	53	2.087	1.5	.057	20	290	DIN 6537 L	
8.10	.319	25.8	1.016	3	10	860.1-0810-025A1-SM	★	10.0	.394	89	3.504	87.6	3.450	47	1.850	1.5	.058	20	290	DIN 6537 K	
8.10	.319	42.0	1.654	5	10	860.1-0810-041A1-SM	★	10.0	.394	103	4.055	101.6	4.002	61	2.402	1.5	.058	20	290	DIN 6537 L	

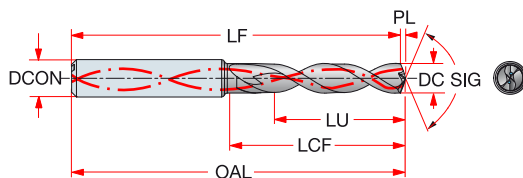


B76

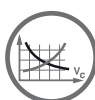
CoroDrill® 860 Vollhartmetallbohrer

Für warmfeste Superlegierungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

							s Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	1210	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG
8.20	.323	26.1	1.028	3	10	860.1-0820-026A1-SM	★	10.0	.394	89	3.504	87.6	3.450	47	1.850	1.5	.059	20	290	DIN 6537 K
8.30	.327	26.4	1.039	3	10	860.1-0830-026A1-SM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.059	20	290	DIN 6537 K
8.33	.328	26.5	1.043	3	10	860.1-0833-026A1-SM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.060	20	290	DIN 6537 K
8.40	.331	26.7	1.051	3	10	860.1-0840-026A1-SM	★	10.0	.394	89	3.504	87.6	3.448	47	1.850	1.5	.060	20	290	DIN 6537 K
8.40	.331	43.5	1.713	5	10	860.1-0840-043A1-SM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.5	.060	20	290	DIN 6537 L
8.45	.333	26.9	1.059	3	10	860.1-0845-026A1-SM	★	10.0	.394	89	3.504	87.6	3.448	47	1.850	1.5	.061	20	290	DIN 6537 K
8.50	.335	27.0	1.063	3	10	860.1-0850-027A1-SM	★	10.0	.394	89	3.504	87.6	3.448	47	1.850	1.6	.061	20	290	DIN 6537 K
8.50	.335	44.0	1.732	5	10	860.1-0850-044A1-SM	★	10.0	.394	103	4.055	101.6	3.999	53	2.087	1.6	.061	20	290	DIN 6537 L
8.60	.339	27.4	1.079	3	10	860.1-0860-027A1-SM	★	10.0	.394	89	3.504	87.6	3.447	47	1.850	1.6	.062	20	290	DIN 6537 K
8.60	.339	44.6	1.756	5	10	860.1-0860-044A1-SM	★	10.0	.394	103	4.055	101.6	3.998	61	2.402	1.6	.062	20	290	DIN 6537 L
8.65	.341	27.5	1.083	3	10	860.1-0865-027A1-SM	★	10.0	.394	89	3.504	87.6	3.447	47	1.850	1.6	.062	20	290	DIN 6537 K
8.70	.343	27.7	1.091	3	10	860.1-0870-027A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.6	.062	20	290	DIN 6537 K
8.73	.344	27.8	1.094	3	10	860.1-0873-027A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.6	.063	20	290	DIN 6537 K
8.73	.344	45.2	1.780	5	10	860.1-0873-045A1-SM	★	10.0	.394	103	4.055	101.5	3.998	61	2.402	1.6	.063	20	290	DIN 6537 L
8.80	.346	28.0	1.102	3	10	860.1-0880-028A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.6	.063	20	290	DIN 6537 K
8.85	.348	28.2	1.110	3	10	860.1-0885-028A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.6	.063	20	290	DIN 6537 K
9.00	.354	28.6	1.126	3	10	860.1-0900-028A1-SM	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.6	.065	20	290	DIN 6537 K
9.00	.354	46.2	1.819	5	10	860.1-0900-046A1-SM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.6	.065	20	290	DIN 6537 L
9.20	.362	29.3	1.154	3	10	860.1-0920-029A1-SM	★	10.0	.394	89	3.504	87.5	3.443	47	1.850	1.7	.066	20	290	DIN 6537 K
9.30	.366	29.6	1.165	3	10	860.1-0930-029A1-SM	★	10.0	.394	89	3.504	87.4	3.443	47	1.850	1.7	.067	20	290	DIN 6537 K
9.30	.366	46.3	1.823	4	10	860.1-0930-046A1-SM	★	10.0	.394	103	4.055	101.4	3.994	61	2.402	1.7	.067	20	290	DIN 6537 L
9.40	.370	29.9	1.177	3	10	860.1-0940-029A1-SM	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.7	.067	20	290	DIN 6537 K
9.50	.374	30.2	1.189	3	10	860.1-0950-030A1-SM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.068	20	290	DIN 6537 K
9.52	.375	30.3	1.193	3	10	860.1-0952-030A1-SM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.068	20	290	DIN 6537 K
9.53	.375	30.3	1.193	3	10	860.1-0953-030A1-SM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.068	20	290	DIN 6537 K
9.60	.378	30.5	1.201	3	10	860.1-0960-030A1-SM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.8	.069	20	290	DIN 6537 K
9.70	.382	30.9	1.217	3	10	860.1-0970-030A1-SM	★	10.0	.394	89	3.504	87.4	3.440	47	1.850	1.8	.070	20	290	DIN 6537 K
9.80	.386	31.2	1.228	3	10	860.1-0980-031A1-SM	★	10.0	.394	89	3.504	87.4	3.439	47	1.850	1.8	.070	20	290	DIN 6537 K
9.80	.386	46.4	1.827	4	10	860.1-0980-046A1-SM	★	10.0	.394	103	4.055	101.4	3.991	61	2.402	1.8	.070	20	290	DIN 6537 L
9.90	.390	46.5	1.831	4	10	860.1-0990-046A1-SM	★	10.0	.394	103	4.055	101.3	3.990	61	2.402	1.8	.071	20	290	DIN 6537 L
9.92	.391	31.6	1.244	3	10	860.1-0992-031A1-SM	★	10.0	.394	89	3.504	87.3	3.439	47	1.850	1.8	.071	20	290	DIN 6537 K
10.00	.394	31.8	1.252	3	10	860.1-1000-031A1-SM	★	10.0	.394	89	3.504	87.3	3.438	47	1.850	1.8	.072	20	290	DIN 6537 K
10.00	.394	46.5	1.831	4	10	860.1-1000-046A1-SM	★	10.0	.394	103	4.055	101.3	3.989	61	2.402	1.8	.072	20	290	DIN 6537 L
10.10	.398	32.1	1.264	3	12	860.1-1010-032A1-SM	★	12.0	.472	102	4.016	100.3	3.949	47	1.850	1.8	.072	20	290	DIN 6537 K
10.20	.402	32.5	1.280	3	12	860.1-1020-032A1-SM	★	12.0	.472	102	4.016	100.3	3.948	55	2.165	1.9	.073	20	290	DIN 6537 K
10.30	.406	32.8	1.291	3	12	860.1-1030-032A1-SM	★	12.0	.472	102	4.016	100.3	3.948	55	2.165	1.9	.074	20	290	DIN 6537 K
10.30	.406	53.4	2.102	5	12	860.1-1030-053A1-SM	★	12.0	.472	118	4.646	116.3	4.578	71	2.795	1.9	.074	20	290	DIN 6537 L
10.32	.406	32.8	1.291	3	12	860.1-1032-032A1-SM	★	12.0	.472	102	4.016	100.3	3.948	55	2.165	1.9	.074	20	290	DIN 6537 K
10.50	.413	33.4	1.315	3	12	860.1-1050-033A1-SM	★	12.0	.472	102	4.016	100.2	3.946	55	2.165	1.9	.075	20	290	DIN 6537 K
10.50	.413	54.2	2.134	5	12	860.1-1050-054A1-SM	★	12.0	.472	118	4.646	116.2	4.576	71	2.795	1.9	.075	20	290	DIN 6537 L
10.80	.425	34.4	1.354	3	12	860.1-1080-034A1-SM	★	12.0	.472	102	4.016	100.2	3.944	55	2.165	2.0	.078	20	290	DIN 6537 K
11.00	.433	35.0	1.378	3	12	860.1-1100-035A1-SM	★	12.0	.472	102	4.016	100.2	3.943	55	2.165	2.0	.079	20	290	DIN 6537 K
11.00	.433	54.2	2.134	4	12	860.1-1100-054A1-SM	★	12.0	.472	118	4.646	116.2	4.573	71	2.795	2.0	.079	20	290	DIN 6537 L
11.11	.437	35.4	1.394	3	12	860.1-1111-035A1-SM	★	12.0	.472	102	4.016	100.1	3.943	55	2.165	2.0	.080	20	290	DIN 6537 K
11.20	.441	35.6	1.402	3	12	860.1-1120-035A1-SM	★	12.0	.472	102	4.016	100.1	3.942	55	2.165	2.0	.080	20	290	DIN 6537 K
11.50	.453	36.6	1.441	3	12	860.1-1150-036A1-SM	★	12.0	.472	102	4.016	100.1	3.940	55	2.165	2.1	.082	20	290	DIN 6537 K
11.80	.465	37.5	1.476	3	12	860.1-1180-037A1-SM	★	12.0	.472	102	4.016	100.0	3.938	55	2.165	2.2	.085	20	290	DIN 6537 K
12.00	.472	38.2	1.504	3	12	860.1-1200-038A1-SM	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.2	.086	20	290	DIN 6537 K
12.00	.472	54.3	2.138	4	12	860.1-1200-054A1-SM	★	12.0	.472	118	4.646	116.0	4.567	61	2.402	2.2	.086	20	290	DIN 6537 L



B76



E9



E28



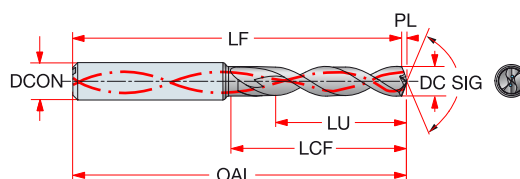
E14

CoroDrill® 860 Vollhartmetallbohrer

Für warmfeste Superlegierungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°



										s	Abmessungen, mm, Zoll									
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	1210	DCON _{MS}	DCON _{MS} "	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
12.10	.476	38.5	1.516	3	14	860.1-1210-038A1-SM	★	14.0	.551	107	4.213	105.0	4.133	60	2.362	2.2	.087	20	290	DIN 6537 K
12.20	.480	38.8	1.528	3	14	860.1-1220-038A1-SM	★	14.0	.551	107	4.213	105.0	4.132	55	2.165	2.2	.087	20	290	DIN 6537 K
12.40	.488	39.5	1.555	3	14	860.1-1240-039A1-SM	★	14.0	.551	107	4.213	104.9	4.131	60	2.362	2.3	.089	20	290	DIN 6537 K
12.50	.492	39.8	1.567	3	14	860.1-1250-039A1-SM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.3	.089	20	290	DIN 6537 K
12.70	.500	40.4	1.591	3	14	860.1-1270-040A1-SM	★	14.0	.551	107	4.213	104.9	4.129	60	2.362	2.3	.091	20	290	DIN 6537 K
12.70	.500	57.6	2.268	4	14	860.1-1270-057A1-SM	★	14.0	.551	124	4.882	121.9	4.798	71	2.795	2.3	.091	20	290	DIN 6537 L
12.90	.508	40.6	1.598	3	14	860.1-1290-040A1-SM	★	14.0	.551	107	4.213	104.8	4.128	60	2.362	2.4	.093	20	290	DIN 6537 K
13.00	.512	40.5	1.594	3	14	860.1-1300-040A1-SM	★	14.0	.551	107	4.213	104.8	4.127	60	2.362	2.4	.093	20	290	DIN 6537 K
13.25	.522	40.5	1.594	3	14	860.1-1325-040A1-SM	★	14.0	.551	107	4.213	104.8	4.125	60	2.362	2.4	.095	20	290	DIN 6537 K
13.50	.531	40.6	1.598	3	14	860.1-1350-040A1-SM	★	14.0	.551	107	4.213	104.7	4.124	60	2.362	2.5	.097	20	290	DIN 6537 K
13.70	.539	40.6	1.598	2	14	860.1-1370-040A1-SM	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.5	.098	20	290	DIN 6537 K
13.70	.539	57.6	2.268	4	14	860.1-1370-057A1-SM	★	14.0	.551	124	4.882	121.7	4.792	77	3.032	2.5	.098	20	290	DIN 6537 L
13.75	.541	40.6	1.598	2	14	860.1-1375-040A1-SM	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.5	.098	20	290	DIN 6537 K
14.00	.551	40.6	1.598	2	14	860.1-1400-040A1-SM	★	14.0	.551	107	4.213	104.7	4.120	60	2.362	2.6	.100	20	290	DIN 6537 K
15.50	.610	43.6	1.717	2	16	860.1-1550-043A1-SM	★	16.0	.630	115	4.528	112.4	4.425	65	2.559	2.8	.111	20	290	DIN 6537 K
15.87	.625	50.5	1.988	3	16	860.1-1587-061A1-SM	★	16.0	.630	133	5.236	130.3	5.132	83	3.268	2.9	.114	20	290	DIN 6537 L



B76



E9



E28



E14

CoroDrill® 861

Tiefbohren mit hoher Stabilität bis zu 30 × DC



B Anwendungsbereich

- Erzielbare Bohrungstoleranz H8–H9
- Bohrtiefen: 12–30 × Bohrerdurchmesser einsetzen
- Nur mit hochpräzisem Spannfutter aufspannen
- Großes Werkstoffspektrum
- Konventionelles Bohren, Kreuzbohrungen, schräge Flächen
- Automobilindustrie: Kurbelwellen, Motorblöcke, Zylinderköpfe
- Kühlschmierstoffdruck optimalerweise 20 bar oder höher

ISO-Anwendungsbereich:



C Merkmale und Vorteile

- Speziell entwickelte Spitzengeometrie hilft Axialkräfte zu reduzieren
- Gleichmäßige Kantenpräparation schützt die Schneide vor frühzeitigen Ausbrüchen und Abplatzungen
- Patentierte Geometrie mit „Doppelter Umfangsstützfase“ sorgt für höhere Stabilität beim Bohrvorgang
- Durch innere Kühlschmierstoffbohrungen gelangt der Kühlschmierstoff selbst bei großer Bohrungstiefe direkt an die Bohrerspitze
- Kann für verlängerte Standzeit gemäß Originalspezifikation nachgeschliffen werden



D www.sandvik.coromant.com/corodrill861

E Empfehlungen

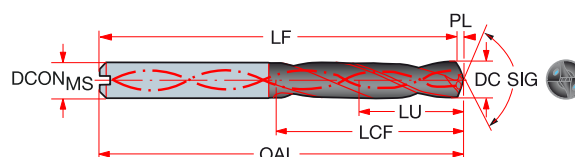
Verwenden Sie CoroChuck 930 mit Ihrem CoroDrill 861 für eine effiziente Produktion durch schnelle, hochgenaue und einfache Werkzeugspannungen und -wechsel



CoroDrill® 861 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Pilotbohrer - Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 150°

							P	M	K	N	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG	
3.00	.118	9.4	.370	3	6	861.1-0300-009A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K	
3.18	.125	9.9	.390	3	6	861.1-0318-010A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K	
3.30	.130	10.3	.406	3	6	861.1-0330-010A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K	
3.50	.138	10.9	.429	3	6	861.1-0350-011A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K	
3.57	.141	11.1	.437	3	6	861.1-0357-011A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K	
3.80	.150	11.9	.469	3	6	861.1-0380-011A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K	
3.97	.156	12.4	.488	3	6	861.1-0397-012A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K	
4.00	.157	12.5	.492	3	6	861.1-0400-012A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K	
4.20	.165	13.1	.516	3	6	861.1-0420-013A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K	
4.36	.172	13.6	.535	3	6	861.1-0436-013A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K	
4.50	.177	14.0	.551	3	6	861.1-0450-014A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K	
4.76	.187	14.9	.587	3	6	861.1-0476-014A1-GP	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 K	
4.80	.189	15.0	.591	3	6	861.1-0480-014A1-GP	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 K	
5.00	.197	15.6	.614	3	6	861.1-0500-015A1-GP	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 K	
5.16	.203	16.1	.634	3	6	861.1-0516-015A1-GP	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 K	
5.50	.217	17.2	.677	3	6	861.1-0550-017A1-GP	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
5.56	.219	17.3	.681	3	6	861.1-0556-017A1-GP	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
5.80	.228	17.6	.693	3	6	861.1-0580-017A1-GP	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
6.00	.236	18.7	.736	3	6	861.1-0600-018A1-GP	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K	
6.35	.250	19.8	.780	3	8	861.1-0635-019A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K	
6.50	.256	20.3	.799	3	8	861.1-0650-020A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K	
6.75	.266	21.1	.831	3	8	861.1-0675-020A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K	
6.80	.268	21.2	.835	3	8	861.1-0680-020A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K	
7.00	.276	21.8	.858	3	8	861.1-0700-021A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K	
7.14	.281	22.3	.878	3	8	861.1-0714-021A1-GP	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	41	1.614	0.9	.035	20	290	DIN 6537 K	
7.50	.295	23.4	.921	3	8	861.1-0750-023A1-GP	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	41	1.614	0.9	.035	20	290	DIN 6537 K	
7.94	.313	24.8	.976	3	8	861.1-0794-024A1-GP	★	★	★	★	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K	
8.00	.315	25.0	.984	3	8	861.1-0800-024A1-GP	★	★	★	★	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K	
8.50	.335	26.5	1.043	3	10	861.1-0850-026A1-GP	★	★	★	★	10.0	.394	89	3.504	88.0	3.465	47	1.850	1.0	.039	20	290	DIN 6537 K	
9.00	.354	28.1	1.106	3	10	861.1-0900-027A1-GP	★	★	★	★	10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K	
9.50	.374	29.6	1.165	3	10	861.1-0950-029A1-GP	★	★	★	★	10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K	
9.53	.375	29.7	1.169	3	10	861.1-0953-029A1-GP	★	★	★	★	10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K	
10.00	.394	31.2	1.228	3	10	861.1-1000-030A1-GP	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K	
10.50	.413	32.8	1.291	3	12	861.1-1050-032A1-GP	★	★	★	★	12.0	.472	102	4.016	100.7	3.965	55	2.165	1.3	.051	20	290	DIN 6537 K	
11.00	.433	34.3	1.350	3	12	861.1-1100-033A1-GP	★	★	★	★	12.0	.472	102	4.016	100.7	3.965	55	2.165	1.3	.051	20	290	DIN 6537 K	
11.11	.437	34.7	1.366	3	12	861.1-1111-033A1-GP	★	★	★	★	12.0	.472	102	4.016	100.7	3.965	55	2.165	1.3	.051	20	290	DIN 6537 K	
11.50	.453	35.9	1.413	3	12	861.1-1150-035A1-GP	★	★	★	★	12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K	
12.00	.472	37.4	1.472	3	12	861.1-1200-036A1-GP	★	★	★	★	12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K	

Schnittdaten: www.sandvik.coromant.com

E9



E28

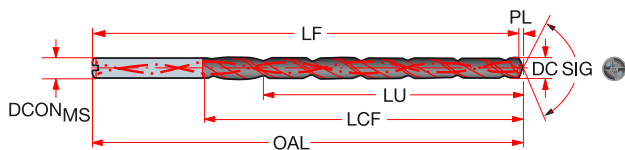


E14

CoroDrill® 861 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Tieflochbohrer – Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

							P	M	K	N	Abmessungen, mm, Zoll																
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	D _{CON} _{MS}	D _{CON} _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG				
3.00	.118	36.5	1.437	12	6	861.1-0300-036A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT				
3.00	.118	45.5	1.791	15	6	861.1-0300-045A1-GM	★	★	★	★	6.0	.236	96	3.780	95.5	3.760	54	2.126	0.5	.020	20	290	COROMANT				
3.00	.118	60.5	2.382	20	6	861.1-0300-060A1-GM	★	★	★	★	6.0	.236	111	4.370	110.5	4.350	69	2.717	0.5	.020	20	290	COROMANT				
3.00	.118	90.5	3.563	30	6	861.1-0300-090A1-GM	★	★	★	★	6.0	.236	141	5.551	140.5	5.532	99	3.898	0.5	.020	20	290	COROMANT				
3.10	.122	37.7	1.484	12	6	861.1-0310-037A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT				
3.18	.125	38.6	1.520	12	6	861.1-0318-038A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT				
3.18	.125	48.1	1.894	15	6	861.1-0318-048A1-GM	★	★	★	★	6.0	.236	99	3.898	98.6	3.882	57	2.244	0.5	.020	20	290	COROMANT				
3.18	.125	64.0	2.520	20	6	861.1-0318-064A1-GM	★	★	★	★	6.0	.236	115	4.528	114.5	4.508	73	2.874	0.5	.020	20	290	COROMANT				
3.18	.125	95.8	3.772	30	6	861.1-0318-095A1-GM	★	★	★	★	6.0	.236	147	5.787	146.3	5.760	105	4.134	0.5	.020	20	290	COROMANT				
3.20	.126	38.9	1.532	12	6	861.1-0320-038A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT				
3.30	.130	40.1	1.579	12	6	861.1-0330-040A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT				
3.30	.130	50.0	1.969	15	6	861.1-0330-050A1-GM	★	★	★	★	6.0	.236	101	3.976	100.9	3.972	59	2.323	0.5	.020	20	290	COROMANT				
3.30	.130	66.5	2.618	20	6	861.1-0330-066A1-GM	★	★	★	★	6.0	.236	118	4.646	117.4	4.622	76	2.992	0.5	.020	20	290	COROMANT				
3.40	.134	41.4	1.630	12	6	861.1-0340-041A1-GM	★	★	★	★	6.0	.236	94	3.701	93.4	3.677	52	2.047	0.6	.024	20	290	COROMANT				
3.50	.138	42.6	1.677	12	6	861.1-0350-042A1-GM	★	★	★	★	6.0	.236	94	3.701	93.4	3.677	52	2.047	0.6	.024	20	290	COROMANT				
3.50	.138	53.1	2.091	15	6	861.1-0350-053A1-GM	★	★	★	★	6.0	.236	105	4.134	104.4	4.110	63	2.480	0.6	.024	20	290	COROMANT				
3.50	.138	70.6	2.780	20	6	861.1-0350-070A1-GM	★	★	★	★	6.0	.236	123	4.843	121.9	4.799	81	3.189	0.6	.024	20	290	COROMANT				
3.50	.138	105.6	4.157	30	6	861.1-0350-105A1-GM	★	★	★	★	6.0	.236	158	6.220	156.9	6.177	116	4.567	0.6	.024	20	290	COROMANT				
3.57	.141	54.2	2.134	15	6	861.1-0357-054A1-GM	★	★	★	★	6.0	.236	106	4.173	105.7	4.161	64	2.520	0.6	.024	20	290	COROMANT				
3.57	.141	72.0	2.835	20	6	861.1-0357-071A1-GM	★	★	★	★	6.0	.236	124	4.882	123.6	4.866	82	3.228	0.6	.024	20	290	COROMANT				
3.70	.146	43.9	1.728	11	6	861.1-0370-044A1-GM	★	★	★	★	6.0	.236	94	3.701	93.4	3.677	52	2.047	0.6	.024	20	290	COROMANT				
3.80	.150	46.2	1.819	12	6	861.1-0380-046A1-GM	★	★	★	★	6.0	.236	109	4.291	108.4	4.268	67	2.638	0.6	.024	20	290	COROMANT				
3.80	.150	57.6	2.268	15	6	861.1-0380-057A1-GM	★	★	★	★	6.0	.236	110	4.331	109.8	4.323	68	2.677	0.6	.024	20	290	COROMANT				
3.80	.150	76.6	3.016	20	6	861.1-0380-076A1-GM	★	★	★	★	6.0	.236	129	5.079	128.8	5.071	87	3.425	0.6	.024	20	290	COROMANT				
3.97	.156	48.3	1.902	12	6	861.1-0397-048A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT				
3.97	.156	60.2	2.370	15	6	861.1-0397-060A1-GM	★	★	★	★	6.0	.236	113	4.449	112.8	4.441	71	2.795	0.7	.028	20	290	COROMANT				
3.97	.156	80.0	3.150	20	6	861.1-0397-079A1-GM	★	★	★	★	6.0	.236	133	5.236	132.6	5.220	91	3.583	0.7	.028	20	290	COROMANT				
3.97	.156	119.7	4.713	30	6	861.1-0397-119A1-GM	★	★	★	★	6.0	.236	173	6.811	172.3	6.783	131	5.157	0.7	.028	20	290	COROMANT				
4.00	.157	48.7	1.917	12	6	861.1-0400-048A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT				
4.00	.157	60.7	2.390	15	6	861.1-0400-060A1-GM	★	★	★	★	6.0	.236	114	4.488	113.3	4.461	72	2.835	0.7	.028	20	290	COROMANT				
4.00	.157	80.7	3.177	20	6	861.1-0400-080A1-GM	★	★	★	★	6.0	.236	134	5.276	133.3	5.248	92	3.622	0.7	.028	20	290	COROMANT				
4.00	.157	120.7	4.752	30	6	861.1-0400-120A1-GM	★	★	★	★	6.0	.236	174	6.850	173.3	6.823	132	5.197	0.7	.028	20	290	COROMANT				
4.10	.161	49.9	1.965	12	6	861.1-0410-049A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT				
4.20	.165	51.1	2.012	12	6	861.1-0420-050A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT				
4.20	.165	63.7	2.508	15	6	861.1-0420-063A1-GM	★	★	★	★	6.0	.236	118	4.646	116.9	4.602	76	2.992	0.7	.028	20	290	COROMANT				
4.20	.165	84.7	3.335	20	6	861.1-0420-084A1-GM	★	★	★	★	6.0	.236	139	5.472	137.9	5.429	97	3.819	0.7	.028	20	290	COROMANT				
4.30	.169	52.3	2.059	12	6	861.1-0430-052A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT				
4.37	.172	53.1	2.091	12	6	861.1-0437-052A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT				
4.37	.172	66.2	2.606	15	6	861.1-0437-065A1-GM	★	★	★	★	6.0	.236	121	4.764	119.9	4.720	79	3.110	0.7	.028	20	290	COROMANT				
4.37	.172	88.0	3.465	20	6	861.1-0437-087A1-GM	★	★	★	★	6.0	.236	142	5.591	141.7	5.579	100	3.937	0.7	.028	20	290	COROMANT				
4.37	.172	131.7	5.185	30	6	861.1-0437-131A1-GM	★	★	★	★	6.0	.236	186	7.323	185.4	7.299	144	5.669	0.7	.028	20	290	COROMANT				
4.50	.177	54.7	2.154	12	6	861.1-0450-054A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT				
4.50	.177	68.2	2.685	15	6	861.1-0450-068A1-GM	★	★	★	★	6.0	.236	123	4.843	122.3	4.815	81	3.189	0.7	.028	20	290	COROMANT				
4.50	.177	90.7	3.571	20	6	861.1-0450-090A1-GM	★	★	★	★	6.0	.236	146	5.748	144.8	5.701	104	4.094	0.7	.028	20	290	COROMANT				
4.50	.177	135.7	5.343	30	6	861.1-0450-135A1-GM	★	★	★	★	6.0	.236	191	7.520	189.8	7.472	149	5.866	0.7	.028	20	290	COROMANT				
4.60	.181	56.0	2.205	12	6	861.1-0460-055A1-GM	★	★	★	★	6.0	.236	109	4.291	108.2	4.260	67	2.638	0.8	.031	20	290	COROMANT				
4.76	.187	57.9	2.280	12	6	861.1-0476-057A1-GM	★	★	★	★	6.0	.236	128	5.039	127.2	5.008	86	3.386	0.8	.031	20	290	COROMANT				
4.76	.187	72.2	2.843	15	6	861.1-0476-071A1-GM	★	★	★	★	6.0	.236	128	5.039	126.9	4.996	86	3.386	0.8	.031	20	290	COROMANT				
4.76	.187	96.0	3.780	20	6	861.1-0476-095A1-GM	★	★	★	★	6.0	.236	152	5.984	150.7	5.933	110	4.331	0.8	.031	20	290	COROMANT				
4.76	.187	143.6	5.654	30	6	861.1-0476-143A1-GM	★	★	★	★	6.0	.236	199	7.835	198.4	7.811	157	6.181	0.8	.031	20	290	COROMANT				

GER

Tieflochbohrer – Innere Kühlschmierstoffzufuhr

B

C

D

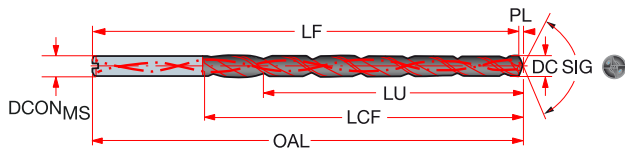
E



CoroDrill® 861 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Tieflochbohrer – Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

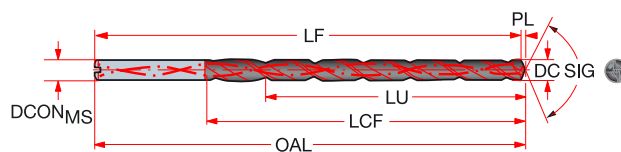
							P	M	K	N	Abmessungen, mm, Zoll													
DC	DC"	LU	LU"	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} "	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG	
7.14	.281	86.9	3.421	12	8	861.1-0714-086A1-GM	★	★	★	★	8.0	.315	158	6.220	156.8	6.173	116	4.567	1.2	.047	20	290	COROMANT	
7.14	.281	108.3	4.264	15	8	861.1-0714-107A1-GM	★	★	★	★	8.0	.315	171	6.732	169.4	6.669	129	5.079	1.2	.047	20	290	COROMANT	
7.14	.281	144.1	5.673	20	8	861.1-0714-143A1-GM	★	★	★	★	8.0	.315	206	8.110	205.1	8.075	164	6.457	1.2	.047	20	290	COROMANT	
7.14	.281	215.5	8.484	30	8	861.1-0714-214A1-GM	★	★	★	★	8.0	.315	278	10.945	276.6	10.890	236	9.291	1.2	.047	20	290	COROMANT	
7.40	.291	90.0	3.543	12	8	861.1-0740-089A1-GM	★	★	★	★	8.0	.315	158	6.220	156.8	6.173	116	4.567	1.2	.047	20	290	COROMANT	
7.50	.295	91.2	3.591	12	8	861.1-0750-090A1-GM	★	★	★	★	8.0	.315	158	6.220	156.8	6.173	116	4.567	1.2	.047	20	290	COROMANT	
7.50	.295	113.7	4.476	15	8	861.1-0750-113A1-GM	★	★	★	★	8.0	.315	177	6.969	175.8	6.921	135	5.315	1.2	.047	20	290	COROMANT	
7.50	.295	151.2	5.953	20	8	861.1-0750-150A1-GM	★	★	★	★	8.0	.315	215	8.465	213.3	8.398	173	6.811	1.2	.047	20	290	COROMANT	
7.50	.295	226.2	8.906	30	8	861.1-0750-225A1-GM	★	★	★	★	8.0	.315	290	11.417	288.3	11.350	248	9.764	1.2	.047	20	290	COROMANT	
7.60	.299	92.4	3.638	12	8	861.1-0760-091A1-GM	★	★	★	★	8.0	.315	158	6.220	156.8	6.173	116	4.567	1.2	.047	20	290	COROMANT	
7.70	.303	93.7	3.689	12	8	861.1-0770-092A1-GM	★	★	★	★	8.0	.315	158	6.220	156.7	6.169	116	4.567	1.3	.051	20	290	COROMANT	
7.80	.307	94.9	3.736	12	8	861.1-0780-094A1-GM	★	★	★	★	8.0	.315	158	6.220	156.7	6.169	116	4.567	1.3	.051	20	290	COROMANT	
7.94	.313	96.6	3.803	12	8	861.1-0794-095A1-GM	★	★	★	★	8.0	.315	158	6.220	156.7	6.169	116	4.567	1.3	.051	20	290	COROMANT	
7.94	.313	120.4	4.740	15	8	861.1-0794-119A1-GM	★	★	★	★	8.0	.315	185	7.283	183.6	7.228	143	5.630	1.3	.051	20	290	COROMANT	
7.94	.313	160.1	6.303	20	8	861.1-0794-159A1-GM	★	★	★	★	8.0	.315	225	8.858	223.3	8.791	183	7.205	1.3	.051	20	290	COROMANT	
7.94	.313	239.4	9.425	30	8	861.1-0794-238A1-GM	★	★	★	★	8.0	.315	304	11.969	302.7	11.917	262	10.315	1.3	.051	20	290	COROMANT	
8.00	.315	97.3	3.831	12	8	861.1-0800-096A1-GM	★	★	★	★	8.0	.315	158	6.220	156.7	6.169	116	4.567	1.3	.051	20	290	COROMANT	
8.00	.315	121.3	4.776	15	8	861.1-0800-120A1-GM	★	★	★	★	8.0	.315	186	7.323	184.7	7.272	144	5.669	1.3	.051	20	290	COROMANT	
8.00	.315	161.3	6.350	20	8	861.1-0800-160A1-GM	★	★	★	★	8.0	.315	226	8.898	224.7	8.846	184	7.244	1.3	.051	20	290	COROMANT	
8.00	.315	241.3	9.500	30	8	861.1-0800-240A1-GM	★	★	★	★	8.0	.315	306	12.047	304.7	11.996	264	10.394	1.3	.051	20	290	COROMANT	
8.10	.319	98.5	3.878	12	10	861.1-0810-097A1-GM	★	★	★	★	10.0	.394	192	7.559	190.7	7.508	146	5.748	1.3	.051	20	290	COROMANT	
8.20	.323	99.7	3.925	12	10	861.1-0820-098A1-GM	★	★	★	★	10.0	.394	192	7.559	190.7	7.508	146	5.748	1.3	.051	20	290	COROMANT	
8.33	.328	101.4	3.992	12	10	861.1-0833-100A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT	
8.40	.331	102.2	4.024	12	10	861.1-0840-101A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT	
8.50	.335	103.4	4.071	12	10	861.1-0850-102A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT	
8.50	.335	128.9	5.075	15	10	861.1-0850-128A1-GM	★	★	★	★	10.0	.394	199	7.835	197.6	7.780	153	6.024	1.4	.055	20	290	COROMANT	
8.50	.335	171.4	6.748	20	10	861.1-0850-170A1-GM	★	★	★	★	10.0	.394	242	9.528	240.1	9.453	196	7.717	1.4	.055	20	290	COROMANT	
8.60	.339	104.6	4.118	12	10	861.1-0860-103A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT	
8.70	.343	105.8	4.165	12	10	861.1-0870-104A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT	
8.73	.344	106.2	4.181	12	10	861.1-0873-105A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT	
8.80	.346	107.0	4.213	12	10	861.1-0880-106A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT	
9.00	.354	109.5	4.311	12	10	861.1-0900-108A1-GM	★	★	★	★	10.0	.394	192	7.559	190.5	7.500	146	5.748	1.5	.059	20	290	COROMANT	
9.00	.354	136.5	5.374	15	10	861.1-0900-135A1-GM	★	★	★	★	10.0	.394	208	8.189	206.5	8.130	162	6.378	1.5	.059	20	290	COROMANT	
9.00	.354	181.5	7.146	20	10	861.1-0900-180A1-GM	★	★	★	★	10.0	.394	253	9.961	251.5	9.902	207	8.150	1.5	.059	20	290	COROMANT	
9.13	.359	111.0	4.370	12	10	861.1-0913-110A1-GM	★	★	★	★	10.0	.394	192	7.559	190.5	7.500	146	5.748	1.5	.059	20	290	COROMANT	
9.30	.366	113.1	4.453	12	10	861.1-0930-112A1-GM	★	★	★	★	10.0	.394	192	7.559	190.5	7.500	146	5.748	1.5	.059	20	290	COROMANT	
9.50	.374	115.6	4.551	12	10	861.1-0950-114A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT	
9.50	.374	144.1	5.673	15	10	861.1-0950-143A1-GM	★	★	★	★	10.0	.394	217	8.543	215.4	8.480	171	6.732	1.6	.063	20	290	COROMANT	
9.50	.374	191.6	7.543	20	10	861.1-0950-190A1-GM	★	★	★	★	10.0	.394	265	10.433	262.9	10.350	219	8.622	1.6	.063	20	290	COROMANT	
9.53	.375	115.9	4.563	12	10	861.1-0953-114A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT	
9.53	.375	144.4	5.685	15	10	861.1-0953-143A1-GM	★	★	★	★	10.0	.394	217	8.543	215.9	8.500	171	6.732	1.6	.063	20	290	COROMANT	
9.53	.375	192.1	7.563	20	10	861.1-0953-191A1-GM	★	★	★	★	10.0	.394	265	10.433	263.5	10.374	219	8.622	1.6	.063	20	290	COROMANT	
9.80	.386	119.2	4.693	12	10	861.1-0980-118A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT	
9.92	.391	120.7	4.752	12	10	861.1-0992-119A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT	
10.00	.394	121.6	4.787	12	10	861.1-1000-120A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT	
10.00	.394	151.6	5.969	15	10	861.1-1000-150A1-GM	★	★	★	★	10.0	.394	226	8.898	224.4	8.835	180	7.087	1.6	.063	20	290	COROMANT	
10.00	.394	201.6	7.937	20	10	861.1-1000-200A1-GM	★	★	★	★	10.0	.394	276	10.866	274.4	10.803	230	9.055	1.6	.063	20	290	COROMANT	
10.20	.402	124.1	4.886	12	12	861.1-1020-122A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT	
10.30	.406	125.3	4.933	12	12	861.1-1030-124A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT	
10.32	.406	125.5	4.941	12	12	861.1-1032-124A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT	
10.40	.409	126.5	4.980	12	12	861.1-1040-125A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT	

CoroDrill® 861 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Tieflochbohrer – Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°



							P	M	K	N	Abmessungen, mm, Zoll														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG		
10.50	.413	127.7	5.028	12	12	861.1-1050-126A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT		
10.50	.413	159.2	6.268	15	12	861.1-1050-158A1-GM	★	★	★	★	12.0	.472	240	9.449	238.3	9.382	189	7.441	1.7	.067	20	290	COROMANT		
10.50	.413	211.7	8.335	20	12	861.1-1050-210A1-GM	★	★	★	★	12.0	.472	293	11.535	290.8	11.449	242	9.528	1.7	.067	20	290	COROMANT		
10.72	.422	130.3	5.130	12	12	861.1-1072-129A1-GM	★	★	★	★	12.0	.472	228	8.976	226.2	8.906	176	6.929	1.8	.071	20	290	COROMANT		
11.00	.433	133.8	5.268	12	12	861.1-1100-132A1-GM	★	★	★	★	12.0	.472	228	8.976	226.2	8.906	176	6.929	1.8	.071	20	290	COROMANT		
11.00	.433	166.8	6.567	15	12	861.1-1100-165A1-GM	★	★	★	★	12.0	.472	249	9.803	247.2	9.732	198	7.795	1.8	.071	20	290	COROMANT		
11.00	.433	221.8	8.732	20	12	861.1-1100-220A1-GM	★	★	★	★	12.0	.472	304	11.969	302.2	11.898	253	9.961	1.8	.071	20	290	COROMANT		
11.11	.437	135.2	5.323	12	12	861.1-1111-133A1-GM	★	★	★	★	12.0	.472	228	8.976	226.2	8.906	176	6.929	1.8	.071	20	290	COROMANT		
11.11	.437	168.5	6.634	15	12	861.1-1111-167A1-GM	★	★	★	★	12.0	.472	251	9.882	249.2	9.811	200	7.874	1.8	.071	20	290	COROMANT		
11.11	.437	224.1	8.823	20	12	861.1-1111-222A1-GM	★	★	★	★	12.0	.472	307	12.087	304.8	12.000	256	10.079	1.8	.071	20	290	COROMANT		
11.20	.441	136.2	5.362	12	12	861.1-1120-134A1-GM	★	★	★	★	12.0	.472	228	8.976	226.2	8.906	176	6.929	1.8	.071	20	290	COROMANT		
11.50	.453	139.9	5.508	12	12	861.1-1150-138A1-GM	★	★	★	★	12.0	.472	228	8.976	226.1	8.902	176	6.929	1.9	.075	20	290	COROMANT		
11.50	.453	174.4	6.866	15	12	861.1-1150-173A1-GM	★	★	★	★	12.0	.472	258	10.158	256.1	10.083	207	8.150	1.9	.075	20	290	COROMANT		
11.50	.453	231.9	9.130	20	12	861.1-1150-230A1-GM	★	★	★	★	12.0	.472	316	12.441	313.6	12.347	265	10.433	1.9	.075	20	290	COROMANT		
11.80	.465	143.5	5.650	12	12	861.1-1180-142A1-GM	★	★	★	★	12.0	.472	228	8.976	226.1	8.902	176	6.929	1.9	.075	20	290	COROMANT		
12.00	.472	146.0	5.748	12	12	861.1-1200-144A1-GM	★	★	★	★	12.0	.472	228	8.976	226.0	8.898	176	6.929	2.0	.079	20	290	COROMANT		
12.00	.472	182.0	7.165	15	12	861.1-1200-180A1-GM	★	★	★	★	12.0	.472	267	10.512	265.0	10.433	216	8.504	2.0	.079	20	290	COROMANT		
12.00	.472	242.0	9.528	20	12	861.1-1200-240A1-GM	★	★	★	★	12.0	.472	327	12.874	325.0	12.795	276	10.866	2.0	.079	20	290	COROMANT		
12.30	.484	149.7	5.894	12	14	861.1-1230-148A1-GM	★	★	★	★	14.0	.551	258	10.158	256.0	10.079	207	8.150	2.0	.079	20	290	COROMANT		
12.50	.492	152.0	5.984	12	14	861.1-1250-150A1-GM	★	★	★	★	14.0	.551	258	10.158	256.0	10.079	207	8.150	2.0	.079	20	290	COROMANT		
12.70	.500	154.5	6.083	12	14	861.1-1270-152A1-GM	★	★	★	★	14.0	.551	258	10.158	255.9	10.075	207	8.150	2.1	.083	20	290	COROMANT		
13.00	.512	158.1	6.224	12	14	861.1-1300-156A1-GM	★	★	★	★	14.0	.551	258	10.158	255.9	10.075	207	8.150	2.1	.083	20	290	COROMANT		
13.10	.516	159.3	6.272	12	14	861.1-1310-157A1-GM	★	★	★	★	14.0	.551	258	10.158	255.9	10.075	207	8.150	2.1	.083	20	290	COROMANT		
13.50	.531	164.2	6.465	12	14	861.1-1350-162A1-GM	★	★	★	★	14.0	.551	258	10.158	255.8	10.071	207	8.150	2.2	.087	20	290	COROMANT		
13.89	.547	169.0	6.654	12	14	861.1-1389-167A1-GM	★	★	★	★	14.0	.551	258	10.158	255.7	10.067	207	8.150	2.3	.091	20	290	COROMANT		
14.00	.551	170.3	6.705	12	14	861.1-1400-168A1-GM	★	★	★	★	14.0	.551	258	10.158	255.7	10.067	207	8.150	2.3	.091	20	290	COROMANT		
14.50	.571	176.4	6.945	12	16	861.1-1450-174A1-GM	★	★	★	★	16.0	.630	291	11.457	288.6	11.362	236	9.291	2.4	.094	20	290	COROMANT		
15.00	.591	182.5	7.185	12	16	861.1-1500-180A1-GM	★	★	★	★	16.0	.630	291	11.457	288.5	11.358	236	9.291	2.5	.098	20	290	COROMANT		
15.50	.610	188.5	7.421	12	16	861.1-1550-186A1-GM	★	★	★	★	16.0	.630	291	11.457	288.5	11.358	236	9.291	2.5	.098	20	290	COROMANT		
15.88	.625	193.1	7.602	12	16	861.1-1588-191A1-GM	★	★	★	★	16.0	.630	291	11.457	288.4	11.354	236	9.291	2.6	.102	20	290	COROMANT		
16.00	.630	194.6	7.661	12	16	861.1-1600-192A1-GM	★	★	★	★	16.0	.630	291	11.457	288.4	11.354	236	9.291	2.6	.102	20	290	COROMANT		



B84



E9



E28



E14

CoroDrill® 862

Vollhartmetallbohrer mit innerer Kühlschmierstoffzufuhr für Mikrobohrungen

Anwendungsbereich

- Erreichbare Bohrungstoleranz: H8-H9
- Für fast Werkstoffe geeignet
- Bohrtiefen: 8-12 × Bohrerdurchmesser



ISO-Anwendungsbereich:



Vorteile und Merkmale

- Optimale Leistung in Stahl, rostfreiem Stahl, Gusseisen und Aluminium
- Spezielle Werkzeuggeometrie und Oberflächenbehandlung für effiziente Spanabfuhr
- Guter Ein- und Austritt, enge Bohrungstoleranz
- ACM (Advanced Chip Management) Spankanalgeometrie für kleine und kontrollierbare Späne
- Speziell entwickelte Spitzengeometrie reduziert Axialkräfte
- Glatte Bohreroberfläche ermöglicht eine schnelle und effiziente Spanabfuhr
- Durch innere Kühlschmierstoffbohrungen gelangt der Kühlschmierstoff selbst bei großer Bohrtiefe direkt an die Bohrerspitze



www.sandvik.coromant.com/corodrigill862

Empfehlungen

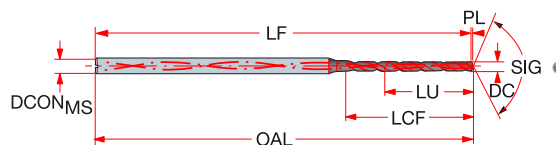
Verwenden Sie CoroChuck 930 mit Ihrem CoroDrill 862 für eine effiziente Produktion durch schnelle, hochgenaue und einfache Werkzeugspannungen und -wechsel



CoroDrill® 862 Vollhartmetallbohrer

Für Multimaterial-Anwendungen

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 140°

							P	M	K	N	S	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	GC34	GC34	GC34	GC34	GC34	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG	
1.85	.073	14.5	.571	7	3	862.1-0185-015A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	20	.787	0.3	.012	40	580	COROMANT	
1.85	.073	22.5	.886	12	3	862.1-0185-022A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	30	1.181	0.3	.012	40	580	COROMANT	
1.90	.075	14.3	.563	7	3	862.1-0190-015A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	20	.787	0.3	.012	40	580	COROMANT	
1.90	.075	23.1	.909	12	3	862.1-0190-023A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	30	1.181	0.3	.012	40	580	COROMANT	
1.98	.078	14.2	.559	7	3	862.1-0198-016A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	20	.787	0.3	.012	40	580	COROMANT	
1.98	.078	24.0	.945	12	3	862.1-0198-024A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	30	1.181	0.3	.012	40	580	COROMANT	
2.00	.079	16.3	.642	8	3	862.1-0200-016A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	22	.866	0.3	.012	40	580	COROMANT	
2.00	.079	24.3	.957	12	3	862.1-0200-024A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	32	1.260	0.3	.012	40	580	COROMANT	
2.05	.081	16.7	.657	8	3	862.1-0205-016A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	22	.866	0.3	.012	40	580	COROMANT	
2.05	.081	24.9	.980	12	3	862.1-0205-025A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	32	1.260	0.3	.012	40	580	COROMANT	
2.08	.082	16.8	.661	8	3	862.1-0208-017A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	22	.866	0.3	.012	40	580	COROMANT	
2.08	.082	25.3	.996	12	3	862.1-0208-025A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	32	1.260	0.3	.012	40	580	COROMANT	
2.10	.083	16.8	.661	8	3	862.1-0210-017A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	22	.866	0.3	.012	40	580	COROMANT	
2.10	.083	25.5	1.004	12	3	862.1-0210-025A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.7	2.862	32	1.260	0.3	.012	40	580	COROMANT	
2.15	.085	16.6	.654	7	3	862.1-0215-017A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.6	2.858	22	.866	0.4	.016	40	580	COROMANT	
2.15	.085	26.2	1.032	12	3	862.1-0215-026A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.6	2.858	32	1.260	0.4	.016	40	580	COROMANT	
2.18	.086	16.6	.654	7	3	862.1-0218-017A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.6	2.858	22	.866	0.4	.016	40	580	COROMANT	
2.20	.087	16.5	.650	7	3	862.1-0220-018A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.6	2.858	22	.866	0.4	.016	40	580	COROMANT	
2.20	.087	26.5	1.043	12	3	862.1-0220-026A1-GM	*	*	*	*	*	3.0	.118	73	2.874	72.6	2.858	32	1.260	0.4	.016	40	580	COROMANT	
2.25	.089	18.4	.724	8	3	862.1-0225-018A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT	
2.25	.089	27.4	1.079	12	3	862.1-0225-027A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT	
2.26	.089	18.5	.728	8	3	862.1-0226-018A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT	
2.30	.091	18.8	.740	8	3	862.1-0230-018A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT	
2.30	.091	28.0	1.102	12	3	862.1-0230-028A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT	
2.38	.094	19.0	.748	7	3	862.1-0238-019A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT	
2.38	.094	29.0	1.142	12	3	862.1-0238-029A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT	
2.40	.094	19.0	.748	7	3	862.1-0240-019A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT	
2.40	.094	29.2	1.150	12	3	862.1-0240-029A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT	
2.44	.096	18.9	.744	7	3	862.1-0244-020A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT	
2.44	.096	29.7	1.169	12	3	862.1-0244-029A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT	
2.50	.098	18.8	.740	7	3	862.1-0250-020A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT	
2.50	.098	29.8	1.173	11	3	862.1-0250-030A1-GM	*	*	*	*	*	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT	
2.58	.102	20.6	.811	7	3	862.1-0258-021A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	27	1.063	0.4	.016	40	580	COROMANT	
2.58	.102	31.4	1.236	12	3	862.1-0258-031A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	38	1.496	0.4	.016	40	580	COROMANT	
2.60	.102	20.5	.807	7	3	862.1-0260-021A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	27	1.063	0.4	.016	40	580	COROMANT	
2.60	.102	31.5	1.240	12	3	862.1-0260-031A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	38	1.496	0.4	.016	40	580	COROMANT	
2.64	.104	20.4	.803	7	3	862.1-0264-021A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	27	1.063	0.4	.016	40	580	COROMANT	
2.64	.104	31.4	1.236	11	3	862.1-0264-032A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	38	1.496	0.4	.016	40	580	COROMANT	
2.70	.106	20.3	.799	7	3	862.1-0270-022A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	27	1.063	0.4	.016	40	580	COROMANT	
2.70	.106	31.3	1.232	11	3	862.1-0270-032A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	38	1.496	0.4	.016	40	580	COROMANT	
2.71	.107	22.1	.870	8	3	862.1-0271-022A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.6	3.291	30	1.181	0.4	.016	40	580	COROMANT	
2.80	.110	22.9	.902	8	3	862.1-0280-022A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT	
2.80	.110	34.1	1.343	12	3	862.1-0280-034A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT	
2.82	.111	23.0	.906	8	3	862.1-0282-023A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT	
2.82	.111	34.3	1.350	12	3	862.1-0282-034A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT	
2.87	.113	22.8	.898	7	3	862.1-0287-023A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT	
2.87	.113	34.8	1.370	12	3	862.1-0287-034A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT	
2.90	.114	22.8	.898	7	3	862.1-0290-023A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT	
2.90	.114	34.8	1.370	12	3	862.1-0290-035A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT	
2.95	.116	22.6	.890	7	3	862.1-0295-024A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT	
2.95	.116	34.6	1.362	11	3	862.1-0295-035A1-GM	*	*	*	*	*	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT	



B92



E9



E28

CoroDrill® 863

Bohrer für CNC-, ADU- und Robotersysteme für Luftfahrt-Strukturbauteile

Anwendungsbereich

- CNC- und ADU-Operationen
- CVD-, PKD- und Hartmetallsorten als Option
- Werkstofftypen: Verbundwerkstoffe, Aluminium, Titan, hochwarmfeste Legierungen und rostfreier Stahl



ISO-Anwendungsbereich:



Vorteile und Merkmale

- Spezielle Geometrien für reduzierte Axialkräfte mindern das Risiko von Delamination an Bohrungen und Gratbildung beim Werkzeugaustritt
- Lagerhaltige Artikel sind eine perfekte Lösung für Testzwecke (Tauglichkeitsprüfung) bei spezifischen Anwendungen
- Die Spitzengeometrie der Bohrer für CFK gewährleisten einen sauberen Austritt aus Geweben und unidirektionalen Schichtverbunden



www.sandvik.coromant.com/corodrigill863

Werkzeugprogramm

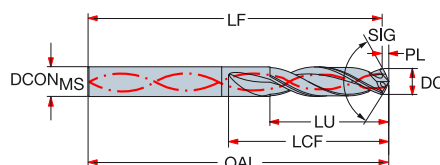
- CoroDrill 863® - O: Für lange Standzeiten in CFK-Schichtverbunden
- CoroDrill 863® - OS: Für gutes Spänemanagement in CFK-/Titan-Schichtverbunden
- CoroDrill 863® - N: Für die Hochgeschwindigkeitsbearbeitung in Aluminium-Schichtverbunden
- CoroDrill 863® - MS: Für Anwendungen in metallischen Schichtverbunden

CoroDrill® 863 Vollhartmetallbohrer

Für die CNC- & ADU-Bearbeitung von Luftfahrt-Strukturbauteilen

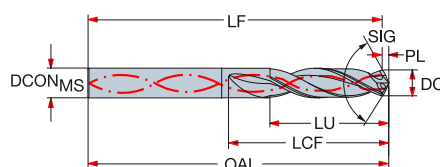
Innere Kühlschmierstoffzufuhr

TCDC 0-0,008
TCHA H8
TCHAL 4
TCHAU 4
SIG 135°



							N	Abmessungen, mm, Zoll												
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	H ₁₀ F	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*			BSG
4.83	.190	20.0	.787	4	5	863.1-0483-020A1-N	★	5.0	.197	58	2.283	56.6	2.226	28	1.102	1.5	.057	9	130	COROMANT
4.85	.191	20.0	.787	4	5	863.1-0485-020A1-N	★	5.0	.197	58	2.283	56.6	2.226	28	1.102	1.5	.057	9	130	COROMANT
6.35	.250	26.0	1.024	4	6	863.1-0635-026A1-N	★	6.0	.236	75	2.953	73.1	2.876	37	1.457	2.0	.077	9	130	COROMANT
6.37	.251	26.0	1.024	4	6	863.1-0637-026A1-N	★	6.0	.236	75	2.953	73.1	2.876	37	1.457	2.0	.077	9	130	COROMANT
7.94	.313	32.0	1.260	4	8	863.1-0794-032A1-N	★	8.0	.315	81	3.189	78.6	3.094	43	1.693	2.4	.095	9	130	COROMANT
7.97	.314	32.0	1.260	4	8	863.1-0796-032A1-N	★	8.0	.315	81	3.189	78.6	3.094	43	1.693	2.4	.095	9	130	COROMANT
9.53	.375	39.0	1.535	4	10	863.1-0953-039A1-N	★	10.0	.394	93	3.661	90.1	3.548	51	2.008	2.9	.113	9	130	COROMANT
9.55	.376	39.0	1.535	4	10	863.1-0955-039A1-N	★	10.0	.394	93	3.661	90.1	3.548	51	2.008	2.9	.113	9	130	COROMANT
11.12	.438	43.0	1.693	3	12	863.1-1112-043A1-N	★	12.0	.472	105	4.134	101.6	4.002	58	2.283	3.4	.132	9	130	COROMANT
11.14	.439	43.0	1.693	3	12	863.1-1114-043A1-N	★	12.0	.472	105	4.134	101.6	4.002	58	2.283	3.4	.132	9	130	COROMANT

TCDC 0-0,008
TCHA H8
TCHAL 4
TCHAU 4
SIG 135°



							N	S	O	Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	H10F	H10E	H10L	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG	
4.83	.190	20.0	.787	4	5	863.1-0483-020A1-OS	☆	★	★	5.0	.197	58	2.283	55.7	2.193	28	1.102	2.3	.091	9	130	COROMANT	
4.85	.191	20.0	.787	4	5	863.1-0485-020A1-OS	☆	★	★	5.0	.197	58	2.283	55.7	2.193	28	1.102	2.3	.091	9	130	COROMANT	
6.35	.250	26.0	1.024	4	6	863.1-0635-026A1-OS	☆	★	★	6.0	.236	75	2.953	72.3	2.845	37	1.457	2.7	.107	9	130	COROMANT	
6.37	.251	26.0	1.024	4	6	863.1-0637-026A1-OS	☆	★	★	6.0	.236	75	2.953	72.3	2.845	37	1.457	2.7	.108	9	130	COROMANT	
7.94	.313	32.0	1.260	4	8	863.1-0794-032A1-OS	☆	★	★	8.0	.315	81	3.189	77.7	3.059	43	1.693	3.3	.130	9	130	COROMANT	
7.97	.314	32.0	1.260	4	8	863.1-0796-032A1-OS	☆	★	★	8.0	.315	81	3.189	77.7	3.059	43	1.693	3.3	.130	9	130	COROMANT	
9.53	.375	39.0	1.535	4	10	863.1-0953-039A1-OS	☆	★	★	10.0	.394	93	3.661	89.1	3.506	51	2.008	3.9	.155	9	130	COROMANT	
9.55	.376	39.0	1.535	4	10	863.1-0955-039A1-OS	☆	★	★	10.0	.394	93	3.661	89.1	3.506	51	2.008	3.9	.155	9	130	COROMANT	
11.12	.438	43.0	1.693	3	12	863.1-1112-043A1-OS	☆	★	★	12.0	.472	105	4.134	100.4	3.952	58	2.283	4.6	.182	9	130	COROMANT	
11.14	.439	43.0	1.693	3	12	863.1-1114-043A1-OS	☆	★	★	12.0	.472	105	4.134	100.4	3.952	58	2.283	4.6	.182	9	130	COROMANT	



B83



E9

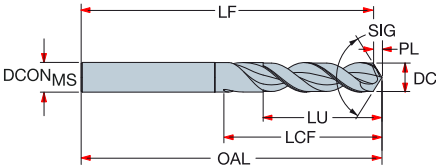


E28

CoroDrill® 863 Vollhartmetallbohrer

Für die CNC- & ADU-Bearbeitung von Luftfahrt-Strukturbauteilen

TCDCh7
TCHAH8
TCHAL3
TCHAU3
SIG90°



												0Abmessungen, mm, Zoll				
DC	DC"	LU	LU"	ULDR	CZC _{MS}	Bestellnummer	ISO	DCON _{MS}	DCON _{MS} "	OAL	OAL"	LF	LF"	PL	PL"	BSG
3.30	.130	17.9	.705	5	6	863.1-0330-017A0-O	★	6.0	.236	66	2.598	64.6	2.543	1.4	.056	COROMANT
4.85	.191	26.3	1.035	5	6	863.1-0485-024A0-O	★	6.0	.236	82	3.228	79.9	3.146	2.1	.082	COROMANT
6.37	.251	34.6	1.362	5	8	863.1-0637-032A0-O	★	8.0	.315	91	3.583	88.3	3.475	2.7	.107	COROMANT
7.96	.313	43.2	1.701	5	8	863.1-0796-039A0-O	★	8.0	.315	91	3.583	87.6	3.448	3.4	.135	COROMANT
9.55	.376	51.9	2.043	5	10	863.1-0955-048A0-O	★	10.0	.394	103	4.055	98.9	3.894	4.1	.161	COROMANT

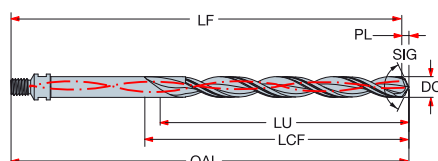


CoroDrill® 863 Vollhartmetallbohrer

Für die CNC- & ADU-Bearbeitung von Luftfahrt-Strukturbauteilen

Schraubkupplung

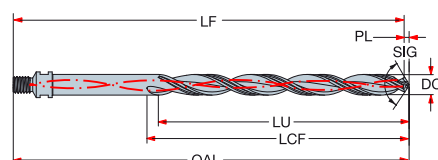
TCDC 0-0,008
TCHA H8
TCHAL 4
TCHAU 4
SIG 135°



Innere Kühlschmierstoffzufuhr

										M	N	S	Abmessungen, mm, Zoll									
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	H10F	H10F	H10F	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG		
4.83	.190	30.0	1.181	6	5/16-24	863.1-0483-030B1-MS	★	☆	★	152	6.000	141.9	5.586	101	4.000	1.7	.068	9	130	COROMANT		
4.85	.191	30.0	1.181	6	5/16-24	863.1-0485-030B1-MS	★	☆	★	152	6.000	141.3	5.564	101	4.000	1.7	.068	9	130	COROMANT		
6.35	.250	39.0	1.535	6	5/16-24	863.1-0635-039B1-MS	★	☆	★	152	6.000	141.4	5.566	101	4.000	2.2	.088	9	130	COROMANT		
6.37	.251	39.0	1.535	6	5/16-24	863.1-0637-039B1-MS	★	☆	★	152	6.000	141.3	5.563	101	4.000	2.2	.088	9	130	COROMANT		
7.94	.313	48.0	1.890	6	5/16-24	863.1-0794-048B1-MS	★	☆	★	152	6.000	140.8	5.544	101	4.000	2.7	.108	9	130	COROMANT		
7.97	.314	48.0	1.890	6	5/16-24	863.1-0796-048B1-MS	★	☆	★	152	6.000	140.8	5.543	101	4.000	2.8	.108	9	130	COROMANT		
9.53	.375	58.0	2.283	6	5/16-24	863.1-0953-058B1-MS	★	☆	★	152	6.000	140.3	5.522	101	4.000	3.3	.129	9	130	COROMANT		
9.55	.376	58.0	2.283	6	5/16-24	863.1-0955-058B1-MS	★	☆	★	152	6.000	140.3	5.523	101	4.000	3.3	.129	9	130	COROMANT		
11.12	.438	67.0	2.638	6	7/16-20	863.1-1112-067B1-MS	★	☆	★	152	6.000	138.1	5.438	101	4.000	3.8	.151	9	130	COROMANT		
11.14	.439	67.0	2.638	6	7/16-20	863.1-1114-067B1-MS	★	☆	★	152	6.000	138.1	5.435	101	4.000	3.8	.151	9	130	COROMANT		

TCDC 0-0,008
TCHA H8
TCHAL 4
TCHAU 4
SIG 135°



Innere Kühlschmierstoffzufuhr

										N	S	O	Abmessungen, mm, Zoll									
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	H10F	H10F	H10F	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BAR	PSI	BSG		
4.83	.190	30.0	1.181	6	5/16-24	863.1-0483-030B1-OS	☆	★	★	152	6.000	142.3	5.600	101	4.000	1.3	.051	9	130	COROMANT		
4.85	.191	30.0	1.181	6	5/16-24	863.1-0485-030B1-OS	☆	★	★	152	6.000	142.3	5.600	101	4.000	1.3	.051	9	130	COROMANT		
6.35	.250	39.0	1.535	6	5/16-24	863.1-0635-039B1-OS	☆	★	★	152	6.000	141.8	5.582	101	4.000	1.8	.069	9	130	COROMANT		
6.37	.251	39.0	1.535	6	5/16-24	863.1-0637-039B1-OS	☆	★	★	152	6.000	141.8	5.582	101	4.000	1.8	.069	9	130	COROMANT		
7.94	.313	48.0	1.890	6	5/16-24	863.1-0794-048B1-OS	☆	★	★	152	6.000	141.3	5.564	101	4.000	2.2	.087	9	130	COROMANT		
7.97	.314	48.0	1.890	6	5/16-24	863.1-0796-048B1-OS	☆	★	★	152	6.000	141.4	5.567	101	4.000	2.2	.087	9	130	COROMANT		
9.53	.375	58.0	2.283	6	5/16-24	863.1-0953-058B1-OS	☆	★	★	152	6.000	140.9	5.548	101	4.000	2.7	.106	9	130	COROMANT		
9.55	.376	58.0	2.283	6	5/16-24	863.1-0955-058B1-OS	☆	★	★	152	6.000	140.9	5.546	101	4.000	2.7	.106	9	130	COROMANT		
11.12	.438	67.0	2.638	6	7/16-20	863.1-1112-067B1-OS	☆	★	★	152	6.000	138.8	5.465	101	4.000	3.1	.120	9	130	COROMANT		
11.14	.439	67.0	2.638	6	7/16-20	863.1-1114-067B1-OS	☆	★	★	152	6.000	138.8	5.466	101	4.000	3.1	.120	9	130	COROMANT		



B83



E9



E28

CoroDrill® 452

Vollhartmetallbohrer, Reib- und Senkwerkzeuge

Anwendungsbereich

- Portable, handgeführte Maschinen
- Niet- und Bolzenlöcher in der Luftfahrt
- Kohlefaserverstärkte Kunststoffe (CFK)
- Kohlefaserverstärkte Kunststoffe/metallische Schichtverbunde



ISO-Anwendungsbereich:



Vorteile und Merkmale

- Enge Bohrungstoleranz, hohe Oberflächengüte
- Für CFK- und Metall-Schichtverbundwerkstoffe optimierte Werkzeuge
- Spezielle Geometrien mindern das Risiko von Delamination und Gratbildung



D www.sandvik.coromant.com/corodrill452

Eine Familie von Werkzeugen für Bolzen- und Nietlöcher. Optionen wie Stufenbohrer, Reibahlen und Senkwerkzeuge sind erhältlich.

Werkzeugprogramm

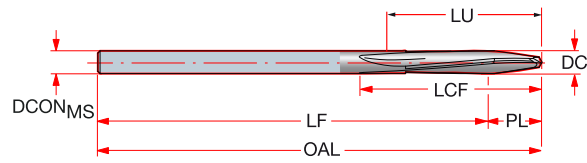
- CoroDrill® 452.1–C: Bohrer für CFK-Schichtverbunde
- CoroDrill® 452.1–CM: Bohrer für FK-Metallschichtverbunde
- CoroDrill® 452.R–CM: Reibahle für CFK-Metallschichtverbunde
- CoroDrill® 452.C1: Senkwerkzeug für CFK

CoroDrill® 452 Vollhartmetallbohrer

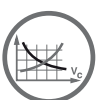
Für handgeführte Maschinen

Für Luftfahrt-Strukturbauteile

TCHA H9
SIG 118°



							0 Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	HT0F	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BSG
2.50	.098	50.0	1.968	20	2	452.1-0250-044A0-C	★	2.5	.098	101	4.000	96.1	3.782	56	2.218	5.5	.218	COROMANT
3.26	.129	51.7	2.035	15	3	452.1-0326-044A0-C	★	3.3	.128	101	4.000	94.4	3.715	58	2.285	7.2	.285	COROMANT
4.17	.164	53.7	2.114	12	4	452.1-0417-044A0-C	★	4.2	.164	101	4.000	92.4	3.636	60	2.364	9.2	.364	COROMANT
4.83	.190	55.2	2.172	11	4	452.1-0483-044A0-C	★	4.8	.190	101	4.000	90.9	3.578	61	2.422	10.7	.422	COROMANT
5.56	.219	56.8	2.235	10	7/32	452.1-0556-044A0-C	★	5.6	.219	101	4.000	89.3	3.515	63	2.485	12.3	.485	COROMANT
6.35	.250	58.6	2.305	9	1/4	452.1-0635-044A0-C	★	6.4	.250	101	4.000	87.5	3.445	64	2.555	14.1	.555	COROMANT
7.94	.313	62.1	2.444	7	5/16	452.1-0794-044A0-C	★	7.9	.313	101	4.000	84.0	3.306	68	2.694	17.6	.694	COROMANT



B94



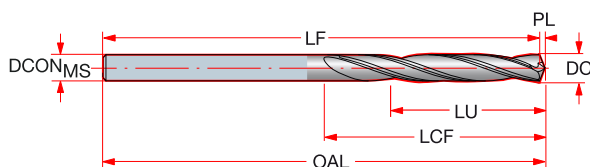
E9

CoroDrill® 452 Vollhartmetallbohrer

Für handgeführte Maschinen

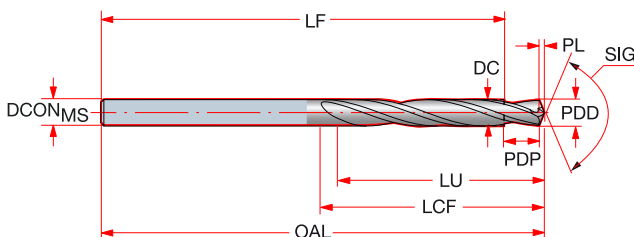
Für Luftfahrt-Strukturbauteile

TCHA H9
SIG 135°



							M	N	S	O	Abmessungen, mm, Zoll											
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	H10F	H10F	H10F	H10F	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	BSG	
2.50	.098	44.5	1.750	17	2	452.1-0250-044A0-CM	★	★	★	★	2.5	.098	101	4.000	101.1	3.980	50	2.000	0.5	.020	COROMANT	
3.26	.129	44.5	1.750	13	3	452.1-0326-044A0-CM	★	★	★	★	3.3	.128	101	4.000	100.9	3.972	50	2.000	0.7	.027	COROMANT	
4.17	.164	44.5	1.750	10	4	452.1-0417-044A0-CM	★	★	★	★	4.2	.164	101	4.000	100.7	3.965	50	2.000	0.9	.034	COROMANT	
4.83	.190	44.5	1.750	9	4	452.1-0483-044A0-CM	★	★	★	★	4.8	.190	101	4.000	100.6	3.961	50	2.000	1.0	.039	COROMANT	
5.56	.219	44.5	1.750	7	7/32	452.1-0556-044A0-CM	★	★	★	★	5.6	.219	101	4.000	100.5	3.955	50	2.000	1.2	.045	COROMANT	
6.35	.250	44.5	1.750	6	1/4	452.1-0635-044A0-CM	★	★	★	★	6.4	.250	101	4.000	100.3	3.949	50	2.000	1.3	.052	COROMANT	
7.94	.313	44.5	1.750	5	5/16	452.1-0794-044A0-CM	★	★	★	★	7.9	.313	101	4.000	100.0	3.937	50	2.000	1.6	.065	COROMANT	

TCHA H9
SIG 135°



							M	N	S	O	Abmessungen, mm, Zoll														
DC	DC*	LU	LU*	ULDR	CZC _{MS}	Bestellnummer	H _{10F}	H _{10F}	H _{10F}	H _{10F}	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	PDD	PDD*	PDP	PDP*	BSG
4.17	.164	44.5	1.750	10	4	452.4-0417-034A0-CM	★	★	★	★	4.2	.164	101	4.000	91.3	3.594	50	2.000	0.7	.028	3.37	.133	9.53	.375	COROMANT
4.83	.190	44.5	1.752	9	4	452.4-0483-034A0-CM	★	★	★	★	4.8	.190	101	4.000	91.2	3.589	50	2.000	0.8	.033	4.06	.160	9.53	.375	COROMANT
5.56	.219	44.5	1.750	7	7/32	452.4-0556-034A0-CM	★	★	★	★	5.6	.219	101	4.000	91.0	3.583	50	2.000	1.0	.039	4.76	.188	9.53	.375	COROMANT
6.35	.250	44.5	1.750	7	1/4	452.4-0635-034A0-CM	★	★	★	★	6.4	.250	101	4.000	90.8	3.576	50	2.000	1.2	.045	5.56	.219	9.53	.375	COROMANT
7.94	.313	44.5	1.750	5	5/16	452.4-0794-034A0-CM	★	★	★	★	7.9	.313	101	4.000	90.5	3.563	50	2.000	1.5	.058	7.15	.281	9.53	.375	COROMANT



B94



E9

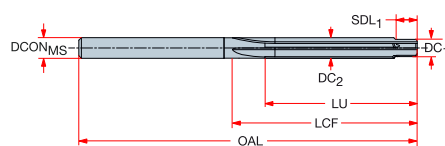
CoroDrill® 452 Vollhartmetall-Reibahle

Für handgeführte Maschinen

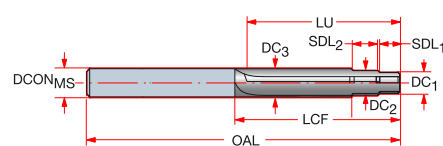
Für Luftfahrt-Strukturbauteile



452.R..45



452.R..32

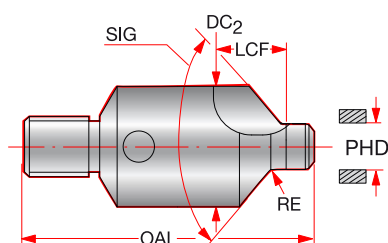


										M	N	S	O	Abmessungen, mm, Zoll											
DC ₁	DC ₁ [*]	DC ₂	DC ₂ [*]	DC ₃	DC ₃ [*]	LU	LU [*]	CZC _{MS}	Bestellnummer	H ₁₀ ⁰	H ₁₀ ¹	H ₁₀ ²	H ₁₀ ³	DCON _{MS}	DCON _{MS} [*]	OAL	OAL [*]	SDL ₁	SDL ₁ [*]	SDL ₂	SDL ₂ [*]	LCF	LCF [*]	BSG	
3.10	.122	4.10	.161			45.00	1.772	4	452.R-0410-045A0-CM	★	★	☆	★	4.10	.161	100.00	3.937	3.74	.147			50.00	1.969	COROMANT	
4.10	.161	5.10	.201			45.00	1.772	5	452.R-0510-045A0-CM	★	★	☆	★	5.10	.201	100.00	3.937	5.00	.197			50.00	1.969	COROMANT	
5.10	.201	6.10	.240			45.00	1.772	6	452.R-0610-045A0-CM	★	★	☆	★	6.10	.240	100.00	3.937	6.00	.236			50.00	1.969	COROMANT	
5.54	.218	6.35	.250			45.00	1.772	1/4	452.R-0635-045A0-CM	★	★	☆	★	6.35	.250	100.00	3.937	7.00	.276			50.00	1.969	COROMANT	
7.13	.281	7.94	.313			45.00	1.772	5/16	452.R-0794-045A0-CM	★	★	☆	★	7.94	.313	100.00	3.937	8.00	.315			50.00	1.969	COROMANT	
2.57	.101	3.35	.132	4.17	.164	50.80	2.000	4	452.R-0417-032A0-CM	★	★	☆	★	4.17	.164	101.60	4.000	6.13	.241	5.95	.234	55.88	2.200	COROMANT	
3.96	.156	4.74	.187	5.56	.219	50.80	2.000	7/32	452.R-0556-032A0-CM	★	★	☆	★	5.56	.219	101.60	4.000	6.02	.237	5.95	.234	55.88	2.200	COROMANT	
4.75	.187	5.54	.218	6.35	.250	50.80	2.000	1/4	452.R-0635-032A0-CM	★	★	☆	★	6.35	.250	101.60	4.000	6.35	.250	6.35	.250	55.88	2.200	COROMANT	
6.34	.250	5.54	.218	7.94	.313	50.80	2.000	5/16	452.R-0794-029A0-CM	★	★	☆	★	7.94	.313	101.60	4.000	7.92	.312	7.92	.312	55.88	2.200	COROMANT	

CoroDrill® 452 Senkwerkzeug

Für handgeführte Maschinen

Für Luftfahrt-Strukturbauteile



											Abmessungen, mm, Zoll									
PHD	PHD [*]	SIG	CZC _{MS}	Bestellnummer		DC ₁	DC ₁ [*]	DC ₂	DC ₂ [*]	OAL	OAL [*]	LCF	LCF [*]	RE	RE [*]					
4.14	.163	100°	1/4-28	452.C1-0414-100T-C	★	4.14	.163	10.00	.393	36.00	1.417	7.85	.309	0.90	.035					
4.14	.163	130°	1/4-28	452.C1-0414-130T-C	★	4.14	.163	10.00	.393	36.00	1.417	12.10	.476	0.60	.024					
4.80	.189	100°	1/4-28	452.C1-0480-100T-C	★	4.80	.189	10.00	.393	36.58	1.440	7.94	.312	0.90	.035					
4.80	.189	130°	1/4-28	452.C1-0480-130T-C	★	4.80	.189	10.00	.393	36.58	1.440	11.88	.467	0.60	.024					
5.53	.217	100°	1/4-28	452.C1-0553-100T-C	★	5.53	.217	10.00	.393	36.58	1.440	12.01	.472	0.90	.035					
5.53	.217	130°	1/4-28	452.C1-0553-130T-C	★	5.53	.217	10.00	.393	36.58	1.440	12.01	.472	0.60	.024					
6.32	.249	100°	1/4-28	452.C1-0632-100T-C	★	6.32	.249	14.00	.551	37.82	1.488	14.58	.574	0.90	.035					
6.32	.249	130°	1/4-28	452.C1-0632-130T-C	★	6.32	.249	14.00	.551	37.82	1.488	14.53	.572	0.60	.024					
7.91	.311	100°	1/4-28	452.C1-0791-100T-C	★	7.91	.311	18.00	.708	39.73	1.564	14.58	.574	1.15	.045					
7.91	.311	130°	1/4-28	452.C1-0791-130T-C	★	7.91	.311	18.00	.708	39.73	1.564	14.58	.574	0.90	.035					
12.68	.499	100°	3/8-24	452.C1-1268-100T-C	★	12.68	.499	26.00	1.023	49.00	1.929	23.77	.935	1.40	.055					



B94



E9

CoroDrill® 400 und CoroDrill® 430

Hochproduktive Bohrungsbearbeitung in Aluminium und Guss

Flexible und präzise Werkzeuglösungen

Der geradenutete CoroDrill® 400 ist eine optimierte Lösung, die für den breiten Einsatz in der Automobilindustrie entwickelt wurde.

Sorgfältig konzipiert, um anspruchsvolle Präzisionsanforderungen zu erfüllen.

Der spiralgenutete CoroDrill® 430 ist eine optimierte Lösung, die für den breiten Einsatz in der Automobilindustrie entwickelt wurde.

Sorgfältig konzipiert, um anspruchsvolle Präzisionsanforderungen zu erfüllen.

ISO-Anwendungsbereich:

N

Vorteile und Merkmale

- Problemlose Spanabfuhr
- Exzellente Bohrungsgeradheit und optimale Oberflächengüte aufgrund Doppelfase
- Mehrstufen, Fasen, Radius und Formen können erzielt werden
- Einfaches Nachschleifen
- Schnelle Lieferung
- Flexibilität



www.sandvik.coromant.com/corodrigill400

www.sandvik.coromant.com/corodrigill430

Einsatz in der Automobilindustrie für:

Zylinderblöcke und -köpfe, Gehäuse, Achsschenkel und Bremszylinder

Aluminium-Silizium-Legierungen und alle Gusswerkstoffe einschließlich Grauguss, Vermiculargraphitguss und Kugelgraphitguss

Kernlochbohren

Fasbohrungen und Mehrstufen-Formen

Gerade genutet

Für komplexe Mehrstufen-Formen und große Stufenverhältnisse



Drei Spankanäle

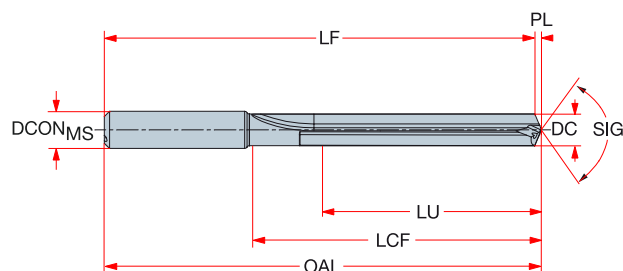
Zur Erweiterung bestehender Bohrungen (Kernlochbohren)



CoroDrill® 400 Vollhartmetallbohrer

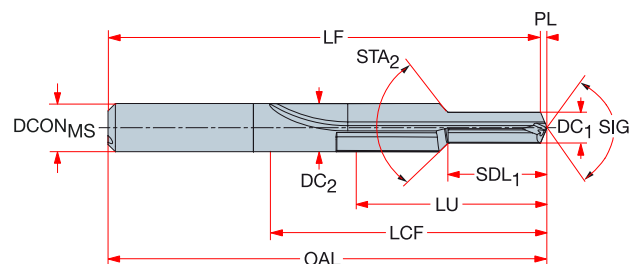
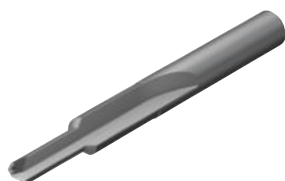
Für Aluminium

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 135°

						N	Abmessungen, mm, Zoll															
DC	DC*	LU	LU*	ULDR	CZC _{MS}		Bestellnummer	NIBU	NIDU	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	SIG		
5.00	.197	30.0	1.181	6	6	400.1-0500-030A1-NM	★	★	6.0	.236	85	3.346	84.0	3.308	45	1.785	1.0	.038	135°	20	290	COROMANT
7.00	.276	50.0	1.969	7	8	400.1-0700-050A1-NM	★	★	8.0	.315	110	4.331	108.6	4.276	68	2.695	1.4	.054	135°	20	290	COROMANT
10.20	.402	70.0	2.756	6	12	400.1-1020-070A1-NM	★	★	12.0	.472	140	5.512	138.0	5.432	92	3.652	2.0	.080	135°	20	290	COROMANT
12.50	.492	75.0	2.953	6	14	400.1-1250-075A1-NM	★	★	14.0	.551	150	5.906	147.5	5.807	100	3.956	2.5	.099	135°	20	290	COROMANT

Innere Kühlschmierstoffzufuhr

TCHA H9
SIG 135°

										N	Abmessungen, mm, Zoll															
DC ₁	DC ₁ [*]	DC ₂	DC ₂ [*]	SDL ₁	SDL ₁ [*]	STA ₂	LU	LU [*]	CZC _{MS}		Bestellnummer	NBU	INDU	DCON _{MS}	DCON _{MS} [*]	OAL	OAL [*]	LF	LF [*]	LCF	LCF [*]	PL	PL [*]	SIG	BAR	PSI
5.00	.197	8.00	.315	15.00	.591	90°	31.0	1.220	8	400.4-0500-031A1-NM	★	★	8.0	.315	90	3.543	89.0	3.505	50	2.002	1.0	.038	135°	20	290	COROMANT
6.80	.268	10.00	.394	20.40	.803	90°	40.0	1.575	10	400.4-0680-040A1-NM	★	★	10.0	.394	105	4.134	103.7	4.081	62	2.452	1.3	.053	135°	20	290	COROMANT
8.50	.335	12.00	.472	25.50	1.004	90°	50.0	1.969	12	400.4-0850-050A1-NM	★	★	12.0	.472	125	4.921	123.3	4.855	74	2.940	1.7	.067	135°	20	290	COROMANT
10.20	.402	16.00	.630	30.60	1.205	90°	63.0	2.480	16	400.4-1020-063A1-NM	★	★	16.0	.630	145	5.709	143.0	5.629	91	3.605	2.0	.080	135°	20	290	COROMANT

Bohrertyp 4 für U/MIN DC2 und Vorschubrate DC1.



B94



E9

A

BOHREN

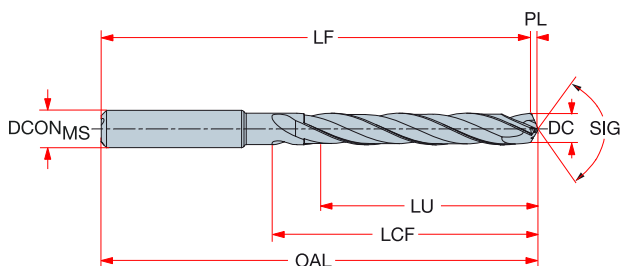
Optimiert

CoroDrill® 430 Vollhartmetallbohrer

Für Aluminium

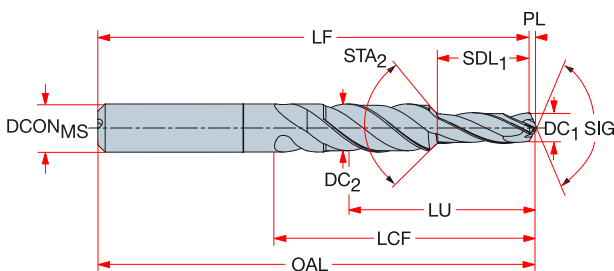
Innere Kühlschmierstoffzufuhr

B

TCHA
SIGH9
135°

C

Innere Kühlschmierstoffzufuhr

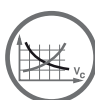
TCHA
SIGH9
135°

D

											N	Abmessungen, mm, Zoll														
DC ₁	DC ₁ "	DC ₂	DC ₂ "	SDL ₁	STA ₂	LU	LU"	CZC _{MS}	Bestellnummer	NBU	DCON _{MS}	DCON _{MS} "	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	SIG	BAR	PSI	BSG		
5.00	.197	8.00	.315	15.00	.591	90°	31.0	1.220	8	430.4-0500-031A1-NM	★	8.0	.315	90	3.543	89.0	3.503	39	1.535	1.0	.041	135°	20	290	COROMANT	
6.80	.268	10.00	.394	20.40	.803	90°	40.4	1.591	10	430.4-0680-040A1-NM	★	10.0	.394	105	4.134	103.6	4.078	50	1.984	1.4	.056	135°	20	290	COROMANT	
8.50	.335	12.00	.472	25.50	1.004	90°	49.5	1.949	12	430.4-0850-050A1-NM	★	12.0	.472	125	4.921	123.2	4.852	61	2.421	1.8	.069	135°	20	290	COROMANT	
10.20	.402	16.00	.630	30.60	1.205	90°	62.6	2.465	16	430.4-1020-063A1-NM	★	16.0	.630	145	5.709	142.9	5.626	78	3.094	2.1	.083	135°	20	290	COROMANT	

Bohrertyp 4 für U/MIN DC2 und Vorschubrate DC1.

E



B94



E9

B 68



Auswahl Ihrer Schnittdaten

Spanbildung und -abfuhr sind kritische Faktoren beim Bohren und abhängig vom zu bearbeitenden Werkstoff, der Bohrer-/Wendeschneidplattengeometrie, dem Kühlschmierstoffdruck/-menge und den Schnittdaten. Spanstau kann radiale Bewegungen des Bohrers verursachen und die Bohrungsqualität, Standzeit sowie die Zuverlässigkeit des Bohrers beeinflussen oder Bohrer- bzw. Plattenbrüche hervorrufen.

Die Spanbildung ist akzeptabel, wenn die Späne problemlos aus den Spankanälen des Bohrers entfernt werden können. Die beste Art das herauszufinden, ist, auf das Bohrgeräusch zu achten. Ein gleichmäßiges Geräusch bedeutet eine gute Spanabfuhr, unterbrochene Geräusche weisen hingegen auf Spanstau hin. Deshalb Vorschubkraft- oder Leistungsanzeige kontrollieren. Gibt es Unregelmäßigkeiten, könnte Spanstau die Ursache sein. Die Späne prüfen. Sind sie lang und gebogen, nicht gewellt, ist ein Spanstau aufgetreten. Die Bohrung prüfen. Ein möglicher Spanstau kann anhand einer unebenen Oberfläche abgelesen werden.

Auswirkungen der Schnittgeschwindigkeit - v_c

Zu hohe Schnittgeschwindigkeit:

Schneller Freiflächenverschleiß
Deformation der Schneidkante
Schlechte Bohrungsqualität und schlechte Bohrungstoleranz

Zu geringe Schnittgeschwindigkeit:

Aufbauschneidenbildung
Schlechte Spanabfuhr
Längere Eingriffszeit

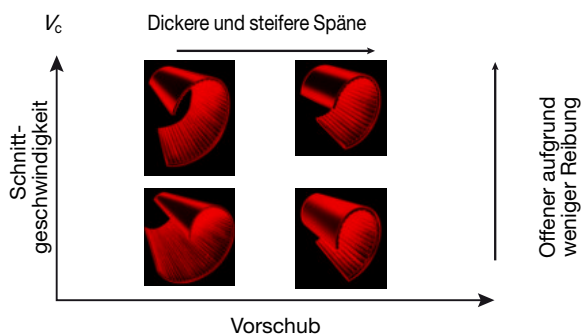
Auswirkungen der Vorschubrate - f_n

Hohe Vorschubgeschwindigkeit:

Härterer Spanbruch
Kürzere Eingriffszeit
Geringerer Werkzeugverschleiß, aber höheres Risiko eines Bohrerbruchs
Verminderte Bohrungsqualität

Geringe Vorschubgeschwindigkeit:

Für langspanende Werkstoffe empfohlen
Qualitätsverbesserung
Schnellerer Werkzeugverschleiß
Längere Eingriffszeit



Erhalt einer hohen Bohrungsqualität

Spanabfuhr

Darauf achten, dass die Spanabfuhr zufriedenstellend ist. Spanstau beeinflusst die Bohrungsqualität und die Zuverlässigkeit/Standzeit. Bohrer/Plattengeometrie sowie Schnittdaten sind entscheidend.

Stabilität, Werkzeugaufspannung

Kürzesten Bohrer wählen. Stablen und präzisen Werkzeughalter mit minimalem Rundlauffehler verwenden. Darauf achten, dass die Maschinenspindel in gutem Zustand und korrekt ausgerichtet ist. Sicherstellen, dass das Bauteil gut eingespannt und stabil ist. Korrekte Vorschubgeschwindigkeiten für unregelmäßige, schräge Oberflächen sowie Kreuzbohrungen einstellen.

A

CoroDrill® 860-GM

Metrische Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc), m/min
ISO	MC-Nr.	Werkstoff	HB	
P	P1.1.Z.AN	Unlegierter Stahl C = 0.05-0.10%	125	(min.-Startwert-max.) 120-145-170
	P1.1.Z.AN	C = 0.1-0.25%	125	120-145-170
	P1.2.Z.AN	C = 0.25-0.55%	150	100-125-150
	P1.3.Z.AN	C = 0.55-0.80%	170	100-125-150
	P1.3.Z.AN	Stahl mit hohem Kohlenstoffgehalt Werkzeugstahl	210	100-125-150
	P2.1.Z.AN	Niedriglegierter Stahl Nicht vergütet	175	100-125-150
	P2.5.Z.HT.1	Vergütet	275	80-100-120
	P2.5.Z.HT.2	Vergütet	350	60-80-100
	P3.0.Z.AN	Hochlegierter Stahl Geglüht	200	64-77-90
	P3.0.Z.HT.1	Gehärteter Werkzeugstahl	300	64-77-90
	P1.5.C.UT	Stahlguss Unlegierter Stahl	150	64-77-90
	P2.6.C.UT	Niedriglegiert (Legierungsanteile < 5%)	200	64-77-90

Zoll-Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc) Fuß/min
ISO	MC-Nr.	Werkstoff	HB	
P	P1.1.Z.AN	Unlegierter Stahl C = 0.05-0.10%	125	(min.-Startwert-max.) 393 - 475 - 557
	P1.1.Z.AN	C = 0.1-0.25%	125	393 - 475 - 557
	P1.2.Z.AN	C = 0.25-0.55%	150	328 - 410 - 492
	P1.3.Z.AN	C = 0.55-0.80%	170	328 - 410 - 492
	P1.3.Z.AN	Stahl mit hohem Kohlenstoffgehalt Werkzeugstahl	210	328 - 410 - 492
	P2.1.Z.AN	Niedriglegierter Stahl Nicht vergütet	175	328 - 410 - 492
	P2.5.Z.HT.1	Vergütet	275	262 - 328 - 393
	P2.5.Z.HT.2	Vergütet	350	196 - 262 - 328
	P3.0.Z.AN	Hochlegierter Stahl Geglüht	200	209 - 252 - 295
	P3.0.Z.HT.1	Gehärteter Werkzeugstahl	300	209 - 252 - 295
	P1.5.C.UT	Stahlguss Unlegierter Stahl	150	209 - 252 - 295
	P2.6.C.UT	Niedriglegiert (Legierungsanteile < 5%)	200	209 - 252 - 295

Metrische Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc), m/min
ISO	MC-Nr.	Werkstoff	HB	
M	M1.0.Z.AQ	Rostfreier Stahl Austenitisch	200	(min.-Startwert-max.) 30-38-46
	M2.0.Z.AQ	Super austenitisch Ni>20%	200	28-36-44
	M3.1.Z.AQ	Austenitisch-ferritisch (Duplex)	230	28-35-42
	M3.2.Z.AQ	Austenitisch-ferritisch (Duplex)	260	26-31-35
	M1.0.C.UT	Austenitisch	200	28-36-44
	M2.0.C.AQ	Super austenitisch Ni>20%	200	28-36-44
	M3.1.C.AQ	Ferritisch	230	24-30-36

Zoll-Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc) Fuß/min
ISO	MC-Nr.	Werkstoff	HB	
M	M1.0.Z.AQ	Rostfreier Stahl Austenitisch	200	(min.-Startwert-max.) 98-125-151
	M2.0.Z.AQ	Super austenitisch Ni>20%	200	92-118-144
	M3.1.Z.AQ	Austenitisch-ferritisch (Duplex)	230	92-115-138
	M3.2.Z.AQ	Austenitisch-ferritisch (Duplex)	260	85-102-115
	M1.0.C.UT	Austenitisch	200	92-118-144
	M2.0.C.AQ	Super austenitisch Ni>20%	200	92-118-144
	M3.1.C.AQ	Ferritisch	230	79-98-118



A

CoroDrill® 860-GM

Metrische Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc), m/min
ISO	MC-Nr.	Werkstoff	HB	
K	K1.1.C.NS	Temperguss Ferritisch/perlitisch	200	(min.-Startwert-max.) 80-100-120
	K2.1.C.UT	Grauguss Niedrige Festigkeit Hohe Festigkeit Hohe Festigkeit	180	100-120-140
	K2.2.C.UT		245	80-100-120
	K2.3.C.UT		175	100-120-140
	K3.1.C.UT	Kugelgraphitguss Ferritisch Perlitisch Perlitisch Perlitisch ADI	155	100-120-140
	K3.2.C.UT		215	80-100-120
	K3.3.C.UT		265	100-120-140
	K3.5.C.UT		190	100-120-140
	K5.1.C.UT		300	60-80-100

Zoll-Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc) Fuß/min
ISO	MC-Nr.	Werkstoff	HB	
K	K1.1.C.NS	Temperguss Ferritisch/perlitisch	200	(min.-Startwert-max.) 262-328-393
	K2.1.C.UT	Grauguss Niedrige Festigkeit Hohe Festigkeit Hohe Festigkeit	180	328-393-459
	K2.2.C.UT		245	262-328-393
	K2.3.C.UT		175	328-393-459
	K3.1.C.UT	Kugelgraphitguss Ferritisch Perlitisch Perlitisch Perlitisch ADI	155	328-393-459
	K3.2.C.UT		215	262-328-393
	K3.3.C.UT		265	328-393-459
	K3.5.C.UT		190	328-393-459
	K5.1.C.UT		300	196-262-328

Metrische Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc), m/min
ISO	MC-Nr.	Werkstoff	HB	
S	S2.0.Z.AN	warmfeste Superlegierungen – nickelbasiert Geglüht oder lösungsbehandelt Ausgehärtet oder lösungsbehandelt und ausgehärtet Gegossen oder gegossen und ausgehärtet	250	(min.-Startwert-max.) 15-20-25
	S2.0.Z.AG		350	10-15-20
	S2.0.C.NS		320	10-15-20
	S4.1.Z.UT	Titanlegierungen Austenitisch Geglüht Legierungen in ausgehärtetem Zustand	200	40-50-60
	S4.2.Z.AN		180	40-50-60
	S4.3.Z.AG		245	30-40-50

Zoll-Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc) Fuß/min
ISO	MC-Nr.	Werkstoff	HB	
S	S2.0.Z.AN	Warmfeste Superlegierungen – nickelbasiert Geglüht oder lösungsbehandelt Ausgehärtet oder lösungsbehandelt und ausgehärtet Gegossen oder gegossen und ausgehärtet	250	(min.-Startwert-max.) 49-65-82
	S2.0.Z.AG		350	32-49-65
	S2.0.C.NS		320	32-49-65
	S4.1.Z.UT	Titanlegierungen Austenitisch Geglüht Legierungen in ausgehärtetem Zustand	200	131-164-196
	S4.2.Z.AN		180	131-164-196
	S4.3.Z.AG		245	98-131-164

B

C

D

E



CoroDrill® 860-GM

Metrische Werte

Bohrerdurchmesser, mm							
3	4	6	8	10	12	16	20
Vorschub (fn) mm/U (min.-Startwert-max.)							
0.08-0.10-0.12	0.10-0.12-0.14	0.12-0.16-0.18	0.16-0.20-0.24	0.20-0.25-0.30	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.15-0.20	0.14-0.18-0.23	0.16-0.22-0.27	0.20-0.26-0.312	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.10-0.12	0.10-0.12-0.14	0.12-0.16-0.18	0.16-0.20-0.24	0.20-0.25-0.30	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.15-0.20	0.14-0.18-0.23	0.16-0.22-0.27	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.12-0.16	0.12-0.15-0.18	0.14-0.18-0.20	0.18-0.23-0.28	0.20-0.27-0.34	0.24-0.30-0.36	0.25-0.32-0.38	0.27-0.34-0.40
0.08-0.12-0.16	0.12-0.15-0.18	0.14-0.18-0.20	0.18-0.23-0.28	0.20-0.27-0.34	0.24-0.30-0.36	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.12-0.16	0.12-0.15-0.18	0.14-0.18-0.20	0.18-0.23-0.28	0.20-0.27-0.34	0.24-0.30-0.36	0.25-0.32-0.38	0.27-0.34-0.40

Zoll-Werte

Bohrerdurchmesser, Zoll							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Vorschub (fn), Zoll/U (min.-Startwert-max.)							
.0031-.0039-.0047	.0039-.0047-.0055	.0047-.0062-.0071	.0062-.0078-.0094	.0078-.0098-.0118	.0086-.0110-.0129	.0098-.0125-.0149	.0160-.0133-.0157
.0039-.0059-.0078	.0055-.0070-.0090	.0062-.0086-.0106	.0078-.0102-.0122	.0102-.0129-.0157	.0118-.0149-.0177	.0133-.0169-.0200	.0141-.0177-.0213
.0031-.0039-.0047	.0039-.0047-.0055	.0047-.0062-.0071	.0062-.0078-.0094	.0078-.0098-.0118	.0086-.0110-.0129	.0098-.0125-.0149	.0160-.0133-.0157
.0039-.0059-.0078	.0055-.0070-.0090	.0062-.0086-.0106	.0078-.0102-.0122	.0102-.0129-.0157	.0118-.0149-.0177	.0133-.0169-.0200	.0141-.0177-.0213
.0039-.0051-.0059	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0157	.0118-.0149-.0177	.0133-.0169-.0200	.0141-.0177-.0213
.0031-.0047-.0062	.0047-.0059-.0070	.0055-.0070-.0078	.0070-.0090-.0110	.0078-.0106-.0133	.0094-.0128-.0141	.0098-.0125-.0149	.0160-.0133-.0157
.0031-.0047-.0062	.0047-.0059-.0070	.0055-.0070-.0078	.0070-.0090-.0110	.0078-.0106-.0133	.0094-.0128-.0141	.0098-.0125-.0149	.0160-.0133-.0157
.0039-.0051-.0059	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0157	.0118-.0149-.0177	.0133-.0169-.0200	.0141-.0177-.0213
.0031-.0047-.0062	.0047-.0059-.0070	.0055-.0070-.0078	.0070-.0090-.0110	.0078-.0106-.0133	.0094-.0128-.0141	.0098-.0125-.0149	.0160-.0133-.0157

Metrische Werte

Bohrerdurchmesser, mm							
3	4	6	8	10	12	16	20
Vorschub (fn) mm/U (min.-Startwert-max.)							
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.08-0.10-0.12	0.10-0.12-0.15	0.10-0.12-0.15	0.10-0.12-0.15
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.08-0.10-0.12	0.10-0.12-0.15	0.10-0.12-0.15	0.10-0.12-0.15
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.08-0.10-0.12	0.10-0.12-0.15	0.10-0.12-0.15	0.10-0.12-0.15
0.06-0.08-0.12	0.06-0.08-0.12	0.06-0.08-0.12	0.08-0.12-0.16	0.10-0.14-0.16	0.12-0.16-0.20	0.16-0.20-0.24	0.20-0.25-0.30
0.06-0.08-0.12	0.06-0.08-0.12	0.06-0.08-0.12	0.08-0.12-0.16	0.10-0.14-0.16	0.12-0.16-0.20	0.16-0.20-0.24	0.20-0.25-0.30
0.06-0.08-0.12	0.06-0.08-0.12	0.06-0.08-0.12	0.08-0.12-0.16	0.10-0.14-0.16	0.12-0.16-0.20	0.16-0.20-0.24	0.20-0.25-0.30

Zoll-Werte

Bohrerdurchmesser, Zoll							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Vorschub (fn), Zoll/U (min.-Startwert-max.)							
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0039-.0047-.0059	.0039-.0047-.0059
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0039-.0047-.0059	.0039-.0047-.0059
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0039-.0047-.0059	.0039-.0047-.0059
.0023-.0031-.0051	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0047-.0062	.0039-.0055-.0062	.0047-.0062-.0078	.0062-.0078-.0094	.0078-.0098-.0118
.0023-.0031-.0051	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0047-.0062	.0039-.0055-.0062	.0047-.0062-.0078	.0062-.0078-.0094	.0078-.0098-.0118
.0023-.0031-.0051	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0047-.0062	.0039-.0055-.0062	.0047-.0062-.0078	.0062-.0078-.0094	.0078-.0098-.0118

A

CoroDrill® 860-GM

Metrische Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc), m/min
ISO	MC-Nr.	Werkstoff	HB	
N	N1.2.Z.UT	Aluminiumbasislegierungen Handelsüblich rein	60	(min.-Startwert-max.) 170-225-280
	N1.2.Z.AG	AlSi Legierungen, Si ≤ 1%	100	170-225-280
	N1.3.C.UT	Gegossen, nicht gealtert	75	170-225-280
	N1.3.C.AG	Gegossen oder gegossen und ausgehärtet	90	160-200-240
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	130	120-150-180
	N3.3.U.UT	Kupferbasislegierungen Automatenlegierungen (Pb > 1%)	110	110-140-170
	N3.1.U.UT	Bleifreie Kupferlegierungen (einschl. elektrolytischer Kupfer)	100	100-125-150

Zoll-Werte

			Härte Brinell	Schnittgeschwindigkeit (Vc) Fuß/min
ISO	MC-Nr.	Werkstoff	HB	
N	N1.2.Z.UT	Aluminiumbasislegierungen Handelsüblich rein	60	(min.-Startwert-max.) 557-738-918
	N1.2.Z.AG	AlSi Legierungen, Si ≤ 1%	100	557-738-918
	N1.3.C.UT	Gegossen, nicht gealtert	75	557-738-918
	N1.3.C.AG	Gegossen oder gegossen und ausgehärtet	90	524-656-787
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	130	393-492-590
	N3.3.U.UT	Kupferbasislegierungen Automatenlegierungen (Pb > 1%)	110	360-459-557
	N3.1.U.UT	Bleifreie Kupferlegierungen (einschl. elektrolytischer Kupfer)	100	328-410-492

C

Metrische Werte

			Härte	Schnittgeschwindigkeit (Vc), m/min
ISO	MC-Nr.	Werkstoff		
H	H1.3.Z.HA	Extra harter Stahl Vergütet	47-60 HRC	(min.-Startwert-max.) 15-20-25
	H1.3.Z.HA		47-60 HRC	15-20-25
	H1.1.Z.HA	Vergütet	50 HRC	15-20-25
	H2.0.C.UT.4	Kokillenhartguss	64 HRC	12-15-18

Zoll-Werte

			Härte	Schnittgeschwindigkeit (Vc) Fuß/min
ISO	MC-Nr.	Werkstoff		
H	H1.3.Z.HA	Extra harter Stahl Vergütet	47-60 HRC	(min.-Startwert-max.) 49-65-82
	H1.3.Z.HA		47-60 HRC	49-65-82
	H1.1.Z.HA	Vergütet	50 HRC	49-65-82
	H2.0.C.UT.4	Kokillenhartguss	64 HRC	39-49-59

D

E



CoroDrill® 860-GM

Metrische Werte

Bohrerdurchmesser, mm							
3	4	6	8	10	12	16	20
Vorschub (fn) mm/U (min.-Startwert-max.)							
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.30	0.26-0.33-0.39	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.30	0.26-0.33-0.39	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.10-0.12	0.10-0.12-0.14	0.12-0.16-0.18	0.16-0.20-0.24	0.20-0.25-0.30	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.13-0.15	0.10-0.12-0.14	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.10-0.12	0.10-0.12-0.14	0.12-0.16-0.18	0.16-0.20-0.24	0.20-0.25-0.30	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40

Zoll-Werte

Bohrerdurchmesser, Zoll							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Vorschub (fn) Zoll/U (min.-Startwert-max.)							
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0153	.0086-.0110-.0129	.0098-.0125-.0149	.0106-.0133-.0157
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0153	.0086-.0110-.0129	.0098-.0125-.0149	.0106-.0133-.0157
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0167	.0118-.0149-.0178	.0134-.0169-.0201	.0141-.0177-.0212
.0031-.0039-.0048	.0039-.0047-.0055	.0047-.0062-.0070	.0062-.0078-.0094	.0078-.0098-.0118	.0086-.0110-.0129	.0098-.0125-.0149	.0106-.0133-.0157
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0167	.0118-.0149-.0178	.0134-.0169-.0201	.0141-.0177-.0212
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0167	.0118-.0149-.0178	.0134-.0169-.0201	.0141-.0177-.0212
.0031-.0039-.0048	.0039-.0047-.0055	.0047-.0062-.0070	.0062-.0078-.0094	.0078-.0098-.0118	.0086-.0110-.0129	.0098-.0125-.0149	.0106-.0133-.0157

Metrische Werte

Bohrerdurchmesser, mm							
3	4	6	8	10	12	16	20
Vorschub (fn) mm/U (min.-Startwert-max.)							
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.12-0.15	0.12-0.15-0.18	0.12-0.15-0.18	0.12-0.15-0.18
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.11-0.13	0.10-0.11-0.13	0.12-0.13-0.15	0.12-0.13-0.15
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.12-0.15	0.12-0.15-0.18	0.12-0.15-0.18	0.12-0.15-0.18
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.11-0.13	0.10-0.11-0.13	0.12-0.13-0.15	0.12-0.13-0.15

Zoll-Werte

Bohrerdurchmesser, Zoll							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Vorschub (fn) Zoll/U (min.-Startwert-max.)							
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0047-.0059-.0070	.0047-.0059-.0070	.0047-.0059-.0070
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0043-.0051	.0039-.0043-.0051	.0047-.0051-.0059	.0047-.0051-.0059
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0047-.0059-.0070	.0047-.0059-.0070	.0047-.0059-.0070
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0043-.0051	.0039-.0043-.0051	.0047-.0051-.0059	.0047-.0051-.0059

CoroDrill® 860-PM

Innere Kühlschmierstoffzufuhr, metrische Werte
3-8 x DC

			Härte Brinell	Sorte	Schnittgeschwindigkeit (V _c), m/min
ISO	MC-Nr.	Werkstoff	HB		
P		Unlegierter Stahl			(min.-Startwert-max.)
	P1.1.Z.AN	C = 0,05–0,10 %	125	4234	140-200-250
	P1.1.Z.AN	C = 0,1–0,25%	125	4234	140-200-250
	P1.2.Z.AN	C = 0,25–0,55%	150	4234	140-180-250
	P1.3.Z.AN	C = 0,55–0,80%	170	4234	140-180-250
		Stahl mit hohem Kohlenstoffgehalt			
	P1.3.Z.AN	Werkzeugstahl	210	4234	150-170-220
		Niedriglegierter Stahl			
	P2.1.Z.AN	Nicht gehärtet	175	4234	120-170-240
	P2.5.Z.HT	Vergütet	275	4234	80-110-140
	P2.5.Z.HT	Vergütet	350	4234	60-80-100
		Hochlegierter Stahl			
	P3.0.Z.AN	Geglüht	200	4234	60-120-140
	P3.0.Z.HT	Gehärteter Werkzeugstahl	300	4234	60-80-100
		Stahlguss			
	P1.5.C.UT	Unlegiert	150	4234	120-170-210
	P2.6.C.UT	Niedriglegiert (Legierungsanteile ≤5 %)	200	4234	120-160-220

CoroDrill® 860-NM

2-3 x DC

			Schnittgeschwindigkeit (V _c), m/min
ISO	MC-Nr.	Werkstoff	
N		Aluminiumbasislegierungen	(min.-Startwert-max.)
	N1.1.Z.UT	Handelsüblich rein	320-400-480
	N1.2.C.NS		320-400-480
	N1.2.S.UT		320-400-480
	N1.2.Z.AG	AlSi Legierungen, Si ≤ 1 %	320-400-480
	N1.2.Z.UT	Gewalzt, nicht ausgehärtet	320-400-480
	N1.3.C.AG	Gegossen oder gegossen und ausgehärtet	240-300-360
	N1.3.C.UT	Gegossen, nicht gealtert	320-400-480
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	200-250-300
	N2.0.C.UT	Magnesiumbasislegierungen	200-250-300

7-8 x DC

			Schnittgeschwindigkeit (V _c), m/min
ISO	MC-Nr.	Werkstoff	
N		Aluminiumbasislegierungen	(min.-Startwert-max.)
	N1.1.Z.UT	Handelsüblich rein	320-400-480
	N1.2.C.NS		320-400-480
	N1.2.S.UT		320-400-480
	N1.2.Z.AG	AlSi Legierungen, Si ≤ 1 %	320-400-480
	N1.2.Z.UT	Gewalzt, nicht ausgehärtet	320-400-480
	N1.3.C.AG	Gegossen oder gegossen und ausgehärtet	240-300-360
	N1.3.C.UT	Gegossen, nicht gealtert	320-400-480
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	200-250-300
	N2.0.C.UT	Magnesiumbasislegierungen	200-250-300

Schnittdatenempfehlungen gelten für innere Kühlschmierstoffzufuhr, mit der die beste Leistung erzielt wird.

