

# Vrtáky s kuželovou stopkou – HSS, extra dlouhé

Tapper shank drills – HSS, extra long

Spiralbohrer mit morsekegel – HSS, extra lang

Сверла с коническим хвостовиком – HSS, особо длинные



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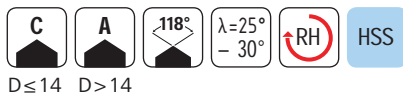
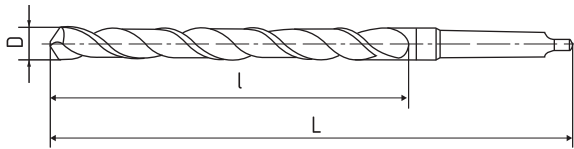
**VK60010 • VK70010 • VK80010**

DIN 341

DIN 1870

Použití / Usage / Applikation / Употребление

- 1
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- 13



D ≤ 14 D > 14



VK60010



VK70010



VK80010

ØD	L	l	CODE
8	181	100	VK60010.0800
8,5	181	100	VK60010.0850
9	188	107	VK60010.0900
9,5	188	107	VK60010.0950
10	197	116	VK60010.1000
10,5	197	116	VK60010.1050
11	206	125	VK60010.1100
11,5	206	125	VK60010.1150
12	215	134	VK60010.1200
12,5	215	134	VK60010.1250
13	215	134	VK60010.1300
13,5	223	142	VK60010.1350
14	223	142	VK60010.1400
14,5	245	147	VK60010.1450
15	245	147	VK60010.1500
15,5	251	153	VK60010.1550
16	251	153	VK60010.1600
16,5	257	159	VK60010.1650
17	257	159	VK60010.1700
17,5	263	165	VK60010.1750
18	263	165	VK60010.1800
18,5	269	171	VK60010.1850
19	269	171	VK60010.1900
19,5	275	177	VK60010.1950
20	275	177	VK60010.2000
20,5	282	184	VK60010.2050
21	282	184	VK60010.2100
21,5	289	191	VK60010.2150
22	289	191	VK60010.2200
22,5	296	198	VK60010.2250
23	296	198	VK60010.2300
23,5	319	198	VK60010.2350

ØD	L	l	CODE
8	265	165	VK70010.0800
8,5	265	165	VK70010.0850
9	275	175	VK70010.0900
9,5	275	175	VK70010.0950
10	285	185	VK70010.1000
10,5	285	185	VK70010.1050
11	300	195	VK70010.1100
11,5	300	195	VK70010.1150
12	310	205	VK70010.1200
12,5	310	205	VK70010.1250
13	310	205	VK70010.1300
13,5	325	220	VK70010.1350
14	325	220	VK70010.1400
14,5	340	220	VK70010.1450
15	340	220	VK70010.1500
15,5	355	230	VK70010.1550
16	355	230	VK70010.1600
16,5	355	230	VK70010.1650
17	355	230	VK70010.1700
17,5	370	245	VK70010.1750
18	370	245	VK70010.1800
18,5	370	245	VK70010.1850
19	370	245	VK70010.1900
19,5	385	260	VK70010.1950
20	385	260	VK70010.2000
20,5	385	260	VK70010.2050
21	385	260	VK70010.2100
21,5	405	270	VK70010.2150
22	405	270	VK70010.2200
22,5	405	270	VK70010.2250
23	405	270	VK70010.2300
23,5	425	270	VK70010.2350

ØD	L	l	CODE
10	360	235	VK80010.1000
10,5	360	235	VK80010.1050
11	375	250	VK80010.1100
11,5	375	250	VK80010.1150
12	395	260	VK80010.1200
12,5	395	260	VK80010.1250
13	395	260	VK80010.1300
13,5	410	275	VK80010.1350
14	410	275	VK80010.1400
14,5	425	275	VK80010.1450
15	425	275	VK80010.1500
15,5	445	295	VK80010.1550
16	445	295	VK80010.1600
16,5	445	295	VK80010.1650
17	445	295	VK80010.1700
17,5	465	310	VK80010.1750
18	465	310	VK80010.1800
18,5	465	310	VK80010.1850
19	465	310	VK80010.1900
19,5	490	325	VK80010.1950
20	490	325	VK80010.2000
20,5	490	325	VK80010.2050
21	490	325	VK80010.2100
21,5	515	345	VK80010.2150
22	515	345	VK80010.2200
22,5	515	345	VK80010.2250
23	515	345	VK80010.2300
23,5	535	345	VK80010.2350
24	555	365	VK80010.2400
24,5	555	365	VK80010.2450
25	555	365	VK80010.2500
25,5	555	365	VK80010.2550

