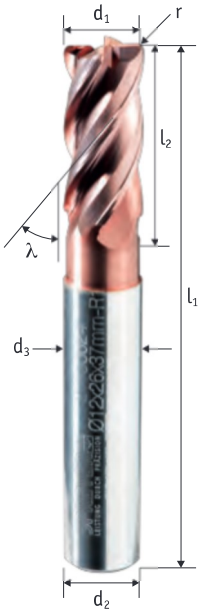
P
K
H

Werksnorm / Company Standard / Norma fábrica / Norme usine / Norma fabbrica



P	M	K	N	S	H
●	●●			●●●	

SWT-TI							
d_1	r	l_2	l_1	d_2	Z	Artikel-Nr.	Euro*
				h6			
6	1	13	58	6	4	SWT-TI-20994026	41,36
8	1	17	64	8	4	SWT-TI-20994025	57,08
10	1	21	73	10	4	SWT-TI-20995092	65,78
12	1	26	84	12	4	SWT-TI-20993024	86,21
16	1	35	93	16	4	SWT-TI-20994024	134,35

P

K

H

Einsatzempfehlung / Recommended use / Recomendaciones de uso / Usinage recommandé / Raccomandazione d'uso

SWT-TI

ae	ap l_2	2,0xD	1,5xD	1,0xD	0,5xD	0,1xD
1,0xD	✓	✓	✓	✓	✓	✓
0,5xD	✓	✓	✓	✓	✓	✓
0,3xD	✓	✓	✓	✓	✓	✓
0,2xD	✓	✓	✓	✓	✓	✓
0,1xD	✓	✓	✓	✓	✓	✓

Schnittwerte / Cutting parameters / Condiciones de corte / Paramètres de coupe / Parametri di taglio

SWT-TI

ap = l_2 **ae = 0,1xD**

	Stahl [N/mm²]			VA Stahl [N/mm²]		GG [N/mm²]	GGG [N/mm²]	Alu	Alu	Cu	Titan [N/mm²]		Gehärteter Stahl	
	<700 P1	<1000 P2	<1300 P3	<900 M1	>900 M2	>400 K1	>750 K2	lang N1	kurz N2	N3	>850 S1		<52HRC H1	<60HRC H2
Vc [m/min]														
min.											55	55		
max.											75	80		
d_1 l_2	**fz [mm]**													
											0,06	0,085		
											0,075	0,09		
											0,075	0,09		
											0,075	0,105		
											0,09	0,14		