Empfohlener Druck. min. 15 bar

Bei äußerer Kühlschmierstoffzufuhr:

- Anpassung der Schnittdaten für gute Spanbildung und -abfuhr ist ein wichtiges Kriterium
- Niedrigere Vorschübe im Vergleich zu denjenigen bei innerer Kühlschmierstoffzufuhr könnten erforderlich werden

3-8 x DC

Bohrerdurchmesser, mm							
3	4	6	8	10	12	16	20
Vorschub (f _n), mm/U (min.-Startwert-max.)							
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.08-0.14-0.20	0.14-0.18-0.24	0.18-0.24-0.32	0.20-0.28-0.36	0.20-0.32-0.40	0.22-0.36-0.44	0.24-0.40-0.48	0.26-0.44-0.50
0.08-0.12-0.18	0.14-0.16-0.22	0.18-0.22-0.30	0.20-0.25-0.33	0.20-0.29-0.37	0.22-0.33-0.41	0.24-0.36-0.42	0.26-0.40-0.48
0.08-0.14-0.22	0.10-0.18-0.24	0.12-0.20-0.26	0.15-0.22-0.28	0.16-0.24-0.32	0.18-0.28-0.40	0.20-0.30-0.42	0.22-0.32-0.44
0.08-0.12-0.16	0.10-0.15-0.18	0.12-0.18-0.22	0.15-0.20-0.28	0.16-0.22-0.32	0.18-0.26-0.36	0.20-0.28-0.40	0.22-0.30-0.42
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48

2-3 x DC

Bohrerdurchmesser, mm							
3	4	6	8	10	12	16	20
Vorschub (f_n), mm/U							
(min.-Startwert-max.)							
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.144-0.180-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.180-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888

7-8 x DC

Bohrerdurchmesser, mm							
3	4	6	8	10	12	16	20
Vorschub (f_n), mm/U							
(min.-Startwert-max.)							
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.12-0.15-0.18	0.144-0.180-0.216	0.20-0.25-0.30	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.44-0.55-0.66	0.464-0.580-0.696
0.12-0.15-0.18	0.144-0.180-0.216	0.20-0.25-0.30	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.44-0.55-0.66	0.464-0.580-0.696

A

CoroDrill® 860-PM

Innere Kühlschmierstoffzufuhr, Zollwerte
3-8 x DC

			Härte Brinell	Sorte	Schnittgeschwindigkeit (Vc), Fuß/min
ISO	MC-Nr.	Werkstoff	HB		
P		Unlegierter Stahl			(min.-Startwert-max.)
	P1.1.Z.AN	C = 0,05–0,10 %	125	4234	460-655-820
	P1.1.Z.AN	C = 0,1–0,25%	125	4234	460-655-820
	P1.2.Z.AN	C = 0,25–0,55%	150	4234	460-590-820
	P1.3.Z.AN	C = 0,55–0,80%	170	4234	460-590-755
		Stahl mit hohem Kohlenstoffgehalt			
	P1.3.Z.AN	Werkzeugstahl	210	4234	490-560-720
		Niedriglegierter Stahl			
	P2.1.Z.AN	Nicht gehärtet	175	4234	395-560-785
	P2.5.Z.HT	Vergütet	275	4234	260-360-460
	P2.5.Z.HT	Vergütet	350	4234	195-260-330
		Hochlegierter Stahl			
	P3.0.Z.AN	Geglüht	200	4234	195-395-460
	P3.0.Z.HT	Gehärteter Werkzeugstahl	300	4234	195-260-330
		Stahlguss			
	P1.5.C.UT	Unlegiert	150	4234	395-560-690
	P2.6.C.UT	Niedriglegiert (Legierungsanteile ≤5 %)	200	4234	395-525-720

B

CoroDrill® 860-NM

2-3 x DC

			Schnittgeschwindigkeit (Vc), Fuß/min
ISO	MC-Nr.	Werkstoff	
N		Aluminiumbasislegierungen	(min.-Startwert-max.)
	N1.1.Z.UT	Handelsüblich rein	1050-1312-1575
	N1.2.C.NS		1050-1312-1575
	N1.2.S.UT		1050-1312-1575
	N1.2.Z.AG	AlSi Legierungen, Si ≤ 1 %	1050-1312-1575
	N1.2.Z.UT	Gewalzt, nicht ausgehärtet	1050-1312-1575
	N1.3.C.AG	Gegossen oder gegossen und ausgehärtet	787-984-1181
	N1.3.C.UT	Gegossen, nicht gealtert	1050-1312-1575
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	656-820-984
		Magnesiumbasislegierungen	
	N2.0.C.UT		656-820-984

C

7-8 x DC

			Schnittgeschwindigkeit (Vc), Fuß/min
ISO	MC-Nr.	Werkstoff	
N		Aluminiumbasislegierungen	(min.-Startwert-max.)
	N1.1.Z.UT	Handelsüblich rein	1050-1312-1575
	N1.2.C.NS		1050-1312-1575
	N1.2.S.UT		1050-1312-1575
	N1.2.Z.AG	AlSi Legierungen, Si ≤ 1 %	1050-1312-1575
	N1.2.Z.UT	Gewalzt, nicht ausgehärtet	1050-1312-1575
	N1.3.C.AG	Gegossen oder gegossen und ausgehärtet	787-984-1181
	N1.3.C.UT	Gegossen, nicht gealtert	1050-1312-1575
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	656-820-984
		Magnesiumbasislegierungen	
	N2.0.C.UT		656-820-984

Schnittdatenempfehlungen gelten für innere Kühlschmierstoffzufuhr, mit der die beste Leistung erzielt wird.

Empfohlener Druck. min. 15 bar

Bei äußerer Kühlschmierstoffzufuhr:

- Anpassung der Schnittdaten für gute Spanbildung und -abfuhr ist ein wichtiges Kriterium
- Niedrigere Vorschübe im Vergleich zu denjenigen bei innerer Kühlschmierstoffzufuhr könnten erforderlich werden

E

CoroDrill® 860-PM

Innere Kühlschmierstoffzufuhr, Zollwerte

3-8 x DC

Bohrerdurchmesser, Zoll							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Vorschub (f _n), Zoll/U							
(min.-Startwert-max.)							
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0031-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0118	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0031-.0055-.0079	.0055-.0071-.0094	.0071-.0094-.0126	.0079-.0110-.0142	.0079-.0126-.0157	.0087-.0142-.0173	.0094-.0157-.0189	.0102-.0173-.0197
.0031-.0047-.0071	.0055-.0063-.0087	.0071-.0087-.0118	.0079-.0098-.0130	.0079-.0114-.0146	.0087-.0130-.0161	.0094-.0142-.0165	.0105-.0157-.0189
.0031-.0055-.0087	.0039-.0071-.0094	.0047-.0079-.0102	.0059-.0087-.0110	.0063-.0094-.0126	.0071-.0110-.0157	.0079-.0118-.0165	.0087-.0126-.0173
.0031-.0047-.0063	.0039-.0059-.0071	.0047-.0071-.0087	.0059-.0079-.0110	.0063-.0087-.0126	.0071-.0102-.0142	.0079-.0110-.0157	.0087-.0118-.0165
.0031-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0118	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0031-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0118	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189

CoroDrill® 860-NM

2 – 3 x DC

Bohrerdurchmesser, Zoll							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Vorschub (f _n), Zoll/U							
(min.-Startwert-max.)							
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0220-.0169-.0203	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0220-.0169-.0203	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350

7 – 8 x DC

Bohrerdurchmesser, Zoll							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Vorschub (f _n), Zoll/U							
(min.-Startwert-max.)							
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0047-.0059-.0071	.0057-.0071-.0085	.0079-.0098-.0118	.0104-.0130-.0156	.0132-.0165-.0198	.0151-.0189-.0227	.0173-.0217-.0260	.0183-.0228-.0274
.0047-.0059-.0071	.0057-.0071-.0085	.0079-.0098-.0118	.0104-.0130-.0156	.0132-.0165-.0198	.0151-.0189-.0227	.0173-.0217-.0260	.0183-.0228-.0274

CoroDrill® 860-MM

Innere Kühlschmierstoffzufuhr

Metrische Werte

			Härte Brinell	Schnittgeschwindigkeit (V _c) m/min	
ISO	MC-Nr.	Werkstoff	HB		
M		Austenitischer rostfreier Stahl		(min.-Startwert-max.)	
	M1.0.C.UT	Gegossen+unbehandelt	165	48 - 60 - 72	
	M1.0.Z.AQ	Geglüht/vergütet	200	48 - 60 - 72	
	M1.0.Z.PH	PH-gehärtet	350	44 - 55 - 66	
	M1.1.Z.AQ	Zerspanbarkeit verbessert	165	48 - 60 - 72	
	M1.2.Z.AQ	Automatenstahl	200	48 - 60 - 72	
	M1.3.C.AQ	Ti-stabilisiert+gegossen	200	48 - 60 - 72	
	M1.3.Z.AQ	Ti-stabilisiert	200	48 - 60 - 72	
	M1.4.Z.AQ	Hohe Festigkeit	250	64 - 80 - 96	
		Super austenitischer (Ni>20%) rostfreier Stahl			
	M2.0.C.AQ	Gegossen+geglüht/vergütet	165	48 - 60 - 72	
	M2.0.Z.AQ	Geglüht/vergütet	200	48 - 60 - 72	
		Rostfreie (austenitische/ferritische) Duplex-Stähle			
	M3.1.Z.AQ	>60% Ferrit (N<0.10%)	250	64 - 80 - 96	
	M3.2.Z.AQ	<60% Ferrit (N≥0.10%)	250	64 - 80 - 96	

Zoll-Werte

			Härte Brinell	Schnittgeschwindigkeit (V _c), Fuß/min	
ISO	MC-Nr.	Werkstoff	HB		
M		Austenitischer rostfreier Stahl		(min.-Startwert-max.)	
	M1.0.C.UT	Gegossen+unbehandelt	165	157 - 197 - 236	
	M1.0.Z.AQ	Geglüht/vergütet	200	157 - 197 - 236	
	M1.0.Z.PH	PH-gehärtet	350	144 - 180 - 217	
	M1.1.Z.AQ	Zerspanbarkeit verbessert	165	157 - 197 - 236	
	M1.2.Z.AQ	Automatenstahl	200	157 - 197 - 236	
	M1.3.C.AQ	Ti-stabilisiert+gegossen	200	157 - 197 - 236	
	M1.3.Z.AQ	Ti-stabilisiert	200	157 - 197 - 236	
	M1.4.Z.AQ	Hohe Festigkeit	250	210 - 262 - 315	
		Super austenitischer (Ni>20%) rostfreier Stahl			
	M2.0.C.AQ	Gegossen+geglüht/vergütet	165	157 - 197 - 236	
	M2.0.Z.AQ	Geglüht/vergütet	200	157 - 197 - 236	
		Rostfreie (austenitische/ferritische) Duplex-Stähle			
	M3.1.Z.AQ	>60% Ferrit (N<0.10%)	250	210 - 262 - 315	
	M3.2.Z.AQ	<60% Ferrit (N≥0.10%)	250	210 - 262 - 315	

Schnittdatenempfehlungen gelten für innere Kühlschmierstoffzufuhr, mit der die beste Leistung erzielt wird.

Empfohlener Druck. min. 15 bar

Bei äußerer Kühlschmierstoffzufuhr:

- Anpassung der Schnittdaten für gute Spanbildung und -abfuhr ist ein wichtiges Kriterium
- Niedrigere Vorschübe im Vergleich zu denjenigen bei innerer Kühlschmierstoffzufuhr könnten erforderlich werden

CoroDrill® 860-MM

Innere Kühlschmierstoffzufuhr

Metrische Werte

Bohrerdurchmesser, mm							
3	4	6	8	10	12	16	
Vorschub (f _n), mm/U (min.-Startwert-max.)							
0.058-0.072-0.086	0.073-0.091-0.109	0.103-0.129-0.155	0.134-0.168-0.202	0.134-0.168-0.202	0.162-0.202-0.242	0.214-0.268-0.322	
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240	
0.032-0.040-0.048	0.032-0.040-0.048	0.058-0.073-0.088	0.096-0.120-0.144	0.122-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240	
0.058-0.072-0.086	0.073-0.091-0.109	0.103-0.129-0.155	0.134-0.168-0.202	0.134-0.168-0.202	0.162-0.202-0.242	0.214-0.268-0.322	
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240	
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240	
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240	
0.058-0.072-0.086	0.073-0.091-0.109	0.103-0.129-0.155	0.134-0.168-0.202	0.134-0.168-0.202	0.162-0.202-0.242	0.214-0.268-0.322	
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240	
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240	
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240	

Zoll-Werte

Bohrerdurchmesser, Zoll							
.1181	.1575	.2362	.315	.3937	.4724	.6299	
Vorschub (f _n), Zoll/U (min.-Startwert-max.)							
.0023-.0028-.0034	.0029-.0036-.0043	.0041-.0051-.0061	.0053-.0066-.0080	.0053-.0066-.0080	.0064-.0080-.0095	.0084-.0106-.0127	
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	
.0013-.0016-.0019	.0013-.0016-.0019	.0023-.0029-.0035	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	
.0023-.0028-.0034	.0029-.0036-.0043	.0041-.0051-.0061	.0053-.0066-.0080	.0053-.0066-.0080	.0064-.0080-.0095	.0084-.0106-.0127	
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	
.0023-.0028-.0034	.0029-.0036-.0043	.0041-.0051-.0061	.0053-.0066-.0080	.0053-.0066-.0080	.0064-.0080-.0095	.0084-.0106-.0127	
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094	

A

CoroDrill® 860-SM

Metrische Werte

ISO	MC-Nr.	Werkstoff	Härte Brinell HB	Schnittgeschwindigkeit (V _c), m/min	Bohrerdurchmesser, mm			
					3.00–6.00	6.01–10.00	10.01–14.00	14.01–20.00
					Vorschub (f _n), mm/U			
S	S1.0.U.AN	Warmfeste Superlegierungen	200	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S1.0.U.AG		280	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.AN	Nickelbasislegierungen	250	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.AG		350	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.UT		275	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.NS		320	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.Z.AN	Kobaltbasislegierungen	200	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.Z.AG		300	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.C.NS		320	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S4.1.Z.UT	Titanbasislegierungen	200	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.10-0.16
	S4.2.Z.AN		320	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.3.Z.AN		330	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.3.Z.AG		375	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.4.Z.AN		330	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.4.Z.AG		410	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.4.Z.AG		410	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30

Zoll-Werte

ISO	MC-Nr.	Werkstoff	Härte Brinell HB	Schnittgeschwindigkeit (V _c), Fuß/min	Bohrerdurchmesser, Zoll			
					.1181–.2362	.2366–.3937	.3941–.5512	.5516–.7874
					Vorschub (f _n), Zoll/U			
S	S1.0.U.AN	Warmfeste Superlegierungen	200	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S1.0.U.AG		280	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S2.0.Z.AN	Nickelbasislegierungen	250	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S2.0.Z.AG		350	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S2.0.Z.UT		275	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S2.0.Z.NS		320	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S3.0.Z.AN	Kobaltbasislegierungen	200	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S3.0.Z.AG		300	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S3.0.C.NS		320	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S4.1.Z.UT	Titanbasislegierungen	200	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.2.Z.AN		320	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.3.Z.AN		330	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.3.Z.AG		375	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.4.Z.AN		330	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.4.Z.AG		410	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.4.Z.AG		410	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118

Schnittdatenempfehlungen gelten für innere Kühlschmierstoffzufuhr, mit der die beste Leistung erzielt wird.

Empfohlener Druck. min. 15 bar

- Bei äußerer Kühlschmierstoffzufuhr:
- Anpassung der Schnittdaten für gute Spanbildung und -abfuhr ist ein wichtiges Kriterium
 - Niedrigere Vorschübe im Vergleich zu denjenigen bei innerer Kühlschmierstoffzufuhr könnten erforderlich werden

E



CoroDrill® 863

Werkzeug		M	N	S	O
863.1-A1-O	v_c m/min f_n mm/U Bohrfräsen mit Vorschubunterbrechung				60 - 120 0.050 - 0.100 NEIN
863.1-A1-N	v_c m/min f_n mm/U Bohrfräsen mit Vorschubunterbrechung		200 - 400 0.150 - 0.300 NEIN		
863.1-A1-OS	v_c m/min f_n mm/U Bohrfräsen mit Vorschubunterbrechung		60 - 120 0.050 - 0.100 Ja	15 - 30 0.050 - 0.100 Ja	60 - 120 0.050 - 0.100 NEIN
863.1-B1-OS	v_c m/min f_n mm/U Bohrfräsen mit Vorschubunterbrechung		60 - 120 0.050 - 0.100 Ja	15 - 30 0.050 - 0.100 Ja	60 - 120 0.050 - 0.100 NEIN
863.1-B1-MS	v_c m/min f_n mm/U Bohrfräsen mit Vorschubunterbrechung	15 - 30 0.050 - 0.100 Ja	60 - 120 0.050 - 0.100 Ja	15 - 30 0.050 - 0.100 Ja	

Wenn das Werkzeug durch unterschiedliche Werkstoffschichten schneidet und die Parameter nicht für jedes Material geändert werden können, sind die niedrigsten Schnittparameter für den gesamten Schichtverbund zu wählen.

CoroDrill® 863 Vollhartmetallbohrer

Metrische Werte

ISO	Werkstoff	Schnittgeschwindigkeit (V_d), m/min	Bohrerdurchmesser, mm			
			3	6	8	10
O	Thermoset	Min. 65	0.05	0.05	0.05	0.05
		Empfehl. 125	0.07	0.07	0.075	0.075
		Max. 200	0.12	0.12	0.15	0.15
	Thermoplaste	Min. 50	0.05	0.05	0.10	0.10
		Empfehl. 75	0.10	0.10	0.15	0.15
		Max. 125	0.15	0.20	0.25	0.25
	BMI/Zyanat/Phenolharz	Min. 50	0.05	0.08	0.08	0.10
		Empfehl. 100	0.10	0.10	0.10	0.15
		Max. 150	0.12	0.20	0.20	0.25

CoroDrill® 861 - GM

12 - 15 x DC

Metrische Werte

			Härte Brinell	Schnittgeschwindigkeit (V _c) m/min	
ISO	MC-Nr.	Werkstoff	HB	Min.	Max.
P		Unlegierter Stahl			
	P1.1.Z.AN	C=0.10-0.25%	125	80	156
	P1.2.Z.AN	C=0.25-0.55%	190	80	156
		Niedriglegierter Stahl			
	P2.2.Z.AN	Geglüht	240	64	120
	P2.5.Z.HT	Vergütet	330	64	120
		Hochlegierter Stahl			
	P3.0.Z.AN	Geglüht	200	64	120
	P4.0.S.NS	Gesinterte Stähle	150	80	132
M		Rostfreier Stahl			
	P5.1.Z.AN	Ferritisch/martensitisch	200	20	120
		Rostfreier Stahl			
	M1.0.Z.AQ	Austenitisch	200	20	42
	M2.0.Z.AQ	Super austenitisch Ni≥20%	200	20	36
	M3.2.Z.AQ	Austenitisch-ferritisch (Duplex)	260	20	30
		Temperguss (ferritisch, perlitisch)			
	K1.1.C.NS		200	60	90
		Grauguss			
K	K2.1.C.UT	Niedrige Festigkeit	180	92	138
	K2.2.C.UT	Hohe Festigkeit	245	60	90
		Kugelgraphitguss			
	K3.1.C.UT	Ferritisch	155	60	90
	K3.3.C.UT	Perlitisch	265	60	90
	K5.1.C.NS	ADI	300	60	90
		Aluminiumbasislegierungen			
	N1.1.Z.UT	Handelsüblich rein	30	216	324
	N1.2.Z.AG	AlSi Legierungen, Si ≤ 1%	100	216	324
N	N1.3.C.AG	AlSi Gusslegierungen, Si > 1% und < 13%	90	72	216
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	130	72	108
	N2.0.C.UT	Magnesiumbasislegierungen	70	72	216
		Kupferbasislegierungen			
	N3.1.U.UT	Bleifreie Kupferlegierungen (einschl. elektrolytischer Kupfer)	100	100	150
	N3.2.C.UT	Messing und bleileg. Bronzen (Pb ≤ 1%)	90	176	264
	N3.3.U.UT	Automatenlegierungen (Pb>1%)	110	176	264
	N3.4.C.UT	Bleilegierte Bronzen (>225HB)	300	80	120
	N4.0.C.UT	Zinkbasislegierungen	70	176	264

CoroDrill® 861 - GM

12 - 15 x DC

Metrische Werte

Bohrerdurchmesser, mm f_n mm/U																			
3.00-3.99		4.00-4.99		5.00-5.99		6.00-7.99		8.00-9.99		10.00-11.99		12.00-14.99		15.00-15.99		16.00-17.99		18.00-20.00	
Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28	0.22	0.31	0.23	0.32	0.25	0.34
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28	0.22	0.31	0.23	0.32	0.25	0.34
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28	0.22	0.31	0.23	0.32	0.25	0.34
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21	0.21	0.23	0.22	0.24	0.24	0.26
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35

B

C

D

E

CoroDrill® 861 - GM

20-30 x DC

Metrische Werte

				Härte Brinell	Schnittgeschwindigkeit (V _c) m/min	
ISO	MC-Nr.	CMC- Nr.	Werkstoff	HB	Min.	Max.
P			Unlegierter Stahl			
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	72	140
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	72	140
			Niedriglegierter Stahl			
	P2.2.Z.AN	02.1	Geglüht	240	58	135
	P2.5.Z.HT	02.2	Vergütet	330	58	135
			Hochlegierter Stahl			
	P3.0.Z.AN	03.11	Geglüht	200	58	135
M			Gesinterte Stähle			
	P4.0.S.NS			150	72	119
			Rostfreier Stahl			
	P5.1.Z.AN	05.11 /15.11	Ferritisch/martensitisch	200	19	108
			Rostfreier Stahl			
	M1.0.Z.AQ	05.21/15.21	Austenitisch	200	19	38
	M2.0.Z.AQ	05.21/15.21	Super austenitisch Ni≥20%	200	19	33
	M3.2.Z.AQ	05.52/15.52	Austenitisch-ferritisch (Duplex)	260	19	28
K			Temperguss			
	K1.1.C.NS	07.1/07.2		200	55	82
			Grauguss			
	K2.1.C.UT	08.1	Niedrige Festigkeit	180	92	138
	K2.2.C.UT	08.2	Hohe Festigkeit	245	55	82
			Kugelgraphitguss			
	K3.1.C.UT	09.1	Ferritisch	155	55	82
	K3.3.C.UT	09.2	Perlitisch	265	55	82
N			ADI			
	K5.1.C.NS			300	55	82
			Aluminiumbasislegierungen			
	N1.1.Z.UT		Handelsüblich rein	30	194	292
	N1.2.Z.AG		AlSi Legierungen, Si ≤ 1%	100	194	292
	N1.3.C.AG	30.21	AlSi Gusslegierungen, Si > 1% und < 13%	90	65	194
	N1.4.C.NS		AlSi Gusslegierungen, Si ≤ 13%	130	65	97
	N2.0.C.UT		Magnesiumbasislegierungen	70	65	194

CoroDrill® 861 - GM

20-30 x DC

Metrische Werte

Bohrerdurchmesser, mm f_n mm/U													
3.00-3.99		4.00-4.99		5.00-5.99		6.00-7.99		8.00-9.99		10.00-11.99		12.00	
Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.04	0.07	0.05	0.08	0.06	0.09	0.07	0.11	0.09	0.14	0.11	0.17	0.13	0.20
0.04	0.07	0.05	0.08	0.06	0.09	0.07	0.11	0.09	0.14	0.11	0.17	0.13	0.20
0.04	0.07	0.05	0.08	0.06	0.09	0.07	0.11	0.09	0.14	0.11	0.17	0.13	0.20
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29

B

C

D

E

CoroDrill® 861 - GM

12-15 x DC

Zoll-Werte

				Härte Brinell	Schnittgeschwindigkeit (Vc), Fuß/min	
ISO	MC-Nr.	CMC- Nr.	Werkstoff	HB	Min.	Max.
P			Unlegierter Stahl			
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	260	510
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	260	510
			Niedriglegierter Stahl			
	P2.2.Z.AN	02.1	Geglüht	240	210	395
	P2.5.Z.HT	02.2	Vergütet	330	210	395
			Hochlegierter Stahl			
	P3.0.Z.AN	03.11	Geglüht	200	210	395
	P4.0.S.NS		Gesinterte Stähle	150	260	435
			Rostfreier Stahl			
M	P5.1.Z.AN	05.11 /15.11	Ferritisch/Martensitisch	200	65	395
			Rostfreier Stahl			
	M1.0.Z.AQ	05.21/15.21	Austenitisch	200	65	140
	M2.0.Z.AQ	05.21/15.21	Super austenitisch Ni≥20%	200	65	120
K	M3.2.Z.AQ	05.52/15.52	Austenitisch-ferritisch (Duplex)	260	65	100
			Temperguss (ferritisch, perlitisch)			
	K1.1.C.NS	07.1/07.2		200	195	295
			Grauguss			
	K2.1.C.UT	08.1	Niedrige Festigkeit	180	300	455
	K2.2.C.UT	08.2	Hohe Festigkeit	245	195	295
			Kugelgraphitguss			
	K3.1.C.UT	09.1	Ferritisch	155	195	295
	K3.2.C.UT	09.2	Perlitisch	265	195	295
	K5.1.C.NS		ADI	300	195	295
N			Aluminiumbasislegierungen			
	N1.1.Z.UT		Handelsüblich rein	30	710	1065
	N1.2.Z.AG		AlSi Legierungen, Si ≤ 1%	100	710	1065
	N1.3.C.AG	30.21	AlSi Gusslegierungen, Si > 1% und < 13%	90	235	710
	N1.4.C.NS		AlSi Gusslegierungen, Si ≤ 13%	130	235	355
	N2.0.C.UT		Magnesiumbasislegierungen	70	235	710
			Kupferbasislegierungen			
	N3.1.U.UT		Bleifreie Kupferlegierungen (einschl. elektrolytischer Kupfer)	100	330	490
	N3.2.C.UT		Messing und bleileg. Bronzen (Pb ≤ 1%)	90	575	865
	N3.3.U.UT		Automatenlegierungen (Pb>1%)	110	575	865
	N3.4.C.UT		Bleilegierte Bronzen (>225HB)	300	260	395
	N4.0.C.UT		Zinkbasislegierungen	70	575	865

CoroDrill® 861 - GM

12-15 x DC

Zoll-Werte

Bohrerdurchmesser, Zoll f _n Zoll/U																			
.1181-.1571		.1572-.1964		.1965-.2358		.2359-.3146		.3147-.3933		.3934-.4720		.4721-.5902		.5905-.6295		.6299-.7083		.7087-.7874	
Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011	.0087	.0122	.0091	.0126	.0098	.0134
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011	.0087	.0122	.0091	.0126	.0098	.0134
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011	.0087	.0122	.0091	.0126	.0098	.0134
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0047	.0055	.0055	.0063	.0063	.0071	.0354	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0047	.0055	.0055	.0063	.0063	.0071	.0354	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083	.0083	.0091	.0087	.0094	.0094	.0102
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138

B

C

D

E

CoroDrill® 861 - GM

20-30 x DC

Zoll-Werte

				Härte Brinell	Schnittgeschwindigkeit (Vc), Fuß/min	
ISO	MC-Nr.	CMC- Nr.	Werkstoff	HB	Min.	Max.
P	P1.1.Z.AN	01.1	Unlegierter Stahl C=0.10-0.25%	125	235	460
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	235	460
	P2.2.Z.AN	02.1	Niedriglegierter Stahl Geglüht	240	190	445
	P2.5.Z.HT	02.2	Vergütet	330	190	445
	P3.0.Z.AN	03.11	Hochlegierter Stahl Geglüht	200	190	445
	P4.0.S.NS		Gesinterte Stähle	150	235	390
	P5.1.Z.AN	05.11 /15.11	Rostfreier Stahl Ferritisch/Martensitisch	200	60	355
	M	M1.0.Z.AQ	Rostfreier Stahl Austenitisch	200	60	125
		M2.0.Z.AQ	Super austenitisch Ni≥20%	200	60	110
		M3.2.Z.AQ	Austenitisch-ferritisch (Duplex)	260	60	90
K	K1.1.C.NS	07.1/07.2	Temperguss (ferritisch, perlitisch)	200	180	270
	K2.1.C.UT	08.1	Grauguss Niedrige Festigkeit	180	300	455
		K2.2.C.UT	Hohe Festigkeit	245	180	270
	K3.1.C.UT	09.1	Kugelgraphitguss Ferritisch	155	180	270
	K3.3.C.UT	09.2	Perlitisch	265	180	270
N	K5.1.C.NS		ADI	300	180	270
	N1.1.Z.UT		Aluminiumbasislegierungen Handelsüblich rein	30	635	960
		N1.2.Z.AG	AlSi Legierungen, Si ≤ 1%	100	635	960
		N1.3.C.AG	AlSi Gusslegierungen, Si > 1% und < 13%	90	215	635
		N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	130	215	320
		N2.0.C.UT				
			Magnesiumbasislegierungen	70	215	635



CoroDrill® 861 - GM

20-30 x DC

Zoll-Werte

Bohrerdurchmesser, Zoll													
.1181-.1571		.1572-.1964		.1965-.2358		.2359-.3146		.3147-.3933		.3934-.4720		.4724	
Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0016	.0028	.002	.0031	.0024	.0035	.0028	.0043	.0035	.0055	.0043	.0067	.0051	.0079
.0016	.0028	.002	.0031	.0024	.0035	.0028	.0043	.0035	.0055	.0043	.0067	.0051	.0079
.0016	.0028	.002	.0031	.0024	.0035	.0028	.0043	.0035	.0055	.0043	.0067	.0051	.0079
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114

B

C

D

E

CoroDrill® 862

Metrische Werte

ISO	MC-Nr.	CMC- Nr.	Werkstoff	Härte Brinell HB	Schnitt- geschwindigkeit (Vc), m/min		Bohrerdurchmesser, DC f _n mm/U			
					min.	max.	1.85-2.49		2.50-2.99	
							min.	max.	min.	max.
P	P1.1.Z.AN	01.1	Unlegierter Stahl C=0.1-0.25%	125	40	60	0.07	0.09	0.10	0.13
	P1.2.Z.AN	01.2		190	40	60	0.07	0.09	0.10	0.13
	P2.2.Z.AN	02.1	Niedriglegierter Stahl Geglüht	240	32	60	0.06	0.08	0.09	0.11
	P2.5.Z.HT	02.2		330	32	60	0.06	0.08	0.09	0.11
	P3.0.Z.AN	03.11	Hochlegierter Stahl Geglüht	200	32	60	0.06	0.08	0.09	0.11
	P4.0.S.NS		Gesinterte Stähle	150	40	60	0.06	0.08	0.09	0.11
M	P5.1.Z.AN	05.11/15.11	Rostfreier Stahl Ferritisch/martensitisch	200	18	60	0.03	0.07	0.04	0.1
	M1.0.Z.AQ	05.21/15.21	Rostfreier Stahl Austenitisch Super austenitisch Ni≥20% Austenitisch/ferritisch (Duplex)	200	18	26	0.02	0.04	0.03	0.05
	M2.0.Z.AQ	05.21/15.21		200	18	26	0.02	0.04	0.03	0.05
	M3.2.Z.AQ	05.52/15.52		260	18	26	0.02	0.04	0.03	0.05
	K1.1.C.NS	07.1/07.2	Temperguss Ferritisch Perlitisch	200	32	48	0.04	0.06	0.06	0.08
	K2.1.C.UT	08.1	Grauguss Niedrige Festigkeit Hohe Festigkeit	180	40	60	0.08	0.10	0.12	0.14
K	K2.2.C.UT	08.2		245	32	48	0.04	0.06	0.06	0.08
	K3.1.C.UT	09.1	Kugelgraphitguss Ferritisch Perlitisch	155	32	48	0.04	0.06	0.06	0.08
	K3.3.C.UT	09.2		265	32	48	0.04	0.06	0.06	0.08
	K4.2.C.UT		CGI	230	32	48	0.04	0.06	0.06	0.08
	K5.1.C.NS		ADI	300	32	48	0.04	0.06	0.06	0.08
	S1.0.U.AG		Warmfeste Superlegierungen Fe-basiert Ni-basiert Titan-basiert	280	12	18	0.02	0.04	0.03	0.05
S	S2.0.Z.AG	20.22		350	12	18	0.02	0.04	0.03	0.05
	S4.3.Z.AN	23.22		330	12	18	0.02	0.04	0.03	0.05
	N1.1.Z.UT		Aluminiumbasislegierungen Handelsüblich rein AlSi Legierungen, Si ≤ 1% AlSi Gusslegierungen, Si > 1% und < 13% AlSi Gusslegierungen, Si ≤ 13%	30	48	72	0.09	0.11	0.14	0.16
	N1.2.Z.AG			100	48	72	0.09	0.11	0.14	0.16
	N1.3.C.AG	30.21		90	40	60	0.09	0.11	0.14	0.16
	N1.4.C.NS			130	40	60	0.09	0.11	0.14	0.16
N	N2.0.C.UT		Magnesiumbasislegierungen	70	120	240	0.06	0.08	0.09	0.11

CoroDrill® 862

Zoll-Werte

ISO	MC-Nr.	CMC- Nr.	Werkstoff	Härte Brinell HB	Schnittgeschwindigkeit (Vc), Fuß/min		Bohrerdurchmesser, DC f _n Zoll/U			
					min.	max.	.0728-.0980		.0981-.1177	
							min.	max.	min.	max.
P	P1.1.Z.AN	01.1	Unlegierter Stahl C=0.1-0.25% C=0.25-0.55%	125	130	195	.0028	.0035	.0039	.0051
	P1.2.Z.AN	01.2		190	130	195	.0028	.0035	.0039	.0051
	P2.2.Z.AN	02.1	Niedriglegierter Stahl Geglüht Vergütet	240	105	195	.0024	.0031	.0035	.0043
	P2.5.Z.HT	02.2		330	105	195	.0024	.0031	.0035	.0043
	P3.0.Z.AN	03.11	Hochlegierter Stahl Geglüht	200	105	195	.0024	.0031	.0035	.0043
	P4.0.S.NS		Gesinterte Stähle	150	130	195	.0024	.0031	.0035	.0043
	P5.1.Z.AN	05.11 /15.11	Rostfreier Stahl Ferritisch/martensitisch	200	60	195	.0012	.0028	.0016	.0039
M	M1.0.Z.AQ	05.21/15.21	Rostfreier Stahl Austenitisch Super austenitisch Ni≥20% Austenitisch/ferritisch (Duplex)	200	60	85	.0008	.0016	.0012	.002
	M2.0.Z.AQ	05.21/15.21		200	60	85	.0008	.0016	.0012	.002
	M3.2.Z.AQ	05.52/15.52		260	60	85	.0008	.0016	.0012	.002
K	K1.1.C.NS	07.1/07.2	Temperguss Ferritisch/perlitisch	200	105	155	.0016	.0024	.0024	.0031
	K2.1.C.UT	08.1	Grauguss Niedrige Festigkeit Hohe Festigkeit	180	130	195	.0031	.0039	.0047	.0055
	K2.2.C.UT	08.2		245	105	155	.0016	.0024	.0024	.0031
	K3.1.C.UT	09.1	Kugelgraphitguss Ferritisch Perlitisch	155	105	155	.0016	.0024	.0024	.0031
	K3.3C.UT	09.2		265	105	155	.0016	.0024	.0024	.0031
	K4.2.C.UT		CGI	230	105	155	.0016	.0024	.0024	.0031
	K5.1.C.NS		ADI	300	105	155	.0016	.0024	.0024	.0031
S	S1.0.U.AG	20.22 23.22	Warmfeste Superlegierungen Fe-basiert Ni-basiert Titan-basiert	280	40	60	.0008	.0016	.0012	.002
	S2.0.Z.AG			350	40	60	.0008	.0016	.0012	.002
	S4.3.Z.AN			330	40	60	.0008	.0016	.0012	.002
N	N1.1.Z.UT	30.21	Aluminiumbasislegierungen Handelsüblich rein AlSi Legierungen, Si ≤ 1% AlSi Gusslegierungen, Si > 1% und < 13% AlSi Gusslegierungen, Si ≤ 13%	30	155	235	.0035	.0043	.0055	.0063
	N1.2.Z.AG			100	155	235	.0035	.0043	.0055	.0063
	N1.3.C.AG			90	130	195	.0035	.0043	.0055	.0063
	N1.4.C.NS			130	130	195	.0035	.0043	.0055	.0063
	N2.0.C.UT		Magnesiumbasislegierungen	70	395	785	.0024	.0031	.0035	.0043

B

C

D

E

CoroDrill® 400

Metrische Werte

ISO	MC-Nr.	Werkstoff	Schnitt- geschwindigkeit (V _c) m/min	Bohrerdurchmesser, mm					
				1.50 - 3.00	3.01 - 6.00	6.01 - 10.00	10.01 - 14.00	14.01 - 20.00	20.01 - 32.00
				Vorschub f _n mm/U (min - max)					
N	N1.1	Reinnickel	300 - 600	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.40 - 0.55	0.45 - 0.60
	N1.2	Al Si ≤1% Si	250 - 500	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60
	N1.3	Al Si Gusslegierungen, Si ≥1% und <13%	250 - 500	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60
	N1.4	Al Si Gusslegierungen, Si ≥13%	200 - 400	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60

Zoll-Werte

			Schnitt- geschwindigkeit (Vc), Fuß/min	Bohrerdurchmesser, Zoll					
				.059 - .118	.118 - .236	.236 - .394	.394 - .551	.552 - .787	.787 - 1.260
ISO	MC-Nr.	Werkstoff		Vorschub f _n Zoll/U (min - max)					
N	N1.1	Reinnickel	984 - 1968	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.2	Al Si ≤1% Si	820 - 1640	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.3	Al Si Gusslegierungen, Si ≥1% und <13%	820 - 1640	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.4	Al Si Gusslegierungen, Si ≥13%	656 - 1312	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024

Bohrertyp 4 für U/MIN DC2 und Vorschubrate DC1.

CoroDrill® 430

Metrische Werte

ISO	MC-Nr.	Werkstoff	Schnitt- geschwindigkeit (V _c) m/min	Bohrerdurchmesser, mm					
				1.50 - 3.00	3.01 - 6.00	6.01 - 10.00	10.01 - 14.00	14.01 - 20.00	20.01 - 32.00
				Vorschub f _n mm/U (min - max)					
N	N1.1	Reinnickel	300 - 600	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.40 - 0.55	0.45 - 0.60
	N1.2	Al Si ≤1% Si	250 - 500	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60
	N1.3	Al Si Gusslegierungen, Si ≥1% und <13%	250 - 500	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60
	N1.4	Al Si Gusslegierungen, Si ≥13%	200 - 400	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60

Zoll-Werte

			Schnitt- geschwindigkeit (V _c), Fuß/min	Bohrerdurchmesser, Zoll					
				.059 - .118	.118 - .236	.236 - .394	.394 - .551	.552 - .787	.787 - 1.260
ISO	MC-Nr.	Werkstoff		Vorschub f _n Zoll/U (min - max)					
N	N1.1	Reinnickel	984 - 1968	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.2	Al Si ≤1% Si	820 - 1640	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.3	Al Si Gusslegierungen, Si ≥1% und <13%	820 - 1640	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.4	Al Si Gusslegierungen, Si ≥13%	656 - 1312	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024

ALLGEMEINER HINWEIS FÜR ALLE - Programmierung erfolgt im Designprogramm

Hinweis: N1 mit PKD-Vein-Technologie für höhere Vorschübe und Schnittgeschwindigkeiten im Vergleich zu Vollhartmetall.
Hinweis: Kalkulieren Sie für Stufenbohrer die U/MIN über den größten Durchmesser & den Vorschub über den kleinsten Durchmesser
Hinweis: Bei den Bohrertypen 2,4,5 & 6 über einem Stufenverhältnis von 1.5, z.B. für einen 5.00 mm Pilotbohrer mit einem max. Durchmesser von 8.00 mm bei empfohlenen minimalen Vorschub beginnen.
Hinweis: Die Schnittgeschwindigkeit des Vollhartmetallbohrers ist beim Einsatz eines Bohrers mit Kühlschmierstoffzufuhr um 20% reduziert.
Hinweis: Vorschub und Schnittgeschwindigkeit können um bis zu 20% vom Startwert variieren.

CoroDrill® 452

Schnittgeschwindigkeitsempfehlungen

	v _c m/min	v _c Fuß/min	f _n mm/U	f _n Zoll/U
CFK	60	197	0.08	.00315
Aluminium	60	197	0.08	.00315
Titan	15	49	0.05	.00197
Rostfreier Stahl	15	49	0.05	.00197



Gewindebohren



Universell

CoroTap™ 200

Metrisch	C6-C10
Metrisch, fein	C11-C13
UNC	C14-C15
UNF	C16-C17
G	C18

CoroTap™ 300

Metrisch	C19-C26
Metrisch, fein	C27-C29
UNC	C30-C31
UNF	C33-C34
G	C36
NPT	C37
NPTF	C37

CoroTap™ 400

Metrisch	C38-C47
Metrisch, fein	C48-C49
UNC	C50
UNF	C51
EGM	C52



Optimiert

CoroTap™ 100

Metrisch	C53-C61
Metrisch, fein	C62-C66
UNC	C67-C68
UNF	C69-C70
G	C71

CoroTap™ 200

Metrisch	C72-C85
Metrisch, fein	C86-C89
MJ	C90
UNC	C91-C96
UNF	C96-C98
UNJC	C99
UNJF	C100

CoroTap™ 300

Metrisch	C101-C117
Metrisch, fein	C118-C124
MJ	C125
UNC	C126-C131
UNF	C131-C136
G	C137
NPT	C138
UNJC	C139
UNJF	C140
EGUNF	C141
EGUNJF	C142

CoroTap™ 400

Metrisch	C143-C147
Metrisch, fein	C148-C149
UNC	C150-C151
UNF	C152-C153



Kundenspezifisch

CoroTap™

CoroTap™ 100	E7
CoroTap™ 200	E7
CoroTap™ 300	E7
CoroTap™ 400	E7



CoroTap™ 100

- Gewindebohrer, gerade genutet
- Vorwiegend für kurz spanende Werkstoffe wie Gusswerkstoffe
- Sowohl für Durchgangs- als auch Grundbohrungen



CoroTap™ 300

- Gewindebohrer, spiral genutet
- Spankanal transportiert Späne aus der Bohrung
- Beste Option bei Grundbohrungen



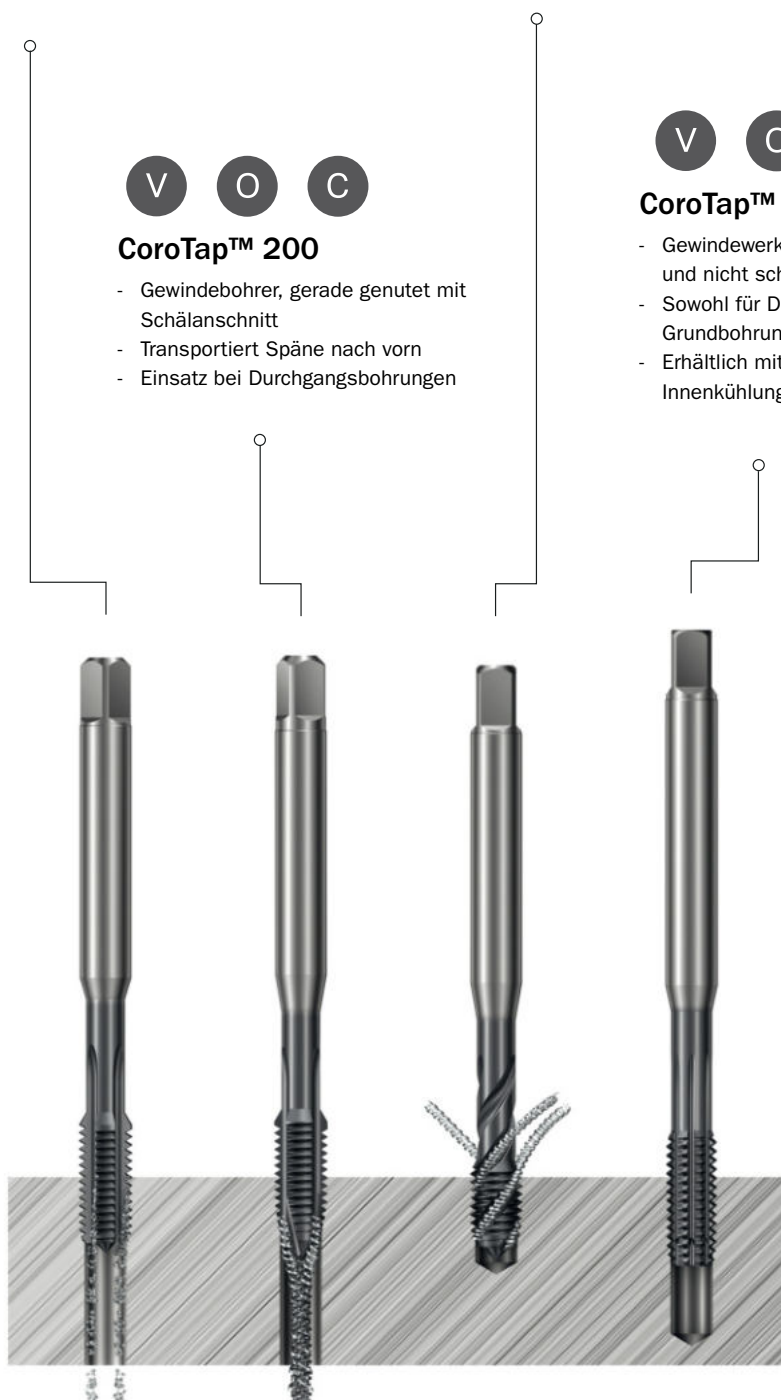
CoroTap™ 200

- Gewindebohrer, gerade genutet mit Schälanschnitt
- Transportiert Späne nach vorn
- Einsatz bei Durchgangsbohrungen



CoroTap™ 400

- Gewindewerkzeuge, die das Gewinde formen und nicht schneiden
- Sowohl für Durchgangs- als auch Grundbohrungen
- Erhältlich mit und ohne Schmiernuten sowie Innenkühlung



Universell

	Metrisch	Metrisch, fein	UNC	UNF	G	Metrisch	Metrisch	Metrisch, fein	UNC
									
CoroTap™	200	200	200	200	200	300	300	300	300
Gewindebereich	M2 - M30	M4 - M30	No.2-1", No.4-1"	No.8-1", No.4-1"	No.1/8-1"	M2 - M36	M2 - M64	M4 - M30	No.4-1", No.2-1"
ISO-Anwendungsbereich									
Durchgangs- oder Grundbohrung									
TCTR	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3, E 1.5-2	C 2-3, E 1.5-2	C 2-3, E 1.5-2
TCTR	6H, 6G	6H	2B, 3BX	2B, 3BX	NORMAL	6H, 6HX	6H, 6G	6H	2B, 3BX
ULDR	2.5-3.0 xD	2.5 xD	2.5 xD	2.5 xD	2.5 xD	1.5-2.0 x D	2.5-3.0 xD	2.5 xD	2.5 xD
Innere Kühlschmierstoffzufuhr	✗	✗	✗	✗	✗	✗	✗	✗	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓	✓	✓	✓	✓
Seite	C7-C10	C11-C13	C14-C15	C16-C17	C18	C20-C22	C23-C26	C27-C29	C30-C31

	UNF	G	NPT	NPTF	Metrisch	Metrisch, fein	UNC	UNF	Wendeschneid- platte für EGM-Gewinde
									
CoroTap™	300	300	300	300	400	400	400	400	400
Gewindebereich	No.4-1", No.8-1"	1/8-1.1/2	1/16 - 1"	1/16 - 3/4"	M1 - M24	M5 - M16	No.4 - 1"	No.10-1	EGM3 - EGM12
ISO-Anwendungsbereich									
Durchgangs- oder Grundbohrung									
TCTR	C 2-3, E 1.5-2	C 2-3	C 2-3	C 2-3	C 2-3, E 1.5-2	C 2-3	C 2-3	C 2-3	C 2-3
TCTR	2B, 3BX	NORMAL	NORMAL	NORMAL	6H, 6HX, 6GX	6HX, 6H	2B	2B	6HMOD
ULDR	2.5 xD	2.5 xD	1.5 x D	1.5 x D	3.0 - 3.5 xD	3.0 xD	3.0 xD	3.0 xD	3.0 xD
Innere Kühlschmierstoffzufuhr	✗	✗	✗	✗	✓	✗	✗	✗	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓	✓	✓	✓	✓
Seite	C33-C34	C36	C37	C37	C39-C47	C48-C49	C50	C51	C52

Optimiert

	Metrisch	Metrisch, fein	UNC	UNF	G	Metrisch	Metrisch, fein
							
CoroTap™	100	100	100	100	100	200	200
Gewindebereich	M3 - M24	M8 - M20	1/4 - 7/8	1/4 - 7/8	No.1/8-1"	M1-M30	M4 - M30
ISO-Anwendungsbereich							
Durchgangs- oder Grundbohrung							
TCTR	C 2-3, E 1.5-2	C 2-3, E 1.5-2	C 2-3, E1.5-2	C 2-3, E1.5-2	C 2-3	B 3.5-5	B 3.5-5, C 2-3
TCTR	6HX, 6H	6HX	2BX	2BX	NORMAL	6HX, 6H	6HX, 6H
ULDR	2.0-2.5 xD	2.5 xD	2.5 xD	2.5 xD	2.0 xD	2.0 - 3.0 xD	2.5 - 3.0 xD
BSG	DIN 371 DIN 376 C-DIN 371 DIN 371/ANSI DIN 376/ANSI	DIN 374 DIN 374/ANSI	DIN 2184-1/ANSI DIN 376/ANSI	DIN 2184-1/ANSI	DIN 5156	DIN 371 DIN 376 C-DIN 371 DIN/ANSI C-DIN/ANSI	DIN 371 DIN 374 DIN/ANSI
Innere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✗	✓	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓	✓	✓
Seite	C54-C61	C62-C66	C67-C68	C69-C70	C71	C73-C85	C86-C89
	MJ	UNC	UNF	UNJC	UNJF	Metrisch	Metrisch, fein
							
CoroTap™	200	200	200	200	200	300	300
Gewindebereich	M4 - M8	No.4-3/4, 1/4-1"	No.4-3/4, No.10-7/8	No.4- No.8	No.10 - 3/8", No.10 - 1/2"	M1.6-M30	M4-M30
ISO-Anwendungsbereich							
Durchgangs- oder Grundbohrung							
TCTR	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3
TCTR	4H	2BX 2B,3B	2B, 3BX	3BX	3B, 3BX	6HX, 6H	6HX, 6H
ULDR	2.0 xD	2.0 - 3.0 xD	2.0 - 2.5 xD	2.0 xD	2.0 xD	1.5 - 3.0 xD	1.5 - 3.0 xD
BSG	DIN 371	DIN/ANSI C-DIN/ANSI	DIN/ANSI	DIN/ANSI	DIN 2184-1 DIN/ANSI	C-DIN 371 DIN 371 DIN 376 DIN/ANSI	DIN 371 DIN 376 DIN/ANSI
Innere Kühlschmierstoffzufuhr	✗	✓	✗	✗	✗	✓	✗
Äußere Kühlschmierstoffzufuhr	✓	✓	✓	✓	✓	✓	✓
Seite	C90	C91-C96	C96-C98	C99	C100	C102-C117	C118-C124

Optimiert

	MJ	UNC	UNF	G	NPT	NPTF	UNJC
							
CoroTap™	300	300	300	300	300	300	300
Gewindebereich	M3 - M8	No.2-1"	No.6-1"	1/8-1"	1/16-1"	1/16-3/4	No.10 -No.8
ISO-Anwendungsbereich							
Durchgangs- oder Grundbohrung							
TCTR	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3
TCTR	4H	2B,3B, 2BX	2B,3B, 2BX	NORMAL	NORMAL	NORMAL	3B
ULDR	1.5 xD	1.5 - 3.0 xD	1.5 - 3.0 xD	2.0 x D	1.5 x D	1.5 x D	1.5 x D
BSG	DIN 371	DIN 2184-1 DIN/ANSI C-DIN/ANSI	DIN 2184-1 DIN/ANSI C-DIN/ANSI	DIN 5156	DIN/ANSI	DIN/ANSI	DIN 2184-1
Innere Kühlschmierstoffzufuhr							
Äußere Kühlschmierstoffzufuhr							
Seite	C125	C126-C131	C131-C136	C137	C138	C142	C139
	UNJF	EGUNF	EGUNJF	Metrisch	Metrisch, fein	UNC	UNF
							
CoroTap™	300	300	300	400	400	400	400
Gewindebereich	No.6 - 3/8"	No.10 - 1/4"	No.10 - 5/16"	M3-M16	M5-M16	No. 4-5/8"	No. 10-5/8"
ISO-Anwendungsbereich							
Durchgangs- oder Grundbohrung							
TCTR	C 2-3	C 2-3	C 2-3	C 2-3, E 0.5-2	C 2-3	C 2-3, E 1.5-2	C 2-3, E 1.5-2
TCTR	3B	3B	3B	6HX, 6GX	6HX	2BX	2BX
ULDR	1.5 x D	2.0 x D	1.5 x D	3.0 xD	3.0 xD	3.0 xD	3.0 xD
BSG	DIN 2184-1	DIN 2184-1	DIN 2184-1	DIN 2174 DIN/ANSI	DIN 2174	DIN/ANSI	DIN/ANSI
Innere Kühlschmierstoffzufuhr							
Äußere Kühlschmierstoffzufuhr							
Seite	C140	C141	C142	C144-C147	C148-C149	C150-C151	C152-C153

B

C

D

E

CoroTap™ 200

Anwendungen

- Nur für Durchgangsbohrungen
- In vielen Gewindeformen und -standards erhältlich
- Bis zu 3xD, abhängig vom Werkstoff



ISO-Anwendungsbereich:



Vorteile und Merkmale

- Anschnitt B (3,5-5 Steigung) für hohe Prozesssicherheit
- Schneidkantenbehandlung für reduzierte Axialkraft und geringeres Drehmoment; sorgt für einen „weicheren“ Lauf des Werkzeugs; minimiert Schneidenausbrüche und verbessert Oberflächengüte, Standzeit und Spanbildung
- Gewindebohrer aus HSS-Pulverschnellstahl für bessere Stabilität, Verschleißfestigkeit und Standzeit
- Es sind verschiedene Beschichtungen und Sorten verfügbar

- Gewindebohrer, gerade genutzt mit Schälanschnitt
- Transportiert Späne nach vorn
- Einsatz bei Durchgangsbohrungen

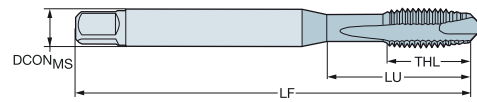
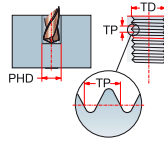


www.sandvik.coromant.com/corotap200



CoroChuck™ 970, siehe Katalog Rotierende Werkzeuge.

GER

3

C

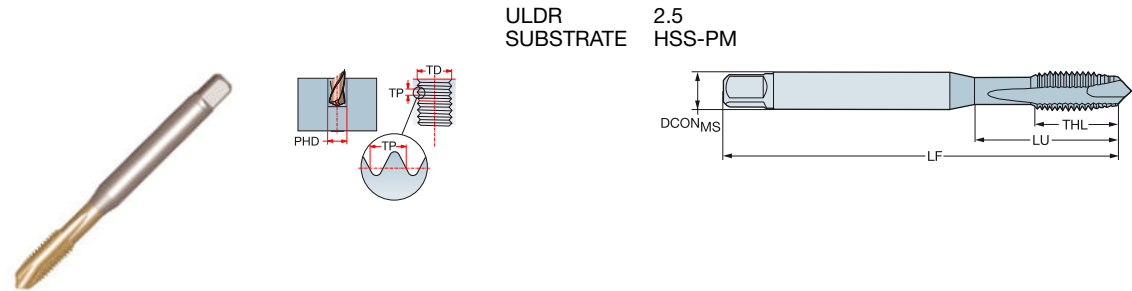
O

—



CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376



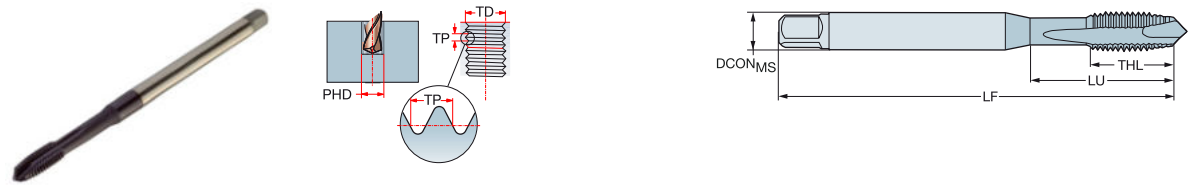
						Bestellnummer	P				M				K				N				S				Abmessungen, mm, Zoll										
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR		B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DOON _{MS}	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	18.00	3.50 x 2.70	B	6G	T200-XM104DA-M3				★	★	★				★	★	★				★	★	★				★	★	★	3.5	3.00	56.0	8.9	3	2.5	DIN 371
		.709																												.138	.118	2.205	.350		.098		
M 4	0.70	21.00	4.50 x 3.40	B	6G	T200-XM104DA-M4				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.00	63.0	12.0	3	3.3	DIN 371
		.827																												.177	.157	2.480	.472		.130		
M 5	0.80	25.00	6.00 x 4.90	B	6G	T200-XM104DA-M5				★	★	★				★	★	★				★	★	★				★	★	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371
		.984																												.236	.197	2.756	.512		.165		
M 6	1.00	30.00	6.00 x 4.90	B	6G	T200-XM104DA-M6				★	★	★				★	★	★				★	★	★				★	★	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371
		1.181																												.236	.236	3.150	.591		.197		
M 8	1.25	35.00	8.00 x 6.20	B	6G	T200-XM104DA-M8				★	★	★				★	★	★				★	★	★				★	★	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.378																												.315	.315	3.543	.709		.268		
M 10	1.50	39.00	10.00 x 8.00	B	6G	T200-XM104DA-M10				★	★	★				★	★	★				★	★	★				★	★	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.535																												.394	.394	3.937	.787		.335		
M 12	1.75	83.00	9.00 x 7.00	B	6G	T200-XM105DA-M12				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376
		3.268																												.354	.472	4.331	.906		.402		
M 16	2.00	68.00	12.00 x 9.00	B	6G	T200-XM105DA-M16				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	110.0	25.0	3	14.0	DIN 376
		2.677																												.472	.630	4.331	.984		.551		
M 20	2.50	95.00	16.00 x 12.00	B	6G	T200-XM105DA-M20	★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	140.0	30.0	4	17.5	DIN 376
		3.740																												.630	.787	5.512	1.181		.689		

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen, lange Ausführung

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR
SUBSTRATE
COATING

3.0
HSS-E
PVD TIALN

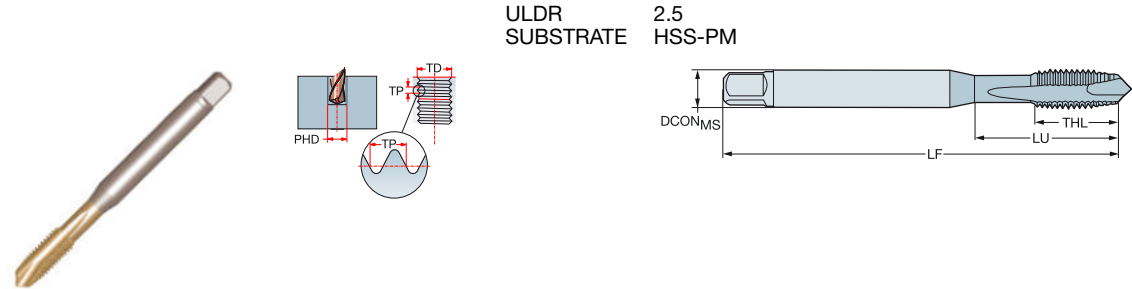


							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.00	3.50 x 2.70	B	6H	E616M3	3.5	3.00	112.0	9.0	3	DIN 371	
	.709						.138	.118	4.409	.354			
M 4	0.70	21.00	4.50 x 3.40	B	6H	E616M4	4.5	4.00	112.0	12.0	3	DIN 371	
	.827						.177	.157	4.409	.472			
M 5	0.80	25.00	6.00 x 4.90	B	6H	E616M5	6.0	5.00	125.0	13.0	3	DIN 371	
	.984						.236	.197	4.921	.512			
M 6	1.00	30.00	6.00 x 4.90	B	6H	E616M6	6.0	6.00	125.0	15.0	3	DIN 371	
	1.181						.236	.236	4.921	.591			
M 8	1.25	40.00	8.00 x 6.20	B	6H	E616M8	8.0	8.00	140.0	18.0	3	DIN 371	
	1.575						.315	.315	5.512	.709			
M 10	1.50	50.00	10.00 x 8.00	B	6H	E616M10	10.0	10.00	160.0	20.0	3	DIN 371	
	1.969						.394	.394	6.299	.787			
M 12	1.75	153.00	9.00 x 7.00	B	6H	E616M12	9.0	12.00	180.0	23.0	3	DIN 376	
	6.024						.354	.472	7.087	.906			
M 14	2.00	151.00	11.00 x 9.00	B	6H	E616M14	11.0	14.00	180.0	25.0	3	DIN 376	
	5.945						.433	.551	7.087	.984			
M 16	2.00	158.00	12.00 x 9.00	B	6H	E616M16	12.0	16.00	200.0	25.0	3	DIN 376	
	6.220						.472	.630	7.874	.984			
M 20	2.50	179.00	16.00 x 12.00	B	6H	E616M20	16.0	20.00	224.0	30.0	4	DIN 376	
	7.047						.630	.787	8.819	1.181			



CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch
DIN 371/ANSI



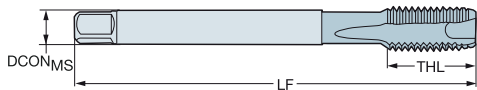
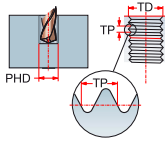
							P	M	K	N	S	Abmessungen, mm, Zoll													
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C110	C145	C150	C110	C145	C150	C110	C145	C150	C110	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
M 4	0.70	21.50 .846	.168 x .131	B	6H	T200-XM100AA-M4	*	*	*	*	*	*	*	*	*	*	*	*	4.3 .168	4.00 .157	63.0 2.480	13.6 .535	3	3.3 .130	DIN 371/ANSI
M 5	0.80	28.00 1.102	.194 x .152	B	6H	T200-XM100AA-M5	*	*	*	*	*	*	*	*	*	*	*	*	4.9 .194	5.00 .197	70.0 2.756	14.6 .575	3	4.2 .165	DIN 371/ANSI
M 6	1.00	25.00 .984	.255 x .191	B	6H	T200-XM100AA-M6	*	*	*	*	*	*	*	*	*	*	*	*	6.5 .255	6.00 .236	80.0 3.150	15.9 .626	3	5.0 .197	DIN 371/ANSI
M 8	1.25	34.00 1.339	.318 x .238	B	6H	T200-XM100AA-M8	*	*	*	*	*	*	*	*	*	*	*	*	8.1 .318	8.00 .315	90.0 3.543	18.9 .744	3	6.8 .268	DIN 371/ANSI
M 10	1.50	38.50 1.516	.381 x .286	B	6H	T200-XM100AA-M10	*	*	*	*	*	*	*	*	*	*	*	*	9.7 .381	10.00 .394	100.0 3.937	21.0 .827	3	8.5 .335	DIN 371/ANSI
M 12	1.75	81.82 3.221	.367 x .275	B	6H	T200-XM101AA-M12	*	*	*	*	*	*	*	*	*	*	*	*	9.3 .367	12.00 .472	110.0 4.331	23.1 .909	3	10.2 .402	DIN 376/ANSI
M 14	2.00	80.30 3.161	.429 x .322	B	6H	T200-XM101AA-M14	*		*		*		*		*		*		10.9 .429	14.00 .551	110.0 4.331	23.1 .909	3	12.0 .472	DIN 376/ANSI
M 16	2.00	65.78 2.590	.480 x .360	B	6H	T200-XM101AA-M16	*	*	*	*	*	*	*	*	*	*	*	*	12.2 .480	16.00 .630	110.0 4.331	23.1 .909	3	14.0 .551	DIN 376/ANSI
M 18	2.50	79.00 3.110	.542 x .406	B	6H	T200-XM101AA-M18	*	*	*	*	*	*	*	*	*	*	*	*	13.8 .542	18.00 .709	125.0 4.921	30.0 1.181	4	15.5 .610	DIN 376/ANSI
M 20	2.50	92.47 3.641	.652 x .489	B	6H	T200-XM101AA-M20	*	*	*	*	*	*	*	*	*	*	*	*	16.6 .652	20.00 .787	140.0 5.512	30.0 1.181	4	17.5 .689	DIN 376/ANSI

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch Fein

DIN 374

ULDR
SUBSTRATE 2.5
HSS-PM

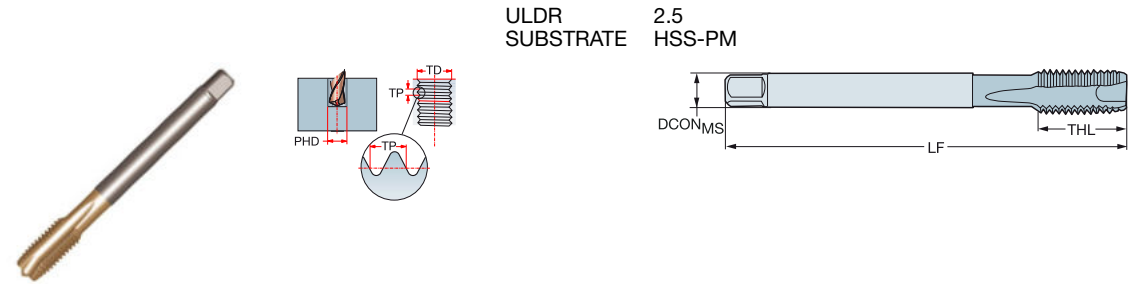


								P					M					K					N					S					Abmessungen, mm, Zoll											
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer		B10	B45	B50	C10	C45	C50	B10	B45	B50	C10	C45	C50	B10	B45	B50	C10	C45	C50	B10	B45	B50	C10	C45	C50	B10	B45	B50	C10	C45	C50	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
MF 4x0.5	0.50	43.00	2.80 x 2.10	B	6H	T200-XM100DB-M4X050					*	*	*						*	*	*				*	*	*						*	*	*	2.8	4.00	63.0	11.9	3	3.5	DIN 374		
		1.693									*	*	*					*	*	*				*	*	*						*	*	*	.110	.157	2.480	.469		.138				
MF 5x0.5	0.50	49.00	3.50 x 2.70	B	6H	T200-XM100DB-M5X050					*	*	*					*	*	*				*	*	*						*	*	*	3.5	5.00	70.0	13.2	3	4.5	DIN 374			
		1.929									*	*	*					*	*	*				*	*	*						*	*	*	.138	.197	2.766	.520		.177				
MF 6x0.75	0.75	59.00	4.50 x 3.40	B	6H	T200-XM100DB-M6X075					*	*	*					*	*	*				*	*	*						*	*	*	4.5	6.00	80.0	15.1	3	5.3	DIN 374			
		2.323									*	*	*					*	*	*				*	*	*						*	*	*	.177	.236	3.150	.594		.209				
MF 8x0.75	0.75	57.00	6.00 x 4.90	B	6H	T200-XM100DB-M8X075					*	*	*					*	*	*				*	*	*						*	*	*	6.0	8.00	80.0	14.9	3	7.3	DIN 374			
		2.244									*	*	*					*	*	*				*	*	*						*	*	*	.236	.315	3.150	.587		.287				
MF 8x1	1.00	67.00	6.00 x 4.90	B	6H	T200-XM100DB-M8X100					*	*	*					*	*	*				*	*	*						*	*	*	6.0	8.00	90.0	18.0	3	7.0	DIN 374			
		2.638									*	*	*					*	*	*				*	*	*						*	*	*	.236	.315	3.543	.709		.276				
MF 10x0.75	0.75	67.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X075					*	*	*					*	*	*				*	*	*						*	*	*	7.0	10.00	90.0	17.6	3	9.3	DIN 374			
		2.638									*	*	*					*	*	*				*	*	*						*	*	*	.276	.394	3.543	.693		.366				
MF 10x1	1.00	67.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X100					*	*	*					*	*	*				*	*	*						*	*	*	7.0	10.00	90.0	17.6	3	9.0	DIN 374			
		2.638									*	*	*					*	*	*				*	*	*						*	*	*	.276	.394	3.543	.693		.354				
MF 10x1.25	1.25	77.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X125					*	*	*					*	*	*				*	*	*						*	*	*	7.0	10.00	100.0	19.8	3	8.8	DIN 374			
		3.032									*	*	*					*	*	*				*	*	*						*	*	*	.276	.394	3.937	.780		.346				
MF 12x1	1.00	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X100					*	*	*					*	*	*				*	*	*						*	*	*	9.0	12.00	100.0	21.0	3	11.0	DIN 374			
		2.874									*	*	*					*	*	*				*	*	*						*	*	*	.354	.472	3.937	.827		.433				
MF 12x1.25	1.25	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X125					*	*	*					*	*	*				*	*	*						*	*	*	9.0	12.00	100.0	21.0	3	10.8	DIN 374			
		2.874									*	*	*					*	*	*				*	*	*						*	*	*	.354	.472	3.937	.827		.425				
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X150					*	*	*					*	*	*				*	*	*						*	*	*	9.0	12.00	100.0	21.0	3	10.5	DIN 374			
		2.874									*	*	*					*	*	*				*	*	*						*	*	*	.354	.472	3.937	.827		.413				
MF 14x1	1.00	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X100					*	*	*					*	*	*				*	*	*						*	*	*	11.0	14.00	100.0	21.0	3	13.0	DIN 374			
		2.795									*	*	*					*	*	*				*	*	*						*	*	*	.433	.551	3.937	.827		.512				
MF 14x1.25	1.25	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X125					*	*	*					*	*	*				*	*	*						*	*	*	11.0	14.00	100.0	21.0	3	12.8	DIN 374			
		2.795									*	*	*					*	*	*				*	*	*						*	*	*	.433	.551	3.937	.827		.504				
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X150					*	*	*					*	*	*				*	*	*						*	*	*	11.0	14.00	100.0	21.0	3	12.5	DIN 374			
		2.795									*	*	*					*	*	*				*	*	*						*	*	*	.433	.551	3.937	.827		.492				
MF 16x1	1.00	58.00	12.00 x 9.00	B	6H	T200-XM100DB-M16X100					*	*	*					*	*	*				*	*	*						*	*	*	12.0	16.00	100.0	21.0	3	15.0	DIN 374			
		2.283									*	*	*					*	*	*				*	*	*						*	*	*	.472	.630	3.937	.827		.591				
MF 16x1.5	1.50	58.00	12.00 x 9.00	B	6H	T200-XM100DB-M16X150					*	*	*					*	*	*				*	*	*						*	*	*	12.0	16.00	100.0	21.0	3	14.5	DIN 374			
		2.283									*	*	*					*	*	*				*	*	*						*	*	*	.472	.630	3.937	.827		.571				
MF 18x1	1.00	66.00	14.00 x 11.00	B	6H	T200-XM100DB-M18X100		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	14.0	18.00	110.0	24.0	4	17.0	DIN 374		
		2.598						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.551	.709	4.331	.945		.669				
MF 18x1.5	1.50	66.00	14.00 x 11.00	B	6H	T200-XM100DB-M18X150		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	14.0	18.00	110.0	24.0	4	16.5	DIN 374		
		2.598						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.551	.709	4.331	.945		.650				
MF 20x1	1.00	80.00	16.00 x 12.00	B	6H	T200-XM100DB-M20X100		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	16.0	20.00	125.0	24.0	4	19.0	DIN 374		
		3.150						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.630	.787	4.921	.945		.748				
MF 20x1.5	1.50	80.00	16.00 x 12.00	B	6H	T200-XM100DB-M20X150		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	16.0	20.00	125.0	24.0	4	18.5	DIN 374		
		3.150						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.630	.787	4.921	.945		.728				
MF 22x1.5	1.50	78.00	18.00 x 14.50	B	6H	T200-XM100DB-M22X150		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	18.0	22.00	125.0	25.0	4	20.5	DIN 374		
		3.071						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.709	.866	4.921	.984		.807				
MF 24x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M24X150		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	18.0	24.00	140.0	28.0	4	22.5	DIN 374		
		3.661						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.709	.945	5.512	1.102		.886				
MF 24x2	2.00	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M24X200		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	18.0	24.00	140.0	28.0	4	22.0	DIN 374		
		3.661						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.709	.945	5.512	1.102		.866				
MF 25x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M25X150		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	18.0	25.00	140.0	28.0	4	23.5	DIN 374		
		3.661						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.709	.984	5.512	1.102		.925				
MF 26x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M26X150		*	*	*					*	*	*					*	*	*					*	*	*		*	*	*	18.0	26.00	140.0	28.0	4	24.5	DIN 374		
		3.661						*	*	*					*	*	*					*	*	*					*	*	*		*	*	.709	1.024	5.512	1.102		.965				
MF 27x1.5	1.50	77.00	20.00 x 16.00	B	6H	T200-XM100DB-M27X150		*	*						*	*						*	*						*	*			*	*	*	20.0	27.00	140.0	28.0	4	25.5	DIN 374		
		3.032						*	*						*	*						*	*						*	*			*	*	.787	1.063	5.512	1.102		1.004				
MF 27x2	2																																											

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch Fein

DIN 374



						Bestellnummer	P						M				K				N				S				Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR		B10	B145	B150	C110	C145	C160	B10	B145	B150	C110	C145	C160	B10	B145	B150	C110	C145	C160	B10	B145	B150	C110	C145	C160	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
MF 28x1.5	1.50	77.00	20.00 x 16.00	B	6H	T200-XM100DB-M28X150	*						*						*						*							20.0	28.00	140.0	28.0	4	26.5	DIN 374
		3.032																														.787	1.102	5.512	1.102		1.043	
MF 30x1.5	1.50	85.00	22.00 x 18.00	B	6H	T200-XM100DB-M30X150	*	*	*				*	*	*				*	*	*				*	*	*					22.0	30.00	150.0	28.0	4	28.5	DIN 374
		3.346																														.866	1.181	5.906	1.102		1.122	
MF 30x2	2.00	85.00	22.00 x 18.00	B	6H	T200-XM100DB-M30X200	*	*	*				*	*	*				*	*	*				*	*	*					22.0	30.00	150.0	28.0	4	28.0	DIN 374
		3.346																														.866	1.181	5.906	1.102		1.102	

C

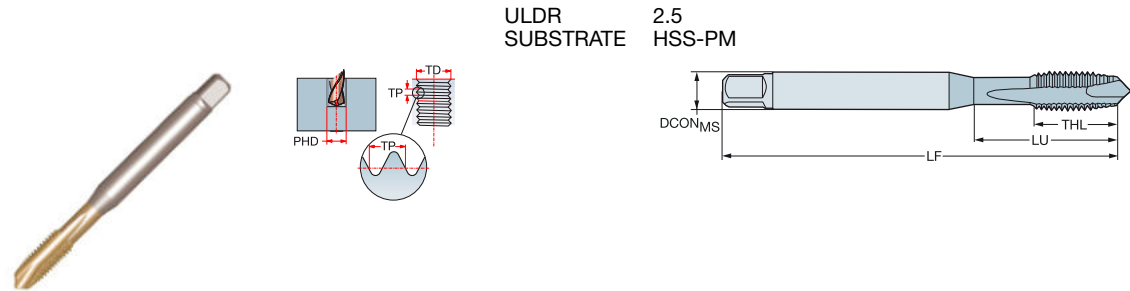
D

E

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch Fein

DIN 374/ANSI



							P	M	K	N	S	Abmessungen, mm, Zoll													
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C10	C145	C160	C10	C145	C160	C10	C145	C160	C10	C145	C160	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
MF 8x1	1.00	34.00	.318 x .238	B	6H	T200-XM100AB-M8X100	★		★	★		★	★	★		★	★	★	8.1	8.00	90.0	18.7	3	7.0	DIN 374/ANSI
		1.339																	.318	.315	3.543	.736		.276	
MF 10x1	1.00	37.50	.381 x .286	B	6H	T200-XM100AB-M10X100	★	★	★	★	★	★	★	★	★	★	★	★	9.7	10.00	90.0	18.0	3	9.0	DIN 374/ANSI
		1.476																	.381	.394	3.543	.709		.354	
MF 14x1.5	1.50	70.30	.429 x .322	B	6H	T200-XM101AB-M14X150		★	★		★	★		★	★		★	★	10.9	14.00	100.0	21.1	3	12.5	DIN 374/ANSI
		2.768																	.429	.551	3.937	.831		.492	
MF 18x1.5	1.50	64.00	.542 x .406	B	6H	T200-XM101AB-M18X150	★			★		★		★			★		13.8	18.00	110.0	23.9	4	16.5	DIN 374/ANSI
		2.520																	.542	.709	4.331	.941		.650	

C162

PHD/PHDX

C157

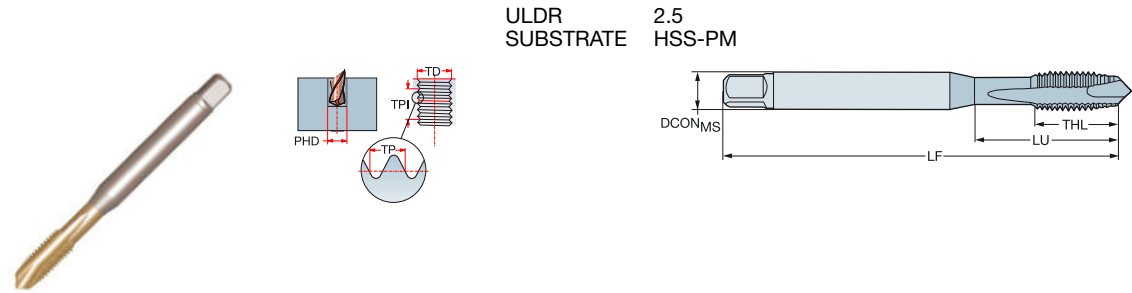
E9

E27

C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNC
DIN 2184-1

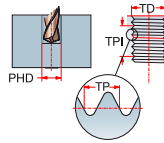


						Bestellnummer	P					M					K					N					S					Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR		B10	B145	C110	C145	C150	B10	B145	C110	C145	C150	B10	B145	C110	C145	C150	B10	B145	C110	C145	C150	B10	B145	C110	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	18.00	3.50 x 2.70	B	2B	T200-XM100DE-4-40			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	3.5	2.84	56.0	8.5	3	2.4	DIN 2184-1
	.709																														.138	.112	2.205	.335		.093		
UNC #5-40	40.00	18.00	3.50 x 2.70	B	2B	T200-XM100DE-5-40			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	3.5	3.18	56.0	9.5	3	2.7	DIN 2184-1
	.709																														.138	.125	2.205	.374		.104		
UNC #6-32	32.00	20.00	4.00 x 3.00	B	2B	T200-XM100DE-6-32			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	4.0	3.51	56.0	10.4	3	2.9	DIN 2184-1
	.787																														.157	.138	2.205	.409		.112		
UNC #8-32	32.00	21.00	4.50 x 3.40	B	2B	T200-XM100DE-8-32			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	4.5	4.17	63.0	11.4	3	3.5	DIN 2184-1
	.827																														.177	.164	2.480	.449		.138		
UNC #10-24	24.00	25.00	6.00 x 4.90	B	2B	T200-XM100DE-10-24			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	6.0	4.83	70.0	13.0	3	3.9	DIN 2184-1
	.984																														.236	.190	2.756	.512		.154		
UNC #12-24	24.00	30.00	6.00 x 4.90	B	2B	T200-XM100DE-12-24			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	6.0	5.49	80.0	15.0	3	4.5	DIN 2184-1
	1.181																														.236	.216	3.150	.591		.177		
UNC 1/4-20	20.00	30.00	7.00 x 5.50	B	2B	T200-XM100DE-1/4			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	7.0	6.35	80.0	14.1	3	5.1	DIN 2184-1
	1.181																														.276	.250	3.150	.555		.201		
UNC 5/16-18	18.00	35.00	8.00 x 6.20	B	2B	T200-XM100DE-5/16			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	8.0	7.94	90.0	17.4	3	6.6	DIN 2184-1
	1.378																														.315	.313	3.543	.685		.260		
UNC 3/8-16	16.00	39.00	10.00 x 8.00	B	2B	T200-XM100DE-3/8			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	10.0	9.53	100.0	18.9	3	8.0	DIN 2184-1
	1.535																														.394	.375	3.937	.744		.315		
UNC 7/16-14	14.00	76.00	8.00 x 6.20	B	2B	T200-XM101DE-7/16			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	8.0	11.11	100.0	20.0	3	9.4	DIN 2184-1
	2.992																														.315	.438	3.937	.787		.370		
UNC 1/2-13	13.00	83.00	9.00 x 7.00	B	2B	T200-XM101DE-1/2			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	9.0	12.70	110.0	23.0	3	10.8	DIN 2184-1
	3.268																														.354	.500	4.331	.906		.425		
UNC 5/8-11	11.00	68.00	12.00 x 9.00	B	2B	T200-XM101DE-5/8			*	*	*			*	*	*			*	*	*			*	*	*			*	*	*	12.0	15.88	110.0	25.0	3	13.5	DIN 2184-1
	2.677																														.472	.625	4.331	.984		.531		
UNC 3/4-10	10.00	81.00	14.00 x 11.00	B	2B	T200-XM101DE-3/4	*	*	*			*	*	*			*	*	*			*	*	*			*	*	*			14.0	19.05	125.0	30.0	4	16.5	DIN 2184-1
	3.189																														.551	.750	4.921	1.181		.650		
UNC 7/8-9	9.00	93.00	18.00 x 14.50	B	2B	T200-XM101DE-7/8	*	*	*			*	*	*			*	*	*			*	*	*			*	*	*			18.0	22.23	140.0	34.0	4	19.5	DIN 2184-1
	3.661																														.709	.875	5.512	1.339		.768		
UNC 1"-8	8.00	113.00	18.00 x 14.50	B	2B	T200-XM101DE-1	*	*	*			*	*	*			*	*	*			*	*	*			*	*	*			18.0	25.40	160.0	38.0	4	22.3	DIN 2184-1
	4.449																														.709	1.000	6.299	1.496		.876		

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNC

DIN 2184-1/ANSI

 ULDR
SUBSTRATE 2.5
HSS-PM


							P	M	K	N	S	Abmessungen, mm, Zoll													
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C10	C45	C60	C10	C45	C60	C10	C45	C60	C10	C45	C60	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
UNC #2-56	56.00	11.99	.141 x .110	B	3BX	T200-XM100AE-2-56	*	*	*	*	*	*	*	*	*	*	*	*	3.6	2.18	45.0	7.0	2	1.9	DIN 2184-1/ANSI
		.472					*	*	*	*	*	*	*	*	*	*	*	*	.141	.086	1.772	.276		.073	
UNC #4-40	40.00	17.00	.141 x .110	B	3BX	T200-XM100AE-4-40	*	*	*	*	*	*	*	*	*	*	*	*	3.6	2.84	56.0	9.5	3	2.4	DIN 2184-1/ANSI
		.689					*	*	*	*	*	*	*	*	*	*	*	*	.141	.112	2.205	.374		.093	
UNC #5-40	40.00	17.50	.141 x .110	B	3BX	T200-XM100AE-5-40	*	*	*	*	*	*	*	*	*	*	*	*	3.6	3.51	56.0	8.9	3	2.7	DIN 2184-1/ANSI
		.689					*	*	*	*	*	*	*	*	*	*	*	*	.141	.138	2.205	.350		.104	
UNC #6-32	32.00	20.50	.141 x .110	B	3BX	T200-XM100AE-6-32	*	*	*	*	*	*	*	*	*	*	*	*	3.6	3.51	56.0	11.6	3	2.9	DIN 2184-1/ANSI
		.807					*	*	*	*	*	*	*	*	*	*	*	*	.141	.138	2.205	.457		.112	
UNC #8-32	32.00	21.50	.168 x .131	B	3BX	T200-XM100AE-8-32	*	*	*	*	*	*	*	*	*	*	*	*	4.3	4.17	63.0	13.6	3	3.5	DIN 2184-1/ANSI
		.846					*	*	*	*	*	*	*	*	*	*	*	*	.168	.164	2.480	.535		.138	
UNC #10-24	24.00	28.00	.194 x .152	B	3BX	T200-XM100AE-10-24	*	*	*	*	*	*	*	*	*	*	*	*	4.9	4.83	70.0	14.8	3	3.9	DIN 2184-1/ANSI
		1.102					*	*	*	*	*	*	*	*	*	*	*	*	.194	.190	2.756	.583		.154	
UNC #12-24	24.00	29.00	.220 x .165	B	3BX	T200-XM100AE-12-24	*	*	*	*	*	*	*	*	*	*	*	*	5.6	5.49	80.0	14.0	3	4.5	DIN 2184-1/ANSI
		1.142					*	*	*	*	*	*	*	*	*	*	*	*	.220	.216	3.150	.551		.177	
UNC 1/4-20	20.00	25.00	.255 x .191	B	3BX	T200-XM100AE-1/4	*	*	*	*	*	*	*	*	*	*	*	*	6.5	6.35	80.0	15.9	3	5.1	DIN 2184-1/ANSI
		.984					*	*	*	*	*	*	*	*	*	*	*	*	.255	.250	3.150	.626		.201	
UNC 5/16-18	18.00	34.00	.318 x .238	B	3BX	T200-XM100AE-5/16	*	*	*	*	*	*	*	*	*	*	*	*	8.1	7.94	90.0	19.0	3	6.6	DIN 2184-1/ANSI
		1.339					*	*	*	*	*	*	*	*	*	*	*	*	.318	.313	3.543	.748		.260	
UNC 3/8-16	16.00	38.50	.381 x .286	B	3BX	T200-XM100AE-3/8	*	*	*	*	*	*	*	*	*	*	*	*	9.7	9.53	100.0	21.3	3	8.0	DIN 2184-1/ANSI
		1.516					*	*	*	*	*	*	*	*	*	*	*	*	.381	.375	3.937	.839		.315	
UNC 7/16-14	14.00	72.59	.323 x .242	B	3BX	T200-XM101AE-7/16	*	*	*	*	*	*	*	*	*	*	*	*	8.2	11.11	100.0	20.1	3	9.4	DIN 2184-1/ANSI
		2.858					*	*	*	*	*	*	*	*	*	*	*	*	.323	.438	3.937	.791		.370	
UNC 1/2-13	13.00	81.82	.367 x .275	B	3BX	T200-XM101AE-1/2	*	*	*	*	*	*	*	*	*	*	*	*	9.3	12.70	110.0	23.1	3	10.8	DIN 2184-1/ANSI
		3.221					*	*	*	*	*	*	*	*	*	*	*	*	.367	.500	4.331	.909		.425	
UNC 9/16-12	12.00	80.30	.429 x .322	B	3BX	T200-XM101AE-9/16	*	*	*	*	*	*	*	*	*	*	*	*	10.9	14.29	110.0	23.1	3	12.2	DIN 2184-1/ANSI
		3.161					*	*	*	*	*	*	*	*	*	*	*	*	.429	.563	4.331	.909		.480	
UNC 5/8-11	11.00	65.78	.480 x .360	B	3BX	T200-XM101AE-5/8	*	*	*	*	*	*	*	*	*	*	*	*	12.2	15.88	110.0	23.1	3	13.5	DIN 2184-1/ANSI
		2.590					*	*	*	*	*	*	*	*	*	*	*	*	.480	.625	4.331	.909		.531	
UNC 3/4-10	10.00	77.47	.590 x .442	B	3BX	T200-XM101AE-3/4	*	*	*	*	*	*	*	*	*	*	*	*	15.0	19.05	125.0	30.0	4	16.5	DIN 2184-1/ANSI
		3.050					*	*	*	*	*	*	*	*	*	*	*	*	.590	.750	4.921	1.181		.650	
UNC 7/8-9	9.00	90.95	.697 x .523	B	3BX	T200-XM101AE-7/8	*	*	*	*	*	*	*	*	*	*	*	*	17.7	22.23	140.0	34.0	4	19.5	DIN 2184-1/ANSI
		3.581					*	*	*	*	*	*	*	*	*	*	*	*	.697	.875	5.512	1.339		.768	
UNC 1"-8	8.00	95.43	.800 x .600	B	3BX	T200-XM101AE-1	*	*	*	*	*	*	*	*	*	*	*	*	20.3	25.40	160.0	36.1	4	22.3	DIN 2184-1/ANSI
		3.757					*	*	*	*	*	*	*	*	*	*	*	*	.800	1.000	6.299	1.421		.876	



C162



C157



E9

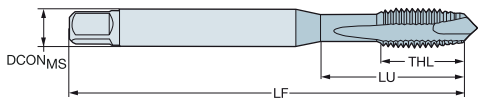


E27



C154

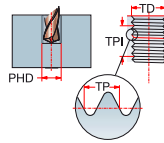
DIN 2184-1

Abmessungen, mm, Zoll

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNF

DIN 2184-1/ANSI

 ULDR
SUBSTRATE 2.5
HSS-PM


						Abmessungen, mm, Zoll																				
						P		M		K		N		S												
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C110	C145	C160	C110	C145	C160	C110	C145	C160	C110	C145	C160	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
UNF #4-48	48.00	17.00	.141 x .110	B	3BX	T200-XM100AF-4-48	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	2.84	56.0	9.4	3	2.4	DIN 2184-1/ANSI
		.669																		.141	.112	2.205	.370		.094	
UNF #6-40	40.00	20.50	.141 x .110	B	3BX	T200-XM100AF-6-40	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	3.51	56.0	11.5	3	3.0	DIN 2184-1/ANSI
		.807																		.141	.138	2.205	.453		.116	
UNF #8-36	36.00	21.50	.168 x .131	B	3BX	T200-XM100AF-8-36	*	*	*	*	*	*	*	*	*	*	*	*	*	4.3	4.17	63.0	13.5	3	3.5	DIN 2184-1/ANSI
		.846																		.168	.164	2.480	.531		.138	
UNF #10-32	32.00	28.00	.194 x .152	B	3BX	T200-XM100AF-10-32	*	*	*	*	*	*	*	*	*	*	*	*	*	4.9	4.83	70.0	14.7	3	4.1	DIN 2184-1/ANSI
		1.102																		.194	.190	2.756	.579		.161	
UNF #12-28	28.00	29.00	.220 x .165	B	3BX	T200-XM100AF-12-28	*	*	*	*	*	*	*	*	*	*	*	*	*	5.6	5.49	80.0	14.0	3	4.6	DIN 2184-1/ANSI
		1.142																		.220	.216	3.150	.551		.181	
UNF 1/4-28	28.00	25.00	.255 x .191	B	3BX	T200-XM100AF-1/4	*	*	*	*	*	*	*	*	*	*	*	*	*	6.5	6.35	80.0	15.7	3	5.5	DIN 2184-1/ANSI
		.984																		.255	.250	3.150	.618		.217	
UNF 5/16-24	24.00	34.00	.318 x .238	B	3BX	T200-XM100AF-5/16	*	*	*	*	*	*	*	*	*	*	*	*	*	8.1	7.94	90.0	18.8	3	6.9	DIN 2184-1/ANSI
		1.339																		.318	.313	3.543	.740		.272	
UNF 3/8-24	24.00	37.50	.381 x .286	B	3BX	T200-XM100AF-3/8	*	*	*	*	*	*	*	*	*	*	*	*	*	9.7	9.53	90.0	20.1	3	8.5	DIN 2184-1/ANSI
		1.476																		.381	.375	3.543	.791		.335	
UNF 7/16-20	20.00	72.59	.323 x .242	B	3BX	T200-XM101AF-7/16	*	*	*	*	*	*	*	*	*	*	*	*	*	8.2	11.11	100.0	20.1	3	9.9	DIN 2184-1/ANSI
		2.858																		.323	.438	3.937	.791		.390	
UNF 1/2-20	20.00	71.82	.367 x .275	B	3BX	T200-XM101AF-1/2	*	*	*	*	*	*	*	*	*	*	*	*	*	9.3	12.70	100.0	21.1	3	11.5	DIN 2184-1/ANSI
		2.828																		.367	.500	3.937	.831		.453	
UNF 9/16-18	18.00	70.30	.429 x .322	B	3BX	T200-XM101AF-9/16	*	*	*	*	*	*	*	*	*	*	*	*	*	10.9	14.29	100.0	21.1	3	12.9	DIN 2184-1/ANSI
		2.768																		.429	.563	3.937	.831		.508	
UNF 5/8-18	18.00	55.78	.480 x .360	B	3BX	T200-XM101AF-5/8	*	*	*	*	*	*	*	*	*	*	*	*	*	12.2	15.88	100.0	21.1	3	14.5	DIN 2184-1/ANSI
		2.196																		.480	.625	3.937	.831		.571	
UNF 3/4-16	16.00	62.47	.590 x .442	B	3BX	T200-XM101AF-3/4	*	*	*	*	*	*	*	*	*	*	*	*	*	15.0	19.05	110.0	23.9	4	17.5	DIN 2184-1/ANSI
		2.459																		.590	.750	4.331	.941		.689	
UNF 7/8-14	14.00	75.95	.697 x .523	B	3BX	T200-XM101AF-7/8	*	*	*	*	*	*	*	*	*	*	*	*	*	17.7	22.23	125.0	23.9	4	20.4	DIN 2184-1/ANSI
		2.990																		.697	.875	4.921	.941		.803	
UNF 1"-12	12.00	75.43	.800 x .600	B	3BX	T200-XM101AF-1-12	*	*	*	*	*	*	*	*	*	*	*	*	*	20.3	25.40	140.0	26.9	4	23.3	DIN 2184-1/ANSI
		2.970																		.800	1.000	5.512	1.059		.915	

B

C

D

E



C162



C157



E9



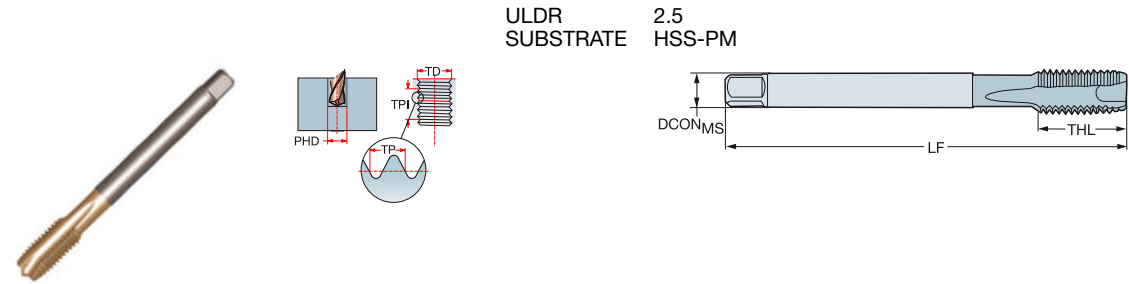
E27



C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: G
DIN 5156



							P				M				K				N				S				Abmessungen, mm, Zoll											
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	B10	B145	B150	C110	C145	C150	B10	B145	B150	C110	C145	C150	B10	B145	B150	C110	C145	C150	B10	B145	B150	C110	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
G 1/8-28	28.00	67.00	7.00 x 5.50	B	NORMAL	T200-XM100DK-1/8				*	*	*					*	*	*				*	*	*				*	*	*	7.0	9.73	90.0	18.0	3	8.8	DIN 5156
		2.638																													.276	.383	3.543	.709		.346		
G 1/4-19	19.00	71.00	11.00 x 9.00	B	NORMAL	T200-XM100DK-1/4				*	*	*					*	*	*				*	*	*				*	*	*	11.0	13.16	100.0	21.0	3	11.8	DIN 5156
		2.795																													.433	.518	3.937	.827		.465		
G 3/8-19	19.00	58.00	12.00 x 9.00	B	NORMAL	T200-XM100DK-3/8				*	*	*					*	*	*				*	*	*				*	*	*	12.0	16.66	100.0	21.0	4	15.3	DIN 5156
		2.283																													.472	.656	3.937	.827		.600		
G 1/2-14	14.00	80.00	16.00 x 12.00	B	NORMAL	T200-XM100DK-1/2	*	*	*				*	*	*		*	*	*				*	*	*	*	*	*	*	*	*	16.0	20.96	125.0	24.0	4	19.0	DIN 5156
		3.150																													.630	.825	4.921	.945		.748		
G 5/8-14	14.00	78.00	18.00 x 14.50	B	NORMAL	T200-XM100DK-5/8	*	*	*				*	*	*		*	*	*				*	*	*	*	*	*	*	*	*	18.0	22.91	125.0	24.0	4	21.0	DIN 5156
		3.071																													.709	.902	4.921	.945		.827		
G 3/4-14	14.00	77.00	20.00 x 16.00	B	NORMAL	T200-XM100DK-3/4	*	*	*				*	*	*		*	*	*				*	*	*	*	*	*	*	*	*	20.0	26.44	140.0	28.0	4	24.5	DIN 5156
		3.032																													.787	1.041	5.512	1.102		.965		
G 7/8-14	14.00	85.00	22.00 x 18.00	B	NORMAL	T200-XM100DK-7/8	*	*					*			*	*			*			*			*			*			22.0	30.20	150.0	28.0	4	28.3	DIN 5156
		3.346																													.866	1.189	5.906	1.102		1.112		
G 1"-11	11.00	93.00	25.00 x 20.00	B	NORMAL	T200-XM100DK-1	*	*	*				*	*	*		*	*	*				*	*	*	*	*	*	*	*	*	25.0	33.25	160.0	30.0	4	30.8	DIN 5156
		3.661																													.984	1.309	6.299	1.181		1.211		

CoroTap™ 300

Anwendungen

- Für Grundbohrungen geeignet
- In vielen Gewindeformen und -standards erhältlich
- Tiefen bis zu $3 \times D$



ISO-Anwendungsbereich:



Vorteile und Merkmale

- Die spiralgenutete Ausführung des Spankanals gewährleistet einen konstanten Spanwinkel und sorgt für einen gleichmäßigen Schnittvorgang
 - Anschnittinterschliff bei hochspiraligen Gewindebohrern reduziert Drehmoment und Absplitterungen
 - Gewindebohrer mit hohem Spiralwinkel bieten hervorragende Spanabfuhr und erlauben Gewindetiefen bis zu $3 \times D$ in Grundbohrungen
 - Gewindebohrer mit niedrigem Spiralwinkel verfügen über stabile Schneiden und sind zur Bearbeitung von zähen Werkstoffen ausgelegt
 - Gewindebohrer aus HSS-Pulverschnellstahl für bessere Stabilität, Verschleißfestigkeit und Standzeit
 - Vollhartmetall-Gewindebohrer für längere Standzeit und höchste Produktivität
-
- Gewindebohrer, spiral genutet
 - Spankanal transportiert Späne aus der Bohrung
 - Beste Option bei Grundbohrungen
 - Unterschiedliche Steigungswinkel für verschiedenste Anwendungen
 - Spankanal für Kühlschmierstoffzufuhr und Spanabfuhr
 - Unterschiedliche Gewindetiefen, je nach Anwendung und Geometrie



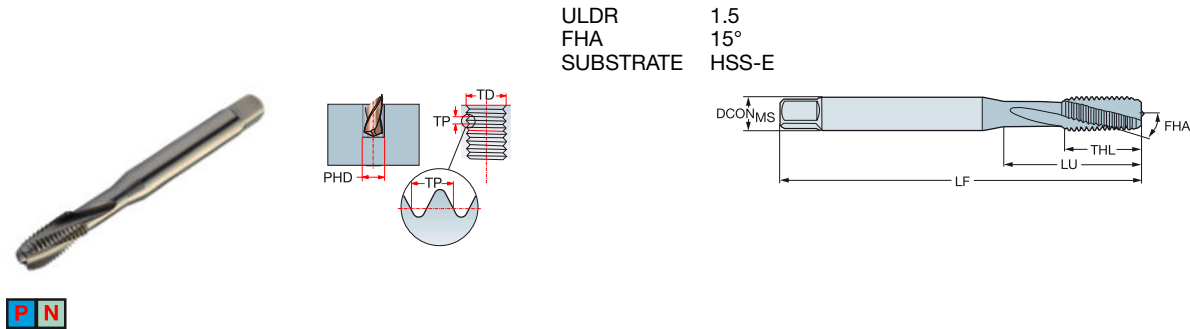
www.sandvik.coromant.com/corotap300



CoroChuck™ 970, siehe Katalog Rotierende Werkzeuge.

