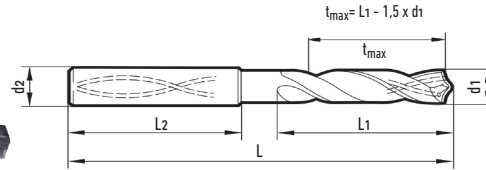


# Tvrdokovový vrták 166540

s vnitřním chlazením / 7xD

- úhel čela 140°
- tolerance průměru m7
- stopka válcová



Popis	Průměr (mm)	L (mm)	L <sub>1</sub> (mm)	L <sub>2</sub> (mm)	Stopka (mm)
V.03000412.S7	3,00	70,0	30,0	36,0	6,000
V.03100412.S7	3,10	70,0	30,0	36,0	6,000
V.03170412.S7	3,17	70,0	30,0	36,0	6,000
V.03200412.S7	3,20	70,0	30,0	36,0	6,000
V.03250412.S7	3,25	70,0	30,0	36,0	6,000
V.03300412.S7	3,30	70,0	30,0	36,0	6,000
V.03400412.S7	3,40	75,0	35,5	36,0	6,000
V.03500412.S7	3,50	75,0	35,5	36,0	6,000
V.03570412.S7	3,57	75,0	35,5	36,0	6,000
V.03600412.S7	3,60	75,0	35,5	36,0	6,000
V.03700412.S7	3,70	75,0	35,5	36,0	6,000
V.03800412.S7	3,80	75,0	37,5	36,0	6,000
V.03900412.S7	3,90	75,0	37,5	36,0	6,000
V.03970412.S7	3,97	75,0	37,5	36,0	6,000
V.04000412.S7	4,00	75,0	37,5	36,0	6,000
V.04100412.S7	4,10	75,0	37,5	36,0	6,000
V.04200412.S7	4,20	75,0	37,5	36,0	6,000
V.04300412.S7	4,30	85,0	45,0	36,0	6,000
V.04370412.S7	4,37	85,0	45,0	36,0	6,000
V.04400412.S7	4,40	85,0	45,0	36,0	6,000
V.04500412.S7	4,50	85,0	45,0	36,0	6,000
V.04600412.S7	4,60	85,0	45,0	36,0	6,000
V.04650412.S7	4,65	85,0	45,0	36,0	6,000
V.04700412.S7	4,70	85,0	45,0	36,0	6,000
V.04760412.S7	4,76	90,0	50,0	36,0	6,000
V.04800412.S7	4,80	90,0	50,0	36,0	6,000
V.04900412.S7	4,90	90,0	50,0	36,0	6,000
V.05000412.S7	5,00	90,0	50,0	36,0	6,000
V.05100412.S7	5,10	90,0	50,0	36,0	6,000
V.05160412.S7	5,16	90,0	50,0	36,0	6,000
V.05200412.S7	5,20	90,0	50,0	36,0	6,000
V.05300412.S7	5,30	90,0	50,0	36,0	6,000
V.05400412.S7	5,40	97,0	57,0	36,0	6,000
V.05500412.S7	5,50	97,0	57,0	36,0	6,000
V.05700412.S7	5,70	97,0	57,0	36,0	6,000
V.05800412.S7	5,80	97,0	57,0	36,0	6,000

