

Vrtáky s kuželovou stopkou – HSSCo5, extra dlouhé

Tapper shank drills – HSSCo5, extra long

Spiralbohrer mit morsekegel – HSSCo5, extra lang

Сверла с коническим хвостовиком – HSSCo5, особо длинные



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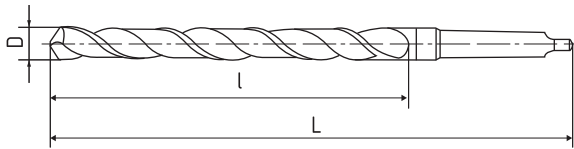
VK60045 • VK70045 • VK80045

DIN 341

DIN 1870

Použití / Usage / Applikation / Употребление

1 2 3 4 5 6 7 8 9 10 11 12 13



VK60045



VK70045



VK80045

| ØD | L | l | CODE |
|------|-----|-----|--------------|
| 8 | 181 | 100 | VK60045.0800 |
| 8,5 | 181 | 100 | VK60045.0850 |
| 9 | 188 | 107 | VK60045.0900 |
| 9,5 | 188 | 107 | VK60045.0950 |
| 10 | 197 | 116 | VK60045.1000 |
| 10,5 | 197 | 116 | VK60045.1050 |
| 11 | 206 | 125 | VK60045.1100 |
| 11,5 | 206 | 125 | VK60045.1150 |
| 12 | 215 | 134 | VK60045.1200 |
| 12,5 | 215 | 134 | VK60045.1250 |
| 13 | 215 | 134 | VK60045.1300 |
| 13,5 | 223 | 142 | VK60045.1350 |
| 14 | 223 | 142 | VK60045.1400 |
| 14,5 | 245 | 147 | VK60045.1450 |
| 15 | 245 | 147 | VK60045.1500 |
| 15,5 | 251 | 153 | VK60045.1550 |
| 16 | 251 | 153 | VK60045.1600 |
| 16,5 | 257 | 159 | VK60045.1650 |
| 17 | 257 | 159 | VK60045.1700 |
| 17,5 | 263 | 165 | VK60045.1750 |
| 18 | 263 | 165 | VK60045.1800 |
| 18,5 | 269 | 171 | VK60045.1850 |
| 19 | 269 | 171 | VK60045.1900 |
| 19,5 | 275 | 177 | VK60045.1950 |
| 20 | 275 | 177 | VK60045.2000 |

| ØD | L | l | CODE |
|------|-----|-----|--------------|
| 8 | 265 | 165 | VK70045.0800 |
| 8,5 | 265 | 165 | VK70045.0850 |
| 9 | 275 | 175 | VK70045.0900 |
| 9,5 | 275 | 175 | VK70045.0950 |
| 10 | 285 | 185 | VK70045.1000 |
| 10,5 | 285 | 185 | VK70045.1050 |
| 11 | 300 | 195 | VK70045.1100 |
| 11,5 | 300 | 195 | VK70045.1150 |
| 12 | 310 | 205 | VK70045.1200 |
| 12,5 | 310 | 205 | VK70045.1250 |
| 13 | 310 | 205 | VK70045.1300 |
| 13,5 | 325 | 220 | VK70045.1350 |
| 14 | 325 | 220 | VK70045.1400 |
| 14,5 | 340 | 220 | VK70045.1450 |
| 15 | 340 | 220 | VK70045.1500 |
| 15,5 | 355 | 230 | VK70045.1550 |
| 16 | 355 | 230 | VK70045.1600 |
| 16,5 | 355 | 230 | VK70045.1650 |
| 17 | 355 | 230 | VK70045.1700 |
| 17,5 | 370 | 245 | VK70045.1750 |
| 18 | 370 | 245 | VK70045.1800 |
| 18,5 | 370 | 245 | VK70045.1850 |
| 19 | 370 | 245 | VK70045.1900 |
| 19,5 | 385 | 260 | VK70045.1950 |
| 20 | 385 | 260 | VK70045.2000 |

| ØD | L | l | CODE |
|------|-----|-----|--------------|
| 14 | 410 | 275 | VK80045.1400 |
| 14,5 | 425 | 275 | VK80045.1450 |
| 15 | 425 | 275 | VK80045.1500 |
| 15,5 | 445 | 295 | VK80045.1550 |
| 16 | 445 | 295 | VK80045.1600 |
| 16,5 | 445 | 295 | VK80045.1650 |
| 17 | 445 | 295 | VK80045.1700 |
| 17,5 | 465 | 310 | VK80045.1750 |
| 18 | 465 | 310 | VK80045.1800 |
| 18,5 | 465 | 310 | VK80045.1850 |
| 19 | 465 | 310 | VK80045.1900 |
| 19,5 | 490 | 325 | VK80045.1950 |
| 20 | 490 | 325 | VK80045.2000 |