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376



						Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TC _{TR}	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 2	0.40	9.00	2.80 x 2.10	C	6H	E207M2	2.8	2.00	45.0	4.0	3	DIN 371
		.354					.110	.079	1.772	.157		
M 2.5	0.45	12.50	2.80 x 2.10	C	6H	E207M2.5	2.8	2.50	50.0	4.0	3	DIN 371
		.492					.110	.098	1.969	.157		
M 3	0.50	18.00	3.50 x 2.70	C	6H	E207M3	3.5	3.00	56.0	9.0	3	DIN 371
		.709					.138	.118	2.205	.354		
M 3.5	0.60	20.00	4.00 x 3.00	C	6H	E207M3.5	4.0	3.50	56.0	11.0	3	DIN 371
		.787					.157	.138	2.205	.433		
M 4	0.70	21.00	4.50 x 3.40	C	6H	E207M4	4.5	4.00	63.0	12.0	3	DIN 371
		.827					.177	.157	2.480	.472		
M 5	0.80	25.00	6.00 x 4.90	C	6H	E207M5	6.0	5.00	70.0	13.0	3	DIN 371
		.984					.236	.197	2.756	.512		
M 6	1.00	30.00	6.00 x 4.90	C	6H	E207M6	6.0	6.00	80.0	15.0	3	DIN 371
		1.181					.236	.236	3.150	.591		
M 7	1.00	30.00	7.00 x 5.50	C	6H	E207M7	7.0	7.00	80.0	15.0	3	DIN 371
		1.181					.276	.276	3.150	.591		
M 8	1.25	35.00	8.00 x 6.20	C	6H	E207M8	8.0	8.00	90.0	18.0	3	DIN 371
		1.378					.315	.315	3.543	.709		
M 10	1.50	39.00	10.00 x 8.00	C	6H	E207M10	10.0	10.00	100.0	20.1	3	DIN 371
		1.535					.394	.394	3.937	.791		
M 4	0.70	43.00	2.80 x 2.10	C	6H	E258M4	2.8	4.00	63.0	12.0	3	DIN 376
		1.693					.110	.157	2.480	.472		
M 5	0.80	49.00	3.50 x 2.70	C	6H	E258M5	3.5	5.00	70.0	13.0	3	DIN 376
		1.929					.138	.197	2.756	.512		
M 6	1.00	59.00	4.50 x 3.40	C	6H	E258M6	4.5	6.00	80.0	15.0	3	DIN 376
		2.323					.177	.236	3.150	.591		
M 8	1.25	67.00	6.00 x 4.90	C	6H	E258M8	6.0	8.00	90.0	18.0	3	DIN 376
		2.638					.236	.315	3.543	.709		
M 10	1.50	77.00	7.00 x 5.50	C	6H	E258M10	7.0	10.00	100.0	20.0	3	DIN 376
		3.032					.276	.394	3.937	.787		
M 12	1.75	83.00	9.00 x 7.00	C	6H	E258M12	9.0	12.00	110.0	23.0	3	DIN 376
		3.268					.354	.472	4.331	.906		
M 14	2.00	81.00	11.00 x 9.00	C	6H	E258M14	11.0	14.00	110.0	25.0	3	DIN 376
		3.189					.433	.551	4.331	.984		
M 16	2.00	68.00	12.00 x 9.00	C	6H	E258M16	12.0	16.00	110.0	25.0	3	DIN 376
		2.677					.472	.630	4.331	.984		
M 18	2.50	81.00	14.00 x 11.00	C	6H	E258M18	14.0	18.00	125.0	30.0	3	DIN 376
		3.189					.551	.709	4.921	1.181		
M 20	2.50	95.00	16.00 x 12.00	C	6H	E258M20	16.0	20.00	140.0	30.0	3	DIN 376
		3.740					.630	.787	5.512	1.181		
M 22	2.50	93.00	18.00 x 14.50	C	6H	E258M22	18.0	22.00	140.0	34.0	4	DIN 376
		3.661					.709	.866	5.512	1.339		
M 24	3.00	113.00	18.00 x 14.50	C	6H	E258M24	18.0	24.00	160.0	38.0	4	DIN 376
		4.449					.709	.945	6.299	1.496		
M 30	3.50	115.00	22.00 x 18.00	C	6H	E258M30	22.0	30.00	180.0	45.0	4	DIN 376
		4.528					.866	1.181	7.087	1.772		
M 36	4.00	131.00	28.00 x 22.00	C	6H	E258M36	28.0	36.00	200.0	55.0	4	DIN 376
		5.157					1.102	1.417	7.874	2.165		

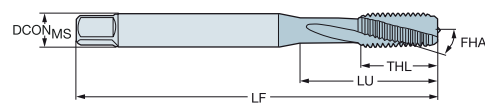
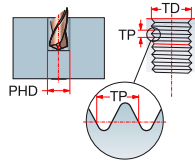
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

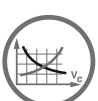
DIN 371, DIN 376

ULDR
FHA
SUBSTRATE
COATING

1.5
15°
HSS-E
PVD TIN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6H	E212M3	3.5	3.00	56.0	9.0	3	DIN 371	
	.709						.138	.118	2.205	.354			
M 4	0.70	21.00	4.50 x 3.40	C	6H	E212M4	4.5	4.00	63.0	11.0	3	DIN 371	
	.827						.177	.157	2.480	.433			
M 5	0.80	25.00	6.00 x 4.90	C	6H	E212M5	6.0	5.00	70.0	13.0	3	DIN 371	
	.984						.236	.197	2.756	.512			
M 6	1.00	30.00	6.00 x 4.90	C	6H	E212M6	6.0	6.00	80.0	15.0	3	DIN 371	
	1.181						.236	.236	3.150	.591			
M 8	1.25	35.00	8.00 x 6.20	C	6H	E212M8	8.0	8.00	90.0	18.0	3	DIN 371	
	1.378						.315	.315	3.543	.709			
M 10	1.50	39.00	10.00 x 8.00	C	6H	E212M10	10.0	10.00	100.0	20.0	3	DIN 371	
	1.535						.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	C	6H	E263M12	9.0	12.00	110.0	23.0	3	DIN 376	
	3.268						.354	.472	4.331	.906			
M 14	2.00	81.00	11.00 x 9.00	C	6H	E263M14	11.0	14.00	110.0	25.0	3	DIN 376	
	3.189						.433	.551	4.331	.984			
M 16	2.00	68.00	12.00 x 9.00	C	6H	E263M16	12.0	16.00	110.0	25.0	3	DIN 376	
	2.677						.472	.630	4.331	.984			
M 18	2.50	81.00	14.00 x 11.00	C	6H	E263M18	14.0	18.00	125.0	30.0	3	DIN 376	
	3.189						.551	.709	4.921	1.181			
M 20	2.50	95.00	16.00 x 12.00	C	6H	E263M20	16.0	20.00	140.0	30.0	3	DIN 376	
	3.740						.630	.787	5.512	1.181			
M 22	2.50	93.00	18.00 x 14.50	C	6H	E263M22	18.0	22.00	140.0	34.0	4	DIN 376	
	3.661						.709	.866	5.512	1.339			
M 24	3.00	113.00	18.00 x 14.50	C	6H	E263M24	18.0	24.00	160.0	38.0	4	DIN 376	
	4.449						.709	.945	6.299	1.496			
M 27	3.00	97.00	20.00 x 16.00	C	6H	E263M27	20.0	27.00	160.0	38.0	4	DIN 376	
	3.819						.787	1.063	6.299	1.496			
M 30	3.50	115.00	22.00 x 18.00	C	6H	E263M30	22.0	30.00	180.0	45.0	4	DIN 376	
	4.528						.866	1.181	7.087	1.772			
M 33	3.50	113.00	25.00 x 20.00	C	6H	E263M33	25.0	33.00	180.0	50.0	4	DIN 376	
	4.449						.984	1.299	7.087	1.969			
M 36	4.00	131.00	28.00 x 22.00	C	6H	E263M36	28.0	36.00	200.0	55.0	4	DIN 376	
	5.157						1.102	1.417	7.874	2.165			



C166



C157



E9



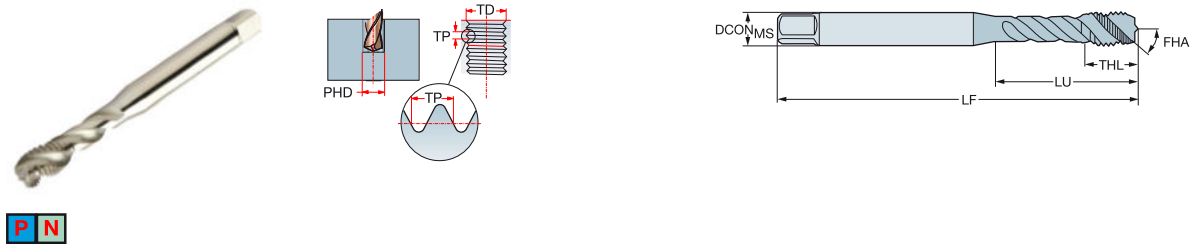
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR
FHA
SUBSTRATE

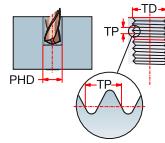
2.0
40°
HSS-E



						Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 3	0.50	18.00	3.50 x 2.70	C	6H	E195M3	3.5	3.00	56.0	5.9	3	DIN 371
		.709					.138	.118	2.205	.232		
M 4	0.70	21.00	4.50 x 3.40	C	6H	E195M4	4.5	4.00	63.0	6.7	3	DIN 371
		.827					.177	.157	2.480	.264		
M 5	0.80	25.00	6.00 x 4.90	C	6H	E195M5	6.0	5.00	70.0	7.7	3	DIN 371
		.984					.236	.197	2.756	.303		
M 6	1.00	30.00	6.00 x 4.90	C	6H	E195M6	6.0	6.00	80.0	10.0	3	DIN 371
		1.181					.236	.236	3.150	.394		
M 8	1.25	35.00	8.00 x 6.20	C	6H	E195M8	8.0	8.00	90.0	11.6	3	DIN 371
		1.378					.315	.315	3.543	.457		
M 10	1.50	39.00	10.00 x 8.00	C	6H	E195M10	10.0	10.00	100.0	15.1	3	DIN 371
		1.535					.394	.394	3.937	.594		
M 12	1.75	83.00	9.00 x 7.00	C	6H	E245M12	9.0	12.00	110.0	16.0	3	DIN 376
		3.268					.354	.472	4.331	.630		
M 14	2.00	81.00	11.00 x 9.00	C	6H	E245M14	11.0	14.00	110.0	20.0	3	DIN 376
		3.189					.433	.551	4.331	.787		
M 16	2.00	68.00	12.00 x 9.00	C	6H	E245M16	12.0	16.00	110.0	20.0	3	DIN 376
		2.677					.472	.630	4.331	.787		
M 18	2.50	81.00	14.00 x 11.00	C	6H	E245M18	14.0	18.00	125.0	25.0	4	DIN 376
		3.189					.551	.709	4.921	.984		
M 20	2.50	95.00	16.00 x 12.00	C	6H	E245M20	16.0	20.00	140.0	25.0	4	DIN 376
		3.740					.630	.787	5.512	.984		
M 22	2.50	93.00	18.00 x 14.50	C	6H	E245M22	18.0	22.00	140.0	21.5	4	DIN 376
		3.661					.709	.866	5.512	.846		
M 24	3.00	113.00	18.00 x 14.50	C	6H	E245M24	18.0	24.00	160.0	25.5	4	DIN 376
		4.449					.709	.945	6.299	1.004		
M 30	3.50	115.00	22.00 x 18.00	C	6H	E245M30	22.0	30.00	180.0	31.0	4	DIN 376
		4.528					.866	1.181	7.087	1.220		



GER

B

C

D

E



PHD/PHDX



$$\begin{bmatrix} C & 3 \\ 1 & \end{bmatrix} - \begin{bmatrix} D & C \\ 2 & 3 \end{bmatrix} = \begin{bmatrix} 1 & 1 \\ 1 & 1 \end{bmatrix}$$

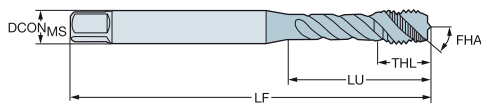
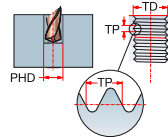

SANDVIK
Coromant

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN 371, DIN 376

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM



B

							P					M					K					N					S					Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MIS}	THCHT	TCTR	Bestellnummer	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON _{MIS}	TD	LF	THL	NOF	PHD	BSG				
M 52	5.00	120.00 4.724	40.00 x 32.00	C	6H	T300-XM101DA-M52	*	*					*	*					*	*				*	*						40.0	52.00	250.0	50.0	5	47.0	DIN 376				
M 56	5.50	120.00 4.724	40.00 x 32.00	C	6H	T300-XM101DA-M56	*	*					*	*					*	*				*	*						1.575	2.047	9.843	1.969		1.850					
M 64	6.00	178.00 7.008	50.00 x 39.00	C	6H	T300-XM101DA-M64	*						*						*					*							40.0	56.00	250.0	55.0	5	50.5	DIN 376				
M 3	0.50	18.00 .709	3.50 x 2.70	E	6H	T300-XM102DA-M3			*	*	*				*	*	*			*	*	*			*	*	*				1.575	2.205	9.843	2.165		1.988					
M 4	0.70	21.00 .827	4.50 x 3.40	E	6H	T300-XM102DA-M4			*	*	*				*	*	*			*	*	*			*	*	*				50.0	64.00	315.0	60.0	6	58.0	DIN 376				
M 5	0.80	21.00 .827	6.00 x 4.90	E	6H	T300-XM102DA-M5			*	*	*				*	*	*			*	*	*			*	*	*				1.969	2.520	12.402	2.362		2.283					
M 6	1.00	31.00 1.220	6.00 x 4.90	E	6H	T300-XM102DA-M6			*	*	*				*	*	*			*	*	*			*	*	*				3.5	3.00	56.0	5.9	3	2.5	DIN 371				
M 8	1.25	35.00 1.378	8.00 x 6.20	E	6H	T300-XM102DA-M8			*	*	*				*	*	*			*	*	*			*	*	*				.138	.118	2.205	.232		.098					
M 10	1.50	39.00 1.535	10.00 x 8.00	E	6H	T300-XM102DA-M10			*	*	*				*	*	*			*	*	*			*	*	*				4.5	4.00	63.0	6.7	3	3.3	DIN 371				
M 12	1.75	83.00 3.268	9.00 x 7.00	E	6H	T300-XM103DA-M12			*	*	*				*	*	*			*	*	*			*	*	*				.177	.157	2.480	.264		.130					
M 14	2.00	81.00 3.189	11.00 x 9.00	E	6H	T300-XM103DA-M14			*	*	*				*	*	*			*	*	*			*	*	*				6.0	5.00	70.0	7.7	3	4.2	DIN 371				
M 16	2.00	68.00 2.677	12.00 x 9.00	E	6H	T300-XM103DA-M16			*	*	*				*	*	*			*	*	*			*	*	*				.236	.197	2.756	.303		.165					
M 20	2.50	95.00 3.740	16.00 x 12.00	E	6H	T300-XM103DA-M20	*	*	*				*	*	*				*	*	*			*	*	*					6.0	6.00	80.0	10.0	3	5.0	DIN 371				
M 3	0.50	18.00 .709	3.50 x 2.70	C	6G	T300-XM104DA-M3			*	*	*				*	*	*			*	*	*			*	*	*				.236	.236	3.150	.394		.197					
M 4	0.70	21.00 .827	4.50 x 3.40	C	6G	T300-XM104DA-M4			*	*	*				*	*	*			*	*	*			*	*	*				8.0	8.00	90.0	11.6	3	6.8	DIN 371				
M 5	0.80	25.00 .984	6.00 x 4.90	C	6G	T300-XM104DA-M5			*	*	*				*	*	*			*	*	*			*	*	*				.315	.315	3.543	.457		.268					
M 6	1.00	31.00 1.220	6.00 x 4.90	C	6G	T300-XM104DA-M6			*	*	*				*	*	*			*	*	*			*	*	*				10.0	10.00	100.0	15.1	3	8.5	DIN 371				
M 8	1.25	35.00 1.378	8.00 x 6.20	C	6G	T300-XM104DA-M8			*	*	*				*	*	*			*	*	*			*	*	*				.394	.394	3.937	.594		.335					
M 10	1.50	39.00 1.535	10.00 x 8.00	C	6G	T300-XM104DA-M10			*	*	*				*	*	*			*	*	*			*	*	*				9.0	12.00	110.0	16.0	3	10.2	DIN 376				
M 12	1.75	83.00 3.268	9.00 x 7.00	C	6G	T300-XM105DA-M12			*	*	*				*	*	*			*	*	*			*	*	*				.354	.472	4.331	.630		.402					
M 14	2.00	81.00 3.189	11.00 x 9.00	C	6G	T300-XM105DA-M14			*	*	*				*	*	*			*	*	*			*	*	*				11.0	14.00	110.0	20.0	3	12.0	DIN 376				
M 16	2.00	68.00 2.677	12.00 x 9.00	C	6G	T300-XM105DA-M16			*	*	*				*	*	*			*	*	*			*	*	*				.433	.551	4.331	.787		.472					
M 20	2.50	95.00 3.740	16.00 x 12.00	C	6G	T300-XM105DA-M20	*	*	*				*	*	*				*	*	*			*	*	*					12.0	16.00	110.0	20.0	4	14.0	DIN 376				
							*	*	*				*	*	*				*	*	*			*	*	*					16.0	20.00	140.0	25.0	4	17.5	DIN 376				
																															.630	.787	5.512	.984		.689					

E



C166



C157



E9



E27



C154

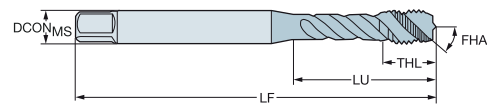
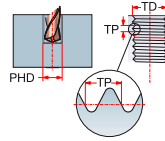
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN 371/ANSI, DIN 376/ANSI

ULDR
FHA
SUBSTRATE

2.5
45°
HSS-PM



							P		M		K		N		S		Abmessungen, mm, Zoll								
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C10	C145	C190	C10	C145	C190	C10	C145	C190	C10	C145	C190	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
M 4	0.70	21.50	.194 x .152	C	6H	T300-XM100AA-M4	*	*	*	*	*	*	*	*	*	*	*	*	4.9	4.00	63.0	8.4	3	3.3	DIN 371/ANSI
	.846																		.194	.157	2.480	.331		.130	
M 5	0.80	28.00	.194 x .152	C	6H	T300-XM100AA-M5	*	*	*	*	*	*	*	*	*	*	*	*	4.9	5.00	70.0	8.6	3	4.2	DIN 371/ANSI
	1.102																		.194	.197	2.756	.339		.165	
M 6	1.00	25.50	.255 x .191	C	6H	T300-XM100AA-M6	*	*	*	*	*	*	*	*	*	*	*	*	6.5	6.00	80.0	11.4	3	5.0	DIN 371/ANSI
	1.004																		.255	.236	3.150	.449		.197	
M 8	1.25	33.50	.318 x .238	C	6H	T300-XM100AA-M8	*	*	*	*	*	*	*	*	*	*	*	*	8.1	8.00	90.0	12.9	3	6.8	DIN 371/ANSI
	1.319																		.318	.315	3.543	.508		.268	
M 10	1.50	38.50	.381 x .286	C	6H	T300-XM100AA-M10	*	*	*	*	*	*	*	*	*	*	*	*	9.7	10.00	100.0	16.1	3	8.5	DIN 371/ANSI
	1.516																		.381	.394	3.937	.634		.335	
M 12	1.75	81.82	.367 x .275	C	6H	T300-XM101AA-M12	*	*	*	*	*	*	*	*	*	*	*	*	9.3	12.00	110.0	18.0	3	10.2	DIN 376/ANSI
	3.221																		.367	.472	4.331	.709		.402	
M 14	2.00	80.30	.429 x .322	C	6H	T300-XM101AA-M14	*	*	*	*	*	*	*	*	*	*	*	*	10.9	14.00	110.0	20.1	3	12.0	DIN 376/ANSI
	3.161																		.429	.551	4.331	.791		.472	
M 16	2.00	65.78	.480 x .360	C	6H	T300-XM101AA-M16	*	*	*	*	*	*	*	*	*	*	*	*	12.2	16.00	110.0	20.1	4	14.0	DIN 376/ANSI
	2.590																		.480	.630	4.331	.791		.551	
M 18	2.50	79.00	.542 x .406	C	6H	T300-XM101AA-M18	*	*	*	*	*	*	*	*	*	*	*	*	13.8	18.00	125.0	24.9	4	15.5	DIN 376/ANSI
	3.110																		.542	.709	4.921	.980		.610	
M 20	2.50	92.47	.652 x .489	C	6H	T300-XM101AA-M20	*	*	*	*	*	*	*	*	*	*	*	*	16.6	20.00	140.0	24.9	4	17.5	DIN 376/ANSI
	3.641																		.652	.787	5.512	.980		.689	
M 4	0.70	21.50	.168 x .131	E	6H	T300-XM102AA-M4	*	*	*	*	*	*	*	*	*	*	*	*	4.3	4.00	63.0	8.4	3	3.3	DIN 371/ANSI
	.846																		.168	.157	2.480	.331		.130	
M 5	0.80	28.00	.194 x .152	E	6H	T300-XM102AA-M5	*	*	*	*	*	*	*	*	*	*	*	*	4.9	5.00	70.0	8.6	3	4.2	DIN 371/ANSI
	1.102																		.194	.197	2.756	.339		.165	
M 6	1.00	25.50	.255 x .191	E	6H	T300-XM102AA-M6	*	*	*	*	*	*	*	*	*	*	*	*	6.5	6.00	80.0	11.4	3	5.0	DIN 371/ANSI
	1.004																		.255	.236	3.150	.449		.197	
M 8	1.25	33.50	.318 x .238	E	6H	T300-XM102AA-M8	*	*	*	*	*	*	*	*	*	*	*	*	8.1	8.00	90.0	12.9	3	6.8	DIN 371/ANSI
	1.319																		.318	.315	3.543	.508		.268	
M 10	1.50	38.50	.381 x .286	E	6H	T300-XM102AA-M10	*	*	*	*	*	*	*	*	*	*	*	*	9.7	10.00	100.0	16.1	3	8.5	DIN 371/ANSI
	1.516																		.381	.394	3.937	.634		.335	
M 12	1.75	81.82	.367 x .275	E	6H	T300-XM103AA-M12	*	*	*	*	*	*	*	*	*	*	*	*	9.3	12.00	110.0	18.0	3	10.2	DIN 376/ANSI
	3.221																		.367	.472	4.331	.709		.402	
M 14	2.00	80.30	.429 x .322	E	6H	T300-XM103AA-M14	*	*	*	*	*	*	*	*	*	*	*	*	10.9	14.00	110.0	20.1	3	12.0	DIN 376/ANSI
	3.161																		.429	.551	4.331	.791		.472	
M 16	2.00	65.78	.480 x .360	E	6H	T300-XM103AA-M16	*	*	*	*	*	*	*	*	*	*	*	*	12.2	16.00	110.0	20.1	4	14.0	DIN 376/ANSI
	2.590																		.480	.630	4.331	.791		.551	
M 18	2.50	79.00	.542 x .406	E	6H	T300-XM103AA-M18	*	*	*	*	*	*	*	*	*	*	*	*	13.8	18.00	125.0	24.9	4	15.5	DIN 376/ANSI
	3.110																		.542	.709	4.921	.980		.610	
M 20	2.50	92.47	.652 x .489	E	6H	T300-XM103AA-M20	*	*	*	*	*	*	*	*	*	*	*	*	16.6	20.00	140.0	24.9	4	17.5	DIN 376/ANSI
	3.641																		.652	.787	5.512	.980		.689	



C166



C157



E9



E27



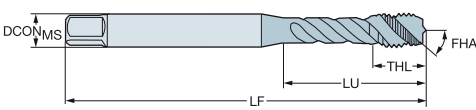
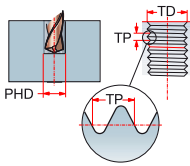
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR
FHA
SUBSTRATE
COATING

3.0
45°
HSS-E
PVD TIALN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6H	E615M3	3.5	3.00	112.0	6.0	3	DIN 371	
	.709						.138	.118	4.409	.236			
M 4	0.70	21.00	4.50 x 3.40	C	6H	E615M4	4.5	4.00	112.0	7.0	3	DIN 371	
	.827						.177	.157	4.409	.276			
M 5	0.80	25.00	6.00 x 4.90	C	6H	E615M5	6.0	5.00	125.0	8.0	3	DIN 371	
	.984						.236	.197	4.921	.315			
M 6	1.00	30.00	6.00 x 4.90	C	6H	E615M6	6.0	6.00	125.0	10.0	3	DIN 371	
	1.181						.236	.236	4.921	.394			
M 8	1.25	40.00	8.00 x 6.20	C	6H	E615M8	8.0	8.00	140.0	13.0	3	DIN 371	
	1.575						.315	.315	5.512	.512			
M 10	1.50	50.00	10.00 x 8.00	C	6H	E615M10	10.0	10.00	160.0	15.0	3	DIN 371	
	1.969						.394	.394	6.299	.591			
M 12	1.75	153.00	9.00 x 7.00	C	6H	E615M12	9.0	12.00	180.0	16.0	3	DIN 376	
	6.024						.354	.472	7.087	.630			
M 14	2.00	151.00	11.00 x 9.00	C	6H	E615M14	11.0	14.00	180.0	20.0	3	DIN 376	
	5.945						.433	.551	7.087	.787			
M 16	2.00	158.00	12.00 x 9.00	C	6H	E615M16	12.0	16.00	200.0	20.0	3	DIN 376	
	6.220						.472	.630	7.874	.787			
M 20	2.50	179.00	16.00 x 12.00	C	6H	E615M20	16.0	20.00	224.0	25.0	4	DIN 376	
	7.047						.630	.787	8.819	.984			

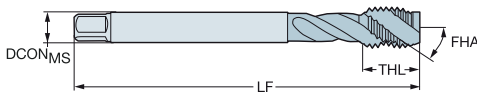
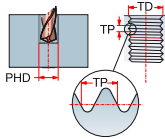


CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein

DIN 374

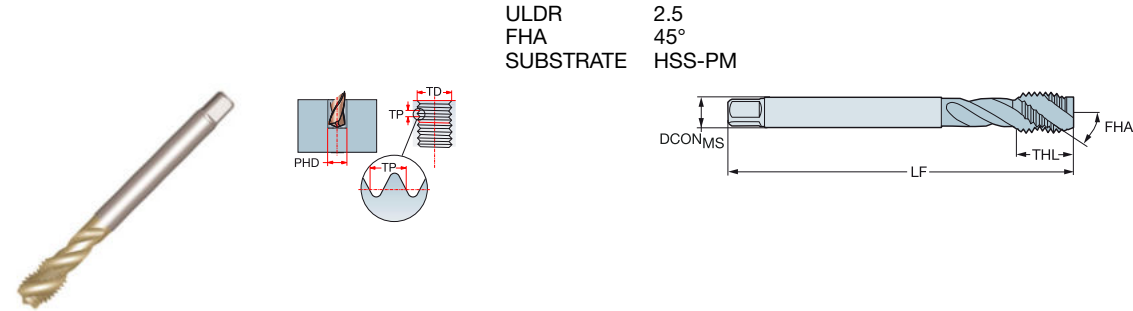
ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM



							P					M					K					N					S					Abmessungen, mm, Zoll																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
MF 4x0.5	0.50	43.00	2.80 x 2.10	C	6H	T300-XM100DB-M4X050				*	*	*				*	*	*				*	*	*							*	*	*																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein
DIN 374



						Bestellnummer	P					M				K				N				S				Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR		B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
MF 28x1.5	1.50	77.00	20.00 x 16.00	C	6H	T300-XM100DB-M28X150	*						*						*						*						20.0	28.00	140.0	20.0	4	26.5	DIN 374
		3.032																													.787	1.102	5.512	.787		1.043	
MF 30x1.5	1.50	85.00	22.00 x 18.00	C	6H	T300-XM100DB-M30X150	*	*	*				*	*	*				*	*	*				*	*	*				22.0	30.00	150.0	20.0	4	28.5	DIN 374
		3.346																													.866	1.181	5.906	.787		1.122	
MF 30x2	2.00	85.00	22.00 x 18.00	C	6H	T300-XM100DB-M30X200	*	*	*				*	*	*				*	*	*				*	*	*				22.0	30.00	150.0	20.0	4	28.0	DIN 374
		3.346																													.866	1.181	5.906	.787		1.102	

C

D

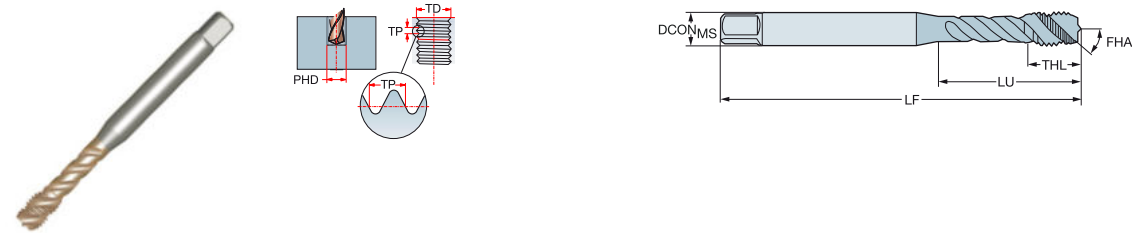
E

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein

DIN 374/ANSI

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM



																	Abmessungen, mm, Zoll						
							P		M		K		N		S								
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C10	C15	C10	C15	C10	C15	C10	C15	C10	C15	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
MF 8x1	1.00	33.50	.318 x .238	C	6H	T300-XM100AB-M8X100	*	*	*	*	*	*	*	*	*	*	8.1	8.00	90.0	12.8	3	7.0	DIN 374/ANSI
		1.319															.318	.315	3.543	.504		.276	
MF 10x1	1.00	37.50	.381 x .286	C	6H	T300-XM100AB-M10X100	*	*	*	*	*	*	*	*	*	*	9.7	10.00	90.0	13.0	3	9.0	DIN 374/ANSI
		1.476															.381	.394	3.543	.512		.354	
MF 14x1.5	1.50	70.30	.429 x .322	C	6H	T300-XM101AB-M14X150	*		*		*		*		*		10.9	14.00	100.0	15.0	3	12.5	DIN 374/ANSI
		2.768															.429	.551	3.937	.591		.492	
MF 18x1.5	1.50	64.00	.542 x .406	C	6H	T300-XM101AB-M18X150	*	*	*	*	*	*	*	*	*	*	13.8	18.00	110.0	17.0	4	16.5	DIN 374/ANSI
		2.520															.542	.709	4.331	.669		.650	
MF 8x1	1.00	33.50	.318 x .238	E	6H	T300-XM102AB-M8X100	*	*	*	*	*	*	*	*	*	*	8.1	8.00	90.0	12.8	3	7.0	DIN 374/ANSI
		1.319															.318	.315	3.543	.504		.276	
MF 10x1	1.00	37.50	.381 x .286	E	6H	T300-XM102AB-M10X100	*	*	*	*	*	*	*	*	*	*	9.7	10.00	90.0	13.0	3	9.0	DIN 374/ANSI
		1.476															.381	.394	3.543	.512		.354	
MF 14x1.5	1.50	70.30	.429 x .322	E	6H	T300-XM103AB-M14X150	*	*	*	*	*	*	*	*	*	*	10.9	14.00	100.0	15.0	3	12.5	DIN 374/ANSI
		2.768															.429	.551	3.937	.591		.492	
MF 18x1.5	1.50	64.00	.542 x .406	E	6H	T300-XM103AB-M18X150	*	*	*	*	*	*	*	*	*	*	13.8	18.00	110.0	17.0	4	16.5	DIN 374/ANSI
		2.520															.542	.709	4.331	.669		.650	

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC
DIN 2184-1

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM



							P			M			K			N			S			Abmessungen, mm, Zoll															
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	18.00	3.50 x 2.70	C	2B	T300-XM100DE-4-40				*	*	*				*	*	*				*	*	*	3.5	2.84	56.0	5.6	3	2.4	DIN 2184-1						
		.709																						.138	.112	2.205	.220		.093								
UNC #5-40	40.00	18.00	3.50 x 2.70	C	2B	T300-XM100DE-5-40				*	*	*				*	*	*				*	*	*	3.5	3.18	56.0	5.6	3	2.7	DIN 2184-1						
		.709																						.138	.125	2.205	.220		.104								
UNC #6-32	32.00	20.00	4.00 x 3.00	C	2B	T300-XM100DE-6-32				*	*	*				*	*	*				*	*	*	4.0	3.51	56.0	6.5	3	2.9	DIN 2184-1						
		.787																						.157	.138	2.205	.256		.112								
UNC #8-32	32.00	21.00	4.50 x 3.40	C	2B	T300-XM100DE-8-32				*	*	*				*	*	*				*	*	*	4.5	4.17	63.0	6.5	3	3.5	DIN 2184-1						
		.827																						.177	.164	2.480	.256		.138								
UNC #10-24	24.00	25.00	6.00 x 4.90	C	2B	T300-XM100DE-10-24				*	*	*				*	*	*				*	*	*	6.0	4.83	70.0	8.0	3	3.9	DIN 2184-1						
		.984																						.236	.190	2.756	.315		.154								
UNC #12-24	24.00	30.00	6.00 x 4.90	C	2B	T300-XM100DE-12-24				*	*	*				*	*	*				*	*	*	6.0	5.49	80.0	10.0	3	4.5	DIN 2184-1						
		1.181																						.236	.216	3.150	.394		.177								
UNC 1/4-20	20.00	30.00	7.00 x 5.50	C	2B	T300-XM100DE-1/4				*	*	*				*	*	*				*	*	*	7.0	6.35	80.0	10.0	3	5.1	DIN 2184-1						
		1.181																						.276	.250	3.150	.394		.201								
UNC 5/16-18	18.00	35.00	8.00 x 6.20	C	2B	T300-XM100DE-5/16				*	*	*				*	*	*				*	*	*	8.0	7.94	90.0	12.0	3	6.6	DIN 2184-1						
		1.378																						.315	.313	3.543	.472		.260								
UNC 3/8-16	16.00	39.00	10.00 x 8.00	C	2B	T300-XM100DE-3/8				*	*	*				*	*	*				*	*	*	10.0	9.53	100.0	15.0	3	8.0	DIN 2184-1						
		1.535																						.394	.375	3.937	.591		.315								
UNC 7/16-14	14.00	75.75	8.00 x 6.20	C	2B	T300-XM101DE-7/16				*	*	*				*	*	*				*	*	*	8.0	11.11	100.0	15.0	3	9.4	DIN 2184-1						
		2.982																						.315	.438	3.937	.591		.370								
UNC 1/2-13	13.00	82.75	9.00 x 7.00	C	2B	T300-XM101DE-1/2				*	*	*				*	*	*				*	*	*	9.0	12.70	110.0	18.0	3	10.8	DIN 2184-1						
		3.258																						.354	.500	4.331	.709		.425								
UNC 5/8-11	11.00	67.75	12.00 x 9.00	C	2B	T300-XM101DE-5/8				*	*	*				*	*	*				*	*	*	12.0	15.88	110.0	20.0	4	13.5	DIN 2184-1						
		2.667																						.472	.625	4.331	.787		.531								
UNC 3/4-10	10.00	80.75	14.00 x 11.00	C	2B	T300-XM101DE-3/4	*	*	*					*	*	*					*	*	*	14.0	19.05	125.0	25.0	4	16.5	DIN 2184-1							
		3.179																						.551	.750	4.921	.984		.650								
UNC 7/8-9	9.00	92.75	18.00 x 14.50	C	2B	T300-XM101DE-7/8	*	*	*					*	*	*					*	*	*	18.0	22.23	140.0	25.0	4	19.5	DIN 2184-1							
		3.652																						.709	.875	5.512	.984		.768								
UNC 1"-8	8.00	112.75	18.00 x 14.50	C	2B	T300-XM101DE-1	*	*	*					*	*	*					*	*	*	18.0	25.40	160.0	30.0	4	22.3	DIN 2184-1							
		4.439																						.709	1.000	6.299	1.181		.876								

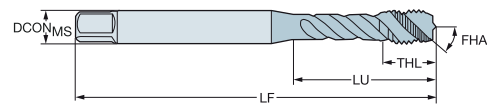
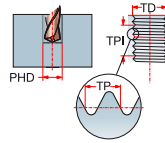
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC

DIN 2184-1/ANSI

ULDR
FHA
SUBSTRATE

2.5
48°
HSS-PM



							P		M		K		N		S		Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C10	C145	C150	C10	C145	C150	C10	C145	C150	C10	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
UNC #2-56	56.00	11.99	.141 x .110	C	3BX	T300-XM100AE-2-56	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	2.18	45.0	4.0	3	1.9	DIN 2184-1/ANSI
		.472					*	*	*	*	*	*	*	*	*	*	*	*	*	.141	.086	1.772	.157		.073	
UNC #4-40	40.00	17.50	.141 x .110	C	3BX	T300-XM100AE-4-40	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	2.84	56.0	7.1	3	2.4	DIN 2184-1/ANSI
		.689					*	*	*	*	*	*	*	*	*	*	*	*	*	.141	.112	2.205	.280		.093	
UNC #5-40	40.00	17.50	.141 x .110	C	3BX	T300-XM100AE-5-40	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	3.18	56.0	6.6	3	2.7	DIN 2184-1/ANSI
		.689					*	*	*	*	*	*	*	*	*	*	*	*	*	.141	.125	2.205	.260		.104	
UNC #6-32	32.00	20.50	.141 x .110	C	3BX	T300-XM100AE-6-32	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	3.51	56.0	7.2	3	2.9	DIN 2184-1/ANSI
		.807					*	*	*	*	*	*	*	*	*	*	*	*	*	.141	.138	2.205	.283		.112	
UNC #8-32	32.00	21.50	.168 x .131	C	3BX	T300-XM100AE-8-32	*	*	*	*	*	*	*	*	*	*	*	*	*	4.3	4.17	63.0	7.7	3	3.5	DIN 2184-1/ANSI
		.846					*	*	*	*	*	*	*	*	*	*	*	*	*	.168	.164	2.480	.303		.138	
UNC #10-24	24.00	28.00	.194 x .152	C	3BX	T300-XM100AE-10-24	*	*	*	*	*	*	*	*	*	*	*	*	*	4.9	4.83	70.0	9.1	3	3.9	DIN 2184-1/ANSI
		1.102					*	*	*	*	*	*	*	*	*	*	*	*	*	.194	.190	2.756	.358		.154	
UNC #12-24	24.00	25.50	.220 x .165	C	3BX	T300-XM100AE-12-24	*	*	*	*	*	*	*	*	*	*	*	*	*	5.6	5.49	80.0	9.9	3	4.5	DIN 2184-1/ANSI
		1.004					*	*	*	*	*	*	*	*	*	*	*	*	*	.220	.216	3.150	.390		.177	
UNC 1/4-20	20.00	25.00	.255 x .191	C	3BX	T300-XM100AE-1/4	*	*	*	*	*	*	*	*	*	*	*	*	*	6.5	6.35	80.0	11.0	3	5.1	DIN 2184-1/ANSI
		.984					*	*	*	*	*	*	*	*	*	*	*	*	*	.255	.250	3.150	.433		.201	
UNC 5/16-18	18.00	34.00	.318 x .238	C	3BX	T300-XM100AE-5/16	*	*	*	*	*	*	*	*	*	*	*	*	*	8.1	7.94	90.0	13.1	3	6.6	DIN 2184-1/ANSI
		1.339					*	*	*	*	*	*	*	*	*	*	*	*	*	.318	.313	3.543	.516		.260	
UNC 3/8-16	16.00	39.00	.381 x .286	C	3BX	T300-XM100AE-3/8	*	*	*	*	*	*	*	*	*	*	*	*	*	9.7	9.53	100.0	16.8	3	8.0	DIN 2184-1/ANSI
		1.535					*	*	*	*	*	*	*	*	*	*	*	*	*	.381	.375	3.937	.661		.315	
UNC 7/16-14	14.00	72.59	.323 x .242	C	3BX	T300-XM101AE-7/16	*	*	*	*	*	*	*	*	*	*	*	*	*	8.2	11.11	100.0	15.0	3	9.4	DIN 2184-1/ANSI
		2.858					*	*	*	*	*	*	*	*	*	*	*	*	*	.323	.438	3.937	.591		.370	
UNC 1/2-13	13.00	81.82	.367 x .275	C	3BX	T300-XM101AE-1/2	*	*	*	*	*	*	*	*	*	*	*	*	*	9.3	12.70	110.0	18.0	3	10.8	DIN 2184-1/ANSI
		3.221					*	*	*	*	*	*	*	*	*	*	*	*	*	.367	.500	4.331	.709		.425	
UNC 9/16-12	12.00	80.30	.429 x .322	C	3BX	T300-XM101AE-9/16	*	*	*	*	*	*	*	*	*	*	*	*	*	10.9	14.29	110.0	20.1	3	12.2	DIN 2184-1/ANSI
		3.161					*	*	*	*	*	*	*	*	*	*	*	*	*	.429	.563	4.331	.791		.480	
UNC 5/8-11	11.00	65.78	.480 x .360	C	3BX	T300-XM101AE-5/8	*	*	*	*	*	*	*	*	*	*	*	*	*	12.2	15.88	110.0	20.1	4	13.5	DIN 2184-1/ANSI
		2.590					*	*	*	*	*	*	*	*	*	*	*	*	*	.480	.625	4.331	.791		.531	
UNC 3/4-10	10.00	77.47	.590 x .442	C	3BX	T300-XM101AE-3/4	*	*	*	*	*	*	*	*	*	*	*	*	*	15.0	19.05	125.0	24.9	4	16.5	DIN 2184-1/ANSI
		3.050					*	*	*	*	*	*	*	*	*	*	*	*	*	.590	.750	4.921	.980		.650	
UNC 7/8-9	9.00	90.95	.697 x .523	C	3BX	T300-XM101AE-7/8	*	*	*	*	*	*	*	*	*	*	*	*	*	17.7	22.23	140.0	24.9	4	19.5	DIN 2184-1/ANSI
		3.581					*	*	*	*	*	*	*	*	*	*	*	*	*	.697	.875	5.512	.980		.768	
UNC 1"-8	8.00	95.43	.800 x .600	C	3BX	T300-XM101AE-1	*	*	*	*	*	*	*	*	*	*	*	*	*	20.3	25.40	160.0	30.0	4	22.3	DIN 2184-1/ANSI
		3.757					*	*	*	*	*	*	*	*	*	*	*	*	*	.800	1.000	6.299	1.181		.876	
UNC #2-56	56.00	15.00	.141 x .110	E	3BX	T300-XM102AE-2-56	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	2.18	45.0	4.0	3	1.9	DIN 2184-1/ANSI
		.591					*	*	*	*	*	*	*	*	*	*	*	*	*	.141	.086	1.772	.157		.073	
UNC #4-40	40.00	17.50	.141 x .110	E	3BX	T300-XM102AE-4-40	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	2.84	56.0	7.1	3	2.4	DIN 2184-1/ANSI
		.689					*	*	*	*	*	*	*	*	*	*	*	*	*	.141	.112	2.205	.280		.093	
UNC #5-40	40.00	17.50	.141 x .110	E	3BX	T300-XM102AE-5-40	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	3.18	56.0	6.6	3	2.7	DIN 2184-1/ANSI
		.689					*	*	*	*	*	*	*	*	*	*	*	*	*	.141	.125	2.205	.260		.104	
UNC #6-32	32.00	20.50	.141 x .110	E	3BX	T300-XM102AE-6-32	*	*	*	*	*	*	*	*	*	*	*	*	*	3.6	3.51	56.0	7.2	3	2.9	DIN 2184-1/ANSI
		.807					*	*	*	*	*	*	*	*	*	*	*	*	*	.141	.138	2.205	.283		.112	
UNC #8-32	32.00	21.50	.168 x .131	E	3BX	T300-XM102AE-8-32	*	*	*	*	*	*	*	*	*	*	*	*	*	4.3	4.17	63.0	7.7	3	3.5	DIN 2184-1/ANSI
		.846					*	*	*	*	*	*	*	*	*	*	*	*	*	.168	.164	2.480	.303		.138	
UNC #10-24	24.00	28.00	.194 x .152	E	3BX	T300-XM102AE-10-24	*	*	*	*	*	*	*	*	*	*	*	*	*	4.9	4.83	70.0	9.1	3	3.9	DIN 2184-1/ANSI
		1.102					*	*	*	*	*	*	*	*	*	*	*	*	*	.194	.190	2.756	.358		.154	
UNC #12-24	24.00	24.80	.255 x .191	E	3BX	T300-XM102AE-12-24	*	*	*	*	*	*	*	*	*	*	*	*	*	6.5	5.49	80.0	9.9	3	4.5	DIN 2184-1/ANSI
		.976					*	*	*	*	*	*	*	*	*	*	*	*	*	.255	.216	3.150	.390		.177	
UNC 1/4-20	20.00	25.00	.255 x .191	E	3BX	T300-XM102AE-1/4	*	*	*	*	*	*	*	*	*	*	*	*	*	6.5	6.35	80.0	11.0	3	5.1	DIN 2184-1/ANSI
		.984					*	*	*	*	*	*	*	*	*	*	*	*	*	.255	.250	3.150	.433		.201	
UNC 5/16-18	18.00	34.00	.318 x .238	E	3BX	T300-XM102AE-5/16	*	*	*	*	*	*	*	*	*	*	*	*	*	8.1	7.94	90.0	13.1	3	6.6	DIN 2184-1/ANSI
		1.339					*	*	*	*	*	*	*	*	*	*	*	*	*	.318	.313	3.543	.516		.260	
UNC 3/8-16	16.00	39.00	.381 x .286	E	3BX	T300-XM102AE-3/8	*	*	*	*	*	*	*	*	*	*	*	*	*	9.7	9.53	100.0	16.8	3	8.0	DIN 2184-1/ANSI
		1.535					*	*	*	*	*	*	*	*	*	*	*	*	*	.381	.375	3.937	.661		.315	



C166



C157



E9



E27



C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC
DIN 2184-1/ANSI

ULDR 2.5
FHA 48°
SUBSTRATE HSS-PM



							P	M	K	N	S	Abmessungen, mm, Zoll													
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	G10	G45	G150	G10	G45	G150	G10	G45	G150	G10	G45	G150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
UNC 7/16-14	14.00	72.59	.323 x .242	E	3BX	T300-XM103AE-7/16	★			★			★			★			8.2	11.11	100.0	15.0	3	9.4	DIN 2184-1/ANSI
		2.858																	.323	.438	3.937	.591		.370	
UNC 1/2-13	13.00	81.82	.367 x .275	E	3BX	T300-XM103AE-1/2	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.70	110.0	18.0	3	10.8	DIN 2184-1/ANSI
		3.221																	.367	.500	4.331	.709		.425	
UNC 9/16-12	12.00	80.30	.429 x .322	E	3BX	T300-XM103AE-9/16	★	★	★	★	★	★	★	★	★	★	★	★	10.9	14.29	110.0	20.1	3	12.2	DIN 2184-1/ANSI
		3.161																	.429	.563	4.331	.791		.480	
UNC 5/8-11	11.00	65.78	.480 x .360	E	3BX	T300-XM103AE-5/8	★	★	★	★	★	★	★	★	★	★	★	★	12.2	15.88	110.0	20.1	4	13.5	DIN 2184-1/ANSI
		2.590																	.480	.625	4.331	.791		.531	
UNC 3/4-10	10.00	77.47	.590 x .442	E	3BX	T300-XM103AE-3/4	★	★	★	★	★	★	★	★	★	★	★	★	15.0	19.05	125.0	24.9	4	16.5	DIN 2184-1/ANSI
		3.050																	.590	.750	4.921	.980		.650	
UNC 7/8-9	9.00	90.95	.697 x .523	E	3BX	T300-XM103AE-7/8	★	★	★	★	★	★	★	★	★	★	★	★	17.7	22.23	140.0	24.9	4	19.5	DIN 2184-1/ANSI
		3.581																	.697	.875	5.512	.980		.768	
UNC 1"-8	8.00	95.43	.800 x .600	E	3BX	T300-XM103AE-1	★	★	★	★	★	★	★	★	★	★	★	★	20.3	25.40	160.0	30.0	4	22.3	DIN 2184-1/ANSI
		3.757																	.800	1.000	6.299	1.181		.876	

C

D

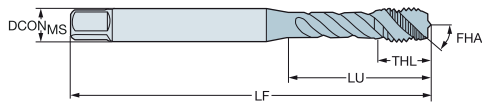
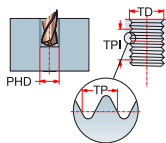
E

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNF

DIN 2184-1

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM



							P			M			K			N			S			Abmessungen, mm, Zoll																		
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG			
UNF #8-36	36.00	21.00	4.50 x 3.40	C	2B	T300-XM100DF-8-36				*	*	*					*	*	*					*	*	*					*	*	*	4.5	4.17	63.0	6.5	3	3.5	DIN 2184-1
		.827																															.177	.164	2.480	.256		.138		
UNF #10-32	32.00	25.00	6.00 x 4.90	C	2B	T300-XM100DF-10-32				*	*	*					*	*	*					*	*	*					*	*	*	6.0	4.83	70.0	7.3	3	4.1	DIN 2184-1
		.984																															.236	.190	2.756	.287		.161		
UNF 1/4-28	28.00	30.00	7.00 x 5.50	C	2B	T300-XM100DF-1/4				*	*	*					*	*	*					*	*	*					*	*	*	7.0	6.35	80.0	10.0	3	5.5	DIN 2184-1
		1.181																															.276	.250	3.150	.394		.217		
UNF 5/16-24	24.00	35.00	8.00 x 6.20	C	2B	T300-XM100DF-5/16				*	*	*					*	*	*					*	*	*					*	*	*	8.0	7.94	90.0	12.0	3	6.9	DIN 2184-1
		1.378																															.315	.313	3.543	.472		.272		
UNF 3/8-24	24.00	39.00	10.00 x 8.00	C	2B	T300-XM100DF-3/8				*	*	*					*	*	*					*	*	*					*	*	*	10.0	9.53	100.0	15.0	3	8.5	DIN 2184-1
		1.535																															.394	.375	3.937	.591		.335		
UNF 7/16-20	20.00	75.75	8.00 x 6.20	C	2B	T300-XM101DF-7/16				*	*	*					*	*	*					*	*	*					*	*	*	8.0	11.11	100.0	15.0	3	9.9	DIN 2184-1
		2.982																															.315	.438	3.937	.591		.390		
UNF 1/2-20	20.00	83.00	9.00 x 7.00	C	2B	T300-XM101DF-1/2				*	*	*					*	*	*					*	*	*					*	*	*	9.0	12.70	110.0	18.0	3	11.5	DIN 2184-1
		3.268																															.354	.500	4.331	.709		.453		
UNF 5/8-18	18.00	67.75	12.00 x 9.00	C	2B	T300-XM101DF-5/8				*	*	*					*	*	*					*	*	*					*	*	*	12.0	15.88	110.0	20.0	4	14.5	DIN 2184-1
		2.667																															.472	.625	4.331	.787		.571		
UNF 3/4-16	16.00	77.50	14.00 x 11.00	C	2B	T300-XM101DF-3/4	*	*	*				*	*	*		*	*	*				*	*	*		*	*	*		*	*	*	14.0	19.05	125.0	25.0	4	17.5	DIN 2184-1
		3.051																															.551	.750	4.921	.984		.689		
UNF 7/8-14	14.00	92.75	18.00 x 14.50	C	2B	T300-XM101DF-7/8	*	*	*				*	*	*		*	*	*				*	*	*		*	*	*		*	*	*	18.0	22.23	140.0	25.0	4	20.4	DIN 2184-1
		3.652																															.709	.875	5.512	.984		.803		
UNF 1"-12	12.00	113.00	18.00 x 14.50	C	2B	T300-XM101DF-1	*	*					*	*			*	*					*	*		*	*			*	*			18.0	25.40	160.0	30.0	4	23.3	DIN 2184-1
		4.449																															.709	1.000	6.299	1.181		.915		



C166



C157



E9



E27



C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNF
DIN 2184-1/ANSI

ULDR
FHA
SUBSTRATE

2.5
45°
HSS-PM



							P	M	K	N	S	Abmessungen, mm, Zoll											
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C10	C45	C10	C45	C10	C45	C10	C45	C10	C45	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
UNF #4-48	48.00	17.50 .689	.141 x .110	C	3BX	T300-XM100AF-4-48	*	*	*	*	*	*	*	*	*	*	3.6 .141	2.84 .112	56.0 2.205	7.1 .280	3	2.4 .094	DIN 2184-1/ANSI
UNF #6-40	40.00	20.50 .807	.141 x .110	C	3BX	T300-XM100AF-6-40	*		*		*		*		*		3.6 .141	3.51 .138	56.0 2.205	7.1 .280	3	3.0 .116	DIN 2184-1/ANSI
UNF #8-36	36.00	21.50 .846	.168 x .131	C	3BX	T300-XM100AF-8-36	*		*		*		*		*		4.3 .168	4.17 .164	63.0 2.480	7.7 .303	3	3.5 .138	DIN 2184-1/ANSI
UNF #10-32	32.00	28.00 1.102	.194 x .152	C	3BX	T300-XM100AF-10-32	*	*	*	*	*	*	*	*	*	*	4.9 .194	4.83 .190	70.0 2.756	8.9 .350	3	4.1 .161	DIN 2184-1/ANSI
UNF #12-28	28.00	31.00 1.220	.220 x .165	C	3BX	T300-XM100AF-12-28	*	*	*	*	*	*	*	*	*	*	5.6 .220	5.49 .216	80.0 3.150	9.9 .390	3	4.6 .181	DIN 2184-1/ANSI
UNF 1/4-28	28.00	25.00 .984	.255 x .191	C	3BX	T300-XM100AF-1/4	*	*	*	*	*	*	*	*	*	*	6.5 .255	6.35 .250	80.0 3.150	10.8 .425	3	5.5 .217	DIN 2184-1/ANSI
UNF 5/16-24	24.00	34.00 1.339	.318 x .238	C	3BX	T300-XM100AF-5/16	*	*	*	*	*	*	*	*	*	*	8.1 .318	7.94 .313	90.0 3.543	12.9 .508	3	6.9 .272	DIN 2184-1/ANSI
UNF 3/8-24	24.00	37.50 1.476	.381 x .286	C	3BX	T300-XM100AF-3/8	*	*	*	*	*	*	*	*	*	*	9.7 .381	9.53 .375	90.0 3.543	15.0 .591	3	8.5 .335	DIN 2184-1/ANSI
UNF 7/16-20	20.00	72.59 2.858	.367 x .275	C	3BX	T300-XM101AF-7/16	*	*	*	*	*	*	*	*	*	*	9.3 .367	11.11 .438	100.0 3.937	15.0 .591	3	9.9 .390	DIN 2184-1/ANSI
UNF 1/2-20	20.00	71.82 2.828	.367 x .275	C	3BX	T300-XM101AF-1/2	*	*	*	*	*	*	*	*	*	*	9.3 .367	12.70 .500	100.0 3.937	18.0 .709	3	11.5 .453	DIN 2184-1/ANSI
UNF 9/16-18	18.00	70.30 2.768	.429 x .322	C	3BX	T300-XM101AF-9/16	*	*	*	*	*	*	*	*	*	*	10.9 .429	14.29 .563	100.0 3.937	19.1 .752	3	12.9 .508	DIN 2184-1/ANSI
UNF 5/8-18	18.00	55.78 2.196	.480 x .360	C	3BX	T300-XM101AF-5/8	*	*	*	*	*	*	*	*	*	*	12.2 .480	15.88 .625	100.0 3.937	20.1 .791	4	14.5 .571	DIN 2184-1/ANSI
UNF 3/4-16	16.00	62.47 2.459	.590 x .442	C	3BX	T300-XM101AF-3/4	*	*	*	*	*	*	*	*	*	*	15.0 .590	19.05 .750	110.0 4.331	24.9 .980	4	17.5 .689	DIN 2184-1/ANSI
UNF 7/8-14	14.00	75.95 2.990	.697 x .523	C	3BX	T300-XM101AF-7/8	*		*		*		*		*		17.7 .697	22.23 .875	125.0 4.921	24.9 .980	4	20.4 .803	DIN 2184-1/ANSI
UNF 1"-12	12.00	75.43 2.970	.800 x .600	C	3BX	T300-XM101AF-1-12			*		*		*		*		20.3 .800	25.40 1.000	140.0 5.512	26.9 1.059	4	23.3 .915	DIN 2184-1/ANSI
UNF #4-48	48.00	17.50 .689	.141 x .110	E	3BX	T300-XM102AF-4-48		*	*		*	*	*		*	*	3.6 .141	2.84 .112	56.0 2.205	7.1 .280	3	2.4 .094	DIN 2184-1/ANSI
UNF #6-40	40.00	20.50 .807	.141 x .110	E	3BX	T300-XM102AF-6-40	*		*		*		*		*	*	3.6 .141	3.51 .138	56.0 2.205	7.1 .280	3	3.0 .116	DIN 2184-1/ANSI
UNF #8-36	36.00	21.50 .846	.168 x .131	E	3BX	T300-XM102AF-8-36	*		*		*		*		*	*	4.3 .168	4.17 .164	63.0 2.480	7.7 .303	3	3.5 .138	DIN 2184-1/ANSI
UNF #10-32	32.00	28.00 1.102	.194 x .152	E	3BX	T300-XM102AF-10-32	*	*	*	*	*	*	*	*	*	*	4.9 .194	4.83 .190	70.0 2.756	8.9 .350	3	4.1 .161	DIN 2184-1/ANSI
UNF #12-28	28.00	31.00 1.220	.220 x .165	E	3BX	T300-XM102AF-12-28	*	*	*	*	*	*	*	*	*	*	5.6 .220	5.49 .216	80.0 3.150	9.9 .390	3	4.6 .181	DIN 2184-1/ANSI
UNF 1/4-28	28.00	25.00 .984	.255 x .191	E	3BX	T300-XM102AF-1/4	*	*	*	*	*	*	*	*	*	*	6.5 .255	6.35 .250	80.0 3.150	10.8 .425	3	5.5 .217	DIN 2184-1/ANSI
UNF 5/16-24	24.00	34.00 1.339	.318 x .238	E	3BX	T300-XM102AF-5/16	*		*		*		*		*		8.1 .318	7.94 .313	90.0 3.543	12.9 .508	3	6.9 .272	DIN 2184-1/ANSI
UNF 3/8-24	24.00	37.50 1.476	.381 x .286	E	3BX	T300-XM102AF-3/8	*	*	*	*	*	*	*	*	*	*	9.7 .381	9.53 .375	90.0 3.543	15.0 .591	3	8.5 .335	DIN 2184-1/ANSI

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNF
DIN 2184-1/ANSI

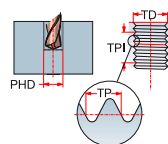
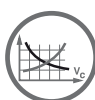
ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM



							P	M	K	N	S	Abmessungen, mm, Zoll													
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	C110	C145	C150	C110	C145	C150	C110	C145	C150	C110	C145	C150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
UNF 7/16-20	20.00	72.59	.323 x .242	E	3BX	T300-XM103AF-7/16	*	*	*	*	*	*	*	*	*	*	*	*	8.2	11.11	100.0	15.0	3	9.9	DIN 2184-1/ANSI
		2.858					*	*	*	*	*	*	*	*	*	*	*	*	.323	.438	3.937	.591		.390	
UNF 1/2-20	20.00	71.82	.367 x .275	E	3BX	T300-XM103AF-1/2	*	*	*	*	*	*	*	*	*	*	*	*	9.3	12.70	100.0	18.0	3	11.5	DIN 2184-1/ANSI
		2.828					*	*	*	*	*	*	*	*	*	*	*	*	.367	.500	3.937	.709		.453	
UNF 9/16-18	18.00	70.30	.429 x .322	E	3BX	T300-XM103AF-9/16	*	*	*	*	*	*	*	*	*	*	*	*	10.9	14.29	100.0	19.1	3	12.9	DIN 2184-1/ANSI
		2.768					*	*	*	*	*	*	*	*	*	*	*	*	.429	.563	3.937	.752		.508	
UNF 5/8-18	18.00	55.78	.480 x .360	E	3BX	T300-XM103AF-5/8	*	*		*	*	*	*	*	*	*	*	*	12.2	15.88	100.0	20.1	4	14.5	DIN 2184-1/ANSI
		2.196					*	*		*	*	*	*	*	*	*	*	*	.480	.625	3.937	.791		.571	
UNF 3/4-16	16.00	62.47	.590 x .442	E	3BX	T300-XM103AF-3/4	*		*	*	*	*	*	*	*	*	*	*	15.0	19.05	110.0	24.9	4	17.5	DIN 2184-1/ANSI
		2.459					*		*	*	*	*	*	*	*	*	*	*	.590	.750	4.331	.980		.689	
UNF 7/8-14	14.00	75.95	.697 x .523	E	3BX	T300-XM103AF-7/8	*		*	*	*	*		*	*	*	*	*	17.7	22.23	125.0	24.9	4	20.4	DIN 2184-1/ANSI
		2.990					*		*	*	*	*		*	*	*	*	*	.697	.875	4.921	.980		.803	
UNF 1"-12	12.00	75.43	.800 x .600	E	3BX	T300-XM103AF-1-12	*		*	*	*	*	*	*	*	*	*	*	20.3	25.40	140.0	26.9	4	23.3	DIN 2184-1/ANSI
		2.970					*		*	*	*	*	*	*	*	*	*	*	.800	1.000	5.512	1.059		.915	

GER

DIN 5156

C

PHD/PHDX



C 36

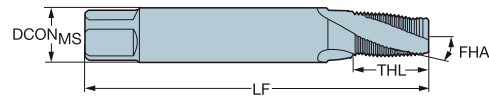
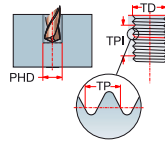


CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: NPT

DIN 2184-1/ANSI

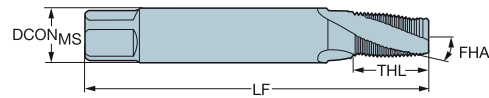
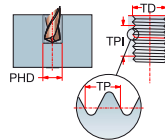
ULDR 1.5
FHA 15°
SUBSTRATE HSS-E



							P	M	K	N	S	Abmessungen, mm, Zoll							
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	B145	B145	B145	B145	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
NPT 1/16-27	27.00	56.00	.313 x .234	C	NORMAL	T300-XM100AL-1/16	*	*	*	*	*	8.0	7.72	80.0	14.0	3	6.3	DIN 2184-1/ANSI	
		2.205										.313	.304	3.150	.551		.248		
NPT 1/8-27	27.00	64.00	.437 x .328	C	NORMAL	T300-XM100AL-1/8	*	*	*	*	*	11.1	10.07	90.0	14.0	4	8.5	DIN 2184-1/ANSI	
		2.520										.437	.396	3.543	.551		.335		
NPT 1/4-18	18.00	59.00	.562 x .421	C	NORMAL	T300-XM100AL-1/4	*	*	*	*	*	14.3	13.37	100.0	20.0	4	11.0	DIN 2184-1/ANSI	
		2.323										.562	.526	3.937	.787		.433		
NPT 3/8-18	18.00	67.00	.700 x .531	C	NORMAL	T300-XM100AL-3/8	*	*	*	*	*	17.8	16.81	110.0	20.0	5	14.5	DIN 2184-1/ANSI	
		2.638										.700	.662	4.331	.787		.571		
NPT 1/2-14	14.00	79.00	.687 x .515	C	NORMAL	T300-XM100AL-1/2	*	*	*	*	*	17.4	20.95	125.0	26.0	5	18.0	DIN 2184-1/ANSI	
		3.110										.687	.825	4.921	1.024		.709		
NPT 3/4-14	14.00	78.00	.906 x .679	C	NORMAL	T300-XM100AL-3/4	*	*	*	*	*	23.0	26.29	140.0	26.0	5	23.0	DIN 2184-1/ANSI	
		3.071										.906	1.035	5.512	1.024		.906		
NPT 1-11.5	11.50	58.00	1.125 x .843	C	NORMAL	T300-XM100AL-1	*	*	*	*	*	28.6	32.91	150.0	31.0	5	29.0	DIN 2184-1/ANSI	
		2.283										1.125	1.296	5.906	1.220		1.142		

Gewindeform: NPTF

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E



							P	M	K	N	S	Abmessungen, mm, Zoll							
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	B ₁₄₅	B ₁₄₅	B ₁₄₅	B ₁₄₅	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
NPTF 1/16-27	27.00	56.00	.313 x .234	C	NORMAL	T300-XM100AM-1/16	*	*	*	*	*	8.0	7.64	80.0	14.0	3	6.2	DIN 2184-1/ANSI	
		2.205										.313	.301	3.150	.551		.244		
NPTF 1/8-27	27.00	64.00	.437 x .328	C	NORMAL	T300-XM100AM-1/8	*	*	*	*	*	11.1	9.98	90.0	14.0	4	8.4	DIN 2184-1/ANSI	
		2.520										.437	.393	3.543	.551		.331		
NPTF 1/4-18	18.00	59.00	.562 x .421	C	NORMAL	T300-XM100AM-1/4	*	*	*	*	*	14.3	13.31	100.0	20.0	4	10.9	DIN 2184-1/ANSI	
		2.323										.562	.524	3.937	.787		.429		
NPTF 3/8-18	18.00	67.00	.700 x .531	C	NORMAL	T300-XM100AM-3/8	*	*	*	*	*	17.8	16.75	110.0	20.0	5	14.3	DIN 2184-1/ANSI	
		2.638										.700	.660	4.331	.787		.561		
NPTF 1/2-14	14.00	79.00	.687 x .515	C	NORMAL	T300-XM100AM-1/2	*	*	*	*	*	17.4	20.92	125.0	26.0	5	17.8	DIN 2184-1/ANSI	
		3.110										.687	.824	4.921	1.024		.699		
NPTF 3/4-14	14.00	78.00	.906 x .679	C	NORMAL	T300-XM100AM-3/4	*	*	*	*	*	23.0	26.27	140.0	26.0	5	23.0	DIN 2184-1/ANSI	
		3.071										.906	1.034	5.512	1.024		.906		



C166



C157



E9



E27



C154

CoroTap™ 400

Anwendungen

- Sowohl für Durchgangs- als auch Grundbohrungen einsetzbar
- In vielen Gewindeformen und -standards erhältlich
- Tiefen bis zu $3.5 \times D$



ISO-Anwendungsbereich:



Vorteile und Merkmale

- Abschnitt C (2-3 Gewindegänge) und Abschnitt E (1.5-2 Gewindegänge). Abschnitt E speziell für Grundbohrungen mit wenig Freiraum
- Gewindeformer aus HSS-E für höhere Verschleißfestigkeit
- Gewindebohrer aus HSS-Pulverschnellstahl für bessere Stabilität, Verschleißfestigkeit und Standzeit
- Gewindewerkzeuge, die das Gewinde formen und nicht schneiden
- Eine spanfreie Lösung
- Nicht für alle Werkstoffe geeignet, da gewisser Grad an Duktilität erforderlich. Empfohlene maximale Zugfestigkeit ist 1200 N/mm²
- Sowohl für Durchgangs- als auch Grundbohrungen
- Erhältlich mit und ohne Schmiernuten sowie Innenkühlung



www.sandvik.coromant.com/corotap400



CoroChuck™ 970, siehe Katalog Rotierende Werkzeuge.

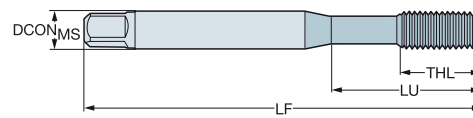
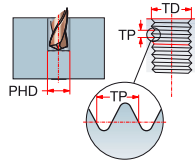
CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch

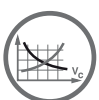
DIN 2174

ULDR
SUBSTRATE

3.0
HSS-E



						Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 1	0.25	20.00	2.50 x 2.10	C	5HX	E301M1	2.5	1.00	40.0	5.5	3	DIN 2174
		.787					.098	.039	1.575	.217		
M 1.2	0.25	20.00	2.50 x 2.10	C	5HX	E301M1.2	2.5	1.20	40.0	5.5	3	DIN 2174
		.787					.098	.047	1.575	.217		
M 1.4	0.30	20.00	2.50 x 2.10	C	5HX	E301M1.4	2.5	1.40	40.0	7.0	3	DIN 2174
		.787					.098	.055	1.575	.276		
M 1.6	0.35	20.00	2.50 x 2.10	C	6HX	E301M1.6	2.5	1.60	40.0	8.0	3	DIN 2174
		.787					.098	.063	1.575	.315		
M 1.7	0.35	20.00	2.50 x 2.10	C	6HX	E301M1.7	2.5	1.70	40.0	8.0	3	DIN 2174
		.787					.098	.067	1.575	.315		
M 1.8	0.35	20.00	2.50 x 2.10	C	6HX	E301M1.8	2.5	1.80	40.0	8.0	3	DIN 2174
		.787					.098	.071	1.575	.315		
M 2	0.40	11.00	2.80 x 2.10	C	6HX	E301M2	2.8	2.00	45.0	6.0	3	DIN 2174
		.433					.110	.079	1.772	.236		
M 2.2	0.45	12.00	2.80 x 2.10	C	6HX	E301M2.2	2.8	2.20	45.0	7.0	3	DIN 2174
		.472					.110	.087	1.772	.276		
M 2.3	0.40	12.00	2.80 x 2.10	C	6HX	E301M2.3	2.8	2.30	45.0	7.0	3	DIN 2174
		.472					.110	.091	1.772	.276		
M 2.5	0.45	14.00	2.80 x 2.10	C	6HX	E301M2.5	2.8	2.50	50.0	8.0	3	DIN 2174
		.551					.110	.098	1.969	.315		
M 2.6	0.45	14.00	2.80 x 2.10	C	6HX	E301M2.6	2.8	2.60	50.0	8.0	3	DIN 2174
		.551					.110	.102	1.969	.315		
M 3	0.50	18.00	3.50 x 2.70	C	6HX	E301M3	3.5	3.00	56.0	9.0	4	DIN 2174
		.709					.138	.118	2.205	.354		
M 3.5	0.60	20.00	4.00 x 3.00	C	6HX	E301M3.5	4.0	3.50	56.0	11.0	4	DIN 2174
		.787					.157	.138	2.205	.433		
M 4	0.70	21.00	4.50 x 3.40	C	6HX	E301M4	4.5	4.00	63.0	12.0	5	DIN 2174
		.827					.177	.157	2.480	.472		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	E301M5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					.236	.197	2.756	.512		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	E301M6	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					.236	.236	3.150	.591		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	E301M8	8.0	8.00	90.0	18.0	5	DIN 2174
		1.378					.315	.315	3.543	.709		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	E301M10	10.0	10.00	100.0	20.0	5	DIN 2174
		1.535					.394	.394	3.937	.787		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	E301M12	9.0	12.00	110.0	23.0	5	DIN 2174
		3.268					.354	.472	4.331	.906		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	E301M16	12.0	16.00	110.0	25.0	6	DIN 2174
		2.677					.472	.630	4.331	.984		
M 20	2.50	70.00	16.00 x 12.00	C	6HX	E301M20	16.0	20.00	140.0	30.0	7	DIN 2174
		2.756					.630	.787	5.512	1.181		
M 24	3.00	80.00	18.00 x 14.50	C	6HX	E301M24	18.0	24.00	160.0	36.0	8	DIN 2174
		3.150					.709	.945	6.299	1.417		



C170



C157



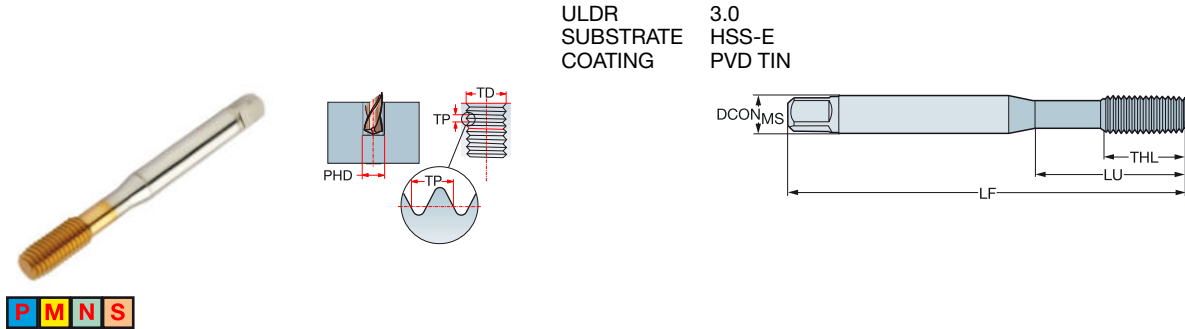
E9



C154

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
DIN 2174



C

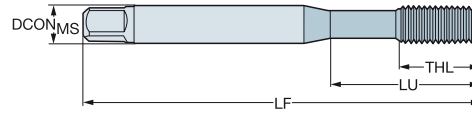
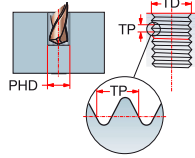
							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 1	0.25	20.00	2.50 x 2.10	C	5HX	E302M1	2.5	1.00	40.0	5.5	3	DIN 2174	
		.787					.098	.039	1.575	.217			
M 1.2	0.25	20.00	2.50 x 2.10	C	5HX	E302M1.2	2.5	1.20	40.0	5.5	3	DIN 2174	
		.787					.098	.047	1.575	.217			
M 1.4	0.30	20.00	2.50 x 2.10	C	5HX	E302M1.4	2.5	1.40	40.0	7.0	3	DIN 2174	
		.787					.098	.055	1.575	.276			
M 1.6	0.35	20.00	2.50 x 2.10	C	6HX	E302M1.6	2.5	1.60	40.0	8.0	3	DIN 2174	
		.787					.098	.063	1.575	.315			
M 1.7	0.35	20.00	2.50 x 2.10	C	6HX	E302M1.7	2.5	1.70	40.0	8.0	3	DIN 2174	
		.787					.098	.067	1.575	.315			
M 1.8	0.35	20.00	2.50 x 2.10	C	6HX	E302M1.8	2.5	1.80	40.0	8.0	3	DIN 2174	
		.787					.098	.071	1.575	.315			
M 2	0.40	11.00	2.80 x 2.10	C	6HX	E302M2	2.8	2.00	45.0	6.0	3	DIN 2174	
		.433					.110	.079	1.772	.236			
M 2.2	0.45	12.00	2.80 x 2.10	C	6HX	E302M2.2	2.8	2.20	45.0	7.0	3	DIN 2174	
		.472					.110	.087	1.772	.276			
M 2.3	0.40	12.00	2.80 x 2.10	C	6HX	E302M2.3	2.8	2.30	45.0	7.0	3	DIN 2174	
		.472					.110	.091	1.772	.276			
M 2.5	0.45	14.00	2.80 x 2.10	C	6HX	E302M2.5	2.8	2.50	50.0	8.0	3	DIN 2174	
		.551					.110	.098	1.969	.315			
M 2.6	0.45	14.00	2.80 x 2.10	C	6HX	E302M2.6	2.8	2.60	50.0	8.0	3	DIN 2174	
		.551					.110	.102	1.969	.315			
M 3	0.50	18.00	3.50 x 2.70	C	6HX	E302M3	3.5	3.00	56.0	9.0	4	DIN 2174	
		.709					.138	.118	2.205	.354			
M 3.5	0.60	20.00	4.00 x 3.00	C	6HX	E302M3.5	4.0	3.50	56.0	11.0	4	DIN 2174	
		.787					.157	.138	2.205	.433			
M 4	0.70	21.00	4.50 x 3.40	C	6HX	E302M4	4.5	4.00	63.0	12.0	5	DIN 2174	
		.827					.177	.157	2.480	.472			
M 5	0.80	25.00	6.00 x 4.90	C	6HX	E302M5	6.0	5.00	70.0	13.0	5	DIN 2174	
		.984					.236	.197	2.756	.512			
M 6	1.00	30.00	6.00 x 4.90	C	6HX	E302M6	6.0	6.00	80.0	15.0	5	DIN 2174	
		1.181					.236	.236	3.150	.591			
M 8	1.25	35.00	8.00 x 6.20	C	6HX	E302M8	8.0	8.00	90.0	18.0	5	DIN 2174	
		1.378					.315	.315	3.543	.709			
M 10	1.50	39.00	10.00 x 8.00	C	6HX	E302M10	10.0	10.00	100.0	20.0	5	DIN 2174	
		1.535					.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	C	6HX	E302M12	9.0	12.00	110.0	23.0	5	DIN 2174	
		3.268					.354	.472	4.331	.906			
M 16	2.00	68.00	12.00 x 9.00	C	6HX	E302M16	12.0	16.00	110.0	25.0	6	DIN 2174	
		2.677					.472	.630	4.331	.984			
M 20	2.50	70.00	16.00 x 12.00	C	6HX	E302M20	16.0	20.00	140.0	30.0	7	DIN 2174	
		2.756					.630	.787	5.512	1.181			
M 24	3.00	80.00	18.00 x 14.50	C	6HX	E302M24	18.0	24.00	160.0	36.0	8	DIN 2174	
		3.150					.709	.945	6.299	1.417			

D

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch

DIN 2174

ULDR
SUBSTRATE
COATING3.0
HSS-E
PVD TIN

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.00	3.50 x 2.70	E	6HX	E305M3	3.5	3.00	56.0	9.0	4	DIN 2174	
		.709					.138	.118	2.205	.354			
M 4	0.70	21.00	4.50 x 3.40	E	6HX	E305M4	4.5	4.00	63.0	12.0	5	DIN 2174	
		.827					.177	.157	2.480	.472			
M 5	0.80	25.00	6.00 x 4.90	E	6HX	E305M5	6.0	5.00	70.0	13.0	5	DIN 2174	
		.984					.236	.197	2.756	.512			
M 6	1.00	30.00	6.00 x 4.90	E	6HX	E305M6	6.0	6.00	80.0	15.0	5	DIN 2174	
		1.181					.236	.236	3.150	.591			
M 8	1.25	35.00	8.00 x 6.20	E	6HX	E305M8	8.0	8.00	90.0	18.0	5	DIN 2174	
		1.378					.315	.315	3.543	.709			
M 10	1.50	39.00	10.00 x 8.00	E	6HX	E305M10	10.0	10.00	100.0	20.0	5	DIN 2174	
		1.535					.394	.394	3.937	.787			
M 3	0.50	18.00	3.50 x 2.70	C	6GX	E309M3	3.5	3.00	56.0	9.0	4	DIN 2174	
		.709					.138	.118	2.205	.354			
M 3.5	0.60	20.00	4.00 x 3.00	C	6GX	E309M3.5	4.0	3.50	56.0	11.0	4	DIN 2174	
		.787					.157	.138	2.205	.433			
M 4	0.70	21.00	4.50 x 3.40	C	6GX	E309M4	4.5	4.00	63.0	12.0	5	DIN 2174	
		.827					.177	.157	2.480	.472			
M 5	0.80	25.00	6.00 x 4.90	C	6GX	E309M5	6.0	5.00	70.0	13.0	5	DIN 2174	
		.984					.236	.197	2.756	.512			
M 6	1.00	30.00	6.00 x 4.90	C	6GX	E309M6	6.0	6.00	80.0	15.0	5	DIN 2174	
		1.181					.236	.236	3.150	.591			
M 8	1.25	35.00	8.00 x 6.20	C	6GX	E309M8	8.0	8.00	90.0	18.0	5	DIN 2174	
		1.378					.315	.315	3.543	.709			
M 10	1.50	39.00	10.00 x 8.00	C	6GX	E309M10	10.0	10.00	100.0	20.0	5	DIN 2174	
		1.535					.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	C	6GX	E309M12	9.0	12.00	110.0	23.0	5	DIN 2174	
		3.268					.354	.472	4.331	.906			
M 3	0.50	18.00	3.50 x 2.70	E	6GX	E310M3	3.5	3.00	56.0	9.0	4	DIN 2174	
		.709					.138	.118	2.205	.354			
M 4	0.70	21.00	4.50 x 3.40	E	6GX	E310M4	4.5	4.00	63.0	12.0	5	DIN 2174	
		.827					.177	.157	2.480	.472			
M 5	0.80	25.00	6.00 x 4.90	E	6GX	E310M5	6.0	5.00	70.0	13.0	5	DIN 2174	
		.984					.236	.197	2.756	.512			
M 6	1.00	30.00	6.00 x 4.90	E	6GX	E310M6	6.0	6.00	80.0	15.0	5	DIN 2174	
		1.181					.236	.236	3.150	.591			
M 8	1.25	35.00	8.00 x 6.20	E	6GX	E310M8	8.0	8.00	90.0	18.0	5	DIN 2174	
		1.378					.315	.315	3.543	.709			
M 10	1.50	39.00	10.00 x 8.00	E	6GX	E310M10	10.0	10.00	100.0	20.0	5	DIN 2174	
		1.535					.394	.394	3.937	.787			



C170



C157



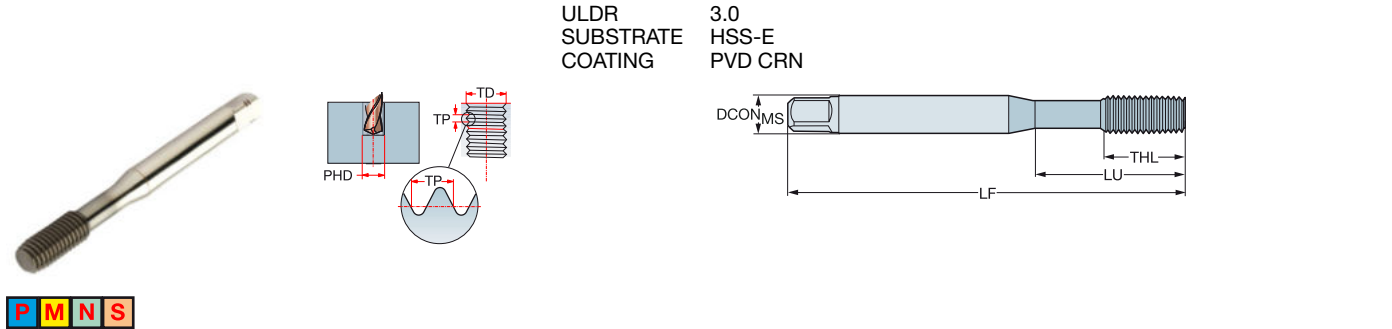
E9



C154

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
DIN 2174



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6HX	E306M3	3.5	3.00	56.0	9.0	4	DIN 2174	
		.709					.138	.118	2.205	.354			
M 4	0.70	21.00	4.50 x 3.40	C	6HX	E306M4	4.5	4.00	63.0	12.0	5	DIN 2174	
		.827					.177	.157	2.480	.472			
M 5	0.80	25.00	6.00 x 4.90	C	6HX	E306M5	6.0	5.00	70.0	13.0	5	DIN 2174	
		.984					.236	.197	2.756	.512			
M 6	1.00	30.00	6.00 x 4.90	C	6HX	E306M6	6.0	6.00	80.0	15.0	5	DIN 2174	
		1.181					.236	.236	3.150	.591			
M 8	1.25	35.00	8.00 x 6.20	C	6HX	E306M8	8.0	8.00	90.0	18.0	5	DIN 2174	
		1.378					.315	.315	3.543	.709			
M 10	1.50	39.00	10.00 x 8.00	C	6HX	E306M10	10.0	10.00	100.0	20.0	5	DIN 2174	
		1.535					.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	C	6HX	E306M12	9.0	12.00	110.0	23.0	5	DIN 2174	
		3.268					.354	.472	4.331	.906			

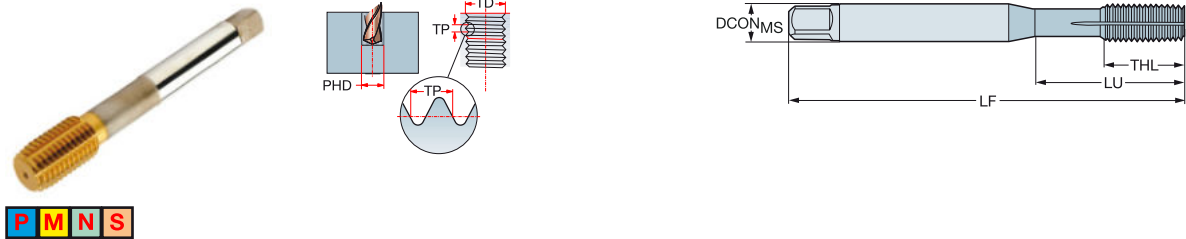


CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
DIN 2174

ULDR
SUBSTRATE
COATING

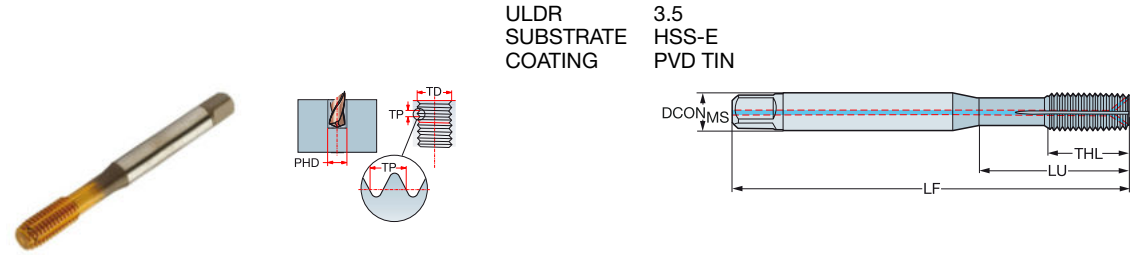
3.5
HSS-E
PVD TIN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6HX	E308M3	3.5	3.00	56.0	9.0	4	DIN 2174	
		.709					.138	.118	2.205	.354			
M 4	0.70	21.00	4.50 x 3.40	C	6HX	E308M4	4.5	4.00	63.0	12.0	5	DIN 2174	
		.827					.177	.157	2.480	.472			
M 5	0.80	25.00	6.00 x 4.90	C	6HX	E308M5	6.0	5.00	70.0	13.0	5	DIN 2174	
		.984					.236	.197	2.756	.512			
M 6	1.00	30.00	6.00 x 4.90	C	6HX	E308M6	6.0	6.00	80.0	15.0	5	DIN 2174	
		1.181					.236	.236	3.150	.591			
M 7	1.00	30.00	7.00 x 5.50	C	6HX	E308M7	7.0	7.00	80.0	15.0	5	DIN 2174	
		1.181					.276	.276	3.150	.591			
M 8	1.25	35.00	8.00 x 6.20	C	6HX	E308M8	8.0	8.00	90.0	18.0	5	DIN 2174	
		1.378					.315	.315	3.543	.709			
M 10	1.50	39.00	10.00 x 8.00	C	6HX	E308M10	10.0	10.00	100.0	20.0	5	DIN 2174	
		1.535					.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	C	6HX	E308M12	9.0	12.00	110.0	23.0	5	DIN 2174	
		3.268					.354	.472	4.331	.906			
M 14	2.00	81.00	11.00 x 9.00	C	6HX	E308M14	11.0	14.00	110.0	25.0	6	DIN 2174	
		3.189					.433	.551	4.331	.984			
M 16	2.00	68.00	12.00 x 9.00	C	6HX	E308M16	12.0	16.00	110.0	25.0	6	DIN 2174	
		2.677					.472	.630	4.331	.984			
M 20	2.50	95.00	16.00 x 12.00	C	6HX	E308M20	16.0	20.00	140.0	30.0	7	DIN 2174	
		3.740					.630	.787	5.512	1.181			
M 24	3.00	113.00	18.00 x 14.50	C	6HX	E308M24	18.0	24.00	160.0	36.0	8	DIN 2174	
		4.449					.709	.945	6.299	1.417			

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
DIN 2174



										Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG	
M 5	0.80	21.00	6.00 x 4.90	C	6HX	1	2	E315M5		6.0	5.00	70.0	13.0	5	DIN 2174	
		.827								.236	.197	2.756	.512			
M 6	1.00	26.00	6.00 x 4.90	C	6HX	1	2	E315M6		6.0	6.00	80.0	15.0	5	DIN 2174	
		1.024								.236	.236	3.150	.591			
M 8	1.25	30.00	8.00 x 6.20	C	6HX	1	2	E315M8		8.0	8.00	90.0	18.0	5	DIN 2174	
		1.181								.315	.315	3.543	.709			
M 10	1.50	33.00	10.00 x 8.00	C	6HX	1	2	E315M10		10.0	10.00	100.0	20.0	5	DIN 2174	
		1.299								.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	2	E315M12		9.0	12.00	110.0	23.0	5	DIN 2174	
		3.268								.354	.472	4.331	.906			

CXSC 2 = radialer Kühlschmierstoffaustritt

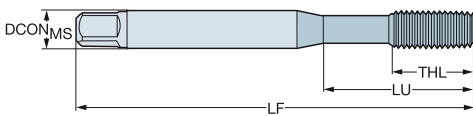
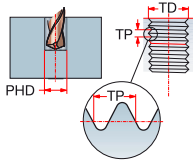
D

E

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
C-DIN 2174, DIN 2174

ULDR
SUBSTRATE
COATING 3.0
HM
PVD TiCN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	10.00	3.50 x 2.70	C	6HX	T115M3	3.5	3.00	56.0	10.0	4	C-DIN 2174	
		.394					.138	.118	2.205	.394			
M 4	0.70	13.00	4.50 x 3.40	C	6HX	T115M4	4.5	4.00	63.0	13.0	5	C-DIN 2174	
		.512					.177	.157	2.480	.512			
M 5	0.80	16.00	6.00 x 4.90	C	6HX	T115M5	6.0	5.00	70.0	16.0	5	C-DIN 2174	
		.630					.236	.197	2.756	.630			
M 6	1.00	30.00	6.00 x 4.90	C	6HX	T115M6	6.0	6.00	80.0	19.0	5	DIN 2174	
		1.181					.236	.236	3.150	.748			
M 8	1.25	35.00	8.00 x 6.20	C	6HX	T115M8	8.0	8.00	90.0	22.0	5	DIN 2174	
		1.378					.315	.315	3.543	.866			
M 10	1.50	39.00	10.00 x 8.00	C	6HX	T115M10	10.0	10.00	100.0	24.0	5	DIN 2174	
		1.535					.394	.394	3.937	.945			

C170

C157

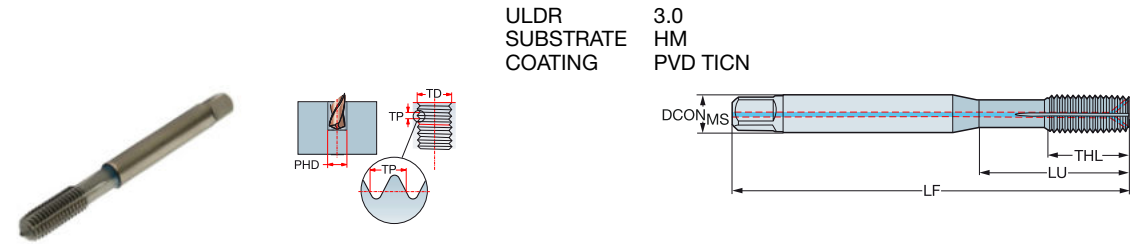
E9

C154



CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
C-DIN 2174, DIN 2174



										Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG
M 5	0.80	16.00	6.00 x 4.90	C	6HX	1	1	T116M5		6.0	5.00	70.0	16.0	5	C-DIN 2174
		.630								.236	.197	2.756	.630		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	1	T116M6		6.0	6.00	80.0	19.0	5	DIN 2174
		1.181								.236	.236	3.150	.748		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	T116M8		8.0	8.00	90.0	22.0	5	DIN 2174
		1.378								.315	.315	3.543	.866		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	T116M10		10.0	10.00	100.0	24.0	5	DIN 2174
		1.535								.394	.394	3.937	.945		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	1	T116M12		9.0	12.00	110.0	23.0	5	DIN 2174
		3.268								.354	.472	4.331	.906		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

D

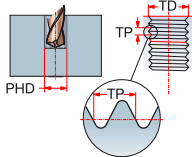
E

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
DIN/ANSI

ULDR
SUBSTRATE
COATING

3.0
HSS-PM
PVD TIN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.81	.141 x .110	C	6H	E890M3	3.6	3.00	56.0	18.8	4	DIN/ANSI	
		.740					.141	.118	2.205	.740			
M 4	0.70	16.58	.168 x .131	C	6H	E890M4	4.3	4.00	63.0	16.5	4	DIN/ANSI	
		.653					.168	.157	2.480	.650			
M 5	0.80	21.42	.194 x .152	C	6H	E890M5	4.9	5.00	70.0	19.3	4	DIN/ANSI	
		.843					.194	.197	2.756	.760			
M 6	1.00	25.59	.255 x .191	C	6H	E890M6	6.5	6.00	80.0	15.0	4	DIN/ANSI	
		1.007					.255	.236	3.150	.591			
M 8	1.25	30.20	.318 x .238	C	6H	E890M8	8.1	8.00	90.0	18.0	5	DIN/ANSI	
		1.189					.318	.315	3.543	.709			
M 10	1.50	32.80	.381 x .286	C	6H	E890M10	9.7	10.00	100.0	20.0	6	DIN/ANSI	
		1.292					.381	.394	3.937	.787			
M 12	1.75	87.00	.367 x .275	C	6H	E890M12	9.3	12.00	110.0	23.0	6	DIN/ANSI	
		3.425					.367	.472	4.331	.906			
M 16	2.00	72.00	.480 x .360	C	6H	E890M16	12.2	16.00	110.0	23.0	8	DIN/ANSI	
		2.835					.480	.630	4.331	.906			
M 18	2.50	87.00	.542 x .406	C	6H	E890M18	13.8	18.00	125.0	30.0	8	DIN/ANSI	
		3.425					.542	.709	4.921	1.181			
M 20	2.50	102.00	.652 x .489	C	6H	E890M20	16.6	20.00	140.0	36.0	8	DIN/ANSI	
		4.016					.652	.787	5.512	1.417			

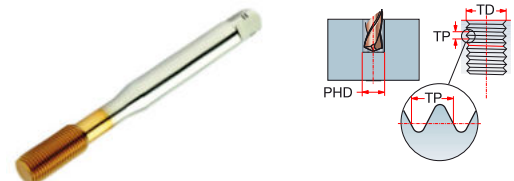


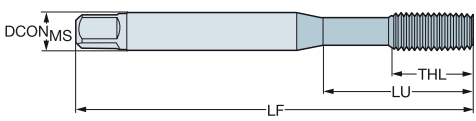
CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch Fein
DIN 2174

ULDR
SUBSTRATE
COATING

3.0
HSS-E
PVD TIN







C

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
MF 5x0.5	0.50	25.00	6.00 x 4.90	C	6HX	E317M5X0.5	6.0	5.00	70.0	13.0	5	DIN 2174	
		.984					.236	.197	2.756	.512			
MF 6x0.75	0.75	30.00	6.00 x 4.90	C	6HX	E317M6X0.75	6.0	6.00	80.0	15.0	5	DIN 2174	
		1.181					.236	.236	3.150	.591			
MF 7x0.75	0.75	30.00	7.00 x 5.50	C	6HX	E317M7X0.75	7.0	7.00	80.0	15.0	5	DIN 2174	
		1.181					.276	.276	3.150	.591			
MF 8x0.75	0.75	57.00	6.00 x 4.90	C	6HX	E317M8X.75	6.0	8.00	80.0	18.0	5	DIN 2174	
		2.244					.236	.315	3.150	.709			
MF 8x1	1.00	67.00	6.00 x 4.90	C	6HX	E317M8X1	6.0	8.00	90.0	18.0	5	DIN 2174	
		2.638					.236	.315	3.543	.709			
MF 10x1	1.00	75.00	7.00 x 5.50	C	6HX	E317M10X1	7.0	10.00	100.0	20.0	5	DIN 2174	
		2.953					.276	.394	3.937	.787			
MF 10x1.25	1.25	75.00	7.00 x 5.50	C	6HX	E317M10X1.25	7.0	10.00	100.0	20.0	5	DIN 2174	
		2.953					.276	.394	3.937	.787			
MF 12x1	1.00	73.00	9.00 x 7.00	C	6HX	E317M12X1	9.0	12.00	100.0	23.0	5	DIN 2174	
		2.874					.354	.472	3.937	.906			
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	E317M12X1.25	9.0	12.00	100.0	23.0	5	DIN 2174	
		2.874					.354	.472	3.937	.906			
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	E317M12X1.5	9.0	12.00	100.0	23.0	5	DIN 2174	
		2.874					.354	.472	3.937	.906			
MF 14x1	1.00	71.00	11.00 x 9.00	C	6HX	E317M14X1	11.0	14.00	100.0	21.0	6	DIN 2174	
		2.795					.433	.551	3.937	.827			
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6HX	E317M14X1.25	11.0	14.00	100.0	21.0	6	DIN 2174	
		2.795					.433	.551	3.937	.827			
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	E317M14X1.5	11.0	14.00	100.0	21.0	6	DIN 2174	
		2.795					.433	.551	3.937	.827			
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	E317M16X1.5	12.0	16.00	100.0	21.0	6	DIN 2174	
		2.283					.472	.630	3.937	.827			

D

C170

C157

E9

C154



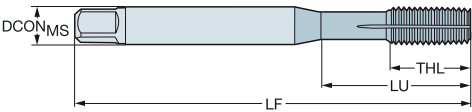
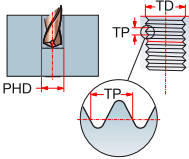
CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch Fein

DIN/ANSI

ULDR
SUBSTRATE
COATING

3.0
HSS-PM
PVD TIN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THGHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
MF 10x1.25	1.25	36.61	.381 x .286	C	6H	E891M10X1.25	9.7	10.00	100.0	20.0	6	DIN/ANSI	
		1.442					.381	.394	3.937	.787			
MF 12x1.5	1.50	87.00	.367 x .275	C	6H	E891M12X1.5	9.3	12.00	110.0	23.0	6	DIN/ANSI	
		3.425					.367	.472	4.331	.906			



C170



C157



E9



C154

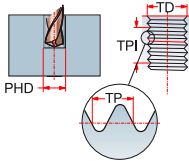


CoroTap™ 400 Gewindeformer

Gewindeform: UNC
DIN/ANSI

ULDR
SUBSTRATE
COATING

3.0
HSS-PM
PVD TIN



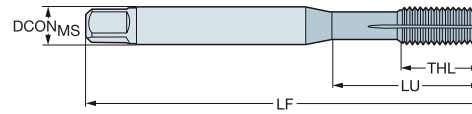
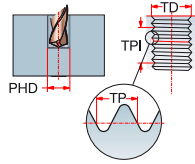
							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THGHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
UNC #4-40	40.00	15.47	.141 x .110	C	2B	E8924-40	3.6	2.84	56.0	11.0	3	DIN/ANSI	
		.609					.141	.112	2.205	.433			
UNC #6-32	32.00	15.08	.141 x .110	C	2B	E8926-32	3.6	3.51	56.0	13.0	3	DIN/ANSI	
		.594					.141	.138	2.205	.510			
UNC #8-32	32.00	16.58	.168 x .131	C	2B	E8928-32	4.3	4.17	63.0	16.5	4	DIN/ANSI	
		.653					.168	.164	2.480	.650			
UNC #10-24	24.00	21.42	.194 x .152	C	2B	E89210-24	4.9	4.83	70.0	19.3	4	DIN/ANSI	
		.843					.194	.190	2.756	.760			
UNC #12-24	24.00	25.55	.220 x .165	C	2B	E89212-24	5.6	5.49	80.0	15.0	4	DIN/ANSI	
		1.006					.220	.216	3.150	.591			
UNC 1/4-20	20.00	25.59	.255 x .191	C	2B	E8921/4	6.5	6.35	80.0	15.0	4	DIN/ANSI	
		1.007					.255	.250	3.150	.591			
UNC 5/16-18	18.00	30.20	.318 x .238	C	2B	E8925/16	8.1	7.94	90.0	18.0	5	DIN/ANSI	
		1.189					.318	.313	3.543	.709			
UNC 3/8-16	16.00	32.80	.381 x .286	C	2B	E8923/8	9.7	9.53	100.0	20.0	6	DIN/ANSI	
		1.292					.381	.375	3.937	.787			
UNC 7/16-14	14.00	72.60	.323 x .242	C	2B	E8927/16	8.2	11.11	100.0	20.0	6	DIN/ANSI	
		2.858					.323	.438	3.937	.787			
UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	E8921/2	9.3	12.70	110.0	23.0	6	DIN/ANSI	
		3.220					.367	.500	4.331	.906			
UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	E8925/8	12.2	15.88	110.0	23.0	8	DIN/ANSI	
		2.591					.480	.625	4.331	.906			
UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	E8923/4	15.0	19.05	125.0	30.0	8	DIN/ANSI	
		3.051					.590	.750	4.921	1.181			
UNC 7/8-9	9.00	90.90	.697 x .523	C	2B	E8927/8-9	17.7	22.23	140.0	34.0	8	DIN/ANSI	
		3.579					.697	.875	5.512	1.339			
UNC 1"-8	8.00	95.40	.800 x .600	C	2B	E8921	20.3	25.40	160.0	38.0	8	DIN/ANSI	
		3.756					.800	1.000	6.299	1.496			



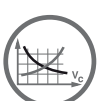
CoroTap™ 400 Gewindeformer

Gewindeform: UNF

DIN/ANSI

ULDR
SUBSTRATE
COATING3.0
HSS-PM
PVD TIN

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
UNF #10-32	32.00	21.42 .843	.194 x .152	C	2B	E89310-32	4.9 .194	4.83 .190	70.0 2.756	19.3 .760	4	DIN/ANSI	
UNF 1/4-28	28.00	25.59 1.007	.255 x .191	C	2B	E8931/4	6.5 .255	6.35 .250	80.0 3.150	15.0 .591	4	DIN/ANSI	
UNF 5/16-24	24.00	30.20 1.189	.318 x .238	C	2B	E8935/16	8.1 .318	7.94 .313	90.0 3.543	18.0 .709	5	DIN/ANSI	
UNF 3/8-24	24.00	32.80 1.292	.381 x .286	C	2B	E8933/8	9.7 .381	9.53 .375	100.0 3.937	20.0 .787	6	DIN/ANSI	
UNF 7/16-20	20.00	72.60 2.858	.323 x .242	C	2B	E8937/16	8.2 .323	11.11 .438	100.0 3.937	20.0 .787	6	DIN/ANSI	
UNF 1/2-20	20.00	81.80 3.220	.367 x .275	C	2B	E8931/2	9.3 .367	12.70 .500	110.0 4.331	23.0 .906	6	DIN/ANSI	
UNF 5/8-18	18.00	65.80 2.591	.480 x .360	C	2B	E8935/8	12.2 .480	15.88 .625	110.0 4.331	23.0 .906	8	DIN/ANSI	
UNF 3/4-16	16.00	77.50 3.051	.590 x .442	C	2B	E8933/4	15.0 .590	19.05 .750	125.0 4.921	30.0 1.181	8	DIN/ANSI	
UNF 1"-12	12.00	95.40 3.756	.800 x .600	C	2B	E8931	20.3 .800	25.40 1.000	160.0 6.299	36.0 1.417	8	DIN/ANSI	



C170



C157



E9



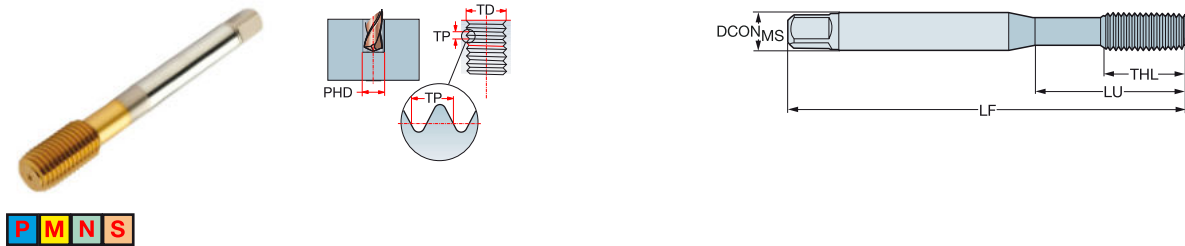
C154

CoroTap™ 400 Gewindeformer

Gewindeform: EGM
DIN 40435

ULDR
SUBSTRATE
COATING

3.0
HSS-E
PVD TIN



		Abmessungen, mm, Zoll										
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
EGM 3	0.50	21.00	4.50 x 3.40	C	6HMOD	E323M3	4.5	3.65	63.0	12.0	4	DIN 40435
		.827					.177	.144	2.480	.472		
EGM 4	0.70	25.00	6.00 x 4.90	C	6HMOD	E323M4	6.0	4.91	70.0	13.0	4	DIN 40435
		.984					.236	.193	2.756	.512		
EGM 5	0.80	30.00	6.00 x 4.90	C	6HMOD	E323M5	6.0	6.04	80.0	15.0	4	DIN 40435
		1.181					.236	.238	3.150	.591		
EGM 6	1.00	35.00	8.00 x 6.20	C	6HMOD	E323M6	8.0	7.30	90.0	18.0	5	DIN 40435
		1.378					.315	.287	3.543	.709		
EGM 8	1.25	39.00	10.00 x 8.00	C	6HMOD	E323M8	10.0	9.62	100.0	20.0	5	DIN 40435
		1.535					.394	.379	3.937	.787		
EGM 10	1.50	73.00	9.00 x 7.00	C	6HMOD	E323M10	9.0	11.95	100.0	21.0	5	DIN 40435
		2.874					.354	.470	3.937	.827		
EGM 12	1.75	81.00	11.00 x 9.00	C	6HMOD	E323M12	11.0	14.27	110.0	25.0	6	DIN 40435
		3.189					.433	.562	4.331	.984		

C

D

E



CoroTap™ 100

Anwendungen

- Für spezielle Werkstoffe optimierter Gewindebohrer
- Sowohl für Durchgangs- als auch Grundbohrungen
- Tiefen bis zu $2.5 \times$ Durchmesser
- Toleranzen ISO K: 6H, 6HX, 2B, 2BX, 3B
- Toleranzen ISO N: 6H
- Toleranzen ISO H: 6H, 6HX



Vorteile und Merkmale

- Optional mit Kühlschmierstoffbohrungen für höchste Produktivität
- Fünf Spannuten reduzieren die auf die Schneidkante wirkenden Schnittkräfte
- Einzigartige Sorte mit höherer Härte für Verschleißminimierung auf Beschichtung und Substrat
- Für ISO N Werkstoffe: Gewindebohrer mit mit ausgesetzten Zähnen für geringeres Drehmoment



- Gewindebohrer, gerade genutet
- Vorwiegend für kurzspanende Werkstoffe wie wie Gusswerkstoffe verwendet
- Sowohl für Durchgangs- als auch Grundbohrungen

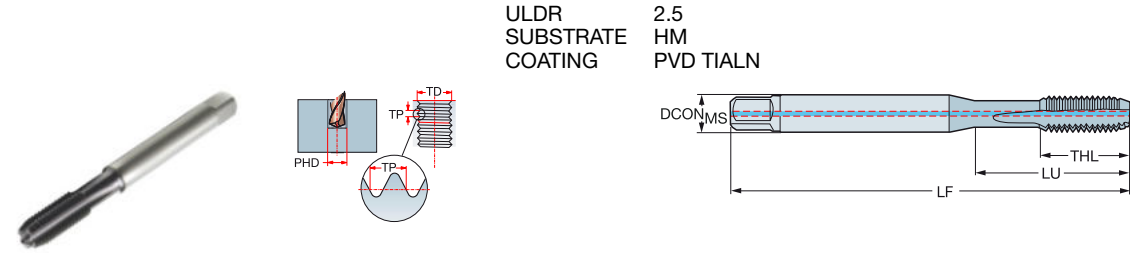
www.sandvik.coromant.com/corotap100



CoroChuck™ 970, siehe Katalog Rotierende Werkzeuge.

CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch
C-DIN 371, DIN 371, DIN 376



K

								Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 5	0.80	47.00	6.00 x 4.90	C	6HX	1	1	T101M5	6.0	5.00	70.0	16.0	4	C-DIN 371
		1.850							.236	.197	2.756	.630		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	1	T101M6	6.0	6.00	80.0	19.0	4	DIN 371
		1.181							.236	.236	3.150	.748		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	T101M8	8.0	8.00	90.0	22.0	4	DIN 371
		1.378							.315	.315	3.543	.866		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	T101M10	10.0	10.00	100.0	24.0	4	DIN 371
		1.535							.394	.394	3.937	.945		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	1	T101M12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268							.354	.472	4.331	.906		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	1	1	T101M16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677							.472	.630	4.331	.984		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

D

E

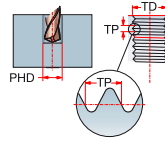
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch

C-DIN 371

ULDR
SUBSTRATE
COATING

2.0
HM
PVD TIALN



H

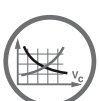
									Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	10.00	3.50 x 2.70	C	6H	0	0	T100M3	3.5	3.00	56.0	10.0	3	C-DIN 371	
	.394								.138	.118	2.205	.394			
M 4	0.70	13.00	4.50 x 3.40	C	6H	0	0	T100M4	4.5	4.00	63.0	13.0	3	C-DIN 371	
	.512								.177	.157	2.480	.512			
M 5	0.80	16.00	6.00 x 4.90	C	6H	0	0	T100M5	6.0	5.00	70.0	16.0	3	C-DIN 371	
	.630								.236	.197	2.756	.630			
M 6	1.00	20.00	6.00 x 4.90	C	6H	0	0	T100M6	6.0	6.00	80.0	20.0	3	C-DIN 371	
	.787								.236	.236	3.150	.787			
M 8	1.25	25.00	8.00 x 6.20	C	6H	0	0	T100M8	8.0	8.00	90.0	25.0	3	C-DIN 371	
	.984								.315	.315	3.543	.984			
M 10	1.50	30.00	10.00 x 8.00	C	6H	0	0	T100M10	10.0	10.00	100.0	30.0	3	C-DIN 371	
	1.181								.394	.394	3.937	1.181			
M 12	1.75	36.00	12.00 x 9.00	C	6H	0	0	T100M12	12.0	12.00	110.0	36.0	3	C-DIN 371	
	1.417								.472	.472	4.331	1.417			
M 3	0.50	8.00	3.50 x 2.70	C	6HX	0	0	T110M3	3.5	3.00	56.0	8.0	4	C-DIN 371	
	.315								.138	.118	2.205	.315			
M 4	0.70	11.00	4.50 x 3.40	C	6HX	0	0	T110M4	4.5	4.00	63.0	11.0	5	C-DIN 371	
	.433								.177	.157	2.480	.433			
M 5	0.80	13.50	6.00 x 4.90	C	6HX	0	0	T110M5	6.0	5.00	70.0	13.5	5	C-DIN 371	
	.531								.236	.197	2.756	.531			
M 6	1.00	16.50	6.00 x 4.90	C	6HX	0	0	T110M6	6.0	6.00	80.0	16.5	5	C-DIN 371	
	.650								.236	.236	3.150	.650			
M 8	1.25	21.50	8.00 x 6.20	C	6HX	0	0	T110M8	8.0	8.00	90.0	21.5	5	C-DIN 371	
	.846								.315	.315	3.543	.846			
M 10	1.50	27.00	10.00 x 8.00	C	6HX	0	0	T110M10	10.0	10.00	100.0	27.0	5	C-DIN 371	
	1.063								.394	.394	3.937	1.063			
M 12	1.75	32.00	12.00 x 9.00	C	6HX	0	0	T110M12	12.0	12.00	110.0	32.0	6	C-DIN 371	
	1.260								.472	.472	4.331	1.260			

B

C

D

E



C172



C157



E9



E28



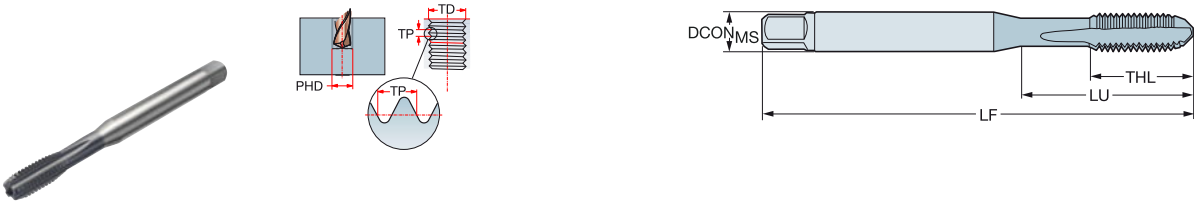
C154

CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



							K	Abmessungen, mm, Zoll							
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D20	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6HX	T100-KM100DA-M3	★	3.5	3.00	56.0	9.0	4	2.5	DIN 371	
		.709						.138	.118	2.205	.354		.098		
M 4	0.70	21.00	4.50 x 3.40	C	6HX	T100-KM100DA-M4	★	4.5	4.00	63.0	12.0	4	3.3	DIN 371	
		.827						.177	.157	2.480	.472		.130		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	T100-KM100DA-M5	★	6.0	5.00	70.0	13.0	5	4.2	DIN 371	
		.984						.236	.197	2.756	.512		.165		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	T100-KM100DA-M6	★	6.0	6.00	80.0	15.0	5	5.0	DIN 371	
		1.181						.236	.236	3.150	.591		.197		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	T100-KM100DA-M8	★	8.0	8.00	90.0	18.0	5	6.8	DIN 371	
		1.378						.315	.315	3.543	.709		.268		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	T100-KM100DA-M10	★	10.0	10.00	100.0	20.0	5	8.5	DIN 371	
		1.535						.394	.394	3.937	.787		.335		
M 8	1.25	67.00	6.00 x 4.90	C	6HX	T100-KM101DA-M8	★	6.0	8.00	90.0	20.0	5	6.8	DIN 376	
		2.638						.236	.315	3.543	.787		.268		
M 10	1.50	77.00	7.00 x 5.50	C	6HX	T100-KM101DA-M10	★	7.0	10.00	100.0	23.5	5	8.5	DIN 376	
		3.032						.276	.394	3.937	.925		.335		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	T100-KM101DA-M12	★	9.0	12.00	110.0	23.0	5	10.2	DIN 376	
		3.268						.354	.472	4.331	.906		.402		
M 14	2.00	81.00	11.00 x 9.00	C	6HX	T100-KM101DA-M14	★	11.0	14.00	110.0	25.0	5	12.0	DIN 376	
		3.189						.433	.551	4.331	.984		.472		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	T100-KM101DA-M16	★	12.0	16.00	110.0	25.0	5	14.0	DIN 376	
		2.677						.472	.630	4.331	.984		.551		
M 18	2.50	81.00	14.00 x 11.00	C	6HX	T100-KM101DA-M18	★	14.0	18.00	125.0	30.0	5	15.5	DIN 376	
		3.189						.551	.709	4.921	1.181		.610		
M 20	2.50	95.00	16.00 x 12.00	C	6HX	T100-KM101DA-M20	★	16.0	20.00	140.0	30.0	5	17.5	DIN 376	
		3.740						.630	.787	5.512	1.181		.689		
M 22	2.50	93.00	18.00 x 14.50	C	6HX	T100-KM101DA-M22	★	18.0	22.00	140.0	34.0	5	19.5	DIN 376	
		3.661						.709	.866	5.512	1.339		.768		
M 24	3.00	113.00	18.00 x 14.50	C	6HX	T100-KM101DA-M24	★	18.0	24.00	160.0	38.0	5	21.0	DIN 376	
		4.449						.709	.945	6.299	1.496		.827		
M 5	0.80	25.00	6.00 x 4.90	E	6HX	T100-KM102DA-M5	★	6.0	5.00	70.0	13.0	5	4.2	DIN 371	
		.984						.236	.197	2.756	.512		.165		
M 6	1.00	30.00	6.00 x 4.90	E	6HX	T100-KM102DA-M6	★	6.0	6.00	80.0	15.0	5	5.0	DIN 371	
		1.181						.236	.236	3.150	.591		.197		
M 8	1.25	35.00	8.00 x 6.20	E	6HX	T100-KM102DA-M8	★	8.0	8.00	90.0	18.0	5	6.8	DIN 371	
		1.378						.315	.315	3.543	.709		.268		
M 10	1.50	39.00	10.00 x 8.00	E	6HX	T100-KM102DA-M10	★	10.0	10.00	100.0	20.0	5	8.5	DIN 371	
		1.535						.394	.394	3.937	.787		.335		
M 12	1.75	83.00	9.00 x 7.00	E	6HX	T100-KM103DA-M12	★	9.0	12.00	110.0	23.0	5	10.2	DIN 376	
		3.268						.354	.472	4.331	.906		.402		

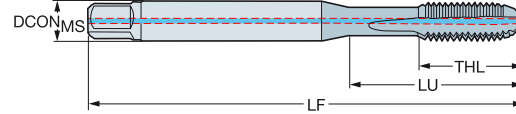
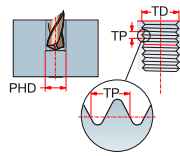
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch

DIN 371, DIN 376

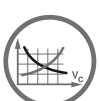
ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TiAlN



										Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG	
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	1	T100-KM104DA-M6	★	6.0	6.00	80.0	15.0	5	DIN 371	
		1.181								.236	.236	3.150	.591			
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	T100-KM104DA-M8	★	8.0	8.00	90.0	18.0	5	DIN 371	
		1.378								.315	.315	3.543	.709			
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	T100-KM104DA-M10	★	10.0	10.00	100.0	20.0	5	DIN 371	
		1.535								.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	1	T100-KM105DA-M12	★	9.0	12.00	110.0	23.0	5	DIN 376	
		3.268								.354	.472	4.331	.906			
M 14	2.00	81.00	11.00 x 9.00	C	6HX	1	1	T100-KM105DA-M14	★	11.0	14.00	110.0	25.0	5	DIN 376	
		3.189								.433	.551	4.331	.984			
M 16	2.00	68.00	12.00 x 9.00	C	6HX	1	1	T100-KM105DA-M16	★	12.0	16.00	110.0	25.0	5	DIN 376	
		2.677								.472	.630	4.331	.984			
M 20	2.50	95.00	16.00 x 12.00	C	6HX	1	1	T100-KM105DA-M20	★	16.0	20.00	140.0	30.0	5	DIN 376	
		3.740								.630	.787	5.512	1.181			
M 22	2.50	93.00	18.00 x 14.50	C	6HX	1	1	T100-KM105DA-M22	★	18.0	22.00	140.0	34.0	5	DIN 376	
		3.661								.709	.866	5.512	1.339			
M 24	3.00	113.00	18.00 x 14.50	C	6HX	1	1	T100-KM105DA-M24	★	18.0	24.00	160.0	38.0	5	DIN 376	
		4.449								.709	.945	6.299	1.496			

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt



C172



C157



E9



E27



E28



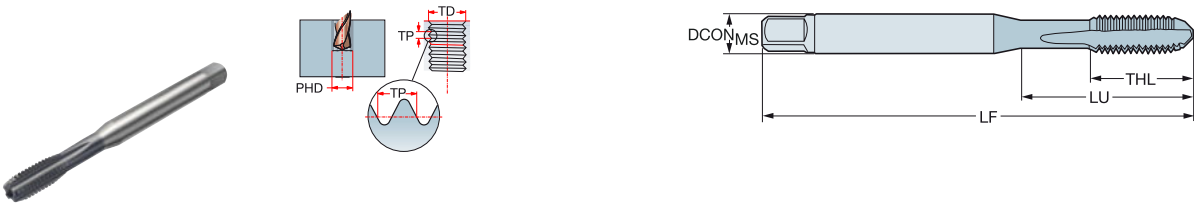
C154

CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch
DIN 371/ANSI, DIN 376/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



						Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D ₂₁₀	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
M 6	1.00	25.00	.255 x .191	C	6HX	T100-KM100AA-M6	★	6.5	6.00	80.0	15.6	5	5.0	DIN 371/ANSI	
		.984						.255	.236	3.150	.614		.197		
M 8	1.25	33.50	.318 x .238	C	6HX	T100-KM100AA-M8	★	8.1	8.00	90.0	18.7	5	6.8	DIN 371/ANSI	
		1.319						.318	.315	3.543	.736		.268		
M 10	1.50	38.00	.381 x .286	C	6HX	T100-KM100AA-M10	★	9.7	10.00	100.0	20.6	5	8.5	DIN 371/ANSI	
		1.496						.381	.394	3.937	.811		.335		
M 12	1.75	81.90	.367 x .275	C	6HX	T100-KM101AA-M12	★	9.3	12.00	110.0	23.0	5	10.2	DIN 376/ANSI	
		3.224						.367	.472	4.331	.906		.402		
M 14	2.00	80.30	.429 x .322	C	6HX	T100-KM101AA-M14	★	10.9	14.00	110.0	23.0	5	12.0	DIN 376/ANSI	
		3.161						.429	.551	4.331	.906		.472		
M 16	2.00	65.70	.480 x .360	C	6HX	T100-KM101AA-M16	★	12.2	16.00	110.0	23.0	5	14.0	DIN 376/ANSI	
		2.587						.480	.630	4.331	.906		.551		
M 18	2.50	79.10	.542 x .406	C	6HX	T100-KM101AA-M18	★	13.8	18.00	125.0	30.0	5	15.5	DIN 376/ANSI	
		3.114						.542	.709	4.921	1.181		.610		
M 6	1.00	25.00	.255 x .191	E	6HX	T100-KM102AA-M6	★	6.5	6.00	80.0	15.6	5	5.0	DIN 371/ANSI	
		.984						.255	.236	3.150	.614		.197		
M 8	1.25	33.50	.318 x .238	E	6HX	T100-KM102AA-M8	★	8.1	8.00	90.0	18.7	5	6.8	DIN 371/ANSI	
		1.319						.318	.315	3.543	.736		.268		
M 10	1.50	38.00	.381 x .286	E	6HX	T100-KM102AA-M10	★	9.7	10.00	100.0	20.6	5	8.5	DIN 371/ANSI	
		1.496						.381	.394	3.937	.811		.335		
M 12	1.75	81.90	.367 x .275	E	6HX	T100-KM103AA-M12	★	9.3	12.00	110.0	23.0	5	10.2	DIN 376/ANSI	
		3.224						.367	.472	4.331	.906		.402		
M 14	2.00	80.30	.429 x .322	E	6HX	T100-KM103AA-M14	★	10.9	14.00	110.0	23.0	5	12.0	DIN 376/ANSI	
		3.161						.429	.551	4.331	.906		.472		
M 16	2.00	65.70	.480 x .360	E	6HX	T100-KM103AA-M16	★	12.2	16.00	110.0	23.0	5	14.0	DIN 376/ANSI	
		2.587						.480	.630	4.331	.906		.551		

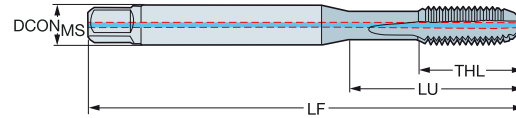
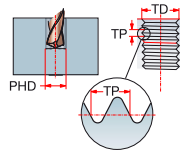
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch

DIN 371/ANSI, DIN 376/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TiAlN



										Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG
M 6	1.00	25.00 .984	.255 x .191	C	6HX	1	1	T100-KM104AA-M6	★	6.5 .255	6.00 .236	80.0 3.150	15.6 .614	5	DIN 371/ANSI
M 8	1.25	33.50 1.319	.318 x .238	C	6HX	1	1	T100-KM104AA-M8	★	8.1 .318	8.00 .315	90.0 3.543	18.7 .736	5	DIN 371/ANSI
M 10	1.50	38.00 1.496	.381 x .286	C	6HX	1	1	T100-KM104AA-M10	★	9.7 .381	10.00 .394	100.0 3.937	20.6 .811	5	DIN 371/ANSI
M 12	1.75	81.90 3.224	.367 x .275	C	6HX	1	1	T100-KM105AA-M12	★	9.3 .367	12.00 .472	110.0 4.331	23.0 .906	5	DIN 376/ANSI
M 16	2.00	65.70 2.587	.480 x .360	C	6HX	1	1	T100-KM105AA-M16	★	12.2 .480	16.00 .630	110.0 4.331	23.0 .906	5	DIN 376/ANSI
M 20	2.50	92.50 3.642	.652 x .489	C	6HX	1	1	T100-KM105AA-M20	★	16.6 .652	20.00 .787	140.0 5.512	30.0 1.181	5	DIN 376/ANSI
M 6	1.00	25.00 .984	.255 x .191	E	6HX	1	1	T100-KM106AA-M6	★	6.5 .255	6.00 .236	80.0 3.150	15.6 .614	5	DIN 371/ANSI
M 8	1.25	33.50 1.319	.318 x .238	E	6HX	1	1	T100-KM106AA-M8	★	8.1 .318	8.00 .315	90.0 3.543	18.7 .736	5	DIN 371/ANSI
M 10	1.50	38.00 1.496	.381 x .286	E	6HX	1	1	T100-KM106AA-M10	★	9.7 .381	10.00 .394	100.0 3.937	20.6 .811	5	DIN 371/ANSI
M 12	1.75	81.90 3.224	.367 x .275	E	6HX	1	1	T100-KM107AA-M12	★	9.3 .367	12.00 .472	110.0 4.331	23.0 .906	5	DIN 376/ANSI
M 14	2.00	80.30 3.161	.429 x .322	E	6HX	1	1	T100-KM107AA-M14	★	10.9 .429	14.00 .551	110.0 4.331	23.0 .906	5	DIN 376/ANSI
M 16	2.00	65.70 2.587	.480 x .360	E	6HX	1	1	T100-KM107AA-M16	★	12.2 .480	16.00 .630	110.0 4.331	23.0 .906	5	DIN 376/ANSI
M 20	2.50	92.50 3.642	.652 x .489	E	6HX	1	1	T100-KM107AA-M20	★	16.6 .652	20.00 .787	140.0 5.512	30.0 1.181	5	DIN 376/ANSI
M 6	1.00	25.00 .984	.255 x .191	C	6HX	1	2	T100-KM108AA-M6	★	6.5 .255	6.00 .236	80.0 3.150	15.6 .614	5	DIN 371/ANSI
M 8	1.25	33.50 1.319	.318 x .238	C	6HX	1	2	T100-KM108AA-M8	★	8.1 .318	8.00 .315	90.0 3.543	18.7 .736	5	DIN 371/ANSI
M 10	1.50	38.00 1.496	.381 x .286	C	6HX	1	2	T100-KM108AA-M10	★	9.7 .381	10.00 .394	100.0 3.937	20.6 .811	5	DIN 371/ANSI
M 12	1.75	81.90 3.224	.367 x .275	C	6HX	1	2	T100-KM109AA-M12	★	9.3 .367	12.00 .472	110.0 4.331	23.0 .906	5	DIN 376/ANSI
M 14	2.00	80.30 3.161	.429 x .322	C	6HX	1	2	T100-KM109AA-M14	★	10.9 .429	14.00 .551	110.0 4.331	23.0 .906	5	DIN 376/ANSI
M 16	2.00	65.70 2.587	.480 x .360	C	6HX	1	2	T100-KM109AA-M16	★	12.2 .480	16.00 .630	110.0 4.331	23.0 .906	5	DIN 376/ANSI
M 20	2.50	92.50 3.642	.652 x .489	C	6HX	1	2	T100-KM109AA-M20	★	16.6 .652	20.00 .787	140.0 5.512	30.0 1.181	5	DIN 376/ANSI

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

CXSC 2 = radialer Kühlschmierstoffaustritt



C172



C157



E9



E27



E28



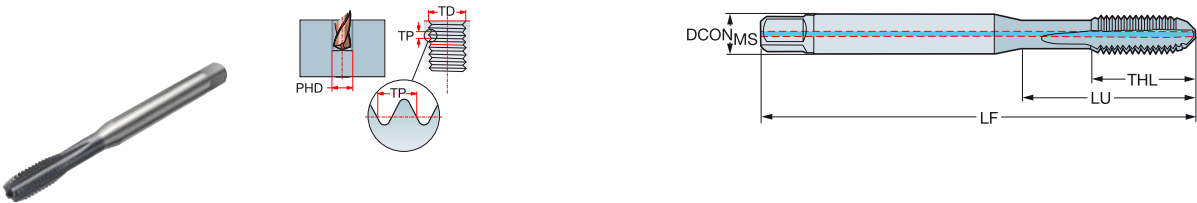
C154

CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



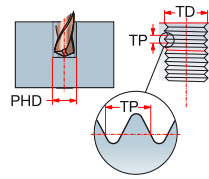
										Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG
M 6	1.00	30.00	6.00 x 4.90	E	6HX	1	1	T100-KM106DA-M6	★	6.0	6.00	80.0	15.0	5	DIN 371
		1.181								.236	.236	3.150	.591		
M 8	1.25	35.00	8.00 x 6.20	E	6HX	1	1	T100-KM106DA-M8	★	8.0	8.00	90.0	18.0	5	DIN 371
		1.378								.315	.315	3.543	.709		
M 10	1.50	39.00	10.00 x 8.00	E	6HX	1	1	T100-KM106DA-M10	★	10.0	10.00	100.0	20.0	5	DIN 371
		1.535								.394	.394	3.937	.787		
M 12	1.75	83.00	9.00 x 7.00	E	6HX	1	1	T100-KM107DA-M12	★	9.0	12.00	110.0	23.0	5	DIN 376
		3.268								.354	.472	4.331	.906		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	2	T100-KM108DA-M6	★	6.0	6.00	80.0	15.0	5	DIN 371
		1.181								.236	.236	3.150	.591		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	2	T100-KM108DA-M8	★	8.0	8.00	90.0	18.0	5	DIN 371
		1.378								.315	.315	3.543	.709		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	2	T100-KM108DA-M10	★	10.0	10.00	100.0	20.0	5	DIN 371
		1.535								.394	.394	3.937	.787		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	2	T100-KM109DA-M12	★	9.0	12.00	110.0	23.0	5	DIN 376
		3.268								.354	.472	4.331	.906		
M 14	2.00	81.00	11.00 x 9.00	C	6HX	1	2	T100-KM109DA-M14	★	11.0	14.00	110.0	25.0	5	DIN 376
		3.189								.433	.551	4.331	.984		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	1	2	T100-KM109DA-M16	★	12.0	16.00	110.0	25.0	5	DIN 376
		2.677								.472	.630	4.331	.984		
M 20	2.50	95.00	16.00 x 12.00	C	6HX	1	2	T100-KM109DA-M20	★	16.0	20.00	140.0	30.0	5	DIN 376
		3.740								.630	.787	5.512	1.181		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt
CXSC 2 = radialer Kühlschmierstoffaustritt

CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch

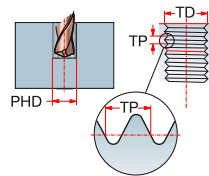
DIN 371

ULDR
SUBSTRATE2.0
HSS-E-PM

N

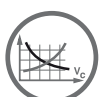
							N	Abmessungen, mm, Zoll							
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6H	T100-NM100DA-M3	★	3.5	3.00	56.0	9.0	3	2.5	DIN 371	
		.709						.138	.118	2.205	.354		.098		
M 4	0.70	21.00	4.50 x 3.40	C	6H	T100-NM100DA-M4	★	4.5	4.00	63.0	12.0	3	3.3	DIN 371	
		.827						.177	.157	2.480	.472		.130		
M 5	0.80	25.00	6.00 x 4.90	C	6H	T100-NM100DA-M5	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371	
		.984						.236	.197	2.756	.512		.165		
M 6	1.00	30.00	6.00 x 4.90	C	6H	T100-NM100DA-M6	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371	
		1.181						.236	.236	3.150	.591		.197		
M 8	1.25	35.00	8.00 x 6.20	C	6H	T100-NM100DA-M8	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371	
		1.378						.315	.315	3.543	.709		.268		
M 10	1.50	39.00	10.00 x 8.00	C	6H	T100-NM100DA-M10	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371	
		1.535						.394	.394	3.937	.787		.335		

DIN 376

ULDR
SUBSTRATE2.0
HSS-E-PM

N

							N	Abmessungen, mm, Zoll							
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
M 12	1.75	83.00	9.00 x 7.00	C	6H	T100-NM101DA-M12	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376	
		3.268						.354	.472	4.331	.906		.402		
M 16	2.00	68.00	12.00 x 9.00	C	6H	T100-NM101DA-M16	★	12.0	16.00	110.0	25.0	4	14.0	DIN 376	
		2.677						.472	.630	4.331	.984		.551		



C172



C157



E9



E27



E28



C154

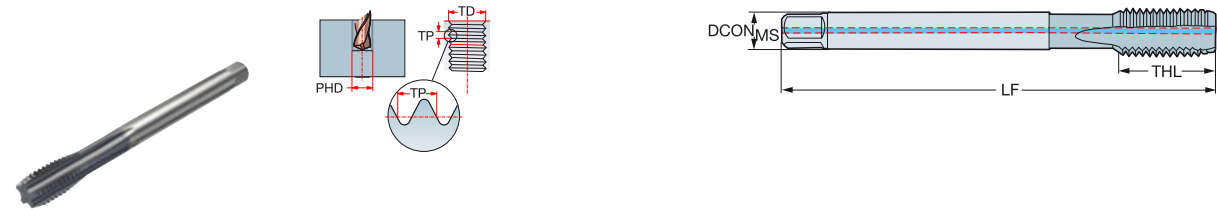
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch Fein

DIN 374

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



										K	Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer			DCON _{MS}	TD	LF	THL	NOF	BSG
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	1	1	T100-KM104DB-M10X100	★	7.0	10.00	90.0	18.0	5	DIN 374	
		2.638								.276	.394	3.543	.709			
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6HX	1	1	T100-KM104DB-M10X125	★	7.0	10.00	100.0	20.0	5	DIN 374	
		3.032								.276	.394	3.937	.787			
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	1	1	T100-KM104DB-M12X125	★	9.0	12.00	100.0	21.0	5	DIN 374	
		2.874								.354	.472	3.937	.827			
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	1	1	T100-KM104DB-M12X150	★	9.0	12.00	100.0	21.0	5	DIN 374	
		2.874								.354	.472	3.937	.827			
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	1	1	T100-KM104DB-M14X150	★	11.0	14.00	100.0	21.0	5	DIN 374	
		2.795								.433	.551	3.937	.827			
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	1	1	T100-KM104DB-M16X150	★	12.0	16.00	100.0	21.0	5	DIN 374	
		2.283								.472	.630	3.937	.827			
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6HX	1	1	T100-KM104DB-M18X150	★	14.0	18.00	110.0	24.0	5	DIN 374	
		2.598								.551	.709	4.331	.945			
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6HX	1	1	T100-KM104DB-M20X150	★	16.0	20.00	125.0	24.0	5	DIN 374	
		3.150								.630	.787	4.921	.945			
MF 10x1	1.00	67.00	7.00 x 5.50	E	6HX	1	1	T100-KM106DB-M10X100	★	7.0	10.00	90.0	18.0	5	DIN 374	
		2.638								.276	.394	3.543	.709			
MF 10x1.25	1.25	77.00	7.00 x 5.50	E	6HX	1	1	T100-KM106DB-M10X125	★	7.0	10.00	100.0	20.0	5	DIN 374	
		3.032								.276	.394	3.937	.787			
MF 12x1.25	1.25	73.00	9.00 x 7.00	E	6HX	1	1	T100-KM106DB-M12X125	★	9.0	12.00	100.0	21.0	5	DIN 374	
		2.874								.354	.472	3.937	.827			
MF 12x1.5	1.50	73.00	9.00 x 7.00	E	6HX	1	1	T100-KM106DB-M12X150	★	9.0	12.00	100.0	21.0	5	DIN 374	
		2.874								.354	.472	3.937	.827			
MF 14x1.5	1.50	71.00	11.00 x 9.00	E	6HX	1	1	T100-KM106DB-M14X150	★	11.0	14.00	100.0	21.0	5	DIN 374	
		2.795								.433	.551	3.937	.827			
MF 16x1.5	1.50	58.00	12.00 x 9.00	E	6HX	1	1	T100-KM106DB-M16X150	★	12.0	16.00	100.0	21.0	5	DIN 374	
		2.283								.472	.630	3.937	.827			
MF 18x1.5	1.50	66.00	14.00 x 11.00	E	6HX	1	1	T100-KM106DB-M18X150	★	14.0	18.00	110.0	24.0	5	DIN 374	
		2.598								.551	.709	4.331	.945			
MF 20x1.5	1.50	80.00	16.00 x 12.00	E	6HX	1	1	T100-KM106DB-M20X150	★	16.0	20.00	125.0	24.0	5	DIN 374	
		3.150								.630	.787	4.921	.945			
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	1	2	T100-KM108DB-M10X100	★	7.0	10.00	90.0	18.0	5	DIN 374	
		2.638								.276	.394	3.543	.709			
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6HX	1	2	T100-KM108DB-M10X125	★	7.0	10.00	100.0	20.0	5	DIN 374	
		3.032								.276	.394	3.937	.787			
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	1	2	T100-KM108DB-M12X125	★	9.0	12.00	100.0	21.0	5	DIN 374	
		2.874								.354	.472	3.937	.827			
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	1	2	T100-KM108DB-M12X150	★	9.0	12.00	100.0	21.0	5	DIN 374	
		2.874								.354	.472	3.937	.827			
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	1	2	T100-KM108DB-M14X150	★	11.0	14.00	100.0	21.0	5	DIN 374	
		2.795								.433	.551	3.937	.827			
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	1	2	T100-KM108DB-M16X150	★	12.0	16.00	100.0	21.0	5	DIN 374	
		2.283								.472	.630	3.937	.827			
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6HX	1	2	T100-KM108DB-M18X150	★	14.0	18.00	110.0	24.0	5	DIN 374	
		2.598								.551	.709	4.331	.945			
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6HX	1	2	T100-KM108DB-M20X150	★	16.0	20.00	125.0	24.0	5	DIN 374	
		3.150								.630	.787	4.921	.945			

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

CXSC 2 = radialer Kühlschmierstoffaustritt



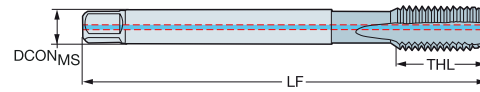
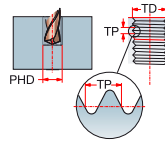
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch Fein

DIN 374

ULDR
SUBSTRATE
COATING

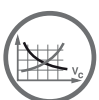
2.5
HM
PVD TIALN



K

									Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCCTR	CNSC	CXSC	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
MF 8x1	1.00	67.00	6.00 x 4.90	C	6HX	1	1	T120M8X1.0	6.0	8.00	90.0	12.0	4	DIN 374
		2.638							.236	.315	3.543	.472		
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	1	1	T120M10X1.0	7.0	10.00	90.0	14.0	4	DIN 374
		2.638							.276	.394	3.543	.551		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	1	1	T120M12X1.5	9.0	12.00	100.0	20.0	4	DIN 374
		2.874							.354	.472	3.937	.787		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	1	1	T120M14X1.5	11.0	14.00	100.0	21.0	4	DIN 374
		2.795							.433	.551	3.937	.827		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt



C172



C157



E9



E28



C154

CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch Fein
DIN 374

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



B

										Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{US}	THCHT	TCTR	Bestellnummer	DIN	DCON _{US}	TD	LF	THL	NOF	PHD	BSG					
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	T100-KM100DB-M10X100		7.0	10.00	90.0	18.0	5	9.0	DIN 374					
		2.638						.276	.394	3.543	.709		.354						
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6HX	T100-KM100DB-M10X125		7.0	10.00	100.0	20.0	5	8.8	DIN 374					
		3.032						.276	.394	3.937	.787		.346						
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	T100-KM100DB-M12X125		9.0	12.00	100.0	21.0	5	10.8	DIN 374					
		2.874						.354	.472	3.937	.827		.423						
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	T100-KM100DB-M12X150		9.0	12.00	100.0	21.0	5	10.5	DIN 374					
		2.874						.354	.472	3.937	.827		.413						
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	T100-KM100DB-M14X150		11.0	14.00	100.0	21.0	5	12.5	DIN 374					
		2.795						.433	.551	3.937	.827		.492						
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	T100-KM100DB-M16X150		12.0	16.00	100.0	21.0	5	14.5	DIN 374					
		2.283						.472	.630	3.937	.827		.571						
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6HX	T100-KM100DB-M18X150		14.0	18.00	110.0	24.0	5	16.5	DIN 374					
		2.598						.551	.709	4.331	.945		.650						
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6HX	T100-KM100DB-M20X150		16.0	20.00	125.0	24.0	5	18.5	DIN 374					
		3.150						.630	.787	4.921	.945		.728						
MF 10x1	1.00	67.00	7.00 x 5.50	E	6HX	T100-KM102DB-M10X100		7.0	10.00	90.0	18.0	5	9.0	DIN 374					
		2.638						.276	.394	3.543	.709		.354						
MF 10x1.25	1.25	77.00	7.00 x 5.50	E	6HX	T100-KM102DB-M10X125		7.0	10.00	100.0	20.0	5	8.8	DIN 374					
		3.032						.276	.394	3.937	.787		.346						
MF 12x1.25	1.25	73.00	9.00 x 7.00	E	6HX	T100-KM102DB-M12X125		9.0	12.00	100.0	21.0	5	10.8	DIN 374					
		2.874						.354	.472	3.937	.827		.423						
MF 12x1.5	1.50	73.00	9.00 x 7.00	E	6HX	T100-KM102DB-M12X150		9.0	12.00	100.0	21.0	5	10.5	DIN 374					
		2.874						.354	.472	3.937	.827		.413						
MF 14x1.5	1.50	71.00	11.00 x 9.00	E	6HX	T100-KM102DB-M14X150		11.0	14.00	100.0	21.0	5	12.5	DIN 374					
		2.795						.433	.551	3.937	.827		.492						
MF 16x1.5	1.50	58.00	12.00 x 9.00	E	6HX	T100-KM102DB-M16X150		12.0	16.00	100.0	21.0	5	14.5	DIN 374					
		2.283						.472	.630	3.937	.827		.571						
MF 18x1.5	1.50	66.00	14.00 x 11.00	E	6HX	T100-KM102DB-M18X150		14.0	18.00	110.0	24.0	5	16.5	DIN 374					
		2.598						.551	.709	4.331	.945		.650						
MF 20x1.5	1.50	80.00	16.00 x 12.00	E	6HX	T100-KM102DB-M20X150		16.0	20.00	125.0	24.0	5	18.5	DIN 374					
		3.150						.630	.787	4.921	.945		.728						

C

D

E

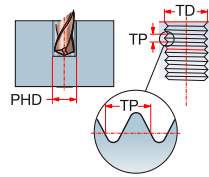
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch Fein

DIN 374/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TiAlN



							Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	1210	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
MF 10x1	1.00	38.00	.361 x .286	C	6HX	T100-KM100AB-M10X100	★	9.7	10.00	90.0	20.6	5	9.0	DIN 374/ANSI		
		1.496						.381	.394	3.543	.811		.354			
MF 12x1.25	1.25	71.90	.367 x .275	C	6HX	T100-KM101AB-M12X125	★	9.3	12.00	100.0	23.0	5	10.8	DIN 374/ANSI		
		2.831						.367	.472	3.937	.906		.423			
MF 12x1.5	1.50	71.90	.367 x .275	C	6HX	T100-KM101AB-M12X150	★	9.3	12.00	100.0	23.0	5	10.5	DIN 374/ANSI		
		2.831						.367	.472	3.937	.906		.413			
MF 14x1.5	1.50	70.30	.429 x .322	C	6HX	T100-KM101AB-M14X150	★	10.9	14.00	100.0	23.0	5	12.5	DIN 374/ANSI		
		2.768						.429	.551	3.937	.906		.492			



C172



C157



E9



E27



C154

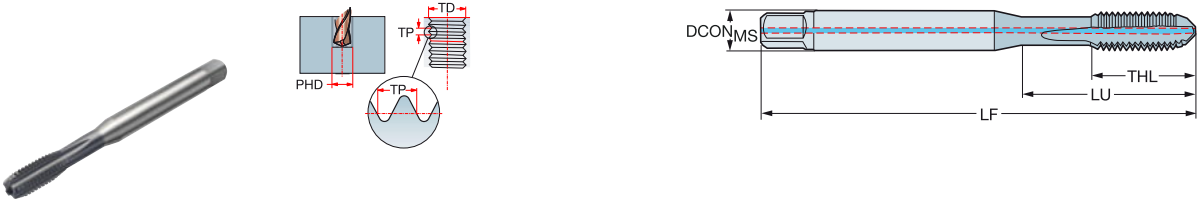
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: Metrisch Fein

DIN 374/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



										Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG	
MF 10x1.25	1.25	38.00	.381 x .286	C	6HX	1	1	T100-KM104AB-M10X125	★	9.7	10.00	100.0	20.6	5	DIN 374/ANSI	
		1.496								.381	.394	3.937	.811			
MF 14x1.5	1.50	70.30	.429 x .322	C	6HX	1	1	T100-KM105AB-M14X150	★	10.9	14.00	100.0	23.0	5	DIN 374/ANSI	
		2.768								.429	.551	3.937	.906			
MF 10x1.25	1.25	38.00	.381 x .286	C	6HX	1	2	T100-KM108AB-M10X125	★	9.7	10.00	100.0	20.6	5	DIN 374/ANSI	
		1.496								.381	.394	3.937	.811			
MF 12x1.5	1.50	71.90	.367 x .275	C	6HX	1	2	T100-KM109AB-M12X150	★	9.3	12.00	100.0	23.0	5	DIN 374/ANSI	
		2.831								.367	.472	3.937	.906			
MF 14x1.5	1.50	70.30	.429 x .322	C	6HX	1	2	T100-KM109AB-M14X150	★	10.9	14.00	100.0	23.0	5	DIN 374/ANSI	
		2.768								.429	.551	3.937	.906			

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt
CXSC 2 = radialer Kühlschmierstoffaustritt

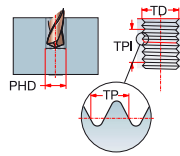
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: UNC

DIN 2184-1/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



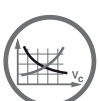
B

										Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D ₁₀	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
UNC 1/4-20	20.00	25.00 .984	.255 x .191	C	2BX	T100-KM100AE-1/4	★	6.5 .255	6.35 .250	80.0 3.150	15.6 .614	5	5.1 .201	DIN 2184-1/ANSI		
UNC 5/16-18	18.00	33.50 1.319	.318 x .238	C	2BX	T100-KM100AE-5/16	★	8.1 .318	7.94 .313	90.0 3.543	18.7 .736	5	6.6 .260	DIN 2184-1/ANSI		
UNC 3/8-16	16.00	38.00 1.496	.381 x .286	C	2BX	T100-KM100AE-3/8	★	9.7 .381	9.53 .375	100.0 3.937	20.6 .811	5	8.0 .315	DIN 2184-1/ANSI		
UNC 7/16-14	14.00	72.70 2.862	.323 x .242	C	2BX	T100-KM101AE-7/16	★	8.2 .323	11.11 .438	100.0 3.937	20.0 .787	5	9.4 .370	DIN 2184-1/ANSI		
UNC 1/2-13	13.00	81.90 3.224	.367 x .275	C	2BX	T100-KM101AE-1/2	★	9.3 .367	12.70 .500	110.0 4.331	23.0 .906	5	10.8 .425	DIN 2184-1/ANSI		
UNC 5/8-11	11.00	65.70 2.587	.480 x .360	C	2BX	T100-KM101AE-5/8	★	12.2 .480	15.88 .625	110.0 4.331	23.0 .906	5	13.5 .531	DIN 2184-1/ANSI		
UNC 3/4-10	10.00	77.50 3.051	.590 x .442	C	2BX	T100-KM101AE-3/4	★	15.0 .590	19.05 .750	125.0 4.921	30.0 1.181	5	16.5 .650	DIN 2184-1/ANSI		
UNC 7/8-9	9.00	90.95 3.581	.697 x .523	C	2BX	T100-KM101AE-7/8	★	17.7 .697	22.23 .875	140.0 5.512	34.0 1.339	5	19.5 .768	DIN 2184-1/ANSI		
UNC 1/4-20	20.00	25.00 .984	.255 x .191	E	2BX	T100-KM102AE-1/4	★	6.5 .255	6.35 .250	80.0 3.150	15.6 .614	5	5.1 .201	DIN 2184-1/ANSI		
UNC 5/16-18	18.00	33.50 1.319	.318 x .238	E	2BX	T100-KM102AE-5/16	★	8.1 .318	7.94 .313	90.0 3.543	18.7 .736	5	6.6 .260	DIN 2184-1/ANSI		
UNC 3/8-16	16.00	38.00 1.496	.381 x .286	E	2BX	T100-KM102AE-3/8	★	9.7 .381	9.53 .375	100.0 3.937	20.6 .811	5	8.0 .315	DIN 2184-1/ANSI		
UNC 1/2-13	13.00	81.90 3.224	.367 x .275	E	2BX	T100-KM103AE-1/2	★	9.3 .367	12.70 .500	110.0 4.331	23.0 .906	5	10.8 .425	DIN 2184-1/ANSI		
UNC 5/8-11	11.00	65.70 2.587	.480 x .360	E	2BX	T100-KM103AE-5/8	★	12.2 .480	15.88 .625	110.0 4.331	23.0 .906	5	13.5 .531	DIN 2184-1/ANSI		
UNC 3/4-10	10.00	77.50 3.051	.590 x .442	E	2BX	T100-KM103AE-3/4	★	15.0 .590	19.05 .750	125.0 4.921	30.0 1.181	5	16.5 .650	DIN 2184-1/ANSI		
UNC 7/8-9	9.00	90.95 3.581	.697 x .523	E	2BX	T100-KM103AE-7/8	★	17.7 .697	22.23 .875	140.0 5.512	34.0 1.339	5	19.5 .768	DIN 2184-1/ANSI		

C

D

E



C172



C157



E9



E27



C154

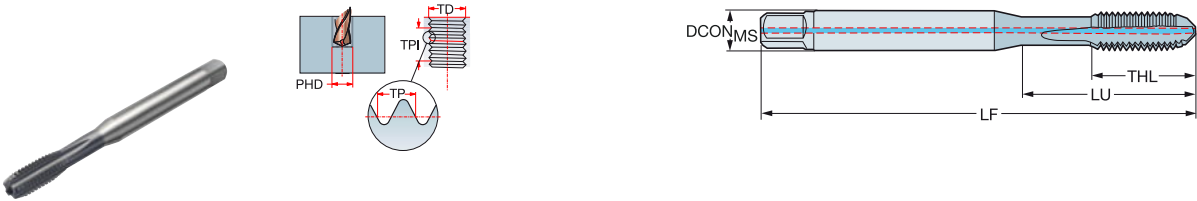
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: UNC

DIN 2184-1/ANSI, DIN 376/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



										Abmessungen, mm, Zoll
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS} TD LF THL NOF BSG
UNC 1/4-20	20.00	25.00 .984	.255 x .191	C	2BX	1	1	T100-KM104AE-1/4	★	6.5 6.35 80.0 15.6 5 DIN 2184-1/ANSI
UNC 5/16-18	18.00	33.50 1.319	.318 x .238	C	2BX	1	1	T100-KM104AE-5/16	★	8.1 7.94 90.0 18.7 5 DIN 2184-1/ANSI
UNC 3/8-16	16.00	38.00 1.496	.381 x .286	C	2BX	1	1	T100-KM104AE-3/8	★	9.7 9.53 100.0 20.6 5 DIN 2184-1/ANSI
UNC 7/16-14	14.00	72.70 2.862	.323 x .242	C	2BX	1	1	T100-KM105AE-7/16	★	8.2 11.11 100.0 20.0 5 DIN 376/ANSI
UNC 1/2-13	13.00	81.90 3.224	.367 x .275	C	2BX	1	1	T100-KM105AE-1/2	★	9.3 12.70 110.0 23.0 5 DIN 2184-1/ANSI
UNC 1/4-20	20.00	25.00 .984	.255 x .191	E	2BX	1	1	T100-KM106AE-1/4	★	6.5 6.35 80.0 15.6 5 DIN 2184-1/ANSI
UNC 5/16-18	18.00	33.50 1.319	.318 x .238	E	2BX	1	1	T100-KM106AE-5/16	★	8.1 7.94 90.0 18.7 5 DIN 2184-1/ANSI
UNC 3/8-16	16.00	38.00 1.496	.381 x .286	E	2BX	1	1	T100-KM106AE-3/8	★	9.7 9.53 100.0 20.6 5 DIN 2184-1/ANSI
UNC 1/2-13	13.00	81.90 3.224	.367 x .275	E	2BX	1	1	T100-KM107AE-1/2	★	9.3 12.70 110.0 23.0 5 DIN 2184-1/ANSI
UNC 1/4-20	20.00	25.00 .984	.255 x .191	C	2BX	1	2	T100-KM108AE-1/4	★	6.5 6.35 80.0 15.6 5 DIN 2184-1/ANSI
UNC 5/16-18	18.00	33.50 1.319	.318 x .238	C	2BX	1	2	T100-KM108AE-5/16	★	8.1 7.94 90.0 18.7 5 DIN 2184-1/ANSI
UNC 3/8-16	16.00	38.00 1.496	.381 x .286	C	2BX	1	2	T100-KM108AE-3/8	★	9.7 9.53 100.0 20.6 5 DIN 2184-1/ANSI
UNC 7/16-14	14.00	72.70 2.862	.323 x .242	C	2BX	1	2	T100-KM109AE-7/16	★	8.2 11.11 100.0 20.0 5 DIN 2184-1/ANSI
UNC 1/2-13	13.00	81.90 3.224	.367 x .275	C	2BX	1	2	T100-KM109AE-1/2	★	9.3 12.70 110.0 23.0 5 DIN 2184-1/ANSI

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt
CXSC 2 = radialer Kühlschmierstoffaustritt

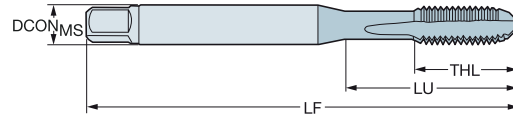
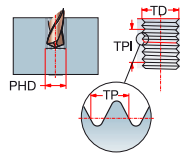
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: UNF

DIN 2184-1/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



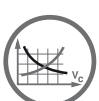
B

							Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D ₁₀	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
UNF 1/4-28	28.00	25.00 .984	.255 x .191	C	2BX	T100-KM100AF-1/4		6.5 .255	6.35 .250	80.0 3.150	15.6 .614	5	5.5 .217	DIN 2184-1/ANSI		
UNF 5/16-24	24.00	33.50 1.319	.318 x .238	C	2BX	T100-KM100AF-5/16	★	8.1 .318	7.94 .313	90.0 3.543	18.7 .736	5	6.9 .272	DIN 2184-1/ANSI		
UNF 3/8-24	24.00	38.00 1.496	.381 x .286	C	2BX	T100-KM100AF-3/8	★	9.7 .381	9.53 .375	90.0 3.543	20.6 .811	5	8.5 .335	DIN 2184-1/ANSI		
UNF 7/16-20	20.00	72.70 2.862	.323 x .242	C	2BX	T100-KM101AF-7/16	★	8.2 .323	11.11 .438	100.0 3.937	20.0 .787	5	9.9 .390	DIN 2184-1/ANSI		
UNF 1/2-20	20.00	71.90 2.831	.367 x .275	C	2BX	T100-KM101AF-1/2	★	9.3 .367	12.70 .500	100.0 3.937	23.0 .906	5	11.5 .453	DIN 2184-1/ANSI		
UNF 3/4-16	16.00	62.50 2.461	.590 x .442	C	2BX	T100-KM101AF-3/4	★	15.0 .590	19.05 .750	110.0 4.331	25.0 .984	5	17.5 .689	DIN 2184-1/ANSI		
UNF 1/4-28	28.00	25.00 .984	.255 x .191	E	2BX	T100-KM102AF-1/4	★	6.5 .255	6.35 .250	80.0 3.150	15.6 .614	5	5.5 .217	DIN 2184-1/ANSI		
UNF 3/8-24	24.00	38.00 1.496	.381 x .286	E	2BX	T100-KM102AF-3/8	★	9.7 .381	9.53 .375	90.0 3.543	20.6 .811	5	8.5 .335	DIN 2184-1/ANSI		
UNF 7/16-20	20.00	72.70 2.862	.323 x .242	E	2BX	T100-KM103AF-7/16	★	8.2 .323	11.11 .438	100.0 3.937	20.0 .787	5	9.9 .390	DIN 2184-1/ANSI		
UNF 1/2-20	20.00	71.90 2.831	.367 x .275	E	2BX	T100-KM103AF-1/2	★	9.3 .367	12.70 .500	100.0 3.937	23.0 .906	5	11.5 .453	DIN 2184-1/ANSI		
UNF 5/8-18	18.00	55.70 2.193	.480 x .360	E	2BX	T100-KM103AF-5/8	★	12.2 .480	15.88 .625	100.0 3.937	23.0 .906	5	14.5 .571	DIN 2184-1/ANSI		
UNF 3/4-16	16.00	62.50 2.461	.590 x .442	E	2BX	T100-KM103AF-3/4	★	15.0 .590	19.05 .750	110.0 4.331	25.0 .984	5	17.5 .689	DIN 2184-1/ANSI		
UNF 7/8-14	14.00	75.95 2.990	.697 x .523	E	2BX	T100-KM103AF-7/8	★	17.7 .697	22.23 .875	125.0 4.921	25.0 .984	5	20.4 .803	DIN 2184-1/ANSI		

C

D

E



C172



C157



E9



E27



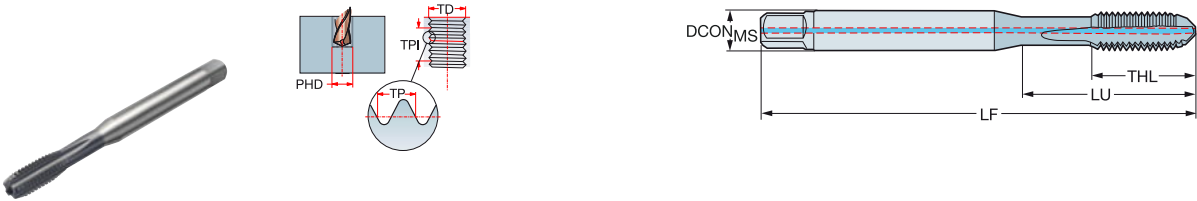
C154

CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: UNF
DIN 2184-1/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TIALN



										Abmessungen, mm, Zoll
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS} TD LF THL NOF BSG
UNF 1/4-28	28.00	25.00 .984	.255 x .191	C	2BX	1	1	T100-KM104AF-1/4	★	6.5 6.35 80.0 15.6 5 DIN 2184-1/ANSI
UNF 5/16-24	24.00	33.50 1.319	.318 x .238	C	2BX	1	1	T100-KM104AF-5/16	★	.255 .250 3.150 .614 8.1 7.94 90.0 18.7 5 DIN 2184-1/ANSI
UNF 3/8-24	24.00	38.00 1.496	.381 x .286	C	2BX	1	1	T100-KM104AF-3/8	★	.318 .313 3.543 .736 9.7 9.53 90.0 20.6 5 DIN 2184-1/ANSI
UNF 7/16-20	20.00	72.70 2.862	.323 x .242	C	2BX	1	1	T100-KM105AF-7/16	★	.381 .375 3.543 .811 8.2 11.11 100.0 20.0 5 DIN 2184-1/ANSI
UNF 1/2-20	20.00	71.90 2.831	.367 x .275	C	2BX	1	1	T100-KM105AF-1/2	★	.323 .438 3.937 .787 9.3 12.70 100.0 23.0 5 DIN 2184-1/ANSI
UNF 1/4-28	28.00	25.00 .984	.255 x .191	E	2BX	1	1	T100-KM106AF-1/4	★	.367 .500 3.937 .906 6.5 6.35 80.0 15.6 5 DIN 2184-1/ANSI
UNF 5/16-24	24.00	33.50 1.319	.318 x .238	E	2BX	1	1	T100-KM106AF-5/16	★	.255 .250 3.150 .614 8.1 7.94 90.0 18.7 5 DIN 2184-1/ANSI
UNF 3/8-24	24.00	38.00 1.496	.381 x .286	E	2BX	1	1	T100-KM106AF-3/8	★	.318 .313 3.543 .736 9.7 9.53 90.0 20.6 5 DIN 2184-1/ANSI
UNF 7/16-20	20.00	72.70 2.862	.323 x .242	E	2BX	1	1	T100-KM107AF-7/16	★	.381 .375 3.543 .811 8.2 11.11 100.0 20.0 5 DIN 2184-1/ANSI
UNF 1/2-20	20.00	71.90 2.831	.367 x .275	E	2BX	1	1	T100-KM107AF-1/2	★	.323 .438 3.937 .787 9.3 12.70 100.0 23.0 5 DIN 2184-1/ANSI
UNF 1/4-28	28.00	25.00 .984	.255 x .191	C	2BX	1	2	T100-KM108AF-1/4	★	.367 .500 3.937 .906 6.5 6.35 80.0 15.6 5 DIN 2184-1/ANSI
UNF 5/16-24	24.00	33.50 1.319	.318 x .238	C	2BX	1	2	T100-KM108AF-5/16	★	.255 .250 3.150 .614 8.1 7.94 90.0 18.7 5 DIN 2184-1/ANSI
UNF 3/8-24	24.00	38.00 1.496	.381 x .286	C	2BX	1	2	T100-KM108AF-3/8	★	.318 .313 3.543 .736 9.7 9.53 90.0 20.6 5 DIN 2184-1/ANSI
UNF 7/16-20	20.00	72.70 2.862	.323 x .242	C	2BX	1	2	T100-KM109AF-7/16	★	.381 .375 3.543 .811 8.2 11.11 100.0 20.0 5 DIN 2184-1/ANSI
UNF 1/2-20	20.00	71.90 2.831	.367 x .275	C	2BX	1	2	T100-KM109AF-1/2	★	.323 .438 3.937 .787 9.3 12.70 100.0 23.0 5 DIN 2184-1/ANSI

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt
CXSC 2 = radialer Kühlschmierstoffaustritt

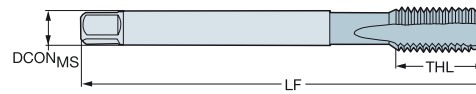
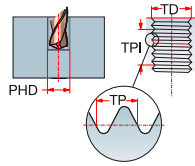
CoroTap™ 100 gerade genuteter Gewindebohrer

Gewindeform: G

DIN 5156

ULDR
SUBSTRATE
COATING

2.0
HSS-E
PVD FEN



K

B

						Abmessungen, mm, Zoll							
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
G 1/8-28	28.00	67.00	7.00 x 5.50	C	NORMAL	E4161/8	7.0	9.73	90.0	20.0	4	DIN 5156	
		2.638					.276	.383	3.543	.787			
G 1/4-19	19.00	71.00	11.00 x 9.00	C	NORMAL	E4161/4	11.0	13.16	100.0	21.0	4	DIN 5156	
		2.795					.433	.518	3.937	.827			
G 3/8-19	19.00	58.00	12.00 x 9.00	C	NORMAL	E4163/8	12.0	16.66	100.0	21.0	5	DIN 5156	
		2.283					.472	.656	3.937	.827			
G 1/2-14	14.00	80.00	16.00 x 12.00	C	NORMAL	E4161/2	16.0	20.96	125.0	24.0	5	DIN 5156	
		3.150					.630	.825	4.921	.945			
G 3/4-14	14.00	77.00	20.00 x 16.00	C	NORMAL	E4163/4	20.0	26.44	140.0	28.0	6	DIN 5156	
		3.032					.787	1.041	5.512	1.102			
G 1"-11	11.00	93.00	25.00 x 20.00	C	NORMAL	E4161	25.0	33.25	160.0	30.0	6	DIN 5156	
		3.661					.984	1.309	6.299	1.181			

C

D

E



C172



C157



E9



C154

CoroTap™ 200

Anwendungen

- Nur für Durchgangsbohrungen
- In vielen Gewindeformen und -standards erhältlich
- Bis zu 3xD, abhängig vom Werkstoff



Vorteile und Merkmale

- Anschnitt B (3.5-5 Steigung) für hohe Prozesssicherheit
- Schneidkantenbehandlung für reduzierte Axialkraft und geringeres Drehmoment; sorgt für einen „weicheren“ Lauf des Werkzeugs; minimiert Schneidenausbrüche und verbessert Oberflächengüte, Standzeit und Spanbildung
- Gewindebohrer aus HSS-Pulverschnellstahl für bessere Stabilität, Verschleißfestigkeit und Standzeit
- Es sind verschiedene Beschichtungen und Sorten verfügbar

- Gewindebohrer, gerade genutet mit Schälanschnitt
- Transportiert Späne nach vorn
- Einsatz bei Durchgangsbohrungen



www.sandvik.coromant.com/corotap200



CoroChuck™ 970, siehe Katalog Rotierende Werkzeuge.

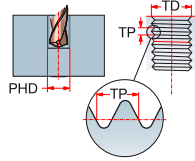
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch

C-DIN371, DIN 371, DIN 376

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TiAlN



30-48 HRC

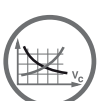
B

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	12.00	4.50 x 3.40	B	6H	E324M3	4.5	3.00	63.0	12.0	3	C-DIN 371	
	.472						.177	.118	2.480	.472			
M 4	0.70	13.00	6.00 x 4.90	B	6H	E324M4	6.0	4.00	70.0	13.0	3	C-DIN 371	
	.512						.236	.157	2.756	.512			
M 5	0.80	15.00	6.00 x 4.90	B	6H	E324M5	6.0	5.00	80.0	15.0	3	C-DIN 371	
	.591						.236	.197	3.150	.591			
M 6	1.00	18.00	8.00 x 6.20	B	6H	E324M6	8.0	6.00	90.0	18.0	3	C-DIN 371	
	.709						.315	.236	3.543	.709			
M 8	1.25	20.00	10.00 x 8.00	B	6H	E324M8	10.0	8.00	100.0	20.0	3	C-DIN 371	
	.787						.394	.315	3.937	.787			
M 10	1.50	39.00	10.00 x 8.00	B	6H	E324M10	10.0	10.00	100.0	20.0	3	DIN 371	
	1.535						.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	B	6H	E326M12	9.0	12.00	110.0	23.0	4	DIN 376	
	3.268						.354	.472	4.331	.906			
M 14	2.00	81.00	11.00 x 9.00	B	6H	E326M14	11.0	14.00	110.0	25.0	4	DIN 376	
	3.189						.433	.551	4.331	.984			
M 16	2.00	68.00	12.00 x 9.00	B	6H	E326M16	12.0	16.00	110.0	25.0	4	DIN 376	
	2.677						.472	.630	4.331	.984			
M 18	2.50	81.00	14.00 x 11.00	B	6H	E326M18	14.0	18.00	125.0	30.0	4	DIN 376	
	3.189						.551	.709	4.921	1.181			
M 20	2.50	95.00	16.00 x 12.00	B	6H	E326M20	16.0	20.00	140.0	30.0	4	DIN 376	
	3.740						.630	.787	5.512	1.181			

C

D

E



C174



C157



E9



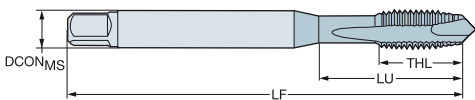
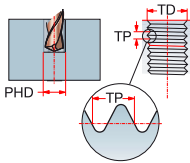
C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch
C-DIN/ANSI, DIN/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TiAlN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	13.00	.168 x .131	B	6H	E854M3	4.3	3.00	63.0	14.7	3	C-DIN/ANSI	
		.512					.168	.118	2.480	.579			
M 4	0.70	15.10	.194 x .152	B	6H	E854M4	4.9	4.00	70.0	15.1	3	C-DIN/ANSI	
		.594					.194	.157	2.756	.594			
M 5	0.80	17.00	.255 x .191	B	6H	E854M5	6.5	5.00	80.0	17.0	3	C-DIN/ANSI	
		.669					.255	.197	3.150	.669			
M 6	1.00	20.20	.318 x .238	B	6H	E854M6	8.1	6.00	90.0	20.2	3	C-DIN/ANSI	
		.795					.318	.236	3.543	.795			
M 8	1.25	20.00	.381 x .286	B	6H	E854M8	9.7	8.00	100.0	22.8	3	C-DIN/ANSI	
		.787					.381	.315	3.937	.898			
M 10	1.50	37.80	.381 x .286	B	6H	E854M10	9.7	10.00	100.0	20.0	3	C-DIN/ANSI	
		1.488					.381	.394	3.937	.787			
M 12	1.75	86.02	.367 x .275	B	6H	E854M12	9.3	12.00	110.0	23.0	4	DIN/ANSI	
		3.386					.367	.472	4.331	.906			
M 14	2.00	84.82	.429 x .322	B	6H	E854M14	10.9	14.00	110.0	23.0	4	DIN/ANSI	
		3.339					.429	.551	4.331	.906			
M 16	2.00	70.86	.480 x .360	B	6H	E854M16	12.2	16.00	110.0	23.0	4	DIN/ANSI	
		2.790					.480	.630	4.331	.906			
M 18	2.50	84.69	.542 x .406	B	6H	E854M18	13.8	18.00	125.0	30.0	4	DIN/ANSI	
		3.334					.542	.709	4.921	1.181			
M 20	2.50	97.58	.652 x .489	B	6H	E854M20	16.6	20.00	140.0	30.0	4	DIN/ANSI	
		3.842					.652	.787	5.512	1.181			

C

D

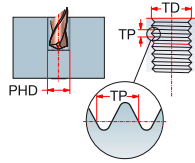
E



CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch

DIN 371, DIN 376

ULDR
SUBSTRATE
COATING3.0
HSS-E-PM
PVD TiAlN

						Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 1	0.25	20.00	2.50 x 2.10	B	5HX	EP03PM1	2.5	1.00	40.0	5.0	2	DIN 371
		.787					.098	.039	1.575	.197		
M 1.2	0.25	20.00	2.50 x 2.10	B	5HX	EP03PM1.2	2.5	1.20	40.0	5.0	2	DIN 371
		.787					.098	.047	1.575	.197		
M 1.4	0.30	20.00	2.50 x 2.10	B	5HX	EP03PM1.4	2.5	1.40	40.0	6.5	2	DIN 371
		.787					.098	.055	1.575	.256		
M 1.6	0.35	20.00	2.50 x 2.10	B	6HX	EP03PM1.6	2.5	1.60	40.0	7.0	2	DIN 371
		.787					.098	.063	1.575	.276		
M 1.8	0.35	20.00	2.50 x 2.10	B	6HX	EP03PM1.8	2.5	1.80	40.0	7.0	2	DIN 371
		.787					.098	.071	1.575	.276		
M 2	0.40	9.00	2.80 x 2.10	B	6HX	EP03PM2	2.8	2.00	45.0	6.0	2	DIN 371
		.354					.110	.079	1.772	.236		
M 2.2	0.45	12.00	2.80 x 2.10	B	6HX	EP03PM2.2	2.8	2.20	45.0	7.0	2	DIN 371
		.472					.110	.087	1.772	.276		
M 2.3	0.40	12.00	2.80 x 2.10	B	6HX	EP03PM2.3	2.8	2.30	45.0	7.0	2	DIN 371
		.472					.110	.091	1.772	.276		
M 2.5	0.45	12.50	2.80 x 2.10	B	6HX	EP03PM2.5	2.8	2.50	50.0	8.0	2	DIN 371
		.492					.110	.098	1.969	.315		
M 3	0.50	18.00	3.50 x 2.70	B	6HX	EP03PM3	3.5	3.00	56.0	8.9	3	DIN 371
		.709					.138	.118	2.205	.350		
M 3.5	0.60	20.00	4.00 x 3.00	B	6HX	EP03PM3.5	4.0	3.50	56.0	10.8	3	DIN 371
		.787					.157	.138	2.205	.425		
M 4	0.70	21.00	4.50 x 3.40	B	6HX	EP03PM4	4.5	4.00	63.0	11.7	3	DIN 371
		.827					.177	.157	2.480	.461		
M 4	0.70	43.00	2.80 x 2.10	B	6HX	EP03PM4DIN376	2.8	4.00	63.0	12.0	3	DIN 376
		1.693					.110	.157	2.480	.472		
M 5	0.80	25.00	6.00 x 4.90	B	6HX	EP03PM5	6.0	5.00	70.0	12.6	3	DIN 371
		.984					.236	.197	2.756	.496		
M 5	0.80	49.00	3.50 x 2.70	B	6HX	EP03PM5DIN376	3.5	5.00	70.0	13.2	3	DIN 376
		1.929					.138	.197	2.756	.520		
M 6	1.00	30.00	6.00 x 4.90	B	6HX	EP03PM6	6.0	6.00	80.0	14.5	3	DIN 371
		1.181					.236	.236	3.150	.571		
M 6	1.00	59.00	4.50 x 3.40	B	6HX	EP03PM6DIN376	4.5	6.00	80.0	15.1	3	DIN 376
		2.323					.177	.236	3.150	.594		
M 7	1.00	30.00	7.00 x 5.50	B	6HX	EP03PM7	7.0	7.00	80.0	14.5	3	DIN 371
		1.181					.276	.276	3.150	.571		
M 8	1.25	35.00	8.00 x 6.20	B	6HX	EP03PM8	8.0	8.00	90.0	17.4	3	DIN 371
		1.378					.315	.315	3.543	.685		
M 8	1.25	67.00	6.00 x 4.90	B	6HX	EP03PM8DIN376	6.0	8.00	90.0	18.0	3	DIN 376
		2.638					.236	.315	3.543	.709		
M 10	1.50	39.00	10.00 x 8.00	B	6HX	EP03PM10	10.0	10.00	100.0	19.2	3	DIN 371
		1.535					.394	.394	3.937	.756		
M 10	1.50	77.00	7.00 x 5.50	B	6HX	EP03PM10DIN376	7.0	10.00	100.0	19.8	3	DIN 376
		3.032					.276	.394	3.937	.780		
M 12	1.75	83.00	9.00 x 7.00	B	6HX	EP03PM12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268					.354	.472	4.331	.906		
M 14	2.00	81.00	11.00 x 9.00	B	6HX	EP03PM14	11.0	14.00	110.0	25.0	4	DIN 376
		3.189					.433	.551	4.331	.984		
M 16	2.00	68.00	12.00 x 9.00	B	6HX	EP03PM16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677					.472	.630	4.331	.984		
M 18	2.50	81.00	14.00 x 11.00	B	6HX	EP03PM18	14.0	18.00	125.0	30.0	4	DIN 376
		3.189					.551	.709	4.921	1.181		
M 20	2.50	95.00	16.00 x 12.00	B	6HX	EP03PM20	16.0	20.00	140.0	30.0	4	DIN 376
		3.740					.630	.787	5.512	1.181		



C174



C157



E9

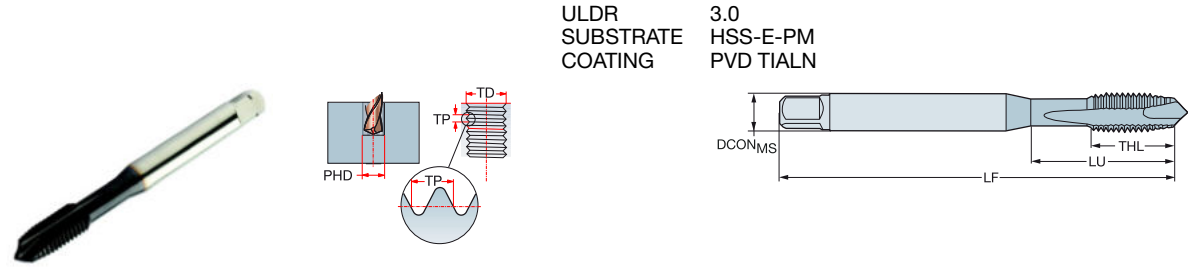


C154



CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 22	2.50	93.00	18.00 x 14.50	B	6HX	EP03PM22	18.0	22.00	140.0	34.0	4	DIN 376	
		3.661					.709	.866	5.512	1.339			
M 24	3.00	113.00	18.00 x 14.50	B	6HX	EP03PM24	18.0	24.00	160.0	38.0	4	DIN 376	
		4.449					.709	.945	6.299	1.496			
M 27	3.00	97.00	20.00 x 16.00	B	6HX	EP03PM27	20.0	27.00	160.0	38.0	4	DIN 376	
		3.819					.787	1.063	6.299	1.496			
M 30	3.50	115.00	22.00 x 18.00	B	6HX	EP03PM30	22.0	30.00	180.0	45.0	4	DIN 376	
		4.528					.866	1.181	7.087	1.772			

C

D

E



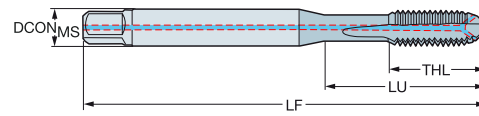
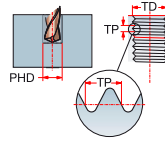
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch

DIN 371, DIN 376

ULDR
SUBSTRATE
COATING

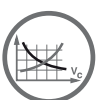
3.0
HSS-E-PM
PVD TiAlN



≤350HB

									Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 4	0.70	21.00	4.50 x 3.40	B	6HX	1	2	EP09PM4	4.5	4.00	63.0	11.7	3	DIN 371
	.827								.177	.157	2.480	.461		
M 5	0.80	25.00	6.00 x 4.90	B	6HX	1	2	EP09PM5	6.0	5.00	70.0	12.6	3	DIN 371
	.984								.236	.197	2.756	.496		
M 6	1.00	30.00	6.00 x 4.90	B	6HX	1	2	EP09PM6	6.0	6.00	80.0	14.5	3	DIN 371
	1.181								.236	.236	3.150	.571		
M 8	1.25	35.00	8.00 x 6.20	B	6HX	1	2	EP09PM8	8.0	8.00	90.0	17.4	3	DIN 371
	1.378								.315	.315	3.543	.685		
M 10	1.50	39.00	10.00 x 8.00	B	6HX	1	2	EP09PM10	10.0	10.00	100.0	19.2	3	DIN 371
	1.535								.394	.394	3.937	.756		
M 12	1.75	83.00	9.00 x 7.00	B	6HX	1	2	EP09PM12	9.0	12.00	110.0	23.0	4	DIN 376
	3.268								.354	.472	4.331	.906		
M 14	2.00	81.00	11.00 x 9.00	B	6HX	1	2	EP09PM14	11.0	14.00	110.0	25.0	4	DIN 376
	3.189								.433	.551	4.331	.984		
M 16	2.00	68.00	12.00 x 9.00	B	6HX	1	2	EP09PM16	12.0	16.00	110.0	25.0	4	DIN 376
	2.677								.472	.630	4.331	.984		
M 18	2.50	81.00	14.00 x 11.00	B	6HX	1	2	EP09PM18	14.0	18.00	125.0	30.0	4	DIN 376
	3.189								.551	.709	4.921	1.181		
M 20	2.50	95.00	16.00 x 12.00	B	6HX	1	2	EP09PM20	16.0	20.00	140.0	30.0	4	DIN 376
	3.740								.630	.787	5.512	1.181		
M 22	2.50	93.00	18.00 x 14.50	B	6HX	1	2	EP09PM22	18.0	22.00	140.0	34.0	4	DIN 376
	3.661								.709	.866	5.512	1.339		
M 24	3.00	113.00	18.00 x 14.50	B	6HX	1	2	EP09PM24	18.0	24.00	160.0	38.0	4	DIN 376
	4.449								.709	.945	6.299	1.496		
M 30	3.50	115.00	22.00 x 18.00	B	6HX	1	2	EP09PM30	22.0	30.00	180.0	45.0	4	DIN 376
	4.528								.866	1.181	7.087	1.772		

CXSC 2 = radialer Kühlschmierstoffaustritt



C174



C157



E9



E28



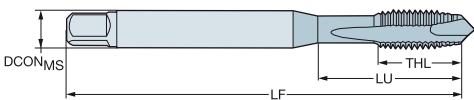
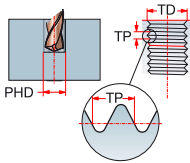
C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch
DIN/ANSI

ULDR
SUBSTRATE
COATING

3.0
HSS-E-PM
PVD TiAlN



B



C

						Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 3	0.50	17.74	.141 x .110	B	6HX	EP03PAM3	3.6	3.00	56.0	9.0	3	DIN/ANSI
		.698					.141	.118	2.205	.354		
M 4	0.70	16.58	.168 x .131	B	6HX	EP03PAM4	4.3	4.00	63.0	13.0	3	DIN/ANSI
		.653					.168	.157	2.480	.512		
M 5	0.80	21.42	.194 x .152	B	6HX	EP03PAM5	4.9	5.00	70.0	14.0	3	DIN/ANSI
		.843					.194	.197	2.756	.551		
M 6	1.00	25.59	.255 x .191	B	6HX	EP03PAM6	6.5	6.00	80.0	15.0	3	DIN/ANSI
		1.007					.255	.236	3.150	.591		
M 8	1.25	30.20	.318 x .238	B	6HX	EP03PAM8	8.1	8.00	90.0	18.0	3	DIN/ANSI
		1.189					.318	.315	3.543	.709		
M 10	1.50	32.80	.381 x .286	B	6HX	EP03PAM10	9.7	10.00	100.0	20.0	3	DIN/ANSI
		1.292					.381	.394	3.937	.787		
M 12	1.75	86.02	.367 x .275	B	6HX	EP03PAM12	9.3	12.00	110.0	23.0	4	DIN/ANSI
		3.386					.367	.472	4.331	.906		
M 14	2.00	84.82	.429 x .322	B	6HX	EP03PAM14	10.9	14.00	110.0	23.0	4	DIN/ANSI
		3.339					.429	.551	4.331	.906		
M 16	2.00	70.86	.480 x .360	B	6HX	EP03PAM16	12.2	16.00	110.0	23.0	4	DIN/ANSI
		2.790					.480	.630	4.331	.906		
M 18	2.50	84.69	.542 x .406	B	6HX	EP03PAM18	13.8	18.00	125.0	30.0	4	DIN/ANSI
		3.334					.542	.709	4.921	1.181		
M 20	2.50	97.58	.652 x .489	B	6HX	EP03PAM20	16.6	20.00	140.0	30.0	4	DIN/ANSI
		3.842					.652	.787	5.512	1.181		
M 24	3.00	101.60	.760 x .570	B	6HX	EP03PAM24	19.3	24.00	160.0	36.0	4	DIN/ANSI
		4.000					.760	.945	6.299	1.417		

D

E



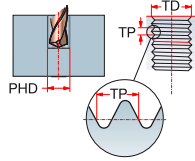
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch

DIN 371, DIN 376

ULDR
SUBSTRATE
COATING

2.5
HSS-E
PVD FEN



M

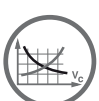
							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.00	3.50 x 2.70	B	6H	E344M3	3.5	3.00	56.0	8.9	3	DIN 371	
	.709						.138	.118	2.205	.350			
M 4	0.70	21.00	4.50 x 3.40	B	6H	E344M4	4.5	4.00	63.0	11.7	3	DIN 371	
	.827						.177	.157	2.480	.461			
M 5	0.80	25.00	6.00 x 4.90	B	6H	E344M5	6.0	5.00	70.0	12.6	3	DIN 371	
	.984						.236	.197	2.756	.496			
M 6	1.00	30.00	6.00 x 4.90	B	6H	E344M6	6.0	6.00	80.0	14.5	3	DIN 371	
	1.181						.236	.236	3.150	.571			
M 8	1.25	35.00	8.00 x 6.20	B	6H	E344M8	8.0	8.00	90.0	17.4	3	DIN 371	
	1.378						.315	.315	3.543	.685			
M 10	1.50	39.00	10.00 x 8.00	B	6H	E344M10	10.0	10.00	100.0	19.2	3	DIN 371	
	1.535						.394	.394	3.937	.756			
M 12	1.75	83.00	9.00 x 7.00	B	6H	E345M12	9.0	12.00	110.0	23.0	4	DIN 376	
	3.268						.354	.472	4.331	.906			
M 14	2.00	81.00	11.00 x 9.00	B	6H	E345M14	11.0	14.00	110.0	25.0	4	DIN 376	
	3.189						.433	.551	4.331	.984			
M 16	2.00	68.00	12.00 x 9.00	B	6H	E345M16	12.0	16.00	110.0	25.0	4	DIN 376	
	2.677						.472	.630	4.331	.984			
M 18	2.50	81.00	14.00 x 11.00	B	6H	E345M18	14.0	18.00	125.0	30.0	4	DIN 376	
	3.189						.551	.709	4.921	1.181			
M 20	2.50	95.00	16.00 x 12.00	B	6H	E345M20	16.0	20.00	140.0	30.0	4	DIN 376	
	3.740						.630	.787	5.512	1.181			
M 24	3.00	113.00	18.00 x 14.50	B	6H	E345M24	18.0	24.00	160.0	38.0	4	DIN 376	
	4.449						.709	.945	6.299	1.496			
M 30	3.50	115.00	22.00 x 18.00	B	6H	E345M30	22.0	30.00	180.0	45.0	4	DIN 376	
	4.528						.866	1.181	7.087	1.772			

B

C

D

E



C174



C157



E9



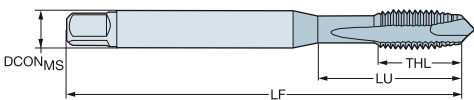
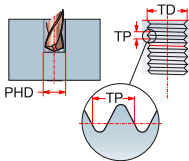
C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR
SUBSTRATE
COATING

2.5
HSS-E
PVD TICN



M

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TC _{TR}	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 1	0.25	20.00	2.50 x 2.10	B	5HX	E454M1	2.5	1.00	40.0	5.0	2	DIN 371	
		.787					.098	.039	1.575	.197			
M 1.2	0.25	20.00	2.50 x 2.10	B	5HX	E454M1.2	2.5	1.20	40.0	5.0	2	DIN 371	
		.787					.098	.047	1.575	.197			
M 1.4	0.30	20.00	2.50 x 2.10	B	5HX	E454M1.4	2.5	1.40	40.0	6.5	2	DIN 371	
		.787					.098	.055	1.575	.256			
M 1.6	0.35	20.00	2.50 x 2.10	B	6H	E454M1.6	2.5	1.60	40.0	7.0	2	DIN 371	
		.787					.098	.063	1.575	.276			
M 1.8	0.35	20.00	2.50 x 2.10	B	6H	E454M1.8	2.5	1.80	40.0	7.0	2	DIN 371	
		.787					.098	.071	1.575	.276			
M 2	0.40	9.00	2.80 x 2.10	B	6H	E454M2	2.8	2.00	45.0	6.0	2	DIN 371	
		.354					.110	.079	1.772	.236			
M 2.2	0.45	12.00	2.80 x 2.10	B	6H	E454M2.2	2.8	2.20	45.0	7.0	2	DIN 371	
		.472					.110	.087	1.772	.276			
M 2.3	0.40	12.00	2.80 x 2.10	B	6H	E454M2.3	2.8	2.30	45.0	7.0	2	DIN 371	
		.472					.110	.091	1.772	.276			
M 2.5	0.45	12.50	2.80 x 2.10	B	6H	E454M2.5	2.8	2.50	50.0	8.0	2	DIN 371	
		.492					.110	.098	1.969	.315			
M 2.6	0.45	12.50	2.80 x 2.10	B	6H	E454M2.6	2.8	2.60	50.0	8.0	2	DIN 371	
		.492					.110	.102	1.969	.315			
M 3	0.50	18.00	3.50 x 2.70	B	6H	E454M3	3.5	3.00	56.0	8.9	3	DIN 371	
		.709					.138	.118	2.205	.350			
M 4	0.70	21.00	4.50 x 3.40	B	6H	E454M4	4.5	4.00	63.0	11.7	3	DIN 371	
		.827					.177	.157	2.480	.461			
M 5	0.80	25.00	6.00 x 4.90	B	6H	E454M5	6.0	5.00	70.0	12.6	3	DIN 371	
		.984					.236	.197	2.756	.496			
M 6	1.00	30.00	6.00 x 4.90	B	6H	E454M6	6.0	6.00	80.0	14.5	3	DIN 371	
		1.181					.236	.236	3.150	.571			
M 8	1.25	35.00	8.00 x 6.20	B	6H	E454M8	8.0	8.00	90.0	17.4	3	DIN 371	
		1.378					.315	.315	3.543	.685			
M 10	1.50	39.00	10.00 x 8.00	B	6H	E454M10	10.0	10.00	100.0	19.2	3	DIN 371	
		1.535					.394	.394	3.937	.756			
M 12	1.75	83.00	9.00 x 7.00	B	6H	E455M12	9.0	12.00	110.0	23.0	4	DIN 376	
		3.268					.354	.472	4.331	.906			
M 14	2.00	81.00	11.00 x 9.00	B	6H	E455M14	11.0	14.00	110.0	25.0	4	DIN 376	
		3.189					.433	.551	4.331	.984			
M 16	2.00	68.00	12.00 x 9.00	B	6H	E455M16	12.0	16.00	110.0	25.0	4	DIN 376	
		2.677					.472	.630	4.331	.984			
M 18	2.50	81.00	14.00 x 11.00	B	6H	E455M18	14.0	18.00	125.0	30.0	4	DIN 376	
		3.189					.551	.709	4.921	1.181			
M 20	2.50	95.00	16.00 x 12.00	B	6H	E455M20	16.0	20.00	140.0	30.0	4	DIN 376	
		3.740					.630	.787	5.512	1.181			



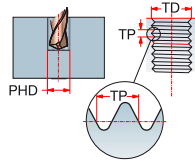
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch

DIN/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TiAlN+WCC



M

B

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 4	0.70	16.58	.168 x .131	B	6H	E852M4	4.3	4.00	63.0	13.0	3	DIN/ANSI	
		.653					.168	.157	2.480	.512			
M 5	0.80	21.42	.194 x .152	B	6H	E852M5	4.9	5.00	70.0	14.0	3	DIN/ANSI	
		.843					.194	.197	2.756	.551			
M 6	1.00	25.59	.255 x .191	B	6H	E852M6	6.5	6.00	80.0	15.0	3	DIN/ANSI	
		1.007					.255	.236	3.150	.591			
M 8	1.25	30.20	.318 x .238	B	6H	E852M8	8.1	8.00	90.0	18.0	3	DIN/ANSI	
		1.189					.318	.315	3.543	.709			
M 10	1.50	32.80	.381 x .286	B	6H	E852M10	9.7	10.00	100.0	20.0	3	DIN/ANSI	
		1.292					.381	.394	3.937	.787			
M 12	1.75	86.02	.367 x .275	B	6H	E852M12	9.3	12.00	110.0	23.0	4	DIN/ANSI	
		3.386					.367	.472	4.331	.906			
M 16	2.00	70.86	.480 x .360	B	6H	E852M16	12.2	16.00	110.0	23.0	4	DIN/ANSI	
		2.790					.480	.630	4.331	.906			
M 18	2.50	84.69	.542 x .406	B	6H	E852M18	13.8	18.00	125.0	30.0	4	DIN/ANSI	
		3.334					.542	.709	4.921	1.181			

C

D

E



C174



C157



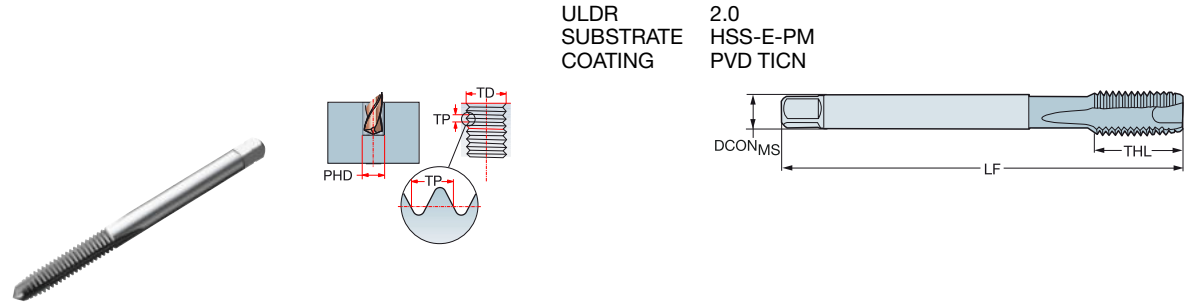
E9



C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376



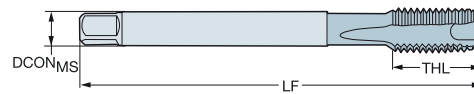
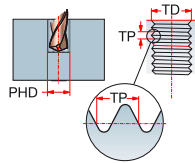
Für Nickelbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	12 DIN	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
M 3	0.50	15.00	3.50 x 2.70	B	6H	T200-SD100DA-M3	★	3.5	3.00	55.6	15.0	3	2.5	DIN 371		
	.591							.138	.118	2.191	.591		.098			
M 4	0.70	20.00	4.50 x 3.40	B	6H	T200-SD100DA-M4	★	4.5	4.00	62.5	20.0	3	3.3	DIN 371		
	.787							.177	.157	2.461	.787		.130			
M 5	0.80	25.00	6.00 x 4.90	B	6H	T200-SD100DA-M5	★	6.0	5.00	69.4	25.0	3	4.2	DIN 371		
	.984							.236	.197	2.733	.984		.165			
M 6	1.00	30.00	6.00 x 4.90	B	6H	T200-SD100DA-M6	★	6.0	6.00	79.3	30.0	3	5.0	DIN 371		
	1.181							.236	.236	3.122	1.181		.197			
M 8	1.25	40.00	8.00 x 6.20	B	6H	T200-SD100DA-M8	★	8.0	8.00	89.2	40.0	3	6.8	DIN 371		
	1.575							.315	.315	3.511	1.575		.268			
M 10	1.50	50.00	10.00 x 8.00	B	6H	T200-SD100DA-M10	★	10.0	10.00	99.0	50.0	3	8.5	DIN 371		
	1.969							.394	.394	3.896	1.969		.335			
M 12	1.75	67.85	9.00 x 7.00	B	6H	T200-SD100DA-M12	★	9.0	12.00	109.7	23.0	4	10.2	DIN 376		
	2.671							.354	.472	4.317	.906		.402			
M 14	2.00	66.20	11.00 x 9.00	B	6H	T200-SD100DA-M14	★	11.0	14.00	110.0	25.0	4	12.0	DIN 376		
	2.606							.433	.551	4.331	.984		.472			
M 16	2.00	66.20	12.00 x 9.00	B	6H	T200-SD100DA-M16	★	12.0	16.00	110.0	25.0	4	14.0	DIN 376		
	2.606							.472	.630	4.331	.984		.551			
M 18	2.50	79.20	14.00 x 11.00	B	6H	T200-SD100DA-M18	★	14.0	18.00	125.0	30.0	4	15.5	DIN 376		
	3.118							.551	.709	4.921	1.181		.610			
M 20	2.50	93.20	16.00 x 12.00	B	6H	T200-SD100DA-M20	★	16.0	20.00	140.0	30.0	4	17.5	DIN 376		
	3.669							.630	.787	5.512	1.181		.689			

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

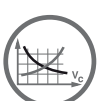
Gewindeform: Metrisch

DIN 371, DIN 376

ULDR
SUBSTRATE
COATING2.0
HSS-E-PM
PVD ALCRN

Für Titanbasislegierungen

							Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DIN	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
M 2	0.40	8.00	2.80 x 2.10	B	6HX	T200-SM100DA-M2		2.8	2.00	45.0	8.0	2	1.6	DIN 371		
		.315						.110	.079	1.772	.315		.063			
M 2.5	0.45	9.00	2.80 x 2.10	B	6HX	T200-SM100DA-M2.5		2.8	2.50	50.0	9.0	2	2.1	DIN 371		
		.354						.110	.098	1.969	.354		.081			
M 3	0.50	10.00	3.50 x 2.70	B	6HX	T200-SM100DA-M3		3.5	3.00	56.0	10.0	2	2.5	DIN 371		
		.394						.138	.118	2.205	.394		.098			
M 3.5	0.60	12.00	4.00 x 3.00	B	6HX	T200-SM100DA-M3.5		4.0	3.50	56.0	12.0	3	2.9	DIN 371		
		.472						.157	.138	2.205	.472		.114			
M 4	0.70	13.00	4.50 x 3.40	B	6HX	T200-SM100DA-M4		4.5	4.00	63.0	13.0	3	3.3	DIN 371		
		.512						.177	.157	2.480	.512		.130			
M 5	0.80	16.00	6.00 x 4.90	B	6HX	T200-SM100DA-M5		6.0	5.00	70.0	16.0	3	4.2	DIN 371		
		.630						.236	.197	2.756	.630		.165			
M 6	1.00	23.00	6.00 x 4.90	B	6HX	T200-SM100DA-M6		6.0	6.00	80.0	15.0	3	5.0	DIN 371		
		.906						.236	.236	3.150	.591		.197			
M 8	1.25	29.50	8.00 x 6.20	B	6HX	T200-SM100DA-M8		8.0	8.00	90.0	18.0	3	6.8	DIN 371		
		1.161						.315	.315	3.543	.709		.268			
M 10	1.50	33.50	10.00 x 8.00	B	6HX	T200-SM101DA-M10		10.0	10.00	100.0	20.0	3	8.5	DIN 371		
		1.319						.394	.394	3.937	.787		.335			
M 12	1.75	83.00	9.00 x 7.00	B	6HX	T200-SM101DA-M12		9.0	12.00	110.0	23.0	4	10.2	DIN 376		
		3.268						.354	.472	4.331	.906		.402			
M 16	2.00	68.00	12.00 x 9.00	B	6HX	T200-SM101DA-M16		12.0	16.00	110.0	25.0	4	14.0	DIN 376		
		2.677						.472	.630	4.331	.984		.551			
M 20	2.50	95.00	16.00 x 12.00	B	6HX	T200-SM101DA-M20		16.0	20.00	140.0	30.0	4	17.5	DIN 376		
		3.740						.630	.787	5.512	1.181		.689			



C174



C157



E9



E27



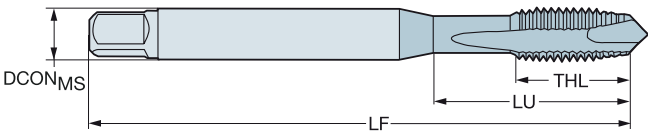
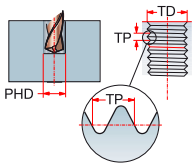
C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch
DIN 371

ULDR
SUBSTRATE
COATING

3.0
HSS-E
PVD ZrN - B125
UNCOAT - B150



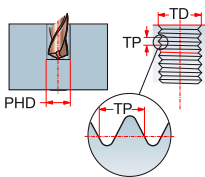
N

											N		Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	B125	B150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG							
M 3	0.50	16.00	3.50 x 2.70	B	6H	T200-NM100DA-M3	★	★	3.5	3.00	56.0	9.0	2	2.5	DIN 371							
		.630							.138	.118	2.205	.354		.098								
M 4	0.70	19.00	4.50 x 3.40	B	6H	T200-NM100DA-M4	★	★	4.5	4.00	63.0	12.0	2	3.3	DIN 371							
		.748							.177	.157	2.480	.472		.130								
M 5	0.80	23.00	6.00 x 4.90	B	6H	T200-NM100DA-M5	★	★	6.0	5.00	70.0	13.0	2	4.2	DIN 371							
		.906							.236	.197	2.756	.512		.165								
M 6	1.00	27.00	6.00 x 4.90	B	6H	T200-NM100DA-M6	★	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371							
		1.063							.236	.236	3.150	.591		.197								
M 8	1.25	28.00	8.00 x 6.20	B	6H	T200-NM100DA-M8	★	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371							
		1.102							.315	.315	3.543	.709		.268								
M 10	1.50	30.00	10.00 x 8.00	B	6H	T200-NM100DA-M10	★		10.0	10.00	100.0	20.0	3	8.5	DIN 371							
		1.181							.394	.394	3.937	.787		.335								

DIN 376

ULDR
SUBSTRATE
COATING

3.0
HSS-E
PVD ZrN - B125
UNCOAT - B150



N

											N		Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	B125	B150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG							
M 12	1.75	83.00	9.00 x 7.00	B	6H	T200-NM101DA-M12	★	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376							
		3.268							.354	.472	4.331	.906		.402								
M 14	2.00	81.00	11.00 x 9.00	B	6H	T200-NM101DA-M14	★		11.0	14.00	110.0	25.0	4	12.0	DIN 376							
		3.189							.433	.551	4.331	.984		.472								
M 16	2.00	68.00	12.00 x 9.00	B	6H	T200-NM101DA-M16	★	★	12.0	16.00	110.0	25.0	4	14.0	DIN 376							
		2.677							.472	.630	4.331	.984		.551								

E



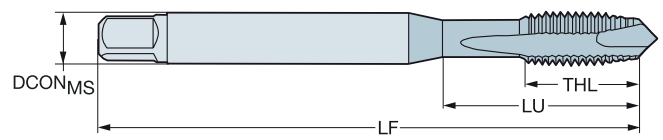
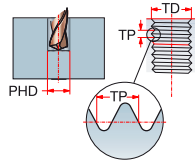
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch

DIN/ANSI

ULDR
SUBSTRATE

3.0
HSS-E-PM



N

B

										Abmessungen, mm, Zoll				
TDZ	TP	LU	CZC _{MS}	THCHT	TCCTR	Bestellnummer	DIN	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	15.88	.141 x .110	B	6H	T200-NM100AA-M3		3.6	3.00	56.0	9.0	2	2.5	DIN/ANSI
		.625					★	.141	.118	2.205	.354		.098	
M 4	0.70	16.58	.168 x .131	B	6H	T200-NM100AA-M4	★	4.3	4.00	63.0	13.0	2	3.3	DIN/ANSI
		.653						.168	.157	2.480	.512		.130	
M 5	0.80	21.42	.194 x .152	B	6H	T200-NM100AA-M5	★	4.9	5.00	70.0	14.0	2	4.2	DIN/ANSI
		.843						.194	.197	2.756	.551		.165	
M 6	1.00	25.59	.255 x .191	B	6H	T200-NM100AA-M6	★	6.5	6.00	80.0	15.0	3	5.0	DIN/ANSI
		1.007						.255	.236	3.150	.591		.197	
M 8	1.25	30.20	.318 x .238	B	6H	T200-NM100AA-M8	★	8.1	8.00	90.0	18.0	3	6.8	DIN/ANSI
		1.189						.318	.315	3.543	.709		.268	

C

D

E



C174



C157



E9



E27



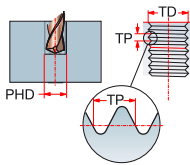
C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch Fein
DIN 374

ULDR
SUBSTRATE
COATING

3.0
HSS-E-PM
PVD TiAlN



B



C

						Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
MF 4x0.5	0.50	43.00	2.80 x 2.10	B	6HX	EP13PM4X.5	2.8	4.00	63.0	12.0	3	DIN 374
		1.693					.110	.157	2.480	.472		
MF 5x0.5	0.50	49.00	3.50 x 2.70	B	6HX	EP13PM5X.5	3.5	5.00	70.0	13.0	3	DIN 374
		1.929					.138	.197	2.756	.512		
MF 6x0.75	0.75	59.00	4.50 x 3.40	B	6HX	EP13PM6X.75	4.5	6.00	80.0	15.0	3	DIN 374
		2.323					.177	.236	3.150	.591		
MF 8x0.75	0.75	57.00	6.00 x 4.90	B	6HX	EP13PM8X.75	6.0	8.00	80.0	15.0	3	DIN 374
		2.244					.236	.315	3.150	.591		
MF 8x1	1.00	67.00	6.00 x 4.90	B	6HX	EP13PM8X1.0	6.0	8.00	90.0	18.0	3	DIN 374
		2.638					.236	.315	3.543	.709		
MF 10x1	1.00	67.00	7.00 x 5.50	B	6HX	EP13PM10X1.0	7.0	10.00	90.0	17.6	3	DIN 374
		2.638					.276	.394	3.543	.693		
MF 10x1.25	1.25	77.00	7.00 x 5.50	B	6HX	EP13PM10X1.25	7.0	10.00	100.0	19.8	3	DIN 374
		3.032					.276	.394	3.937	.780		
MF 12x1	1.00	73.00	9.00 x 7.00	B	6HX	EP13PM12X1.0	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					.354	.472	3.937	.827		
MF 12x1.25	1.25	73.00	9.00 x 7.00	B	6HX	EP13PM12X1.25	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					.354	.472	3.937	.827		
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6HX	EP13PM12X1.5	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					.354	.472	3.937	.827		
MF 14x1	1.00	71.00	11.00 x 9.00	B	6HX	EP13PM14X1.0	11.0	14.00	100.0	21.0	4	DIN 374
		2.795					.433	.551	3.937	.827		
MF 14x1.25	1.25	71.00	11.00 x 9.00	B	6HX	EP13PM14X1.25	11.0	14.00	100.0	21.0	4	DIN 374
		2.795					.433	.551	3.937	.827		
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6HX	EP13PM14X1.5	11.0	14.00	100.0	21.0	4	DIN 374
		2.795					.433	.551	3.937	.827		
MF 16x1	1.00	58.00	12.00 x 9.00	B	6HX	EP13PM16X1.0	12.0	16.00	100.0	21.0	4	DIN 374
		2.283					.472	.630	3.937	.827		
MF 16x1.5	1.50	58.00	12.00 x 9.00	B	6HX	EP13PM16X1.5	12.0	16.00	100.0	21.0	4	DIN 374
		2.283					.472	.630	3.937	.827		
MF 18x1	1.00	66.00	14.00 x 11.00	B	6HX	EP13PM18X1.0	14.0	18.00	110.0	24.0	4	DIN 374
		2.598					.551	.709	4.331	.945		
MF 18x1.5	1.50	66.00	14.00 x 11.00	B	6HX	EP13PM18X1.5	14.0	18.00	110.0	24.0	4	DIN 374
		2.598					.551	.709	4.331	.945		
MF 20x1	1.00	80.00	16.00 x 12.00	B	6HX	EP13PM20X1.0	16.0	20.00	125.0	24.0	4	DIN 374
		3.150					.630	.787	4.921	.945		
MF 20x1.5	1.50	80.00	16.00 x 12.00	B	6HX	EP13PM20X1.5	16.0	20.00	125.0	24.0	4	DIN 374
		3.150					.630	.787	4.921	.945		
MF 22x1.5	1.50	78.00	18.00 x 14.50	B	6HX	EP13PM22X1.5	18.0	22.00	125.0	25.0	4	DIN 374
		3.071					.709	.866	4.921	.984		
MF 24x1.5	1.50	93.00	18.00 x 14.50	B	6HX	EP13PM24X1.5	18.0	24.00	140.0	28.0	4	DIN 374
		3.661					.709	.945	5.512	1.102		
MF 24x2	2.00	93.00	18.00 x 14.50	B	6HX	EP13PM24X2.0	18.0	24.00	140.0	28.0	4	DIN 374
		3.661					.709	.945	5.512	1.102		
MF 26x1.5	1.50	93.00	18.00 x 14.50	B	6HX	EP13PM26X1.5	18.0	26.00	140.0	28.0	4	DIN 374
		3.661					.709	1.024	5.512	1.102		
MF 27x2	2.00	77.00	20.00 x 16.00	B	6HX	EP13PM27X2.0	20.0	27.00	140.0	28.0	4	DIN 374
		3.032					.787	1.063	5.512	1.102		
MF 28x1.5	1.50	77.00	20.00 x 16.00	B	6HX	EP13PM28X1.5	20.0	28.00	140.0	28.0	4	DIN 374
		3.032					.787	1.102	5.512	1.102		
MF 30x1.5	1.50	85.00	22.00 x 18.00	B	6HX	EP13PM30X1.5	22.0	30.00	150.0	28.0	4	DIN 374
		3.346					.866	1.181	5.906	1.102		
MF 30x2	2.00	85.00	22.00 x 18.00	B	6HX	EP13PM30X2.0	22.0	30.00	150.0	28.0	4	DIN 374
		3.346					.866	1.181	5.906	1.102		

E



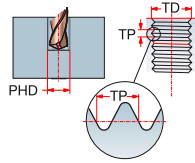
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch Fein

DIN/ANSI

ULDR
SUBSTRATE
COATING

3.0
HSS-E-PM
PVD TiAlN



≤350HB

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
MF 8x1	1.00	30.20	.318 x .238	B	6HX	EP13PAM8X1.0	8.1	8.00	90.0	18.0	3	DIN/ANSI	
		1.189					.318	.315	3.543	.709			
MF 10x1.25	1.25	32.80	.381 x .286	B	6HX	EP13PAM10X1.25	9.7	10.00	100.0	20.0	3	DIN/ANSI	
		1.292					.381	.394	3.937	.787			
MF 12x1.25	1.25	86.02	.367 x .275	B	6HX	EP13PAM12X1.25	9.3	12.00	110.0	23.0	4	DIN/ANSI	
		3.386					.367	.472	4.331	.906			
MF 12x1.5	1.50	86.02	.367 x .275	B	6HX	EP13PAM12X1.5	9.3	12.00	110.0	23.0	4	DIN/ANSI	
		3.386					.367	.472	4.331	.906			
MF 14x1.5	1.50	84.82	.429 x .322	B	6HX	EP13PAM14X1.5	10.9	14.00	110.0	23.0	4	DIN/ANSI	
		3.339					.429	.551	4.331	.906			
MF 16x1.5	1.50	70.86	.480 x .360	B	6HX	EP13PAM16X1.5	12.2	16.00	110.0	23.0	4	DIN/ANSI	
		2.790					.480	.630	4.331	.906			
MF 18x1.5	1.50	84.69	.542 x .406	B	6HX	EP13PAM18X1.5	13.8	18.00	125.0	30.0	4	DIN/ANSI	
		3.334					.542	.709	4.921	1.181			



C174



C157



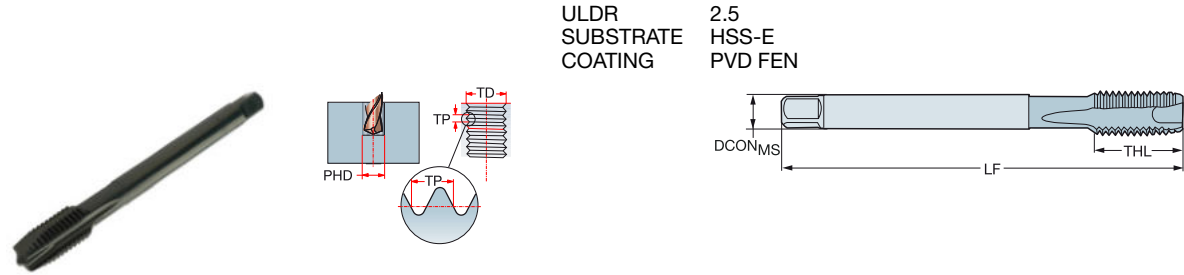
E9



C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch Fein
DIN 374



M

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
MF 8x1	1.00	67.00	6.00 x 4.90	B	6H	E364M8X1.0	6.0	8.00	90.0	18.0	3	DIN 374	
		2.638					.236	.315	3.543	.709			
MF 10x1	1.00	67.00	7.00 x 5.50	B	6H	E364M10X1.0	7.0	10.00	90.0	20.0	3	DIN 374	
		2.638					.276	.394	3.543	.787			
MF 10x1.25	1.25	77.00	7.00 x 5.50	B	6H	E364M10X1.25	7.0	10.00	100.0	20.0	3	DIN 374	
		3.032					.276	.394	3.937	.787			
MF 12x1	1.00	73.00	9.00 x 7.00	B	6H	E364M12X1.0	9.0	12.00	100.0	21.0	4	DIN 374	
		2.874					.354	.472	3.937	.827			
MF 12x1.25	1.25	73.00	9.00 x 7.00	B	6H	E364M12X1.25	9.0	12.00	100.0	21.0	4	DIN 374	
		2.874					.354	.472	3.937	.827			
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6H	E364M12X1.5	9.0	12.00	100.0	21.0	4	DIN 374	
		2.874					.354	.472	3.937	.827			
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6H	E364M14X1.5	11.0	14.00	100.0	21.0	4	DIN 374	
		2.795					.433	.551	3.937	.827			
MF 16x1.5	1.50	58.00	12.00 x 9.00	B	6H	E364M16X1.5	12.0	16.00	100.0	21.0	5	DIN 374	
		2.283					.472	.630	3.937	.827			
MF 18x1.5	1.50	66.00	14.00 x 11.00	B	6H	E364M18X1.5	14.0	18.00	110.0	24.0	5	DIN 374	
		2.598					.551	.709	4.331	.945			
MF 20x1.5	1.50	80.00	16.00 x 12.00	B	6H	E364M20X1.5	16.0	20.00	125.0	24.0	5	DIN 374	
		3.150					.630	.787	4.921	.945			

D

E



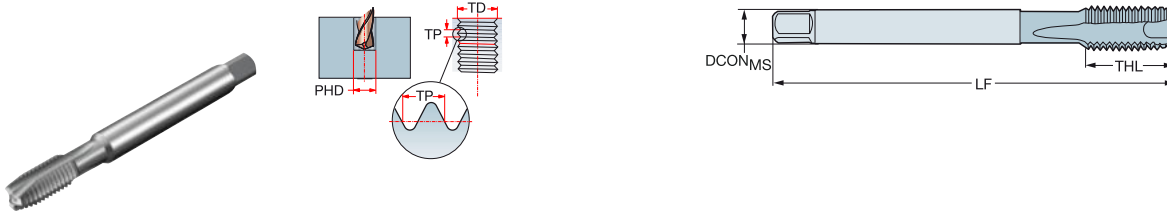
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: Metrisch Fein

DIN 371, DIN 374

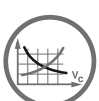
ULDR
SUBSTRATE
COATING

2.0
HSS-E-PM
PVD ALCRN



Für Titanbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DIN 371	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
MF 6x0.75	0.75	23.00	6.00 x 4.90	B	6HX	T200-SM100DB-M6X075		6.0	6.00	80.0	15.0	3	5.3	DIN 371		
		.906						.236	.236	3.150	.591		.207			
MF 8x0.75	0.75	29.50	8.00 x 6.20	B	6HX	T200-SM100DB-M8X075		8.0	8.00	90.0	18.0	3	7.3	DIN 371		
		1.161						.315	.315	3.543	.709		.285			
MF 8x1	1.00	29.50	8.00 x 6.20	B	6HX	T200-SM100DB-M8X100		8.0	8.00	90.0	18.0	3	7.0	DIN 371		
		1.161						.315	.315	3.543	.709		.276			
MF 10x1	1.00	33.50	10.00 x 8.00	B	6HX	T200-SM100DB-M10X100		10.0	10.00	100.0	20.0	3	9.0	DIN 371		
		1.319						.394	.394	3.937	.787		.354			
MF 12x1	1.00	73.00	9.00 x 7.00	B	6HX	T200-SM100DB-M12X100		9.0	12.00	100.0	21.0	4	11.0	DIN 374		
		2.874						.354	.472	3.937	.827		.433			
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6HX	T200-SM100DB-M12X150		9.0	12.00	100.0	21.0	4	10.5	DIN 374		
		2.874						.354	.472	3.937	.827		.413			
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6HX	T200-SM100DB-M14X150		11.0	14.00	100.0	21.0	4	12.5	DIN 374		
		2.795						.433	.551	3.937	.827		.492			



C174



C157



E9



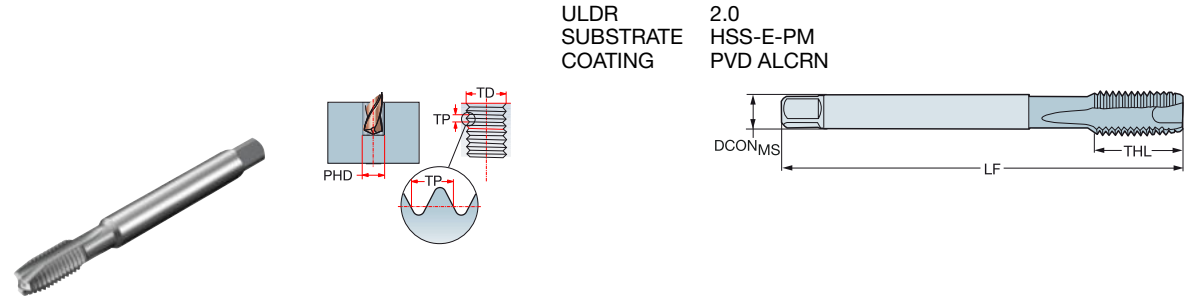
E27



C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: MJ
DIN 371



Für Titanbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DS	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
MJ 4	0.70	13.00	4.50 x 3.40	B	4H	T200-SM100DC-MJ4	★	4.5	4.00	63.0	13.0	3	3.3	DIN 371		
		.512						.177	.157	2.480	.512		.130			
MJ 5	0.80	16.00	6.00 x 4.90	B	4H	T200-SM100DC-MJ5	★	6.0	5.00	70.0	16.0	3	4.2	DIN 371		
		.630						.236	.197	2.756	.630		.165			
MJ 6	1.00	23.00	6.00 x 4.90	B	4H	T200-SM100DC-MJ6	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371		
		.906						.236	.236	3.150	.591		.197			
MJ 8	1.25	29.50	8.00 x 6.20	B	4H	T200-SM100DC-MJ8	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371		
		1.161						.315	.315	3.543	.709		.268			

D

E

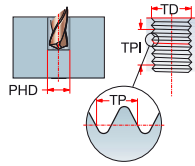
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNC

C-DIN/ANSI, DIN/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-E-PM
PVD TiAlN



30-48 HRC

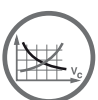
B

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
UNC #4-40	40.00	11.90	.141 x .110	B	2B	E8744-40	3.6	2.84	56.0	11.9	3	C-DIN/ANSI	
		.469					.141	.112	2.205	.469			
UNC #5-40	40.00	11.00	.141 x .110	B	2B	E8745-40	3.6	3.18	56.0	11.0	3	C-DIN/ANSI	
		.433					.141	.125	2.205	.433			
UNC #6-32	32.00	13.90	.168 x .131	B	2B	E8746-32	4.3	3.51	63.0	13.9	3	C-DIN/ANSI	
		.547					.168	.138	2.480	.547			
UNC #8-32	32.00	15.10	.194 x .152	B	2B	E8748-32	4.9	4.17	70.0	15.1	3	C-DIN/ANSI	
		.594					.194	.164	2.756	.594			
UNC #10-24	24.00	17.00	.255 x .191	B	2B	E87410-24	6.5	4.83	80.0	17.0	3	C-DIN/ANSI	
		.669					.255	.190	3.150	.669			
UNC 1/4-20	20.00	20.20	.318 x .238	B	2B	E8741/4	8.1	6.35	90.0	20.2	3	C-DIN/ANSI	
		.795					.318	.250	3.543	.795			
UNC 5/16-18	18.00	20.00	.381 x .286	B	2B	E8745/16	9.7	7.94	100.0	22.8	3	C-DIN/ANSI	
		.787					.381	.313	3.937	.898			
UNC 3/8-16	16.00	29.16	.381 x .286	B	2B	E8743/8	9.7	9.53	100.0	20.0	3	DIN/ANSI	
		1.148					.381	.375	3.937	.787			
UNC 1/2-13	13.00	81.80	.367 x .275	B	2B	E8741/2	9.3	12.70	110.0	23.0	4	DIN/ANSI	
		3.220					.367	.500	4.331	.906			
UNC 5/8-11	11.00	65.80	.480 x .360	B	2B	E8745/8	12.2	15.88	110.0	23.0	4	DIN/ANSI	
		2.591					.480	.625	4.331	.906			
UNC 3/4-10	10.00	77.50	.590 x .442	B	2B	E8743/4	15.0	19.05	125.0	30.0	4	DIN/ANSI	
		3.051					.590	.750	4.921	1.181			

