

Vybrušované vrtáky HSS-Co8 typ 81018

VLASTNOSTI:

- > Nástroj vyrobený v Německu.
- > Rozměry podle DIN 338.
- > 8% Co pro maximální výkon při vysokých teplotách.
- > 135° úhel špičky podle NAS 907 pro přesné zavrtání s minimální posuvovou silou již od Ø 1 mm.
- > Povrchová úprava oxidací, bronzová barva.
- > Speciálně navržený tvar drážky pro spolehlivou tvorbu a odvod třísek.
- > Vhodný pro strojní i ruční obrábění.


81018

D	Rozměry	Balení	Cena
mm	mm	ks	Kč
1,000	1,000 X 34,000	10	83
1,100	1,100 X 36,000	10	89
1,200	1,200 X 38,000	10	92
1,300	1,300 X 38,000	10	91
1,400	1,400 X 40,000	10	87
1,500	1,500 X 40,000	10	77
1,590	1,590 X 43,000	10	76
1,600	1,600 X 43,000	10	76
1,700	1,700 X 43,000	10	82
1,800	1,800 X 46,000	10	80
1,900	1,900 X 46,000	10	80
1,980	1,980 X 49,000	10	83
2,000	2,000 X 49,000	10	67
2,100	2,100 X 49,000	10	76
2,200	2,200 X 53,000	10	78
2,300	2,300 X 53,000	10	77
2,380	2,380 X 57,000	10	74
2,400	2,400 X 57,000	10	78
2,500	2,500 X 57,000	10	73
2,600	2,600 X 57,000	10	82
2,700	2,700 X 61,000	10	83
2,780	2,780 X 61,000	10	81
2,800	2,800 X 61,000	10	81
2,900	2,900 X 61,000	10	78
3,000	3,000 X 61,000	10	73
3,100	3,100 X 65,000	10	86
3,170	3,170 X 65,000	10	74
3,200	3,200 X 65,000	10	83
3,250	3,250 X 65,000	10	74
3,300	3,300 X 65,000	10	77
3,400	3,400 X 70,000	10	89
3,500	3,500 X 70,000	10	83
3,570	3,570 X 70,000	10	95
3,600	3,600 X 70,000	10	95
3,700	3,700 X 70,000	10	89
3,800	3,800 X 75,000	10	105
3,900	3,900 X 75,000	10	105
3,970	3,970 X 75,000	10	96
4,000	4,000 X 75,000	10	89
4,100	4,100 X 75,000	10	105
4,200	4,200 X 75,000	10	99
4,300	4,300 X 80,000	10	119
4,400	4,400 X 80,000	10	111
4,500	4,500 X 80,000	10	113

D	Rozměry	Balení	Cena
mm	mm	ks	Kč
4,600	4,600 X 80,000	10	119
4,700	4,700 X 80,000	10	118
4,760	4,760 X 86,000	10	105
4,800	4,800 X 86,000	10	123
4,900	4,900 X 86,000	10	120
5,000	5,000 X 86,000	10	108
5,100	5,100 X 86,000	10	133
5,160	5,160 X 86,000	10	138
5,200	5,200 X 86,000	10	136
5,300	5,300 X 86,000	10	137
5,400	5,400 X 93,000	10	149
5,500	5,500 X 93,000	10	152
5,560	5,560 X 93,000	10	131
5,600	5,600 X 93,000	10	156
5,700	5,700 X 93,000	10	172
5,800	5,800 X 93,000	10	172
5,900	5,900 X 93,000	10	170
5,950	5,950 X 93,000	10	181
6,000	6,000 X 93,000	10	141
6,100	6,100 X 101,000	10	172
6,200	6,200 X 101,000	10	181
6,300	6,300 X 101,000	10	167
6,350	6,350 X 101,000	10	167
6,400	6,400 X 101,000	10	186
6,500	6,500 X 101,000	10	174
6,600	6,600 X 101,000	10	195
6,700	6,700 X 101,000	10	191
6,800	6,800 X 109,000	10	194
6,900	6,900 X 109,000	10	227
7,000	7,000 X 109,000	10	200
7,100	7,100 X 109,000	10	238
7,140	7,140 X 109,000	10	231
7,200	7,200 X 109,000	10	228
7,300	7,300 X 109,000	10	233
7,400	7,400 X 109,000	10	256
7,500	7,500 X 109,000	10	215
7,540	7,540 X 117,000	5	264
7,600	7,600 X 117,000	5	270
7,700	7,700 X 117,000	5	264
7,800	7,800 X 117,000	5	277
7,900	7,900 X 117,000	5	283
7,940	7,940 X 117,000	5	256
8,000	8,000 X 117,000	5	237
8,100	8,100 X 117,000	5	297

