

- EN Slot drills | short, 3 - fluted centre cutting
- DE Langlochfräser | Kurz, dreischneider mit Zentrumschnitt
- RU Фрезы шпоночные | короткие, трехзубые, несимметричные

DIN 1835B

DIN 327

typ N

$\lambda=30^\circ$   
 $\gamma=12^\circ$

HSSE PM

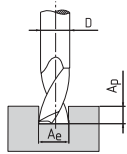
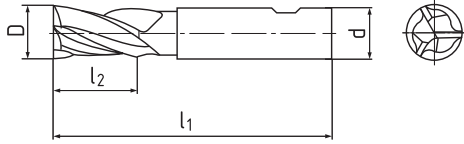
AlTiN

HSS Co8

TiAlN

2304

2304



| D<br>e 8 | d<br>h 6 | l <sub>1</sub> | l <sub>2</sub> | Z |
|----------|----------|----------------|----------------|---|
| 2        | 6        | 48             | 4              | 3 |
| 3        | 6        | 49             | 5              | 3 |
| 3,5      | 6        | 50             | 6              | 3 |
| 4        | 6        | 51             | 7              | 3 |
| 4,5      | 6        | 51             | 7              | 3 |
| 5        | 6        | 52             | 8              | 3 |
| 5,5      | 6        | 52             | 8              | 3 |
| 6        | 6        | 52             | 8              | 3 |
| 6,5      | 10       | 60             | 10             | 3 |
| 7        | 10       | 60             | 10             | 3 |
| 7,5      | 10       | 60             | 10             | 3 |
| 8        | 10       | 61             | 11             | 3 |
| 9        | 10       | 61             | 11             | 3 |
| 9,5      | 10       | 61             | 11             | 3 |
| 10       | 10       | 63             | 13             | 3 |
| 11       | 12       | 70             | 13             | 3 |
| 12       | 12       | 73             | 16             | 3 |

| 230417 | 230418 | 230418     |
|--------|--------|------------|
|        | .020   | .020 TIALN |
|        | .030   | .030 TIALN |
|        | .035   | .035 TIALN |
|        | .040   | .040 TIALN |
|        | .045   | .045 TIALN |
|        | .050   | .050 TIALN |
|        | .055   | .055 TIALN |
| .060   | .060   | .060 TIALN |
|        | .065   | .065 TIALN |
|        | .070   | .070 TIALN |
|        | .075   | .075 TIALN |
| .080   | .080   | .080 TIALN |
|        | .090   | .090 TIALN |
|        | .095   | .095 TIALN |
| .100   | .100   | .100 TIALN |
|        | .110   | .110 TIALN |
| .120   | .120   | .120 TIALN |

### Řezné podmínky / Cutting conditions / Schnittbedingungen / Условия резания

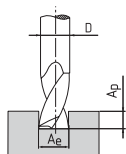
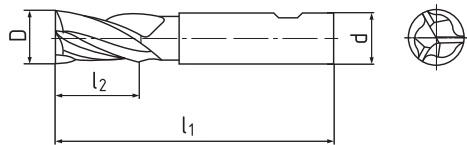
| Material   | Ap                          | Ae    | Vc  | fz (mm/z) |        |        |        |        |        |        |        |        |
|------------|-----------------------------|-------|-----|-----------|--------|--------|--------|--------|--------|--------|--------|--------|
|            |                             |       |     | Ø 3       | Ø 6    | Ø 8    | Ø 10   | Ø 12   | Ø 16   | Ø 18   | Ø 20   |        |
| <b>P.1</b> | ≤ 600 N/mm <sup>2</sup>     | 0,5xD | 1xD | 45        | 0,009  | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>P.2</b> | ≤ 850 N/mm <sup>2</sup>     | 0,5xD | 1xD | 39        | 0,009  | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>P.3</b> | ≤ 1100 N/mm <sup>2</sup>    | 0,5xD | 1xD | 24        | 0,009  | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>P.4</b> | ≤ 900 N/mm <sup>2</sup>     | 0,5xD | 1xD | 30        | 0,009  | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>M.2</b> | 750 - 850 N/mm <sup>2</sup> | 0,5xD | 1xD | 15        | 0,009  | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>K.1</b> | < 240 HB                    | 0,5xD | 1xD | 35        | 0,009  | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>K.2</b> | > 240 HB                    | 0,5xD | 1xD | 25        | 0,009  | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>S.2</b> | ≤ 1250 N/mm <sup>2</sup>    | 0,5xD | 1xD | 12        | 0,0063 | 0,0154 | 0,0203 | 0,0252 | 0,0308 | 0,0406 | 0,0455 | 0,0511 |