C

D

E



C174



C157



E9



C154



CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNC
DIN/ANSI

ULDR
SUBSTRATE
COATING

3.0
HSS-E-PM
PVD TiAlN



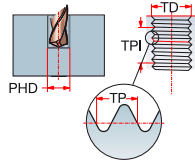
										Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG	
UNC 1/4-20	20.00	24.59 .968	.255 x .191	B	2BX	1	2	EP29PA1/4		6.5 .255	6.35 .250	80.0 3.150	15.0 .591	3	DIN/ANSI	
UNC 5/16-18	18.00	33.17 1.306	.318 x .238	B	2BX	1	2	EP29PA5/16		8.1 .318	7.94 .313	90.0 3.543	18.0 .709	3	DIN/ANSI	
UNC 3/8-16	16.00	37.77 1.487	.381 x .286	B	2BX	1	2	EP29PA3/8		9.7 .381	9.53 .375	100.0 3.937	20.0 .787	3	DIN/ANSI	
UNC 7/16-14	14.00	72.60 2.858	.323 x .242	B	2BX	1	2	EP29PA7/16		8.2 .323	11.11 .438	100.0 3.937	20.0 .787	4	DIN/ANSI	
UNC 1/2-13	13.00	81.80 3.220	.367 x .275	B	2BX	1	2	EP29PA1/2		9.3 .367	12.70 .500	110.0 4.331	23.0 .906	4	DIN/ANSI	
UNC 5/8-11	11.00	65.80 2.591	.480 x .360	B	2BX	1	2	EP29PA5/8		12.2 .480	15.88 .625	110.0 4.331	23.0 .906	4	DIN/ANSI	
UNC 3/4-10	10.00	77.50 3.051	.590 x .442	B	2BX	1	2	EP29PA3/4		15.0 .590	19.05 .750	125.0 4.921	30.0 1.181	4	DIN/ANSI	
UNC 7/8-9	9.00	90.90 3.579	.697 x .523	B	2BX	1	2	EP29PA7/8		17.7 .697	22.23 .875	140.0 5.512	34.0 1.339	4	DIN/ANSI	
UNC 1"-8	8.00	95.40 3.756	.800 x .600	B	2BX	1	2	EP29PA1		20.3 .800	25.40 1.000	160.0 6.299	36.0 1.417	4	DIN/ANSI	

CXSC 2 = radialer Kühlschmierstoffaustritt

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNC

DIN/ANSI

ULDR
SUBSTRATE
COATING3.0
HSS-E-PM
PVD TiAlN

≤350HB

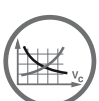
B

							Abmessungen, mm, Zoll						
TCT	TDZ	TPI	LU	CZC _{AG}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
H1	UNC #2-56	56.00	11.99	.141 x .110	B	2B	EP23PA2-56	3.6	2.18	45.0	7.0	2	DIN/ANSI
		.472						.141	.086	1.772	.276		
H2	UNC #4-40	40.00	16.97	.141 x .110	B	2B	EP23PA4-40	3.6	2.84	56.0	9.0	3	DIN/ANSI
		.668						.141	.112	2.205	.354		
H3	UNC #6-32	32.00	20.20	.141 x .110	B	2B	EP23PA6-32	3.6	3.51	56.0	11.0	3	DIN/ANSI
		.795						.141	.138	2.205	.433		
H3	UNC #8-32	32.00	21.18	.168 x .131	B	2B	EP23PA8-32	4.3	4.17	63.0	13.0	3	DIN/ANSI
		.834						.168	.164	2.480	.512		
H5	UNC #8-32	32.00	21.18	.168 x .131	B	2BX	EP23PA8-32H5	4.3	4.17	63.0	13.0	3	DIN/ANSI
		.834						.168	.164	2.480	.512		
H3	UNC #10-24	24.00	27.54	.194 x .152	B	2B	EP23PA10-24	4.9	4.83	70.0	14.0	3	DIN/ANSI
		1.084						.194	.190	2.756	.551		
H3	UNC 1/4-20	20.00	24.59	.255 x .191	B	3B	EP23PA1/4	6.5	6.35	80.0	15.0	3	DIN/ANSI
		.968						.255	.250	3.150	.591		
H5	UNC 1/4-20	20.00	24.59	.255 x .191	B	2B	EP23PA1/4H5	6.5	6.35	80.0	15.0	3	DIN/ANSI
		.968						.255	.250	3.150	.591		
H3	UNC 5/16-18	18.00	33.17	.318 x .238	B	3B	EP23PA5/16	8.1	7.94	90.0	18.0	3	DIN/ANSI
		1.306						.318	.313	3.543	.709		
H5	UNC 5/16-18	18.00	33.17	.318 x .238	B	2B	EP23PA5/16H5	8.1	7.94	90.0	18.0	3	DIN/ANSI
		1.306						.318	.313	3.543	.709		
H3	UNC 3/8-16	16.00	37.77	.381 x .286	B	3B	EP23PA3/8	9.7	9.53	100.0	20.0	3	DIN/ANSI
		1.487						.381	.375	3.937	.787		
H5	UNC 3/8-16	16.00	37.77	.381 x .286	B	2B	EP23PA3/8H5	9.7	9.53	100.0	20.0	3	DIN/ANSI
		1.487						.381	.375	3.937	.787		
H3	UNC 7/16-14	14.00	72.60	.323 x .242	B	3B	EP23PA7/16	8.2	11.11	100.0	20.0	4	DIN/ANSI
		2.858						.323	.438	3.937	.787		
H3	UNC 1/2-13	13.00	81.80	.367 x .275	B	3B	EP23PA1/2	9.3	12.70	110.0	23.0	4	DIN/ANSI
		3.220						.367	.500	4.331	.906		
H5	UNC 1/2-13	13.00	81.80	.367 x .275	B	2B	EP23PA1/2H5	9.3	12.70	110.0	23.0	4	DIN/ANSI
		3.220						.367	.500	4.331	.906		
H3	UNC 5/8-11	11.00	65.80	.480 x .360	B	3B	EP23PA5/8	12.2	15.88	110.0	23.0	4	DIN/ANSI
		2.591						.480	.625	4.331	.906		
H5	UNC 5/8-11	11.00	65.80	.480 x .360	B	2B	EP23PA5/8H5	12.2	15.88	110.0	23.0	4	DIN/ANSI
		2.591						.480	.625	4.331	.906		
H3	UNC 3/4-10	10.00	77.50	.590 x .442	B	3B	EP23PA3/4	15.0	19.05	125.0	30.0	4	DIN/ANSI
		3.051						.590	.750	4.921	1.181		
H5	UNC 3/4-10	10.00	77.50	.590 x .442	B	2B	EP23PA3/4H5	15.0	19.05	125.0	30.0	4	DIN/ANSI
		3.051						.590	.750	4.921	1.181		
H4	UNC 7/8-9	9.00	92.50	.697 x .523	B	3B	EP23PA7/8	17.7	22.23	140.0	34.0	4	DIN/ANSI
		3.642						.697	.875	5.512	1.339		
H4	UNC 1"-8	8.00	95.40	.800 x .600	B	3B	EP23PA1	20.3	25.40	160.0	36.0	4	DIN/ANSI
		3.756						.800	1.000	6.299	1.417		

C

D

E



C174



C157



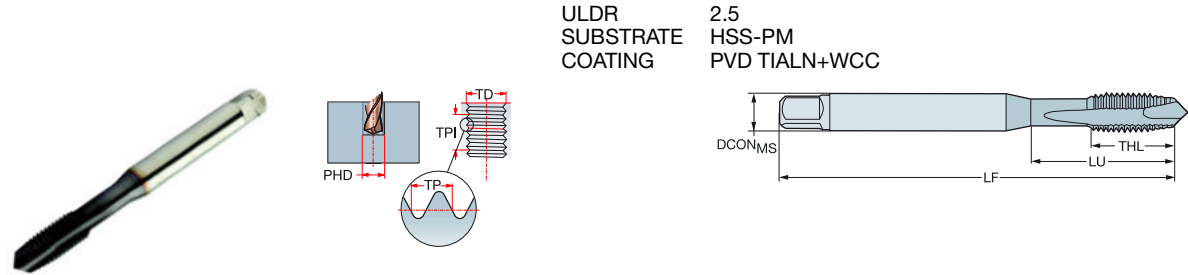
E9



C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNC
DIN/ANSI



M

						Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THGHT	TC _{TR}	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
UNC #4-40	40.00	15.47 .609	.141 x .110	B	2B	E8724-40	3.6 .141	2.84 .112	56.0 2.205	9.0 .354	3	DIN/ANSI
UNC #6-32	32.00	15.08 .594	.141 x .110	B	2B	E8726-32	3.6 .141	3.51 .138	56.0 2.205	11.0 .433	3	DIN/ANSI
UNC #8-32	32.00	16.58 .653	.168 x .131	B	2B	E8728-32	4.3 .168	4.17 .164	63.0 2.480	13.0 .512	3	DIN/ANSI
UNC #10-24	24.00	21.42 .843	.194 x .152	B	2B	E87210-24	4.9 .194	4.83 .190	70.0 2.756	14.0 .551	3	DIN/ANSI
UNC 1/4-20	20.00	25.59 1.007	.255 x .191	B	2B	E8721/4	6.5 .255	6.35 .250	80.0 3.150	15.0 .591	3	DIN/ANSI
UNC 5/16-18	18.00	30.20 1.189	.318 x .238	B	2B	E8725/16	8.1 .318	7.94 .313	90.0 3.543	18.0 .709	3	DIN/ANSI
UNC 3/8-16	16.00	32.80 1.292	.381 x .286	B	2B	E8723/8	9.7 .381	9.53 .375	100.0 3.937	20.0 .787	3	DIN/ANSI
UNC 7/16-14	14.00	72.60 2.858	.323 x .242	B	2B	E8727/16	8.2 .323	11.11 .438	100.0 3.937	20.0 .787	4	DIN/ANSI
UNC 1/2-13	13.00	81.80 3.220	.367 x .275	B	2B	E8721/2	9.3 .367	12.70 .500	110.0 4.331	23.0 .906	4	DIN/ANSI
UNC 3/4-10	10.00	77.50 3.051	.590 x .442	B	2B	E8723/4	15.0 .590	19.05 .750	125.0 4.921	30.0 1.181	4	DIN/ANSI

D

E



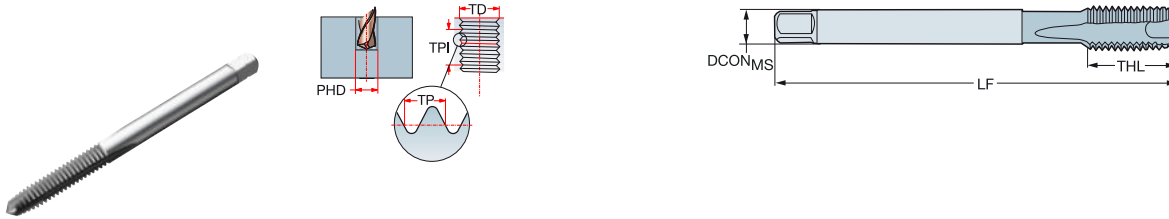
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNC

DIN/ANSI

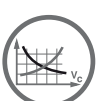
ULDR
SUBSTRATE
COATING

2.0
HSS-E-PM
PVD TiCN



Für Nickelbasislegierungen

							Abmessungen, mm, Zoll							
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DIN	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	14.20	.141 x .110	B	3BX	T200-SD100AE-4-40		3.6	2.84	55.9	14.2	3	2.4	DIN/ANSI
		.559					★	.141	.112	2.202	.559		.083	
UNC #6-32	32.00	17.50	.141 x .110	B	3BX	T200-SD100AE-6-32	★	3.6	3.51	55.3	17.5	3	2.9	DIN/ANSI
		.689						.141	.138	2.176	.689		.112	
UNC #8-32	32.00	20.80	.168 x .131	B	3BX	T200-SD100AE-8-32	★	4.3	4.17	62.6	20.8	3	3.5	DIN/ANSI
		.819						.168	.164	2.466	.819		.138	
UNC #10-24	24.00	24.10	.194 x .152	B	3BX	T200-SD100AE-10-24	★	4.9	4.83	69.7	24.1	3	3.9	DIN/ANSI
		.949						.194	.190	2.744	.949		.154	
UNC 1/4-20	20.00	31.80	.255 x .191	B	3BX	T200-SD100AE-1/4	★	6.5	6.35	79.0	31.8	3	5.1	DIN/ANSI
		1.252						.255	.250	3.111	1.252		.201	
UNC 5/16-18	18.00	39.70	.323 x .242	B	3BX	T200-SD100AE-5/16	★	8.2	7.94	89.1	39.7	3	6.6	DIN/ANSI
		1.563						.323	.313	3.509	1.563		.260	
UNC 3/8-16	16.00	47.60	.381 x .286	B	3BX	T200-SD100AE-3/8	★	9.7	9.53	99.2	47.6	3	8.0	DIN/ANSI
		1.874						.381	.375	3.906	1.874		.315	
UNC 7/16-14	14.00	72.60	.323 x .242	B	3BX	T200-SD100AE-7/16	★	8.2	11.11	100.0	20.0	4	9.4	DIN/ANSI
		2.858						.323	.438	3.937	.787		.370	
UNC 1/2-13	13.00	81.80	.367 x .275	B	3BX	T200-SD100AE-1/2	★	9.3	12.70	110.0	23.0	4	10.8	DIN/ANSI
		3.220						.367	.500	4.331	.906		.425	
UNC 5/8-11	11.00	65.80	.480 x .360	B	3BX	T200-SD100AE-5/8	★	12.2	15.88	110.0	23.0	4	13.5	DIN/ANSI
		2.591						.480	.625	4.331	.906		.531	
UNC 3/4-10	10.00	77.50	.590 x .442	B	3BX	T200-SD100AE-3/4	★	15.0	19.05	125.0	30.0	4	16.5	DIN/ANSI
		3.051						.590	.750	4.921	1.181		.650	



C174



C157



E9



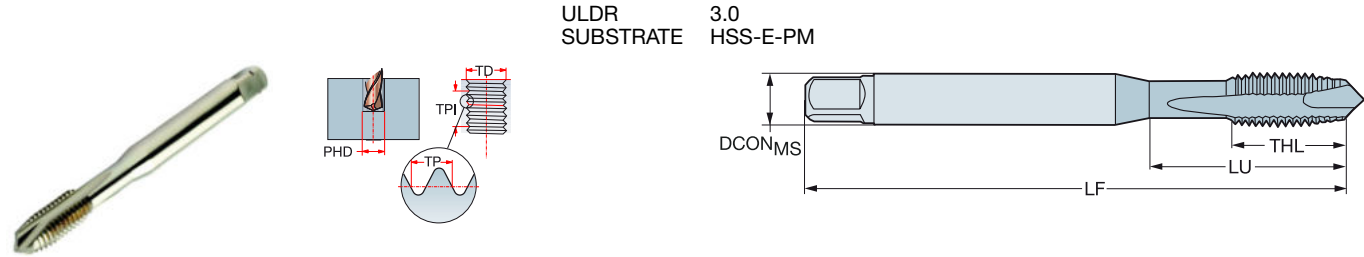
E27



C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNC
DIN/ANSI



N

						N Abmessungen, mm, Zoll									
						DIN									
TDZ	TPI	LU	CZC _{US}	THCHT	TCTR	Bestellnummer	DIN	DCON _{US}	TD	LF	THL	NOF	PHD	BSG	
UNC #4-40	40.00	15.47	.141 x .110	B	2B	T200-NM100AE-4-40	★	3.6	2.84	56.0	9.0	2	2.4	DIN/ANSI	
		.609						.141	.112	2.205	.354		.093		
UNC #6-32	32.00	15.08	.141 x .110	B	2B	T200-NM100AE-6-32	★	3.6	3.51	56.0	11.0	2	2.9	DIN/ANSI	
		.594						.141	.138	2.205	.433		.112		
UNC #8-32	32.00	16.58	.168 x .131	B	2B	T200-NM100AE-8-32	★	4.3	4.17	63.0	13.0	2	3.5	DIN/ANSI	
		.653						.168	.164	2.480	.512		.138		
UNC #10-24	24.00	21.42	.194 x .152	B	2B	T200-NM100AE-10-24	★	4.9	4.83	70.0	14.0	2	3.9	DIN/ANSI	
		.843						.194	.190	2.756	.551		.154		
UNC 1/4-20	20.00	25.59	.255 x .191	B	2B	T200-NM100AE-1/4	★	6.5	6.35	80.0	15.0	3	5.1	DIN/ANSI	
		1.007						.255	.250	3.150	.591		.201		
UNC 5/16-18	18.00	30.20	.318 x .238	B	2B	T200-NM100AE-5/16	★	8.1	7.94	90.0	18.0	3	6.6	DIN/ANSI	
		1.189						.318	.313	3.543	.709		.260		
UNC 7/16-14	14.00	72.60	.323 x .242	B	2B	T200-NM100AE-7/16	★	8.2	11.11	100.0	20.0	3	9.4	DIN/ANSI	
		2.858						.323	.438	3.937	.787		.370		
UNC 1/2-13	13.00	81.80	.367 x .275	B	2B	T200-NM100AE-1/2	★	9.3	12.70	110.0	23.0	3	10.8	DIN/ANSI	
		3.220						.367	.500	4.331	.906		.425		

Gewindeform: UNF
DIN/ANSI

						N Abmessungen, mm, Zoll								
TDZ	TPI	LU	CZC _{US}	THCHT	TCTR	Bestellnummer	DS	DCON _{US}	TD	LF	THL	NOF	PHD	BSG
UNF #10-32	32.00	21.42	.194 x .152	B	2B	T200-NM100AF-10-32	★	4.9	4.83	70.0	14.0	2	4.1	DIN/ANSI
		.843						.194	.190	2.756	.551		.161	
UNF 1/4-28	28.00	25.59	.255 x .191	B	2B	T200-NM100AF-1/4	★	6.5	6.35	80.0	15.0	3	5.5	DIN/ANSI
		1.007						.255	.250	3.150	.591		.217	

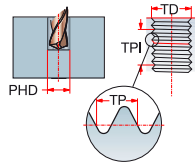
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNF

DIN/ANSI

ULDR
SUBSTRATE
COATING

2.5
HSS-PM
PVD TiAlN+WCC



M

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
UNF #10-32	32.00	21.42 .843	.194 x .152	B	2B	E87310-32	4.9 .194	4.83 .190	70.0 2.756	14.0 .551	3	DIN/ANSI	
UNF 1/4-28	28.00	25.59 1.007	.255 x .191	B	2B	E8731/4	6.5 .255	6.35 .250	80.0 3.150	15.0 .591	3	DIN/ANSI	
UNF 5/16-24	24.00	30.20 1.189	.318 x .238	B	2B	E8735/16	8.1 .318	7.94 .313	90.0 3.543	18.0 .709	3	DIN/ANSI	
UNF 3/8-24	24.00	32.80 1.292	.381 x .286	B	2B	E8733/8	9.7 .381	9.53 .375	100.0 3.937	20.0 .787	3	DIN/ANSI	
UNF 7/16-20	20.00	72.60 2.858	.323 x .242	B	2B	E8737/16	8.2 .323	11.11 .438	100.0 3.937	20.0 .787	4	DIN/ANSI	
UNF 1/2-20	20.00	81.80 3.220	.367 x .275	B	2B	E8731/2	9.3 .367	12.70 .500	110.0 4.331	23.0 .906	4	DIN/ANSI	
UNF 5/8-18	18.00	65.80 2.591	.480 x .360	B	2B	E8735/8	12.2 .480	15.88 .625	110.0 4.331	23.0 .906	4	DIN/ANSI	
UNF 7/8-14	14.00	90.90 3.579	.697 x .523	B	2B	E8737/8	17.7 .697	22.23 .875	140.0 5.512	34.0 1.339	4	DIN/ANSI	

B

C

D

E



C174



C157



E9



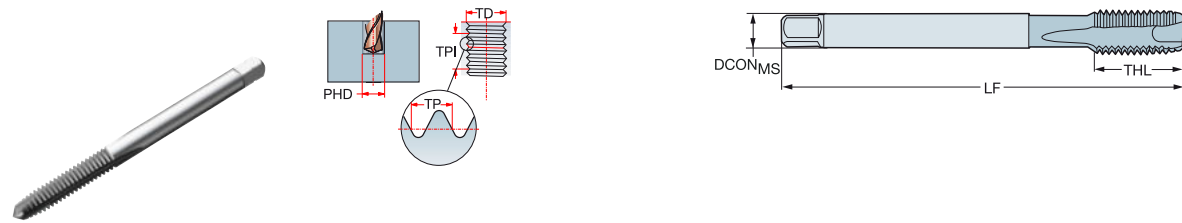
C154

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNF
DIN/ANSI

ULDR
SUBSTRATE
COATING

2.0
HSS-E-PM
PVD TiCN



B

Für Nickelbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	1/2 DIN	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
UNF #4-48	48.00	14.20	.141 x .110	B	3BX	T200-SD100AF-4-48	★	3.6	2.84	55.9	14.2	3	2.4	DIN/ANSI		
		.559						.141	.112	2.202	.559		.094			
UNF #6-40	40.00	17.50	.141 x .110	B	3BX	T200-SD100AF-6-40	★	3.6	3.51	55.3	17.5	3	3.0	DIN/ANSI		
		.689						.141	.138	2.176	.689		.116			
UNF #8-36	36.00	20.80	.168 x .131	B	3BX	T200-SD100AF-8-36	★	4.3	4.17	62.6	20.8	3	3.5	DIN/ANSI		
		.819						.168	.164	2.466	.819		.138			
UNF #10-32	32.00	24.10	.194 x .152	B	3BX	T200-SD100AF-10-32	★	4.9	4.83	69.7	24.1	3	4.1	DIN/ANSI		
		.949						.194	.190	2.744	.949		.161			
UNF 1/4-28	28.00	31.80	.255 x .191	B	3BX	T200-SD100AF-1/4	★	6.5	6.35	79.0	31.8	3	5.5	DIN/ANSI		
		1.252						.255	.250	3.111	1.252		.217			
UNF 5/16-24	24.00	39.70	.318 x .238	B	3BX	T200-SD100AF-5/16	★	8.1	7.94	89.1	39.7	3	6.9	DIN/ANSI		
		1.563						.318	.313	3.509	1.563		.272			
UNF 3/8-24	24.00	47.60	.381 x .286	B	3BX	T200-SD100AF-3/8	★	9.7	9.53	99.2	47.6	3	8.5	DIN/ANSI		
		1.874						.381	.375	3.906	1.874		.335			
UNF 7/16-20	20.00	72.60	.323 x .242	B	3BX	T200-SD100AF-7/16	★	8.2	11.11	100.0	20.0	4	9.9	DIN/ANSI		
		2.858						.323	.438	3.937	.787		.390			
UNF 1/2-20	20.00	81.80	.367 x .275	B	3BX	T200-SD100AF-1/2	★	9.3	12.70	110.0	23.0	4	11.5	DIN/ANSI		
		3.220						.367	.500	4.331	.906		.453			
UNF 5/8-18	18.00	65.80	.480 x .360	B	3BX	T200-SD100AF-5/8	★	12.2	15.88	110.0	23.0	4	14.5	DIN/ANSI		
		2.591						.480	.625	4.331	.906		.571			
UNF 3/4-16	16.00	77.50	.590 x .442	B	3BX	T200-SD100AF-3/4	★	15.0	19.05	125.0	30.0	4	17.5	DIN/ANSI		
		3.051						.590	.750	4.921	1.181		.689			

CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNJC

DIN/ANSI

ULDR
SUBSTRATE
COATING2.0
HSS-E-PM
PVD TiCN

Für Nickelbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DIN	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
UNJC #4-40	40.00	14.20	.141 x .110	B	3BX	T200-SD100AH-4-40		3.6	2.84	55.9	14.2	3	2.4	DIN/ANSI		
		.559					★	.141	.112	2.202	.559		.083			
UNJC #6-32	32.00	17.50	.141 x .110	B	3BX	T200-SD100AH-6-32	★	3.6	3.51	55.3	17.5	3	2.9	DIN/ANSI		
		.689					★	.141	.138	2.176	.689		.112			
UNJC #8-32	32.00	20.80	.168 x .131	B	3BX	T200-SD100AH-8-32	★	4.3	4.17	62.6	20.8	3	3.5	DIN/ANSI		
		.819					★	.168	.164	2.466	.819		.138			



C174



C157



E9



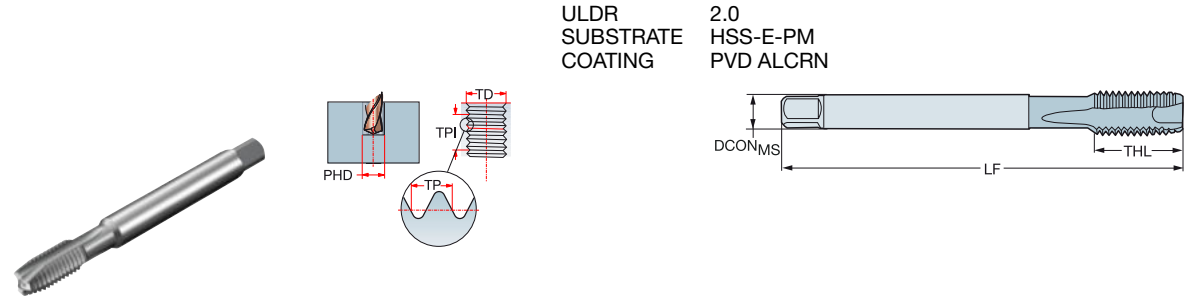
E27



C154

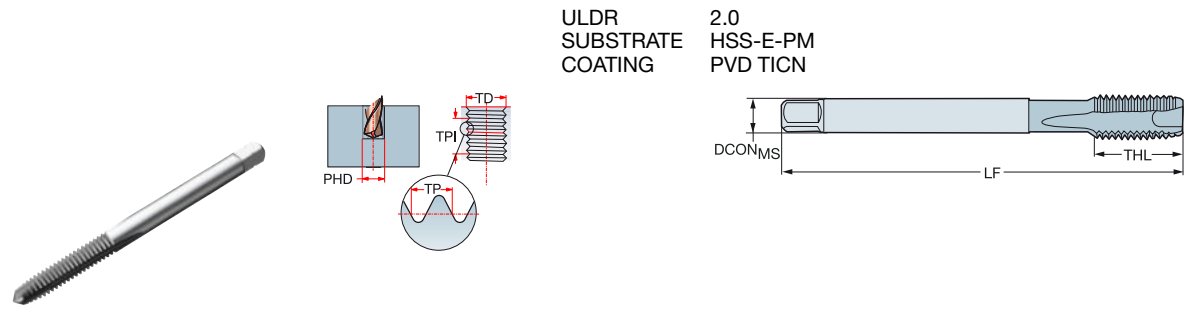
CoroTap™ 200 Gewindebohrer für Durchgangsbohrungen

Gewindeform: UNJF
DIN 2184-1, DIN/ANSI



Für Titanbasislegierungen

						s Abmessungen, mm, Zoll								
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DIS	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
UNJF #10-32	32.00	16.00	6.00 x 4.90	B	3B	T200-SM100DI-10-32	★	6.0	4.83	70.0	16.0	3	4.1	DIN 2184-1
		.630						.236	.190	2.756	.630		.161	
UNJF 1/4-28	28.00	25.00	7.00 x 5.50	B	3B	T200-SM100DI-1/4	★	7.0	6.35	80.0	15.0	3	5.5	DIN 2184-1
		.984						.276	.250	3.150	.591		.217	
UNJF 5/16-24	24.00	29.50	8.00 x 6.20	B	3B	T200-SM100DI-5/16	★	8.0	7.94	90.0	18.0	3	6.9	DIN 2184-1
		1.161						.315	.313	3.543	.709		.272	
UNJF 3/8-24	24.00	33.50	10.00 x 8.00	B	3B	T200-SM100DI-3/8	★	10.0	9.53	100.0	20.0	3	8.5	DIN 2184-1
		1.319						.394	.375	3.937	.787		.335	



Für Nickelbasislegierungen

							s	Abmessungen, mm, Zoll							
							D15								
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
UNJF #10-32	32.00	24.10	.194 x .152	B	3BX	T200-SD100AI-10-32	★	4.9	4.83	69.7	24.1	3	4.1	DIN/ANSI	
		.949						.194	.190	2.744	.949		.161		
UNJF 1/4-28	28.00	31.80	.255 x .191	B	3BX	T200-SD100AI-1/4	★	6.5	6.35	79.0	31.8	3	5.5	DIN/ANSI	
		1.252						.255	.250	3.111	1.252		.217		
UNJF 5/16-24	24.00	39.70	.323 x .242	B	3BX	T200-SD100AI-5/16	★	8.2	7.94	89.1	39.7	3	6.9	DIN/ANSI	
		1.563						.323	.313	3.509	1.563		.272		
UNJF 3/8-24	24.00	47.60	.381 x .286	B	3BX	T200-SD100AI-3/8	★	9.7	9.53	99.2	47.6	3	8.5	DIN/ANSI	
		1.874						.381	.375	3.906	1.874		.335		
UNJF 7/16-20	20.00	72.60	.323 x .242	B	3BX	T200-SD100AI-7/16	★	8.2	11.11	100.0	20.0	4	9.9	DIN/ANSI	
		2.858						.323	.438	3.937	.787		.390		
UNJF 1/2-20	20.00	81.80	.367 x .275	B	3BX	T200-SD100AI-1/2	★	9.3	12.70	110.0	23.0	4	11.5	DIN/ANSI	
		3.220						.367	.500	4.331	.906		.453		

CoroTap™ 300

Anwendungen

- Für Grundbohrungen geeignet
- In vielen Gewindeformen und -standards erhältlich
- Tiefen bis zu $3 \times D$



Vorteile und Merkmale

- Die spiralgenutete Ausführung des Spankanals gewährleistet einen konstanten Spanwinkel und sorgt für einen gleichmäßigen Schnitvorgang
 - Anschnittinterschliff bei hochspiraligen Gewindebohrern reduziert Drehmoment und Absplitterungen
 - Gewindebohrer mit hohem Spiralwinkel bieten hervorragende Spanabfuhr und erlauben Gewindetiefen bis zu $3 \times D$ in Grundbohrungen
 - Gewindebohrer mit niedrigem Spiralwinkel verfügen über stabile Schneiden und sind zur Bearbeitung von zähen Werkstoffen ausgelegt
 - Gewindebohrer aus HSS-Pulverschnellstahl für bessere Stabilität, Verschleißfestigkeit und Standzeit
 - Vollhartmetall-Gewindebohrer für längere Standzeit und höchste Produktivität
-
- Gewindebohrer, spiral genutet
 - Spankanal transportiert Späne aus der Bohrung
 - Beste Option bei Grundbohrungen
 - Unterschiedliche Steigungswinkel für verschiedenste Anwendungen
 - Spankanal für Kühlschmierstoffzufuhr und Spanabfuhr
 - Unterschiedliche Gewindetiefen, je nach Anwendung und Geometrie



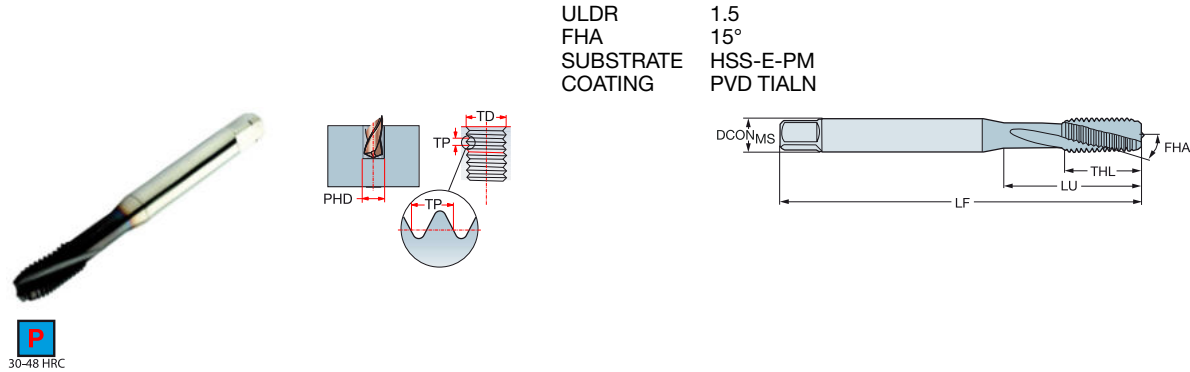
www.sandvik.coromant.com/corotap300



CoroChuck™ 970, siehe Katalog Rotierende Werkzeuge.

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
C-DIN 371, DIN 371, DIN 376



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MIS}	THCHT	TCTR	Bestellnummer	DCON _{MIS}	TD	LF	THL	NOF	BSG	
M 3	0.50	12.00	4.50 x 3.40	C	6H	E314M3	4.5	3.00	63.0	12.0	3	C-DIN 371	
		.472					.177	.118	2.480	.472			
M 4	0.70	13.00	6.00 x 4.90	C	6H	E314M4	6.0	4.00	70.0	13.0	3	C-DIN 371	
		.512					.236	.157	2.756	.512			
M 5	0.80	15.00	6.00 x 4.90	C	6H	E314M5	6.0	5.00	80.0	15.0	3	C-DIN 371	
		.591					.236	.197	3.150	.591			
M 6	1.00	18.00	8.00 x 6.20	C	6H	E314M6	8.0	6.00	90.0	18.0	3	C-DIN 371	
		.709					.315	.236	3.543	.709			
M 8	1.25	20.00	10.00 x 8.00	C	6H	E314M8	10.0	8.00	100.0	20.0	3	C-DIN 371	
		.787					.394	.315	3.937	.787			
M 10	1.50	39.00	10.00 x 8.00	C	6H	E314M10	10.0	10.00	100.0	20.0	3	DIN 371	
		1.535					.394	.394	3.937	.787			
M 12	1.75	83.00	9.00 x 7.00	C	6H	E316M12	9.0	12.00	110.0	23.0	4	DIN 376	
		3.268					.354	.472	4.331	.906			
M 14	2.00	81.00	11.00 x 9.00	C	6H	E316M14	11.0	14.00	110.0	25.0	4	DIN 376	
		3.189					.433	.551	4.331	.984			
M 16	2.00	68.00	12.00 x 9.00	C	6H	E316M16	12.0	16.00	110.0	25.0	4	DIN 376	
		2.677					.472	.630	4.331	.984			
M 20	2.50	95.00	16.00 x 12.00	C	6H	E316M20	16.0	20.00	140.0	30.0	4	DIN 376	
		3.740					.630	.787	5.512	1.181			

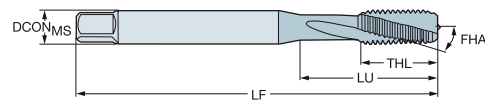
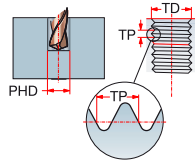
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN/ANSI

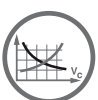
ULDR
FHA
SUBSTRATE
COATING

1.5
15°
HSS-E-PM
PVD TIALN



30-48 HRC

							Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 3	0.50	13.00	.168 x .131	C	6H	E864M3	4.3	3.00	63.0	14.7	3	DIN/ANSI
		.512					.168	.118	2.480	.579		
M 4	0.70	15.10	.194 x .152	C	6H	E864M4	4.9	4.00	70.0	15.1	3	DIN/ANSI
		.594					.194	.157	2.756	.594		
M 5	0.80	17.00	.255 x .191	C	6H	E864M5	6.5	5.00	80.0	17.0	3	DIN/ANSI
		.669					.255	.197	3.150	.669		
M 6	1.00	20.20	.318 x .238	C	6H	E864M6	8.1	6.00	90.0	20.2	3	DIN/ANSI
		.795					.318	.236	3.543	.795		
M 8	1.25	20.00	.381 x .286	C	6H	E864M8	9.7	8.00	100.0	22.8	3	DIN/ANSI
		.787					.381	.315	3.937	.898		
M 10	1.50	37.80	.381 x .286	C	6H	E864M10	9.7	10.00	100.0	20.0	3	DIN/ANSI
		1.488					.381	.394	3.937	.787		
M 12	1.75	86.02	.367 x .275	C	6H	E864M12	9.3	12.00	110.0	23.0	4	DIN/ANSI
		3.386					.367	.472	4.331	.906		
M 14	2.00	84.82	.429 x .322	C	6H	E864M14	10.9	14.00	110.0	23.0	4	DIN/ANSI
		3.339					.429	.551	4.331	.906		
M 16	2.00	70.86	.480 x .360	C	6H	E864M16	12.2	16.00	110.0	23.0	4	DIN/ANSI
		2.790					.480	.630	4.331	.906		
M 18	2.50	84.69	.542 x .406	C	6H	E864M18	13.8	18.00	125.0	30.0	4	DIN/ANSI
		3.334					.542	.709	4.921	1.181		
M 20	2.50	97.58	.652 x .489	C	6H	E864M20	16.6	20.00	140.0	30.0	4	DIN/ANSI
		3.842					.652	.787	5.512	1.181		



C177



C157



E9



C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR
FHA
SUBSTRATE
COATING

3.0
48°
HSS-E-PM
PVD TIALN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 1.6	0.35	20.00	2.50 x 2.10	C	6HX	EX03PM1.6	2.5	1.60	40.0	6.0	2	DIN 371	
	.787						.098	.063	1.575	.236			
M 2	0.40	9.00	2.80 x 2.10	C	6HX	EX03PM2	2.8	2.00	45.0	4.0	3	DIN 371	
	.354						.110	.079	1.772	.157			
M 2.3	0.40	12.00	2.80 x 2.10	C	6HX	EX03PM2.3	2.8	2.30	45.0	4.0	3	DIN 371	
	.472						.110	.091	1.772	.157			
M 2.5	0.45	12.50	2.80 x 2.10	C	6HX	EX03PM2.5	2.8	2.50	50.0	4.0	3	DIN 371	
	.492						.110	.098	1.969	.157			
M 2.6	0.45	12.50	2.80 x 2.10	C	6HX	EX03PM2.6	2.8	2.60	50.0	4.0	3	DIN 371	
	.492						.110	.102	1.969	.157			
M 3	0.50	18.00	3.50 x 2.70	C	6HX	EX03PM3	3.5	3.00	56.0	5.9	3	DIN 371	
	.709						.138	.118	2.205	.232			
M 3.5	0.60	20.00	4.00 x 3.00	C	6HX	EX03PM3.5	4.0	3.50	56.0	7.0	3	DIN 371	
	.787						.157	.138	2.205	.276			
M 4	0.70	21.00	4.50 x 3.40	C	6HX	EX03PM4	4.5	4.00	63.0	6.7	3	DIN 371	
	.827						.177	.157	2.480	.264			
M 5	0.80	25.00	6.00 x 4.90	C	6HX	EX03PM5	6.0	5.00	70.0	7.7	3	DIN 371	
	.984						.236	.197	2.756	.303			
M 5	0.80	49.00	3.50 x 2.70	C	6HX	EX03PM5DIN376	3.5	5.00	70.0	8.0	3	DIN 376	
	1.929						.138	.197	2.756	.315			
M 6	1.00	30.00	6.00 x 4.90	C	6HX	EX03PM6	6.0	6.00	80.0	10.0	3	DIN 371	
	1.181						.236	.236	3.150	.394			
M 6	1.00	59.00	4.50 x 3.40	C	6HX	EX03PM6DIN376	4.5	6.00	80.0	10.0	3	DIN 376	
	2.323						.177	.236	3.150	.394			
M 7	1.00	31.00	7.00 x 5.50	C	6HX	EX03PM7	7.0	7.00	80.0	10.0	3	DIN 371	
	1.220						.276	.276	3.150	.394			
M 8	1.25	35.00	8.00 x 6.20	C	6HX	EX03PM8	8.0	8.00	90.0	11.6	3	DIN 371	
	1.378						.315	.315	3.543	.457			
M 8	1.25	67.00	6.00 x 4.90	C	6HX	EX03PM8DIN376	6.0	8.00	90.0	13.0	3	DIN 376	
	2.638						.236	.315	3.543	.512			
M 10	1.50	39.00	10.00 x 8.00	C	6HX	EX03PM10	10.0	10.00	100.0	15.1	3	DIN 371	
	1.535						.394	.394	3.937	.594			
M 10	1.50	77.00	7.00 x 5.50	C	6HX	EX03PM10DIN376	7.0	10.00	100.0	15.0	3	DIN 376	
	3.032						.276	.394	3.937	.591			
M 12	1.75	83.00	9.00 x 7.00	C	6HX	EX03PM12	9.0	12.00	110.0	16.0	3	DIN 376	
	3.268						.354	.472	4.331	.630			
M 14	2.00	81.00	11.00 x 9.00	C	6HX	EX03PM14	11.0	14.00	110.0	20.0	3	DIN 376	
	3.189						.433	.551	4.331	.787			
M 16	2.00	68.00	12.00 x 9.00	C	6HX	EX03PM16	12.0	16.00	110.0	20.0	4	DIN 376	
	2.677						.472	.630	4.331	.787			
M 18	2.50	81.00	14.00 x 11.00	C	6HX	EX03PM18	14.0	18.00	125.0	25.0	4	DIN 376	
	3.189						.551	.709	4.921	.984			
M 20	2.50	95.00	16.00 x 12.00	C	6HX	EX03PM20	16.0	20.00	140.0	25.0	4	DIN 376	
	3.740						.630	.787	5.512	.984			
M 22	2.50	93.00	18.00 x 14.50	C	6HX	EX03PM22	18.0	22.00	140.0	25.0	4	DIN 376	
	3.661						.709	.866	5.512	.984			
M 24	3.00	113.00	18.00 x 14.50	C	6HX	EX03PM24	18.0	24.00	160.0	30.0	4	DIN 376	
	4.449						.709	.945	6.299	1.181			
M 27	3.00	97.00	20.00 x 16.00	C	6HX	EX03PM27	20.0	27.00	160.0	30.0	4	DIN 376	
	3.819						.787	1.063	6.299	1.181			
M 30	3.50	115.00	22.00 x 18.00	C	6HX	EX03PM30	22.0	30.00	180.0	36.0	4	DIN 376	
	4.528						.866	1.181	7.087	1.417			



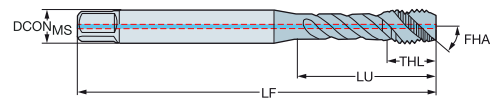
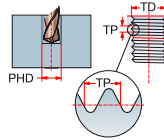
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN 371, DIN 376

ULDR
FHA
SUBSTRATE
COATING

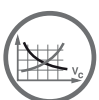
3.0
48°
HSS-E-PM
PVD TIALN



≤350HB

									Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 4	0.70	21.00	4.50 x 3.40	C	6HX	1	1	EX09PM4	4.5	4.00	63.0	6.7	3	DIN 371
	.827								.177	.157	2.480	.264		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	1	1	EX09PM5	6.0	5.00	70.0	7.7	3	DIN 371
	.984								.236	.197	2.756	.303		
M 6	1.00	31.00	6.00 x 4.90	C	6HX	1	1	EX09PM6	6.0	6.00	80.0	10.0	3	DIN 371
	1.220								.236	.236	3.150	.394		
M 7	1.00	31.00	7.00 x 5.50	C	6HX	1	1	EX09PM7	7.0	7.00	80.0	10.0	3	DIN 371
	1.220								.276	.276	3.150	.394		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	EX09PM8	8.0	8.00	90.0	11.6	3	DIN 371
	1.378								.315	.315	3.543	.457		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	EX09PM10	10.0	10.00	100.0	15.1	3	DIN 371
	1.535								.394	.394	3.937	.594		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	1	EX09PM12	9.0	12.00	110.0	16.0	3	DIN 376
	3.268								.354	.472	4.331	.630		
M 14	2.00	81.00	11.00 x 9.00	C	6HX	1	1	EX09PM14	11.0	14.00	110.0	20.0	3	DIN 376
	3.189								.433	.551	4.331	.787		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	1	1	EX09PM16	12.0	16.00	110.0	20.0	4	DIN 376
	2.677								.472	.630	4.331	.787		
M 18	2.50	81.00	14.00 x 11.00	C	6HX	1	1	EX09PM18	14.0	18.00	125.0	25.0	4	DIN 376
	3.189								.551	.709	4.921	.984		
M 20	2.50	95.00	16.00 x 12.00	C	6HX	1	1	EX09PM20	16.0	20.00	140.0	25.0	4	DIN 376
	3.740								.630	.787	5.512	.984		
M 22	2.50	93.00	18.00 x 14.50	C	6HX	1	1	EX09PM22	18.0	22.00	140.0	25.0	4	DIN 376
	3.661								.709	.866	5.512	.984		
M 24	3.00	113.00	18.00 x 14.50	C	6HX	1	1	EX09PM24	18.0	24.00	160.0	30.0	4	DIN 376
	4.449								.709	.945	6.299	1.181		
M 27	3.00	97.00	20.00 x 16.00	C	6HX	1	1	EX09PM27	20.0	27.00	160.0	30.0	4	DIN 376
	3.819								.787	1.063	6.299	1.181		
M 30	3.50	115.00	22.00 x 18.00	C	6HX	1	1	EX09PM30	22.0	30.00	180.0	36.0	4	DIN 376
	4.528								.866	1.181	7.087	1.417		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt



C177



C157



E9



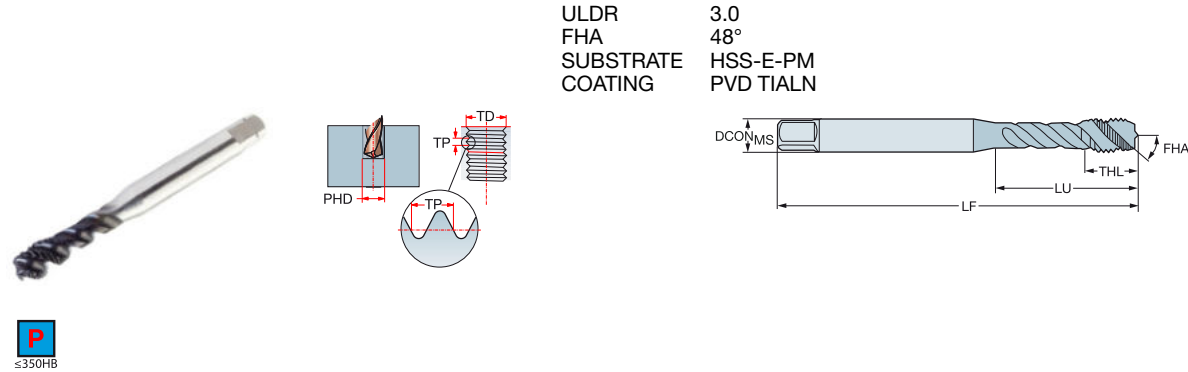
E28



C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
DIN/ANSI



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	15.88	.141 x .110	C	6HX	EX03PAM3	3.6	3.00	56.0	6.0	3	DIN/ANSI	
		.625					.141	.118	2.205	.236			
M 4	0.70	16.58	.168 x .131	C	6HX	EX03PAM4	4.3	4.00	63.0	7.0	3	DIN/ANSI	
		.653					.168	.157	2.480	.276			
M 5	0.80	21.42	.194 x .152	C	6HX	EX03PAM5	4.9	5.00	70.0	8.0	3	DIN/ANSI	
		.843					.194	.197	2.756	.315			
M 6	1.00	25.59	.255 x .191	C	6HX	EX03PAM6	6.5	6.00	80.0	10.0	3	DIN/ANSI	
		1.007					.255	.236	3.150	.394			
M 8	1.25	30.20	.318 x .238	C	6HX	EX03PAM8	8.1	8.00	90.0	12.0	3	DIN/ANSI	
		1.189					.318	.315	3.543	.472			
M 10	1.50	37.77	.381 x .286	C	6HX	EX03PAM10	9.7	10.00	100.0	15.0	3	DIN/ANSI	
		1.487					.381	.394	3.937	.591			
M 12	1.75	86.02	.367 x .275	C	6HX	EX03PAM12	9.3	12.00	110.0	18.0	3	DIN/ANSI	
		3.386					.367	.472	4.331	.709			
M 14	2.00	84.82	.429 x .322	C	6HX	EX03PAM14	10.9	14.00	110.0	20.0	3	DIN/ANSI	
		3.339					.429	.551	4.331	.787			
M 16	2.00	70.86	.480 x .360	C	6HX	EX03PAM16	12.2	16.00	110.0	23.0	4	DIN/ANSI	
		2.790					.480	.630	4.331	.906			
M 18	2.50	84.69	.542 x .406	C	6HX	EX03PAM18	13.8	18.00	125.0	30.0	4	DIN/ANSI	
		3.334					.542	.709	4.921	1.181			
M 20	2.50	97.58	.652 x .489	C	6HX	EX03PAM20	16.6	20.00	140.0	30.0	4	DIN/ANSI	
		3.842					.652	.787	5.512	1.181			
M 24	3.00	101.60	.760 x .570	C	6HX	EX03PAM24	19.3	24.00	160.0	30.0	4	DIN/ANSI	
		4.000					.760	.945	6.299	1.181			



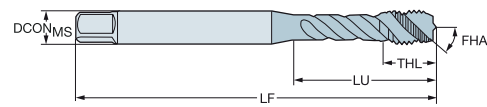
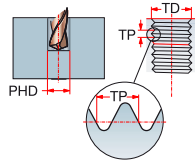
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN 371, DIN 376

ULDR
FHA
SUBSTRATE
COATING

2.0
40°
HSS-E
PVD FEN



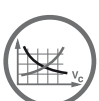
M

B

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6H	E346M3	3.5	3.00	56.0	5.9	3	DIN 371	
	.709						.138	.118	2.205	.232			
M 4	0.70	21.00	4.50 x 3.40	C	6H	E346M4	4.5	4.00	63.0	6.7	3	DIN 371	
	.827						.177	.157	2.480	.264			
M 5	0.80	25.00	6.00 x 4.90	C	6H	E346M5	6.0	5.00	70.0	7.7	3	DIN 371	
	.984						.236	.197	2.756	.303			
M 6	1.00	30.00	6.00 x 4.90	C	6H	E346M6	6.0	6.00	80.0	10.0	3	DIN 371	
	1.181						.236	.236	3.150	.394			
M 8	1.25	33.00	8.00 x 6.20	C	6H	E346M8	8.0	8.00	90.0	11.6	3	DIN 371	
	1.299						.315	.315	3.543	.457			
M 10	1.50	39.00	10.00 x 8.00	C	6H	E346M10	10.0	10.00	100.0	15.1	3	DIN 371	
	1.535						.394	.394	3.937	.594			
M 12	1.75	83.00	9.00 x 7.00	C	6H	E347M12	9.0	12.00	110.0	16.0	4	DIN 376	
	3.268						.354	.472	4.331	.630			
M 14	2.00	81.00	11.00 x 9.00	C	6H	E347M14	11.0	14.00	110.0	20.0	4	DIN 376	
	3.189						.433	.551	4.331	.787			
M 16	2.00	68.00	12.00 x 9.00	C	6H	E347M16	12.0	16.00	110.0	20.0	4	DIN 376	
	2.677						.472	.630	4.331	.787			
M 18	2.50	81.00	14.00 x 11.00	C	6H	E347M18	14.0	18.00	125.0	25.0	4	DIN 376	
	3.189						.551	.709	4.921	.984			
M 20	2.50	95.00	16.00 x 12.00	C	6H	E347M20	16.0	20.00	140.0	25.0	4	DIN 376	
	3.740						.630	.787	5.512	.984			
M 24	3.00	113.00	18.00 x 14.50	C	6H	E347M24	18.0	24.00	160.0	30.0	4	DIN 376	
	4.449						.709	.945	6.299	1.181			
M 27	3.00	97.00	20.00 x 16.00	C	6H	E347M27	20.0	27.00	160.0	30.0	4	DIN 376	
	3.819						.787	1.063	6.299	1.181			
M 30	3.50	115.00	22.00 x 18.00	C	6H	E347M30	22.0	30.00	180.0	36.0	4	DIN 376	
	4.528						.866	1.181	7.087	1.417			

C

D



C177



C157



E9



C154

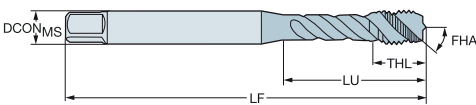
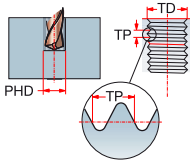
E

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR
FHA
SUBSTRATE
COATING

2.5
48°
HSS-E
PVD TIALN+WCC



M

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 1.6	0.35	8.00	2.50 x 2.10	C	6H	E404M1.6	2.5	1.60	40.0	6.0	2	DIN 371	
	.315						.098	.063	1.575	.236			
M 2	0.40	9.00	2.80 x 2.10	C	6H	E404M2	2.8	2.00	45.0	4.0	3	DIN 371	
	.354						.110	.079	1.772	.157			
M 2.2	0.45	12.00	2.80 x 2.10	C	6H	E404M2.2	2.8	2.20	45.0	4.0	3	DIN 371	
	.472						.110	.087	1.772	.157			
M 2.3	0.40	12.00	2.80 x 2.10	C	6H	E404M2.3	2.8	2.30	45.0	4.0	3	DIN 371	
	.472						.110	.091	1.772	.157			
M 2.5	0.45	12.50	2.80 x 2.10	C	6H	E404M2.5	2.8	2.50	50.0	4.0	3	DIN 371	
	.492						.110	.098	1.969	.157			
M 3	0.50	18.00	3.50 x 2.70	C	6H	E404M3	3.5	3.00	56.0	5.9	3	DIN 371	
	.709						.138	.118	2.205	.232			
M 4	0.70	21.00	4.50 x 3.40	C	6H	E404M4	4.5	4.00	63.0	6.7	3	DIN 371	
	.827						.177	.157	2.480	.264			
M 5	0.80	25.00	6.00 x 4.90	C	6H	E404M5	6.0	5.00	70.0	7.7	3	DIN 371	
	.984						.236	.197	2.756	.303			
M 6	1.00	30.00	6.00 x 4.90	C	6H	E404M6	6.0	6.00	80.0	10.0	3	DIN 371	
	1.181						.236	.236	3.150	.394			
M 8	1.25	35.00	8.00 x 6.20	C	6H	E404M8	8.0	8.00	90.0	11.6	3	DIN 371	
	1.378						.315	.315	3.543	.457			
M 10	1.50	39.00	10.00 x 8.00	C	6H	E404M10	10.0	10.00	100.0	15.1	3	DIN 371	
	1.535						.394	.394	3.937	.594			
M 12	1.75	83.00	9.00 x 7.00	C	6H	E404M12	9.0	12.00	110.0	23.0	3	DIN 376	
	3.268						.354	.472	4.331	.906			
M 14	2.00	81.00	11.00 x 9.00	C	6H	E404M14	11.0	14.00	110.0	20.0	3	DIN 376	
	3.189						.433	.551	4.331	.787			
M 16	2.00	68.00	12.00 x 9.00	C	6H	E404M16	12.0	16.00	110.0	20.0	4	DIN 376	
	2.677						.472	.630	4.331	.787			
M 20	2.50	95.00	16.00 x 12.00	C	6H	E404M20	16.0	20.00	140.0	25.0	4	DIN 376	
	3.740						.630	.787	5.512	.984			



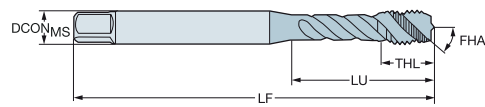
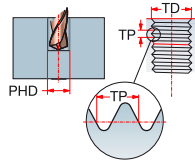
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

2.5
48°
HSS-PM
PVD TiAlN+WCC



M

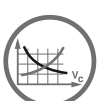
B

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
M 4	0.70	16.58	.168 x .131	C	6H	E862M4	4.3	4.00	63.0	7.9	3	DIN/ANSI	
		.653					.168	.157	2.480	.311			
M 5	0.80	21.42	.194 x .152	C	6H	E862M5	4.9	5.00	70.0	8.0	3	DIN/ANSI	
		.843					.194	.197	2.756	.315			
M 6	1.00	25.59	.255 x .191	C	6H	E862M6	6.5	6.00	80.0	10.7	3	DIN/ANSI	
		1.007					.255	.236	3.150	.421			
M 8	1.25	30.20	.318 x .238	C	6H	E862M8	8.1	8.00	90.0	12.1	3	DIN/ANSI	
		1.189					.318	.315	3.543	.476			
M 10	1.50	32.80	.381 x .286	C	6H	E862M10	9.7	10.00	100.0	15.1	3	DIN/ANSI	
		1.292					.381	.394	3.937	.594			
M 12	1.75	86.02	.367 x .275	C	6H	E862M12	9.3	12.00	110.0	18.0	3	DIN/ANSI	
		3.386					.367	.472	4.331	.709			
M 16	2.00	70.86	.480 x .360	C	6H	E862M16	12.2	16.00	110.0	20.0	4	DIN/ANSI	
		2.790					.480	.630	4.331	.787			

C

D

E



C177



C157



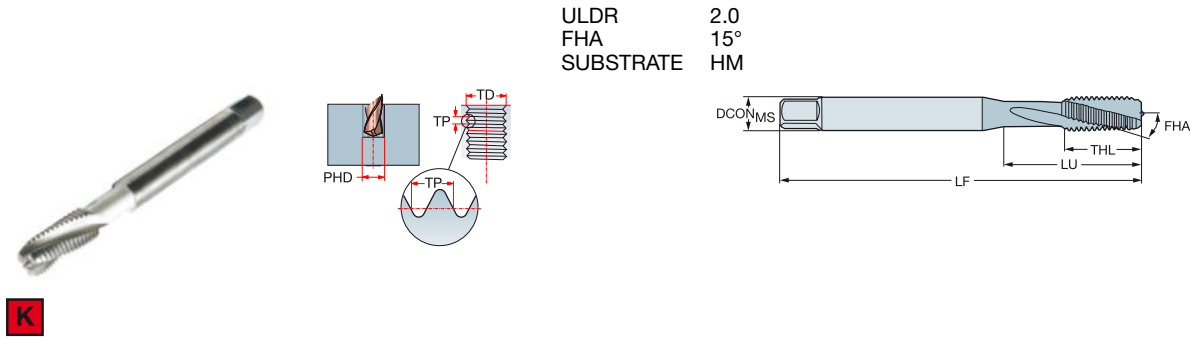
E9



C154

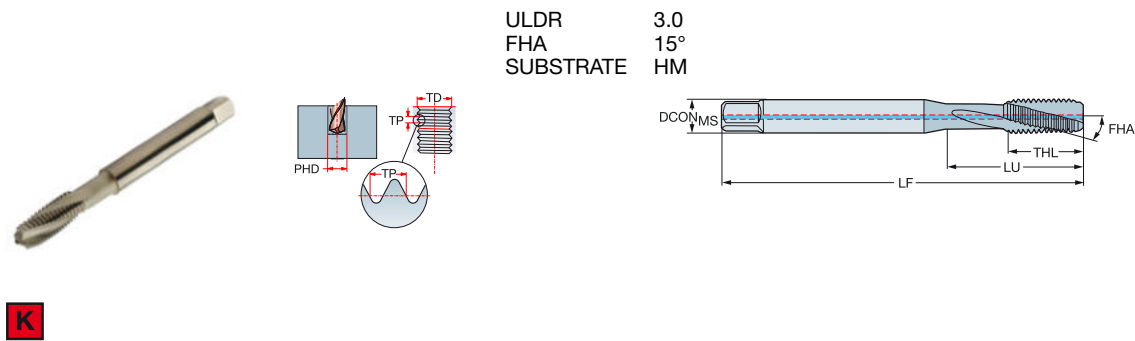
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
C-DIN 371, DIN 376



K

							Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
M 3	0.50	10.00	3.50 x 2.70	C	6H	T105M3	3.5	3.00	56.0	10.0	3	C-DIN 371
	.394						.138	.118	2.205	.394		
M 4	0.70	13.00	4.50 x 3.40	C	6H	T105M4	4.5	4.00	63.0	13.0	3	C-DIN 371
	.512						.177	.157	2.480	.512		
M 5	0.80	16.00	6.00 x 4.90	C	6H	T105M5	6.0	5.00	70.0	16.0	3	C-DIN 371
	.630						.236	.197	2.756	.630		
M 6	1.00	30.00	6.00 x 4.90	C	6H	T105M6	6.0	6.00	80.0	19.0	3	C-DIN 371
	1.181						.236	.236	3.150	.748		
M 8	1.25	35.00	8.00 x 6.20	C	6H	T105M8	8.0	8.00	90.0	22.0	3	C-DIN 371
	1.378						.315	.315	3.543	.866		
M 10	1.50	39.00	10.00 x 8.00	C	6H	T105M10	10.0	10.00	100.0	24.0	3	C-DIN 371
	1.535						.394	.394	3.937	.945		
M 12	1.75	83.00	9.00 x 7.00	C	6H	T105M12	9.0	12.00	110.0	23.0	3	DIN 376
	3.268						.354	.472	4.331	.906		



K

							Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC CXSC	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF BSG
M 5	0.80	47.00	6.00 x 4.90	C	6H	1 1	T106M5	6.0	5.00	70.0	16.0	3 C-DIN 371
	1.850							.236	.197	2.756	.630	
M 6	1.00	30.00	6.00 x 4.90	C	6H	1 1	T106M6	6.0	6.00	80.0	19.0	3 C-DIN 371
	1.181							.236	.236	3.150	.748	
M 8	1.25	35.00	8.00 x 6.20	C	6H	1 1	T106M8	8.0	8.00	90.0	22.0	3 C-DIN 371
	1.378							.315	.315	3.543	.866	
M 10	1.50	39.00	10.00 x 8.00	C	6H	1 1	T106M10	10.0	10.00	100.0	24.0	3 C-DIN 371
	1.535							.394	.394	3.937	.945	
M 12	1.75	83.00	9.00 x 7.00	C	6H	1 1	T106M12	9.0	12.00	110.0	23.0	3 DIN 376
	3.268							.354	.472	4.331	.906	

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

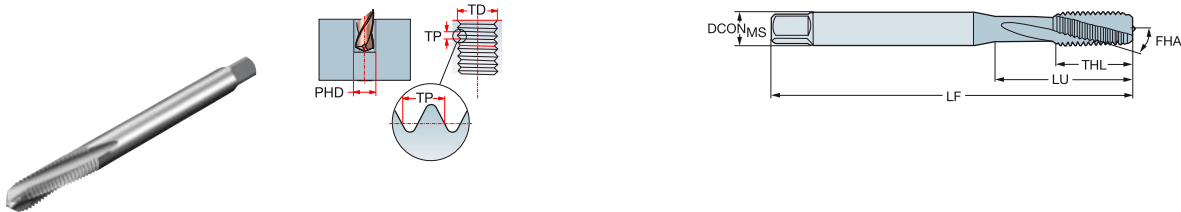
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN 371

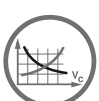
ULDR
FHA
SUBSTRATE

1.5
10°
HSS-E-PM



Für Nickelbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
M 3	0.50	8.00	3.50 x 2.70	C	6HX	T300-SD100DA-M3	★	3.5	3.00	56.0	8.0	3	2.5	DIN 371		
		.315						.138	.118	2.205	.315		.098			
M 4	0.70	10.50	4.50 x 3.40	C	6HX	T300-SD100DA-M4	★	4.5	4.00	63.0	10.5	3	3.3	DIN 371		
		.413						.177	.157	2.480	.413		.130			
M 5	0.80	13.00	6.00 x 4.90	C	6HX	T300-SD100DA-M5	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371		
		.512						.236	.197	2.756	.512		.165			
M 6	1.00	16.00	6.00 x 4.90	C	6HX	T300-SD100DA-M6	★	6.0	6.00	80.0	16.0	3	5.0	DIN 371		
		.630						.236	.236	3.150	.630		.197			
M 8	1.25	20.50	8.00 x 6.20	C	6HX	T300-SD100DA-M8	★	8.0	8.00	90.0	20.5	3	6.8	DIN 371		
		.807						.315	.315	3.543	.807		.268			
M 10	1.50	25.50	10.00 x 8.00	C	6HX	T300-SD100DA-M10	★	10.0	10.00	100.0	25.5	3	8.5	DIN 371		
		1.004						.394	.394	3.937	1.004		.335			
M 12	1.75	30.50	12.00 x 9.00	C	6HX	T300-SD100DA-M12	★	12.0	12.00	110.0	30.5	4	10.2	DIN 371		
		1.201						.472	.472	4.331	1.201		.402			
M 16	2.00	39.50	16.00 x 12.00	C	6HX	T300-SD100DA-M16	★	16.0	16.00	110.0	39.5	4	14.0	DIN 371		
		1.555						.630	.630	4.331	1.555		.551			



C177



C157



E9



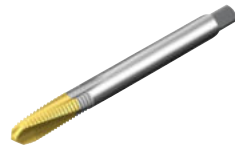
E27

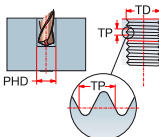


C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

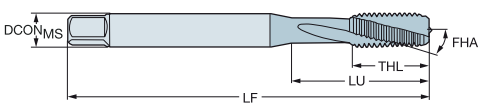
Gewindeform: Metrisch
DIN 371





ULDR
FHA
SUBSTRATE
COATING

1.5
10°
HSS-E-PM
PVD TIN



B

Für Nickelbasislegierungen

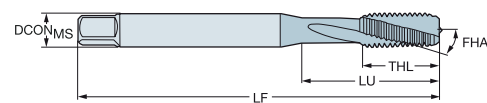
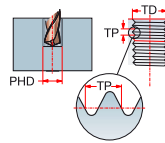
							P	M	K	N	S	H	Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D1.25	D1.25	D1.25	D1.25	D1.25	D1.25	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	8.00	3.50 x 2.70	C	6HX	T300-SD101DA-M3	☆	☆	☆	☆	★	☆	3.5	3.00	56.0	8.0	3	2.5	DIN 371
	.315												.138	.118	2.205	.315		.098	
M 4	0.70	10.50	4.50 x 3.40	C	6HX	T300-SD101DA-M4	☆	☆	☆	☆	★	☆	4.5	4.00	63.0	10.5	3	3.3	DIN 371
	.413												.177	.157	2.480	.413		.130	
M 5	0.80	13.00	6.00 x 4.90	C	6HX	T300-SD101DA-M5	☆	☆	☆	☆	★	☆	6.0	5.00	70.0	13.0	3	4.2	DIN 371
	.512												.236	.197	2.756	.512		.165	
M 6	1.00	16.00	6.00 x 4.90	C	6HX	T300-SD101DA-M6	☆	☆	☆	☆	★	☆	6.0	6.00	80.0	16.0	3	5.0	DIN 371
	.630												.236	.236	3.150	.630		.197	
M 8	1.25	20.50	8.00 x 6.20	C	6HX	T300-SD101DA-M8	☆	☆	☆	☆	★	☆	8.0	8.00	90.0	20.5	3	6.8	DIN 371
	.807												.315	.315	3.543	.807		.268	
M 10	1.50	25.50	10.00 x 8.00	C	6HX	T300-SD101DA-M10	☆	☆	☆	☆	★	☆	10.0	10.00	100.0	25.5	3	8.5	DIN 371
	1.004												.394	.394	3.937	1.004		.335	
M 12	1.75	30.50	12.00 x 9.00	C	6HX	T300-SD101DA-M12	☆	☆	☆	☆	★	☆	12.0	12.00	110.0	30.5	4	10.2	DIN 371
	1.201												.472	.472	4.331	1.201		.402	
M 16	2.00	39.50	16.00 x 12.00	C	6HX	T300-SD101DA-M16	☆	☆	☆	☆	★	☆	16.0	16.00	110.0	39.5	4	14.0	DIN 371
	1.555												.630	.630	4.331	1.555		.551	

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN 371, DIN 376

ULDR 2.0
FHA 15°
SUBSTRATE HSS-E-PM
COATING PVD ALCRN



Für Titanbasislegierungen

										Abmessungen, mm, Zoll				
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D15	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
M 2	0.40	8.00	2.80 x 2.10	C	6HX	T300-SM100DA-M2	★	2.8	2.00	45.0	8.0	3	1.6	DIN 371
		.315						.110	.079	1.772	.315		.063	
M 2.5	0.45	30.00	2.80 x 2.10	C	6HX	T300-SM100DA-M2.5	★	2.8	2.50	50.0	9.0	3	2.1	DIN 371
		1.181						.110	.098	1.969	.354		.081	
M 3	0.50	10.00	3.50 x 2.70	C	6HX	T300-SM100DA-M3	★	3.5	3.00	56.0	10.0	3	2.5	DIN 371
		.394						.138	.118	2.205	.394		.098	
M 3.5	0.60	12.00	4.00 x 3.00	C	6HX	T300-SM100DA-M3.5	★	4.0	3.50	56.0	12.0	3	2.9	DIN 371
		.472						.157	.138	2.205	.472		.114	
M 4	0.70	13.00	4.50 x 3.40	C	6HX	T300-SM100DA-M4	★	4.5	4.00	63.0	13.0	3	3.3	DIN 371
		.512						.177	.157	2.480	.512		.130	
M 5	0.80	16.00	6.00 x 4.90	C	6HX	T300-SM100DA-M5	★	6.0	5.00	70.0	16.0	3	4.2	DIN 371
		.630						.236	.197	2.756	.630		.165	
M 6	1.00	23.00	6.00 x 4.90	C	6HX	T300-SM100DA-M6	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371
		.906						.236	.236	3.150	.591		.197	
M 8	1.25	29.50	8.00 x 6.20	C	6HX	T300-SM100DA-M8	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.161						.315	.315	3.543	.709		.268	
M 10	1.50	33.50	10.00 x 8.00	C	6HX	T300-SM101DA-M10	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.319						.394	.394	3.937	.787		.335	
M 12	1.75	83.00	9.00 x 7.10	C	6HX	T300-SM101DA-M12	★	9.0	12.00	110.0	23.0	4	10.2	DIN 376
		3.268						.354	.472	4.331	.906		.402	
M 16	2.00	68.00	12.00 x 9.00	C	6HX	T300-SM101DA-M16	★	12.0	16.00	110.0	25.0	4	14.0	DIN 376
		2.677						.472	.630	4.331	.984		.551	
M 20	2.50	95.00	16.00 x 12.00	C	6HX	T300-SM101DA-M20	★	16.0	20.00	140.0	30.0	4	17.5	DIN 376
		3.740						.630	.787	5.512	1.181		.689	



C177



C157



E9



E27



C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
DIN 371

ULDR
FHA
SUBSTRATE
COATING

1.5
15°
HSS-E-PM
PVD ZrN - D125
UNCOAT - D150



N

							Abmessungen, mm, Zoll									
							N									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D125	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6H	T300-NM100DA-M3	★	★	3.5	3.00	56.0	9.0	3	2.5	DIN 371	
		.709							.138	.118	2.205	.354		.098		
M 4	0.70	21.00	4.50 x 3.40	C	6H	T300-NM100DA-M4	★	★	4.5	4.00	63.0	12.0	3	3.3	DIN 371	
		.827							.177	.157	2.480	.472		.130		
M 5	0.80	25.00	6.00 x 4.90	C	6H	T300-NM100DA-M5	★	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371	
		.984							.236	.197	2.756	.512		.165		
M 6	1.00	30.00	6.00 x 4.90	C	6H	T300-NM100DA-M6	★	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371	
		1.181							.236	.236	3.150	.591		.197		
M 8	1.25	35.00	8.00 x 6.20	C	6H	T300-NM100DA-M8	★	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371	
		1.378							.315	.315	3.543	.709		.268		
M 10	1.50	39.00	10.00 x 8.00	C	6H	T300-NM100DA-M10	★	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371	
		1.535							.394	.394	3.937	.787		.335		

C

D

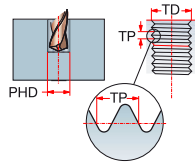
E

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN 376

ULDR 1.5
 FHA 15°
 SUBSTRATE HSS-E-PM
 COATING UNCOAT - D150



N

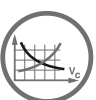
							N	Abmessungen, mm, Zoll							
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
M 14	2.00	81.00	11.00 x 9.00	C	6H	T300-NM101DA-M14	★	11.0	14.00	110.0	25.0	3	12.0	DIN 376	
		3.189						.433	.551	4.331	.984		.472		
M 16	2.00	68.00	12.00 x 9.00	C	6H	T300-NM101DA-M16	★	12.0	16.00	110.0	25.0	3	14.0	DIN 376	
		2.677						.472	.630	4.331	.984		.551		

B

C

D

E



C177



C157



E9



E27

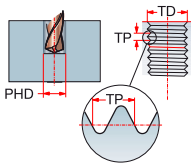


C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch
DIN 371, DIN 376

ULDR2.5
FHA35°
SUBSTRATEHSS-E, HSS-E-PM
COATINGUNCOAT - B150



N

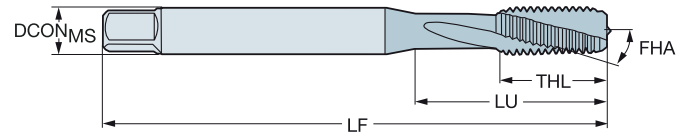
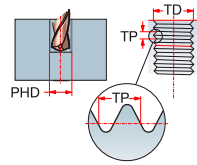
							N	Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	BSG	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG			
M 3	0.50	18.00	3.50 x 2.70	C	6H	T300-NM100DA-M3	★	3.5	3.00	56.0	9.0	3	2.5	DIN 371			
	.709							.138	.118	2.205	.354		.098				
M 4	0.70	21.00	4.50 x 3.40	C	6H	T300-NM100DA-M4	★	4.5	4.00	63.0	12.0	3	3.3	DIN 371			
	.827							.177	.157	2.480	.472		.130				
M 5	0.80	25.00	6.00 x 4.90	C	6H	T300-NM100DA-M5	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371			
	.984							.236	.197	2.756	.512		.165				
M 6	1.00	30.00	6.00 x 4.90	C	6H	T300-NM100DA-M6	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371			
	1.181							.236	.236	3.150	.591		.197				
M 8	1.25	35.00	8.00 x 6.20	C	6H	T300-NM100DA-M8	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371			
	1.378							.315	.315	3.543	.709		.268				
M 10	1.50	39.00	10.00 x 8.00	C	6H	T300-NM100DA-M10	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371			
	1.535							.394	.394	3.937	.787		.335				
M 14	2.00	81.00	11.00 x 9.00	C	6H	T300-NM101DA-M14	★	11.0	14.00	110.0	25.0	3	12.0	DIN 376			
	3.189							.433	.551	4.331	.984		.472				
M 16	2.00	68.00	12.00 x 9.00	C	6H	T300-NM101DA-M16	★	12.0	16.00	110.0	25.0	3	14.0	DIN 376			
	2.677							.472	.630	4.331	.984		.551				
M 12	1.75	83.00	9.00 x 7.00	C	6H	T300-NM101DA-M12	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376			
	3.268							.354	.472	4.331	.906		.402				
M 20	2.50	95.00	16.00 x 12.00	C	6H	T300-NM101DA-M20	★	16.0	20.00	140.0	30.0	3	17.5	DIN 376			
	3.740							.630	.787	5.512	1.181		.689				

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch

DIN/ANSI

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E-PM



N

B

							N	Abmessungen, mm, Zoll							
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
M 5	0.80	21.42 .843	.194 x .152	C	6H	T300-NM100AA-M5	★	4.9 .194	5.00 .197	70.0 2.756	14.0 .551	3	4.2 .165	DIN/ANSI	
M 6	1.00	25.59 1.007	.255 x .191	C	6H	T300-NM100AA-M6	★	6.5 .255	6.00 .236	80.0 3.150	15.0 .591	3	5.0 .197	DIN/ANSI	
M 8	1.25	30.20 1.189	.318 x .238	C	6H	T300-NM100AA-M8	★	8.1 .318	8.00 .315	90.0 3.543	18.0 .709	3	6.8 .268	DIN/ANSI	
M 10	1.50	32.80 1.292	.381 x .286	C	6H	T300-NM100AA-M10	★	9.7 .381	10.00 .394	100.0 3.937	20.0 .787	3	8.5 .335	DIN/ANSI	
M 12	1.75	86.02 3.386	.367 x .275	C	6H	T300-NM101AA-M12	★	9.3 .367	12.00 .472	110.0 4.331	23.0 .906	3	10.2 .402	DIN/ANSI	

C

D

E



C177



C157



E9



E27



C154

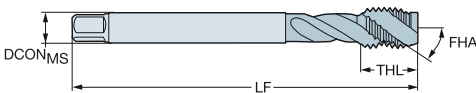
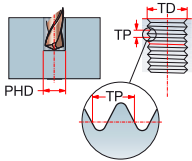
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein

DIN 374

ULDR
FHA
SUBSTRATE
COATING

3.0
48°
HSS-E-PM
PVD TIALN



B

C

D

E

							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
MF 4x0.5	0.50	43.00	2.80 x 2.10	C	6HX	EX13PM4X.50	2.8	4.00	63.0	7.0	3	DIN 374	
		1.693					.110	.157	2.480	.276			
MF 5x0.5	0.50	49.00	3.50 x 2.70	C	6HX	EX13PM5X.50	3.5	5.00	70.0	8.0	3	DIN 374	
		1.929					.138	.197	2.756	.315			
MF 6x0.75	0.75	59.00	4.50 x 3.40	C	6HX	EX13PM6X.75	4.5	6.00	80.0	10.0	3	DIN 374	
		2.323					.177	.236	3.150	.394			
MF 8x0.75	0.75	57.00	6.00 x 4.90	C	6HX	EX13PM8X.75	6.0	8.00	80.0	13.0	3	DIN 374	
		2.244					.236	.315	3.150	.512			
MF 8x1	1.00	67.00	6.00 x 4.90	C	6HX	EX13PM8X1.0	6.0	8.00	90.0	13.0	3	DIN 374	
		2.638					.236	.315	3.543	.512			
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	EX13PM10X1.0	7.0	10.00	90.0	13.0	3	DIN 374	
		2.638					.276	.394	3.543	.512			
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6HX	EX13PM10X1.25	7.0	10.00	100.0	15.0	3	DIN 374	
		3.032					.276	.394	3.937	.591			
MF 12x1	1.00	73.00	9.00 x 7.00	C	6HX	EX13PM12X1.0	9.0	12.00	100.0	15.0	3	DIN 374	
		2.874					.354	.472	3.937	.591			
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	EX13PM12X1.25	9.0	12.00	100.0	15.0	3	DIN 374	
		2.874					.354	.472	3.937	.591			
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	EX13PM12X1.5	9.0	12.00	100.0	15.0	3	DIN 374	
		2.874					.354	.472	3.937	.591			
MF 14x1	1.00	71.00	11.00 x 9.00	C	6HX	EX13PM14X1.0	11.0	14.00	100.0	15.0	3	DIN 374	
		2.795					.433	.551	3.937	.591			
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6HX	EX13PM14X1.25	11.0	14.00	100.0	15.0	3	DIN 374	
		2.795					.433	.551	3.937	.591			
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	EX13PM14X1.5	11.0	14.00	100.0	15.0	3	DIN 374	
		2.795					.433	.551	3.937	.591			
MF 16x1	1.00	58.00	12.00 x 9.00	C	6HX	EX13PM16X1.0	12.0	16.00	100.0	15.0	4	DIN 374	
		2.283					.472	.630	3.937	.591			
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	EX13PM16X1.5	12.0	16.00	100.0	15.0	4	DIN 374	
		2.283					.472	.630	3.937	.591			
MF 18x1	1.00	66.00	14.00 x 11.00	C	6HX	EX13PM18X1.0	14.0	18.00	110.0	17.0	4	DIN 374	
		2.598					.551	.709	4.331	.669			
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6HX	EX13PM18X1.5	14.0	18.00	110.0	17.0	4	DIN 374	
		2.598					.551	.709	4.331	.669			
MF 20x1	1.00	80.00	16.00 x 12.00	C	6HX	EX13PM20X1.0	16.0	20.00	125.0	17.0	4	DIN 374	
		3.150					.630	.787	4.921	.669			
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6HX	EX13PM20X1.5	16.0	20.00	125.0	17.0	4	DIN 374	
		3.150					.630	.787	4.921	.669			
MF 22x1.5	1.50	78.00	18.00 x 14.50	C	6HX	EX13PM22X1.5	18.0	22.00	125.0	17.0	4	DIN 374	
		3.071					.709	.866	4.921	.669			
MF 24x1.5	1.50	93.00	18.00 x 14.50	C	6HX	EX13PM24X1.5	18.0	24.00	140.0	20.0	4	DIN 374	
		3.661					.709	.945	5.512	.787			
MF 24x2	2.00	93.00	18.00 x 14.50	C	6HX	EX13PM24X2.0	18.0	24.00	140.0	20.0	4	DIN 374	
		3.661					.709	.945	5.512	.787			
MF 25x1.5	1.50	93.00	18.00 x 14.50	C	6HX	EX13PM25X1.5	18.0	25.00	140.0	20.0	4	DIN 374	
		3.661					.709	.984	5.512	.787			
MF 26x1.5	1.50	93.00	18.00 x 14.50	C	6HX	EX13PM26X1.5	18.0	26.00	140.0	20.0	4	DIN 374	
		3.661					.709	1.024	5.512	.787			
MF 27x1.5	1.50	77.00	20.00 x 16.00	C	6HX	EX13PM27X1.5	20.0	27.00	140.0	20.0	4	DIN 374	
		3.032					.787	1.063	5.512	.787			
MF 27x2	2.00	77.00	20.00 x 16.00	C	6HX	EX13PM27X2.0	20.0	27.00	140.0	20.0	4	DIN 374	
		3.032					.787	1.063	5.512	.787			

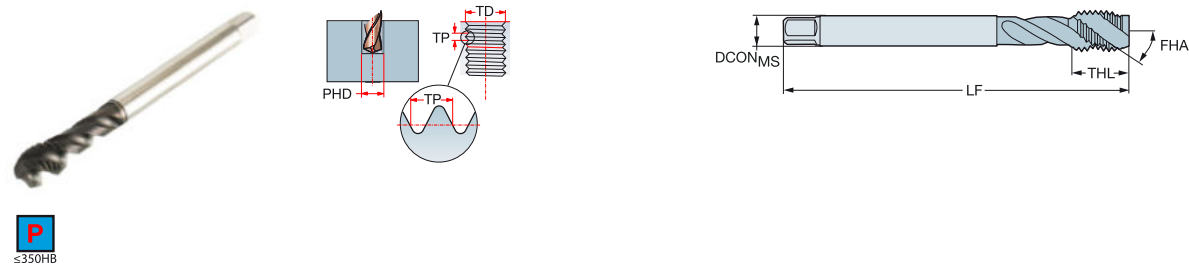


CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein
DIN 374

ULDR
FHA
SUBSTRATE
COATING

3.0
48°
HSS-E-PM
PVD TIALN



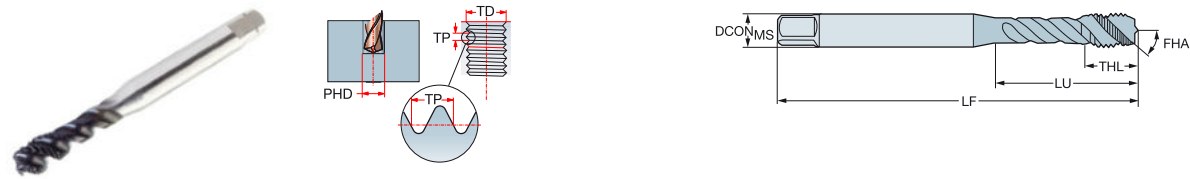
						Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
MF 30x1.5	1.50	85.00	22.00 x 18.00	C	6HX	EX13PM30X1.5	22.0	30.00	150.0	20.0	4	DIN 374
		3.346					.866	1.181	5.906	.787		
MF 30x2	2.00	85.00	22.00 x 18.00	C	6HX	EX13PM30X2.0	22.0	30.00	150.0	20.0	4	DIN 374
		3.346					.866	1.181	5.906	.787		

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein
DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

3.0
48°
HSS-E-PM
PVD TIALN



							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
MF 8x1	1.00	33.17	.318 x .238	C	6HX	EX13PAM8X1.0	8.1	8.00	90.0	12.1	3	DIN/ANSI	
		1.306					.318	.315	3.543	.476			
MF 12x1.25	1.25	81.80	.367 x .275	C	6HX	EX13PAM12X1.25	9.3	12.00	110.0	18.0	3	DIN/ANSI	
		3.220					.367	.472	4.331	.709			
MF 12x1.5	1.50	81.80	.367 x .275	C	6HX	EX13PAM12X1.5	9.3	12.00	110.0	18.0	3	DIN/ANSI	
		3.220					.367	.472	4.331	.709			
MF 16x1.5	1.50	65.80	.480 x .360	C	6HX	EX13PAM16X1.5	12.2	16.00	110.0	20.0	4	DIN/ANSI	
		2.591					.480	.630	4.331	.787			
MF 18x1.5	1.50	79.00	.542 x .406	C	6HX	EX13PAM18X1.5	13.8	18.00	125.0	25.0	4	DIN/ANSI	
		3.110					.542	.709	4.921	.984			

C

D

E



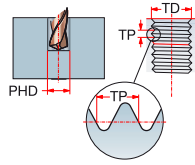
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein

DIN 374

ULDR
FHA
SUBSTRATE
COATING

2.0
40°
HSS-E
PVD FEN



M

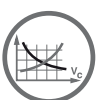
							Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
MF 6x0.75	0.75	59.00	4.50 x 3.40	C	6H	E363M6X.75	4.5	6.00	80.0	10.0	3	DIN 374	
		2.323					.177	.236	3.150	.394			
MF 8x1	1.00	67.00	6.00 x 4.90	C	6H	E363M8X1.0	6.0	8.00	90.0	12.0	3	DIN 374	
		2.638					.236	.315	3.543	.472			
MF 10x1	1.00	67.00	7.00 x 5.50	C	6H	E363M10X1.0	7.0	10.00	90.0	12.0	3	DIN 374	
		2.638					.276	.394	3.543	.472			
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6H	E363M10X1.25	7.0	10.00	100.0	15.0	3	DIN 374	
		3.032					.276	.394	3.937	.591			
MF 12x1	1.00	73.00	9.00 x 7.00	C	6H	E363M12X1.0	9.0	12.00	100.0	13.0	4	DIN 374	
		2.874					.354	.472	3.937	.512			
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6H	E363M12X1.25	9.0	12.00	100.0	13.0	4	DIN 374	
		2.874					.354	.472	3.937	.512			
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6H	E363M12X1.5	9.0	12.00	100.0	13.0	4	DIN 374	
		2.874					.354	.472	3.937	.512			
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6H	E363M14X1.5	11.0	14.00	100.0	15.0	4	DIN 374	
		2.795					.433	.551	3.937	.591			
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6H	E363M16X1.5	12.0	16.00	100.0	15.0	5	DIN 374	
		2.283					.472	.630	3.937	.591			
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6H	E363M18X1.5	14.0	18.00	110.0	17.0	5	DIN 374	
		2.598					.551	.709	4.331	.669			
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6H	E363M20X1.5	16.0	20.00	125.0	17.0	5	DIN 374	
		3.150					.630	.787	4.921	.669			

B

C

D

E



C177



C157



E9

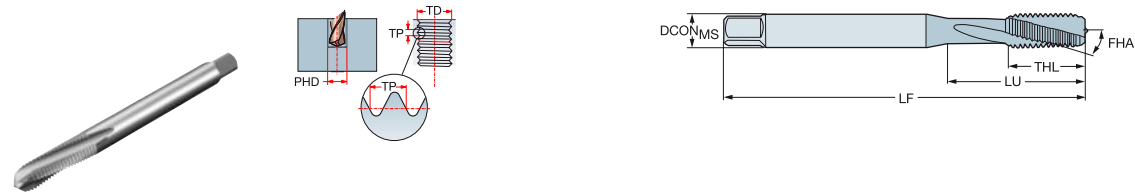


C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein
DIN 374

ULDR1.5
FHA10°
SUBSTRATEHSS-E-PM



Für Nickelbasislegierungen

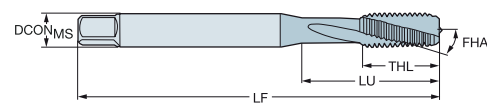
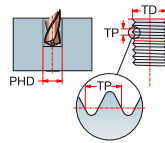
							s Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TC _{TR}	Bestellnummer	DIN 374	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
MF 8x1	1.00	20.00	8.00 x 6.20	C	6HX	T300-SD100DB-M8X100		8.0	8.00	90.0	20.0	3	7.0	DIN 374		
		.787						.315	.315	3.543	.787		.276			
MF 10x1	1.00	24.00	10.00 x 8.00	C	6HX	T300-SD100DB-M10X100		10.0	10.00	90.0	24.0	3	9.0	DIN 374		
		.945						.394	.394	3.543	.945		.354			
MF 10x1.25	1.25	24.50	10.00 x 8.00	C	6HX	T300-SD100DB-M10X125		10.0	10.00	100.0	24.5	3	8.8	DIN 374		
		.965						.394	.394	3.937	.965		.344			
MF 12x1	1.00	28.00	12.00 x 9.00	C	6HX	T300-SD100DB-M12X100		12.0	12.00	100.0	28.0	4	11.0	DIN 374		
		1.102						.472	.472	3.937	1.102		.433			
MF 12x1.25	1.25	28.50	12.00 x 9.00	C	6HX	T300-SD100DB-M12X125		12.0	12.00	100.0	28.5	4	10.8	DIN 374		
		1.122						.472	.472	3.937	1.122		.423			
MF 12x1.5	1.50	29.50	12.00 x 9.00	C	6HX	T300-SD100DB-M12X150		12.0	12.00	100.0	29.5	4	10.5	DIN 374		
		1.161						.472	.472	3.937	1.161		.413			

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein

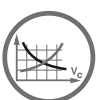
DIN 371, DIN 374

ULDR 2.0
FHA 15°
SUBSTRATE HSS-E-PM
COATING PVD ALCRN



Für Titanbasislegierungen

							Abmessungen, mm, Zoll							
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D _{T15}	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
MF 6x0.75	0.75	23.00	6.00 x 4.90	C	6HX	T300-SM100DB-M6X075		6.0	6.00	80.0	15.0	3	5.3	DIN 371
		.906						.236	.236	3.150	.591		.207	
MF 8x0.75	0.75	29.50	8.00 x 6.20	C	6HX	T300-SM100DB-M8X075	★	8.0	8.00	90.0	18.0	3	7.3	DIN 371
		1.161						.315	.315	3.543	.709		.285	
MF 8x1	1.00	29.50	8.00 x 6.20	C	6HX	T300-SM100DB-M8X100	★	8.0	8.00	90.0	18.0	3	7.0	DIN 371
		1.161						.315	.315	3.543	.709		.276	
MF 10x1	1.00	33.50	10.00 x 8.00	C	6HX	T300-SM100DB-M10X100	★	10.0	10.00	100.0	20.0	3	9.0	DIN 371
		1.319						.394	.394	3.937	.787		.354	
MF 12x1	1.00	73.00	9.00 x 7.00	C	6HX	T300-SM100DB-M12X100	★	9.0	12.00	100.0	21.0	4	11.0	DIN 374
		2.874						.354	.472	3.937	.827		.433	
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	T300-SM100DB-M12X150	★	9.0	12.00	100.0	21.0	4	10.5	DIN 374
		2.874						.354	.472	3.937	.827		.413	
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	T300-SM100DB-M14X150	★	11.0	14.00	100.0	21.0	4	12.5	DIN 374
		2.795						.433	.551	3.937	.827		.492	



C177



C157



E9



E27



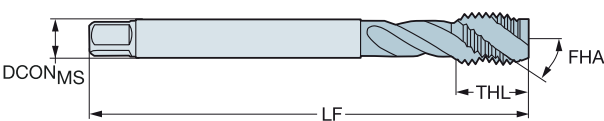
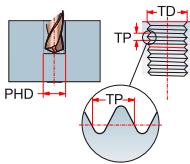
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: Metrisch Fein
DIN 374

ULDR
FHA
SUBSTRATE
COATING

2.5
35°
HSS-E
UNCOAT



N

						Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	BSG	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
MF 5x0.5	0.50	49.00	3.50 x 2.70	C	6H	T300-NM100DB-M5X050	★	3.5	5.00	70.0	13.0	2	4.5	DIN 374	
		1.929						.138	.197	2.756	.512		.177		
MF 8x1	1.00	67.00	6.00 x 4.90	C	6H	T300-NM100DB-M8X100	★	6.0	8.00	90.0	18.0	2	7.0	DIN 374	
		2.638						.236	.315	3.543	.709		.276		
MF 10x1	1.00	67.00	7.00 x 5.50	C	6H	T300-NM100DB-M10X100	★	7.0	10.00	90.0	20.0	3	9.0	DIN 374	
		2.638						.276	.394	3.543	.787		.354		
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6H	T300-NM100DB-M10X125	★	7.0	10.00	100.0	20.0	3	8.8	DIN 374	
		3.032						.276	.394	3.937	.787		.346		
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6H	T300-NM100DB-M12X125	★	9.0	12.00	100.0	21.0	3	10.8	DIN 374	
		2.874						.354	.472	3.937	.827		.425		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6H	T300-NM100DB-M12X150	★	9.0	12.00	100.0	21.0	3	10.5	DIN 374	
		2.874						.354	.472	3.937	.827		.413		
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6H	T300-NM100DB-M14X125	★	11.0	14.00	100.0	21.0	3	12.8	DIN 374	
		2.795						.433	.551	3.937	.827		.504		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6H	T300-NM100DB-M14X150	★	11.0	14.00	100.0	21.0	3	12.5	DIN 374	
		2.795						.433	.551	3.937	.827		.492		
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6H	T300-NM100DB-M16X150	★	12.0	16.00	100.0	21.0	3	14.5	DIN 374	
		2.283						.472	.630	3.937	.827		.571		
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6H	T300-NM100DB-M18X150	★	14.0	18.00	110.0	24.0	3	16.5	DIN 374	
		2.598						.551	.709	4.331	.945		.650		
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6H	T300-NM100DB-M20X150	★	16.0	20.00	125.0	24.0	3	18.5	DIN 374	
		3.150						.630	.787	4.921	.945		.728		

D

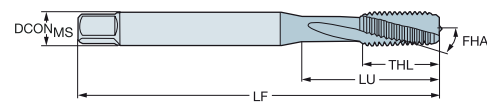
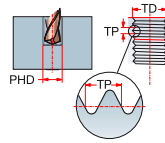
E

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: MJ

DIN 371

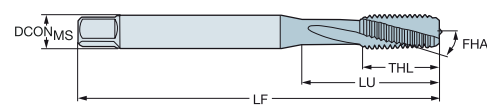
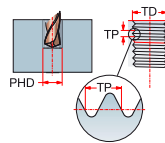
ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM



Für Nickelbasislegierungen

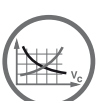
							s Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
MJ 3	0.50	8.00	3.50 x 2.70	C	4H	T300-SD100DC-MJ3	★	3.5	3.00	56.0	8.0	3	2.5	DIN 371		
		.315						.138	.118	2.205	.315		.098			
MJ 4	0.70	10.50	4.50 x 3.40	C	4H	T300-SD100DC-MJ4	★	4.5	4.00	63.0	10.5	3	3.3	DIN 371		
		.413						.177	.157	2.480	.413		.130			
MJ 5	0.80	13.00	6.00 x 4.90	C	4H	T300-SD100DC-MJ5	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371		
		.512						.236	.197	2.756	.512		.165			
MJ 6	1.00	15.50	6.00 x 4.90	C	4H	T300-SD100DC-MJ6	★	6.0	6.00	80.0	15.5	3	5.0	DIN 371		
		.610						.236	.236	3.150	.610		.197			

ULDR 2.0
FHA 15°
SUBSTRATE HSS-E-PM
COATING PVD ALCRN



Für Titanbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D15	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
MJ 4	0.70	13.00	4.50 x 3.40	C	6HX	T300-SM100DC-MJ4	★	4.5	4.00	63.0	13.0	3	3.3	DIN 371		
		.512						.177	.157	2.480	.512		.130			
MJ 5	0.80	16.00	6.00 x 4.90	C	6HX	T300-SM100DC-MJ5	★	6.0	5.00	70.0	16.0	3	4.2	DIN 371		
		.630						.236	.197	2.756	.630		.165			
MJ 6	1.00	23.00	6.00 x 4.90	C	6HX	T300-SM100DC-MJ6	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371		
		.906						.236	.236	3.150	.591		.197			
MJ 8	1.25	29.50	8.00 x 6.20	C	6HX	T300-SM100DC-MJ8	★	8.0	8.00	100.0	18.0	3	6.8	DIN 371		
		1.161						.315	.315	3.937	.709		.268			



C177



C157



E9



E27



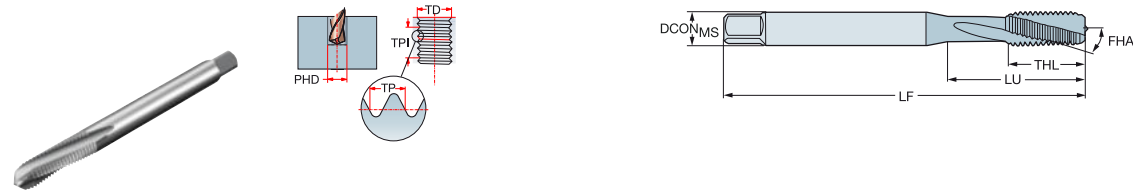
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC
DIN 2184-1

ULDR
FHA
SUBSTRATE

1.5
25°
HSS-E-PM



B

Für Nickelbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	s	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
UNC #3-48	48.00	9.00	2.80 x 2.10	C	2B	T300-SD100DE-3-48		2.8	2.51	50.0	9.0	3	2.1	DIN 2184-1		
		.354						.110	.099	1.969	.354		.083			
UNC #2-56	56.00	9.00	2.80 x 2.10	C	2B	T300-SD100DE-2-56		2.8	2.18	45.0	9.0	3	1.9	DIN 2184-1		
		.354						.110	.086	1.772	.354		.073			
UNC #4-40	40.00	10.00	3.50 x 2.70	C	2B	T300-SD100DE-4-40		3.5	2.84	56.0	10.0	3	2.4	DIN 2184-1		
		.394						.138	.112	2.205	.394		.093			
UNC #6-32	32.00	12.00	4.00 x 3.00	C	2B	T300-SD100DE-6-32		4.0	3.51	56.0	12.0	3	2.9	DIN 2184-1		
		.472						.157	.138	2.205	.472		.112			
UNC #8-32	32.00	13.00	4.50 x 3.40	C	2B	T300-SD100DE-8-32		4.5	4.17	63.0	13.0	3	3.5	DIN 2184-1		
		.512						.177	.164	2.480	.512		.138			
UNC #10-24	24.00	16.00	6.00 x 4.90	C	2B	T300-SD100DE-10-24		6.0	4.83	70.0	16.0	3	3.9	DIN 2184-1		
		.630						.236	.190	2.756	.630		.154			
UNC 1/4-20	20.00	25.00	7.00 x 5.50	C	2B	T300-SD100DE-1/4		7.0	6.35	80.0	15.0	3	5.1	DIN 2184-1		
		.984						.276	.250	3.150	.591		.201			
UNC 5/16-18	18.00	29.50	8.00 x 6.20	C	2B	T300-SD100DE-5/16		8.0	7.94	90.0	18.0	3	6.6	DIN 2184-1		
		1.161						.315	.313	3.543	.709		.260			
UNC 3/8-16	16.00	33.50	10.00 x 8.00	C	2B	T300-SD100DE-3/8		10.0	9.53	100.0	20.0	4	8.0	DIN 2184-1		
		1.319						.394	.375	3.937	.787		.315			

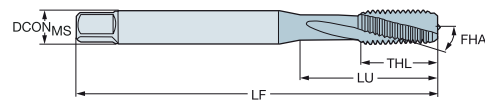
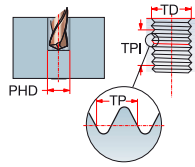
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC

C-DIN/ANSI, DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

1.5
15°
HSS-E-PM
PVD TIALN



							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
UNC #4-40	40.00	11.90	.141 x .110	C	2B	E8844-40	3.6	2.84	56.0	11.9	3	C-DIN/ANSI	
		.469					.141	.112	2.205	.469			
UNC #6-32	32.00	13.90	.168 x .131	C	2B	E8846-32	4.3	3.51	63.0	13.9	3	C-DIN/ANSI	
		.547					.168	.138	2.480	.547			
UNC #8-32	32.00	15.10	.194 x .152	C	2B	E8848-32	4.9	4.17	70.0	15.1	3	C-DIN/ANSI	
		.594					.194	.164	2.756	.594			
UNC #10-24	24.00	17.00	.255 x .191	C	2B	E88410-24	6.5	4.83	80.0	17.0	3	C-DIN/ANSI	
		.669					.255	.190	3.150	.669			
UNC 1/4-20	20.00	20.20	.318 x .238	C	2B	E8841/4	8.1	6.35	90.0	20.2	3	C-DIN/ANSI	
		.795					.318	.250	3.543	.795			
UNC 5/16-18	18.00	20.00	.381 x .286	C	2B	E8845/16	9.7	7.94	100.0	22.8	3	C-DIN/ANSI	
		.787					.381	.313	3.937	.898			
UNC 3/8-16	16.00	37.00	.381 x .286	C	2B	E8843/8	9.7	9.53	100.0	20.0	3	DIN/ANSI	
		1.457					.381	.375	3.937	.787			
UNC 7/16-14	14.00	72.60	.323 x .242	C	2B	E8847/16	8.2	11.11	100.0	20.0	4	DIN/ANSI	
		2.858					.323	.438	3.937	.787			
UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	E8841/2	9.3	12.70	110.0	23.0	4	DIN/ANSI	
		3.220					.367	.500	4.331	.906			
UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	E8845/8	12.2	15.88	110.0	23.0	4	DIN/ANSI	
		2.591					.480	.625	4.331	.906			
UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	E8843/4	15.0	19.05	125.0	30.0	4	DIN/ANSI	
		3.051					.590	.750	4.921	1.181			

B

C

D

E



C177



C157



E9



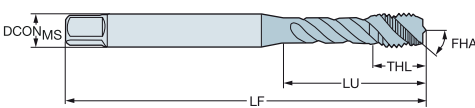
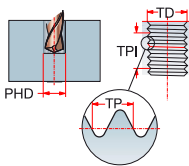
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC
DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

3.0
48°
HSS-E-PM
PVD TIALN



							Abmessungen, mm, Zoll						
TCT	TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
H1	UNC #2-56	56.00	11.99	.141 x .110	C	3B	EX23PA2-56	3.6	2.18	45.0	4.0	3	DIN/ANSI
			.472					.141	.086	1.772	.157		
H2	UNC #4-40	40.00	16.97	.141 x .110	C	2B	EX23PA4-40	3.6	2.84	56.0	6.5	3	DIN/ANSI
			.668					.141	.112	2.205	.256		
H2	UNC #5-40	40.00	17.74	.141 x .110	C	2B	EX23PA5-40	3.6	3.18	56.0	6.5	3	DIN/ANSI
			.698					.141	.125	2.205	.256		
H3	UNC #6-32	32.00	20.20	.141 x .110	C	2B	EX23PA6-32	3.6	3.51	56.0	6.5	3	DIN/ANSI
			.795					.141	.138	2.205	.256		
H3	UNC #8-32	32.00	21.18	.168 x .131	C	2B	EX23PA8-32	4.3	4.17	63.0	7.0	3	DIN/ANSI
			.834					.168	.164	2.480	.276		
H5	UNC #8-32	32.00	21.18	.168 x .131	C	2B	EX23PA8-32H5	4.3	4.17	63.0	7.0	3	DIN/ANSI
			.834					.168	.164	2.480	.276		
H3	UNC #10-24	24.00	27.54	.194 x .152	C	2B	EX23PA10-24	4.9	4.83	70.0	8.4	3	DIN/ANSI
			1.084					.194	.190	2.756	.331		
H3	UNC 1/4-20	20.00	24.69	.255 x .191	C	3B	EX23PA1/4	6.5	6.35	80.0	10.2	3	DIN/ANSI
			.972					.255	.250	3.150	.402		
H5	UNC 1/4-20	20.00	24.69	.255 x .191	C	2B	EX23PA1/4H5	6.5	6.35	80.0	10.2	3	DIN/ANSI
			.972					.255	.250	3.150	.402		
H3	UNC 5/16-18	18.00	33.17	.318 x .238	C	3B	EX23PA5/16	8.1	7.94	90.0	12.2	3	DIN/ANSI
			1.306					.318	.313	3.543	.480		
H5	UNC 5/16-18	18.00	33.17	.318 x .238	C	2B	EX23PA5/16H5	8.1	7.94	90.0	12.2	3	DIN/ANSI
			1.306					.318	.313	3.543	.480		
H3	UNC 3/8-16	16.00	38.07	.381 x .286	C	3B	EX23PA3/8	9.7	9.53	100.0	15.8	3	DIN/ANSI
			1.499					.381	.375	3.937	.622		
H5	UNC 3/8-16	16.00	38.07	.381 x .286	C	2B	EX23PA3/8H5	9.7	9.53	100.0	15.8	3	DIN/ANSI
			1.499					.381	.375	3.937	.622		
H3	UNC 7/16-14	14.00	72.60	.323 x .242	C	3B	EX23PA7/16	8.2	11.11	100.0	15.0	3	DIN/ANSI
			2.858					.323	.438	3.937	.591		
H3	UNC 1/2-13	13.00	81.80	.367 x .275	C	3B	EX23PA1/2	9.3	12.70	110.0	18.0	3	DIN/ANSI
			3.220					.367	.500	4.331	.709		
H5	UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	EX23PA1/2H5	9.3	12.70	110.0	18.0	3	DIN/ANSI
			3.220					.367	.500	4.331	.709		
H3	UNC 5/8-11	11.00	65.80	.480 x .360	C	3B	EX23PA5/8	12.2	15.88	110.0	20.0	4	DIN/ANSI
			2.591					.480	.625	4.331	.787		
H5	UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	EX23PA5/8H5	12.2	15.88	110.0	20.0	4	DIN/ANSI
			2.591					.480	.625	4.331	.787		
H3	UNC 3/4-10	10.00	77.50	.590 x .442	C	3B	EX23PA3/4	15.0	19.05	125.0	25.0	4	DIN/ANSI
			3.051					.590	.750	4.921	.984		
H5	UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	EX23PA3/4H5	15.0	19.05	125.0	25.0	4	DIN/ANSI
			3.051					.590	.750	4.921	.984		
H4	UNC 7/8-9	9.00	90.90	.697 x .523	C	3B	EX23PA7/8	17.7	22.23	140.0	25.0	4	DIN/ANSI
			3.579					.697	.875	5.512	.984		
H4	UNC 1"-8	8.00	95.40	.800 x .600	C	3B	EX23PA1	20.3	25.40	160.0	30.0	4	DIN/ANSI
			3.756					.800	1.000	6.299	1.181		



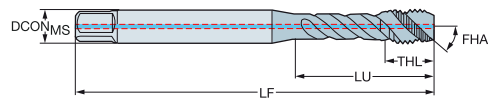
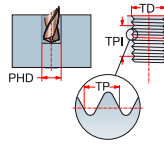
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC

DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

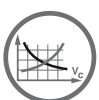
3.0
48°
HSS-E-PM
PVD TIALN



≤350HB

									Abmessungen, mm, Zoll					
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
UNC 1/4-20	20.00	24.69	.255 x .191	C	2BX	1	1	EX29PA1/4	6.5	6.35	80.0	10.2	3	DIN/ANSI
		.972							.255	.250	3.150	.402		
UNC 5/16-18	18.00	33.17	.318 x .238	C	2BX	1	1	EX29PA5/16	8.1	7.94	90.0	12.2	3	DIN/ANSI
		1.306							.318	.313	3.543	.480		
UNC 3/8-16	16.00	38.07	.381 x .286	C	2BX	1	1	EX29PA3/8	9.7	9.53	100.0	15.8	3	DIN/ANSI
		1.499							.381	.375	3.937	.622		
UNC 1/2-13	13.00	81.90	.367 x .275	C	2BX	1	1	EX29PA1/2	9.3	12.70	110.0	18.0	3	DIN/ANSI
		3.224							.367	.500	4.331	.709		
UNC 5/8-11	11.00	65.80	.480 x .360	C	2BX	1	1	EX29PA5/8	12.2	15.88	110.0	20.0	4	DIN/ANSI
		2.591							.480	.625	4.331	.787		
UNC 3/4-10	10.00	77.50	.590 x .442	C	2BX	1	1	EX29PA3/4	15.0	19.05	125.0	25.0	4	DIN/ANSI
		3.051							.590	.750	4.921	.984		
UNC 7/8-9	9.00	90.90	.697 x .523	C	2BX	1	1	EX29PA7/8	17.7	22.23	140.0	25.0	4	DIN/ANSI
		3.579							.697	.875	5.512	.984		
UNC 1"-8	8.00	95.40	.800 x .600	C	2BX	1	1	EX29PA1	20.3	25.40	160.0	30.0	4	DIN/ANSI
		3.756							.800	1.000	6.299	1.181		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt



C177



C157



E9



E28



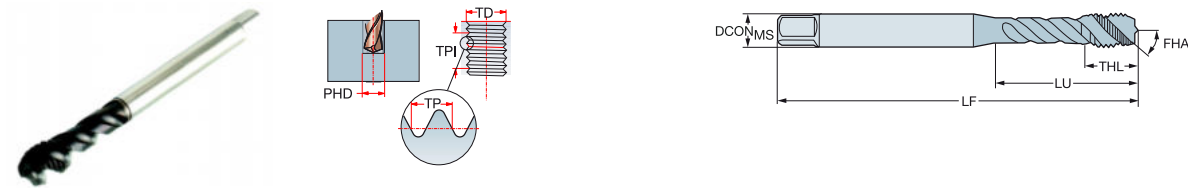
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC
DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

2.5
48°
HSS-PM
PVD TIALN+WCC



M

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
UNC #4-40	40.00	15.47	.141 x .110	C	2B	E8824-40	3.6	2.84	56.0	6.5	3	DIN/ANSI	
		.609					.141	.112	2.205	.256			
UNC #6-32	32.00	15.08	.141 x .110	C	2B	E8826-32	3.6	3.51	56.0	6.5	3	DIN/ANSI	
		.594					.141	.138	2.205	.256			
UNC #8-32	32.00	16.58	.168 x .131	C	2B	E8828-32	4.3	4.17	63.0	7.0	3	DIN/ANSI	
		.653					.168	.164	2.480	.276			
UNC #10-24	24.00	21.00	.194 x .152	C	2B	E88210-24	4.9	4.83	70.0	8.4	3	DIN/ANSI	
		.827					.194	.190	2.756	.331			
UNC 1/4-20	20.00	25.59	.255 x .191	C	2B	E8821/4	6.5	6.35	80.0	10.2	3	DIN/ANSI	
		1.007					.255	.250	3.150	.402			
UNC 5/16-18	18.00	30.20	.318 x .238	C	2B	E8825/16	8.1	7.94	90.0	12.2	3	DIN/ANSI	
		1.189					.318	.313	3.543	.480			
UNC 3/8-16	16.00	32.80	.381 x .286	C	2B	E8823/8	9.7	9.53	100.0	15.8	3	DIN/ANSI	
		1.292					.381	.375	3.937	.622			
UNC 7/16-14	14.00	72.60	.323 x .242	C	2B	E8827/16	8.2	11.11	100.0	15.0	3	DIN/ANSI	
		2.858					.323	.438	3.937	.591			
UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	E8821/2	9.3	12.70	110.0	18.0	3	DIN/ANSI	
		3.220					.367	.500	4.331	.709			
UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	E8825/8	12.2	15.88	110.0	20.0	4	DIN/ANSI	
		2.591					.480	.625	4.331	.787			
UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	E8823/4	15.0	19.05	125.0	25.0	4	DIN/ANSI	
		3.051					.590	.750	4.921	.984			
UNC 7/8-9	9.00	90.90	.697 x .523	C	2B	E8827/8	17.7	22.23	140.0	25.0	4	DIN/ANSI	
		3.579					.697	.875	5.512	.984			

D

E

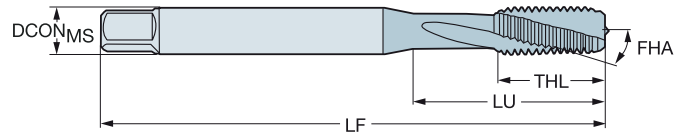
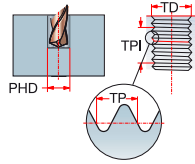


CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNC

DIN/ANSI

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E-PM



N

						Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
UNC #6-32	32.00	15.08	.141 x .110	C	2B	T300-NM100AE-6-32	★	3.6	3.51	56.0	11.0	3	2.9	DIN/ANSI	
		.594						.141	.138	2.205	.433		.112		
UNC #8-32	32.00	16.58	.168 x .131	C	2B	T300-NM100AE-8-32	★	4.3	4.17	63.0	13.0	3	3.5	DIN/ANSI	
		.653						.168	.164	2.480	.512		.138		
UNC 1/4-20	20.00	25.59	.255 x .191	C	2B	T300-NM100AE-1/4	★	6.5	6.35	80.0	15.0	3	5.1	DIN/ANSI	
		1.007						.255	.250	3.150	.591		.201		
UNC 5/16-18	18.00	30.20	.318 x .238	C	2B	T300-NM100AE-5/16	★	8.1	7.94	90.0	18.0	3	6.6	DIN/ANSI	
		1.189						.318	.313	3.543	.709		.260		
UNC 3/8-16	16.00	32.80	.381 x .286	C	2B	T300-NM100AE-3/8	★	9.7	9.53	100.0	20.0	3	8.0	DIN/ANSI	
		1.292						.381	.375	3.937	.787		.315		
UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	T300-NM100AE-1/2	★	9.3	12.70	110.0	23.0	3	10.8	DIN/ANSI	
		3.220						.367	.500	4.331	.906		.425		
UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	T300-NM100AE-5/8	★	12.2	15.88	110.0	23.0	3	13.5	DIN/ANSI	
		2.591						.480	.625	4.331	.906		.531		
UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	T300-NM100AE-3/4	★	15.0	19.05	125.0	30.0	4	16.5	DIN/ANSI	
		3.051						.590	.750	4.921	1.181		.650		

Gewindeform: UNF

DIN/ANSI

						Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	D150	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
UNF #10-32	32.00	21.42	.194 x .152	C	2B	T300-NM100AF-10-32	★	4.9	4.83	70.0	14.0	3	4.1	DIN/ANSI	
		.843						.194	.190	2.756	.551		.161		
UNF 1/4-28	28.00	25.59	.255 x .191	C	2B	T300-NM100AF-1/4	★	6.5	6.35	80.0	15.0	3	5.5	DIN/ANSI	
		1.007						.255	.250	3.150	.591		.217		
UNF 5/16-24	24.00	30.20	.318 x .238	C	2B	T300-NM100AF-5/16	★	8.1	7.94	90.0	18.0	3	6.9	DIN/ANSI	
		1.189						.318	.313	3.543	.709		.272		
UNF 3/8-24	24.00	32.80	.381 x .286	C	2B	T300-NM100AF-3/8	★	9.7	9.53	100.0	20.0	3	8.5	DIN/ANSI	
		1.292						.381	.375	3.937	.787		.335		
UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	T300-NM100AF-1/2	★	9.3	12.70	110.0	23.0	3	11.5	DIN/ANSI	
		3.220						.367	.500	4.331	.906		.453		



C177



C157



E9



E27



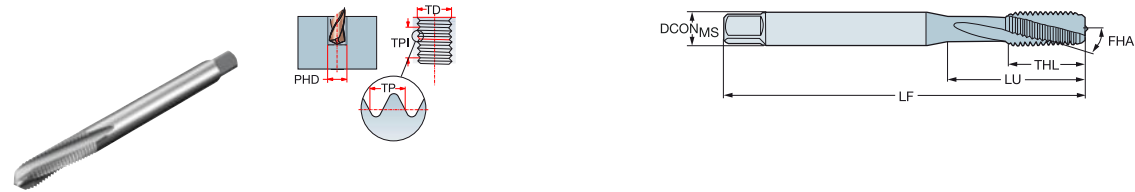
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNF
DIN 2184-1

ULDR
FHA
SUBSTRATE

1.5
25°
HSS-E-PM



B

Für Nickelbasislegierungen

							s Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	s	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
UNF #6-40	40.00	12.00	4.00 x 3.00	C	3B	T300-SD100DF-6-40		4.0	3.51	56.0	12.0	3	3.0	DIN 2184-1		
		.472					★	.157	.138	2.205	.472		.116			
UNF #8-36	36.00	42.00	4.50 x 3.40	C	3B	T300-SD100DF-8-36	★	4.5	4.17	63.0	13.0	3	3.5	DIN 2184-1		
		1.654						.177	.164	2.480	.512		.138			
UNF #10-32	32.00	16.00	6.00 x 4.90	C	3B	T300-SD100DF-10-32	★	6.0	4.83	70.0	16.0	3	4.1	DIN 2184-1		
		.630						.236	.190	2.756	.630		.161			
UNF #12-28	28.00	23.00	6.00 x 4.90	C	3B	T300-SD100DF-12-28	★	6.0	5.49	80.0	15.0	3	4.6	DIN 2184-1		
		.906						.236	.216	3.150	.591		.181			
UNF 1/4-28	28.00	25.00	7.00 x 5.50	C	3B	T300-SD100DF-1/4	★	7.0	6.35	80.0	15.0	3	5.5	DIN 2184-1		
		.984						.276	.250	3.150	.591		.217			
UNF 5/16-24	24.00	29.50	8.00 x 6.20	C	3B	T300-SD100DF-5/16	★	8.0	7.94	90.0	18.0	3	6.9	DIN 2184-1		
		1.161						.315	.313	3.543	.709		.272			
UNF 3/8-24	24.00	33.50	10.00 x 8.00	C	3B	T300-SD100DF-3/8	★	10.0	9.53	100.0	20.0	4	8.5	DIN 2184-1		
		1.319						.394	.375	3.937	.787		.335			

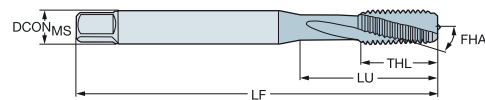
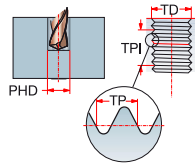
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNF

C-DIN/ANSI, DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

1.5
15°
HSS-E-PM
PVD TIALN



30-48 HRC

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
UNF #10-32	32.00	17.00	.255 x .191	C	2B	E88510-32	6.5	4.83	80.0	17.0	3	C-DIN/ANSI	
		.669					.255	.190	3.150	.669			
UNF 1/4-28	28.00	20.20	.318 x .238	C	2B	E8851/4	8.1	6.35	90.0	20.2	3	C-DIN/ANSI	
		.795					.318	.250	3.543	.795			
UNF 5/16-24	24.00	20.00	.381 x .286	C	2B	E8855/16	9.7	7.94	100.0	22.8	3	C-DIN/ANSI	
		.787					.381	.313	3.937	.898			
UNF 3/8-24	24.00	33.00	.381 x .286	C	2B	E8853/8	9.7	9.53	100.0	20.0	3	DIN/ANSI	
		1.299					.381	.375	3.937	.787			
UNF 7/16-20	20.00	72.60	.323 x .242	C	2B	E8857/16	8.2	11.11	100.0	20.0	4	DIN/ANSI	
		2.858					.323	.438	3.937	.787			
UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	E8851/2	9.3	12.70	110.0	23.0	4	DIN/ANSI	
		3.220					.367	.500	4.331	.906			
UNF 5/8-18	18.00	65.80	.480 x .360	C	2B	E8855/8	12.2	15.88	110.0	23.0	4	DIN/ANSI	
		2.591					.480	.625	4.331	.906			
UNF 3/4-16	16.00	77.50	.590 x .442	C	2B	E8853/4	15.0	19.05	125.0	30.0	4	DIN/ANSI	
		3.051					.590	.750	4.921	1.181			



C177



C157



E9



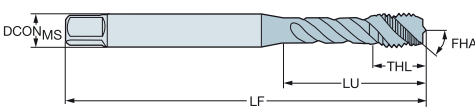
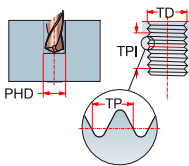
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNF
DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

3.0
48°
HSS-E-PM
PVD TIALN



							Abmessungen, mm, Zoll						
TCT	TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG
H2	UNF #8-36	36.00	21.18	.168 x .131	C	2B	EX33PA8-36	4.3	4.17	63.0	7.0	3	DIN/ANSI
			.834					.168	.164	2.480	.276		
H3	UNF #10-32	32.00	27.54	.194 x .152	C	2B	EX33PA10-32	4.9	4.83	70.0	8.0	3	DIN/ANSI
			1.084					.194	.190	2.756	.315		
H3	UNF 1/4-28	28.00	24.69	.255 x .191	C	3B	EX33PA1/4	6.5	6.35	80.0	10.2	3	DIN/ANSI
			.972					.255	.250	3.150	.402		
H4	UNF 1/4-28	28.00	24.69	.255 x .191	C	2B	EX33PA1/4H4	6.5	6.35	80.0	10.2	3	DIN/ANSI
			.972					.255	.250	3.150	.402		
H3	UNF 5/16-24	24.00	33.17	.318 x .238	C	3B	EX33PA5/16	8.1	7.94	90.0	12.0	3	DIN/ANSI
			1.306					.318	.313	3.543	.472		
H4	UNF 5/16-24	24.00	33.17	.318 x .238	C	2B	EX33PA5/16H4	8.1	7.94	90.0	12.0	3	DIN/ANSI
			1.306					.318	.313	3.543	.472		
H3	UNF 3/8-24	24.00	38.07	.381 x .286	C	3B	EX33PA3/8	9.7	9.53	100.0	15.8	3	DIN/ANSI
			1.499					.381	.375	3.937	.622		
H4	UNF 3/8-24	24.00	38.07	.381 x .286	C	2B	EX33PA3/8H4	9.7	9.53	100.0	15.8	3	DIN/ANSI
			1.499					.381	.375	3.937	.622		
H3	UNF 7/16-20	20.00	72.60	.323 x .242	C	3B	EX33PA7/16	8.2	11.11	100.0	15.0	3	DIN/ANSI
			2.858					.323	.438	3.937	.591		
H3	UNF 1/2-20	20.00	81.80	.367 x .275	C	3B	EX33PA1/2	9.3	12.70	110.0	18.0	3	DIN/ANSI
			3.220					.367	.500	4.331	.709		
H5	UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	EX33PA1/2H5	9.3	12.70	110.0	18.0	3	DIN/ANSI
			3.220					.367	.500	4.331	.709		
H3	UNF 5/8-18	18.00	65.80	.480 x .360	C	3B	EX33PA5/8	12.2	15.88	110.0	20.0	4	DIN/ANSI
			2.591					.480	.625	4.331	.787		
H5	UNF 5/8-18	18.00	65.80	.480 x .360	C	2B	EX33PA5/8H5	12.2	15.88	110.0	20.0	4	DIN/ANSI
			2.591					.480	.625	4.331	.787		
H3	UNF 3/4-16	16.00	77.50	.590 x .442	C	3B	EX33PA3/4	15.0	19.05	125.0	25.0	4	DIN/ANSI
			3.051					.590	.750	4.921	.984		
H5	UNF 3/4-16	16.00	77.50	.590 x .442	C	2B	EX33PA3/4H5	15.0	19.05	125.0	25.0	4	DIN/ANSI
			3.051					.590	.750	4.921	.984		
H4	UNF 7/8-14	14.00	90.90	.697 x .523	C	3B	EX33PA7/8	17.7	22.23	140.0	25.0	4	DIN/ANSI
			3.579					.697	.875	5.512	.984		
H4	UNF 1"-12	12.00	95.40	.800 x .600	C	3B	EX33PA1-12	20.3	25.40	160.0	30.0	4	DIN/ANSI
			3.756					.800	1.000	6.299	1.181		



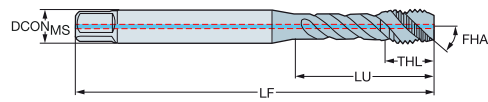
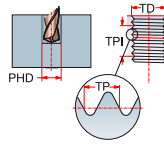
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNF

DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

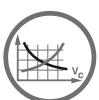
3.0
48°
HSS-E-PM
PVD TIALN



≤350HB

										Abmessungen, mm, Zoll					
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG
UNF #10-32	32.00	27.54	.194 x .152	C	2BX	1	1	EX39PA10-32		4.9	4.83	70.0	8.0	3	DIN/ANSI
		1.084								.194	.190	2.756	.315		
UNF 1/4-28	28.00	24.69	.255 x .191	C	2BX	1	1	EX39PA1/4		6.5	6.35	80.0	10.2	3	DIN/ANSI
		.972								.255	.250	3.150	.402		
UNF 5/16-24	24.00	33.17	.318 x .238	C	2BX	1	1	EX39PA5/16		8.1	7.94	90.0	12.0	3	DIN/ANSI
		1.306								.318	.313	3.543	.472		
UNF 3/8-24	24.00	38.07	.381 x .286	C	2BX	1	1	EX39PA3/8		9.7	9.53	100.0	15.8	3	DIN/ANSI
		1.499								.381	.375	3.937	.622		
UNF 1/2-20	20.00	81.80	.367 x .275	C	2BX	1	1	EX39PA1/2		9.3	12.70	110.0	18.0	3	DIN/ANSI
		3.220								.367	.500	4.331	.709		
UNF 5/8-18	18.00	65.80	.480 x .360	C	2BX	1	1	EX39PA5/8		12.2	15.88	110.0	20.0	4	DIN/ANSI
		2.591								.480	.625	4.331	.787		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt



C177



C157



E9



E28



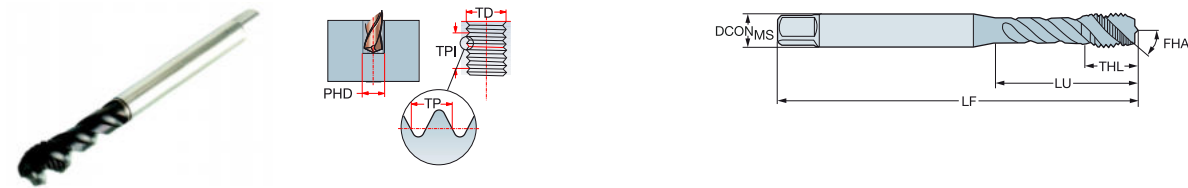
C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNF
DIN/ANSI

ULDR
FHA
SUBSTRATE
COATING

2.5
48°
HSS-PM
PVD TIALN+WCC



M

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
UNF #10-32	32.00	21.42	.194 x .152	C	2B	E88310-32	4.9	4.83	70.0	8.4	3	DIN/ANSI	
		.843					.194	.190	2.756	.331			
UNF 1/4-28	28.00	25.59	.255 x .191	C	2B	E8831/4	6.5	6.35	80.0	10.2	3	DIN/ANSI	
		1.007					.255	.250	3.150	.402			
UNF 5/16-24	24.00	30.20	.318 x .238	C	2B	E8835/16	8.1	7.94	90.0	12.2	3	DIN/ANSI	
		1.189					.318	.313	3.543	.480			
UNF 3/8-24	24.00	32.80	.381 x .286	C	2B	E8833/8	9.7	9.53	100.0	15.8	3	DIN/ANSI	
		1.292					.381	.375	3.937	.622			
UNF 7/16-20	20.00	72.60	.323 x .242	C	2B	E8837/16	8.2	11.11	100.0	15.0	3	DIN/ANSI	
		2.858					.323	.438	3.937	.591			
UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	E8831/2	9.3	12.70	110.0	18.0	3	DIN/ANSI	
		3.220					.367	.500	4.331	.709			
UNF 5/8-18	18.00	65.80	.480 x .360	C	2B	E8835/8	12.2	15.88	110.0	20.0	4	DIN/ANSI	
		2.591					.480	.625	4.331	.787			
UNF 3/4-16	16.00	77.50	.590 x .442	C	2B	E8833/4	15.0	19.05	125.0	25.0	4	DIN/ANSI	
		3.051					.590	.750	4.921	.984			
UNF 7/8-14	14.00	90.90	.697 x .523	C	2B	E8837/8	17.7	22.23	140.0	25.0	4	DIN/ANSI	
		3.579					.697	.875	5.512	.984			

D

E



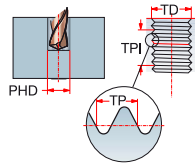
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: G

DIN 5156

ULDR
FHA
SUBSTRATE
COATING

2.0
40°
HSS-E
PVD FEN



M

B

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
G 1/8-28	28.00	67.00	7.00 x 5.50	C	NORMAL	E3621/8	7.0	9.73	90.0	12.0	3	DIN 5156	
		2.638					.276	.383	3.543	.472			
G 1/4-19	19.00	71.00	11.00 x 9.00	C	NORMAL	E3621/4	11.0	13.16	100.0	15.0	4	DIN 5156	
		2.795					.433	.518	3.937	.591			
G 3/8-19	19.00	58.00	12.00 x 9.00	C	NORMAL	E3623/8	12.0	16.66	100.0	15.0	4	DIN 5156	
		2.283					.472	.656	3.937	.591			
G 1/2-14	14.00	80.00	16.00 x 12.00	C	NORMAL	E3621/2	16.0	20.96	125.0	24.0	4	DIN 5156	
		3.150					.630	.825	4.921	.945			
G 3/4-14	14.00	77.00	20.00 x 16.00	C	NORMAL	E3623/4	20.0	26.44	140.0	20.0	4	DIN 5156	
		3.032					.787	1.041	5.512	.787			
G 1"-11	11.00	93.00	25.00 x 20.00	C	NORMAL	E3621	25.0	33.25	160.0	24.0	4	DIN 5156	
		3.661					.984	1.309	6.299	.945			

C

D

E



C177



C157



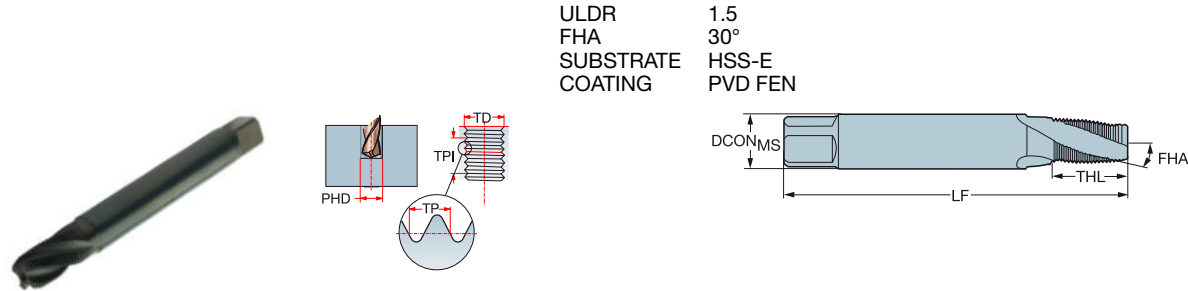
E9



C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

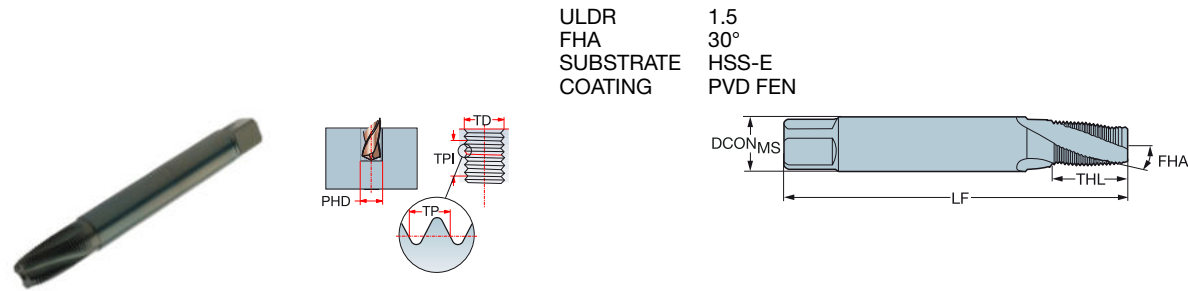
Gewindeform: NPT
DIN/ANSI



M

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
NPT 1/16-27	27.00	56.00	.313 x .234	C	NORMAL	E7361/16	8.0	7.72	80.0	14.0	3	DIN/ANSI	
		2.205					.313	.304	3.150	.551			
NPT 1/8-27	27.00	64.00	.437 x .328	C	NORMAL	E7361/8	11.1	10.07	90.0	14.0	4	DIN/ANSI	
		2.520					.437	.396	3.543	.551			
NPT 1/4-18	18.00	59.00	.562 x .421	C	NORMAL	E7361/4	14.3	13.37	100.0	20.0	4	DIN/ANSI	
		2.323					.562	.526	3.937	.787			
NPT 3/8-18	18.00	67.00	.700 x .531	C	NORMAL	E7363/8	17.8	16.81	110.0	20.0	5	DIN/ANSI	
		2.638					.700	.662	4.331	.787			
NPT 1/2-14	14.00	79.00	.687 x .515	C	NORMAL	E7361/2	17.4	20.95	125.0	26.0	5	DIN/ANSI	
		3.110					.687	.825	4.921	1.024			
NPT 3/4-14	14.00	78.00	.906 x .679	C	NORMAL	E7363/4	23.0	26.29	140.0	26.0	5	DIN/ANSI	
		3.071					.906	1.035	5.512	1.024			
NPT 1-11.5	11.50	58.00	1.125 x .843	C	NORMAL	E7361	28.6	32.91	150.0	31.0	5	DIN/ANSI	
		2.283					1.125	1.296	5.906	1.220			

Gewindeform: NPTF



M

							Abmessungen, mm, Zoll						
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	DCON _{MS}	TD	LF	THL	NOF	BSG	
NPTF 1/16-27	27.00	56.00	.313 x .234	C	NORMAL	E7381/16	8.0	7.64	80.0	14.0	3	DIN/ANSI	
		2.205					.313	.301	3.150	.551			
NPTF 1/8-27	27.00	64.00	.437 x .328	C	NORMAL	E7381/8	11.1	9.98	90.0	20.0	4	DIN/ANSI	
		2.520					.437	.393	3.543	.787			
NPTF 1/4-18	18.00	59.00	.562 x .421	C	NORMAL	E7381/4	14.3	13.31	100.0	20.0	4	DIN/ANSI	
		2.323					.562	.524	3.937	.787			
NPTF 3/8-18	18.00	67.00	.700 x .531	C	NORMAL	E7383/8	17.8	16.75	110.0	26.0	5	DIN/ANSI	
		2.638					.700	.660	4.331	1.024			
NPTF 1/2-14	14.00	79.00	.437 x .328	C	NORMAL	E7381/2	11.1	20.92	125.0	14.0	5	DIN/ANSI	
		3.110					.437	.824	4.921	.551			
NPTF 3/4-14	14.00	78.00	.687 x .515	C	NORMAL	E7383/4	17.4	26.27	140.0	26.0	5	DIN/ANSI	
		3.071					.687	1.034	5.512	1.024			

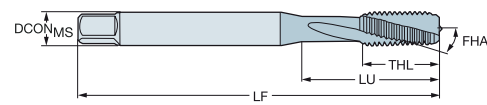
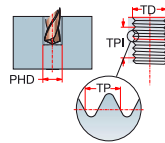


CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNJC

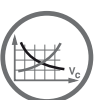
DIN 2184-1

ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM



Für Nickelbasislegierungen

							Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	s									
								DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
UNJC #10-24	24.00	13.50	6.00 x 4.90	C	3B	T300-SD100DH-10-24	★	6.0	4.83	70.0	13.5	3	3.9	DIN 2184-1		
		.531						.236	.190	2.756	.531		.154			
UNJC 1/4-20	20.00	17.50	7.00 x 5.50	C	3B	T300-SD100DH-1/4	★	7.0	6.35	80.0	17.5	3	5.1	DIN 2184-1		
		.689						.276	.250	3.150	.689		.201			
UNJC 3/8-16	16.00	25.00	10.00 x 8.00	C	3B	T300-SD100DH-3/8	★	10.0	9.53	100.0	25.0	3	8.0	DIN 2184-1		
		.984						.394	.375	3.937	.984		.315			
UNJC 5/16-18	18.00	21.00	8.00 x 6.20	C	3B	T300-SD100DH-5/16	★	8.0	7.94	90.0	21.0	3	6.6	DIN 2184-1		
		.827						.315	.313	3.543	.827		.260			
UNJC #4-40	40.00	8.00	3.50 x 2.70	C	3B	T300-SD100DH-4-40	★	3.5	2.84	56.0	8.0	3	2.4	DIN 2184-1		
		.315						.138	.112	2.205	.315		.093			
UNJC #6-32	32.00	10.00	4.00 x 3.00	C	3B	T300-SD100DH-6-32	★	4.0	3.51	56.0	10.0	3	2.9	DIN 2184-1		
		.394						.157	.138	2.205	.394		.112			
UNJC #8-32	32.00	11.00	4.50 x 3.40	C	3B	T300-SD100DH-8-32	★	4.5	4.17	63.0	11.0	3	3.5	DIN 2184-1		
		.433						.177	.164	2.480	.433		.138			



C177



C157



E9



E27

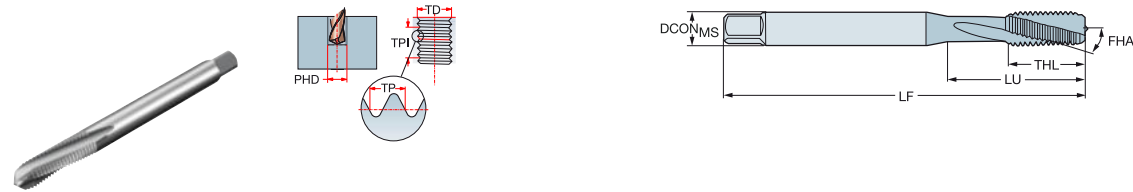


C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: UNJF
DIN 2184-1

ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM



Für Nickelbasislegierungen

						s Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	1/16	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
UNJF #6-40	40.00	9.50	4.00 x 3.00	C	3B	T300-SD100DI-6-40	★	4.0	3.51	56.0	9.5	3	3.0	DIN 2184-1	
		.374						.157	.138	2.205	.374		.116		
UNJF #8-36	36.00	11.00	4.50 x 3.40	C	3B	T300-SD100DI-8-36	★	4.5	4.17	63.0	11.0	3	3.5	DIN 2184-1	
		.433						.177	.164	2.480	.433		.138		
UNJF #10-32	32.00	12.50	6.00 x 4.90	C	3B	T300-SD100DI-10-32	★	6.0	4.83	70.0	12.5	3	4.1	DIN 2184-1	
		.492						.236	.190	2.756	.492		.161		
UNJF 1/4-28	28.00	16.00	7.00 x 5.50	C	3B	T300-SD100DI-1/4	★	7.0	6.35	80.0	16.0	3	5.5	DIN 2184-1	
		.630						.276	.250	3.150	.630		.217		
UNJF 5/16-24	24.00	20.00	8.00 x 6.20	C	3B	T300-SD100DI-5/16	★	8.0	7.94	90.0	20.0	3	6.9	DIN 2184-1	
		.787						.315	.313	3.543	.787		.272		
UNJF 3/8-24	24.00	23.00	10.00 x 8.00	C	3B	T300-SD100DI-3/8	★	10.0	9.53	100.0	23.0	3	8.5	DIN 2184-1	
		.906						.394	.375	3.937	.906		.335		

ULDR 2.0
FHA 15°
SUBSTRATE HSS-E-PM
COATING PVD ALCRN



Für Titanbasislegierungen

						s Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	1/16	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
UNJF #10-32	32.00	16.00	6.00 x 4.90	C	3B	T300-SM100DI-10-32	★	6.0	4.83	70.0	16.0	3	4.1	DIN 2184-1	
		.630						.236	.190	2.756	.630		.161		
UNJF 1/4-28	28.00	25.00	7.00 x 5.50	C	3B	T300-SM100DI-1/4	★	7.0	6.35	80.0	15.0	3	5.5	DIN 2184-1	
		.984						.276	.250	3.150	.591		.217		
UNJF 5/16-24	24.00	29.50	8.00 x 6.20	C	3B	T300-SM100DI-5/16	★	8.0	7.94	90.0	18.0	3	6.9	DIN 2184-1	
		1.161						.315	.313	3.543	.709		.272		
UNJF 3/8-24	24.00	33.50	10.00 x 8.00	C	3B	T300-SM100DI-3/8	★	10.0	9.53	100.0	20.0	3	8.5	DIN 2184-1	
		1.319						.394	.375	3.937	.787		.335		

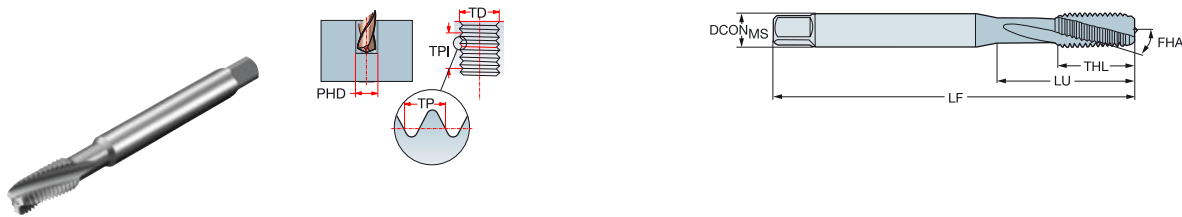
CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: EGUNF

DIN 2184-1

ULDR
FHA
SUBSTRATE
COATING

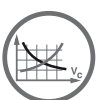
2.0
15°
HSS-E-PM
PVD ALCRN



Gewindebohrer für Gewindeeinsätze

Für Titanbasislegierungen

							s	Abmessungen, mm, Zoll							
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	Drill	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
EGUNF #10-32	32.00	16.00	6.00 x 4.90	C	3B	T300-SM100DS-10-32	★	6.0	5.94	70.0	16.0	3	5.1	DIN 2184-1	
		.630						.236	.234	2.756	.630		.201		
EGUNF 1/4-28	28.00	25.00	8.00 x 6.20	C	3B	T300-SM100DS-1/4	★	8.0	7.60	80.0	15.0	3	6.6	DIN 2184-1	
		.984						.315	.299	3.150	.591		.260		



C177



C157



E9



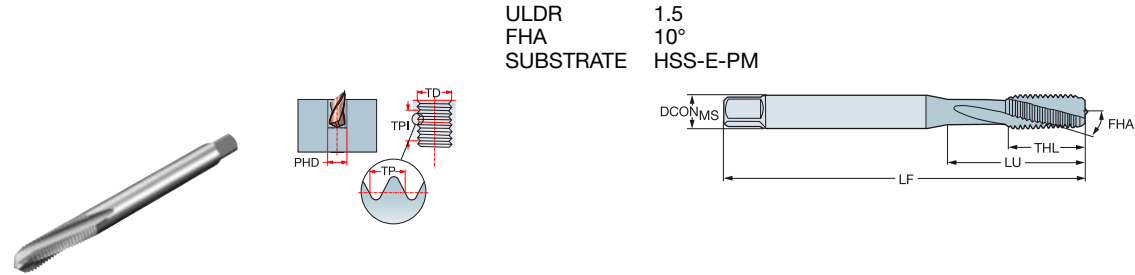
E27



C154

CoroTap™ 300 Gewindebohrer für Grundbohrungen

Gewindeform: EGUNJF
DIN 2184-1



Gewindebohrer für Gewindeeinsätze
Für Nickelbasislegierungen

						s Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THOHT	TC _{TR}	Bestellnummer									
EGUNJF #10-32	32.00	12.50	6.00 x 4.90	C	3B	T300-SD100DZ-10-32	★	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	DIN 2184-1
	.492							.236	.234	2.756	.591		.201		
EGUNJF 1/4-28	28.00	16.00	8.00 x 6.20	C	3B	T300-SD100DZ-1/4	★	8.0	7.60	80.0	18.0	3	6.6		DIN 2184-1
	.630							.315	.299	3.150	.709		.260		
EGUNJF 3/8-24	24.00	23.00	11.00 x 9.00	C	3B	T300-SD100DZ-3/8	★	11.0	10.99	100.0	20.0	3	9.8		DIN 2184-1
	.906							.433	.433	3.937	.787		.386		
EGUNJF 5/16-24	24.00	20.00	10.00 x 8.00	C	3B	T300-SD100DZ-5/16	★	10.0	9.40	90.0	20.0	3	8.2		DIN 2184-1
	.787							.394	.370	3.543	.787		.323		

D

E

CoroTap™ 400

Anwendungen

- Sowohl für Durchgangs- als auch Grundbohrungen einsetzbar
- In vielen Gewindeformen und -standards erhältlich
- Tiefen bis zu $3.5 \times D$



Vorteile und Merkmale

- Anschnitt C (2-3 Gewindegänge) und Anschnitt E (1.5-2 Gewindegänge). Anschnitt E speziell für Grundbohrungen mit wenig Freiraum
 - Gewindeformer aus HSS-E für höhere Verschleißfestigkeit
 - Gewindeformer aus HSS-Pulverschnellstahl für bessere Stabilität, Verschleißfestigkeit und Standzeit
-
- Gewindewerkzeuge, die das Gewinde formen und nicht schneiden
 - Eine spanfreie Lösung
 - Nicht für alle Werkstoffe geeignet, da gewisser Grad an Duktilität erforderlich. Empfohlene maximale Zugfestigkeit ist 1200 N/mm²
 - Sowohl für Durchgangs- als auch Grundbohrungen
 - Erhältlich mit und ohne Schmiernuten sowie Innenkühlung



www.sandvik.coromant.com/corotap400



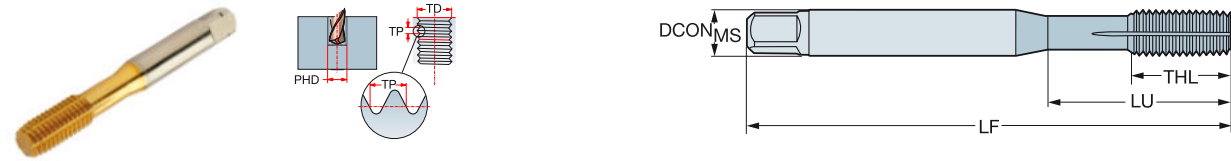
CoroChuck™ 970, siehe Katalog Rotierende Werkzeuge.

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
DIN 2174

ULDR
SUBSTRATE
COATING

3.0
HSS-E-PM
PVD TIN

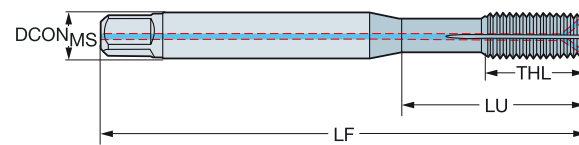
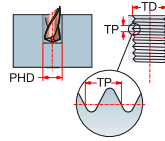


							P	Abmessungen, mm, Zoll						
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	ESG LC	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
M 9	1.25	35.00	9.00 x 7.00	C	6HX	T400-PM100DA-M9	★	9.0	9.00	90.0	13.0	6	8.3	DIN 2174
		1.378						.354	.354	3.543	.512		.325	
M 3	0.50	18.00	3.50 x 2.70	C	6HX	T400-PM100DA-M3	★	3.5	3.00	56.0	6.0	4	2.8	DIN 2174
		.709						.138	.118	2.205	.236		.108	
M 4	0.70	21.00	4.50 x 3.40	C	6HX	T400-PM100DA-M4	★	4.5	4.00	63.0	7.0	5	3.7	DIN 2174
		.827						.177	.157	2.480	.276		.144	
M 5	0.80	25.00	6.00 x 4.90	C	6HX	T400-PM100DA-M5	★	6.0	5.00	70.0	8.0	5	4.6	DIN 2174
		.984						.236	.197	2.756	.315		.181	
M 6	1.00	30.00	6.00 x 4.90	C	6HX	T400-PM100DA-M6	★	6.0	6.00	80.0	10.0	5	5.5	DIN 2174
		1.181						.236	.236	3.150	.394		.217	
M 7	1.00	30.00	7.00 x 5.50	C	6HX	T400-PM100DA-M7	★	7.0	7.00	80.0	7.0	6	6.5	DIN 2174
		1.181						.276	.276	3.150	.276		.256	
M 8	1.25	35.00	8.00 x 6.20	C	6HX	T400-PM100DA-M8	★	8.0	8.00	90.0	12.0	6	7.4	DIN 2174
		1.378						.315	.315	3.543	.472		.291	
M 10	1.50	39.00	10.00 x 8.00	C	6HX	T400-PM100DA-M10	★	10.0	10.00	100.0	15.0	7	9.3	DIN 2174
		1.535						.394	.394	3.937	.591		.364	
M 12	1.75	42.00	9.00 x 7.00	C	6HX	T400-PM100DA-M12	★	9.0	12.00	110.0	16.0	8	11.2	DIN 2174
		1.654						.354	.472	4.331	.630		.441	
M 14	2.00	49.00	11.00 x 9.00	C	6HX	T400-PM100DA-M14	★	11.0	14.00	110.0	20.0	8	13.0	DIN 2174
		1.929						.433	.551	4.331	.787		.512	
M 16	2.00	55.00	12.00 x 9.00	C	6HX	T400-PM100DA-M16	★	12.0	16.00	110.0	20.0	8	15.0	DIN 2174
		2.165						.472	.630	4.331	.787		.591	
M 3	0.50	18.00	3.50 x 2.70	C	6GX	T400-PM101DA-M3	★	3.5	3.00	56.0	6.0	4	2.8	DIN 2174
		.709						.138	.118	2.205	.236		.108	
M 4	0.70	21.00	4.50 x 3.40	C	6GX	T400-PM101DA-M4	★	4.5	4.00	63.0	7.0	5	3.7	DIN 2174
		.827						.177	.157	2.480	.276		.144	
M 5	0.80	25.00	6.00 x 4.90	C	6GX	T400-PM101DA-M5	★	6.0	5.00	70.0	8.0	5	4.6	DIN 2174
		.984						.236	.197	2.756	.315		.181	
M 6	1.00	30.00	6.00 x 4.90	C	6GX	T400-PM101DA-M6	★	6.0	6.00	80.0	10.0	5	5.5	DIN 2174
		1.181						.236	.236	3.150	.394		.217	
M 8	1.25	35.00	8.00 x 6.20	C	6GX	T400-PM101DA-M8	★	8.0	8.00	90.0	12.0	6	7.4	DIN 2174
		1.378						.315	.315	3.543	.472		.291	
M 10	1.50	39.00	10.00 x 8.00	C	6GX	T400-PM101DA-M10	★	10.0	10.00	100.0	15.0	7	9.3	DIN 2174
		1.535						.394	.394	3.937	.591		.364	
M 12	1.75	42.00	9.00 x 7.00	C	6GX	T400-PM101DA-M12	★	9.0	12.00	110.0	16.0	8	11.2	DIN 2174
		1.654						.354	.472	4.331	.630		.441	
M 14	2.00	49.00	11.00 x 9.00	C	6GX	T400-PM101DA-M14	★	11.0	14.00	110.0	20.0	8	13.0	DIN 2174
		1.929						.433	.551	4.331	.787		.512	
M 16	2.00	55.00	12.00 x 9.00	C	6GX	T400-PM101DA-M16	★	12.0	16.00	110.0	20.0	8	15.0	DIN 2174
		2.165						.472	.630	4.331	.787		.591	
M 3	0.50	18.00	3.50 x 2.70	E	6HX	T400-PM102DA-M3	★	3.5	3.00	56.0	6.0	4	2.8	DIN 2174
		.709						.138	.118	2.205	.236		.108	
M 4	0.70	21.00	4.50 x 3.40	E	6HX	T400-PM102DA-M4	★	4.5	4.00	63.0	7.0	5	3.7	DIN 2174
		.827						.177	.157	2.480	.276		.144	
M 5	0.80	25.00	6.00 x 4.90	E	6HX	T400-PM102DA-M5	★	6.0	5.00	70.0	8.0	5	4.6	DIN 2174
		.984						.236	.197	2.756	.315		.181	
M 6	1.00	30.00	6.00 x 4.90	E	6HX	T400-PM102DA-M6	★	6.0	6.00	80.0	10.0	5	5.5	DIN 2174
		1.181						.236	.236	3.150	.394		.217	
M 8	1.25	35.00	8.00 x 6.20	E	6HX	T400-PM102DA-M8	★	8.0	8.00	90.0	12.0	6	7.4	DIN 2174
		1.378						.315	.315	3.543	.472		.291	
M 10	1.50	39.00	10.00 x 8.00	E	6HX	T400-PM102DA-M10	★	10.0	10.00	100.0	15.0	7	9.3	DIN 2174
		1.535						.394	.394	3.937	.591		.364	
M 12	1.75	42.00	9.00 x 7.00	E	6HX	T400-PM102DA-M12	★	9.0	12.00	110.0	16.0	8	11.2	DIN 2174
		1.654						.354	.472	4.331	.630		.441	
M 14	2.00	49.00	11.00 x 9.00	E	6HX	T400-PM102DA-M14	★	11.0	14.00	110.0	20.0	8	13.0	DIN 2174
		1.929						.433	.551	4.331	.787		.512	
M 16	2.00	55.00	12.00 x 9.00	E	6HX	T400-PM102DA-M16	★	12.0	16.00	110.0	20.0	8	15.0	DIN 2174
		2.165						.472	.630	4.331	.787		.591	

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch

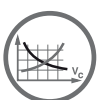
DIN 2174

ULDR
SUBSTRATE
COATING3.0
HSS-E-PM
PVD TIN

										p Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer	ISO 1181	DCON _{MS}	TD	LF	THL	NOF	BSG
M 9	1.25	35.00	9.00 x 7.00	C	6HX	1	2	T400-PM103DA-M9	★	9.0	9.00	90.0	13.0	6	DIN 2174
		1.378								.354	.354	3.543	.512		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	1	2	T400-PM103DA-M5	★	6.0	5.00	70.0	8.0	5	DIN 2174
		.984								.236	.197	2.756	.315		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	2	T400-PM103DA-M6	★	6.0	6.00	80.0	10.0	5	DIN 2174
		1.181								.236	.236	3.150	.394		
M 7	1.00	30.00	7.00 x 5.50	C	6HX	1	2	T400-PM103DA-M7	★	7.0	7.00	80.0	7.0	6	DIN 2174
		1.181								.276	.276	3.150	.276		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	2	T400-PM103DA-M8	★	8.0	8.00	90.0	12.0	6	DIN 2174
		1.378								.315	.315	3.543	.472		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	2	T400-PM103DA-M10	★	10.0	10.00	100.0	15.0	7	DIN 2174
		1.535								.394	.394	3.937	.591		
M 12	1.75	42.00	9.00 x 7.00	C	6HX	1	2	T400-PM103DA-M12	★	9.0	12.00	110.0	16.0	8	DIN 2174
		1.654								.354	.472	4.331	.630		
M 14	2.00	49.00	11.00 x 9.00	C	6HX	1	2	T400-PM103DA-M14	★	11.0	14.00	110.0	20.0	8	DIN 2174
		1.929								.433	.551	4.331	.787		
M 16	2.00	55.00	12.00 x 9.00	C	6HX	1	2	T400-PM103DA-M16	★	12.0	16.00	110.0	20.0	8	DIN 2174
		2.165								.472	.630	4.331	.787		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	1	1	T400-PM104DA-M5	★	6.0	5.00	70.0	8.0	5	DIN 2174
		.984								.236	.197	2.756	.315		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	1	T400-PM104DA-M6	★	6.0	6.00	80.0	10.0	5	DIN 2174
		1.181								.236	.236	3.150	.394		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	T400-PM104DA-M8	★	8.0	8.00	90.0	12.0	6	DIN 2174
		1.378								.315	.315	3.543	.472		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	T400-PM104DA-M10	★	10.0	10.00	100.0	15.0	7	DIN 2174
		1.535								.394	.394	3.937	.591		
M 12	1.75	42.00	9.00 x 7.00	C	6HX	1	1	T400-PM104DA-M12	★	9.0	12.00	110.0	16.0	8	DIN 2174
		1.654								.354	.472	4.331	.630		
M 14	2.00	49.00	11.00 x 9.00	C	6HX	1	1	T400-PM104DA-M14	★	11.0	14.00	110.0	20.0	8	DIN 2174
		1.929								.433	.551	4.331	.787		
M 16	2.00	55.00	12.00 x 9.00	C	6HX	1	1	T400-PM104DA-M16	★	12.0	16.00	110.0	20.0	8	DIN 2174
		2.165								.472	.630	4.331	.787		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

CXSC 2 = radialer Kühlschmierstoffaustritt



C182



C157



E9



E27



E28



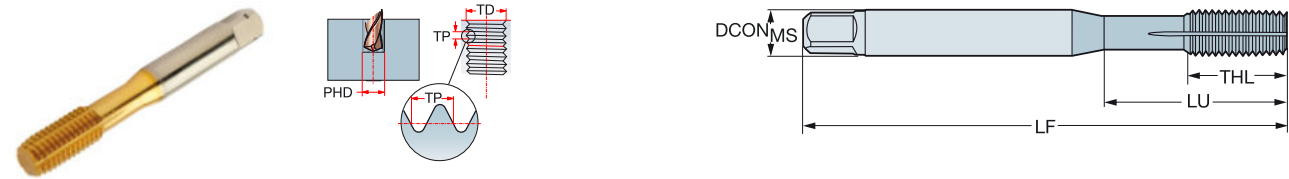
C154

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch
DIN/ANSI

ULDR
SUBSTRATE
COATING

3.0
HSS-E-PM
PVD TIN



		p Abmessungen, mm, Zoll												
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	ISO	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	18.00	.141 x .110	C	6HX	T400-PM100AA-M3	★	3.6	3.00	56.0	6.0	4	2.8	DIN/ANSI
		.709						.141	.118	2.205	.236		.108	
M 4	0.70	21.00	.168 x .131	C	6HX	T400-PM100AA-M4	★	4.3	4.00	63.0	7.0	5	3.7	DIN/ANSI
		.827						.168	.157	2.480	.276		.144	
M 5	0.80	25.00	.194 x .152	C	6HX	T400-PM100AA-M5	★	4.9	5.00	70.0	8.0	5	4.6	DIN/ANSI
		.984						.194	.197	2.756	.315		.181	
M 6	1.00	30.00	.255 x .191	C	6HX	T400-PM100AA-M6	★	6.5	6.00	80.0	10.0	5	5.5	DIN/ANSI
		1.181						.255	.236	3.150	.394		.217	
M 8	1.25	35.00	.318 x .238	C	6HX	T400-PM100AA-M8	★	8.1	8.00	90.0	12.0	6	7.4	DIN/ANSI
		1.378						.318	.315	3.543	.472		.291	
M 10	1.50	39.00	.381 x .286	C	6HX	T400-PM100AA-M10	★	9.7	10.00	100.0	15.0	7	9.3	DIN/ANSI
		1.535						.381	.394	3.937	.591		.364	
M 12	1.75	42.00	.367 x .275	C	6HX	T400-PM100AA-M12	★	9.3	12.00	110.0	16.0	8	11.2	DIN/ANSI
		1.654						.367	.472	4.331	.630		.441	
M 14	2.00	49.00	.429 x .322	C	6HX	T400-PM100AA-M14	★	10.9	14.00	110.0	20.0	8	13.0	DIN/ANSI
		1.929						.429	.551	4.331	.787		.512	
M 16	2.00	55.00	.480 x .360	C	6HX	T400-PM100AA-M16	★	12.2	16.00	110.0	20.0	8	15.0	DIN/ANSI
		2.165						.480	.630	4.331	.787		.591	

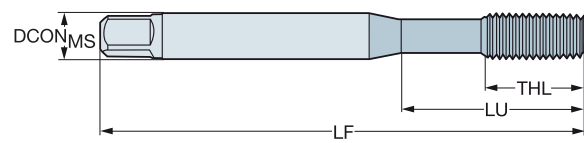
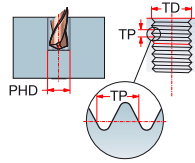
CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch

DIN 2174

ULDR
SUBSTRATE
COATING

3.0
HSS-E
DLC a-C:H



N

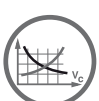
							N	Abmessungen, mm, Zoll							
							B05								
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	PHD	BSG	
M 3	0.50	18.00	3.50 x 2.70	C	6HX	T400-NM100DA-M3	★	3.5	3.00	56.0	9.0	4	2.8	DIN 2174	
		.709						.138	.118	2.205	.354		.110		
M 4	0.70	21.00	4.50 x 3.40	C	6HX	T400-NM100DA-M4	★	4.5	4.00	63.0	12.0	5	3.7	DIN 2174	
		.827						.177	.157	2.480	.472		.146		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	T400-NM100DA-M5	★	6.0	5.00	70.0	13.0	5	4.6	DIN 2174	
		.984						.236	.197	2.756	.512		.181		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	T400-NM100DA-M6	★	6.0	6.00	80.0	15.0	5	5.5	DIN 2174	
		1.181						.236	.236	3.150	.591		.217		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	T400-NM100DA-M8	★	8.0	8.00	90.0	18.0	5	7.4	DIN 2174	
		1.378						.315	.315	3.543	.709		.291		

B

C

D

E



C182



C157



E9



E27



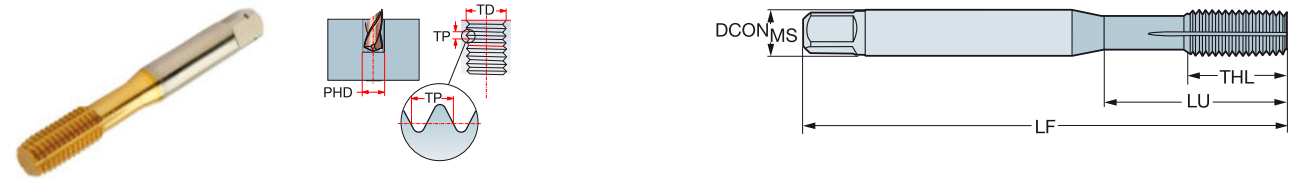
C154

CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch Fein
DIN 2174

ULDR
SUBSTRATE
COATING

3.0
HSS-E-PM
PVD TIN



							p Abmessungen, mm, Zoll									
TDZ	TP	LU	CZC _{US}	THCHT	TCTR	Bestellnummer	ISO 15400	DCON _{US}	TD	LF	THL	NOF	PHD	BSG		
MF 5x0.5	0.50	25.00	6.00 x 4.90	C	6HX	T400-PM100DB-M5X050	★	6.0	5.00	70.0	8.0	5	4.8	DIN 2174		
		.984						.236	.197	2.756	.315		.187			
MF 6x0.75	0.75	30.00	6.00 x 4.90	C	6HX	T400-PM100DB-M6X075	★	6.0	6.00	80.0	10.0	5	5.6	DIN 2174		
		1.181						.236	.236	3.150	.394		.220			
MF 8x1	1.00	35.00	6.00 x 4.90	C	6HX	T400-PM100DB-M8X100	★	6.0	8.00	90.0	12.0	6	7.5	DIN 2174		
		1.378						.236	.315	3.543	.472		.295			
MF 10x1	1.00	39.00	7.00 x 5.50	C	6HX	T400-PM100DB-M10X100	★	7.0	10.00	90.0	12.0	7	9.5	DIN 2174		
		1.535						.276	.394	3.543	.472		.374			
MF 10x1.25	1.25	39.00	7.00 x 5.50	C	6HX	T400-PM100DB-M10X125	★	7.0	10.00	100.0	15.0	7	9.4	DIN 2174		
		1.535						.276	.394	3.937	.591		.370			
MF 12x1	1.00	42.00	9.00 x 7.00	C	6HX	T400-PM100DB-M12X100	★	9.0	12.00	100.0	13.0	8	11.5	DIN 2174		
		1.654						.354	.472	3.937	.512		.453			
MF 12x1.5	1.50	42.00	9.00 x 7.00	C	6HX	T400-PM100DB-M12X125	★	9.0	12.00	100.0	13.0	8	11.4	DIN 2174		
		1.654						.354	.472	3.937	.512		.449			
MF 12x1.5	1.50	42.00	9.00 x 7.00	C	6HX	T400-PM100DB-M12X150	★	9.0	12.00	100.0	13.0	8	11.3	DIN 2174		
		1.654						.354	.472	3.937	.512		.443			
MF 14x1	1.00	49.00	11.00 x 9.00	C	6HX	T400-PM100DB-M14X100	★	11.0	14.00	100.0	15.0	8	13.5	DIN 2174		
		1.929						.433	.551	3.937	.591		.531			
MF 14x1.25	1.25	49.00	11.00 x 9.00	C	6HX	T400-PM100DB-M14X125	★	11.0	14.00	100.0	15.0	8	13.4	DIN 2174		
		1.929						.433	.551	3.937	.591		.528			
MF 14x1.5	1.50	49.00	11.00 x 9.00	C	6HX	T400-PM100DB-M14X150	★	11.0	14.00	100.0	15.0	8	13.3	DIN 2174		
		1.929						.433	.551	3.937	.591		.522			
MF 16x1.5	1.50	50.00	12.00 x 9.00	C	6HX	T400-PM100DB-M16X150	★	12.0	16.00	100.0	15.0	8	15.3	DIN 2174		
		1.969						.472	.630	3.937	.591		.600			

D

E

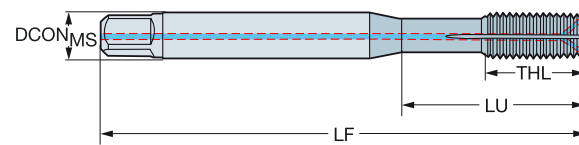
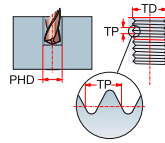
CoroTap™ 400 Gewindeformer

Gewindeform: Metrisch Fein

DIN 2174

ULDR
SUBSTRATE
COATING

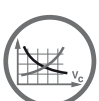
3.0
HSS-E-PM
PVD TIN



										p Abmessungen, mm, Zoll					
TDZ	TP	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer	ISO 1181	DCON _{MS}	TD	LF	THL	NOF	BSG
MF 8x1	1.00	35.00	6.00 x 4.90	C	6HX	1	2	T400-PM101DB-M8X100	★	6.0	8.00	90.0	12.0	6	DIN 2174
		1.378								.236	.315	3.543	.472		
MF 10x1	1.00	39.00	7.00 x 5.50	C	6HX	1	2	T400-PM101DB-M10X100	★	7.0	10.00	90.0	12.0	7	DIN 2174
		1.535								.276	.394	3.543	.472		
MF 10x1.25	1.25	39.00	7.00 x 5.50	C	6HX	1	2	T400-PM101DB-M10X125	★	7.0	10.00	100.0	15.0	7	DIN 2174
		1.535								.276	.394	3.937	.591		
MF 12x1	1.00	42.00	9.00 x 7.00	C	6HX	1	2	T400-PM101DB-M12X100	★	9.0	12.00	100.0	13.0	8	DIN 2174
		1.654								.354	.472	3.937	.512		
MF 12x1.25	1.25	42.00	9.00 x 7.00	C	6HX	1	2	T400-PM101DB-M12X125	★	9.0	12.00	100.0	13.0	8	DIN 2174
		1.654								.354	.472	3.937	.512		
MF 12x1.5	1.50	42.00	9.00 x 7.00	C	6HX	1	2	T400-PM101DB-M12X150	★	9.0	12.00	100.0	13.0	8	DIN 2174
		1.654								.354	.472	3.937	.512		
MF 14x1.5	1.50	49.00	11.00 x 9.00	C	6HX	1	2	T400-PM101DB-M14X150	★	11.0	14.00	100.0	15.0	8	DIN 2174
		1.929								.433	.551	3.937	.591		
MF 16x1.5	1.50	50.00	12.00 x 9.00	C	6HX	1	2	T400-PM101DB-M16X150	★	12.0	16.00	100.0	15.0	8	DIN 2174
		1.969								.472	.630	3.937	.591		
MF 8x1	1.00	35.00	6.00 x 4.90	C	6HX	1	1	T400-PM102DB-M8X100	★	6.0	8.00	90.0	12.0	6	DIN 2174
		1.378								.236	.315	3.543	.472		
MF 10x1	1.00	39.00	7.00 x 5.50	C	6HX	1	1	T400-PM102DB-M10X100	★	7.0	10.00	90.0	10.0	7	DIN 2174
		1.535								.276	.394	3.543	.394		
MF 10x1.25	1.25	39.00	7.00 x 5.50	C	6HX	1	1	T400-PM102DB-M10X125	★	7.0	10.00	100.0	15.0	7	DIN 2174
		1.535								.276	.394	3.937	.591		
MF 12x1.25	1.25	42.00	9.00 x 7.00	C	6HX	1	1	T400-PM102DB-M12X125	★	9.0	12.00	100.0	12.0	8	DIN 2174
		1.654								.354	.472	3.937	.472		
MF 12x1.5	1.50	42.00	9.00 x 7.00	C	6HX	1	1	T400-PM102DB-M12X150	★	9.0	12.00	100.0	12.0	8	DIN 2174
		1.654								.354	.472	3.937	.472		
MF 14x1.5	1.50	49.00	11.00 x 9.00	C	6HX	1	1	T400-PM102DB-M14X150	★	11.0	14.00	100.0	15.0	8	DIN 2174
		1.929								.433	.551	3.937	.591		
MF 16x1.5	1.50	50.00	12.00 x 9.00	C	6HX	1	1	T400-PM102DB-M16X150	★	12.0	16.00	100.0	15.0	8	DIN 2174
		1.969								.472	.630	3.937	.591		

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

CXSC 2 = radialer Kühlschmierstoffaustritt



C182



C157



E9



E27



E28



C154

CoroTap™ 400 Gewindeformer

Gewindeform: UNC

DIN/ANSI

ULDR

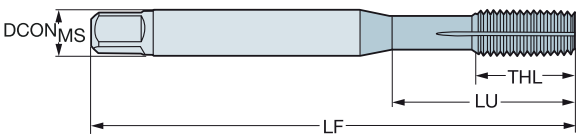
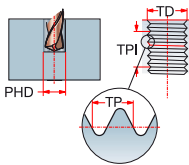
SUBSTRATE

COATING

3.0

HSS-E-PM

PVD TIN



B

C

D

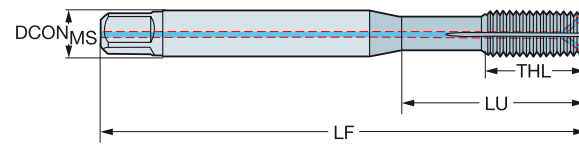
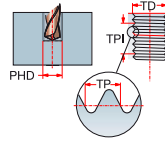
E

						p Abmessungen, mm, Zoll											
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	ISO 1182	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG			
UNC #4-40	40.00	18.00	.141 x .110	C	2BX	T400-PM100AE-4-40	★	3.6	2.84	56.0	6.0	3	2.6	DIN/ANSI			
		.709						.141	.112	2.205	.236		.102				
UNC #6-32	32.00	20.00	.141 x .110	C	2BX	T400-PM100AE-6-32	★	3.6	3.50	56.0	6.5	4	3.2	DIN/ANSI			
		.787						.141	.138	2.205	.256		.126				
UNC #8-32	32.00	25.00	.168 x .131	C	2BX	T400-PM100AE-8-32	★	4.3	4.16	63.0	6.0	5	3.9	DIN/ANSI			
		.984						.168	.164	2.480	.236		.154				
UNC #10-24	24.00	25.00	.194 x .152	C	2BX	T400-PM100AE-10-24	★	4.9	4.80	70.0	8.0	5	4.4	DIN/ANSI			
		.984						.194	.189	2.756	.315		.173				
UNC #12-24	24.00	30.00	.220 x .165	C	2BX	T400-PM100AE-12-24	★	5.6	5.48	80.0	10.0	5	5.1	DIN/ANSI			
		1.181						.220	.216	3.150	.394		.201				
UNC 1/4-20	20.00	30.00	.255 x .191	C	2BX	T400-PM100AE-1/4	★	6.5	6.35	80.0	10.0	5	5.9	DIN/ANSI			
		1.181						.255	.250	3.150	.394		.232				
UNC 5/16-18	18.00	35.00	.318 x .238	C	2BX	T400-PM100AE-5/16	★	8.1	7.94	90.0	12.0	6	7.4	DIN/ANSI			
		1.378						.318	.313	3.543	.472		.291				
UNC 3/8-16	16.00	39.00	.381 x .286	C	2BX	T400-PM100AE-3/8	★	9.7	9.52	100.0	15.0	6	8.9	DIN/ANSI			
		1.535						.381	.375	3.937	.591		.350				
UNC 7/16-14	14.00	39.00	.323 x .242	C	2BX	T400-PM100AE-7/16	★	8.2	11.11	100.0	15.0	7	10.4	DIN/ANSI			
		1.535						.323	.437	3.937	.591		.409				
UNC 1/2-13	13.00	44.50	.367 x .275	C	2BX	T400-PM100AE-1/2	★	9.3	12.70	110.0	18.0	8	12.0	DIN/ANSI			
		1.752						.367	.500	4.331	.709		.472				
UNC 5/8-11	11.00	55.00	.480 x .360	C	2BX	T400-PM100AE-5/8	★	12.2	15.88	110.0	20.0	8	15.0	DIN/ANSI			
		2.165						.480	.625	4.331	.787		.591				
UNC #4-40	40.00	18.00	.141 x .110	E	2BX	T400-PM101AE-4-40	★	3.6	2.84	56.0	6.0	3	2.6	DIN/ANSI			
		.709						.141	.112	2.205	.236		.102				
UNC #6-32	32.00	20.00	.141 x .110	E	2BX	T400-PM101AE-6-32	★	3.6	3.50	56.0	6.5	4	3.2	DIN/ANSI			
		.787						.141	.138	2.205	.256		.126				
UNC #8-32	32.00	25.00	.168 x .131	E	2BX	T400-PM101AE-8-32	★	4.3	4.16	63.0	6.0	5	3.9	DIN/ANSI			
		.984						.168	.164	2.480	.236		.154				
UNC #10-24	24.00	25.00	.194 x .152	E	2BX	T400-PM101AE-10-24	★	4.9	4.80	70.0	8.0	5	4.4	DIN/ANSI			
		.984						.194	.189	2.756	.315		.173				
UNC #12-24	24.00	30.00	.220 x .165	E	2BX	T400-PM101AE-12-24	★	5.6	5.48	80.0	10.0	5	5.1	DIN/ANSI			
		1.181						.220	.216	3.150	.394		.201				
UNC 1/4-20	20.00	30.00	.255 x .191	E	2BX	T400-PM101AE-1/4	★	6.5	6.35	80.0	10.0	5	5.8	DIN/ANSI			
		1.181						.255	.250	3.150	.394		.228				
UNC 5/16-18	18.00	35.00	.318 x .238	E	2BX	T400-PM101AE-5/16	★	8.1	7.94	90.0	12.0	6	7.4	DIN/ANSI			
		1.378						.318	.313	3.543	.472		.291				
UNC 3/8-16	16.00	39.00	.381 x .286	E	2BX	T400-PM101AE-3/8	★	9.7	9.52	100.0	15.0	6	8.9	DIN/ANSI			
		1.535						.381	.375	3.937	.591		.350				
UNC 7/16-14	14.00	39.00	.323 x .242	E	2BX	T400-PM101AE-7/16	★	8.2	11.11	100.0	15.0	7	10.4	DIN/ANSI			
		1.535						.323	.437	3.937	.591		.409				
UNC 1/2-13	13.00	44.50	.367 x .275	E	2BX	T400-PM101AE-1/2	★	9.3	12.70	110.0	18.0	8	12.0	DIN/ANSI			
		1.752						.367	.500	4.331	.709		.472				
UNC 5/8-11	11.00	55.00	.480 x .360	E	2BX	T400-PM101AE-5/8	★	12.2	15.88	110.0	20.0	8	15.0	DIN/ANSI			
		2.165						.480	.625	4.331	.787		.591				

CoroTap™ 400 Gewindeformer

Gewindeform: UNC

DIN/ANSI

ULDR
SUBSTRATE
COATING3.0
HSS-E-PM
PVD TIN

										p Abmessungen, mm, Zoll					
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	CNSC	CXSC	Bestellnummer	MS	DCON _{MS}	TD	LF	THL	NOF	BSG
UNC #8-32	32.00	25.00 .984	.168 x .131	C	2BX	1	2	T400-PM102AE-8-32	★	4.3 .168	4.16 .164	63.0 2.480	6.0 .236	5	DIN/ANSI
UNC #10-24	24.00	25.00 .984	.194 x .152	C	2BX	1	2	T400-PM102AE-10-24	★	4.9 .194	4.80 .189	70.0 2.756	8.0 .315	5	DIN/ANSI
UNC #12-24	24.00	30.00 1.181	.220 x .165	C	2BX	1	2	T400-PM102AE-12-24	★	5.6 .220	5.48 .216	80.0 3.150	10.0 .394	5	DIN/ANSI
UNC 1/4-20	20.00	30.00 1.181	.255 x .191	C	2BX	1	2	T400-PM102AE-1/4	★	6.5 .255	6.35 .250	80.0 3.150	10.0 .394	5	DIN/ANSI
UNC 5/16-18	18.00	35.00 1.378	.318 x .238	C	2BX	1	2	T400-PM102AE-5/16	★	8.1 .318	7.94 .313	90.0 3.543	12.0 .472	6	DIN/ANSI
UNC 3/8-16	16.00	39.00 1.535	.381 x .286	C	2BX	1	2	T400-PM102AE-3/8	★	9.7 .381	9.52 .375	100.0 3.937	15.0 .591	6	DIN/ANSI
UNC 7/16-14	14.00	39.00 1.535	.323 x .242	C	2BX	1	2	T400-PM102AE-7/16	★	8.2 .323	11.11 .437	100.0 3.937	15.0 .591	7	DIN/ANSI
UNC 1/2-13	13.00	44.50 1.752	.367 x .275	C	2BX	1	2	T400-PM102AE-1/2	★	9.3 .367	12.70 .500	110.0 4.331	18.0 .709	8	DIN/ANSI
UNC 5/8-11	11.00	55.00 2.165	.480 x .360	C	2BX	1	2	T400-PM102AE-5/8	★	12.2 .480	15.88 .625	110.0 4.331	20.0 .787	8	DIN/ANSI
UNC #8-32	32.00	25.00 .984	.168 x .131	C	2BX	1	1	T400-PM103AE-8-32	★	4.3 .168	4.16 .164	63.0 2.480	6.0 .236	5	DIN/ANSI
UNC #10-24	24.00	25.00 .984	.194 x .152	C	2BX	1	1	T400-PM103AE-10-24	★	4.9 .194	4.80 .189	70.0 2.756	8.0 .315	5	DIN/ANSI
UNC #12-24	24.00	30.00 1.181	.220 x .165	C	2BX	1	1	T400-PM103AE-12-24	★	5.6 .220	5.48 .216	80.0 3.150	10.0 .394	5	DIN/ANSI
UNC 1/4-20	20.00	35.00 1.378	.318 x .238	C	2BX	1	1	T400-PM103AE-5/16	★	8.1 .318	7.94 .313	90.0 3.543	12.0 .472	6	DIN/ANSI
UNC 5/16-18	18.00	30.00 1.181	.255 x .191	C	2BX	1	1	T400-PM103AE-1/4	★	6.5 .255	6.35 .250	80.0 3.150	10.0 .394	5	DIN/ANSI
UNC 3/8-16	16.00	39.00 1.535	.381 x .286	C	2BX	1	1	T400-PM103AE-3/8	★	9.7 .381	9.52 .375	100.0 3.937	15.0 .591	6	DIN/ANSI
UNC 7/16-14	14.00	39.00 1.535	.323 x .242	C	2BX	1	1	T400-PM103AE-7/16	★	8.2 .323	11.11 .437	100.0 3.937	15.0 .591	7	DIN/ANSI
UNC 1/2-13	13.00	44.50 1.752	.367 x .275	C	2BX	1	1	T400-PM103AE-1/2	★	9.3 .367	12.70 .500	110.0 4.331	18.0 .709	8	DIN/ANSI
UNC 5/8-11	11.00	55.00 2.165	.480 x .360	C	2BX	1	1	T400-PM103AE-5/8	★	12.2 .480	15.88 .625	110.0 4.331	20.0 .787	8	DIN/ANSI

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

CXSC 2 = radialer Kühlschmierstoffaustritt



C182



C157



E9



E27



E28



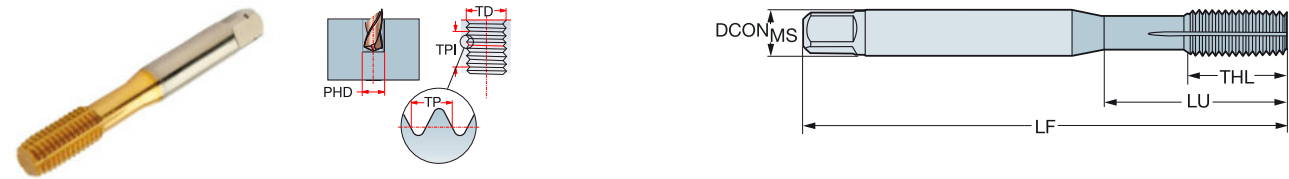
C154

CoroTap™ 400 Gewindeformer

Gewindeform: UNF
DIN/ANSI

ULDR
SUBSTRATE
COATING

3.0
HSS-E-PM
PVD TIN



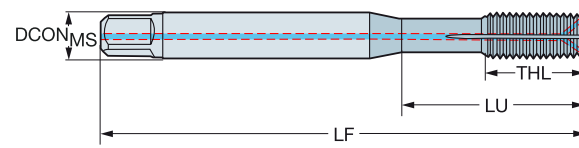
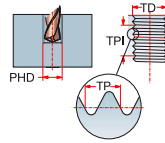
							p Abmessungen, mm, Zoll									
TDZ	TPI	LU	CZC _{MS}	THCHT	TCTR	Bestellnummer	ISO LZ	DCON _{MS}	TD	LF	THL	NOF	PHD	BSG		
UNF #10-32	32.00	25.00	.194 x .152	C	2BX	T400-PM100AF-10-32	★	4.9	4.82	70.0	8.0	5	4.5	DIN/ANSI		
		.984						.194	.190	2.756	.315		.177			
UNF 1/4-28	28.00	30.00	.255 x .191	C	2BX	T400-PM100AF-1/4	★	6.5	6.35	80.0	10.0	5	6.0	DIN/ANSI		
		1.181						.255	.250	3.150	.394		.236			
UNF 5/16-24	24.00	35.00	.318 x .238	C	2BX	T400-PM100AF-5/16	★	8.1	7.94	90.0	12.0	6	7.5	DIN/ANSI		
		1.378						.318	.313	3.543	.472		.295			
UNF 3/8-24	24.00	39.00	.381 x .286	C	2BX	T400-PM100AF-3/8	★	9.7	9.50	100.0	12.0	6	9.1	DIN/ANSI		
		1.535						.381	.374	3.937	.472		.358			
UNF 7/16-20	20.00	39.00	.323 x .242	C	2BX	T400-PM100AF-7/16	★	8.2	11.11	100.0	15.0	7	10.7	DIN/ANSI		
		1.535						.323	.437	3.937	.591		.421			
UNF 1/2-20	20.00	44.50	.367 x .275	C	2BX	T400-PM100AF-1/2	★	9.3	12.70	100.0	13.0	8	12.2	DIN/ANSI		
		1.752						.367	.500	3.937	.512		.480			
UNF 5/8-18	18.00	50.00	.480 x .360	C	2BX	T400-PM100AF-5/8	★	12.2	15.88	100.0	15.0	8	15.4	DIN/ANSI		
		1.969						.480	.625	3.937	.591		.606			
UNF #10-32	32.00	25.00	.194 x .152	E	2BX	T400-PM101AF-10-32	★	4.9	4.82	70.0	8.0	5	4.5	DIN/ANSI		
		.984						.194	.190	2.756	.315		.177			
UNF 1/4-28	28.00	30.00	.255 x .191	E	2BX	T400-PM101AF-1/4	★	6.5	6.35	80.0	10.0	5	6.0	DIN/ANSI		
		1.181						.255	.250	3.150	.394		.236			
UNF 5/16-24	24.00	35.00	.318 x .238	E	2BX	T400-PM101AF-5/16	★	8.1	7.94	90.0	12.0	6	7.5	DIN/ANSI		
		1.378						.318	.313	3.543	.472		.295			
UNF 3/8-24	24.00	39.00	.381 x .286	E	2BX	T400-PM101AF-3/8	★	9.7	9.50	100.0	12.0	6	9.1	DIN/ANSI		
		1.535						.381	.374	3.937	.472		.358			
UNF 7/16-20	20.00	39.00	.323 x .242	E	2BX	T400-PM101AF-7/16	★	8.2	11.11	100.0	15.0	7	10.7	DIN/ANSI		
		1.535						.323	.437	3.937	.591		.421			
UNF 1/2-20	20.00	44.50	.367 x .275	E	2BX	T400-PM101AF-1/2	★	9.3	12.70	100.0	13.0	8	12.2	DIN/ANSI		
		1.752						.367	.500	3.937	.512		.480			
UNF 5/8-18	18.00	50.00	.480 x .360	E	2BX	T400-PM101AF-5/8	★	12.2	15.88	100.0	15.0	8	15.4	DIN/ANSI		
		1.969						.480	.625	3.937	.591		.606			

D

CoroTap™ 400 Gewindeformer

Gewindeform: UNF

DIN/ANSI

ULDR
SUBSTRATE
COATING3.0
HSS-E-PM
PVD TIN

										Abmessungen, mm, Zoll					
TDZ	TPI	LU	CZC _{MS}	THCHT	TC _{TR}	CNSC	CXSC	Bestellnummer		DCON _{MS}	TD	LF	THL	NOF	BSG
UNF #10-32	32.00	25.00 .984	.194 x .152	C	2BX	1	2	T400-PM102AF-10-32	★	4.9 .194	4.82 .190	70.0 2.756	8.0 .315	5	DIN/ANSI
UNF 1/4-28	28.00	30.00 1.181	.255 x .191	C	2BX	1	2	T400-PM102AF-1/4	★	6.5 .255	6.35 .250	80.0 3.150	10.0 .394	5	DIN/ANSI
UNF 5/16-24	24.00	35.00 1.378	.318 x .238	C	2BX	1	2	T400-PM102AF-5/16	★	8.1 .318	7.94 .313	90.0 3.543	12.0 .472	6	DIN/ANSI
UNF 3/8-24	24.00	39.00 1.535	.381 x .286	C	2BX	1	2	T400-PM102AF-3/8	★	9.7 .381	9.50 .374	100.0 3.937	12.0 .472	6	DIN/ANSI
UNF 7/16-20	20.00	39.00 1.535	.323 x .242	C	2BX	1	2	T400-PM102AF-7/16	★	8.2 .323	11.11 .437	100.0 3.937	15.0 .591	7	DIN/ANSI
UNF 1/2-20	20.00	44.50 1.752	.367 x .275	C	2BX	1	2	T400-PM102AF-1/2	★	9.3 .367	12.70 .500	100.0 3.937	13.0 .512	8	DIN/ANSI
UNF 5/8-18	18.00	50.00 1.969	.480 x .360	C	2BX	1	2	T400-PM102AF-5/8	★	12.2 .480	15.88 .625	100.0 3.937	15.0 .591	8	DIN/ANSI
UNF #10-32	32.00	25.00 .984	.194 x .152	C	2BX	1	1	T400-PM103AF-10-32	★	4.9 .194	4.82 .190	70.0 2.756	8.0 .315	5	DIN/ANSI
UNF 1/4-28	28.00	30.00 1.181	.255 x .191	C	2BX	1	1	T400-PM103AF-1/4	★	6.5 .255	6.35 .250	80.0 3.150	10.0 .394	5	DIN/ANSI
UNF 5/16-24	24.00	35.00 1.378	.318 x .238	C	2BX	1	1	T400-PM103AF-5/16	★	8.1 .318	7.94 .313	90.0 3.543	12.0 .472	6	DIN/ANSI
UNF 3/8-24	24.00	39.00 1.535	.381 x .286	C	2BX	1	1	T400-PM103AF-3/8	★	9.7 .381	9.50 .374	100.0 3.937	12.0 .472	6	DIN/ANSI
UNF 7/16-20	20.00	39.00 1.535	.323 x .242	C	2BX	1	1	T400-PM103AF-7/16	★	8.2 .323	11.11 .437	100.0 3.937	15.0 .591	7	DIN/ANSI
UNF 1/2-20	20.00	44.50 1.752	.367 x .275	C	2BX	1	1	T400-PM103AF-1/2	★	9.3 .367	12.70 .500	100.0 3.937	13.0 .512	8	DIN/ANSI
UNF 5/8-18	18.00	50.00 1.969	.480 x .360	C	2BX	1	1	T400-PM103AF-5/8	★	12.2 .480	15.88 .625	100.0 3.937	15.0 .591	8	DIN/ANSI

CXSC 1 = axial konzentrischer Kühlschmierstoffaustritt

CXSC 2 = radialer Kühlschmierstoffaustritt



C182



C157



E9



E27



E28



C154

Gewindebohrer

Werkstoff

HM Hartmetall	HSS Schnellarbeitsstahl	HSS-E Hochlegierter Schnellarbeitsstahl (mit Kobalt)	HSS-PM HSS-Pulverschnellstahl	HSS-E-PM HSS-E Pulverschnellstahl

B

Sorte/Beschichtung

C110/B110 Optimale Kombination von hoher Härte und Abrasionsverschleißfestigkeit	Cool Top Optimale Kombination von hoher Härte und Abrasionsverschleißfestigkeit	Smooth Top Geringer Reibungskoeffizient minimiert Werkstoffhaftung an der Schneidkante	ST/C145/B145 Dampfangelassen, zum Schutz der Oberfläche und Vermeidung von Aufbauschneidenbildung	TiCN Titancarbonitrid
CrN Chromnitrid	TiN Titannitrid	N Nitriert	Bright/C150/B150 Unbeschichtet, für reduziertes Aufkleben bei weichen Materialien	D115 Verschleißfeste Sorte mit geringem Reibungswert
D210 Höchste Verschleißfestigkeit sowohl bei Nass- als auch Trockenbearbeitung	D125 Verschleißfeste Sorte mit mittlerem Reibungswert	F125 Verschleißfeste Sorte mit geringem Reibungswert Optimiert für Stahl		

C

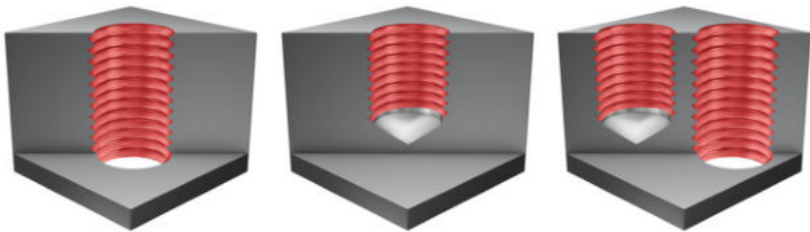
D

Bohrungstyp

Durchgangsbohrung

Grundbohrung

Durchgangs- oder Grund- oder Durchgangsbohrung

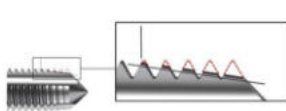


ALLGEMEINE HINWEISE ZUM GEWINDEBOHREN

Der Erfolg jeder Gewindebearbeitung wird von einer Anzahl Faktoren bestimmt, welche die Qualität des fertigen Bauteils beeinflussen. Für eine erfolgreiche Bearbeitung beachten Sie bitte folgende Tipps:

1. Wählen Sie die richtige Werkzeugausführung für Bauteilwerkstoff und Bohrungstyp, zum Beispiel Durchgangs- oder Grundbohrung aus der Werkstoff-Klassifizierungsliste.
2. Sorgen Sie für eine sichere Werkstückspannung - eine laterale Ablenkung kann zu Werkzeugbruch und Gewinden schlechter Qualität führen.
3. Wählen Sie auf der entsprechenden Katalogseite die korrekte Bohrergröße. Beachten Sie, dass die Werkzeuggrößen für die Gewindeformer unterschiedlich sind. Falsche Wahl oder ungünstige Bearbeitungsbedingungen können zu Kaltverfestigung des Werkstoffes führen und so die Leistung des Gewindebohrers oder -formers beeinträchtigen.
4. Wählen Sie die korrekten Schnittdaten, wie auf der Produktseite des Katalogs und in der 'Geführten Produktsuche' angegeben.
5. Setzen Sie das für eine richtige Anwendung angemessene Kühlmittel ein.
6. Sorgen Sie für einen problemlosen Eintritt des Gewindewerkzeugs in die Bohrung, da ein ungleichmäßiger Vorschub zu einer Bohrung mit Anbohrtrichter führen kann.

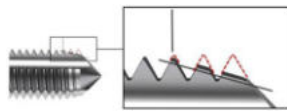
Anschnitt



Anschnitt B=3.5 – 5 × Steigung

Langer Anschnitt:

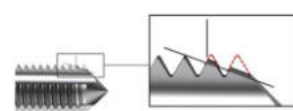
Hohes Drehmoment
Beste Oberflächengüte
Dünne Späne
Niedriger Druck am Anschnitt
Höhere Standzeit
Hauptsächlich für gerade genutete Gewindebohrer mit Schälanschnitt



Anschnitt C=2 – 3 × Steigung

Mittlerer Anschnitt:

Niedriges Drehmoment
Hohe Oberflächengüte
Normale Spandicke
Normaler Druck am Anschnitt
Normale Standzeit
Häufigste Ausführung
Standard-Anschnitt für Grundbohrungen
Hauptsächlich für Gewindebohrer mit gedrahten Spankanälen



Anschnitt E=1.5 – 2 × Steigung

Kurzer Anschnitt:

Niedriges Drehmoment
Hohe Oberflächengüte
Dicke Späne
Hoher Druck am Anschnitt
Reduzierte Standzeit
Extreme Teilung
Einsatz bei geringerem Freiraum am Bohrungsgrund

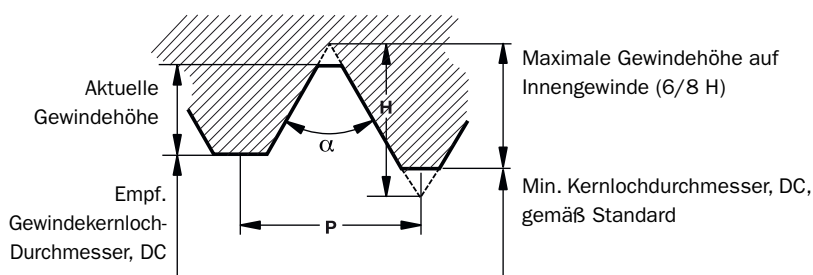
Was ist Gewindehöhe in % ?

Beispiel gilt für ISO & UTS

Gewindehöhe in % ist das Verhältnis zwischen aktueller und maximaler Höhe des Innengewindes.

Beispiel, M8x1.25

Beispiel, M8x1.25



Maximale Gewindehöhe ist:
 $6/8 * (0.866 * 1,25) = 0.811 \text{ mm}$
 Aktuelle Gewindehöhe bei einem Kernlochdurchmesser von DC 6.9 mm:
 $(8 - 6,9) / 2 = 0.55 \text{ mm}$
 Gewindehöhe ist dann $(0.55 / 0.81) \times 100 = 68\%$

GEWINDEBOHRERKLASSEN 2B & 3B: UNIFIED INCH SCREW THREADS (GENORMTE ZOLLGEWINDE)

GER

	TPI		Gewindegrenzen	
Größe	UNC	UNF	Klasse 2B	Klasse 3B
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	TPI		Gewindegrenzen	
Größe	UNC	UNF	Klasse 2B	Klasse 3B
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1"	8		H6	H4
1"		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

Bohrungsgröße - Empfehlungen

Bohrungsdurchmesser - Leitfaden

Dieser Leitfaden gibt Empfehlungen zur Auswahl des korrekten Durchmessers von Bohrungen, die gewindegebohrt werden sollen.

Bohrertyp und Werkstoff bestimmen, welcher Durchmesser sich empfiehlt.

Beachten Sie, dass sich der Bohrungsdurchmesser von der Bohrergröße unterscheiden kann, je nach Toleranz des Bohrers. Für möglichst präzise Bohrungsgrößen empfiehlt sich der Einsatz von Hightech-Vollhartmetallbohrern mit engen Toleranzen. Dadurch kann ein Bohrer mit nahezu dem maximalen Bohrungsdurchmesser gewählt werden, wie er in diesem Leitfaden angegeben wird.

In Ausnahmefällen wie dem Bohren in sehr zähem Werkstoff kann ein größerer Bohrungsdurchmesser gewählt werden, um eine höhere Standzeit zu erzielen. Die Gewindestabilität kann ausreichend sein, das Gewinde kann jedoch außerhalb der gängigen Toleranz liegen.

Weitere technische Informationen, siehe www.sandvik.coromant.com/de

M

DIN 13			Metrisch		Zoll	
TDZ	TP		PHD	PHDX	PHD	PHDX *5H/6H
M 1*	x	0.25	0.75	0.785	.0295	.0309
M 1.1*	x	0.25	0.85	0.885	.0335	.0348
M 1.2*	x	0.25	0.95	0.985	.0374	.0388
M 1.4*	x	0.30	1.10	1.142	.0433	.0450
M 1.6	x	0.35	1.25	1.321	.0492	.0520
M 1.8	x	0.35	1.45	1.521	.0571	.0599
M 2	x	0.40	1.60	1.679	.0630	.0661
M 2.2	x	0.45	1.75	1.838	.0689	.0724
M 2.3	x	0.40	1.85	1.938	.0728	.0763
M 2.5	x	0.45	2.05	2.138	.0807	.0842
M 2.6	x	0.45	2.15	2.238	.0846	.0881
M 3	x	0.50	2.50	2.599	.0984	.1023
M 3.5	x	0.60	2.90	3.010	.1142	.1185
M 4	x	0.70	3.30	3.422	.1299	.1347
M 4.5	x	0.75	3.70	3.878	.1457	.1527
M 5	x	0.80	4.20	4.334	.1654	.1706
M 6	x	1.00	5.00	5.153	.1969	.2029
M 7	x	1.00	6.00	6.153	.2362	.2422
M 8	x	1.25	6.80	6.912	.2677	.2721
M 9	x	1.25	7.80	7.912	.3071	.3115
M 10	x	1.50	8.50	8.676	.3346	.3416
M 11	x	1.50	9.50	9.676	.3740	.3809
M 12	x	1.75	10.20	10.441	.4016	.4111
M 14	x	2.00	12.00	12.210	.4724	.4807
M 16	x	2.00	14.00	14.210	.5512	.5594
M 18	x	2.50	15.50	15.744	.6102	.6198
M 20	x	2.50	17.50	17.744	.6890	.6986
M 22	x	2.50	19.50	19.744	.7677	.7773
M 24	x	3.00	21.00	21.252	.8268	.8367
M 27	x	3.00	24.00	24.252	.9449	.9548
M 30	x	3.50	26.50	26.771	1.0433	1.0540
M 33	x	3.50	29.50	29.771	1.1614	1.1721
M 36	x	4.00	32.00	32.270	1.2598	1.2705
M 39	x	4.00	35.00	35.270	1.3780	1.3886
M 42	x	4.50	37.50	37.799	1.4764	1.4881
M 45	x	4.50	40.50	40.799	1.5945	1.6063
M 48	x	5.00	43.00	43.297	1.6929	1.7046
M 52	x	5.00	47.00	47.297	1.8504	1.8621
M 56	x	5.50	50.50	50.796	1.9882	1.9998
M 64	x	6.00	58.00	58.305	2.2835	2.2955



E9

Bohrungsgröße - Empfehlungen

Gewindebohrer

MF

DIN 13			Metrisch		Zoll	
TDZ	TP		PHD	PHDX 6H	PHD	PHDX 6H
MF 2.5	x 0.35		2.15	2.221	.0846	.0874
MF 3.0	x 0.35		2.65	2.721	.1043	.1071
MF 3.5	x 0.35		3.15	3.221	.1240	.1268
MF 4.0	x 0.50		3.50	3.599	.1378	.1417
MF 4.5	x 0.50		4.00	4.099	.1575	.1614
MF 5.0	x 0.50		4.50	4.599	.1772	.1811
MF 5.5	x 0.50		5.00	5.099	.1969	.2007
MF 6.0	x 0.75		5.25	5.378	.2047	.2117
MF 7.0	x 0.75		6.25	6.378	.2441	.2511
MF 8.0	x 0.50		7.50	7.599	.2953	.2992
MF 8.0	x 0.75		7.25	7.378	.2835	.2905
MF 8.0	x 1.00		7.00	7.153	.2756	.2816
MF 9.0	x 0.75		8.25	8.378	.3228	.3298
MF 9.0	x 1.00		8.00	8.153	.3150	.3210
MF 10	x 0.75		9.25	9.378	.3622	.3692
MF 10	x 1.00		9.00	9.153	.3543	.3604
MF 10	x 1.25		8.80	8.912	.3465	.3509
MF 11	x 0.75		10.25	10.378	.4016	.4086
MF 11	x 1.00		10.00	10.153	.3937	.3997
MF 12	x 1.00		11.00	11.153	.4331	.4391
MF 12	x 1.25		10.75	10.912	.4252	.4296
MF 12	x 1.50		10.50	10.676	.4134	.4203
MF 14	x 1.00		13.00	13.153	.5118	.5178
MF 14	x 1.25		12.75	12.912	.5039	.5083
MF 14	x 1.50		12.50	12.676	.4921	.4991
MF 15	x 1.00		14.00	14.153	.5512	.5572
MF 15	x 1.50		13.50	13.676	.5315	.5384
MF 16	x 1.00		15.00	15.153	.5906	.5966
MF 16	x 1.25		14.80	14.912	.5827	.5871
MF 16	x 1.50		14.50	14.676	.5709	.5778
MF 17	x 1.00		16.00	16.153	.6299	.6359
MF 17	x 1.50		15.50	15.676	.6102	.6172
MF 18	x 1.00		17.00	17.153	.6693	.6753
MF 18	x 1.50		16.50	16.676	.6496	.6565
MF 20	x 1.00		19.00	19.153	.7480	.7541
MF 20	x 1.50		18.50	18.676	.7283	.7353
MF 20	x 2.00		18.00	18.210	.7087	.7169
MF 22	x 1.00		21.00	21.153	.8268	.8328
MF 22	x 1.50		20.50	20.676	.8071	.8140
MF 22	x 2.00		20.00	20.210	.7874	.7957
MF 24	x 1.00		23.00	23.153	.9055	.9115
MF 24	x 1.50		22.50	22.676	.8858	.8928
MF 24	x 2.00		22.00	22.210	.8661	.8744
MF 25	x 1.00		24.00	24.153	.9449	.9509
MF 25	x 1.50		23.50	23.676	.9252	.9321
MF 25	x 2.00		23.00	23.210	.9055	.9138
MF 27	x 1.00		26.00	26.153	1.0236	1.0296
MF 27	x 1.50		25.50	25.676	1.0039	1.0109
MF 27	x 2.00		25.00	25.210	.9843	.9925
MF 28	x 1.00		27.00	27.153	1.0630	1.0690
MF 28	x 1.50		26.50	26.676	1.0433	1.0502
MF 28	x 2.00		26.00	26.210	1.0236	1.0319
MF 30	x 1.00		29.00	29.153	1.1417	1.1478
MF 30	x 1.50		28.50	28.676	1.1220	1.1290
MF 30	x 2.00		28.00	28.210	1.1024	1.1106
MF 30	x 3.00		27.00	27.252	1.0630	1.0729
MF 32	x 1.50		30.50	30.676	1.2008	1.2077
MF 32	x 2.00		30.00	30.210	1.1811	1.1894
MF 33	x 1.50		31.50	31.676	1.2402	1.2471
MF 33	x 2.00		31.00	31.210	1.2205	1.2287
MF 33	x 3.00		30.00	30.252	1.1811	1.1910
MF 35	x 1.50		33.50	33.676	1.3189	1.3258
MF 36	x 1.50		34.50	34.676	1.3583	1.3652



Bohrungsgröße - Empfehlungen

Gewindebohrer

UNC

ASME B1.1		Metrisch			Zoll		
TDZ	TPI	PHD	PHDX 2B	PHDX 3B	PHD	PHDX 2B	PHDX 3B
Nr. 1	- 64	1.55	1.582	1.582	.0610	.0623	.0623
Nr. 2	- 56	1.85	1.872	1.872	.0728	.0737	.0737
Nr. 3	- 48	2.10	2.146	2.146	.0827	.0845	.0845
Nr. 4	- 40	2.35	2.385	2.385	.0925	.0939	.0939
Nr. 5	- 40	2.65	2.697	2.697	.1043	.1062	.1062
Nr. 6	- 32	2.85	2.896	2.896	.1122	.1140	.1140
Nr. 8	- 32	3.50	3.531	3.528	.1378	.1390	.1389
Nr. 10	- 24	3.90	3.962	3.950	.1535	.1560	.1555
Nr. 12	- 24	4.50	4.597	4.590	.1772	.1810	.1807
1/4	- 20	5.10	5.268	5.250	.2008	.2074	.2067
5/16	- 18	6.60	6.734	6.680	.2598	.2651	.2630
3/8	- 16	8.00	8.164	8.082	.3150	.3214	.3182
7/16	- 14	9.40	9.550	9.441	.3701	.3760	.3717
1/2	- 13	10.80	11.013	10.881	.4252	.4336	.4284
9/16	- 12	12.20	12.456	12.301	.4803	.4904	.4843
5/8	- 11	13.50	13.868	13.693	.5315	.5460	.5391
3/4	- 10	16.50	16.833	16.324	.6496	.6627	.6427
7/8	- 9	19.50	19.748	19.520	.7677	.7775	.7685
1	- 8	22.25	22.598	22.344	.8760	.8897	.8797
1 1/8	- 7	25.00	25.349	25.082	.9843	.9980	.9875
1 1/4	- 7	28.00	28.524	28.258	1.1024	1.1230	1.1125
1 3/8	- 6	30.75	31.120	30.851	1.2106	1.2252	1.2146
1 1/2	- 6	34.00	34.295	34.026	1.3386	1.3502	1.3396
1 3/4	- 5	39.50	39.814	39.560	1.5551	1.5675	1.5575
2	- 4.5	45.00	45.598	45.367	1.7717	1.7952	1.7861

UNF

ASME B1.1		Metrisch			Zoll		
TDZ	TPI	PHD	PHDX 2B	PHDX 3B	PHD	PHDX 2B	PHDX 3B
Nr.1	- 72	1.55	1.613	1.613	.0610	.0635	.0635
Nr.2	- 64	1.85	1.913	1.913	.0728	.0753	.0753
Nr.3	- 56	2.15	2.197	2.197	.0846	.0865	.0865
Nr.4	- 48	2.40	2.459	2.459	.0945	.0968	.0968
Nr.5	- 44	2.70	2.741	2.741	.1063	.1079	.1079
Nr.6	- 40	2.95	3.023	3.012	.1161	.1190	.1186
Nr.8	- 36	3.50	3.607	3.597	.1378	.1420	.1416
Nr. 10	- 32	4.10	4.166	4.168	.1614	.1640	.1641
Nr. 12	- 28	4.60	4.724	4.717	.1811	.1860	.1857
1/4	- 28	5.50	5.580	5.563	.2165	.2197	.2190
5/16	- 24	6.90	7.038	6.995	.2717	.2771	.2754
3/8	- 24	8.50	8.626	8.565	.3346	.3396	.3372
7/16	- 20	9.90	10.030	9.947	.3898	.3949	.3916
1/2	- 20	11.50	11.618	11.524	.4528	.4574	.4537
9/16	- 18	12.90	13.084	12.969	.5079	.5151	.5106
5/8	- 18	14.50	14.671	14.554	.5709	.5776	.5730
3/4	- 16	17.50	17.689	17.546	.6890	.6964	.6908
7/8	- 14	20.40	20.663	20.493	.8031	.8135	.8068
1	- 12	23.25	23.569	23.363	.9154	.9279	.9198
1 1/8	- 12	26.50	26.744	26.538	1.0433	1.0529	1.0448
1 1/4	- 12	29.50	29.919	29.713	1.1614	1.1779	1.1698
1 3/8	- 12	32.75	33.094	32.888	1.2894	1.3029	1.2948
1 1/2	- 12	36.00	36.269	36.063	1.4173	1.4279	1.4198



E9

Bohrungsgröße - Empfehlungen

Gewindebohrer

G

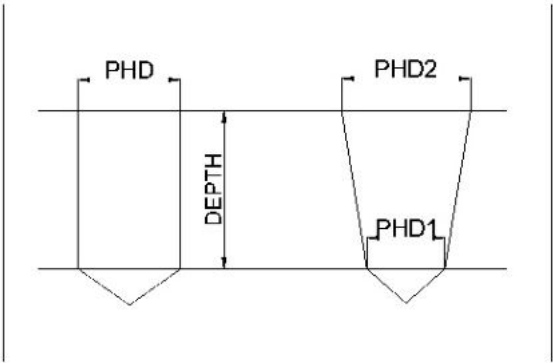
DIN-ISO 228		Metrisch		Zoll	
TDZ	TPI	PHD	PHDX	PHD	PHDX
G 1/16	- 28	6.80	6.843	.2677	.2694
G 1/8	- 28	8.80	8.848	.3465	.3483
G 1/4	- 19	11.80	11.890	.4646	.4681
G 3/8	- 19	15.25	15.395	.6004	.6061
G 1/2	- 14	19.00	19.173	.7480	.7548
G 5/8	- 14	21.00	21.129	.8268	.8319
G 3/4	- 14	24.50	24.659	.9646	.9708
G 7/8	- 14	28.25	28.419	1.1122	1.1189
G 1	- 11	30.75	30.932	1.2106	1.2178
G 1 1/8	- 11	35.50	35.580	1.3976	1.4008
G 1 1/4	- 11	39.50	39.593	1.5551	1.5588
G 1 1/2	- 11	45.25	45.486	1.7815	1.7908

NPT

ASME B1.20.1 Kegel 1:16		Metrisch				Zoll			
TDZ	TPI	PHD	PHD1	PHD2	TIEFE	PHD	PHD1	PHD2	TIEFE
1/16	- 27	6.15	5.95	6.39	10.7	.2421	.2343	.2516	.4213
1/8	- 27	8.40	8.31	8.74	10.8	.3307	.3272	.3441	.4252
1/4	- 18	11.10	10.73	11.36	15.6	.4370	.4224	.4472	.6142
3/8	- 18	14.30	14.15	14.80	16.0	.5630	.5571	.5827	.6299
1/2	- 14	17.90	17.47	18.32	20.8	.7047	.6878	.7213	.8189
3/4	- 14	23.30	22.79	23.67	21.3	.9173	.8972	.9319	.8386
1	- 11.5	29.00	28.46	29.69	25.6	1.1417	1.0472	1.1689	1.0079

NPTF

ASME B1.20.3 Kegel 1:16		Metrisch				Zoll			
TDZ	TPI	PHD	PHD1	PHD2	TIEFE	PHD	PHD1	PHD2	TIEFE
1/16	- 27	6.10	5.97	6.41	10.30	.2402	.2350	.2524	.4055
1/8	- 27	8.40	8.33	8.77	10.30	.3307	.3280	.3453	.4055
1/4	- 18	11.00	10.77	11.40	15.00	.4331	.4240	.4488	.5906
3/8	- 18	14.50	14.19	14.84	15.30	.5709	.5587	.5843	.6024
1/2	- 14	17.00	17.48	18.33	19.00	.6693	.6882	.7217	.7480
3/4	- 14	23.00	22.84	23.72	9.00	.9055	.8992	.9339	.3543
1	- 11,5	29.00	28.68	29.76	20.40	1.1417	1.1291	1.1717	.8031



Bohrungsgröße - Empfehlungen

Gewindeformer

M

DIN 13		Metrisch	Zoll
TDZ	TP	PHD	PHD
M 1	x 0.25	0.90	.0354
M 1.2	x 0.25	1.10	.0433
M 1.4	x 0.30	1.26	.0496
M 1.6	x 0.35	1.45	.0571
M 1.7	x 0.35	1.55	.0610
M 1.8	x 0.35	1.65	.0650
M 2	x 0.40	1.82	.0728
M 2.2	x 0.45	2.00	.0787
M 2.5	x 0.45	2.30	.0906
M 3	x 0.50	2.80	.1102
M 3.5	x 0.60	3.25	.1280
M 4	x 0.70	3.70	.1457
M 5	x 0.80	4.65	.1831
M 6	x 1.00	5.55	.2185
M 7	x 1.00	6.55	.2579
M 8	x 1.25	7.40	.2913
M 9	x 1.25	8.40	.3307
M 10	x 1.50	9.30	.3661
M 11	x 1.50	10.30	.4055
M 12	x 1.75	11.20	.4409
M 14	x 2.00	13.10	.5157
M 16	x 2.00	15.10	.5945
M 18	x 2.50	16.90	.6654
M 20	x 2.50	18.90	.7441
M 22	x 2.50	20.90	.8228
M 24	x 3.00	22.70	.8937

MF

DIN 13		Metrisch	Zoll
TDZ	TP	PHD	PHD
M 2.5	x 0.35	2.35	.0925
M 3	x 0.35	2.85	.1122
M 4	x 0.35	3.85	.1516
M 4	x 0.50	3.80	.1496
M 5	x 0.50	4.80	.1890
M 5.5	x 0.50	5.30	.2087
M 6	x 0.75	5.65	.2224
M 7	x 0.75	6.65	.2618
M 8	x 0.75	7.65	.3012
M 8	x 1.00	7.55	.2972
M 9	x 0.75	8.65	.3406
M 9	x 1.00	8.55	.3366
M 10	x 0.75	9.65	.3799
M 10	x 1.00	9.55	.3760
M 10	x 1.25	9.40	.3701
M 11	x 0.75	10.65	.4193
M 11	x 1.00	10.55	.4154
M 12	x 1.00	11.55	.4547
M 12	x 1.25	11.40	.4488
M 12	x 1.50	11.30	.4449
M 14	x 1.00	13.55	.5335
M 14	x 1.25	13.40	.5276
M 14	x 1.25	13.30	.5236
M 15	x 1.00	14.55	.5728
M 15	x 1.50	14.30	.5630
M 16	x 1.00	15.55	.6122
M 16	x 1.50	15.30	.6024
M 17	x 1.00	16.55	.6516
M 17	x 1.50	16.30	.6417
M 18	x 1.00	17.55	.6909
M 18	x 1.50	17.30	.6811
M 18	x 2.00	17.10	.6732
M 20	x 1.00	19.55	.7697
M 20	x 1.50	19.30	.7598
M 24	x 1.00	23.55	.9272
M 24	x 1.50	23.30	.9173
M 24	x 2.00	23.10	.9094

UNC

ASME B1.1		Metrisch	Zoll
TDZ	TPI	PHD	PHD
Nr. 1	- 64	1.68	.0661
Nr. 2	- 56	1.98	.0780
Nr. 3	- 48	2.28	.0898
Nr. 4	- 40	2.55	.1004
Nr. 5	- 40	2.90	.1142
Nr. 6	- 32	3.15	.1240
Nr. 8	- 32	3.80	.1496
Nr. 10	- 24	4.35	.1713
Nr. 12	- 24	5.00	.1969
1/4	- 20	5.75	.2264
5/16	- 18	7.30	.2874
3/8	- 16	8.80	.3465
7/16	- 14	10.30	.4055
1/2	- 13	11.80	.4646
9/16	- 12	13.30	.5236
5/8	- 11	14.80	.5827
3/4	- 10	17.90	.7047
7/8	- 9	21.00	.8268
1	- 8	24.00	.9449