Popis	Průměr (mm)	L (mm)	L <sub>1</sub> (mm)	L <sub>2</sub> (mm)	Stopka (mm)
V.05900412.S7	5,90	97,0	57,0	36,0	6,000
V.05950412.S7	5,95	97,0	57,0	36,0	6,000
V.06000412.S7	6,00	97,0	57,0	36,0	6,000
V.06200412.S7	6,20	106,0	66,0	36,0	8,000
V.06300412.S7	6,30	106,0	66,0	36,0	8,000
V.06350412.S7	6,35	106,0	66,0	36,0	8,000
V.06500412.S7	6,50	106,0	66,0	36,0	8,000
V.06600412.S7	6,60	106,0	66,0	36,0	8,000
V.06700412.S7	6,70	106,0	66,0	36,0	8,000
V.06800412.S7	6,80	106,0	66,0	36,0	8,000
V.06900412.S7	6,90	116,0	76,0	36,0	8,000
V.07000412.S7	7,00	116,0	76,0	36,0	8,000
V.07100412.S7	7,10	116,0	76,0	36,0	8,000
V.07200412.S7	7,20	116,0	76,0	36,0	8,000
V.07500412.S7	7,50	116,0	76,0	36,0	8,000
V.07600412.S7	7,60	116,0	76,0	36,0	8,000
V.07700412.S7	7,70	116,0	76,0	36,0	8,000
V.07800412.S7	7,80	116,0	76,0	36,0	8,000
V.08000412.S7	8,00	116,0	76,0	36,0	8,000
V.08100412.S7	8,10	131,0	87,0	40,0	10,000
V.08200412.S7	8,20	131,0	87,0	40,0	10,000
V.08400412.S7	8,40	131,0	87,0	40,0	10,000
V.08500412.S7	8,50	131,0	87,0	40,0	10,000
V.08600412.S7	8,60	131,0	87,0	40,0	10,000
V.08700412.S7	8,70	131,0	87,0	40,0	10,000
V.08800412.S7	8,80	131,0	87,0	40,0	10,000
V.09000412.S7	9,00	131,0	87,0	40,0	10,000
V.09100412.S7	9,10	139,0	95,0	40,0	10,000
V.09200412.S7	9,20	139,0	95,0	40,0	10,000
V.09250412.S7	9,25	139,0	95,0	40,0	10,000
V.09300412.S7	9,30	139,0	95,0	40,0	10,000
V.09400412.S7	9,40	139,0	95,0	40,0	10,000
V.09500412.S7	9,50	139,0	95,0	40,0	10,000
V.09520412.S7	9,52	139,0	95,0	40,0	10,000
V.09700412.S7	9,70	139,0	95,0	40,0	10,000
V.09800412.S7	9,80	139,0	95,0	40,0	10,000

Popis	Průměr (mm)	L (mm)	L <sub>1</sub> (mm)	L <sub>2</sub> (mm)	Stopka (mm)
V.09900412.S7	9,90	139,0	95,0	40,0	10,000
V.10000412.S7	10,00	139,0	95,0	40,0	10,000
V.10200412.S7	10,20	155,0	106,0	45,0	12,000
V.10300412.S7	10,30	155,0	106,0	45,0	12,000
V.10500412.S7	10,50	155,0	106,0	45,0	12,000
V.10800412.S7	10,80	155,0	106,0	45,0	12,000
V.11000412.S7	11,00	155,0	106,0	45,0	12,000
V.11200412.S7	11,20	163,0	114,0	45,0	12,000
V.11500412.S7	11,50	163,0	114,0	45,0	12,000
V.11800412.S7	11,80	163,0	114,0	45,0	12,000
V.12000412.S7	12,00	163,0	114,0	45,0	12,000
V.12200412.S7	12,20	182,0	133,0	45,0	14,000
V.12500412.S7	12,50	182,0	133,0	45,0	14,000
V.12700412.S7	12,70	182,0	133,0	45,0	14,000
V.13000412.S7	13,00	182,0	133,0	45,0	14,000
V.13100412.S7	13,10	182,0	133,0	45,0	14,000
V.13500412.S7	13,50	182,0	133,0	45,0	14,000
V.14000412.S7	14,00	182,0	133,0	45,0	14,000
V.14200412.S7	14,20	204,0	152,0	48,0	16,000
V.14500412.S7	14,50	204,0	152,0	48,0	16,000
V.15000412.S7	15,00	204,0	152,0	48,0	16,000
V.15100412.S7	15,10	204,0	152,0	48,0	16,000
V.15500412.S7	15,50	204,0	152,0	48,0	16,000
V.16000412.S7	16,00	204,0	152,0	48,0	16,000
V.16500412.S7	16,50	223,0	171,0	48,0	18,000
V.16900412.S7	16,90	223,0	171,0	48,0	18,000
V.17000412.S7	17,00	223,0	171,0	48,0	18,000
V.17500412.S7	17,50	223,0	171,0	48,0	18,000
V.18000412.S7	18,00	223,0	171,0	48,0	18,000
V.18500412.S7	18,50	244,0	190,0	50,0	20,000
V.18900412.S7	18,90	244,0	190,0	50,0	20,000
V.19000412.S7	19,00	244,0	190,0	50,0	20,000
V.19050412.S7	19,05	244,0	190,0	50,0	20,000
V.19500412.S7	19,50	244,0	190,0	50,0	20,000
V.20000412.S7	20,00	244,0	190,0	50,0	20,000