TiAlN: Vc + 50 %

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## 2304



| D<br>e 8 | d<br>h 6 | l <sub>1</sub> | l <sub>2</sub> | Z |
|----------|----------|----------------|----------------|---|
| 13       | 12       | 73             | 16             | 3 |
| 14       | 12       | 73             | 16             | 3 |
| 15       | 12       | 73             | 16             | 3 |
| 16       | 16       | 79             | 19             | 3 |
| 18       | 16       | 79             | 19             | 3 |
| 19,7     | 20       | 88             | 22             | 3 |
| 20       | 20       | 88             | 22             | 3 |
| 21,7     | 20       | 88             | 22             | 3 |
| 22       | 20       | 88             | 22             | 3 |
| 24,7     | 25       | 102            | 26             | 3 |
| 25       | 25       | 102            | 26             | 3 |
| 28       | 25       | 102            | 26             | 3 |
| 30       | 25       | 102            | 26             | 3 |
| 32       | 32       | 112            | 32             | 3 |

| 230417 | 230418 | 230418     |
|--------|--------|------------|
|        | .130   | .130 TIALN |
| .140   | .140   | .140 TIALN |
|        | .150   | .150 TIALN |
| .160   | .160   | .160 TIALN |
| .180   | .180   | .180 TIALN |
|        | .197   | .197 TIALN |
| .200   | .200   | .200 TIALN |
|        | .217   | .217 TIALN |
|        | .220   | .220 TIALN |
|        | .247   | .247 TIALN |
|        | .250   | .250 TIALN |
|        | .280   | .280 TIALN |
|        | .300   | .300 TIALN |
|        | .320   | .320 TIALN |

### Řezné podmínky / Cutting conditions / Schnittbedingungen / Условия резания

| Material                               | Ap    | Ae  | Vc | fz (mm/z) |        |        |        |        |        |        |        |
|--|-------|-----|----|-----------|--------|--------|--------|--------|--------|--------|--------|
|  |       |     |    | Ø 3       | Ø 6    | Ø 8    | Ø 10   | Ø 12   | Ø 16   | Ø 18   | Ø 20   |
| <b>P.1</b> ≤ 600 N/mm <sup>2</sup>     | 0,5xD | 1xD | 45 | 0,009     | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>P.2</b> ≤ 850 N/mm <sup>2</sup>     | 0,5xD | 1xD | 39 | 0,009     | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>P.3</b> ≤ 1100 N/mm <sup>2</sup>    | 0,5xD | 1xD | 24 | 0,009     | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>P.4</b> ≤ 900 N/mm <sup>2</sup>     | 0,5xD | 1xD | 30 | 0,009     | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>M.2</b> 750 - 850 N/mm <sup>2</sup> | 0,5xD | 1xD | 15 | 0,009     | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>K.1</b> < 240 HB                    | 0,5xD | 1xD | 35 | 0,009     | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>K.2</b> > 240 HB                    | 0,5xD | 1xD | 25 | 0,009     | 0,022  | 0,029  | 0,036  | 0,044  | 0,058  | 0,065  | 0,073  |
| <b>S.2</b> ≤ 1250 N/mm <sup>2</sup>    | 0,5xD | 1xD | 12 | 0,0063    | 0,0154 | 0,0203 | 0,0252 | 0,0308 | 0,0406 | 0,0455 | 0,0511 |

TiAlN: Vc + 50 %