UNF

UNF: ASME B1.1		Metrisch	Zoll
TDZ	TPI	PHD	PHD
Nr. 1	- 72	1.70	.0669
Nr. 2	- 64	2.00	.0787
Nr. 3	- 56	2.30	.0906
Nr. 4	- 48	2.60	.1024
Nr. 5	- 44	2.90	.1142
Nr. 6	- 40	3.20	.1260
Nr. 8	- 36	3.85	.1516
Nr. 10	- 32	4.45	.1752
Nr. 12	- 28	5.10	.2008
1/4	- 28	5.95	.2343
1/16	- 24	7.45	.2933
3/8	- 24	9.05	.3563
7/16	- 20	10.55	.4154
1/2	- 20	12.10	.4764
9/16	- 18	13.65	.5374
5/8	- 18	15.25	.6004
3/4	- 16	18.35	.7224
7/8	- 14	21.40	.8425
1	- 12	24.45	.9626

EGM

DIN 8140		Metrisch
TDZ	TP	PHD
EG M 3	- 0.50	3.40
EG M 4	- 0.70	4.60
EG M 5	- 0.80	5.65
EG M 6	- 1.00	6.85
EG M 8	- 1.25	9.05
EG M 10	- 1.50	11.30
EG M 12	- 1.75	13.50



E9

CoroTap - Universell

CoroTap™ 200

Metrische Werte

					E616		
ULDR(xTD)					1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	-	-	-
	P1.1.Z.HT		639	190	46	38	33
	P1.2.Z.AN		639	190	37	30	26
	P1.2.Z.HT		708	210	34	28	24
	P1.3.Z.AN		639	190	37	30	26
	P1.3.Z.HT		1013	300	18	15	13
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	37	30	26
	P2.2.Z.AN		811	240	34	28	24
	P2.3.Z.AN		867	260	18	15	13
	P2.5.Z.HT.1		961	285	18	15	13
	P3.0.Z.AN	Hochlegierter Stahl	674	200	34	28	24
	P3.0.Z.HT.1		1282	380	12	10	9
	P3.1.Z.AN		839	250	34	28	24
	P1.5.C.UT	Stahlguss	503	150	37	30	26
	P2.6.C.UT		674	200	34	28	24
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	34	28	24
	P5.0.Z.PH		1114	330	6	5	4
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	674	200	7	6	5
	M1.0.C.UT		674	200	7	6	5
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	674	200	7	6	5
	M2.0.C.AQ		674	200	7	6	5
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	778	230	6	5	4
	M3.1.C.AQ		778	230	6	5	4
	M3.2.Z.AQ		867	260	6	5	4
K	K1.1.C.NS	Temperguss	674	200	29	24	21
	K2.1.C.UT	Grauguss	602	180	24	20	17
	K2.2.C.UT		825	245	20	16	14
	K2.3.C.UT		591	175	29	24	21
	K3.1.C.UT	Kugelgraphitguss	518	155	29	24	21
	K3.2.C.UT		727	215	29	24	21
	K3.3.C.UT		885	265	29	24	21
	K3.5.C.UT		639	190	29	24	21
N	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	20	16	14
	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	-	-	-
	N1.2.Z.AG		-	100	-	-	-
	N1.3.C.UT		-	75	-	-	-
	N1.3.C.AG		-	90	-	-	-
	N1.4.C.NS		-	130	-	-	-
	N3.3.U.UT	Kupferbasislegierungen	-	110	55	45	38
	N3.1.U.UT		-	100	22	18	15

CoroTap - Universell

CoroTap™ 200

Metrische Werte

				T200-XM								
				Sorte B110/C110			Sorte B145/C145			Sorte B150/C150		
				ULDR			ULDR			ULDR		
				ULDR(xTD)			1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	HB	v _c m/min			v _c m/min			v _c m/min		
P		Unlegierter Stahl										
	P1.1.Z.AN		125	43	35	30	31	25	21	31	25	21
	P1.1.Z.HT		190	41	34	29	27	22	19	27	22	19
	P1.2.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.2.Z.HT		210	31	26	22	20	16	14	20	16	14
	P1.3.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.3.Z.HT		300	21	17	15	12	10	9	12	10	9
	P2.1.Z.AN	Niedriglegierter Stahl	175	39	32	27	22	18	15	22	18	15
	P2.2.Z.AN		240	31	26	22	20	16	14	20	16	14
	P2.3.Z.AN		260	21	17	15	12	10	9	12	10	9
	P2.5.Z.HT.1		285	21	17	15	12	10	9	12	10	9
	P3.0.Z.AN	Hochlegierter Stahl	200	31	26	22	20	16	14	20	16	14
	P3.0.Z.HT.1		380	10	8	7	6	5	4	6	5	4
	P3.1.Z.AN		250	31	26	22	20	16	14	20	16	14
	P1.5.C.UT	Stahlguss	150	39	32	27	22	18	15	22	18	15
	P2.6.C.UT		200	31	26	22	20	16	14	20	16	14
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	330	32	26	22	20	16	14	20	16	14
P5.0.Z.PH		330	12	10	9	5	4	3				
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	200	10	8	7	7	6	5	-	-	-
	M1.0.C.UT		230	10	8	7	7	6	5	-	-	-
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	200	10	8	7	7	6	5	-	-	-
	M2.0.C.AQ		260	10	8	7	7	6	5	-	-	-
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	200	6	5	4	5	4	3	-	-	-
	M3.2.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.1.C.AQ		230	6	5	4	5	4	3	-	-	-
K	K1.1.C.NS	Temperguss	200	24	20	17	18	15	13	18	15	13
	K2.1.C.UT	Grauguss	180	23	19	16	18	15	13	18	15	13
	K2.2.C.UT		245	16	13	11	10	8	7	10	8	7
	K2.3.C.UT		175	24	20	17	18	15	13	18	15	13
	K3.1.C.UT	Kugelgraphitguss	155	24	20	17	18	15	13	18	15	13
	K3.2.C.UT		215	24	20	17	18	15	13	18	15	13
	K3.3.C.UT		265	24	20	17	18	15	13	18	15	13
	K3.5.C.UT		190	24	20	17	18	15	13	18	15	13
K5.1.C.NS	Austenitisch-bainitisches Gusseisen	300	16	13	11	10	8	7	10	8	7	
N	N1.2.Z.UT	Aluminiumbasislegierungen	60	49	40	34	-	-	-	43	35	30
	N1.2.Z.AG		100	49	40	34	-	-	-	43	35	30
	N1.3.C.UT		75	49	40	34	-	-	-	43	35	30
	N1.3.C.AG		90	31	25	21	-	-	-	24	20	17
	N1.4.C.NS		130	21	18	15	-	-	-	18	15	13
	N3.3.U.UT	Kupferbasislegierungen	110	46	38	32	-	-	-	37	30	26
	N3.1.U.UT		100	18	15	13	-	-	-	15	12	10
S	S1.0.U.AN	Eisenbasissuperlegierungen	200	9	8	6	-	-	-	6	5	4
	S2.0.Z.UT	Nickelbasissuperlegierungen	275	9	8	6	-	-	-	6	5	4
	S2.0.Z.AN		250	9	8	6	-	-	-	6	5	4
	S2.1.Z.AN		125	23	19	16	-	-	-	15	12	10
	S4.1.Z.UT	Titanbasislegierungen	200	21	18	15	-	-	-	18	15	13

B

C

D

E

CoroTap - Universell

CoroTap™ 200

Zoll-Werte

B

C

D

E

					E616		
ULDR(xTD)					1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c Fuß/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	-	-	-
	P1.1.Z.HT		639	190	152	125	107
	P1.2.Z.AN		639	190	120	98	84
	P1.2.Z.HT		708	210	112	92	79
	P1.3.Z.AN		639	190	120	98	84
	P1.3.Z.HT		1013	300	60	49	42
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	120	98	84
	P2.2.Z.AN		811	240	112	92	79
	P2.3.Z.AN		867	260	60	49	42
	P2.5.Z.HT.1		961	285	60	49	42
	P3.0.Z.AN	Hochlegierter Stahl	674	200	112	92	79
	P3.0.Z.HT.1		1282	380	40	33	28
	P3.1.Z.AN		839	250	112	92	79
	P1.5.C.UT	Stahlguss	503	150	120	98	84
	P2.6.C.UT		674	200	112	92	79
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	112	92	79
	P5.0.Z.PH		1114	330	20	16	14
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	674	200	24	20	17
	M1.0.C.UT		674	200	24	20	17
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	674	200	24	20	17
	M2.0.C.AQ		674	200	24	20	17
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	778	230	20	16	14
	M3.1.C.AQ		778	230	20	16	14
	M3.2.Z.AQ		867	260	20	16	14
K	K1.1.C.NS	Temperguss	674	200	96	79	67
	K2.1.C.UT	Grauguss	602	180	80	66	56
	K2.2.C.UT		825	245	64	52	45
	K2.3.C.UT		591	175	96	79	67
	K3.1.C.UT	Kugelgraphitguss	518	155	96	79	67
	K3.2.C.UT		727	215	96	79	67
	K3.3.C.UT		885	265	96	79	67
	K3.5.C.UT		639	190	96	79	67
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	64	52	45
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	-	-	-
	N1.2.Z.AG		-	100	-	-	-
	N1.3.C.UT		-	75	-	-	-
	N1.3.C.AG		-	90	-	-	-
	N1.4.C.NS		-	130	-	-	-
	N3.3.U.UT	Kupferbasislegierungen	-	110	181	148	126
	N3.1.U.UT		-	100	72	59	51

CoroTap - Universell

CoroTap™ 200

Zoll-Werte

				T200-XM								
				Sorte B110/C110			Sorte B145/C145			Sorte B150/C150		
				ULDR			ULDR			ULDR		
				ULDR(xTD)			1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		
P		Unlegierter Stahl										
	P1.1.Z.AN		125	140	115	98	100	82	70	100	82	70
	P1.1.Z.HT		190	134	110	94	88	72	62	88	72	62
	P1.2.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.2.Z.HT		210	102	84	72	64	52	45	64	52	45
	P1.3.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.3.Z.HT		300	70	57	49	40	33	28	40	33	28
	P2.1.Z.AN	Niedriglegierter Stahl	175	126	103	88	72	59	51	72	59	51
	P2.2.Z.AN		240	102	84	72	64	52	45	64	52	45
	P2.3.Z.AN		260	70	57	49	40	33	28	40	33	28
	P2.5.Z.HT.1		285	70	57	49	40	33	28	40	33	28
	P3.0.Z.AN	Hochlegierter Stahl	200	102	84	72	64	52	45	64	52	45
	P3.0.Z.HT.1		380	32	26	22	20	16	14	20	16	14
	P3.1.Z.AN		250	102	84	72	64	52	45	64	52	45
	P1.5.C.UT	Stahlguss	150	126	103	88	72	59	51	72	59	51
	P2.6.C.UT		200	102	84	72	64	52	45	64	52	45
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	330	104	85	73	64	52	45	64	52	45
P5.0.Z.PH		330	40	33	28	16	13	11	-	-	-	
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	200	32	26	22	24	20	17	-	-	-
	M1.0.C.UT		230	32	26	22	24	20	17	-	-	-
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	200	32	26	22	24	20	17	-	-	-
	M2.0.C.AQ		260	32	26	22	24	20	17	-	-	-
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	200	20	16	14	16	13	11	-	-	-
	M3.2.Z.AQ		200	20	16	14	16	13	11	-	-	-
M3.1.C.AQ		230	20	16	14	16	13	11	-	-	-	
K	K1.1.C.NS	Temperguss	200	80	66	56	60	49	42	60	49	42
		Grauguss										
	K2.1.C.UT		180	74	61	52	60	49	42	60	49	42
	K2.2.C.UT		245	52	43	36	32	26	22	32	26	22
	K2.3.C.UT		175	80	66	56	60	49	42	60	49	42
	K3.1.C.UT	Kugelgraphitguss	155	80	66	56	60	49	42	60	49	42
	K3.2.C.UT		215	80	66	56	60	49	42	60	49	42
	K3.3.C.UT		265	80	66	56	60	49	42	60	49	42
K3.5.C.UT		190	80	66	56	60	49	42	60	49	42	
K5.1.C.NS	Austenitisch-bainitisches Gusseisen	300	52	43	36	32	26	22	32	26	22	
N	N1.2.Z.UT	Aluminiumbasislegierungen	60	161	131	112	-	-	-	140	115	98
	N1.2.Z.AG		100	161	131	112	-	-	-	140	115	98
	N1.3.C.UT		75	161	131	112	-	-	-	140	115	98
	N1.3.C.AG		90	100	82	70	-	-	-	80	66	56
	N1.4.C.NS		130	70	57	49	-	-	-	60	49	42
	N3.3.U.UT	Kupferbasislegierungen	110	150	123	105	-	-	-	120	98	84
N3.1.U.UT		100	60	49	42	-	-	-	48	39	34	
S	S1.0.U.AN	Eisenbasissuperlegierungen	200	30	25	21	-	-	-	20	16	14
		Nickelbasissuperlegierungen										
	S2.0.Z.UT		275	30	25	21	-	-	-	20	16	14
	S2.0.Z.AN		250	30	25	21	-	-	-	20	16	14
	S2.1.Z.AN		125	74	61	52	-	-	-	48	39	34
	S4.1.Z.UT	Titanbasislegierungen	200	70	57	49	-	-	-	60	49	42

B

C

D

E

CoroTap - Universell

CoroTap™ 300

Metrische Werte

					E003			E013			E023			E033			E195 E245			E615			E207 E258			E212 E263			T300-XM100AL T300-XM100AM		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c m/min			v _c m/min			v _c m/min			v _c m/min			v _c m/min			v _c m/min			v _c m/min			v _c m/min			v _c m/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	31	25	21	27	22	19	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	P1.1.Z.HT		639	190	27	22	19	24	20	17	46	38	33	24	43	5															
	P1.2.Z.AN		639	190	22	18	15	20	16	14	37	30	26	20	34	7															
	P1.2.Z.HT		708	210	20	16	14	15	12	10	34	28	24	15	29	7															
	P1.3.Z.AN		639	190	22	18	15	20	16	14	37	30	26	20	34	7															
	P1.3.Z.HT		1013	300	12	10	9	9	7	6	18	15	13	9	12	5															
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	22	18	15	20	16	14	37	30	26	20	34	7															
	P2.2.Z.AN		811	240	20	16	14	15	12	10	34	28	24	15	29	7															
	P2.3.Z.AN		867	260	12	10	9	9	7	6	18	15	13	9	12	5															
	P2.5.Z.HT.1		961	285	12	10	9	9	7	6	18	15	13	9	12	5															
	P3.0.Z.AN	Hochlegierter Stahl	674	200	20	16	14	15	12	10	34	28	24	15	29	7															
	P3.0.Z.HT.1		1282	380	-	-	-	-	-	-	12	10	9	-	-	4															
	P3.1.Z.AN		839	250	20	16	14	15	12	10	34	28	24	15	29	7															
	P1.5.C.UT	Stahlguss	503	150	22	18	15	20	16	14	37	30	26	20	34	7															
	P2.6.C.UT		674	200	20	16	14	15	12	10	34	28	24	15	29	7															
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	20	16	14	15	12	10	34	28	24	15	29	7															
	P5.0.Z.PH		1114	330	5	4	3	-	-	-	6	5	4	-	-	-															
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	674	200	7	6	5	-	-	-	7	6	5	-	-	3															
	M1.0.C.UT		674	200	7	6	5	-	-	-	7	6	5	-	-	3															
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	674	200	7	6	5	-	-	-	7	6	5	-	-	3															
	M2.0.C.AQ		674	200	7	6	5	-	-	-	7	6	5	-	-	-															
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	778	230	5	4	3	-	-	-	6	5	4	-	-	2															
	M3.1.C.AQ		778	230	5	4	3	-	-	-	6	5	4	-	-	2															
K	M3.2.Z.AQ		867	260	5	4	3	-	-	-	6	5	4	-	-	2															
	K1.1.C.NS	Temperguss	674	200	-	-	-	-	-	-	29	24	21	-	-	-															
	K2.1.C.UT	Grauguss	602	180	-	-	-	-	-	-	24	20	17	-	-	11															
	K2.2.C.UT		825	245	-	-	-	-	-	-	20	16	14	-	-	5															
	K2.3.C.UT		591	175	-	-	-	-	-	-	29	24	21	-	-	-															
	K3.1.C.UT	Kugelgraphitguss	518	155	-	-	-	-	-	-	29	24	21	-	-	-															
	K3.2.C.UT		727	215	-	-	-	-	-	-	29	24	21	-	-	-															
	K3.3.C.UT		885	265	-	-	-	-	-	-	29	24	21	-	-	-															
	K3.5.C.UT		639	190	-	-	-	-	-	-	29	24	21	-	-	-															
N	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	-	-	-	-	-	-	20	16	14	-	-	-															
	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	-	-	-	43	35	30	-	-	-	37	43	-															
	N1.2.Z.AG		-	100	-	-	-	43	35	30	-	-	-	37	43	-															
	N1.3.C.UT		-	75	-	-	-	43	35	30	-	-	-	37	43	-															
	N1.3.C.AG		-	90	-	-	-	24	20	17	-	-	-	18	24	20															
	N1.4.C.NS		-	130	-	-	-	18	15	13	-	-	-	-	-	15															
	N3.3.U.UT	Kupferbasislegierungen	-	110	-	-	-	-	-	-	55	45	38	-	-	60															
	N3.1.U.UT		-	100	-	-	-	-	-	-	22	18	15	-	-	-															

CoroTap - Universell

CoroTap™ 300

Metrische Werte

			ULDR(xTD)	T300-XM								
				Sorte B110/C110			Sorte B145*/C145			Sorte B150/C150		
				ULDR			ULDR			ULDR		
ISO	MC-Nr.	Werkstoff	HB	v _c m/min			v _c m/min			v _c m/min		
P	Unlegierter Stahl			1.5	2	3	1.5	2	3	1.5	2	3
	P1.1.Z.AN		125	43	35	30	31	25	21	31	25	21
	P1.1.Z.HT		190	41	34	29	27	22	19	27	22	19
	P1.2.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.2.Z.HT		210	31	26	22	20	16	14	20	16	14
	P1.3.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.3.Z.HT		300	21	17	15	12	10	9	12	10	9
	Niedriglegierter Stahl											
	P2.1.Z.AN		175	39	32	27	22	18	15	22	18	15
	P2.2.Z.AN		240	31	26	22	20	16	14	20	16	14
	P2.3.Z.AN		260	21	17	15	12	10	9	12	10	9
	P2.5.Z.HT.1		285	21	17	15	12	10	9	12	10	9
	Hochlegierter Stahl											
	P3.0.Z.AN		200	31	26	22	20	16	14	20	16	14
	P3.0.Z.HT.1		380	6	5	4	6	5	4	6	5	4
	P3.1.Z.AN		250	31	26	22	20	16	14	20	16	14
	Stahlguss											
	P1.5.C.UT		150	39	32	27	22	18	15	22	18	15
	P2.6.C.UT		200	31	26	22	20	16	14	20	16	14
	Ferritisch/martensitischer rostfreier Stahl											
	P5.0.Z.HT.1		330	32	26	22	20	16	14	20	16	14
	P5.0.Z.PH		330	12	10	9	5	4	3	-	-	-
M	Austenitischer rostfreier Stahl											
	M1.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M1.0.C.UT		230	10	8	7	7	6	5	-	-	-
	Super austenitischer rostfreier Stahl											
	M2.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M2.0.C.AQ		260	10	8	7	7	6	5	-	-	-
	Rostfreie (austenitische/ferritische) Duplex-Stähle											
	M3.1.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.2.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.1.C.AQ		230	6	5	4	5	4	3	-	-	-
K	Temperguss											
	K1.1.C.NS		200	24	20	17	18	15	13	-	-	-
	Grauguss											
	K2.1.C.UT		180	23	19	16	18	15	13	-	-	-
	K2.2.C.UT		245	16	13	11	10	8	7	-	-	-
	K2.3.C.UT		175	24	20	17	18	15	13	-	-	-
	Kugelgraphitguss											
	K3.1.C.UT		155	24	20	17	18	15	13	-	-	-
	K3.2.C.UT		215	24	20	17	18	15	13	-	-	-
	K3.3.C.UT		265	24	20	17	18	15	13	-	-	-
	K3.5.C.UT		190	24	20	17	18	15	13	-	-	-
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	300	16	13	11	10	8	7	-	-	-
N	Aluminiumbasislegierungen											
	N1.2.Z.UT		60	49	40	34	-	-	-	43	35	30
	N1.2.Z.AG		100	49	40	34	-	-	-	43	35	30
	N1.3.C.UT		75	49	40	34	-	-	-	43	35	30
	N1.3.C.AG		90	31	25	21	-	-	-	24	20	17
	N1.4.C.NS		130	21	18	15	-	-	-	18	15	13
	Kupferbasislegierungen											
	N3.3.U.UT		110	-	-	-	-	-	-	-	-	-
	N3.1.U.UT		100	-	-	-	-	-	-	-	-	-
S	Eisenbasissuperlegierungen											
	S1.0.U.AN		200	9	8	6	-	-	-	6	5	4
	Nickelbasissuperlegierungen											
	S2.0.Z.UT		275	9	8	6	-	-	-	6	5	4
	S2.0.Z.AN		250	9	8	6	-	-	-	6	5	4
	S2.1.Z.AN		125	23	19	16	-	-	-	15	12	10
	Titanbasislegierungen											
	S4.1.Z.UT		200	21	18	15	-	-	-	18	15	13

* Hinweis! Empfehlungen zu Schnittgeschwindigkeiten für T300-XM100AL und T300-XM100AM, siehe Seite C166

B

C

D

E

CoroTap - Universell

CoroTap™ 300

Zoll-Werte

					E003			E013			E023			E033			E195 E245			E615			E207 E258			E212 E263			T300-XM100AL T300-XM100AM		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min			v _c Fuß/min			v _c Fuß/min			v _c Fuß/min			v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	100	82	70	88	72	62	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	P1.1.Z.HT		639	190	88	72	62	80	66	56	152	125	107	80	-	-	140	-	-	80	-	-	140	-	-	80	-	-	140	-	-
	P1.2.Z.AN		639	190	72	59	51	64	52	45	120	98	84	64	-	-	112	-	-	64	-	-	112	-	-	64	-	-	112	-	-
	P1.2.Z.HT		708	210	64	52	45	48	39	34	112	92	79	48	-	-	96	-	-	48	-	-	96	-	-	48	-	-	96	-	-
	P1.3.Z.AN		639	190	72	59	51	64	52	45	120	98	84	64	-	-	112	-	-	64	-	-	112	-	-	64	-	-	112	-	-
	P1.3.Z.HT		1013	300	40	33	28	28	23	20	60	49	42	28	-	-	40	-	-	28	-	-	40	-	-	28	-	-	40	-	-
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	72	59	51	64	52	45	120	98	84	20	-	-	34	-	-	20	-	-	34	-	-	20	-	-	34	-	-
	P2.2.Z.AN		811	240	64	52	45	48	39	34	112	92	79	15	-	-	29	-	-	15	-	-	29	-	-	15	-	-	29	-	-
	P2.3.Z.AN		867	260	40	33	28	28	23	20	60	49	42	9	-	-	12	-	-	9	-	-	12	-	-	9	-	-	12	-	-
	P2.5.Z.HT.1		961	285	40	33	28	28	23	20	60	49	42	9	-	-	12	-	-	9	-	-	12	-	-	9	-	-	12	-	-
	P3.0.Z.AN	Hochlegierter Stahl	674	200	64	52	45	48	39	34	112	92	79	15	-	-	29	-	-	15	-	-	29	-	-	15	-	-	29	-	-
	P3.0.Z.HT.1		1282	380	-	-	-	-	-	-	40	33	28	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	P3.1.Z.AN	Stahlguss	839	250	64	52	45	48	39	34	112	92	79	15	-	-	29	-	-	15	-	-	29	-	-	15	-	-	29	-	-
	P1.5.C.UT		503	150	72	59	51	64	52	45	120	98	84	20	-	-	34	-	-	20	-	-	34	-	-	20	-	-	34	-	-
	P2.6.C.UT		674	200	64	52	45	48	39	34	112	92	79	15	-	-	29	-	-	15	-	-	29	-	-	15	-	-	29	-	-
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	64	52	45	48	39	34	112	92	79	15	-	-	29	-	-	15	-	-	29	-	-	15	-	-	29	-	-
	P5.0.Z.PH		1114	330	16	13	11	-	-	-	20	16	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	674	200	24	20	17	-	-	-	24	20	17	-	-	-	10	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	M1.0.C.UT		674	200	24	20	17	-	-	-	24	20	17	-	-	-	10	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	674	200	24	20	17	-	-	-	24	20	17	-	-	-	10	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	M2.0.C.AQ		674	200	24	20	17	-	-	-	24	20	17	-	-	-	10	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	778	230	16	13	11	-	-	-	20	16	14	-	-	-	6	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	M3.1.C.AQ		778	230	16	13	11	-	-	-	20	16	14	-	-	-	6	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	K2.3.C.UT		867	260	16	13	11	-	-	-	20	16	14	-	-	-	6	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K1.1.C.NS	Temperguss	674	200	-	-	-	-	-	-	96	79	67	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K2.1.C.UT	Grauguss	602	180	-	-	-	-	-	-	80	66	56	-	-	-	11	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K2.2.C.UT		825	245	-	-	-	-	-	-	64	52	45	-	-	-	5	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K2.3.C.UT		591	175	-	-	-	-	-	-	96	79	67	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K3.1.C.UT	Kugelgraphitguss	518	155	-	-	-	-	-	-	96	79	67	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K3.2.C.UT		727	215	-	-	-	-	-	-	96	79	67	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K3.3.C.UT		885	265	-	-	-	-	-	-	96	79	67	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K3.5.C.UT		639	190	-	-	-	-	-	-	96	79	67	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	-	-	-	-	-	-	64	52	45	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	-	-	-	140	115	98	-	-	-	37	-	-	43	-	-	37	-	-	43	-	-	37	-	-	43	-	-
	N1.2.Z.AG		-	100	-	-	-	140	115	98	-	-	-	37	-	-	43	-	-	37	-	-	43	-	-	37	-	-	43	-	-
	N1.3.C.UT		-	75	-	-	-	140	115	98	-	-	-	37	-	-	43	-	-	37	-	-	43	-	-	37	-	-	43	-	-
	N1.3.C.AG		-	90	-	-	-	80	66	56	-	-	-	18	-	-	24	-	-	18	-	-	24	-	-	18	-	-	24	-	-
	N1.4.C.NS		-	130	-	-	-	60	49	42	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	N3.3.U.UT	Kupferbasislegierungen	-	110	-	-	-	-	-	-	181	148	126	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	N3.1.U.UT		-	100	-	-	-	-	-	-	72	59	51	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

CoroTap - Universell

CoroTap™ 300

Zoll-Werte

			ULDR(xTD)	T300-XM								
				Sorte B110/C110			Sorte B145*/C145			Sorte B150/C150		
				ULDR			ULDR			ULDR		
ISO	MC-Nr.	Werkstoff	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		
P		Unlegierter Stahl		1.5	2	3	1.5	2	3	1.5	2	3
	P1.1.Z.AN		125	140	115	98	100	82	70	100	82	70
	P1.1.Z.HT		190	134	110	94	88	72	62	88	72	62
	P1.2.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.2.Z.HT		210	102	84	72	64	52	45	64	52	45
	P1.3.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.3.Z.HT		300	70	57	49	40	33	28	40	33	28
	P2.1.Z.AN	Niedriglegierter Stahl	175	126	103	88	72	59	51	72	59	51
	P2.2.Z.AN		240	102	84	72	64	52	45	64	52	45
	P2.3.Z.AN		260	70	57	49	40	33	28	40	33	28
	P2.5.Z.HT.1		285	70	57	49	40	33	28	40	33	28
	P3.0.Z.AN	Hochlegierter Stahl	200	102	84	72	64	52	45	64	52	45
	P3.0.Z.HT.1		380	20	16	14	20	16	14	20	16	14
	P3.1.Z.AN		250	102	84	72	64	52	45	64	52	45
	P1.5.C.UT	Stahlguss	150	126	103	88	72	59	51	72	59	51
	P2.6.C.UT		200	102	84	72	64	52	45	64	52	45
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	330	104	85	73	64	52	45	64	52	45
	P5.0.Z.PH		330	40	33	28	16	13	11	-	-	-
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	200	32	26	22	24	20	17	-	-	-
	M1.0.C.UT		230	32	26	22	24	20	17	-	-	-
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	200	32	26	22	24	20	17	-	-	-
	M2.0.C.AQ		260	32	26	22	24	20	17	-	-	-
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	200	20	16	14	16	13	11	-	-	-
	M3.2.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.1.C.AQ		230	20	16	14	16	13	11	-	-	-
	K1.1.C.NS	Temperguss	200	80	66	56	60	49	42	-	-	-
	K2.1.C.UT	Grauguss	180	74	61	52	60	49	42	-	-	-
K	K2.2.C.UT		245	52	43	36	32	26	22	-	-	-
	K2.3.C.UT		175	80	66	56	60	49	42	-	-	-
	K3.1.C.UT	Kugelgraphitguss	155	80	66	56	60	49	42	-	-	-
	K3.2.C.UT		215	80	66	56	60	49	42	-	-	-
	K3.3.C.UT		265	80	66	56	60	49	42	-	-	-
	K3.5.C.UT		190	80	66	56	60	49	42	-	-	-
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	300	52	43	36	32	26	22	-	-	-
	N1.2.Z.UT	Aluminiumbasislegierungen	60	161	131	112	-	-	-	140	115	98
	N1.2.Z.AG		100	161	131	112	-	-	-	140	115	98
N	N1.3.C.UT		75	161	131	112	-	-	-	140	115	98
	N1.3.C.AG		90	100	82	70	-	-	-	80	66	56
	N1.4.C.NS		130	70	57	49	-	-	-	60	49	42
	N3.3.U.UT	Kupferbasislegierungen	110	-	-	-	-	-	-	-	-	-
	N3.1.U.UT		100	-	-	-	-	-	-	-	-	-
	S1.0.U.AN	Eisenbasissuperlegierungen	200	30	25	21	-	-	-	20	16	14
	S2.0.Z.UT	Nickelbasissuperlegierungen	275	30	25	21	-	-	-	20	16	14
	S2.0.Z.AN		250	30	25	21	-	-	-	20	16	14
	S2.1.Z.AN		125	74	61	52	-	-	-	48	39	34
S	S4.1.Z.UT	Titanbasislegierungen	200	70	57	49	-	-	-	60	49	42

* Hinweis! Empfehlungen zu Schnittgeschwindigkeiten für T300-XM100AL und T300-XM100AM, siehe Seite C168

B

C

D

E

CoroTap - Universell

CoroTap™ 400

Metrische Werte

					E301			E890 E891 E892 E893 E091 E096 E097 E099			E302 E305 E306 E308 E309 E310 E315 E317 E323			T115 T116		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min			vc m/min			vc m/min			vc m/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	18	15	13	33	27	23	33	27	23	73	60	51
	P1.1.Z.HT		639	190	16	13	11	30	25	21	30	25	21	73	60	51
	P1.2.Z.AN		639	190	14	11	10	27	22	19	27	22	19	73	60	51
	P1.2.Z.HT		708	210	12	10	8	24	20	17	24	20	17	49	40	34
	P1.3.Z.AN		639	190	14	11	10	27	22	19	27	22	19	73	60	51
	P1.3.Z.HT		1013	300	-	-	-	12	10	8	12	10	8	37	30	26
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	14	11	10	27	22	19	27	22	19	73	60	51
	P2.2.Z.AN		811	240	12	10	8	24	20	17	24	20	17	49	40	34
	P2.3.Z.AN		867	260	-	-	-	12	10	8	12	10	8	37	30	26
	P2.5.Z.HT.1		961	285	-	-	-	12	10	8	12	10	8	37	30	26
	P3.0.Z.AN	Hochlegierter Stahl	674	200	12	10	8	24	20	17	24	20	17	49	40	34
	P3.0.Z.HT.1		1282	380	-	-	-	-	-	-	-	-	-	-	-	-
	P3.1.Z.AN		839	250	12	10	8	24	20	17	24	20	17	49	40	34
	P1.5.C.UT	Stahlguss	503	150	14	11	10	27	22	19	27	22	19	73	60	51
	P2.6.C.UT		674	200	12	10	8	24	20	17	24	20	17	49	40	34
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	12	10	8	24	20	17	24	20	17	49	40	34
	P5.0.Z.PH		1114	330	-	-	-	6	5	4	12	5	4	31	25	21
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	674	200	-	-	-	9	7	6	9	7	6	31	25	21
	M1.0.C.UT		674	200	-	-	-	9	7	6	9	7	6	31	25	21
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	961	200	-	-	-	9	7	6	9	7	6	31	25	21
	M2.0.C.AQ		674	200	-	-	-	9	7	6	9	7	6	31	25	21
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	674	230	-	-	-	6	5	4	6	5	4	31	25	21
	M3.1.C.AQ		778	230	-	-	-	6	5	4	6	5	4	31	25	21
	M3.2.Z.AQ		867	260	-	-	-	6	5	4	6	5	4	31	25	21
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	46	38	33	67	55	47	67	55	47	98	80	68
	N1.2.Z.AG		-	100	46	38	33	67	55	47	67	55	47	98	80	68
	N1.3.C.UT		-	75	46	38	33	67	55	47	67	55	47	98	80	68
	N1.3.C.AG		-	90	27	22	19	49	40	34	49	40	34	98	80	68
	N1.4.C.NS		-	130	-	-	-	31	25	21	31	25	21	-	-	-
	N3.1.U.UT	Kupferbasislegierungen	-	100	-	-	-	31	25	21	31	25	21	49	40	34

CoroTap - Universell

CoroTap™ 400

Zoll-Werte

					E301			E890 E891 E892 E893 E091 E096 E097 E099			E302 E305 E306 E308 E309 E310 E317 E323			T115 T116		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	60	49	42	110	90	77	110	90	77	241	197	168
	P1.1.Z.HT		639	190	54	44	38	100	82	70	100	82	70	241	197	168
	P1.2.Z.AN		639	190	46	37	32	90	74	63	90	74	63	241	197	168
	P1.2.Z.HT		708	210	40	33	28	80	65	56	80	115	56	161	131	112
	P1.3.Z.AN		639	190	46	37	32	90	74	63	90	74	63	241	197	168
	P1.3.Z.HT		1013	300	-	-	-	40	33	28	40	33	28	120	98	84
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	46	37	32	90	74	63	90	74	63	241	197	168
	P2.2.Z.AN		811	240	40	33	28	80	65	56	80	115	56	161	131	112
	P2.3.Z.AN		867	260	-	-	-	40	33	28	40	33	28	120	98	84
	P2.5.Z.HT.1		961	285	-	-	-	40	33	28	40	33	28	120	98	84
	P3.0.Z.AN	Hochlegierter Stahl	674	200	40	33	28	80	65	56	80	115	56	161	131	112
	P3.0.Z.HT.1		1282	380	-	-	-	-	-	-	-	-	-	-	-	-
	P3.1.Z.AN		839	250	40	33	28	80	65	56	80	115	56	161	131	112
	P1.5.C.UT	Stahlguss	503	150	46	37	32	90	74	63	90	74	63	241	197	168
	P2.6.C.UT		674	200	40	33	28	80	65	56	80	115	56	161	131	112
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	40	33	28	80	65	56	80	115	56	161	131	112
	P5.0.Z.PH		1114	330	-	-	-	20	16	14	20	16	14	100	82	70
M	M1.0.Z.AQ	Austenitischer rostfreier Stahl	674	200	-	-	-	30	24	21	30	24	21	100	82	70
	M1.0.C.UT		674	200	-	-	-	30	24	21	30	24	21	100	82	70
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	961	200	-	-	-	30	24	21	30	24	21	100	82	70
	M2.0.C.AQ		674	200	-	-	-	30	24	21	30	24	21	100	82	70
	M3.1.Z.AQ	Rostfreie (austenitische/ferritische) Duplex-Stähle	674	230	-	-	-	20	16	14	20	16	14	100	82	70
	M3.1.C.AQ		778	230	-	-	-	20	16	14	20	16	14	100	82	70
N	M3.2.Z.AQ		867	260	-	-	-	20	16	14	20	16	14	100	82	70
	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	152	125	107	221	180	154	221	180	154	321	262	225
	N1.2.Z.AG		-	100	152	125	107	221	180	154	221	180	154	321	262	225
	N1.3.C.UT		-	75	152	125	107	221	180	154	221	180	154	321	262	225
	N1.3.C.AG		-	90	88	72	62	161	131	112	161	131	112	321	262	225
	N1.4.C.NS		-	130	-	-	-	100	82	70	100	82	70	321	262	225
	N3.1.U.UT	Kupferbasislegierungen	-	100	-	-	-	100	82	70	100	82	70	161	131	112

B

C

D

E

CoroTap - Optimiert

CoroTap™ 100 KM

Metrische Werte

					T100-KM		
ULDR(xTD)					1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min		
P	P2.1.Z.AN	Niedriglegierter Stahl	591	175	15	12	10
K	K1.1.C.NS	Temperguss	674	200	73	60	51
	K1.2.C.NS		1076	260	73	60	51
	K2.1.C.UT	Grauguss	602	180	73	60	51
	K2.2.C.UT		825	245	61	50	43
	K2.3.C.UT		591	175	73	60	51
	K3.1.C.UT	Kugelgraphitguss	518	155	73	60	51
	K3.2.C.UT		727	215	73	60	51
	K3.3.C.UT		885	265	61	50	43
	K3.4.C.UT		1114	330	49	40	34
	K3.5.C.UT		639	190	61	50	43
	K4.1.C.UT	Vermiculargraphitguss	533	160	55	45	38
	K4.2.C.UT		778	230	55	45	38
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	12	10	9
N	N1.3.C.UT	Aluminiumbasislegierungen	-	75	55	45	38

Zoll-Werte

					T100-KM		
ULDR(xTD)					1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc Fuß/min		
P	P2.1.Z.AN	Niedriglegierter Stahl	591	175	48	39	34
K	K1.1.C.NS	Temperguss	674	200	241	197	168
	K1.2.C.NS		1076	260	241	197	168
	K2.1.C.UT	Grauguss	602	180	241	197	168
	K2.2.C.UT		825	245	201	164	140
	K2.3.C.UT		591	175	241	197	168
	K3.1.C.UT	Kugelgraphitguss	518	155	241	197	168
	K3.2.C.UT		727	215	241	197	168
	K3.3.C.UT		885	265	201	164	140
	K3.4.C.UT		1114	330	161	131	112
	K3.5.C.UT		639	190	201	164	140
	K4.1.C.UT	Vermiculargraphitguss	533	160	181	148	126
	K4.2.C.UT		778	230	181	148	126
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	40	33	28
N	N1.3.C.UT	Aluminiumbasislegierungen	-	75	181	148	126

CoroTap - Optimiert

CoroTap™ 100

Metrische Werte

					E416		T101 T120		
ULDR(xTD)					1.5	2	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min		vc m/min		
K	K1.1.C.NS	Temperguss	674	200	18	15	79	65	55
	K2.1.C.UT	Grauguss	602	180	18	15	79	65	55
	K2.2.C.UT		825	245	10	8	63	52	44
	K2.3.C.UT		591	175	18	15	79	65	55
	K3.1.C.UT	Kugelgraphitguss	518	155	18	15	79	65	55
	K3.2.C.UT		727	215	18	15	79	65	55
	K3.3.C.UT		885	265	18	15	63	52	44
	K3.5.C.UT		639	190	18	15	63	52	44
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	10	8	16	13	11

					T100-NM					
ULDR(xTD)					1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min			vc m/min		
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	43	35	30	43	35	30
	N1.2.Z.AG		-	100	43	35	30	43	35	30
	N1.3.C.UT		-	75	43	35	30	43	35	30
	N1.3.C.AG		-	90	24	20	17	24	20	17
	N1.4.C.NS		-	130	18	15	13	18	15	13

Zoll-Werte

					E416		T101 T120		
ULDR(xTD)					1.5	2	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc Fuß/min		vc Fuß/min		
K	K1.1.C.NS	Temperguss	674	200	60	49	260	215	180
	K2.1.C.UT	Grauguss	602	180	60	49	260	215	180
	K2.2.C.UT		825	245	32	26	205	170	145
	K2.3.C.UT		591	175	60	49	260	215	180
	K3.1.C.UT	Kugelgraphitguss	518	155	60	49	260	215	180
	K3.2.C.UT		727	215	60	49	260	215	180
	K3.3.C.UT		885	265	60	49	205	170	145
	K3.5.C.UT		639	190	60	49	205	170	145
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	32	26	52	43	36

					T100-NM					
ULDR(xTD)					1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc Fuß/min			vc Fuß/min		
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	140	115	98	140	115	98
	N1.2.Z.AG		-	100	140	115	98	140	115	98
	N1.3.C.UT		-	75	140	115	98	140	115	98
	N1.3.C.AG		-	90	80	66	56	80	66	56
	N1.4.C.NS		-	130	60	49	42	60	49	42

CoroTap - Optimiert

CoroTap™ 200

Metrische Werte

					E324 E326 E854 E855 E874 E875			EP03P EP03PA EP13P EP13PA EP23PA EP33PA			EP09P EP29PA EP39PA		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min			vc m/min			vc m/min		
P	P1.1.Z.HT	Unlegierter Stahl	639	190	-	-	-	55	45	38	55	45	38
	P1.2.Z.AN		639	190	-	-	-	55	45	38	55	45	38
	P1.2.Z.HT		708	210	-	-	-	43	35	30	55	45	38
	P1.3.Z.AN		639	190	-	-	-	55	45	38	55	45	38
	P1.3.Z.HT		1013	300	21	17	15	31	25	21	43	35	30
	P1.5.C.UT		503	150	-	-	-	55	45	38	55	45	38
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	-	-	-	55	45	38	55	45	38
	P2.2.Z.AN		811	240	-	-	-	43	35	30	55	45	38
	P2.3.Z.AN		867	260	21	17	15	31	25	21	43	35	30
	P2.5.Z.HT.1		961	285	21	17	15	31	25	21	43	35	30
	P2.6.C.UT		674	200	-	-	-	43	35	30	55	45	38
	P3.0.Z.AN	Hochlegierter Stahl	674	200	-	-	-	43	35	30	55	45	38
	P3.0.Z.HT.1		1282	380	13	11	9	-	-	-	-	-	-
	P3.1.Z.AN		839	250	-	-	-	43	35	30	55	45	38
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	-	-	-	43	35	30	55	45	38

					E344 E345 E364			E454 E455 E852 E872 E873		
ULDR(xTD)					1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min			vc m/min		
P	P1.3.Z.HT	Unlegierter Stahl	1013	300	12	10	9	21	17	15
	P2.3.Z.AN	Niedriglegierter Stahl	867	260	12	10	9	21	17	15
	P2.5.Z.HT.1		1114	285	12	10	9	21	17	15
	P3.0.Z.HT.1	Hochlegierter Stahl	1282	380	6	5	4	13	11	9
	P5.0.Z.PH	Ferritisch/martensitischer rostfreier Stahl	1112	330	6	5	4	7	6	5
M	M1.0.C.UT	Austenitischer rostfreier Stahl	674	200	9	7	6	12	10	9
	M1.0.Z.AQ		674	200	9	7	6	12	10	9
	M1.0.Z.PH		1013	300	6	5	4	7	6	5
	M2.0.C.AQ	Super austenitischer rostfreier Stahl	674	200	9	7	6	12	10	9
	M2.0.Z.AQ		674	200	9	7	6	12	10	9
	M3.1.Z.AQ	Rostfreier Duplex-Stahl	778	230	6	5	4	7	6	5
	M3.2.Z.AQ		867	260	6	5	4	7	6	5
	M3.1.C.AQ		778	230	6	5	4	7	6	5
	M3.2.C.AQ		867	260	6	5	4	7	6	5

					T200-NM B150			T200-NM B125			T200-NM D150		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min			vc m/min			vc m/min		
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	43	35	30	55	45	38	43	35	30
	N1.2.Z.AG		-	100	43	35	30	55	45	38	43	35	30
	N1.3.C.UT		-	75	43	35	30	55	45	38	43	35	30
	N1.3.C.AG		-	90	24	20	17	37	30	26	24	20	17
	N1.4.C.NS		-	130	18	15	13	24	20	17	18	15	13
	N3.3.U.UT	Kupferbasislegierungen	-	110	37	30	26	55	45	38	37	30	26
	N3.1.U.UT		-	100	15	12	10	22	18	15	15	12	10

CoroTap - Optimiert

CoroTap™ 200

Zoll-Werte

					E324 E326 E854 E855 E874 E875			EP03P EP03PA EP13P EP13PA EP23PA EP33PA			EP09P EP29PA EP39PA		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm ²	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		
P	P1.1.Z.HT	Unlegierter Stahl	639	190	-	-	-	181	148	126	181	148	126
	P1.2.Z.AN		639	190	-	-	-	181	148	126	181	148	126
	P1.2.Z.HT		708	210	-	-	-	140	115	98	181	148	126
	P1.3.Z.AN		639	190	-	-	-	181	148	126	181	148	126
	P1.3.Z.HT		1013	300	68	56	48	100	82	70	140	115	98
	P1.5.C.UT		503	150	-	-	-	181	148	126	181	148	126
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	-	-	-	181	148	126	181	148	126
	P2.2.Z.AN		811	240	-	-	-	140	115	98	181	148	126
	P2.3.Z.AN		867	260	68	56	48	100	82	70	140	115	98
	P2.5.Z.HT.1		961	285	68	56	48	100	82	70	140	115	98
	P2.6.C.UT		674	200	-	-	-	140	115	98	181	148	126
	P3.0.Z.AN	Hochlegierter Stahl	674	200	-	-	-	140	115	98	181	148	126
	P3.0.Z.HT.1		1282	380	44	36	31	-	-	-	-	-	-
	P3.1.Z.AN		839	250	-	-	-	140	115	98	181	148	126
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	-	-	-	140	115	98	181	148	126

					E344 E345 E364			E454 E455 E852 E872 E873		
ULDR(xTD)					1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm ²	HB	v _c Fuß/min			v _c Fuß/min		
P	P1.3.Z.HT	Unlegierter Stahl	1013	300	40	33	28	68	56	48
	P2.3.Z.AN	Niedriglegierter Stahl	867	260	40	33	28	68	56	48
	P2.5.Z.HT.1		1114	285	40	33	28	68	56	48
	P3.0.Z.HT.1	Hochlegierter Stahl	1282	380	20	16	14	44	36	31
	P5.0.Z.PH	Ferritisch/martensitischer rostfreier Stahl	1112	330	20	16	14	24	20	17
M	M1.0.C.UT	Austenitischer rostfreier Stahl	674	200	28	23	20	40	33	28
	M1.0.Z.AQ		674	200	28	23	20	40	33	28
	M1.0.Z.PH		1013	300	20	16	14	24	20	17
	M2.0.Z.AQ	Super austenitischer rostfreier Stahl	778	200	28	23	20	40	33	28
	M2.0.C.AQ		867	200	28	23	20	40	33	28
	M3.1.Z.AQ	Rostfreier Duplex-Stahl	674	200	20	16	14	24	20	17
	M3.2.Z.AQ		674	200	20	16	14	24	20	17
	M3.1.C.AQ		778	230	20	16	14	24	20	17
	M3.2.C.AQ		867	260	20	16	14	24	20	17

					T200-NM B150			T200-NM B125			T200-NM D150		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm ²	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	140	115	98	181	148	126	140	115	98
	N1.2.Z.AG		-	100	140	115	98	181	148	126	140	115	98
	N1.3.C.UT		-	75	140	115	98	181	148	126	140	115	98
	N1.3.C.AG		-	90	80	66	56	120	98	84	80	66	56
	N1.4.C.NS		-	130	60	49	42	80	66	56	60	49	42
	N3.3.U.UT	Kupferbasislegierungen	-	110	120	98	84	181	148	126	120	98	84
	N3.1.U.UT		-	100	48	39	34	72	59	51	48	39	34

CoroTap - Optimiert

CoroTap™ 200

Metrische Werte

ULDR				T200-SD	
				1.5	2
ISO	MC-Code	Werkstoff	HB	v _c m/min	
S	S1.0.U.AN	Warmfeste Superlegierungen	200	7	6
	S1.0.U.AG		280	5	4
	S2.0.Z.AN	Ni-basierte Legierungen	250	7	6
	S2.0.Z.AG		350	2	2
	S2.0.Z.UT		275	5	4
	S2.0.C.NS		320	5	4
	S3.0.Z.AN	Kobaltbasislegierungen	200	5	4
	S3.0.Z.AG		300	2	2
	S3.0.C.NS		320	5	4

Zoll-Werte

ULDR				T200-SD	
				1.5	2
ISO	MC-Code	Werkstoff	HB	v _c Fuß/min	
S	S1.0.U.AN	Warmfeste Superlegierungen	200	23	20
	S1.0.U.AG		280	17	14
	S2.0.Z.AN	Ni-basierte Legierungen	250	23	20
	S2.0.Z.AG		350	7	7
	S2.0.Z.UT		275	17	14
	S2.0.C.NS		320	17	14
	S3.0.Z.AN	Kobaltbasislegierungen	200	17	14
	S3.0.Z.AG		300	7	7
	S3.0.C.NS		320	17	14

CoroTap - Optimiert für spezifische Werkstoffe

Metrische Werte

ULDR				T200-SM	
				1.5	2
ISO	MC-Code	Werkstoff	HB	v _c m/min	
S	S4.1.Z.UT	Titanbasislegierungen	200	7	6
	S4.2.Z.AN		320	7	6
	S4.3.Z.AN		330	5	4
	S4.3.Z.AG		375	5	4
	S4.4.Z.AN		330	5	4
	S4.4.Z.AG		410	5	4

Zoll-Ausführung

ULDR				T200-SM	
				1.5	2
ISO	MC-Code	Werkstoff	HB	Fuß m/min	
S	S4.1.Z.UT	Titanbasislegierungen	200	23	20
	S4.2.Z.AN		320	23	20
	S4.3.Z.AN		330	17	14
	S4.3.Z.AG		375	17	14
	S4.4.Z.AN		330	17	14
	S4.4.Z.AG		410	17	14

CoroTap - Optimiert

CoroTap™ 300

Metrische Werte

					E314 E316 E864 E865 E884 E885			EX03P EX03PA EX13P EX13PA EX23PA EX33PA			EX09P EX29PA EX39PA		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min			vc m/min			vc m/min		
P	P1.1.Z.HT	Unlegierter Stahl	639	190	-	-	-	49	40	34	55	45	38
	P1.2.Z.AN		639	190	-	-	-	49	40	34	55	45	38
	P1.2.Z.HT		708	210	-	-	-	37	30	26	49	40	34
	P1.3.Z.AN		639	190	-	-	-	49	40	34	55	45	38
	P1.3.Z.HT		1013	300	21	17	15	24	20	17	37	30	26
	P1.5.C.UT		503	150	-	-	-	49	40	34	55	45	38
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	-	-	-	49	40	34	55	45	38
	P2.2.Z.AN		811	240	-	-	-	37	30	26	49	40	34
	P2.3.Z.AN		867	260	21	17	15	24	20	17	37	30	26
	P2.5.Z.HT.1		961	285	21	17	15	24	20	17	37	30	26
	P2.6.C.UT		674	200	-	-	-	37	30	26	49	40	34
	P3.0.Z.AN	Hochlegierter Stahl	674	200	-	-	-	37	30	26	49	40	34
	P3.0.Z.HT.1		1282	380	13	11	9	-	-	-	-	-	-
	P3.1.Z.AN		839	250	-	-	-	37	30	26	49	40	34
	P5.0.Z.HT.1	Ferritisch/martensitischer rostfreier Stahl	1114	330	-	-	-	37	30	26	49	40	34

					E047			E404 E862 E882 E883 E048			E346 E347 E362 E363 E095			E069 E079			E736 E738	
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2		1.5	2	3	1.5	
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min			vc m/min			vc m/min			vc m/min			vc m/min	
P	P1.3.Z.HT	Unlegierter Stahl	1013	300	12	10	9	16	13	11	12	10		12	10	9	-	
	P2.3.Z.AN	Niedriglegierter Stahl	867	260	12	10	9	16	13	11	12	10		12	10	9	-	
	P2.5.Z.HT.1		1114	285	12	10	9	16	13	11	12	10		12	10	9	-	
	P3.0.Z.HT.1	Hochlegierter Stahl	1282	380	6	5	4	13	11	9	6	5		6	5	4	-	
	P5.0.Z.PH	Ferritisch/martensitischer rostfreier Stahl	1114	330	6	5	4	7	6	5	6	5		5	4	3	4	
M	M1.0.C.UT	Austenitischer rostfreier Stahl	674	200	9	7	6	12	10	9	9	7		7	6	5	4	
	M1.0.Z.AQ		674	200	9	7	6	12	10	9	9	7		7	6	5	4	
	M1.0.Z.PH		1013	300	6	5	4	7	6	5	6	5		-	-	-	-	
	M2.0.C.AQ	Super austenitischer rostfreier Stahl	674	200	9	7	6	12	10	9	9	7		7	6	5	4	
	M2.0.Z.AQ		674	200	9	7	6	12	10	9	9	7		7	6	5	4	
	M3.1.Z.AQ	Rostfreier Duplex-Stahl	778	230	6	5	4	7	6	5	6	5		5	4	3	4	
	M3.2.Z.AQ		867	260	6	5	4	7	6	5	6	5		5	4	3	4	
	M3.1.C.AQ		778	230	6	5	4	7	6	5	6	5		5	4	3	4	
	M3.2.C.AQ		867	260	6	5	4	7	6	5	6	5		5	4	3	4	

CoroTap - Optimiert

CoroTap™ 300

Zoll-Werte

					E314 E316 E864 E865 E884 E885			EX03P EX03PA EX13P EX13PA EX23PA EX33PA			EX09P EX29PA EX39PA		
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	-	-	-	-	-	-	-	-	-
	P1.1.Z.HT		639	190	-	-	-	161	131	112	181	148	126
	P1.2.Z.AN		639	190	-	-	-	161	131	112	181	148	126
	P1.2.Z.HT		708	210	-	-	-	120	98	84	161	131	112
	P1.3.Z.AN		639	190	-	-	-	161	131	112	181	148	126
	P1.3.Z.HT		1013	300	68	56	48	80	66	56	120	98	84
	P1.5.C.UT		503	150	-	-	-	161	131	112	181	148	126
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	-	-	-	161	131	112	181	148	126
	P2.2.Z.AN		811	240	-	-	-	120	98	84	161	131	112
	P2.3.Z.AN		867	260	68	56	48	80	66	56	120	98	84
	P2.5.Z.HT.1		961	285	68	56	48	80	66	56	120	98	84
	P2.6.C.UT		674	200	-	-	-	120	98	84	161	131	112
	P3.0.Z.AN	Hochlegierter Stahl	674	200	-	-	-	120	98	84	161	131	112
	P3.0.Z.HT.1		1282	380	44	36	31	-	-	-	-	-	-
	P3.1.Z.AN		839	250	-	-	-	120	98	84	161	131	112
	P5.0.Z.AN	Ferritisch/martensitischer rostfreier Stahl	674	200	-	-	-	-	-	-	-	-	-
	P5.0.Z.PH		1114	330	-	-	-	-	-	-	-	-	-
	P5.0.Z.HT.1		1114	330	-	-	-	120	98	84	161	131	112
	P5.0.C.UT		839	200	-	-	-	-	-	-	-	-	-
	P5.0.C.HT		1114	330	-	-	-	-	-	-	-	-	-

					E047			E404 E862 E882 E883 E048			E346 E347 E362 E363 E095		E069 E079			E736 E738	
ULDR(xTD)					1.5	2	3	1.5	2	3	1.5	2	1.5	2	3	1.5	
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		v _c Fuß/min			v _c Fuß/min	
P	P1.3.Z.HT	Unlegierter Stahl	1013	300	40	33	28	52	43	36	40	33	40	33	28	-	
	P2.3.Z.AN	Niedriglegierter Stahl	867	260	40	33	28	52	43	36	40	33	40	33	28	-	
	P2.5.Z.HT.1		1114	285	40	33	28	52	43	36	40	33	40	33	28	-	
	P3.0.Z.HT.1	Hochlegierter Stahl	1282	380	20	16	14	44	36	31	20	16	20	16	14	-	
	P5.0.Z.PH	Ferritisch/martensitischer rostfreier Stahl	1114	330	20	16	14	24	20	17	20	16	16	13	11	12	
M	M1.0.C.UT	Austenitischer rostfreier Stahl	674	200	28	23	20	40	33	28	28	23	24	20	17	12	
	M1.0.Z.AQ		674	200	28	23	20	40	33	28	28	23	24	20	17	12	
	M1.0.Z.PH		1013	300	20	16	14	24	20	17	20	16	-	-	-	-	
	M2.0.C.AQ	Super austenitischer rostfreier Stahl	674	200	28	23	20	40	33	28	28	23	24	20	17	12	
	M2.0.Z.AQ		674	200	28	23	20	40	33	28	28	23	24	20	17	12	
	M3.1.Z.AQ	Rostfreier Duplex-Stahl	778	230	20	16	14	24	20	17	20	16	16	13	11	12	
	M3.2.Z.AQ		867	260	20	16	14	24	20	17	20	16	16	13	11	12	
	M3.1.C.AQ		778	230	20	16	14	24	20	17	20	16	16	13	11	12	
	M3.2.C.AQ		867	260	20	16	14	24	20	17	20	16	16	13	11	12	

CoroTap - Optimiert

CoroTap™ 300

Metrische Werte

ISO	MC-Nr.	Werkstoff	N/mm²	HB	T105		T106		
					ULDR(xTD)		1.5	2	3
K	K1.1.C.NS	Temperguss	674	200	vc m/min		31	25	21
	K2.1.C.UT	Grauguss	602	180	vc m/min		49	40	34
	K2.2.C.UT		825	245	vc m/min		18	15	13
	K2.3.C.UT		591	175	vc m/min		31	25	21
	K3.1.C.UT	Kugelgraphitguss	518	155	vc m/min		31	25	21
	K3.2.C.UT		727	215	vc m/min		31	25	21
	K3.3.C.UT		885	265	vc m/min		31	25	21
	K3.5.C.UT		639	190	vc m/min		31	25	21
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	vc m/min		18	15	13

ISO	MC-Nr.	Werkstoff	N/mm²	HB	T300-NM D150			T300-NM D125			T300-NM B150		
					ULDR(xTD)			1.5	2	3	1.5	2	3
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	vc m/min			43	35	30	55	45	38
	N1.2.Z.AG		-	100	vc m/min			43	35	30	55	45	38
	N1.3.C.UT		-	75	vc m/min			43	35	30	55	45	38
	N1.3.C.AG		-	90	vc m/min			24	20	17	37	30	26
	N1.4.C.NS		-	130	vc m/min			18	15	13	24	20	17
	N3.3.U.UT	Kupferbasislegierungen	-	110	vc m/min			15	12	10	22	18	15
	N3.1.U.UT		-	100	vc m/min			15	12	10	22	18	15

CoroTap - Optimiert

CoroTap™ 300

Zoll-Werte

					T105		T106		
					ULDR(xTD)		1,5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c Fuß/min		v _c Fuß/min		
K	K1.1.C.NS	Temperguss	674	200	100	82	100	82	70
	K2.1.C.UT	Grauguss	602	180	161	131	161	131	112
	K2.2.C.UT		825	245	60	49	60	49	42
	K2.3.C.UT		591	175	100	82	100	82	70
	K3.1.C.UT	Kugelgraphitguss	518	155	100	82	100	82	70
	K3.2.C.UT		727	215	100	82	100	82	70
	K3.3.C.UT		885	265	100	82	100	82	70
	K3.5.C.UT		639	190	100	82	100	82	70
	K5.1.C.NS	Austenitisch-bainitisches Gusseisen	1013	300	60	49	60	49	42

					T300-NM D150			T300-NM D125			T300-NM B150		
					ULDR(xTD)			1,5	2	3	1,5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c Fuß/min			v _c Fuß/min			v _c Fuß/min		
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	140	115	98	181	148	126	140	115	98
	N1.2.Z.AG		-	100	140	115	98	181	148	126	140	115	98
	N1.3.C.UT		-	75	140	115	98	181	148	126	140	115	98
	N1.3.C.AG		-	90	80	66	56	120	98	84	80	66	56
	N1.4.C.NS		-	130	60	49	42	80	66	56	-	-	-
	N3.3.U.UT	Kupferbasislegierungen	-	110	120	98	84	181	148	126	-	-	-
	N3.1.U.UT		-	100	48	39	34	72	59	51	48	39	34

CoroTap - Optimiert

CoroTap™ 300

Metrische Werte

ULDR				T300-SD	
				1.5	
ISO	MC-Nr.	Werkstoff	HB	vc m/min	
S	S1.0.U.AN	Warmfeste Superlegierungen	200	7	
	S1.0.U.AG		280	5	
	S2.0.Z.AN	Nickelbasislegierungen	250	5	
	S2.0.Z.AG		350	3	
	S2.0.Z.UT		275	5	
	S2.0.C.NS		320	3	

Zoll-Ausführung

ULDR				T300-SD	
				1.5	
ISO	MC-Nr.	Werkstoff	HB	Fuß m/min	
S	S1.0.U.AN	Warmfeste Superlegierungen	200	23	
	S1.0.U.AG		280	17	
	S2.0.Z.AN	Nickelbasislegierungen	250	17	
	S2.0.Z.AG		350	10	
	S2.0.Z.UT		275	17	
	S2.0.C.NS		320	10	

Metrische Werte

ULDR				T300-SM	
				1.5	2
ISO	MC-Nr.	Werkstoff	HB	vc m/min	
S	S4.1.Z.UT	Titanbasislegierungen	200	10	8
	S4.2.Z.AN		320	6	5
	S4.3.Z.AN		330	6	5
	S4.3.Z.AG		375	5	4
	S4.4.Z.AN		330	5	4
	S4.4.Z.AG		410	5	4

Zoll-Ausführung

ULDR				T300-SM	
				1.5	2
ISO	MC-Nr.	Werkstoff	HB	Fuß m/min	
S	S4.1.Z.UT	Titanbasislegierungen	200	33	27
	S4.2.Z.AN		320	20	17
	S4.3.Z.AN		330	20	17
	S4.3.Z.AG		375	17	14
	S4.4.Z.AN		330	17	14
	S4.4.Z.AG		410	17	14

CoroTap - Optimiert

CoroTap™ 400

Metrische Werte

					T400-NM		
ULDR(xTD)					1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc m/min		
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	67	55	47
	N1.2.Z.AG		-	100	67	55	47
	N1.3.C.UT		-	75	67	55	47
	N1.3.C.AG		-	90	49	40	34
	N3.1.U.UT	Kupferbasislegierungen	-	100	31	25	21

Zoll-Werte

					T400-NM		
ULDR(xTD)					1.5	2	3
ISO	MC-Nr.	Werkstoff	N/mm²	HB	vc Fuß/min		
N	N1.2.Z.UT	Aluminiumbasislegierungen	-	60	221	180	154
	N1.2.Z.AG		-	100	221	180	154
	N1.3.C.UT		-	75	221	180	154
	N1.3.C.AG		-	90	161	131	112
	N3.1.U.UT	Kupferbasislegierungen	-	100	100	82	70

Metrische Werte

				ULDR (xTD)	T400-PM		
					1.5	2.0	3.0
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c m/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	40	33	28
	P1.1.Z.HT		639	190	36	30	26
	P1.2.Z.AN		639	190	33	27	23
	P1.2.Z.HT		708	210	29	24	21
	P1.3.Z.AN		639	190	33	27	23
	P1.3.Z.HT		1013	300	15	12	10
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	33	27	23
	P2.2.Z.AN		811	240	29	24	21
	P2.3.Z.AN		867	260	15	12	10
	P2.5.Z.HT.1		961	285	15	12	10
	P3.0.Z.AN	Hochlegierter Stahl	674	200	29	24	21
	P3.1.Z.AN		839	250	29	24	21
	P1.5.C.UT	Stahlguss	503	150	33	27	23
	P2.6.C.UT		674	200	29	24	21
	P1.5.C.UT	Ferritisch/martensitischer rostfreier Stahl	1114	330	29	24	21
	P2.6.C.UT		1114	330	8	6	5

Zoll-Werte

				ULDR (xTD)	T400-PM		
					1.5	2.0	3.0
ISO	MC-Nr.	Werkstoff	N/mm²	HB	v _c Fuß/min		
P	P1.1.Z.AN	Unlegierter Stahl	428	125	132	108	93
	P1.1.Z.HT		639	190	120	99	84
	P1.2.Z.AN		639	190	108	89	76
	P1.2.Z.HT		708	210	96	78	68
	P1.3.Z.AN		639	190	108	89	76
	P1.3.Z.HT		1013	300	48	40	34
	P2.1.Z.AN	Niedriglegierter Stahl	591	175	108	89	76
	P2.2.Z.AN		811	240	96	78	68
	P2.3.Z.AN		867	260	48	40	34
	P2.5.Z.HT.1		961	285	48	40	34
	P3.0.Z.AN	Hochlegierter Stahl	674	200	96	78	68
	P3.1.Z.AN		839	250	96	78	68
	P1.5.C.UT	Stahlguss	503	150	108	89	76
	P2.6.C.UT		674	200	96	78	68
	P1.5.C.UT	Ferritisch/martensitischer rostfreier Stahl	1114	330	96	78	68
	P2.6.C.UT		1114	330	24	20	17

Reiben



Universell

CoroReamer™ 435
Für Multimaterial

D2
D3-D4



Optimiert

CoroReamer™ 835
Für Stahlwerkstoffe
Für rostfreie Materialien

D5
D6-D7
D9-D10

CoroReamer™ 830
Vollhartmetall-Schneidkopf
Adapter

D11
D12
D13



Kundenspezifisch

E8

CoroReamer™ 435

Universelles, leistungsstarkes Reibwerkzeug für einen großen Werkstoffbereich geeignet

Vorteile und Merkmale

- Optimale Produktivität dank hoher Schnittparameter
- Konsistenz und Produktivität sparen Zeit und Kosten
- Exzellente Oberflächengüte des Werkstücks
- Hohe Wiederholgenauigkeit für lange Standzeit und beste Maßgenauigkeit
- Große Stabilität dank Vollhartmetallkörper
- Innere Kühlschmierstoffzufuhr für bessere Spanabfuhr und minimierten Verschleiß



ISO-Anwendungsbereich:



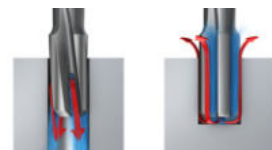
www.sandvik.coromant.com/cororeamer435

Universelle Werkzeuge gewährleisten eine hohe Leistung und optimale Prozesssicherheit bei einer Vielzahl von Werkstoffen, Anwendungen, Bauteilgrößen und -formen bei maximaler Maschinenauslastung.

Spankanalgeometrie mit ungleicher Teilung

Extrem ungleiche Teilung bedeutet, dass die Abstände zwischen jeder Schneide ungleichmäßig sind. Da sich dabei keine Zähne diametral gegenüberliegen, produziert die Reibahle eine Bohrung mit verbesserter Rundheit.

Durchgangs-
bohrung Grundbohrung



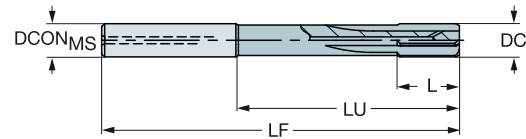
E14

CoroReamer™ 435 Vollhartmetall-Reibahle

Für Multimaterial-Anwendungen

Für Grundbohrungen

CNSC 1
CXSC 1
SUBSTRATE HF



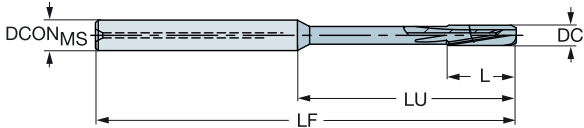
					P K N			Abmessungen, mm, Zoll															
DC	DC"	LU	LU"	CZC _{MS}	Bestellnummer	H ₁₀ F	H ₁₀ F	H ₁₀ F	DCON _{MS}	DCON _{MS} "	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
4.00	.157	39.00	1.535	6	435.B-0400-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.01	.158	39.00	1.535	6	435.B-0401-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.50	.177	39.00	1.535	6	435.B-0450-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.32	2.926	0.3	.012	4.30	.169	COROMANT
5.00	.197	39.00	1.535	6	435.B-0500-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.01	.197	39.00	1.535	6	435.B-0501-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
6.00	.236	39.00	1.535	6	435.B-0600-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.01	.237	39.00	1.535	6	435.B-0601-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
7.00	.276	64.00	2.520	8	435.B-0700-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
8.00	.315	64.00	2.520	8	435.B-0800-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.01	.315	64.00	2.520	8	435.B-0801-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.02	.316	64.00	2.520	8	435.B-0802-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
10.00	.394	80.00	3.150	10	435.B-1000-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	435.B-1001-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
12.00	.472	75.00	2.953	12	435.B-1200-A1-XF	★	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.03	.474	75.00	2.953	12	435.B-1203-A1-XF	★	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT
13.00	.512	85.00	3.346	14	435.B-1300-A1-XF	★	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT
14.00	.551	85.00	3.346	14	435.B-1400-A1-XF	★	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	435.B-1500-A1-XF	★	★	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	435.B-1600-A1-XF	★	★	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT
17.00	.669	102.00	4.016	18	435.B-1700-A1-XF	★	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.45	5.805	0.3	.012	16.80	.661	COROMANT
18.00	.709	102.00	4.016	18	435.B-1800-A1-XF	★	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT
20.00	.787	100.00	3.937	20	435.B-2000-A1-XF	★	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT

CoroReamer™ 435 Vollhartmetall-Reibahle

Für Multimaterial-Anwendungen

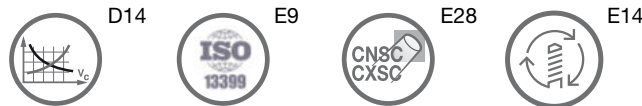
Für Durchgangsbohrungen

FHA 10°
CNSC 1
CXSC 2
SUBSTRATE HF



					Abmessungen, mm, Zoll																	
					P K N																	
					H10F H10F H10F																	
DC	DC*	LU	LU*	CZC _{MS}	Bestellnummer	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LCF	LCF*	L	L*	LF	LF*	APMX	APMX*	PHD	PHD*	BSG		
4.00	.157	39.00	1.535	6	435.T-0400-A1-XF	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT		
5.00	.197	39.00	1.535	6	435.T-0500-A1-XF	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT		
5.97	.235	39.00	1.535	6	435.T-0597-A1-XF	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT		
6.00	.236	39.00	1.535	6	435.T-0600-A1-XF	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT		
6.02	.237	39.00	1.535	6	435.T-0602-A1-XF	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT		
6.50	.256	64.00	2.520	8	435.T-0650-A1-XF	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	99.02	3.898	0.3	.012	6.30	.248	COROMANT		
7.00	.276	64.00	2.520	8	435.T-0700-A1-XF	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT		
8.00	.315	64.00	2.520	8	435.T-0800-A1-XF	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT		
9.00	.354	60.00	2.362	10	435.T-0900-A1-XF	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT		
9.50	.374	80.00	3.150	10	435.T-0950-A1-XF	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT		
9.98	.393	80.00	3.150	10	435.T-0998-A1-XF	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT		
10.00	.394	80.00	3.150	10	435.T-1000-A1-XF	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT		
10.01	.394	80.00	3.150	10	435.T-1001-A1-XF	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT		
10.02	.394	80.00	3.150	10	435.T-1002-A1-XF	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT		
11.00	.433	75.00	2.953	12	435.T-1100-A1-XF	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT		
11.97	.471	75.00	2.953	12	435.T-1197-A1-XF	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT		
12.00	.472	75.00	2.953	12	435.T-1200-A1-XF	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT		
13.00	.512	85.00	3.346	14	435.T-1300-A1-XF	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT		
14.00	.551	85.00	3.346	14	435.T-1400-A1-XF	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT		
15.00	.591	82.00	3.228	16	435.T-1500-A1-XF	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT		
16.00	.630	102.00	4.016	16	435.T-1600-A1-XF	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT		
17.00	.669	102.00	4.016	18	435.T-1700-A1-XF	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.45	5.805	0.3	.012	16.80	.661	COROMANT		
18.00	.709	102.00	4.016	18	435.T-1800-A1-XF	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT		
19.00	.748	100.00	3.937	20	435.T-1900-A1-XF	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	147.14	5.793	0.3	.012	18.80	.740	COROMANT		
20.00	.787	100.00	3.937	20	435.T-2000-A1-XF	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT		

Volle Durchmesser H7 Bohrungstoleranz
Durch die Abstufung im Hunderstel-Durchmesserbereich können bestimmte Toleranzbereiche eingehalten werden.
Fertigung erfolgt auf +0.004 mm.



CoroReamer™ 835

Hochleistungsreibahle für Stahl

Anwendungsbereich

- Für alle Industriebereiche, wie z.B. allgemeiner Maschinenbau, Formen- und Gesenkbau, Automobilindustrie, Energie- und Stromerzeugung
- Erhältlich mit spiralförmigem Spankanal für Durchgangsbohrungen und geradem Spankanal für Grundbohrungen
- Durchgangsbohrungen, schräge Flächen und Kreuzbohrung
- Kühlschmierstoffdruck 20 bar



ISO-Anwendungsbereich:



Vorteile und Merkmale

- Optimale Produktivität dank hoher Schnittparameter
- Konsistenz und Produktivität sparen Zeit und Kosten
- Exzellente Oberflächengüte des Werkstücks
- Hohe Rundlaufgenauigkeit für lange Standzeit und Maßgenauigkeit
- Große Stabilität dank Vollhartmetallkörper
- Innere Kühlschmierstoffzufuhr für bessere Spanabfuhr und weniger Verschleiß
- Feinkörniges Hartmetall für hohe Härte und Zähigkeit
- Spankanalgeometrie mit extrem ungleicher Teilung

www.sandvik.coromant.com/cororeamer835

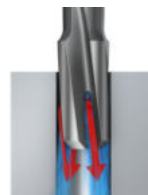
Spankanalgeometrie mit ungleicher Teilung

Extrem ungleiche Teilung bedeutet, dass die Abstände zwischen jeder Schneide ungleichmäßig sind. Da sich dabei keine Zähne diametral gegenüberliegen, produziert die Reibahle eine Bohrung mit verbesserter Rundheit.

Grundbohrung



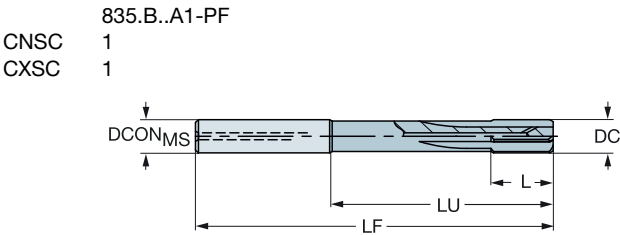
Durchgangsbohrung



E14

CoroReamer™ 835 Vollhartmetall-Reibahle

Für Stahlwerkstoffe
Für Grundbohrungen



						P	K	Abmessungen, mm, Zoll																
						1024	1024																	
DC	DC*	LU	LU*	CZC _{MS}	Bestellnummer			DCON _{MS}	DCON _{MS} *	OAL	OAL*	LCF	LCF*	L	L*	LF	LF*	APMX	APMX*	PHD	PHD*	BSG		
4.00	.157	39.00	1.535	6	835.B-0400-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT		
5.00	.197	39.00	1.535	6	835.B-0500-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT		
5.99	.236	39.00	1.535	6	835.B-0599-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT		
6.00	.236	39.00	1.535	6	835.B-0600-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT		
6.01	.237	39.00	1.535	6	835.B-0601-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT		
6.02	.237	39.00	1.535	6	835.B-0602-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT		
6.03	.237	39.00	1.535	6	835.B-0603-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.09	2.917	0.3	.012	5.80	.228	COROMANT		
7.00	.276	64.00	2.520	8	835.B-0700-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT		
7.97	.314	64.00	2.520	8	835.B-0797-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT		
7.98	.314	64.00	2.520	8	835.B-0798-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT		
7.99	.315	64.00	2.520	8	835.B-0799-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT		
8.00	.315	64.00	2.520	8	835.B-0800-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT		
8.02	.316	64.00	2.520	8	835.B-0802-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT		
9.00	.354	60.00	2.362	10	835.B-0900-A1-PF	★	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT		
9.50	.374	80.00	3.150	10	835.B-0950-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT		
9.97	.393	80.00	3.150	10	835.B-0997-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT		
10.00	.394	80.00	3.150	10	835.B-1000-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT		
10.01	.394	80.00	3.150	10	835.B-1001-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT		
10.02	.394	80.00	3.150	10	835.B-1002-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT		
10.03	.395	80.00	3.150	10	835.B-1003-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT		
10.50	.413	75.00	2.953	12	835.B-1050-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.42	4.662	0.3	.012	10.30	.406	COROMANT		
11.00	.433	75.00	2.953	12	835.B-1100-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT		
11.50	.453	75.00	2.953	12	835.B-1150-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.27	4.656	0.3	.012	11.30	.445	COROMANT		
11.97	.471	75.00	2.953	12	835.B-1197-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT		
11.99	.472	75.00	2.953	12	835.B-1199-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT		
12.00	.472	75.00	2.953	12	835.B-1200-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT		
12.01	.473	75.00	2.953	12	835.B-1201-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT		
12.02	.473	75.00	2.953	12	835.B-1202-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT		
13.00	.512	85.00	3.346	14	835.B-1300-A1-PF	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT		
14.00	.551	85.00	3.346	14	835.B-1400-A1-PF	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT		
15.00	.591	82.00	3.228	16	835.B-1500-A1-PF	★	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT		
16.00	.630	102.00	4.016	16	835.B-1600-A1-PF	★	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT		
18.00	.709	102.00	4.016	18	835.B-1800-A1-PF	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT		
19.00	.748	100.00	3.937	20	835.B-1900-A1-PF	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	147.14	5.793	0.3	.012	18.80	.740	COROMANT		
20.00	.787	100.00	3.937	20	835.B-2000-A1-PF	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT		

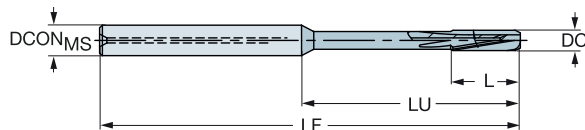
Volle Durchmesser H7 Bohrungstoleranz
Durch die Abstufung im Hunderstel-Durchmesserbereich können bestimmte Toleranzbereiche eingehalten werden.
Fertigung erfolgt auf +0.004 mm.



CoroReamer™ 835 Vollhartmetall-Reibahle

Für Stahlwerkstoffe

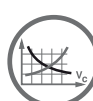
Für Durchgangsbohrungen

TCHA
CNSCH7
1

										P K		Abmessungen, mm, Zoll													
DC	DC*	LU	LU*	CZC _{MS}	Bestellnummer	1024	1024	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LCF	LCF*	L	L*	LF	LF*	APMX	APMX*	PHD	PHD*	BSG			
3.98	.157	39.00	1.535	6	835.T-0398-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT			
4.00	.157	39.00	1.535	6	835.T-0400-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT			
4.01	.158	39.00	1.535	6	835.T-0401-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT			
4.02	.158	39.00	1.535	6	835.T-0402-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT			
5.00	.197	39.00	1.535	6	835.T-0500-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT			
5.01	.197	39.00	1.535	6	835.T-0501-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT			
5.98	.235	39.00	1.535	6	835.T-0598-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT			
6.00	.236	39.00	1.535	6	835.T-0600-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT			
6.01	.237	39.00	1.535	6	835.T-0601-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT			
6.02	.237	39.00	1.535	6	835.T-0602-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT			
6.03	.237	39.00	1.535	6	835.T-0603-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.09	2.917	0.3	.012	5.80	.228	COROMANT			
6.50	.256	64.00	2.520	8	835.T-0650-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	99.02	3.898	0.3	.012	6.30	.248	COROMANT			
7.00	.276	64.00	2.520	8	835.T-0700-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT			
7.50	.295	64.00	2.520	8	835.T-0750-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.87	3.893	0.3	.012	7.30	.287	COROMANT			
7.97	.314	64.00	2.520	8	835.T-0797-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT			
8.00	.315	64.00	2.520	8	835.T-0800-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT			
8.01	.315	64.00	2.520	8	835.T-0801-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT			
8.02	.316	64.00	2.520	8	835.T-0802-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT			
8.03	.316	64.00	2.520	8	835.T-0803-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT			
9.00	.354	60.00	2.362	10	835.T-0900-A1-PF	★	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT			
9.50	.374	80.00	3.150	10	835.T-0950-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT			
9.97	.393	80.00	3.150	10	835.T-0997-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT			
9.99	.393	80.00	3.150	10	835.T-0999-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT			
10.00	.394	80.00	3.150	10	835.T-1000-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT			
10.01	.394	80.00	3.150	10	835.T-1001-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT			
10.02	.394	80.00	3.150	10	835.T-1002-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT			
10.50	.413	75.00	2.953	12	835.T-1050-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.42	4.662	0.3	.012	10.30	.406	COROMANT			
11.00	.433	75.00	2.953	12	835.T-1100-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT			
12.00	.472	75.00	2.953	12	835.T-1200-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT			
12.01	.473	75.00	2.953	12	835.T-1201-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT			
12.02	.473	75.00	2.953	12	835.T-1202-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT			
13.00	.512	85.00	3.346	14	835.T-1300-A1-PF	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT			
14.00	.551	85.00	3.346	14	835.T-1400-A1-PF	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT			
15.00	.591	82.00	3.228	16	835.T-1500-A1-PF	★	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT			
16.00	.630	102.00	4.016	16	835.T-1600-A1-PF	★	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT			
17.00	.669	102.00	4.016	18	835.T-1700-A1-PF	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.45	5.805	0.3	.012	16.80	.661	COROMANT			
18.00	.709	102.00	4.016	18	835.T-1800-A1-PF	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT			
20.00	.787	100.00	3.937	20	835.T-2000-A1-PF	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT			

Volle Durchmesser H7 Bohrungstoleranz

Durch die Abstufung im Hunderstel-Durchmesserbereich können bestimmte Toleranzbereiche eingehalten werden. Fertigung erfolgt auf +0.004 mm.



D19



E9



E28



E14

CoroReamer™ 835

Hochleistungs-Reibahle für rostfreien Stahl

Anwendungsbereich

- Für alle Industriebereiche, wie z.B. allgemeiner Maschinenbau, Formen- und Gesenkbau, Automobilindustrie, Energie- und Stromerzeugung
- Erhältlich mit spiralförmigem Spankanal für Durchgangsbohrungen und geradem Spankanal für Grundbohrungen
- Durchgangsbohrungen, schräge Flächen und Kreuzbohrung
- Kühlschmierstoffdruck 20 bar

ISO-Anwendungsbereich:



Vorteile und Merkmale

- Optimale Produktivität dank hoher Schnittparameter
- Konsistenz und Produktivität sparen Zeit und Kosten
- Exzellente Oberflächengüte des Werkstücks
- Hohe Rundlaufgenauigkeit für lange Standzeit und Maßgenauigkeit
- Große Stabilität dank Vollhartmetallkörper
- Innere Kühlschmierstoffzufuhr für bessere Spanabfuhr und weniger Verschleiß
- Feinkörniges Hartmetall für hohe Härte und Zähigkeit
- Spankanalgeometrie mit extrem ungleicher Teilung

www.sandvik.coromant.com/cororeamer835

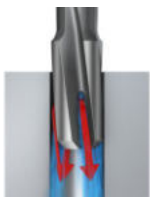
Spankanalgeometrie mit ungleicher Teilung

Extrem ungleiche Teilung bedeutet, dass die Abstände zwischen jeder Schneide ungleichmäßig sind. Da sich dabei keine Zähne diametral gegenüberliegen, produziert die Reibahle eine Bohrung mit verbesserter Rundheit.

Grundbohrung



Durchgangsbohrung



E14

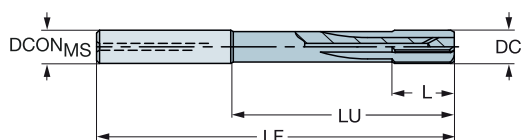
CoroReamer™ 835 Vollhartmetall-Reibahle

Für rostfreie Materialien

Für Grundbohrungen

TCHA
CNSC

H7
1



					M	Abmessungen, mm, Zoll																
					1024																	
DC	DC*	LU	LU*	CZC _{MS}	Bestellnummer	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LCF	LCF*	L	L*	LF	LF*	APMX	APMX*	PHD	PHD*	BSG		
3.97	.156	39.00	1.535	6	835.B-0397-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT	
4.00	.157	39.00	1.535	6	835.B-0400-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT	
4.02	.158	39.00	1.535	6	835.B-0402-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT	
4.97	.196	39.00	1.535	6	835.B-0497-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT	
5.00	.197	39.00	1.535	6	835.B-0500-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT	
6.00	.236	39.00	1.535	6	835.B-0600-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT	
6.01	.237	39.00	1.535	6	835.B-0601-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT	
6.02	.237	39.00	1.535	6	835.B-0602-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT	
7.00	.276	64.00	2.520	8	835.B-0700-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT	
8.00	.315	64.00	2.520	8	835.B-0800-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT	
8.01	.315	64.00	2.520	8	835.B-0801-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT	
8.50	.335	60.00	2.362	10	835.B-0850-A1-MF	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.72	3.887	0.3	.012	8.30	.327	COROMANT	
9.00	.354	60.00	2.362	10	835.B-0900-A1-MF	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT	
10.00	.394	80.00	3.150	10	835.B-1000-A1-MF	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT	
11.00	.433	75.00	2.953	12	835.B-1100-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT	
11.50	.453	75.00	2.953	12	835.B-1150-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.27	4.656	0.3	.012	11.30	.445	COROMANT	
12.00	.472	75.00	2.953	12	835.B-1200-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT	
14.00	.551	85.00	3.346	14	835.B-1400-A1-MF	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT	
16.00	.630	102.00	4.016	16	835.B-1600-A1-MF	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT	

Volle Durchmesser H7 Bohrungstoleranz

Durch die Abstufung im Hunderstel-Durchmesserbereich können bestimmte Toleranzbereiche eingehalten werden.
Fertigung erfolgt auf +0.004 mm.



D22



E9



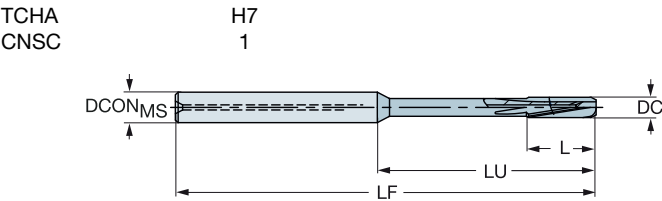
E28



E14

CoroReamer™ 835 Vollhartmetall-Reibahle

Für rostfreie Materialien
Für Durchgangsbohrungen



					M Abmessungen, mm, Zoll																
					1024																
DC	DC*	LU	LU*	CZC _{MS}	Bestellnummer	★	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LCF	LCF*	L	L*	LF	LF*	APMX	APMX*	PHD	PHD*	BSG
3.97	.156	39.00	1.535	6	835.T-0397-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.00	.157	39.00	1.535	6	835.T-0400-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.01	.158	39.00	1.535	6	835.T-0401-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.02	.158	39.00	1.535	6	835.T-0402-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
5.00	.197	39.00	1.535	6	835.T-0500-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.03	.198	39.00	1.535	6	835.T-0503-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.24	2.923	0.3	.012	4.80	.189	COROMANT
5.99	.236	39.00	1.535	6	835.T-0599-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.00	.236	39.00	1.535	6	835.T-0600-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.02	.237	39.00	1.535	6	835.T-0602-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.50	.256	64.00	2.520	8	835.T-0650-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	99.02	3.898	0.3	.012	6.30	.248	COROMANT
7.00	.276	64.00	2.520	8	835.T-0700-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
7.50	.295	64.00	2.520	8	835.T-0750-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.87	3.893	0.3	.012	7.30	.287	COROMANT
8.00	.315	64.00	2.520	8	835.T-0800-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.02	.316	64.00	2.520	8	835.T-0802-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
8.50	.335	60.00	2.362	10	835.T-0850-A1-MF	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.72	3.887	0.3	.012	8.30	.327	COROMANT
9.00	.354	60.00	2.362	10	835.T-0900-A1-MF	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT
9.50	.374	80.00	3.150	10	835.T-0950-A1-MF	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT
10.00	.394	80.00	3.150	10	835.T-1000-A1-MF	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	835.T-1001-A1-MF	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.50	.413	75.00	2.953	12	835.T-1050-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.42	4.662	0.3	.012	10.30	.406	COROMANT
12.00	.472	75.00	2.953	12	835.T-1200-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
14.00	.551	85.00	3.346	14	835.T-1400-A1-MF	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	835.T-1500-A1-MF	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	835.T-1600-A1-MF	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT

Volle Durchmesser H7 Bohrungstoleranz
Durch die Abstufung im Hunderstel-Durchmesserbereich können bestimmte Toleranzbereiche eingehalten werden.
Fertigung erfolgt auf +0.004 mm.



CoroReamer™ 830

Wechselkopfwerkzeug mit hohen Vorschüben für Durchgangsbohrungen

Anwendungsbereich

- Für alle Industriebereiche, wie z.B. allgemeiner Maschinenbau, Formen- und Gesenkbau, Automobilindustrie, Energie- und Stromerzeugung
- Erhältlich mit spiralförmigem Spankanal für Durchgangsbohrungen und geradem Spankanal für Grundbohrungen
- Erreichbare Bohrungstoleranz: H7
- Kühlschmierstoffdruck 20 bar

ISO-Anwendungsbereich:



Vorteile und Merkmale

- Hohe Oberflächengüte und Bearbeitungssicherheit
- Hohe Vorschübe/Zeiteinheit
- Schneller und problemloser Schneidkopfwechsel mit hoher Genauigkeit <3 µm (120 Mikrozoll)
- Effektive Spanabfuhr durch die Zufuhr von Kühlschmierstoff an jede Schneidkante
- Erreichbare Bohrungstoleranz: H7
- Gelötete Cermetplatten in der Sorte P10R
- Lange und kurze Schaftausführungen
- Schneidkopfwechsel

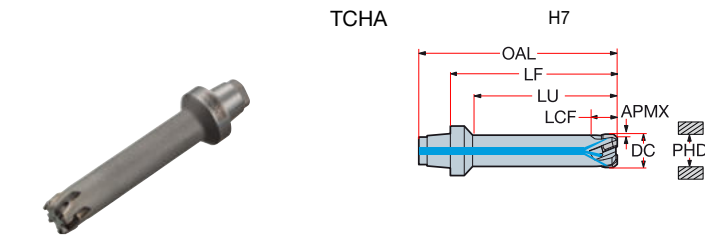


CoroReamer™ 830 Vollhartmetall-Schneidkopf zum Reiben

Für Stahl- und Gusswerkstoffe
Innere Kühlschmierstoffzufuhr



		Abmessungen, mm, Zoll																
DC	DC*	CZC _{MS}	Bestellnummer	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LCF	LCF*	L	L*	LF	LF*	APMX	APMX*	PHD	PHD*	BSG
19.00	.748	S12	830A-E06D1900H7S12	12.00	.472	25.85	1.018	10.83	.426	6.00	.236	14.50	.571	0.3	.012	18.80	.740	COROMANT
19.05	.750	S12	830A-E06D1905H7S12	12.00	.472	25.85	1.018	10.83	.426	6.00	.236	14.50	.571	0.3	.012	18.83	.741	COROMANT
20.00	.787	S12	830A-E06D2000H7S12	12.00	.472	25.85	1.018	10.83	.426	6.00	.236	14.50	.571	0.3	.012	19.80	.780	COROMANT
21.00	.827	S12	830A-E06D2100H7S12	12.00	.472	25.85	1.018	10.83	.426	6.00	.236	14.50	.571	0.3	.012	20.80	.819	COROMANT
22.00	.866	S14	830A-E06D2200H7S14	14.00	.551	27.85	1.096	13.05	.514	6.00	.236	15.50	.610	0.3	.012	21.80	.858	COROMANT
23.00	.906	S14	830A-E06D2300H7S14	14.00	.551	27.85	1.096	13.05	.514	6.00	.236	15.50	.610	0.3	.012	22.80	.898	COROMANT
24.00	.945	S16	830A-E06D2400H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	23.80	.937	COROMANT
25.00	.984	S16	830A-E06D2500H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	24.80	.976	COROMANT
25.40	1.000	S16	830A-E06D2540H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	25.20	.992	COROMANT
26.00	1.024	S16	830A-E06D2600H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	25.80	1.016	COROMANT
27.00	1.063	S16	830A-E06D2700H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	26.80	1.055	COROMANT
28.00	1.102	S16	830A-E06D2800H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	27.80	1.094	COROMANT
29.00	1.142	S16	830A-E06D2900H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	28.80	1.134	COROMANT
30.00	1.181	S20	830A-E06D3000H7S20	20.00	.787	31.85	1.254	13.22	.520	6.00	.236	17.00	.669	0.3	.012	29.80	1.173	COROMANT
31.75	1.250	S20	830A-E06D3175H7S20	20.00	.787	31.85	1.254	13.22	.520	6.00	.236	17.00	.669	0.3	.012	31.60	1.244	COROMANT



		Abmessungen, mm, Zoll																
DC	DC*	LU	LU*	CZC _{MS}	Bestellnummer	DCON _{MS}	DCON _{MS} *	OAL	OAL*	LCF	LCF*	L	L*	LF	LF*	APMX	APMX*	PHD
10.00	.394	45.00	1.772	S12	830B-E06D1000H7S12	12.00	.472	71.35	2.809	9.99	.393	6.00	.236	60.00	2.362	0.3	.012	9.80
11.00	.433	45.00	1.772	S12	830B-E06D1100H7S12	12.00	.472	71.35	2.809	10.00	.394	6.00	.236	60.00	2.362	0.3	.012	10.80
12.00	.472	45.00	1.772	S12	830B-E06D1200H7S12	12.00	.472	71.35	2.809	9.99	.393	6.00	.236	60.00	2.362	0.3	.012	11.80
13.00	.512	45.00	1.772	S12	830B-E06D1300H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	12.80
14.00	.551	45.00	1.772	S12	830B-E06D1400H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	13.80
15.00	.591	45.00	1.772	S12	830B-E06D1500H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	14.80
16.00	.630	45.00	1.772	S12	830B-E06D1600H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	15.80
17.00	.669	45.00	1.772	S12	830B-E06D1700H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	16.80
18.00	.709	45.00	1.772	S12	830B-E06D1800H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	17.80

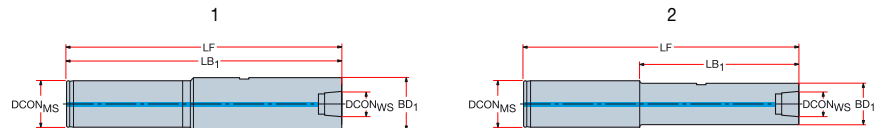
Volle Durchmesser H7 Bohrungstoleranz
Durch die Abstufung im Hunderstel-Durchmesserbereich können bestimmte Toleranzbereiche eingehalten werden.
Fertigung erfolgt auf +0.004 mm.