D	Rozměry	Balení	Cena
mm	mm	ks	Kč
8,200	8,200 X 117,000	5	283
8,300	8,300 X 117,000	5	290
8,330	8,330 X 117,000	5	343
8,400	8,400 X 117,000	5	304
8,500	8,500 X 117,000	5	270
8,600	8,600 X 125,000	5	350
8,700	8,700 X 125,000	5	363
8,730	8,730 X 125,000	5	283
8,800	8,800 X 125,000	5	343
8,900	8,900 X 125,000	5	375
9,000	9,000 X 125,000	5	310
9,100	9,100 X 125,000	5	369
9,130	9,130 X 125,000	5	375
9,200	9,200 X 125,000	5	396
9,300	9,300 X 125,000	5	375
9,500	9,500 X 125,000	5	356
9,520	9,520 X 133,000	5	375
9,600	9,600 X 133,000	5	409
9,700	9,700 X 133,000	5	422
9,800	9,800 X 133,000	5	428
9,900	9,900 X 133,000	5	442
9,920	9,920 X 133,000	5	468
10,000	10,000 X 133,000	5	375
10,100	10,100 X 133,000	5	541
10,200	10,200 X 133,000	5	488
10,300	10,300 X 133,000	5	461
10,320	10,320 X 133,000	5	442
10,500	10,500 X 133,000	5	482
10,720	10,720 X 142,000	1	535
10,800	10,800 X 142,000	1	646
11,000	11,000 X 142,000	1	554
11,110	11,110 X 142,000	1	474
11,500	11,500 X 142,000	1	646
11,510	11,510 X 142,000	1	613
11,910	11,910 X 151,000	1	673
12,000	12,000 X 151,000	1	698
12,200	12,200 X 151,000	1	975
12,300	12,300 X 151,000	1	805
12,500	12,500 X 151,000	1	765
12,700	12,700 X 151,000	1	791
12,800	12,800 X 151,000	1	1082
13,000	13,000 X 151,000	1	886

Doporučené řezné podmínky

Vrták Ø mm	Posuv (číslo sloupce)								
	1	2	3	4	5	6	7	8	9
	f (mm/ot.)								
0.50	0.004	0.006	0.007	0.008	0.010	0.012	0.014	0.016	0.019
1.00	0.006	0.008	0.012	0.014	0.016	0.018	0.020	0.023	0.025
2.00	0.020	0.025	0.032	0.040	0.050	0.063	0.080	0.100	0.125
2.50	0.025	0.032	0.040	0.050	0.063	0.080	0.100	0.125	0.160
3.15	0.032	0.040	0.050	0.063	0.080	0.100	0.125	0.160	0.160
4.00	0.040	0.050	0.063	0.080	0.100	0.125	0.160	0.200	0.200
5.00	0.040	0.050	0.063	0.080	0.100	0.125	0.160	0.200	0.250
6.30	0.050	0.063	0.080	0.100	0.125	0.160	0.200	0.250	0.315
8.00	0.063	0.080	0.100	0.125	0.160	0.200	0.250	0.315	0.315
10.00	0.080	0.100	0.125	0.160	0.200	0.250	0.315	0.400	0.400
12.50	0.080	0.100	0.125	0.160	0.200	0.250	0.315	0.400	0.500
16.00	0.100	0.125	0.160	0.200	0.250	0.315	0.400	0.500	0.630
20.00	0.125	0.160	0.200	0.250	0.315	0.400	0.500	0.630	0.630