# Tvrdokovový vrták 166540

s vnitřním / 7xD



## Řezné podmínky

	Typ materiálu	Pevnost v tahu (N/mm <sup>2</sup> ) Tvrdost	V <sub>c</sub> (m/min.)	Posuv (mm/ot.)			
				3,0 - 7,9	8,0 - 15,9	16,0 - 20,0	
<b>P</b>	Konstrukční ocel	≤500	145	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400	
		≤1000	120	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315	
	Automatová ocel	≤850	170	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500	
		≤1000	145	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500	
	Nelegovaná kalená ocel	≤700	130	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500	
		≤850	125	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400	
		≤1000	120	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400	
	Legovaná kalená ocel	≤1000	120	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400	
		≤1400	105	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400	
	Nelegovaná cementovaná ocel	≤850	145	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500	
	Legovaná cementovaná ocel	≤1000	120	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400	
		≤1400	85	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315	
	Nitridovaná ocel	≤1000	110	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500	
		≤1400	105	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315	
Nástrojová ocel	≤850	80	0,063 - 0,080 - 0,100	0,125 - 0,160	0,200 - 0,250		
	≤1400	65	0,063 - 0,080 - 0,100	0,125 - 0,160	0,200 - 0,250		
<b>M</b>	Nerezová ocel	≤900	60	0,063 - 0,080 - 0,100	0,125 - 0,160	0,200 - 0,250	
		austenititická	≤1100	55	0,063 - 0,080 - 0,100	0,125 - 0,160	0,200 - 0,250
	Martenzitická	≤1500	45	0,063 - 0,080 - 0,100	0,125 - 0,160	0,200 - 0,250	
<b>H</b>	Kalená ocel	≤48 HRC	55	0,040 - 0,050 - 0,063	0,080 - 0,100	0,125 - 0,160	
		≤66 HRC	35	0,032 - 0,040 - 0,050	0,063 - 0,080	0,100 - 0,125	
<b>K</b>	Litina	≤240 HB	195	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630	
		≤350 HB	160	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630	
	Temperovaná litina	≤240 HB	140	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630	
		≤350 HB	130	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500	
	Tvrzená litina	≤350 HB	40	0,040 - 0,050 - 0,063	0,080 - 0,100	0,125 - 0,160	
<b>S</b>	Titan a slitiny Titanu	≤850	40	0,050 - 0,063 - 0,080	0,100 - 0,125	0,160 - 0,200	
		≤1400	40	0,040 - 0,050 - 0,063	0,080 - 0,100	0,125 - 0,160	
<b>N</b>	Hliník a slitiny hliníku	≤400	310	0,160 - 0,200 - 0,315	0,315 - 0,500	0,500 - 0,630	
		Kovaný hliník	≤650	310	0,160 - 0,200 - 0,315	0,315 - 0,500	0,500 - 0,630
	Slitiny hliníku ≤ 10 % Si	≤600	260	0,160 - 0,200 - 0,315	0,315 - 0,500	0,500 - 0,630	
		> 10 % Si	≤600	220	0,160 - 0,200 - 0,315	0,315 - 0,500	0,500 - 0,630
	Hořčík a slitiny hořčíku	≤400	280	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500	
	Měď	≤500	125	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400	
		Mosaz	≤600	325	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
			≤600	220	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400
		Bronz	≤600	125	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400
			≤850	105	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315
			≤850	90	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315
≤1000	80	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315			