doporučené řezné rychlosti • recommended cutting speed • empfohlene schnittgeschwindigkeit • рекомендуемая скорость резания

| Skupina Group Gruppe Группа | Materiál Material Material Материал | Pevnost Strength Festigkeit Твердость | Příklad Example Beispiel Пример | v (m/min) | | | |
|--------------------------------------|--|--|---|-----------|-----------------|---------|-------------------|
| | | | | HSS | HSSE HSS Co5 | HSS Co8 | HSSE-PM +AlTiN |
| 1 | Automatové a konstrukční oceli Free-cutting steels, general constr. steels Automatenstähle, allgemeine Baustähle Автоматные и конструкционные стали | ≤ 600 MPa | DIN 1.0037 DIN 1.0050 11 109 11 500 | 30 | 37,5 | 45 | 76 |
| 2 | Konstrukční a lité oceli General construction steels, steel castings Allgemeine Baustähle, Stahlguss Конструкционные и литые стали | ≤ 850 MPa | DIN 1.0503 DIN 1.0070 12 050 422650 | 26 | 32,5 | 39 | 66 |
| 3 | Nástrojové oceli nízkolegované Tool steels low alloyed Niedriglegierte Werkzeugstähle Инструментальная сталь низколегированная | ≤ 1100 MPa | DIN 1.2711 19 662 422865 | | 18 | 24 | 41 |
| 4 | Zuštětované oceli Heat treatable steels Vergütungsstähle Улучшенные стали | ≤ 900 MPa | DIN 1.5710 DIN 1.8159 16 240 | 20 | 25 | 30 | 51 |
| 5 | Nástrojové oceli vysocelegované Tool steels high alloyed Hochlegierte Werkzeugstähle Инструментальная сталь высоколегированная | ≤ 1100 MPa | DIN 1.3243 19 436 | | 18 | 24 | 41 |
| 6 | Nástrojové a zuštětované oceli Tool and treated steels Werkzeug- und Vergütungsstähle Инструментальная и улучшенная сталь | > 1100 MPa | DIN 1.2343 15 241 15 260 19 552 | | 16 | 20 | 34 |
| 7 | Litina Cast iron Temperguss Чугун | ≤ 240 HB | GG – 15 GG – 20 422415 422420 | 25 | 30 | 35 | 59 |
| 8 | Litina Cast iron Gusseisen Чугун | > 240 HB | GG – 30 422430 | 17 | 22 | 25 | 44 |
| 9 | Nerezavějící oceli Corrosion- and acid-proof steels Rost- und säurebeständige Нержавеющие стали | ≤ 850 MPa | DIN 1.4013 17 041 | | 10 | 15 | 25 |
| 10 | Slitiny Cr-Ni Chrome-nickel alloys Chrom-Nickellegierungen Хромникелевые сплавы | ≤ 850 MPa | DIN 1.4301 DIN 2.4360 Nimonic Hasteloy B 17 242 | | 8 | 12 | 21 |
| 11 | Slitiny Cu-Zn, Cu-Sn Copper-zinc alloys, copper-tin alloys Kupfer-Zink-Legierungen Медноцинковые и меднооловянные сплавы | ≤ 800 MPa | DIN 2.0402 DIN 2.1080 423035 423018 | 50-90 | 60-100 | 80-120 | 120-200 |
| 12 | Hliník, Al-Si slitiny Aluminium, Aluminium cast alloys Si Aluminium, Aluminium-Gu leg. Si Алюминий, алюминий-кремниевые сплавы | ≤ 500 MPa | DIN 3.3211 424254 424203 | 140-240 | 160-250 | 160-300 | 240-450 |
| 13 | Titan, Slitiny titanu Titanium, Titanium alloys Titan, Titanlegierungen Титан, Сплавы титана | ≤ 1200 MPa | DIN 3.7124 DIN 3.7165 DIN 3.7185 | | 9 | 12 | 20 |

Při použití povlaků je možno řeznou rychlost zvýšit:

In case of using coatings it is possible to increase the cutting speed:

Beim Einsatz der Beschichtungen ist es möglich, die Schneidgeschwindigkeit zu erhöhen:

При использовании покрытий можно увеличить скорость резания:

| | |
|--------------|---------|
| TiN | v x 1,3 |
| TiCN | v x 1,4 |
| TiAlN, AlTiN | v x 1,5 |