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**VK60010 • VK70010 • VK80010**

DIN  
341

DIN  
1870

ØD	L	I	CODE
24	327	206	VK60010.2400
24,5	327	206	VK60010.2450
25	327	206	VK60010.2500
25,5	335	214	VK60010.2550
26	335	214	VK60010.2600
26,5	335	214	VK60010.2650
27	343	222	VK60010.2700
27,5	343	222	VK60010.2750
28	343	222	VK60010.2800
28,5	351	230	VK60010.2850
29	351	230	VK60010.2900
29,5	351	230	VK60010.2950
30	351	230	VK60010.3000
31	360	239	VK60010.3100
32	397	248	VK60010.3200
33	397	248	VK60010.3300
34	406	257	VK60010.3400
35	406	257	VK60010.3500
36	416	267	VK60010.3600
37	416	267	VK60010.3700
38	426	277	VK60010.3800
39	426	277	VK60010.3900
40	426	277	VK60010.4000
41	436	287	VK60010.4100
42	436	287	VK60010.4200
43	447	298	VK60010.4300
44	447	298	VK60010.4400
45	447	298	VK60010.4500
46	459	310	VK60010.4600
47	459	310	VK60010.4700
48	470	321	VK60010.4800
49	470	321	VK60010.4900
50	470	321	VK60010.5000

ØD	L	I	CODE
24	440	290	VK70010.2400
24,5	440	290	VK70010.2450
25	440	290	VK70010.2500
25,5	440	290	VK70010.2550
26	440	290	VK70010.2600
26,5	440	290	VK70010.2650
27	460	305	VK70010.2700
27,5	460	305	VK70010.2750
28	460	305	VK70010.2800
28,5	460	305	VK70010.2850
29	460	305	VK70010.2900
29,5	460	305	VK70010.2950
30	460	305	VK70010.3000
31	480	320	VK70010.3100
32	505	320	VK70010.3200
33	505	320	VK70010.3300
34	530	340	VK70010.3400
35	530	340	VK70010.3500
36	530	340	VK70010.3600
37	530	340	VK70010.3700
38	555	360	VK70010.3800
39	555	360	VK70010.3900
40	555	360	VK70010.4000
41	555	360	VK70010.4100
42	555	360	VK70010.4200
43	585	385	VK70010.4300
44	585	385	VK70010.4400
45	585	385	VK70010.4500
46	585	385	VK70010.4600
47	585	385	VK70010.4700
48	605	405	VK70010.4800
49	605	405	VK70010.4900
50	605	405	VK70010.5000

ØD	L	I	CODE
26	555	365	VK80010.2600
26,5	555	365	VK80010.2650
27	580	385	VK80010.2700
27,5	580	385	VK80010.2750
28	580	385	VK80010.2800
28,5	580	385	VK80010.2850
29	580	385	VK80010.2900
29,5	580	385	VK80010.2950
30	580	385	VK80010.3000
31	610	410	VK80010.3100
32	635	410	VK80010.3200
33	635	410	VK80010.3300
34	665	430	VK80010.3400
35	665	430	VK80010.3500
36	665	430	VK80010.3600
37	665	430	VK80010.3700
38	695	460	VK80010.3800
39	695	460	VK80010.3900
40	695	460	VK80010.4000
41	695	460	VK80010.4100
42	695	460	VK80010.4200
43	735	490	VK80010.4300
44	735	490	VK80010.4400
45	735	490	VK80010.4500
46	735	490	VK80010.4600
47	735	490	VK80010.4700
48	765	510	VK80010.4800
49	765	510	VK80010.4900
50	765	510	VK80010.5000



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	Zuštětělé oceli Heat treatable steels Vergütungsstähle Улучшенные стали	≤ 900 MPa	DIN 1.5710 DIN 1.8159 16 240	20	25	30	51
5	Nástrojové oceli vysocolegované Tool steels high alloyed Hochlegierte Werkzeugstähle Инструментальная сталь высоколегированная	≤ 1100 MPa	DIN 1.3243 19 436		18	24	41
6	Nástrojové a zuštětělé 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