Zylinderschaft Adapter für CoroReamer® 830

Innere Kühlschmierstoffzufuhr

DSGN



		Abmessungen, mm, Zoll																	
CZC _{MS}	CZC _{WS}	CNSC	CXSC	DSGN	Bestellnummer	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BAR PSI	NM	KG	RPMX		
20.0	S12	1	1	2	830-S12A20035F	20.0	12.0	50	85.0	35.0	85.0	17.8	20.0	100	7.0	0.23	50000		
						.787	.472	1.969	3.346	1.378	3.346	.701	.787	1450					
	S12	1	1	2	830-S12A20069F	20.0	12.0	50	118.5	68.5	118.5	17.8	20.0	100	7.0	0.29	50000		
						.787	.472	1.969	4.665	2.697	4.665	.701	.787	1450					
	S12	1	1	2	830-S12A20130F	20.0	12.0	50	179.5	129.5	179.5	17.8	20.0	100	7.0	0.40	50000		
						.787	.472	1.969	7.067	5.098	7.067	.701	.787	1450					
	S14	1	1	1	830-S14A20070F	20.0	14.0	50	119.5	119.5		20.5		100	7.0	0.31	50000		
						.787	.551	1.969	4.705	4.705		.807		1450					
	S14	1	1	1	830-S14A20131F	20.0	14.0	50	180.5	180.5		20.5		100	7.0	0.44	50000		
						.787	.551	1.969	7.106	7.106		.807		1450					
25.0	S16	1	1	2	830-S16A25090F	25.0	16.0	60	150.0	90.0	150.0	23.2	25.0	100	12.0	0.55	50000		
						.984	.630	2.362	5.906	3.543	5.906	.913	.984	1450					
	S16	1	1	2	830-S16A25151F	25.0	16.0	60	211.0	151.0	211.0	23.2	25.0	100	12.0	0.70	50000		
						.984	.630	2.362	8.307	5.945	8.307	.913	.984	1450					
	S20	1	1	1	830-S20A25089F	25.0	20.0	60	149.0	149.0		29.3		100	12.0	0.64	50000		
						.984	.787	2.362	5.866	5.866		1.154		1450					
	S20	1	1	1	830-S20A25150F	25.0	20.0	60	210.0	210.0		29.3		100	12.0	1.03	50000		
						.984	.787	2.362	8.268	8.268		1.154		1450					

Zubehör

Für Reibahlundurchmesser



mm	Zoll	Schlüssel für Schneidkopf (mm)	Anzugsbolzen mit innerer Kühlschmierstoffzufuhr	Anzugsbolzen ohne innere Kühlschmierstoffzufuhr
10-19.05	.750-709	3021 010-040 (4.0)	5519 107-01	5519 106-01
20-23	.787-906	3021 010-040 (4.0)	—	5519 106-01
24-31.75	.945-1.250	3021 010-050 (5.0)	—	5519 106-02

Zubehör ist gesondert zu bestellen



E9



E28

A

REIBEN

Schnittdaten

Schnittdaten für CoroReamer™ 435

Metrische Werte

GER

CoroReamer™ 435 -XF					Ø mm					
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
P		Unlegierter Stahl								
	P1.1.Z.AN	C=0.10-0.25%	428	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P1..Z.AN	Vergütet	639	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P1.2.Z.AN	C = 0.25-0.55%	639	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P1.2.Z.HT		708	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P1.3.Z.AN	C = 0.55-0.80%	639	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P1.3.Z.HT		991	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
		Niedriglegierter Stahl								
	P2.1.Z.AN	Nicht gehärtet	591	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P2.2.Z.AN	Geglüht	811	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P2.3.Z.AN		867	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P2.5.Z.HT	Vergütet	961	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
		Stahlguss								
	P1.5.C.UT	Unlegiert	503	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P2.6.C.UT	Niedriglegiert (Legierungsanteile ≤ 5%)	674	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
		Hochlegierter Stahl								
	P3.0.Z.AN	Geglüht	674	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P3.0.Z.HT		1282	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P3.1.Z.AN	HSS, geglüht	839	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P5.0.Z.HT		1114	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30
	P5.0.Z.PH		503	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.30 0.20	0.30 0.30

B

C

D

E

Schnittdaten für CoroReamer™ 435

Zoll-Werte

CoroReamer™ 435 -XF				Ø Zoll						
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
P	Unlegierter Stahl									
	P1.1.Z.AN	C=0.10-0.25%	428	v _c Fuß/min f _n Zoll/U Aufmaß			98			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P1.1.Z.AN	Vergütet	639	v _c Fuß/min f _n Zoll/U Aufmaß			98			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P1.2.Z.AN	C = 0.25-0.55%	639	v _c Fuß/min f _n Zoll/U Aufmaß			98			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P1.2.Z.HT		708	v _c Fuß/min f _n Zoll/U Aufmaß			98			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P1.3.Z.AN	C = 0.55-0.80%	639	v _c Fuß/min f _n Zoll/U Aufmaß			98			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P1.3.Z.HT		991	v _c Fuß/min f _n Zoll/U Aufmaß			66			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	Niedriglegierter Stahl									
	P2.1.Z.AN	Nicht gehärtet	591	v _c Fuß/min f _n Zoll/U Aufmaß			98			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P2.2.Z.AN	Geglüht	811	v _c Fuß/min f _n Zoll/U Aufmaß			66			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P2.3.Z.AN		867	v _c Fuß/min f _n Zoll/U Aufmaß			66			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P2.5.Z.HT	Vergütet	961	v _c Fuß/min f _n Zoll/U Aufmaß			49			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	Stahlguss									
	P1.5.C.UT	Unlegiert	503	v _c Fuß/min f _n Zoll/U Aufmaß			98			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P2.6.C.UT	Niedriglegiert (Legierungsanteile ≤ 5%)	674	v _c Fuß/min f _n Zoll/U Aufmaß			66			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	Hochlegierter Stahl									
	P3.0.Z.AN	Geglüht	674	v _c Fuß/min f _n Zoll/U Aufmaß			66			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P3.0.Z.HT		1282	v _c Fuß/min f _n Zoll/U Aufmaß			49			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P3.1.Z.AN	HSS, geglüht	839	v _c Fuß/min f _n Zoll/U Aufmaß			66			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P5.0.Z.HT		1114	v _c Fuß/min f _n Zoll/U Aufmaß			49			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012
	P5.0.Z.PH		503	v _c Fuß/min f _n Zoll/U Aufmaß			98			
					.006	.007	.008	.008	.012	.012
					.004	.004	.008	.008	.008	.012

B

C

D

E

Schnittdaten für CoroReamer™ 435

Metrische Werte

CoroReamer™ 435 -XF					Ø mm					
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
K		Temperguss								
	K1.1.C.NS	Ferritisch Perlitisch	428	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.25 0.20	0.30 0.30
		Grauguss								
	K2.1.C.UT	Niedrige Festigkeit	639	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.25 0.20	0.30 0.30
	K2.2.C.UT	Hohe Festigkeit	639	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.25 0.20	0.30 0.30
	K2.3.C.UT		708	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.25 0.20	0.30 0.30
		Kugelgraphitguss								
	K3.1.C.UT	Ferritisch	639	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.25 0.20	0.30 0.30
	K3.2.C.UT	Perlitisch	991	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.25 0.20	0.30 0.30
	K3.3.C.UT	Perlitisch	503	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.25 0.20	0.30 0.30
	K3.5.C.UT		591	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.20	0.20 0.20	0.25 0.20	0.30 0.30
		Aluminiumlegierungen								
	N1.2.Z.UT	Geschmiedet, nicht ausgehärtet	400	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.15	0.20 0.20	0.25 0.20	0.30 0.30
	N1.2.Z.AG	Gewalzt oder gewalzt und ausgehärtet	650	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.15	0.20 0.20	0.25 0.20	0.30 0.30
	N1.3.C.UT	Gegossen, nicht ausgehärtet	600	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.15	0.20 0.20	0.25 0.20	0.30 0.30
	N1.3.C.AG	Gegossen oder gegossen und ausgehärtet	700	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.15	0.20 0.20	0.25 0.20	0.30 0.30
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	700	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.15 0.10	0.15 0.20	0.20 0.20	0.20 0.20	0.30 0.30
		Kupferbasislegierungen								
	N3.3.U.UT	Automatenlegierungen (Pb>1%)	550	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.15	0.20 0.20	0.25 0.20	0.30 0.30
	N3.1.U.UT	Bleifreie Kupferlegierungen (einschl. elektrolytischer Kupfer)	1350	v_c m/min f_n mm/U Aufmaß	0.15 0.10	0.18 0.10	0.20 0.15	0.20 0.20	0.25 0.20	0.30 0.30
		Kunststoff								
O				v_c m/min f_n mm/U Aufmaß	0.15 0.15	0.15 0.15	0.15 0.20	0.35 0.20	0.35 0.20	0.40 0.30

Schnittdaten für CoroReamer™ 435

Zoll-Werte

CoroReamer™ 435 -XF					Ø Zoll					
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
K		Temperguss								
	K1.1.C.NS	Ferritisch Perlitisch	428	v_c Fuß/min f_r Zoll/U Aufmaß	98 .006 .004	.007	.008	.008	.010	.012
		Grauguss								
	K2.1.C.UT	Niedrige Festigkeit	639	v_c Fuß/min f_r Zoll/U Aufmaß	98 .006 .004	.007	.008	.008	.010	.012
	K2.2.C.UT	Hohe Festigkeit	639	v_c Fuß/min f_r Zoll/U Aufmaß	98 .006 .004	.007	.008	.008	.010	.012
	K2.3.C.UT		708	v_c Fuß/min f_r Zoll/U Aufmaß	98 .006 .004	.007	.008	.008	.010	.012
		Kugelgraphitguss								
	K3.1.C.UT	Ferritisch	639	v_c Fuß/min f_r Zoll/U Aufmaß	66 .006 .004	.007	.008	.008	.010	.012
	K3.2.C.UT	Perlitisch	991	v_c Fuß/min f_r Zoll/U Aufmaß	66 .006 .004	.007	.008	.008	.010	.012
	K3.3.C.UT	Perlitisch	503	v_c Fuß/min f_r Zoll/U Aufmaß	66 .006 .004	.007	.008	.008	.010	.012
	K3.5.C.UT		591	v_c Fuß/min f_r Zoll/U Aufmaß	66 .006 .004	.007	.008	.008	.010	.012
N		Aluminiumlegierungen								
	N1.2.Z.UT	Geschmiedet, nicht ausgehärtet	400	v_c Fuß/min f_r Zoll/U Aufmaß	164 .006 .004	.007	.008	.008	.010	.012
	N1.2.Z.AG	Gewalzt oder gewalzt und ausgehärtet	650	v_c Fuß/min f_r Zoll/U Aufmaß	164 .006 .004	.007	.008	.008	.010	.012
	N1.3.C.UT	Gegossen, nicht ausgehärtet	600	v_c Fuß/min f_r Zoll/U Aufmaß	164 .006 .004	.007	.008	.008	.010	.012
	N1.3.C.AG	Gegossen oder gegossen und ausgehärtet	700	v_c Fuß/min f_r Zoll/U Aufmaß	164 .006 .004	.007	.008	.008	.010	.012
	N1.4.C.NS	AlSi Gusslegierungen, Si ≤ 13%	700	v_c Fuß/min f_r Zoll/U Aufmaß	98 .006 .004	.006	.006	.008	.008	.012
		Kupferbasislegierungen								
	N3.3.U.UT	Automatenlegierungen (Pb>1%)	550	v_c Fuß/min f_r Zoll/U Aufmaß	164 .006 .004	.007	.008	.008	.010	.012
	N3.1.U.UT	Bleifreie Kupferlegierungen (einschl. elektrolytischer Kupfer)	1350	v_c Fuß/min f_r Zoll/U Aufmaß	164 .006 .004	.007	.008	.008	.010	.012
		Kunststoff								
O				v_c Fuß/min f_r Zoll/U Aufmaß	131 .006 .006	.006	.006	.014	.014	.016

B

C

D

E

Schnittdaten für Reibahle 830

Metrische Werte

ISO	CMC-Nr.	Werkstoff	Härte Brinell HB	Sorte	Schnittgeschwindigkeit V_c m/min	Vorschub f_z mm/Zahn	Radiale Schnitttiefe a_p mm
P	01.1	Unlegierter Stahl Nicht vergütet 0,10-0,25% C	90-200	P10R	150-200	0.15-0.25	0.1-0.3
	01.2	Nicht vergütet 0,25-0,55% C	125-225		150-200	0.15-0.25	
	01.3	Nicht gehärtet 0,55-0,80% C	150-225		140-180	0.15-0.25	
	01.4	Legierter und hochlegierter Werkzeugstahl	180-225		140-180	0.15-0.25	
	02.1	Niedriglegierter Stahl Nicht gehärtet	150-260	P10R	110-180	0.15-0.25	0.1-0.3
	02.2	Vergütet	220-400		70-130	0.10-0.20	
K	06.1	Stahlguss Unlegiert	90-225	P10R	140-180	0.15-0.25	0.1-0.3
	06.2	Niedrig legiert	150-250		100-150	0.15-0.25	
	07.2	Temperguss Perlitisch	150-270	P10R	150-200	0.15-0.25	0.1-0.3
	09.2	Kugelgraphitguss Perlitisch	200-300	P10R	110-190	0.15-0.25	0.1-0.3

Zoll-Werte

ISO	CMC-Nr.	Werkstoff	Härte Brinell HB	Sorte	Schnittgeschwindigkeit V_c ft/min	Vorschub f_z Zoll/Wendeschneidplatte	Radiale Schnitttiefe a_p Zoll
P	01.1	Unlegierter Stahl Nicht vergütet 0,10-0,25% C	90-200	P10R	490-650	.006-.010	.004-.012
	01.2	Nicht vergütet 0,25-0,55% C	125-225		490-650	.006-.010	
	01.3	Nicht gehärtet 0,55-0,80% C	150-225		460-590	.006-.010	
	01.4	Legierter und hochlegierter Werkzeugstahl	180-225		460-590	.006-.010	
	02.1	Niedriglegierter Stahl Nicht gehärtet	150-260	P10R	360-590	.006-.010	.004-.012
	02.2	Vergütet	220-400		230-425	.004-.008	
K	06.1	Stahlguss Unlegiert	90-225	P10R	460-590	.006-.010	.004-.012
	06.2	Niedriglegiert	150-250		330-490	.006-.010	
	07.2	Temperguss Perlitisch	150-270	P10R	490-650	.006-.010	.004-.012
	09.2	Kugelgraphitguss Perlitisch	200-300	P10R	360-620	.006-.010	.004-.012

Schnittdaten für CoroReamer™ 835

Metrische Werte

CoroReamer™ 835 - PF					Ø mm					
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
P	Unlegierter Stahl									
	P1.1.Z.AN	C=0.10-0.25%	428	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.1.Z.AN	Vergütet	639	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.2.Z.AN	C = 0.25-0.55%	639	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.2.Z.HT		708	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.3.Z.AN	C = 0.55-0.80%	639	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P1.3.Z.HT		991	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	Niedriglegierter Stahl									
	P2.1.Z.AN	Nicht gehärtet	591	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P2.2.Z.AN	Geglüht	811	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P2.3.Z.AN		867	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P2.5.Z.HT	Vergütet	961	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	Stahlguss									
	P1.5.C.UT	Unlegiert	503	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P2.6.C.UT	Niedriglegiert (Legierungsanteile ≤ 5%)	674	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	Hochlegierter Stahl									
	P3.0.Z.AN	Geglüht	674	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P3.0.Z.HT		1282	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P3.1.Z.AN	HSS, geglüht	839	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20
	P5.0.Z.HT		1114	v_c m/min f_r mm/U Aufmaß	0.20 0.10	0.30 0.10	0.50 0.10	0.80 0.15	1.10 0.20	1.50 0.20

B

C

D

E

Schnittdaten für CoroReamer™ 835

Zoll-Werte

CoroReamer™ 835 - PF					Ø Zoll					
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
P	Unlegierter Stahl									
	P1.1.Z.AN	C=0.10-0.25%	428	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P1..Z.AN	Vergütet	639	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P1.2.Z.AN	C = 0.25-0.55%	639	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P1.2.Z.HT		708	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P1.3.Z.AN	C = 0.55-0.80%	639	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P1.3.Z.HT		991	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	Niedriglegierter Stahl									
	P2.1.Z.AN	Nicht gehärtet	591	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P2.2.Z.AN	Geglüht	811	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P2.3.Z.AN		867	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P2.5.Z.HT	Vergütet	961	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	Stahlguss									
	P1.5.C.UT	Unlegiert	503	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P2.6.C.UT	Niedriglegiert (Legierungsanteile ≤ 5%)	674	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	Hochlegierter Stahl									
	P3.0.Z.AN	Geglüht	674	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P3.0.Z.HT		1282	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P3.1.Z.AN	HSS, geglüht	839	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008
	P5.0.Z.HT		1114	v_c Fuß/min f_n Zoll/U Aufmaß	.008 .004	.012 .004	.020 .004	.031 .006	.043 .008	.059 .008

Schnittdaten für CoroReamer™ 835

Metrische Werte

CoroReamer™ 835 -PF					Ø mm					
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
K		Temperguss								
	K1.1.C.NS	Ferritisch Perlitisch	428	v_c m/min f_h mm/U Aufmaß	0.30 0.10	0.40 0.10	0.60 0.15	90 1.00 0.20	1.30 0.20	1.80 0.30
	K2.1.C.UT	Grauguss Niedrige Festigkeit	639	v_c m/min f_h mm/U Aufmaß	0.30 0.10	0.40 0.10	0.60 0.15	110 1.00 0.20	1.30 0.20	1.80 0.30
	K2.2.C.UT	Hohe Festigkeit	639	v_c m/min f_h mm/U Aufmaß	0.30 0.10	0.40 0.10	0.60 0.15	150 1.00 0.20	1.30 0.20	1.80 0.30
	K2.3.C.UT		708	v_c m/min f_h mm/U Aufmaß	0.30 0.10	0.40 0.10	0.60 0.15	90 1.00 0.20	1.30 0.20	1.80 0.30
	K3.1.C.UT	Kugelgraphitguss Ferritisch	639	v_c m/min f_h mm/U Aufmaß	0.30 0.10	0.40 0.10	0.60 0.15	90 1.00 0.20	1.30 0.20	1.80 0.30
	K3.2.C.UT	Perlitisch	991	v_c m/min f_h mm/U Aufmaß	0.30 0.10	0.40 0.10	0.60 0.15	90 1.00 0.20	1.30 0.20	1.80 0.30
	K3.3.C.UT	Perlitisch	503	v_c m/min f_h mm/U Aufmaß	0.30 0.10	0.40 0.10	0.60 0.15	90 1.00 0.20	1.30 0.20	1.80 0.30
	K3.5.C.UT		591	v_c m/min f_h mm/U Aufmaß	0.30 0.10	0.40 0.10	0.60 0.15	90 1.00 0.20	1.30 0.20	1.80 0.30

Zoll-Werte

CoroReamer™ 835 -PF					Ø Zoll						
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787	
K		Temperguss									
	K1.1.C.NS	Ferritisch Perlitisch	428	v_c Fuß/min f_n Zoll/U Aufmaß	.012 .004	.016 .004	.024 .006	.039 .008	.051 .008	.071 .012	
	K2.1.C.UT	Niedrige Festigkeit	639	v_c Fuß/min f_n Zoll/U Aufmaß	.012 .004	.016 .004	.024 .006	.039 .008	.051 .008	.071 .012	
	K2.2.C.UT	Hohe Festigkeit	639	v_c Fuß/min f_n Zoll/U Aufmaß	.012 .004	.016 .004	.024 .006	.039 .008	.051 .008	.071 .012	
	K2.3.C.UT		708	v_c Fuß/min f_n Zoll/U Aufmaß	.012 .004	.016 .004	.024 .006	.039 .008	.051 .008	.071 .012	
	K3.1.C.UT	Ferritisch	639	v_c Fuß/min f_n Zoll/U Aufmaß	.012 .004	.016 .004	.024 .006	.039 .008	.051 .008	.071 .012	
	K3.2.C.UT	Perlitisch	991	v_c Fuß/min f_n Zoll/U Aufmaß	.012 .004	.016 .004	.024 .006	.039 .008	.051 .008	.071 .012	
	K3.3.C.UT	Perlitisch	503	v_c Fuß/min f_n Zoll/U Aufmaß	.012 .004	.016 .004	.024 .006	.039 .008	.051 .008	.071 .012	
	K3.5.C.UT		591	v_c Fuß/min f_n Zoll/U Aufmaß	.012 .004	.016 .004	.024 .006	.039 .008	.051 .008	.071 .012	

A

Schnittdaten für CoroReamer™ 835

Metrische Werte

CoroReamer™ 835 -MF					Ø mm					
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
P	P5.0.Z.PH	Unlegierter Stahl	503	v_c m/min	30					
				f_n mm/U	0.10	0.15	0.30	0.40	0.50	0.60
				Aufmaß	0.05	0.10	0.10	0.10	0.20	0.20
M	M1.0.Z.AQ	Austenitisch	811	v_c m/min	40					
				f_n mm/U	0.10	0.15	0.30	0.40	0.50	0.60
				Aufmaß	0.05	0.10	0.10	0.10	0.20	0.20
	M2.0.Z.AQ	Superaustenitisch	961	v_c m/min	40					
				f_n mm/U	0.10	0.15	0.30	0.40	0.50	0.60
				Aufmaß	0.05	0.10	0.10	0.10	0.20	0.20
	M3.1.Z.AQ		674	v_c m/min	30					
				f_n mm/U	0.10	0.15	0.30	0.40	0.50	0.60
				Aufmaß	0.05	0.10	0.10	0.10	0.20	0.20
	M3.2.Z.AQ	Austenitisch-ferritisch (Duplex)	674	v_c m/min	30					
				f_n mm/U	0.10	0.15	0.30	0.40	0.50	0.60
				Aufmaß	0.05	0.10	0.10	0.10	0.20	0.20
	M1.0.C.UT		674	v_c m/min	40					
				f_n mm/U	0.10	0.15	0.30	0.40	0.50	0.60
				Aufmaß	0.05	0.10	0.10	0.10	0.20	0.20
	M2.0.C.AQ			v_c m/min	40					
				f_n mm/U	0.10	0.15	0.30	0.40	0.50	0.60
				Aufmaß	0.05	0.10	0.10	0.10	0.20	0.20
	M3.1.C.AQ		1114	v_c m/min	30					
				f_n mm/U	0.20	0.30	0.50	0.80	1.10	1.50
				Aufmaß	0.10	0.10	0.10	0.15	0.20	0.20

B

C

Zoll-Werte

CoroReamer™ 835 -MF					Ø mm							
ISO	MC-Nr.	Werkstoff	N/mm²	Anwendungsdaten	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787		
P	P5.0.Z.PH	Unlegierter Stahl	503	v_c Fuß/min	98							
				f_n Zoll/U	.004	.006	.012	.016	.020	.024		
				Aufmaß	.002	.004	.004	.004	.008	.008		
M	M1.0.Z.AQ	Austenitisch	811	v_c Fuß/min	131							
				f_n Zoll/U	.004	.006	.012	.016	.020	.024		
				Aufmaß	.002	.004	.004	.004	.008	.008		
	M2.0.Z.AQ	Superaustenitisch	961	v_c Fuß/min	131							
				f_n Zoll/U	.004	.006	.012	.016	.020	.024		
				Aufmaß	.002	.004	.004	.004	.008	.008		
	M3.1.Z.AQ		674	v_c Fuß/min	98							
				f_n Zoll/U	.004	.006	.012	.016	.020	.024		
				Aufmaß	.002	.004	.004	.004	.008	.008		
	M3.2.Z.AQ	Austenitisch-ferritisch (Duplex)	674	v_c Fuß/min	98							
				f_n Zoll/U	.004	.006	.012	.016	.020	.024		
				Aufmaß	.002	.004	.004	.004	.008	.008		
	M1.0.C.UT		674	v_c Fuß/min	131							
				f_n Zoll/U	.004	.006	.012	.016	.020	.024		
				Aufmaß	.002	.004	.004	.004	.008	.008		
	M2.0.C.AQ			v_c Fuß/min	131							
				f_n Zoll/U	.004	.006	.012	.016	.020	.024		
				Aufmaß	.002	.004	.004	.004	.008	.008		
	M3.1.C.AQ		1114	v_c Fuß/min	98							
				f_n Zoll/U	.008	.012	.020	.031	.043	.059		
				Aufmaß	.004	.004	.004	.006	.008	.008		

D

E



Allgemeine Informationen

Kundenspezifische Lösungen	E2-E8
ISO 13399	E9
Allgemeine Formeln	E12
Ifind	E13
Nachschleifen	E14
Coromant Recycling Konzept (CRC)	E15
Sicherheitshinweise	E16
Werkstoff-Vergleichstabelle	E17
Bestellnummernschlüssel	E22
CoroMill® Plura	E26
CoroMill® Plura, Gewindefräsen	E27
CoroTap™	E27
Informationen zur Kühlschmierstoffzufuhr	E28
Alphanumerisches Verzeichnis	E29

Kundenspezifische Vollhartmetallwerkzeuge

B



CoroMill® Plura - Universell			CoroMill® Plura - Optimiert	
Schaftfräser für große Eingriffsbreiten	Schaftfräser für mittlere Eingriffsbreiten	Kugelschaftfräser für die Profilbearbeitung	Schaftfräser für die Heavy Duty Bearbeitung (HD)	Schaftfräser für die High Feed Sidemilling Bearbeitung
D _c mm	2-25.4	2-25.4	2-25.4	4-25.4
ZEFP	2/3/4	3	2/3/4	4
FHA	30/35	45	0/20/30/40/45/50/60	37
Schaft	HA/HB	HA/HB	HA/HB/ILO	HA/HB
RE	0.4xDC	0.4xDC	N/A	0.4xDC
CHW	0.2xDC	0.2xDC	N/A	0.15xDC
KCH	30-60	30-60	N/A	40-50
APMX	5xDC	5xDC	-	6xDC
Sorte	H10F/1620/1630	H10F/1620/1630	H10F/1630/N20C	H10F/1720/1730/1740

C

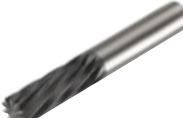


CoroMill® Plura - Optimiert				
Schaftfräser für die High Feed Sidemilling Bearbeitung in ISO S	Schaftfräser für Stabilität und Spanraum	Schaftfräser für die Hartbearbeitung	Schaftfräser für ISO N	Schaftfräser mit Kordelverzahnung
D _c mm	4-38.1	2-32	2-20	2-25.4
ZEFP	4/5/6	3-8	2-8	2/3/4
FHA	42	30/50	0/20/30/40/45/50/55/60	25/30/45
Schaft	HA/HB/ILO	HA/HB/ILO	HA/HB/ILO	HA/HB/RS
RE	0.4xDC	0.25XDC	0.495xDC	0.4xDC
CHW	0.15xDC	0.2xDC	0.2xDC	0.2xDC
KCH	40-50	20-60	20-60	15-60
APMX	4xDC	4xDC	5xDC	5xDC
Sorte	1745/1710	H10F/1610/1620/1630/1640/1725	H10F/1610/1620/1630/1640	H10F/1630/N20C

E

Kundenspezifische Vollhartmetallwerkzeuge



CoroMill® Plura - Optimiert			
	Schaftfräser für die Schlicht- bearbeitung	Kugelschaftfräser für die Profilbearbeitung	Schaftfräser für das Besäumen
			
D_c mm	2-32	2-25.4	4.0 - 12.7
ZEFP	2/10	2-4	Geometrieabhängig
FHA	0/20/30/40/45/50/55/60	0/30/50/60	Geometrieabhängig
Schaft	HA/HB/ILO	HA/HB	SS
RE	0.495xDC	N/A	N/A
CHW	0.2xDC	N/A	N/A
KCH	20-60	N/A	N/A
APMX	5xDC	5xDC	5xDC
Sorte	H10F/1610/1620/1630/ 1640	H10F/1620/1630	H10F/O10M/O10A/ O12M

Kundenspezifische Vollhartmetallwerkzeuge

B



CoroMill® 316					
	Fräskopf für die Heavy Duty Bearbeitung	Fräskopf für Stabilität und Spanraum	Fräskopf für die High Feed-Facemilling Bearbeitung	Fräskopf für die Hartbearbeitung	Fräskopf mit Kordelverzahnung
D _c mm	0,6xDC-DC	0,6xDC-DC	Nominal DC	0,6xDC-DC	0,6xDC-DC
ZEFP	4/5	3/4/5	3/4	3	4/5/6/8
FHA	38/42	50	50	45	40/45
Schaft	EH	EH	EH	EH	EH
RE	0.4xDC	0.4xDC	0.4xDC	0.4xDC	0.4xDC
CHW	0.2xDC	0.2xDC	0.2xDC	0.2xDC	0.2xDC
KCH	40-50	40-50	40-50	40-50	40-50
APMX	0.55-1.2xDC	0.55-1-1.2-1.5XDC	0.55-1-1.2-1.5XDC	0.55-1-1.2-1.5XDC	0.55-1-1.2-1.5XDC
Sorte	H10F/1630	H10F/1030/1620/1730	H10F/1030/1620/1730	H10F/1030/1620/1730	H10F/1030/1620/1730

C



CoroMill® 316				
	Fräskopf für die Schlichtbearbeitung	Fräskopf für das Fasfräsen	Fräskopf für die Profilbearbeitung	Fräskopf für die High Feed Sidemilling Bearbeitung
D _c mm	0,6xDC-DC	Nenndurchmesser DC	0,6xDC-DC	0,6xDC-DC
ZEFP	6/8/10/12	4/6/8	2/4	6
FHA	50	0	40	42
Schaft	EH	EH	EH	EH
RE	0.4xDC	0.4xDC	N/A	0.4xDC
CHW	0.2xDC	0.2xDC	N/A	0.2xDC
KCH	40-50	40-50	N/A	40-50
APMX	0.55-1-1.2-1.5XDC	0.55-1-1.2-1.5XDC	0,55-1-1,2-1,5XDC	0.5-1.5xDC
Sorte	H10F/1030/1620/1730	H10F/1030/1620/1730	H10F/1030/1620/1730	1745

D

E

Kundenspezifische Vollhartmetallbohrer

	CoroDrill® 860-PM	CoroDrill® 860-MM	CoroDrill® 860-NM	CoroDrill® 860-SM	CoroDrill® 861-GP	CoroDrill® 861-GM	CoroDrill® 862-GM
							
Produktausführung	Optimierte Lösung für Stahl	Optimierte Lösung für rostfreien Stahl	Optimierte Lösung für Aluminium	Optimierte Lösung für HRSA	Pilotbohrer	Bohrer für tiefe Bohrungen in verschiedenen Werkstoffen	Optimierte Lösung für kleine Durchmesser
ISO-Anwendungsbereich							
Bohrerdurchmesser	3.0 - 20.00	3.0 - 20.00	3.0 - 20.00	3.0 - 16.00	3.0 - 20.00	3.0 - 20.00	1.801 - 2.999
Bohrtiefe	<8 x Ø	<8 x Ø	<8 x Ø	<8 x Ø	<5 x Ø	<30 x Ø	<12 x Ø
Toleranzoptionen	NEIN	Ja	Ja	Ja	NEIN	NEIN	Ja
Schaftausführung	HA, HE	HA, HE	HA, HE	HA, HE	HA	HA	HA
Kühlschmierstoff	Innen & Außen	Innen	Innen & Außen	Innen & Außen	Innen	Innen	Innen
Bohrertyp	1, 2 & 3	1 & 2	1, 2 & 4	1, 2 & 3	1 & 2	1	1
Beschichtungsoptionen	NEIN	NEIN	Ja	NEIN	NEIN	NEIN	NEIN
Eckenfase	NEIN	NEIN	NEIN	NEIN	NEIN	NEIN	NEIN
Eckenradius	NEIN	NEIN	NEIN	NEIN	NEIN	NEIN	NEIN
Spitzenwinkeloptionen	NEIN	NEIN	NEIN	NEIN	NEIN	NEIN	NEIN
Fase	Einseitig	Einseitig	Einseitig	Einseitig	Einseitig	Doppelte Umfangsstützphase	Einseitig
Kantenverrundungsoptionen	NEIN	NEIN	NEIN	NEIN	NEIN	NEIN	NEIN
Polierte Spankanäle	NEIN	NEIN	NEIN	NEIN	NEIN	Standard	NEIN

B

C

D

E

Kundenspezifische Vollhartmetallbohrer

CoroDrill® 860-GM	CoroDrill® 400	CoroDrill® 430	CoroDrill® 865	CoroDrill® 460-XM	Gesteinsbohrer	CoroDrill® 452	CoroDrill® 863
							
Optimierte Lösung für verschiedene Werkstoffe	Gerader Spankanal für ISO-K	Ausführung mit drei Spankanälen für ISO-K	Kurbelwellen-Ölbohrungen ISOK & ISO-P	Flexible Lösung für verschiedene Werkstoffe	Optimierte Lösung für ISO-H	Bohren mit portablen, handgeführten Werkzeugen	Bohrer für Verbundwerkstoffe
							
3.0 - 20.00	3.0 - 25.00	3.0 - 25.00	3.0 - 10.00	3.0 - 25.00	7.0 - 20.00	2.0 - 12.7	4.0 - 11.2
<8 x Ø	<10 x Ø	<10 x Ø	<25 x Ø	<8 x Ø	<2 x Ø	<15 x Ø	<15 x Ø
Ja	Ja	Ja	NEIN	Ja	NEIN	NEIN	NEIN
HA, HE	HA & MQL	HA & MQL	HA MQL, Erweiterte Länge MMS	HA, HE, SS, RR, MQL	HA	SS	SS, HA, RR, RS, THA
Innen & Außen	Innen & Außen	Innen & Außen	Innen	Innen & Außen	Außen	Außen	Innen & Außen
1, 2, 3, 4 & 5	1, 2, 3, 4, 5 & 6	1, 2, 4, 5 & 6	1	1, 2, 3, 4 & 5	1	1,4,6	1,4
NEIN	Standard, basierend auf ISO-K Sorte	Standard, basierend auf ISO-K Sorte	NEIN	TiAlNTop, TiAlN, TiN	NEIN	NEIN	1220, N20C
Ja	Ja	Ja	NEIN	Ja	Ja	NEIN	NEIN
Ja	Ja	Ja	NEIN	Ja	Ja	NEIN	NEIN
118° - 150°	90° - 180°	110° - 180°	NEIN	90° - 180°	127°	NEIN	NEIN
Einseitig	Doppelt	Einseitig	Doppelte Umfangsstützflase	Einfach oder doppelt	Einseitig	Einfach oder doppelt	Einseitig
NEIN	Ja	Ja	NEIN	NEIN	Ja	NEIN	NEIN
NEIN	Ja	Ja	Standard	NEIN	Ja	NEIN	NEIN

Kundenspezifische Gewindebohrer

	CoroTap™ 100	CoroTap™ 200	CoroTap™ 300	CoroTap™ 400
				
ISO-Anwendungsbereich				
Substrat	HSS-E-PM/Vollhartmetall	HSSE/HSS-E-PM	HSSE/HSS-E-PM	HSS-E-PM
Gewindeform	M,MF,UNC,UNF,UNJC,UNJF	M,MF,UNC,UNF,UN,UNEF,UNJC,UNJF,G	M,MF,UNC,UNF,UN,UNEF,UNJC,UNJF,G	M,MF,UNC,UNF,UN,UNEF,UNJC,UNJF,G
Gewindegröße	M8-M16 1/4-5/8	M6-M16 1/4-5/8	M6-M16 1/4-5/8	M2-M16 4-40-5/8
BSG	DIN371,DIN376,DIN/ANSI	DIN371,DIN376,DIN/ANSI,ISO,ANSI,JIS	DIN371,DIN376,DIN/ANSI,ISO,ANSI,JIS	DIN2174,ISO,ANSI,DIN-ANSI,JIS
FHA			15,40,45	
Anzahl der Spankanäle	4/5	3/4	3/4	Abhängig vom Gewindedurchmesser
Schnitttrichtung	Rechts- oder Linksausführung	Rechts- oder Linksausführung	Rechts- oder Linksausführung	Rechts- oder Linksausführung
TCTR	4H,6H,6G,4HX,6HX,2B,2BX,3B,3BX	4H,6H,6G,4HX,6HX,6GX,7H,7G,7GX,2B,2BX,3B,3BX	4H,6H,6G,4HX,6HX,6GX,7H,7G,7GX	4H,4HX,6H,6HX,6G,6GX,7G,7GX,7H,2B,2BX,3B,3BX
Übermaß / Untermaß	+/- 0.1 mm	+/- 0.1 mm	+/- 0.1 mm	+/- 0.1 mm
Fasentyp	C,E,F	E,C,B,A	E,C,B,A	C,E,F,A,B
LF	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung
THL	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung
LU	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung	Je nach Gewindebohrerausführung
Kühlschmierstoff	Kein, axial, radial	Kein, axial, radial	Kein, axial, radial	Kein, axial, radial
Sorte	D210,D215,E210	Cooltop,TIN,TICN,	Cooltop,TIN,TICN,	F125,F150,F115
Zusätzliche Merkmale	Rückwärtige Fase, Standard	Rückwärtige Fase, Unterbrochene Gewinde	Rückwärtige Fase, Unterbrochene Gewinde	

B

C

D

E

Kundenspezifische Vollhartmetall-Reibahlen

B



	CoroReamer® 435	CoroReamer™ 835 -PF	CoroReamer™ 835
			
Produktausführung	Flexible Lösungen	Optimierte Lösung ISO-P	Optimierte Lösung für M, N, H & Titan
ISO Anwendungsbereich			
Bohrerdurchmesser, mm	2.80 - 20.20	2.80 - 20.20	3.701 - 20.20
Bohrungstyp	Durchgangs- & Grundbohrungen	Durchgangs- & Grundbohrungen	Durchgangs- & Grundbohrungen
Bohrungstoleranzoptionen	Ja	Ja	Ja
Kühlschmierstoff	Innen	Innen	Innen
Beschichtungsoptionen	NEIN	NEIN	NEIN

C

D

E

Um Ihnen das Leben leichter zu machen, gibt es eine neue Norm

ISO 13399 ist eine internationale Norm, die einen einfacheren Austausch von Schneidwerkzeugdaten anstrebt. Sie werden bei jedem Werkzeug leicht veränderte Parameter und Beschreibungen feststellen.

Zum ersten Mal gibt es eine standardisierte Form der Produktdatenbeschreibung für Zerspanungswerkzeuge. Durch die Verwendung der gleichen Parameter und Definitionen in der Werkzeugbranche wird ist die Kommunikation von Werkzeugdaten zwischen verschiedenen Softwaresystemen deutlich vereinfacht.

Und was bedeutet das für Sie?

Einfach gesagt heißt das, dass Ihr System mit unserem kommunizieren kann, denn sie sprechen dieselbe Sprache. Laden Sie Produktdaten von unserer Webseite herunter und verwenden Sie diese direkt in Ihrer CAD/CAM Software, um Werkzeuge zusammenzustellen, die Sie in der Fertigung benötigen. Kein langes Suchen nach Informationen in Katalogen und Auslegen von Daten. Denken Sie nur, wie viel Zeit Sie dadurch sparen!

Kurzname	Bevorzugte Bezeichnung
ADJLN	Minimale Verstellgrenze
ADJLX	Maximale Verstellgrenze
ADJRG	Verstellbereich
ALP	Axialfreiwinkel
AN	Hauptfreiwinkel
ANN	Normalfreiwinkel, Nebenschneide
APMX	Maximale Schnitttiefe
APMX_EFW	Max. Schnitttiefe - Endvorschub
APMX_FFW	Max. Schnitttiefe - Seitenvorschub
AZ	Maximale Eintauchtiefe
B	Schaftbreite
BAWS	Werkzeugwinkel, werkstückseitig
BAMS	Körperwinkel Maschinenseite
BBD	Konstruktiv gewuchtete Ausführung
BBR	Individuell gewuchtete Ausführung
BCH	Eckenfasenlänge
BD	Körperdurchmesser
BHTA	Körperkegeleinstellwinkel
BN	Planfasenbreite
BS	Planschneidenbreite
BSG	Norm/Standard
BSR	Wiper Eckenradius
CDX	Einstechtiefe, max.
CEMR	Hauptschneidenradius
CF	Spitzenfase
CHBA	Fasenwinkel am Körper
CHBL	Eckenfasenlänge
CHW	Eckenfasenbreite
CICT	Anzahl Schneidteile
CICT _E	Anzahl Schneidteile - umfangseitig
CICT _P	Anzahl Schneidteile - Zwischenposition
CICT _S	Anzahl Schneidteile - stirnseitig
CICT _T	Anzahl Schneidteile - gesamt
CND	Kühlschmierstoffeintrittsdurchmesser
CNSC	Kühlschmierstoffeintritt
CNT	Gewindegröße Kühlschmierstoff-Einlass
COATING	Beschichtung
CP	Max. Kühlschmierstoffdruck
CRKS	Anzugsbolzen, Gewindegröße
CRNT	Gewindegröße radialer Kühlschmierstoff-Einlass
CTPT	Bearbeitungstyp
CUTDIA	Maximaler Werkstückdurchmesser für das Abstechen
CW	Schnittbreite, Nennmaß
CWN	Minimale Schnittbreite
CWTOLL	Untere Schnittbreitentoleranz
CWTOLU	Obere Schnittbreitentoleranz
CWX	Schnittbreite, max.
CXSC	Kühlschmierstoffaustrittscode
CZC	Aufnahmegröße
CZC _{MS}	Anschlussgröße (Code), maschinenseitig
CZC _{WS}	Anschlussgröße (Code), werkstückseitig
D1	Durchmesser Befestigungsbohrung
DAH	Durchmesser Zugangsbohrung
DAXIN	Axialer Einstechdurchmesser, min.

B

C

D

E

DAXN	Minimaler Außendurchmesser der Axialnut
DAXX	Maximaler Außendurchmesser der Axialnut
DBC	Schneidendurchmesser
DC	Werkzeugdurchmesser
DCB	Spanndurchmesser, nominal, werkstückseitig
DCBN	Spanndurchmesser, min.
DCBX	Spanndurchmesser, max.
DCF	Funktionsdurchmesser
DCIN	Schnittdurchmesser innen
DCN	Minimaler Schnittdurchmesser
DCON	Aufnahmedurchmesser, werkstückseitig
DCON _{MS}	Schaftdurchmesser, maschinenseitig
DCON _{WS}	Aufnahmedurchmesser, werkstückseitig
DCPS	Datenchip Bereitstellungsgröße
DCSF _{MS}	Durchmesser, Plananlage, maschinenseitig
DCSF _{WS}	Durchmesser, Plananlage, werkstückseitig
DCX	Schneidendurchmesser, max.
DHUB	Nabendurchmesser
DIX	Maximaler Schnittstellendurchmesser des Werkzeugwechslers
DMIN	Bohrungsdurchmesser, min.
DMM	Aufnahmedurchmesser, maschinenseitig
DN	Durchmesser des Freistichs
DRVCT	Antriebsanzahl
DSGN	Design
EPSR	Eckenwinkel Schneidplatte
FHA	Drallwinkel
FLGT	Flanschdicke
FTDZ	Gewindetyp
H	Schafthöhe
HA	Theoretische Gewindehöhe
HB	Unterschied Gewindehöhe
HBH	Gewindehöhendifferenz
HC	Gewindehöhe
HF	Funktionshöhe
HRY	Tiefster Punkt von der Bezugsebene aus
HTB	Körperhöhe
HTH	Höhe
IC	Einbeschriebener Kreis
INSL	Schneidplattenlänge
INSUC	Code zur Schneidplattenverwendung
IZC	Code Plattengröße
KAPR	Winkel Werkzeugschneidkante
KAPR_EFW	Einstellwinkelart - Endvorschub
KCH	Eckenfase
KRINS	Einstellwinkel, Hauptschneide
KWW	Keilnutbreite
L	Schneidkantenlänge
LAMS	Neigungswinkel
LB	Grundkörperlänge
LCF	Spankanallänge
LCOX	Maximale Kürzungslänge
LE	Schneidenlänge begrenzt
LF	Funktionslänge
LFN	Minimale funktionale Länge
LH	Kopflänge
LPR	Kraglänge
LS	Schaftlänge
LSC	Einspannlänge
LSCN	Spannlänge, min.
LSCS	Abstand zum Einspannbeginn
LSCX	Einspannlänge, max.
LSD	Schaftlänge
LU	Nutzlänge
LU_BFW	Nutzlänge - rückwärtiges Anspiegeln
LUX	Nutzlänge. max.
MHD	Abstand Bohrung 1
MIID	Bezeichnung Schneidplatte
MIID _E	Bezeichnung Schneidplatte - Endposition
MIID _S	Bezeichnung Schneidplatte - Seitenposition
MIID _C	Bezeichnung Schneidplatte - Zentrumsposition
MIID _P	Bezeichnung Schneidplatte - Außenposition
MIID _I	Bezeichnung Schneidplatte - Zwischenposition
MMCC	Code für Vorspannmoment
MMCX	Max. Schnittmoment
NOF	Anzahl Schneiden
NT	Zähnezahl
OAH	Gesamthöhe
OAL	Gesamtlänge
OAW	Gesamtbreite

OH	Empfohlene Auskraglänge
OHN	Minimale Auskraglänge
OHX	Maximale Auskraglänge
ORDCODE	Bestellnummer
PCL	Periphere zylindrische Länge
PDX	Profilabstand ex
PDY	Profilabstand ey
PHD	Ausgangsdurchmesser
PHDX	Ausgangsdurchmesser, max.
PL	Abstand Schneidenlänge zu Schneidenspitze
PNA	Profilwinkel
PRFRAD	Profilradius
PRSPC	Profilspezifikation
PSIR	Hauptschneidenwinkel
PSIRL	Hauptschneidenwinkel links
PSIRR	Hauptschneidenwinkel rechts
PSW	Vorbearbeitete Nutenbreite
RADH	Radialhöhe
RADW	Radialbreite
RAR	Nebenschneidenwinkel, rechts
RE	Eckenradius
REL	Eckenradius links
RER	Eckenradius rechts
RETOLL	Untere Eckenradiustoleranz
RETOLU	Obere Eckenradiustoleranz
RGL	Nachschleiflänge
RMPX	Eintauchwinkel, max.
RPMX	Drehzahl, max.
S	Schneidplattendicke
SDL	Länge des Stufendurchmessers
SIG	Spitzenwinkel
SPTL	Splitline
SSC	Code Plattensitzgröße
SSC _E	Plattensitzkodierung - Endposition
SSC _P	Plattensitzkodierung - Außenposition
SSC _S	Plattensitzkodierung - Seitenposition
STA	Eingeschlossener Stufenwinkel
SUBSTRATE	Substrat
TCDC	Toleranzklasse, Aufnahmedurchmesser
TCDCON	Toleranz Schaftdurchmesser
TCDDMM	Aufnahmedurchmesser, maschinenseitig, ISO-Toleranzklasse
TCHA	Erreichbare Bohrungstoleranz
TCHAL	Untere erreichbare Bohrungstoleranz
TCHAU	Obere erreichbare Bohrungstoleranz
TCT	Werkzeugtoleranzklasse
TCTR	Gewindetoleranzklasse
TD	Gewindenennndurchmesser, metrisch
TDZ	Gewindennummer
TFLA	Gewindebohrer, Längenausgleich vorne
TFLB	Gewindebohrer, Längenausgleich hinten
TG	Abschrägungsgradient
THBTP	Nach hinten abgeflachte Zähne
THCA	Korrekturwinkel Gewindesteigung
THCHT	Anschnitt
THFT	Gewindeart
THFTS	Gewindeformstandardserie
THL	Gewindelänge
THUB	Nabendicke
TP	Gewindesteigung
TPI	Gangzahl je Inch
TPIN	Gangzahl je Inch, min.
TPIX	Gangzahl je Inch, max.
TPN	Gewindesteigung, min.
TPT	Gewindeprofiltyp
TPX	Gewindesteigung, max.
TRMAX	Max. Gewindebereich
TQ	Drehmoment
TSYC	Code für Werkzeugtyp
TTP	Gewindetyp
ULDR	Verhältnis nutzbare Länge/Durchmesser
VCX	Max. Schnittgeschwindigkeit
W1	Schneidplattenbreite
WB	Grundkörperbreite
WF	Funktionsbreite
WFCIRP	Breite zum Bezugspunkt des Zerspanungsteils
WSC	Spannbreite
WT	Masse (Gewicht)
ZEFF	Anzahl wirksamer Schneiden, stirnseitig
ZEFP	Anzahl wirksamer Schneiden, umfangseitig
ZWX	Maximale Anzahl Wiper-Wendeplatten

Umrechnungstabelle

Metrische in englische Maße

Abstand
1 Meter = 39,370 Zoll
1 Meter = 3,281 Fuß
1 Millimeter = 0,039 Zoll

Gewicht
1 Kilogramm = 2,205 Pfund
1 Kilogramm = 35,274 Unzen

Drehmoment
1 Newton meter (Nm) = 0.738 ft-lbs
1 Newton meter (Nm) = 8.851 ft-lbs

Englische in metrische Maße

Abstand
1 Zoll = 25,4 Millimeter
1 Fuß = 0,3 Meter
1 Fuß = 304,8 Millimeter

Gewicht
1 Pfund = 0,45 Kiogramm
1 Unze = 28,35 Gramm

Drehmoment
1 Pfund-Kraft Fuß (ft-lbf) = 1,4 Newtonmeter (Nm)
1 Pfund-Kraft Zoll (in-lbf) = 0,1 Newtonmeter (Nm)

Formeln und Definitionen

v_c = Schnittgeschwindigkeit
 n = Spindeldrehzahl
 v_f = Tischvorschub
 z_n = Gesamtanzahl der Schneidkanten
 z_c = Anzahl effektiver Schneidkanten
 f_z = Vorschub pro Zahn
 f_n = Vorschub pro Umdrehung
 h_{ex} = maximale Spandicke
 a_p = Schnitttiefe
 l_a = Breite der Wendeschneidplatte
 a_e = Schnittbreite
 a_e/D_c % = Radialer Eingriff
 T = Bearbeitungszeit
 Q = Zerspanungsleistung
 n_{ap} = Anzahl der Durchgänge
TPI = Gewindegänge pro Zoll
 k_c = spezifische Schnittkraft
 R_a = Oberflächenrauheit

Metrisch	Englische Maßeinheit
m/min (Meter/Minute)	ft/min (Fuß/Minute)
U/min (Umdrehungen pro Minute)	
mm/min	Zoll/min.
mm/z	Zoll/z
mm/U	Zoll/Umdr.
mm	Zoll
mm	Zoll
mm	Zoll
mm	Zoll
%	%
min.	min.
cm³/min	Zoll³/min.
N/mm²	lbs/Zoll²
µm	µin

Wendeschneidplattengröße

iC = einbeschriebener Kreis in Zoll

 = Schneidkantenlänge in mm

Ifind

Unsere nützlichsten Tools für Sie zusammengestellt

Sie sind online, unterwegs und in der Fertigung. Wo auch immer Sie sind: Sie finden alle Funktionen, die Sie benötigen, in der Ifind-App.

Die App hilft Ihnen dabei, Werkzeuge, Lösungen oder die für Ihre Arbeit benötigten Informationen zu finden. Sie können Werkzeugempfehlungen erhalten, Käufe tätigen, Ihre Bestellung verfolgen und sich sogar weiterbilden. Was möchten Sie heute machen?

Alles, was Sie in der Ifind-App finden, steht auf jedem beliebigen Gerät zur Verfügung.



Nachschleifen

Wir bieten mehr als nur das traditionelle “Nachschleifen”. Wir garantieren eine reproduzierbare Originalleistung für reduzierte Kosten pro Anwendung.

B

Unser Angebot



100%

Zuverlässigkeit
Unsere Spezialisten stehen Ihnen für Support und Know-how stets zur Verfügung.



x3

Original-Leistung
Garantierte Wiederaufbereitung Ihrer Werkzeuge in Original-Qualität – bis zu drei Nachschleiffe.



50%

Einsparungen
Durch Wiederaufbereitung können Sie Ihre Werkzeugkosten um bis zu 50% senken.

Produkte mit Wiederaufbereitungsservice



Bohren



Fräsen



Reiben



Wie durch das Wiederaufbereitungs-Symbol auf den Familien- und Produktseiten angegeben.

C

Zusatzinformationen



D

Nachschleifbox
Die Box ist in zwei Größen bestellbar:
- Klein (300 x 200 x 138 mm)
Artikelnummer: 6949557

- Mittelgroß (400 x 300 x 138 mm)
Artikelnummer: 6949558

Alle Sandvik Coromant Werkzeugtypen können in derselben Box verschickt werden.



Nachschleifservice
Vor dem Nachschleiff werden Ihre Bohrer einer gründlichen Inspektion zur Feststellung der Nachschleiffähigkeit unterzogen. Nicht nachschleiffähige Bohrer werden zurückgeschickt

- Jedes Nachschleifen wird durch Laserbeschriftung auf dem Schaft vermerkt
- Die Werkzeuge werden in Originalverpackung zurückgesendet



- Was geschieht mit Ihren Werkzeugen?**
- Komplette Geometrie wird wiederhergestellt
 - Bohrerlänge wird reduziert
 - Schaftfräserdurchmesser und -länge werden reduziert (Minstdurchmesser ist ca. 0.9xDc)
 - Reibahlentoleranz bleibt erhalten

E

Für Preise wenden Sie sich bitte an Ihren Sandvik Coromant Ansprechpartner.

Der Umwelt zuliebe

Nutzen Sie das Coromant Recycling Concept (CRC)!

- Das Coromant Recycling Concept (CRC) ist ein umfassender Service für gebrauchte Hartmetall-Wendeschneidplatten und Vollhartmetallwerkzeuge - ein Angebot für alle Kunden von Sandvik Coromant. Vor dem Hintergrund eines steigenden Verbrauchs von nicht erneuerbaren Rohstoffen ist der wirtschaftliche Umgang mit schwindenden Ressourcen Aufgabe eines jeden Herstellers. Sandvik Coromant bietet an, gebrauchte Hartmetallwendeschneidplatten und Vollhartmetallwerkzeuge auf umweltfreundliche Weise zu sammeln und zu recyceln. Alle gebrauchten Hartmetallwendeschneidplatten werden in der Sammelbox am Arbeitsplatz gesammelt. Der Inhalt wird in die Transportbox übertragen. Wenn die Transportbox voll ist, wird sie an die nächstgelegene Sandvik Coromant-Niederlassung oder an Ihren Sandvik Coromant-Händler gesendet.
- Dieser kann Ihnen auch weitere Informationen geben.
- Die Vorteile des CRC sprechen für sich
- Ein weltweites Recycling-System unter einem Dach.
- Für Direktkunden und Händler.
- Einfaches Verfahren mit Sammel- und Transportboxen.
- Weniger Abfall, weniger Belastung für die Umwelt.
- Bessere Nutzung der Ressourcen.
- Hartmetall-Wendeschneidplatten anderer Hersteller werden ebenfalls angenommen.



Bestellen Sie eine Sammelbox für jede Drehmaschine, Fräsmaschine, jeden Bohrer oder für Ihr Bearbeitungszentrum. Wir empfehlen für jeden Arbeitsplatz eine Sammelbox für Wendeschneidplatten und eine separate Box für Vollhartmetallwerkzeuge. Für weitere Angaben über den Verkauf Ihrer gebrauchten Wendeschneidplatten und Vollhartmetallwerkzeuge, besuchen Sie bitte sandvik.coromant.com und wählen Sie Ihren Markt aus.

Sammelbox:

Transportbox für Vollhartmetallwerkzeuge (Holz):

Transportbox für Wendeschneidplatten (Holz):

Bestellnummern

91617

92994

92995

Sicherheitshinweise

Sicherheitsinformationen in Verbindung mit Schleifen von Hartmetall

Zusammensetzung des Werkzeugmaterials

Werkzeughalter

Werkzeughalter bestehen überwiegend aus Eisen (FE) und niedriglegierten Legierungselementen wie z.B. Chrom, Nickel, Mangan, Molybdän und Silizium.

Wendeschneidplatten/Schneideinsätze/Vollhartmetallwerkzeuge

Substanzen in Hartmetallprodukten enthalten überwiegend Wolframkarbid und Kobalt. Sie könnten auch Karbide und Karbonnitride der folgenden Elemente enthalten: Titan, Tantal, Niob, Chrom, Molybdän und Vanadium.

Wege der Exposition

Durch das Schleifen oder Erhitzen von Hartmetall-Rohlingen oder Hartmetallprodukten entstehen Stäube oder Dämpfe mit gefährlichen Inhaltsstoffen, die eingeatmet oder verschluckt werden können oder mit Augen oder Haut in Berührung kommen können.

Akute Toxizität

Der Staub ist giftig beim Einatmen. Das Einatmen kann Reizungen oder Entzündungen der Atemwege hervorrufen. Eine signifikant höhere akute Toxizität durch Einatmen wurde festgestellt beim gleichzeitigen Einatmen von Kobalt und Wolframkarbid im Vergleich dazu, wenn ausschließlich Kobalt eingeatmet wird.

Berührung mit der Haut kann Reizungen und Ausschläge verursachen. Bei sensibilisierten Personen können allergische Reaktionen auftreten.

Chronische Toxizität

Ein wiederholtes Einatmen von kobalthaltigen Aerosolen kann Behinderungen der Atemwege erzeugen. Anhaltendes Einatmen von erhöhten Konzentrationen können eine Lungenfibrose oder Lungenkrebs verursachen. Epidemiologische Untersuchungen haben ergeben, dass Mitarbeiter, die in der Vergangenheit hohen Konzentrationen von Wolframkarbid/Kobalt ausgesetzt waren, stärker gefährdet sind, an Lungenkrebs zu erkranken.

Kobalt und Nickel sind mögliche Hautreizstoffe. Wiederholter oder langfristiger Hautkontakt kann zu Hautreaktionen führen.

Risiken

Toxisch: Gefahr ernsthafter gesundheitlicher Schäden durch langfristiges Einatmen.

Toxisch durch Einatmen.

Kein ausreichender Nachweis für Krebsrisiken.

Kann zu Reaktionen durch Einatmen und Hautkontakt führen.

Vorbeugende Maßnahmen

Staub nicht einatmen. Bildung von Staub vermeiden. Lokales Luftabzugssystem verwenden, das dazu geeignet ist, die persönliche Exposition auf Werte weit unter den national erlaubten Grenzwerten zu beschränken.

Bei unzureichender oder nicht vorhandener Belüftung ein Atemschutzgerät anlegen, dessen Verwendung für diese Zwecke behördlich genehmigt wurde.

Schutzbrillen mit seitlichen Schutzschilden tragen.

Vermeiden Sie wiederholten Hautkontakt. Tragen Sie geeignete Handschuhe. Waschen Sie gründlich Ihre Hände.

Geeignete Schutzkleidung tragen. Kleidung nach Bedarf waschen.

Bei der Arbeit nicht essen, trinken, rauchen. Vor dem Essen, Trinken oder Rauchen Hände sorgfältig abwaschen.



Werkstoff-Vergleichstabelle

ISO	MC	CMC-Nr.	Land										
			Europa	Deutsch-land	Großbritannien		Schwe-den	USA	Frankreich	Italien	Spanien	Japan	
			Standard										
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS	
P	Unlegierter Stahl												
	P1.1.Z.AN	01.1	S235JR G2	1.0038	4360 40 C	-	1311	A570.36	E 24-2 Ne	-	-	STKM 12A;C	
	P1.1.Z.AN	01.1	S235J2 G3	1.0116	4360 40 B	-	1312	A573-81 65	E 24-U	Fe37-3	-	-	
	P1.1.Z.AN	01.1	C15	1.0401	080M15	-	1350	1015	CC12	C15C16	F.111	-	
	P1.1.Z.AN	01.1	C22	1.0402	050A20	2C/2D	1450	1020	CC20	C20C21	F.112	-	
	P1.1.Z.AN	01.1	C15E	1.1141	080M15	32C	1370	1015	XC12	C16	C15K	S15C	
	P1.1.Z.AN	01.1	C25E	1.1158	-	-	-	1025	-	-	-	S25C	
	P1.1.Z.AN	01.1	S380N	1.8900	4360 55 E	-	2145	A572-60	-	FeE390KG	-	-	
	P1.1.Z.AN	01.1	17MnV7	1.0870	4360 55 E	-	2142	A572-60	NFA 35-501 E 36	-	-	-	
	P1.1.Z.AN	02.1	55Si7	1.0904	250A53	45	2085	9255	55S7	55Si8	56Si7	-	
	P1.1.Z.AN	02.2	-	-	-	-	2090	9255	55S7	-	-	-	
	P1.2.Z.AN	01.2	C35	1.0501	060A35	-	1550	1035	CC35	C35	F.113	-	
	P1.2.Z.AN	01.2	C45	1.0503	080M46	-	1650	1045	CC45	C45	F.114	-	
	P1.2.Z.AN	01.2	40Mn4	1.1157	150M36	15	-	1039	35M5	-	-	-	
	P1.2.Z.AN	01.2	36MN5	1.1167	-	-	2120	1335	40M5	-	36Mn5	SMn438(H)	
	P1.2.Z.AN	01.2	28Mn6	1.1170	150M28	14A	-	1330	20M5	C28Mn	-	SCMn1	
	P1.2.Z.AN	01.2	C35G	1.1183	060A35	-	1572	1035	XC38TS	C36	-	S35C	
	P1.2.Z.AN	01.2	C45E	1.1191	080M46	-	1672	1045	XC42	C45	C45K	S45C	
	P1.2.Z.AN	01.2	C53G	1.1213	060A52	-	1674	1050	XC48TS	C53	-	S50C	
	P1.2.Z.AN	01.3	C55	1.0535	070M55	-	1655	1055	-	C55	-	-	
	P1.2.Z.AN	01.3	C55E	1.1203	070M55	-	-	1055	XC55	C50	C55K	S55C	
	P1.2.Z.AN	02.1	S275J2G3	1.0144	4360 43C	-	1412	A573-81	E 28-3	-	-	SM 400A;B;C	
	P1.2.Z.AN	02.1	S355J2G3+C2	1.0570	4360 50B	-	2132	-	E36-3	Fe52BFN/Fe52CFN	-	SM490A;B;C;YA;YB	
	P1.2.Z.AN	02.1	S355J2G3	1.0841	150 M 19	-	2172	5120	20 MC 5	Fe52	F-431	-	
	P1.3.Z.AN	01.3	C60E	1.0601	080A62	43D	-	1060	CC55	C60	-	-	
	P1.3.Z.AN	01.3	C60E	1.1221	080A62	43D	1678	1060	XC60	C60	-	S58C	
	P1.3.Z.AN	01.4	C101E	1.1274	060 A 96	-	1870	1095	XC 100	-	F-5117	-	
	P1.3.Z.AN	01.4	C101u	1.1545	BW 1A	-	1880	W 1	Y105	C36KU	F-5118	SK 3	
	P1.3.Z.AN	01.4	C105W1	-	BW2	-	2900	W210	Y120	C120KU	F.515	SUP4	
	P1.3.Z.AN	02.1	S340 MGC	1.0961	-	-	-	9262	60SC7	60SiCr8	60SiCr8	-	
	P1.4.Z.AN	01.1	11SMn30	1.0715	230M07	-	1912	1213	S250	CF9SMn28	11SMn28	SUM22	
	P1.4.Z.AN	01.1	11SMnPb30	1.0718	-	-	1914	12L13	S250Pb	CF9SMnPb28	11SMnPb28	SUM22L	
	P1.4.Z.AN	01.1	10SPb20	1.0722	-	-	-	-	10PbF2	CF10SPb20	10SPb20	-	
	P1.4.Z.AN	01.1	11SMn37	1.0736	240M07	1B	-	1215	S 300	CF9SMn36	12SMn35	-	
	P1.4.Z.AN	01.1	11SMnPb37	1.0737	-	-	1926	12L14	S300Pb	CF9SMnPb36	12SMnP35	-	
	P1.4.Z.AN	01.2	35S20	1.0726	212M36	8M	1957	1140	35MF4	-	F210G	-	
	P1.5.C.UT	01.1	GC16E	1.1142	030A04	1A	1325	1115	-	-	-	-	
	Stahl	Niedriglegierter Stahl											
		P2.1.Z.AN	02.1	16Mo3	1.5415	1501-240	-	2912	A204Gr.A	15D3	16Mo3KW	16Mo3	-
		P2.1.Z.AN	02.1	14Ni6	1.5622	-	-	-	A350LF5	16N6	14Ni6	15Ni6	-
		P2.1.Z.AN	02.1	21NiCrMo2	1.6523	805M20	362	2506	8620	20NCD2	20NiCrMo2	20NiCrMo2	SNCM220(H)
		P2.1.Z.AN	02.1	17CrNiMo6	1.6587	820A16	-	-	-	18NCD6	-	14NiCrMo13	-
		P2.1.Z.AN	02.1	15Cr3	1.7015	523M15	-	-	5015	12C3	-	-	SCR415(H)
		P2.1.Z.AN	02.1	55Cr3	1.7176	527A60	48	-	5155	55C3	-	-	SUP9(A)
		P2.1.Z.AN	02.1	15CrMo5	1.7262	-	-	2216	-	12CD4	-	12CrMo4	SCM415(H)
		P2.1.Z.AN	02.1	13CrMo4-5	1.7335	1501-620Gr27	-	-	A182 F11;F12	15CD3.5	14CrMo4 5	14CrMo45	-
										15CD4.5			
		P2.1.Z.AN	02.1	10CrMo9 10	1.7380	1501-622 Gr.31;45	-	2218	A182 F.22	12CD9, 10	12CrMo9, 10	TU.H	-
		P2.1.Z.AN	02.1	14MoV6 3	1.7715	1503-660-440	-	-	-	-	-	13MoCrV6	-
		P2.1.Z.AN	02.1	50CoMo4	1.7228	823M30	33	2512	-	-	653M31	-	-
		P2.1.Z.AN	02.2	14NiCr10	1.5732	-	-	-	3415	14NC11	16NiCr11	15NiCr11	SNC415(H)
		P2.1.Z.AN	02.2	14NiCr14	1.5752	655M13; A12	36A	-	3415;3310	12NC15	-	-	SNC815(H)
		P2.1.Z.AN	02.1/02.2	16MnCr5	1.7131	(527M20)	-	2511	5115	16MC5	16MnCr5	16MnCr5	-
		P2.1.Z.AN	02.1/02.2	34CrMo4	1.7220	708A37	19B	2234	4137;4135	35CD4	35CrMo4	34CrMo4	SCM432;SCCRM3
		P2.1.Z.AN	02.1/02.2	41CrMo4	1.7223	708M40	19A	2244	4140;4142	42CD4TS	41CrMo4	42CrMo4	SCM 440
P2.1.Z.AN		02.1/02.2	42CrMo4	1.7225	708M40	19A	2244	4140	42CD4	42CrMo4	42CrMo4	SCM440(H)	
P2.1.Z.AN		03.11	14NiCrMo134	1.6657	832M13	36C	-	-	-	15NiCrMo13	14NiCrMo131	-	
P2.2.Z.AN		02.1	31CrMo12	1.8515	722 M 24	-	2240	-	30 CD 12	30CrMo12	F-1712	-	
P2.2.Z.AN		02.1	39CrMoV13 9	1.8523	897M39	40C	-	-	-	36CrMoV12	-	-	
P2.2.Z.AN		02.1	41CrS4	1.7039	524A14	-	2092	L1	-	105WCR 5	-	-	
P2.2.Z.AN		02.1	50NiCr13	1.2721	-	-	2550	L6	55NCV6	-	F-528	-	
P2.2.Z.AN		03.11	45WCrV7	1.2542	BS1	-	2710	S1	-	45WCrV8KU	45WCrSi8	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	36CrNiMo4	1.6511	816M40	110	-	9840	40NCD3	38NiCrMo4(KB)	35NiCrMo4	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	34CrNiMo6	1.6582	817M40	24	2541	4340	35NCD6	35NiCrMo6(KB)	-	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	34Cr4	1.7033	530A32	18B	-	5132	32C4	34Cr4(KB)	35Cr4	SCR430(H)	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	41Cr4	1.7035	530A40	18	-	5140	42C4	41Cr4	42Cr4	SCR440(H)	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	32CrMo12	1.7361	722M24	40B	2240	-	30CD12	32CrMo12	F.124.A	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	51CrV4	1.8159	735A50	47	2230	6150	50CV4	50CrV4	51CrV4	SUP10	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	41CrAlMo7	1.8509	905M39	41B	2940	-	40CAD6, 12	41CrAlMo7	41CrAlMo7	-	
P2.3.Z.AN		02.1	100Cr6	1.3505	534A99	31	2258	52100	100C6	100Cr6	F.131	SUJ2	

Werkstoff-Vergleichstabelle

ISO	MC	CMC-Nr.	Land									
			Europa	Deutschland	Großbritannien	Schwe- den	USA	Frankreich	Italien	Spanien	Japan	
			Standard									
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
P	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	105WCr6	1.2419	-	-	2140	-	105WC13	10WCr6	105WCr5	SKS31
	P2.3.Z.AN/H1.2.Z.HA	-	-	-	-	-	-	-	-	107WCr5KU	-	SKS2, SKS3
	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	-	1.2714	-	-	-	L6	55NCDV7	-	F.520.S	SKT4
	P2.3.Z.AN/H1.3.Z.HA	02.1/02.2	100Cr6	1.2067	BL3	-	-	L3	Y100C6	-	100Cr6	-
	P2.4.Z.AN	02.1	16MnCr5	1.7139	-	-	2127	-	-	-	-	-
	P2.5.Z.HT	02.1	16Mo5	1.5423	1503-245-420	-	-	4520	-	16Mo5	16Mo5	-
	P2.5.Z.HT	02.1	40NiCrMo8-4	1.6562	311-Type 7	-	-	8740	-	40NiCrMo2(KB)	40NiCrMo2	SNCM240
	P2.5.Z.HT	02.1	42Cr4	1.7045	-	-	2245	5140	-	-	42Cr4	SCr440
	P2.5.Z.HT	02.1	31NiCrMo14	1.5755	830 M 31	-	2534	-	-	-	F-1270	-
	P2.5.Z.HT	02.2	36NiCr6	1.5710	640A35	111A	-	3135	35NC6	-	-	SNC236
	P2.6.C.UT	02.1	22Mo4	1.5419	605A32	-	2108	8620	-	-	F520.S	-
	P2.6.C.UT	02.1/02.2	25CrMo4	1.7218	1717CDS110	-	2225	4130	25CD4	25CrMo4(KB)	AM26CrMo4	SCM420;SCM430
	P2.6.C.UT	06.2	-	-	-	-	2223	-	-	-	-	-
Hochlegierter Stahl												
Stahl	P3.0.Z.AN	03.11	X210Cr12	1.2080	BD3	-	-	D3	Z200C12	X210Cr13KU X250Cr12KU	X210Cr12	SKD1
	P3.0.Z.AN	03.11	X43Cr13	1.2083	-	-	2314	-	-	-	-	-
	P3.0.Z.AN	03.11	X40CrMoV5 1	1.2344	BH13	-	2242	H13	Z40CDV5	X35CrMoV05KU X40CrMoV511KU	X40CrMoV5	SKD61
	P3.0.Z.AN	03.11	X100CrMoV5 1	1.2363	BA2	-	2260	A2	Z100CDV5	X100CrMoV51KU	X100CrMoV5	SKD12
	P3.0.Z.AN	03.11	X210CrW12	1.2436	-	-	2312	-	-	X215CrW12 1KU	X210CrW12	SKD2
	P3.0.Z.AN	03.11	X30WCrV9 3	1.2581	BH21	-	-	H21	Z30WCV9	X28W09KU X30WCrV9 3KU	X30WCrV9	SKD5
	P3.0.Z.AN	03.11	X165CrMoV 12	1.2601	-	-	2310	-	-	X165CrMoW12KU	X160CrMoV12	-
	P3.0.Z.AN	03.21	X155CrMoV12-1	1.2379	-	-	2736	HNv3	-	-	-	-
	P3.0.Z.HT	03.11	X8Ni9	1.5662	1501-509;510	-	-	ASTM A353	-	X10Ni9	XBNI09	-
	P3.0.Z.HT	03.11	12Ni19	1.5680	-	-	-	2515	Z18N5	-	-	-
	P3.1.Z.AN	03.11	S6-5-2	1.3343	4959BA2	-	2715	D3	Z40CSD10	15NiCrMo13	-	SUH3
	P3.1.Z.AN	03.13	-	-	BM 2	-	2722	M 2	Z85WDCV	HS 6-5-2-2	F-5603.	SKH 51
	P3.1.Z.AN	03.13	HS 6-5-2-5	1.3243	BM 35	-	2723	M 35	6-5-2-5	HS 6-5-2-5	F-5613	SKH 55
	P3.1.Z.AN	03.13	HS 2-9-2	1.3348	-	-	2782	M 7	-	HS 2-9-2	F-5607	-
	P3.2.C.AQ	06.33	G-X120Mn12	1.3401	Z120M12	-	2183	L3	Z120M12	XG120Mn12	X120Mn12	SCMnH/1
Ferritisch/martensitischer rostfreier Stahl												
Stahl	P5.0.Z.AN	05.11/15.11	X10CrAl13	1.4724	403S17	-	-	405	Z10C13	X10CrAl12	F311	SUS405
	P5.0.Z.AN	05.11/15.11	X10CrAl18	1.4742	430S15	60	-	430	Z10CAS18	X8Cr17	F3113	SUS430
	P5.0.Z.AN	05.11/15.11	X10CrAl2-4	1.4762	-	-	2322	446	Z10CAS24	X16Cr26	-	SUH446
	P5.0.Z.AN	05.11/15.11	X1CrMoTi18-2	1.4521	-	-	2326	S44400	-	-	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr13	1.4000	403S17	-	2301	403	Z6C13	X6Cr13	F3110	SUS403
	P5.0.Z.AN/P5.0.Z.HT	-	X7Cr14	1.4001	-	-	-	-	-	-	F.8401	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X10Cr13	1.4006	410S21	56A	2302	410	Z10C14	X12Cr13	F3401	SUS410
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr17	1.4016	430S15	960	2320	430	Z8C17	X8Cr17	F3113	SUS430
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrAl13	1.4002	405S17	-	-	405	Z8CA12	X6CrAl13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X20Cr13	1.4021	420S37	-	2303	420	Z20C13	X20Cr13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrMo17-1	1.4113	434S17	-	2325	434	Z8CD17.01	X8CrMo17	-	SUS434
	P5.0.Z.HT	03.11	X45CrS9-3-1	1.4718	401S45	52	-	HW3	Z45CS9	X45GrSi8	F322	SUH1
	P5.0.Z.HT	05.11/15.11	X85CrMoV18-2	1.4748	443S65	59	-	HNv6	Z80CSN20.02	X80CrSiNi20	F.320B	SUH4
	P5.0.Z.HT	05.11/15.11	X20CrMoV12-1	1.4922	-	-	2317	-	-	X20CrMoNi 12 01	-	-
	P5.0.Z.PH	05.11/15.11	X12CrS13	1.4005	416 S 21	-	2380	416	Z11CF13	X12 CrS 13	F-3411	SUS 416
	P5.0.Z.PH	05.11/15.11	X46Cr13	1.4034	420S45	56D	2304	-	Z40CM	X40Cr14	F.3405	SUS420J2
	P5.0.Z.PH	05.11/15.11	X19CrNi17-2	1.4057	431S29	57	2321	431	Z15CNI6.02	X16CrNi16	F.3427	SUS431
	P5.0.Z.PH	05.12/15.12	X5CrNiCuNb16-4	1.4542 1.4548	-	-	-	630	Z7CNU17-04	-	-	-
P5.0.Z.PH	15.21	X4 CrNiMo16-5	1.4418	-	-	2387	-	Z6CND16-04-01	-	-	-	
P5.1.Z.AN/P5.0.Z.HT	05.11/15.11	X14CrMoS17	1.4104	-	-	2383	430F	Z10CF17	X10CrS17	F3117	SUS430F	
Stahl	P2.1.Z.AN	02.1	1.0045	Handelsbezeichnungen								
	P2.2.Z.AN	02.1		OVAKO 520M (Ovako Steel)								
	P2.2.Z.AN	02.1		FORMAX (Uddeholm Tooling)								
	P2.5.Z.HT	02.2		IMACRO NIT (Imatra Steel)								
	P1.2.Z.AN			INEXA 482 (XM) (Inexa Profil)								
	P1.2.Z.AN			S355J2G3(XM)								
	P1.2.Z.AN			C45(XM)								
	P1.2.Z.AN			16MnCrS5(XM)								
	P2.5.Z.HT			INEXA280(XM)								
	P2.5.Z.HT	02.2		070M20(XM)								
	P2.5.Z.HT	02.2		HARDOX 500 (SSAB – Swedish Steel Corp.)								
	P2.5.Z.HT			WELDOX 700 (SSAB – Swedish Steel Corp.)								

Werkstoff-Vergleichstabelle

ISO	MC	CMC-Nr.	Land	Deutschland	Großbritan- nien	Schwe- den	USA	Frankreich	Italien	Spanien	Japan		
			Europa										
			Standard										
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS	
M	Austenitischer rostfreier Stahl												
	M1.0.Z.AQ	05.11/15.11	X3CrNiMo13-4	1.4313	425C11	-	2385	CA6-NM	Z4CND13.4M Z38C13M	(G)X6CrNi304	-	SCS5	
	M1.0.Z.AQ/M1.0.C.UT	05.11/15.11	X53CrMnNiN21-9	1.4871	349S54	-	-	EV8	Z52CMN21.09	X53CrMnNiN21 9	-	SUH35, SUH36	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiN18-10	1.4311	304S62	-	2371	304LN	Z2CN18.10	-	-	SUS304LN	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-13-3	1.4429	-	-	2375	316LN	Z2CND17.13	-	-	SUS316LN	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo17-12-2	1.4404	316S13	-	2348	316L	Z2CND17-12	X2CrNiMo1712	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-14-3	1.4435	316S13	-	2353	316L	Z2CND17.12	X2CrNiMo17 12	-	SCS16, SUS316L	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X3CrNiMo17-3-3	1.4436	316S33	-	2343, 2347	316	Z6CND18-12-03	X8CrNiMo1713	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-15-4	1.4438	317S12	-	2367	317L	Z2CND19.15	X2CrNiMo18 16	-	SUS317L	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiNb18-10	1.4550	347S17	58F	2338	347	Z6CNNb18.10	X6CrNiNb18 11	F.3552 F.3524	SUS347	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiMoTi17-12-2	1.4571	320S17	58J	2350	316Ti	Z6NDT17.12	X6CrNiMoTi17 12	F.3535	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X10CrNiMoNb 18-12	1.4583	-	-	-	318	Z6CNDNb17 13B	X6CrNiMoNb17 13	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X15CrNiSi20-12	1.4828	309S24	-	-	309	Z15CNS20.12	-	-	SUH309	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-11-2	1.4406	301S21	58C	2370	308	Z1NCDU25.20	-	F.8414	SCS17	
	M1.0.Z.AQ	05.21/15.21	X1CrNiMoCuN20-18-7	1.4547	-	-	2378	S31254	Z1CNDU20-18-06AZ	-	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X9CrNi18-8	1.4310	-	-	2331	301	Z12CN17.07	X12CrNi17 07	F.3517	SUS301	
	M1.0.Z.PH	05.22/15.22	X7CrNiAl17-7	1.4568 1.4504	316S111	-	-	17-7PH	Z8CNA17-07	X2CrNiMo1712	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNi19-11	1.4306	304S11	-	2352	304L	Z2CN18-10	X2CrNi18 11	-	-	
					304S12								
	M1.1.Z.AQ	05.21/15.21	-	-	304S31	58E	2332, 2333	304	Z6CN18.09	X5CrNi18 10	F.3504 F.3541	SUS304	
	M1.1.Z.AQ	05.21/15.21	X5CrNi18-10	1.4301	304S15	58E	2332	304	Z6CN18.09	X5CrNi18 10	F.3551	SUS304	
	M1.1.Z.AQ	05.21/15.21	X5CrNiMo17-2-2	1.4401	316S16	58J	2347	316	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316	
	M1.1.Z.AQ	05.21/15.21	X6CrNiTi18-10	1.4541	321S12	58B	2337	321	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523	SUS321	
	M1.2.Z.AQ	05.21/15.21	X8CrNiS18-9	1.4305	303S21	58M	2346	303	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303	
	Rostfreier Stahl	Super austenitischer (Ni>20%) rostfreier Stahl											
		M2.0.C.AQ	20.11	G-X40NiCrSi36-18	1.4865	330C11	-	-	-	-	XG50NiCr39 19	-	SCH15
		M2.0.Z.AQ	05.21/15.21	X1NiCrMoCu25-20-5	1.4539	-	-	2562	UNS V 0890A	Z2 NCDU25-20	-	-	-
		M2.0.Z.AQ	05.21/15.21	X8CrNi25-21	1.4845	310S24	-	2361	310S	Z12CN25 20	X6CrNi25 20	F.331	SUH310
		M2.0.Z.AQ	20.11	X12NiCrSi36 16	1.4864	-	-	-	330	Z12NCS35.16	F-3313	-	SUH330
		M2.0.Z.AQ	05.23/15.23	X1NiCrMoCu31-27-4	1.4563	-	-	2584	NO8028	Z1NCDU31-27-03	-	-	-
		Rostfreie (austenititische/ferritische) Duplex-Stähle											
		M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X2CrNiN23-4	1.4362	-	-	2376	S31500	-	-	-	-
		M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X8CrNiMo27-5	-	-	-	2324	S32900	-	-	-	-
		M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiN23-4	-	-	-	2327	S32304	Z2CN23-04AZ	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	-	-	-	-	2328	-	-	-	-	-	
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiMoN22-53	-	-	-	2377	S31803	Z2CND22-05-03	-	-	-	
	Rostfreier Stahl												
		M1.1.Z.AQ	05.21/15.21		1.0045	Handelsbezeichnungen SANMAC 304 (Sandvik Steel) SANMAC 304L (Sandvik Steel) SANMAC 316 (Sandvik Steel) SANMAC 316L (Sandvik Steel) 254 SMO 654 SMO SANMAC SAF 2205 (Sandvik Steel) SANMAC SAF 2507 (Sandvik Steel)							
		M1.1.Z.AQ	05.21/15.21										
		M1.1.Z.AQ	05.21/15.21										
		M1.1.Z.AQ	05.21/15.21										
		M1.0.Z.AQ	05.23/15.23										
		M2.0.Z.AQ	05.23/15.23										
		M3.2.Z.AQ	05.52/15.52										
		M3.2.Z.AQ	05.52/15.52										

B

C

D

E

Werkstoff-Vergleichstabelle

ISO	MC	CMC-Nr.	Land									
			Europa	Deutsch-land	Großbritannien	Schwe-den	USA	Frankreich	Italien	Spanien	Japan	
			Standard									
K	Temperguss											
	K1.1.C.NS	07.1	-	-	8 290/6	-	0814	-	MN 32-8	-	-	FCMB310
	K1.1.C.NS	07.1	EN-GJMB350-10	0.8135	B 340/12	-	0815	32510	MN 35-10	-	-	FCMW330
	K1.1.C.NS	07.2	EN-GJMB450-6	0.8145	P 440/7	-	0852	40010	Mn 450	GMN 45	-	FCMW370
	K1.1.C.NS	07.2	EN-GJMB550-4	0.8155	P 510/4	-	0854	50005	MP 50-5	GMN 55	-	FCMP490
					P 570/3		0858	70003	MP 60-3			FCMP540
	K1.1.C.NS	07.2	EN-GJMB650-2	0.8165	P570/3	-	0856	A220-70003	Mn 650-3	GMN 65	-	FCMP590
	K1.1.C.NS	07.3	EN-GJMB700-2	0.8170	P690/2	-	0862	A220-80002	Mn700-2	GMN 70	-	FCMP690
	Grauguss											
	K2.1.C.UT	08.1	-	-	-	-	0100	-	-	-	-	-
K2.1.C.UT	08.1	EN-GJL-100	0.6010	-	-	0110	No 20 B	Ft 10 D	-	-	FC100	
K2.1.C.UT	08.1	EN-GJL-150	0.6015	Grade 150	-	0115	No 25 B	Ft 15 D	G 15	FG 15	FC150	
K2.1.C.UT	08.1	EN-GJL-200	0.6020	Grade 220	-	0120	No 30 B	Ft 20 D	G 20	-	FC200	
K2.1.C.UT	08.2	EN-GJL-250	0.6025	Grade 260	-	0125	No 35 B	Ft 25 D	G 25	FG 25	FC250	
K2.1.C.UT	08.2	EN-JLZ	0.6040	Grade 400	-	0140	No 55 B	Ft 40 D	-	-	-	
K2.2.C.UT	08.2	EN-GJL-300	0.6030	Grade 300	-	0130	No 45 B	Ft 30 D	G 30	FG 30	FC300	
K2.2.C.UT	08.2	EN-GJL-350	0.6035	Grade 350	-	0135	No 50 B	Ft 35 D	G 35	FG 35	FC350	
K2.3.C.UT	08.3	GGL-NiCr20-2	0.6660	L-NiCuCr202	-	0523	A436 Type 2	L-NC 202	-	-	-	
Grauguss	Kugelgraphitguss											
	K3.1.C.UT	09.1	EN-GJS-400-15	0.7040	SNG 420/12	-	0717-02	60-40-18	FCS 400-12	GS 370-17	FGE 38-17	FCD400
	K3.1.C.UT	09.1	EN-GJS-400-18-LT	0.7043	SNG 370/17	-	0717-12	-	FGS 370-17	-	-	-
	K3.1.C.UT	09.1	EN-GJS-350-22-LT	0.7033	-	-	0717-15	-	-	-	-	-
	K3.1.C.UT	09.1	EN-GJS-800-7	0.7050	SNG 500/7	-	0727	80-55-06	FGS 500-7	GS 500	FGE 50-7	FCD500
	K3.2.C.UT	09.2	EN-GJS-600-3	0.7060	SNG 600/3	-	0732-03	-	FGS 600-3	-	-	FCD600
	K3.3.C.UT	09.2	EN-GJS-700-2	0.7070	SNG 700/2	-	0737-01	100-70-03	FGS 700-2	GS 700-2	FGS 70-2	FCD700
	K3.5.C.UT	-	EN-GJSA-XNiCr20-2	0.7660	Grade S6	-	0776	A43D2	S-NC 202	-	-	-
	Vermiculargraphitguss											
	K4.1.C.UT	-	EN-GJV-300									
K4.1.C.UT	-	EN-GJV-350										
K4.2.C.UT	-	EN-GJV-400										
K4.2.C.UT	-	EN-GJV-450										
K4.2.C.UT	-	EN-GJV-500										
	Austenitisch-bainitisches Gusseisen											
	K5.1.C.NS	-	EN-GJS-800-8	-	-	-	-	ASTM A897 No. 1	-	-	-	-
	K5.1.C.NS	-	EN-GJS-1000-5	-	-	-	-	ASTM A897 No. 2	-	-	-	-
	K5.2.C.NS	-	EN-GJS-1200-2	-	-	-	-	ASTM A897 No. 3	-	-	-	-
	K5.2.C.NS	-	EN-GJS-1400-1	-	-	-	-	ASTM A897 No. 4	-	-	-	-
	K5.3.C.NS	-	-	-	-	-	-	ASTM A897 No. 5	-	-	-	-

Werkstoff-Vergleichstabelle

ISO	MC	CMC-Nr.	Land										
			Europa	Deutsch-land	Großbritannien		Schwe-den	USA	Frankreich	Italien	Span-nien	Japan	
			Standard										
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS	
N	Aluminiumbasislegierungen												
	N1.3.C.AG	30.21	G-AISI9MGWA	3.2373	-	-	4251	SC64D	A-S7G	-	-	C4BS	
	N1.3.C.UT	30.21	G-ALMG5	-	LM5	-	4252	GD-AISI12	A-SU12	-	-	AC4A	
	N1.3.C.UT/N1.3.C.AG	30.21/30.22	-	-	LM25	-	4244	356.1	-	-	-	A5052	
	N1.3.C.UT	-	GD-AISI12	-	-	-	4247	A413.0	-	-	-	A6061	
	N1.3.C.AG	-	GD-AISI8Cu3	-	LM24	-	4250	A380.1	-	-	-	A7075	
	N1.3.C.UT	-	G-AISI12(Cu)	-	LM20	-	4260	A413.1	-	-	-	ADC12	
	N1.3.C.UT	-	G-AISI12	-	LM6	-	4261	A413.2	-	-	-	-	
	N1.3.C.AG	-	G-AISI10Mg(Cu)	-	LM9	-	4253	A360.2	-	-	-	-	
S	Nickelbasislegierungen												
	S2.0.Z.AG	20.22	S-NiCr13A16MoNb	LW2 4670	mar-46	-	-	5391	NC12AD	-	-	-	
	S2.0.C.UT	20.24	NiCo15Cr10MoAlTi	LW2 4674	-	-	-	AMS 5397	-	-	-	-	
	S2.0.Z.AG	20.22	NiFe35Cr14MoTi	LW2.4662	-	-	-	5660	ZSNCDT42	-	-	-	
	S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	HR8	-	-	5383	NC19eNB	-	-	-	
	S2.0.Z.AG	20.22	NiCr20TiAk	2.4631	Hr401.601	-	-	-	NC20TA	-	-	-	
	S2.0.Z.AG	20.22	NiCr19Co11MoTi	2.4973	-	-	-	AMS 5399	NC19KDT	-	-	-	
	S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	-	-	-	AMS 5544	NC20K14	-	-	-	
	S2.0.Z.AN	20.21	-	2.4603	-	-	-	5390A	NC22FeD	-	-	-	
	S2.0.Z.AN	20.21	NiCr22Mo9Nb	2.4856	-	-	-	5666	NC22FeDNB	-	-	-	
	S2.0.Z.AN	20.21	NiCr20Ti	2.4630	HR5.203-4	-	-	-	NC20T	-	-	-	
	S2.0.Z.AG	20.22	NiCu30Al3Ti	2.4375	3072-76	-	-	4676	-	-	-	-	
	Kobaltbasislegierungen												
	-	-	CoCr20W15Ni	-	-	-	-	5537C, AMS	KC20WN	-	-	-	
	S3.0.Z.AG	20.32	CoCr22W14Ni	LW2.4964	-	-	-	5772	KC22WN	-	-	-	
	Titanlegierungen												
	S4.2.Z.AN	23.22	TiAl5Sn2.5	3.7115.1	TA14/17	-	-	UNS R54520	T-A5E	-	-	-	
	S4.2.Z.AN	23.22	TiAl6V4	3.7165.1	TA10-13/TA28	-	-	UNS R56401	UNS R56400	-	-	-	
	S4.3.Z.AN	23.22	TiAl5V5Mo5Cr3	-	-	-	-	-	T-A6V	-	-	-	
	S4.2.Z.AN	23.22	TiAl4Mo4Sn4Si0.5	3.7185	-	-	-	-	-	-	-	-	
	Warmfeste Superlegierungen			Handelsbezeichnungen									
				Eisenbasislegierungen									
		S2.0.Z.UT/S2.0.Z.AN	20.11	Incoloy 800									
				Nickelbasislegierungen									
		S2.0.Z.AN	20.2	Haynes 600									
		S2.0.Z.AN	20.2	Nimocast PD16									
		S2.0.Z.AG	20.2	Nimonic PE 13									
		S2.0.Z.AG	20.2	Rene 95									
		S2.0.Z.AN	20.21	Hastelloy C									
		S2.0.Z.AN	20.21	Incoloy 825									
S2.0.Z.AN		20.21	Inconel 600										
S2.0.Z.AN		20.21	Monel 400										
S2.0.Z.AG		20.22	Inconel 700										
S2.0.Z.AG		S2.0.Z.AG	Inconel 718										
S2.0.Z.AG		20.22	Mar – M 432										
S2.0.Z.AG		20.22	Nimonic 901										
S2.0.Z.AG		20.22	Waspaloy										
S2.0.C.NS		20.24	Jessop G 64										
		Kobaltbasislegierungen											
S3.0.Z.AG	20.3	Air Resist 213											
S3.0.Z.AG	20.3	Jetalloy 209											
H	Gehärtete Werkstoffe												
	H1.2.Z.HA	04.1	X100CrMo13	1.4108	-	-	2258 08	440A	-	-	-	C4BS	
	H1.3.Z.HA	04.1	X110CrMoV15	1.4111	-	-	2534 05	610	-	-	-	AC4A	
	H1.2.Z.HA	04.1	X65CrMo14	-	-	-	2541 06	0-2	-	-	-	AC4A	

B

C

D

E

Bestellnummerschlüssel für CoroMill® Plura Werkzeuge/Fräser

R A 21 5 . 3 A - 100 30 – A C 22 H														
1	2	3	4		5	6	7	8	9	10	11	12	13	14

1 Drehrichtung R Rechtsausführung L Linksausführung	2 Bemaßung A Zoll-Ausführung	3 Haltertyp 21 Schaftfräser	4 Bohrfunktion 5 Nicht bohrend 6 Bohren
6 Anzahl Zähne 1-9 1-9 Zähne A-Z 10-32 Zähne	8 Werkzeugdurchmesser Werkzeuge in Zoll Effektiver Durchmesser DC in 1/64 Zoll. Beispiel: 10 = 5/32 Zoll Metrische Werkzeuge Effektiver Durchmesser DC in 1/10 mm. Beispiel: 100 = 10.0 mm	9 Spiralwinkel Spiralwinkel auf die nächsten 5 Grad gerundet	
7 Kühlschmierstoff C = Innere Kühlschmierstoffzufuhr - = Äußere Kühlschmierstoffzufuhr	12 Schaftlänge S Kurze Schaftlänge C Große Schaftlänge K Schaftlänge > "C" L Schaftlänge > "K" X Schaftlänge > "L" E Kurze LF und LU I Mittlere LF, mittlere LU J Mittlere LF, große LU O Lange LF, mittlere LU P Lange LF, große LU	13 Max. Schnitttiefe, APMX Werkzeuge in Zoll Schnittlänge in 1/16 Zoll Wenn DC < 1/8 in 1/64 Zoll Beispiel: 09 = 9/16 Zoll für DC 3/16 Zoll Metrische Werkzeuge Schnittlänge in mm Wenn D_c oder D_{c2} < 3mm in 1/10 mm Beispiel: 07 = 7 mm für DC 6 mm 70 = 7 mm für DC 2.5 mm	

Bestellnummernschlüssel für CoroMill® Plura Werkzeuge/Fräser

5 Schaftfräser, Grundauführung

0 Schaftfräser für das Fasfräsen, konkave Auführung	6 Kugelschaftfräser, Vollradius, sphärische Ausführung
1 Rechtwinklige Form mit/ohne Eckenfase, enge Toleranz an DC	7 Konische Schaftfräser, gerade Ausführung
2 Eckige Fom, mit Eckenradius	8 Schaftfräser zum Fasen, 45°
3 Eckige Form, mit/ohne Eckenradius	9 Schaftfräser zum Fasen, 30°
4 Kugelschaftfräser, Vollradius (6 oder weniger Zähne)	H Hochvorschub-Schaftfräser
5 Konische Kugelschaftfräser mit Vollradius (6 Zähne oder kleiner)	T Schaftfräser für die Multi-Task Bearbeitung

10 Eckenradius/Konuswinkel

Eckenradius		Konuswinkel
Metrische Werkzeuge	Werkzeuge in Zoll	Metrische Werkzeuge
– Kein Radius	– Kein Radius	– Kein Radius/Winkel
A <0.5 mm	A 1/64 Zoll	M 0.5°
B 0.5 mm	B 1/32 Zoll	N 1°
C 1.0 mm	C 3/64 Zoll	O 1.5°
D 1.5 mm	D 1/16 Zoll	P 2°
E 2.0 mm	E 5/64 Zoll	Q 2.5°
F 2.5 mm	F 3/32 Zoll	R 3°
usw.	usw.	S 3.5°
		T 4°
		usw.

11 Schafttyp

- A** Zylindrisch
- B** Weldon
- C** Zylindrisch mit Freistich
- E-J** Zylindrisch mit Freistich (Freistichlänge/DC, mm)
- E = 0.1 - 1.9 H = 6.0 - 7.9
- F = 2.0 - 3.9 I = 8.0 - 9.9
- G = 4.0 - 5.9 J = 10 - 11.9
- Y = Zylindrisch mit iLock

14 Geometrie-Typ

Schneidkante	Kerndurchmesser in % von DC	Spanwinkel γ°
K Kordel	50-60	9°-12°
B Spanbrecher	60	4°-7°
U Kordel	<50	9°-12°
A Gerade	<45	12°-15°
P Gerade	45-55	9°-12°
N Gerade	56-65	9°-12°
L Gerade	66-75	4°-12°
G Gerade	50-75	-3°-3°
H Gerade	>75	<-3°
C Kompressionsfräser		

TW = Kerndurchmesser

Bestellnummerschlüssel für CoroMill® Plura Werkzeuge/Fräser

2	S	3	4	0	-	1200	-	200	-	M	A	1640
1	2	3	4	5		6		7	8	9	10	11

1	Serie
1:	Universell
2:	Optimiert

2	Geometrie
S:	90° Eckenradius, mit Zentrumschneide
F:	90° Eckenradius, nicht bohrend einsetzbar
P:	90°, mit Zentrumschneide
N:	Nicht bohrend einsetzbar
B:	Kugelschaftfräser
C:	Faswerkzeuge
H:	Fräsen mit hohen Vorschüben
U:	Fase
T:	Multitask-Bearbeitung

3	Drallwinkel
0:	0°<FHA≤15°
1:	15°<FHA≤25°
2:	25°<FHA≤35°
3:	35°<FHA≤45°
4:	45°<FHA≤55°
5:	55°<FHA≤65°

4	Durchschnittliche Schnittlänge der Werkzeugausführung (APMX/DC)
0:	0-0.5 x DC
1:	0.6-1.0 x DC
2:	1.1-1.5 x DC
3:	1.6-2.0 x DC
4:	2.1-2.5 x DC
5:	2.6-3.0 x DC
6:	3.1-3.5 x DC
7:	3.6-4.0 x DC
8:	4.1-5.0 x DC
9:	> 5.0 x DC

5	Laufende Nummer zur Unterscheidung zwischen den Codes der Werkzeugausführung

6	Effektiver Durchmesser (DC) in 1/100. z.B. 1200 = 12.00 mm

7	Eckenradius, Fase oder Fasenradius in 1/100. z.B. Eckenradius 200 = 2 mm z.B. Fase 045 = 45°

8	Kühlschmierstoff
-	Kein Kühlschmierstoff
C:	Kühlschmierstoff radialer Austritt
A:	Kühlschmierstoff axialer Austritt

9	Primärer ISO-Werkstoff
P:	ISO P
K:	ISO K
M:	ISO M
S:	ISO S
H:	ISO H
N:	ISO N
O:	ISO O
X:	Multi

10	Schaft
A:	Zylindrisch
B:	Weldon
C:	Zylindrisch mit Freistich
D:	Weldon mit Freistich
G:	Reduziert

11	Sorte

Bestellnummernschlüssel für auswechselbare Fräsköpfe, CoroMill® 316

A	316	-	12	S	M	4	50	C	120	05	P
1	2		3	4	5	6	7	8	9	10	11

1 Bemaßung A = Zoll-Ausführung	2 Familienname z.B.: 316 = CoroMill® 316	3 Größe der Schnittstelle CoroMill® EH Kupplungsgröße z.B.: 12 = E12	4 Grundausführung S = Gerade = 90° F = Gerade, nicht zentrumschneidend B = Kugelschaftfräser C = Faswerkzeuge H = HFC (Hochvorschubfräser) U = Fase																												
5 Länge des Fräskopfes M = Mittel	6 Anzahl der Schneidkanten z.B.: ZEFP = 4	7 Spiralwinkel Spiralwinkel in Grad																													
8 Kühlschmierstoff - Kein Kühlschmierstoff C Kühlschmierstoff radialer Austritt A Kühlschmierstoff axialer Austritt	9 Werkzeug-durchmesser Metrische Werkzeuge z.B.: 120 = 12,0 mm Werkzeuge in Zoll z.B.: 050 = 0.5 Zoll	10 Eckenradius Metrische Werkzeuge z.B.: 05 = RE 0.5 mm Werkzeuge in Zoll z.B.: 04 = RE 0.4 mm (.015")																													
11 Geometrie <table> <tr> <th>Geometrie</th><th>Spannwinkel</th><th>Kerndurchmesser</th><th></th></tr> <tr> <td>P</td><td>9-12°</td><td>50%</td><td></td></tr> <tr> <td>L</td><td>4-12°</td><td>70%</td><td></td></tr> <tr> <td>G</td><td>-3-3°</td><td>70%</td><td></td></tr> <tr> <td>K</td><td>9-12°</td><td>60%</td><td>Kordel</td></tr> <tr> <td>A</td><td>12-15°</td><td></td><td></td></tr> <tr> <td>D</td><td>-10°-0°</td><td></td><td></td></tr> </table>				Geometrie	Spannwinkel	Kerndurchmesser		P	9-12°	50%		L	4-12°	70%		G	-3-3°	70%		K	9-12°	60%	Kordel	A	12-15°			D	-10°-0°		
Geometrie	Spannwinkel	Kerndurchmesser																													
P	9-12°	50%																													
L	4-12°	70%																													
G	-3-3°	70%																													
K	9-12°	60%	Kordel																												
A	12-15°																														
D	-10°-0°																														

B

C

D

E

Bestellnummernschlüssel für CoroMill® Plura Schaftfräser zum Gewindefräsen

R 21 7 . 1 5 C 100 300 A K 30 N												
1	2	3		4	5	6	7	8	9	10	11	12

1 Drehrichtung R Rechtsausführung	4 Gewindetyp 1= Metrisch/Fein- und MJ-Innengewinde 2= Metrisch/Fein Außengewinde 3= UNC/UNF Innengewinde 4= UNC/UNF Außengewinde 5= NPT Innengewinde 6= NPT Außengewinde 7= NPTF Innengewinde 8= NPTF Außengewinde 9= G Innengewinde 0= G Außengewinde	5 Anzahl Zähne 1-9 1-9 Zähne 6 Kühlschmierstoffzufuhr C Innere Kühlschmierstoff-zufuhr - Ohne Kühlschmierstoffzufuhr 7 Werkzeugdurchmesser Durchmesser in 1/10 mm
2 Haltertyp 21 Schaftfräser		
3 Funktion 7 Gewindefräser		
8 Steigung Steigung in 1/100 mm	9 Schaftausführung A Zylinderschaft B Weldonschaft C Zylinderschaft mit Fase	10 Schaftlänge S Kurze Schaftlänge C Große Schaftlänge K Schaftlänge > "C" L Schaftlänge > "K" X Schaftlänge > "L"
11 Max. Schnitttiefe, APMX Schnittlänge in mm (Wenn DCor DCX < 3 mm in 1/10 mm)	12 Geometrie-Typ N 10° Spiralsteigung, 9-12° Spanwinkel, Innengewinde H 30° Spiralsteigung, < 0° Spanwinkel, Innengewinde P 15° Spiralwinkel 9-10° Spanwinkel S 15° Spiralwinkel 4-5° Spanwinkel	

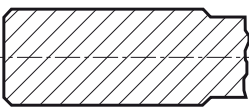
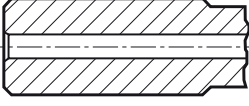
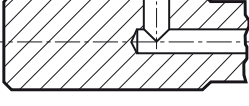
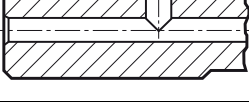
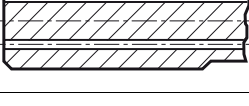
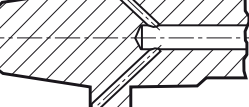
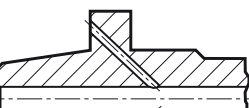
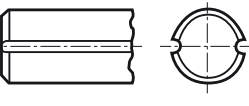
Bestellnummernschlüssel für Gewindebohrer

T200	-	S	D	100	D	A	-	M3
1		2	3	4	5	6		7

1 Produktfamilie	2 ISO-Werkstoff P = Stahl M = Rostfreier Stahl K = Grauguss S = HRSA-Werkstoffe H = Gehärteter Werkstoff N = NE-Metalle X = Allround-Material	3 Werkstoff-Zerspanbarkeit E = Leicht M = Mittel D = Schwierig
4 Anzahl 1 0 0 Unterschiedlicher Code für: verstärkter oder gerader Schaft unterschiedliche Fase, Werkzeug, Kühlschmierstoffzufuhr, etc.	5 Standard D = DIN A = ANSI & DIN/ANSI J = JIS I = ISO	6 Gewindeform A = M B = MF C = MJ D = UN E = UNC F = UNF G = UNEF H = UNJC I = UNJF J = UNS K = G L = NPT M = NPTF N = NPSF O = NPSM P = EGM Q = EGMF R = EGUNC S = EGUNF T = PG U = R V = Rc X = Rp Y = BA Z = EGUNJF
7 Nennmaß Gewindesteigung nur wenn erforderlich, wie bei MF. M3 M10x125 (Steigungsgrößen ohne Dezimalkomma)		

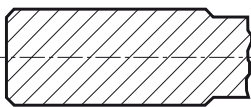
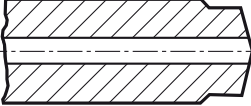
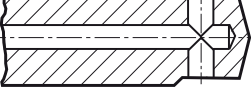
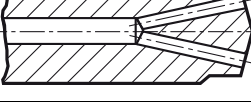
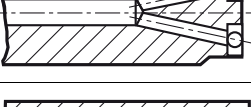
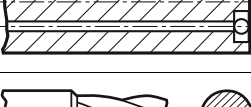
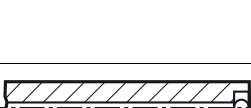
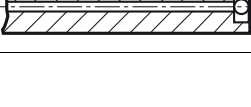
CNSC

Kühlschmierstoffeintrittscode

Code	Bezeichnung	Bild
0	Ohne Kühlschmierstoff	
1	Axial konzentrischer Eintritt	
2	Radialer Eintritt	
3	Axial konzentrischer und radialer Eintritt	
4	Axial konzentrischer Eintritt am Lochkreis	
5	Radialer Eintritt vor Adapter	
6	Dezentral über Flansch	
7	Dezentral über Flansch und axial	
8	Dezentral über Ausgang auf dem Schaft	

CXSC

Kühlschmierstoffeintrittscode

Code	Bezeichnung	Bild
0	Kein Kühlschmierstoff-austritt	
1	Axial konzentrischer Austritt	
2	Radialer Austritt	
3	Axial geneigter Austritt	
4	Axial konzentrisch am Lochkreis	
5	Axial geneigter Austritt mit Düse, verstellbar	
6	Dezentraler Austritt mit Düse, verstellbar	
7	Dezentral über Ausgang auf dem Schaft	
8	Axialer oder dezentraler Austritt mit Düse, verstellbar	

Bestellnummer	Seite	Bestellnummer	Seite	Bestellnummer	Seite
1B230-XA	A32	2S220-NC	A90	A316..FL..L	A151
1B231-XA	A33	2S221-NG	A90	A316..FM..L	A165
1B232-XA	A33	2S340-MA	A58	A316..HM..C..P	A153
1B240-XA	A34	2S342..CMA	A51-A52	A316..HM..P	A154
1C050-XA	A36	2S342..CMB	A49	A316..SL..P	A144
1C050-XB	A36	2S342-PA	A47	A316..SM..C..P	A147
1P220-XA	A12	2S342-PB	A45	A316..SM..K	A160
1P220-XB	A13	2S440-SD	A79	A316..SM..P	A149
1P221-XA	A14	316..BM..DG	A163	A316..UM..G	A170
1P221-XB	A15	316..BM..G	A163	A326..VM-TH	A175
1P222-XA	A16	316..BM2..G	A162	A326-CH	A174
1P222-XB	A16	316..CM..G	A168	E	
1P230-XA	A17-A18	316..CM2..G	A169	E195	C22
1P230-XB	A17	316..FL..L	A151	E207	C20
1P231-XA	A19	316..FM..D	A172	E212	C21
1P231-XB	A20	316..FM..L	A165-A166	E245	C22
1P240-XA	A21	316..HM..C..P	A153	E258	C20
1P240-XB	A21	316..HM..D	A172	E263	C21
1P250-XA	A22	316..HM..P	A154	E301	C39
1P250-XB	A22	316..SL..P	A143, A145	E302	C40
1P251-XA	A23	316..SM..A	A158	E305	C41
1P251-XB	A23	316..SM..C..P	A147	E306	C42
1P260-XA	A24	316..SM..K	A160	E308	C43
1P260-XB	A24	316..SM..P	A148	E309	C41
1P330-XA	A26	316..SM2..P	A156	E310	C41
1P330-XB	A26	316..UM..G	A170	E314	C102
1P340-XA	A30	326..VM-TH	A175	E315	C44
1P340-XB	A30	326-CH	A174	E316	C102
1P341-XA	A27	400.1..A1-NM	B67	E317	C48
1P341-XB	A27	400.4..A1-NM	B67	E323	C52
1P360-XA	A28	430.1..A1-NM	B68	E324	C73
1P370-XA	A28	430.4..A1-NM	B68	E326	C73
1U000-XA	A37	435.B..A1-XF	D3	E344	C79
2B230-NA	A114	435.T..A1-XF	D4	E345	C79
2B320-NG	A112	452.1-C	B63	E346	C107
2B330-NC	A113	452.1-CM	B64	E347	C107
2F210-SC	A140	452.4-CM	B64	E362	C137
2F340..CSC	A59	452.C1-C	B65	E363	C121
2F340..CSD	A62	452.R-CM	B65	E364	C88
2F340..SC	A60-A61	460.1..A0-XM	B13-B17	E404	C108
2F340-SD	A62	460.1..A1-XM	B4-B12	E416	C71
2F341-SC	A63	830	D13	E454	C80
2F341-SD	A64	830A	D12	E455	C80
2F342-PC	A40	830B	D12	E615	C26
2F342-PD	A42	835.B..A1-MF	D9	E616	C9
2F440-ASD	A78	835.B..A1-PF	D6	E736	C138
2H310-SC	A140	835.T..A1-MF	D10	E738	C138
2N342-PC	A41	835.T..A1-PF	D7	E852	C81
2N342-PD	A43	860.1..A0-GM	B20, B22-B24	E854	C74
2P050-OA	A123	860.1..A1	B29-B35	E862	C109
2P051-OA	A122	860.1..A1-GM	B19-B24	E864	C103
2P120-NC	A86	860.1..A1-MM	B37-B40	E872	C94
2P121-NC	A87	860.1..A1-NM	B42-B44	E873	C97
2P122-NC	A87	860.1..A1-SM	B46-B49	E874	C91
2P123-NG	A88	860.1..B0-GM	B20, B22-B24	E882	C130
2P160-NA	A86	860.1..B1-GM	B19-B24	E883	C136
2P170-NA	A88	860.1..C0-GM	B25-B26	E884	C127
2P210-NC	A92	860.1..C1-GM	B19-B24	E885	C133
2P211-PC	A106	860.1..D0-GM	B25-B26	E890	C47
2P212-PC	A106	860.1..G1-GM	B20, B22-B24	E891	C49
2P230-NA	A91	860.2..B1-GM	B25-B26	E892	C50
2P231-NA	A91	860.2..C1-GM	B25-B26	E893	C51
2P232-NA	A89	860.2..E1-GM	B27	EP03P	C75-C76
2P340-PA	A54	861.1..A1-GM	B52-B55	EP03PA	C78
2P340-PB	A54	861.1..A1-GP	B51	EP09P	C77
2P341-MA	A57	862.1..A1-GM	B57	EP13P	C86
2P342..CMB	A48	863.1..A0-O	B60	EP13PA	C87
2P342-CMA	A50	863.1..A1-N	B59	EP23PA	C93
2P342-PA	A46	863.1..A1-OS	B59	EP29PA	C92
2P342-PB	A44	863.1..B1-MS	B61	EX03P	C104
2P350-OA	A125	863.1..B1-OS	B61	EX03PA	C106
2P360-PA	A55	A		EX09P	C105
2P370-PB	A56	A316..BM..G	A163	EX13P	C118-C119
2P440-SD	A80	A316..BM2..G	A162	EX13PA	C120
2P460-NA	A124	A316..CM..G	A168	EX23PA	C128
2P460-OA	A126	A316..CM2..G	A169	EX29PA	C129

Bestellnummer	Seite	Bestellnummer	Seite	Bestellnummer	Seite
EX33PA	C134	T100-KM100DB	C64	T200-XM100DE	C14
EX39PA	C135	T100-KM101AA	C58	T200-XM100DF	C16
R		T100-KM101AB	C65	T200-XM100DK	C18
R215.2x..AC..H	A101	T100-KM101AE	C67	T200-XM101AA	C10
R215.34C..BC..P	A72	T100-KM101AF	C69	T200-XM101AB	C13
R215.3x..30AC..H	A100	T100-KM101DA	C56	T200-XM101AE	C15
R215.3x..50AC..H	A100	T100-KM102AA	C58	T200-XM101AF	C17
R215.3x..50-AC..L	A102	T100-KM102AE	C67	T200-XM101DA	C7
R215.Hx..AC..H	A66	T100-KM102AF	C69	T200-XM101DE	C14
R215.Hx..AC..P	A68	T100-KM102DA	C56	T200-XM101DF	C16
R215.Hx..AK..P	A67	T100-KM102DB	C64	T200-XM104DA	C8
R216.22..AI..G	A82	T100-KM103AA	C58	T200-XM105DA	C8
R216.24..AI..G	A82	T100-KM103AE	C67	T300-NM100AA	C117
R216.2x..50CC..P	A76	T100-KM103AF	C69	T300-NM100AE	C131
R216.2x..AJ..G	A82	T100-KM103DA	C56	T300-NM100AF	C131
R216.2x..AK..H	A70	T100-KM104AA	C59	T300-NM100DA	C114, C116
R216.2x..AK..P	A73	T100-KM104AB	C66	T300-NM100DB	C124
R216.2x..AP..G	A83	T100-KM104AE	C68	T300-NM101AA	C117
R216.2x..BC..P	A77	T100-KM104AF	C70	T300-NM101DA	C115-C116
R216.2x..CK/L..P	A74	T100-KM104DA	C57	T300-NM101DA (FHA35)	C116
R216.3x..30-AE..G	A106	T100-KM104DB	C62	T300-SD100DA	C111
R216.3x..30-AI..G	A106	T100-KM105AA	C59	T300-SD100DB	C122
R216.3x..30-AJ..G	A106	T100-KM105AB	C66	T300-SD100DC	C125
R216.3x..30-BC..B	A94	T100-KM105AE	C68	T300-SD100DE	C126
R216.3x..30-BS..K	A96	T100-KM105AF	C70	T300-SD100DF	C132
R216.3x..40-AC..U	A95	T100-KM105DA	C57	T300-SD100DH	C139
R216.3x..40-AJ..U	A95	T100-KM106AA	C59	T300-SD100DI	C140
R216.3x..40-BC..K	A96	T100-KM106AE	C68	T300-SD100DZ	C142
R216.3x..50-AK..H	A71	T100-KM106AF	C70	T300-SD101DA	C112
R216.3x..50-AK..P	A75	T100-KM106DA	C60	T300-SM100DA	C113
R216.3x..50-BC..P	A77	T100-KM106DB	C62	T300-SM100DB	C123
R216.3x..60-AC..L	A103	T100-KM107AA	C59	T300-SM100DC	C125
R216.3x..CC/K..K	A97	T100-KM107AE	C68	T300-SM100DI	C140
R216.3xC..40-DC..K	A98	T100-KM107AF	C70	T300-SM100DS	C141
R216.3xC..40-DS..K	A98	T100-KM107DA	C60	T300-SM101DA	C113
R216.42..30-..C..G	A110	T100-KM108AA	C59	T300-XM100AA	C25
R216.42..30-AI..G	A115	T100-KM108AB	C66	T300-XM100AB	C29
R216.42..30-AS/C..G	A118	T100-KM108AE	C68	T300-XM100AE	C31
R216.44..30-AI..G	A118	T100-KM108AF	C70	T300-XM100AF	C34
R216.4x..30-AC..G	A119	T100-KM108DA	C60	T300-XM100AL	C37
R216.4x..30-AE..G	A108	T100-KM108DB	C62	T300-XM100AM	C37
R216.4x..30-AJ..G	A109	T100-KM109AA	C59	T300-XM100DA	C23
R216.4x..30-AK..A	A112	T100-KM109AB	C66	T300-XM100DB	C27-C28
R216.4x..30-AK..G	A115	T100-KM109AE	C68	T300-XM100DE	C30
R216.4x..30-AO..G	A108	T100-KM109AF	C70	T300-XM100DF	C33
R216.4x..30-AP..G	A116	T100-KM109DA	C60	T300-XM100DK	C36
R216.4x..30-AQ..G	A116	T100-NM100DA	C61	T300-XM101AA	C25
D		T100-NM101DA	C61	T300-XM101AB	C29
R216.52/3..AL..G	A117	T101	C54	T300-XM101AE	C31
R216.54..AL..G	A117	T105	C110	T300-XM101AF	C34
R216.62..30-AO..G	A120	T106	C110	T300-XM101DA	C23-C24
R216.64..30-AO..G	A120	T110	C55	T300-XM101DE	C30
R217.1x..AC..H	A134	T115	C45	T300-XM101DF	C33
R217.1x..AC..M	A132	T116	C46	T300-XM102AA	C25
R217.1x..AC..N	A130	T120	C63	T300-XM102AB	C29
R217.1x..AC..P	A131	T200-NM100AA	C85	T300-XM102AE	C31
R217.1x..AC..S	A133	T200-NM100AE	C96	T300-XM102AF	C34
R217.1x..CC..K	A129	T200-NM100AF	C96	T300-XM102DA	C24
R217.1xC..AC/K..H	A134	T200-NM100DA	C84	T300-XM103AA	C25
R217.1xC..AC/K..N	A128	T200-NM101DA	C84	T300-XM103AB	C29
R217.3x..AC..P	A136	T200-SD100AE	C95	T300-XM103AE	C32
R217.3xC..AC..M	A135	T200-SD100AF	C98	T300-XM103AF	C35
R217.5x..AC..N	A137	T200-SD100AH	C99	T300-XM103DA	C24
R217.7x..AC..N	A137	T200-SD100AI	C100	T300-XM104DA	C24
R217.9x..BC..N	A138	T200-SD100DA	C82	T300-XM105DA	C24
E		RA215.2x..AK/L..L	A104	T400-NM100DA	C147
RA216.2x..AK..G	A84	RA216.2x..AK..H	A70	T400-PM100AA	C146
RA216.2x..AK..P	A73	RA216.2x..AK..P	A73	T400-PM100AE	C150
RA216.4x..AK..G	A119	T200-SM100DI	C100	T400-PM100AF	C152
T		T200-SM101DA	C83	T400-PM100DA	C144
T100	C55	T200-XM100AA	C10	T400-PM100DB	C148
T100-KM100AA	C58	T200-XM100AB	C13	T400-PM101AE	C150
T100-KM100AB	C65	T200-XM100AE	C15	T400-PM101AF	C152
T100-KM100AE	C67	T200-XM100AF	C17	T400-PM101DA	C144
T100-KM100AF	C69	T200-XM100DA	C7	T400-PM101DB	C149
T100-KM100DA	C56	T200-XM100DB-MF	C11-C12	T400-PM102AE	C151

Bestellnummer	Seite	Bestellnummer	Seite	Bestellnummer	Seite
T400-PM102AF	C153				
T400-PM102DA	C144				
T400-PM102DB	C149				
T400-PM103AE	C151				
T400-PM103AF	C153				
T400-PM103DA	C145				
T400-PM104DA	C145				