Objednávací číslo (R) 81018

Standard/DIN: 338

Materiál nástroje HSS-Co8

Povrchová úprava ●

Typ: P2000

Směr řezu: (R)

Materiálové skupiny	Příklady materiálů Tučně označené hodnoty = číslo materiálu podle DIN EN 10 027	Pevnost N/mm ²	Tvrdost	Chlazení	v _c m/min	Posuv (číslo sloupce)
Common structural steels	1.0035 S185(S133), 1.0486 P275N(SHE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2) 1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		○ ○	35 30	6 5
Free-cutting steels	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		○ ○	40 40	6 5
Unalloyed heat-treatable steels	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		○ ○ ○	40 40 35	5 5 4
Alloyed heat-treatable steels	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤1400		○ ○	25 20	4 3
Unalloyed case hard. steels	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		○	40	6
Alloyed case hardened steels	1.7276 10CrMo11, 1.5125 11MnSi6 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1000 ≤1400		● ●	20 15	4 3
Nitriding steels	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1000 ≤1400		○ ●	20 15	4 3
Tool steels	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤1400		○ ●	18 12	4 3
High speed steels	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400		●	12	3
Spring steels	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	●	8	2
Hardened steels	-		≤48 HRC ≤66 HRC	● ●		
Stainless steels, sulphured austenitic martensitic	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9 1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A) 1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤900 ≤1100 ≤1500		● ● ●	14 10 12	4 3 3
Cast iron	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤240 HB ≤350 HB	○ ○	38 30	6 6
Spheroidal graphite iron and malleable cast iron	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35) 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤240 HB ≤350 HB	○ ○	30 25	6 6
Chilled cast iron	-		≤350 HB	○	10	3
New cast materials GG	EN-GJV250 (GGV25), EN-GJV350 (GGV35) EN-GJV400 (GGV40), EN-GJV500 (GGV50), SiMo 6		≤220 HB ≤300 HB	○ ○		
New cast materials ADI	EN-GJS-800-8 (ADI800), EN-GJS-1000-5 (ADI1000) EN-GJS-1200-2 (ADI1200), EN-GJS-1400-1 (ADI1400)	≤1000 ≤1400		○ ○		
Special alloys	Nimonic, Inconel, Monel, Hastelloy	≤2000		●	5	2
Ti and Ti-alloys	3.7024 Ti99.5, 3.7114 TiAl5Sn2.5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2.5, -TiAl8Mo1V1	≤850 ≤1400		● ●		
Aluminium and Al-alloys	3.0255 Al99.5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		○	90	7
Al wrought alloys	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1.5	≤650		○	90	7
Al cast alloys ≤ 10 % Si ≤ 24 % Si	3.2131 G-ALSi5Cu1, 3.2153 G-ALSi7Cu3, 3.2573 G-ALSi9 3.2581 G-ALSi12, 3.2583 G-ALSi12Cu, - G-ALSi12CuNiMg	≤600 ≤600		○ ○	80 70	7 6
Magnesium alloys	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		○	85	6
Copper, low-alloyed	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		○	80	5
Brass, short-chipping long-chipping	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0.5	≤600 ≤600		○ ○	70 40	5 5
Bronze, short-chipping	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 ≤850		○ ●	40 30	4 4
Bronze, long-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		● ●	25 15	4 4
Duroplastics	Epoxy resin, Resopal, Pertinax, Moltopren	≤150		○	20	4
Thermoplastics	Plexiglass, Hostalen, Novodur, Makralon	≤100		○	25	5
Kevlar	Kevlar	≤1000		○		
Glass, carbon concentr. plastics	GFK/CFK	≤1000		○		

Chlazení: ○ Vzduch ● Řezný olej ○ Emulze