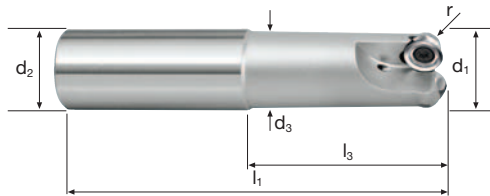


Rundplattenfräser AX

Wendeplatten 12mm, mit integriertem Luft-/Kühlkanal

HM λ 0°
 γ 20°



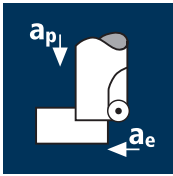
| | | | | | | | | | |
|--|--|--|-------------------------|-------------------------|------------------------|--|--------------|------------------------|--|
| | | | Al Aluminum > 99% | Al Aluminum Alloy | Al Aluminum Cast | | Cu Copper | Plastic Thermoplast | CuZn Brass CF/GF Fiber Reinforced Plastics |
|--|--|--|-------------------------|-------------------------|------------------------|--|--------------|------------------------|--|

| Rundplattenfräser | | Lieferumfang: Fräserkörper inkl. Klemmschrauben für Wendeplatten montiert | | | | | | | |
|-------------------|----|---|----|-----|----|--------------------|---|-------|---|
| Bestell-Nr. | d1 | d2 h6 | d3 | l1 | l3 | ap _{max.} | z | L-Typ | |
| W03150.252 | 25 | 25 | 24 | 124 | 65 | 1.7 | 2 | M | ● |
| W03195.252 | 25 | 25 | 24 | 210 | 65 | 1.7 | 2 | XL | ● |
| W03150.323 | 32 | 32 | 31 | 144 | 81 | 1.7 | 3 | M | ● |
| W03195.323 | 32 | 32 | 31 | 250 | 81 | 1.7 | 3 | XL | ● |
| | | | | | | | | | |
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| AX Wendeplatten 12mm | | Lieferumfang: Verpackungseinheit 10 Stk. | | |
|----------------------|------|--|-----|---|
| Bestell-Nr. | D1 | r | D | |
| W53510.012 | 12.0 | 6.0 | 4.8 | ● |

| Zubehör | | Lieferumfang Klemmschrauben für Wendeplatten: Verpackungseinheit 10 Stk. | | |
|-------------|--|--|--|---|
| Bestell-Nr. | | | | |
| W93110.012 | Drehmoment-Schraubendreher 4.25 Nm mit Klinge Torx TX 15 | | | ● |
| W90111.013 | Wechselklinge zu Drehmoment-Schraubendreher Torx TX 15 | | | ● |
| W90100.013 | Schraubendreher Torx TX 15 | | | ● |
| W93500.012 | Klemmschrauben für Wendeplatten Torx TX 15 / M 4 x 8.5 | | | ● |

Anwendung



Werkstoff

Al-Knetlegierung
Si < 6%



Aluminiumguss
Si 6%-15%



Reinkupfer



Thermoplaste

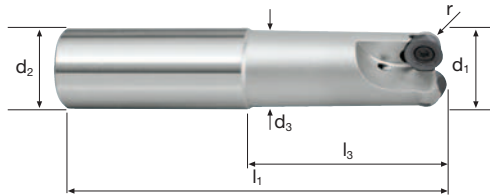


| L-Typ [mm] | d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|---------------|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| M | 25 | 3 | 650 | 0.450 | 1.50 | 15.0 | 8275 | 11170 | 251.5 |
| | 32 | 4 | 550 | 0.450 | 1.50 | 19.2 | 5470 | 9845 | 283.5 |
| XL | 25 | 3 | 600 | 0.430 | 1.40 | 10.0 | 7640 | 9855 | 138.0 |
| | 32 | 4 | 500 | 0.430 | 1.40 | 12.8 | 4975 | 8555 | 153.5 |
| M | 25 | 3 | 500 | 0.400 | 1.50 | 15.0 | 6365 | 7640 | 172.0 |
| | 32 | 4 | 450 | 0.400 | 1.50 | 19.2 | 4475 | 7160 | 206.0 |
| XL | 25 | 3 | 450 | 0.380 | 1.40 | 10.0 | 5730 | 6530 | 91.5 |
| | 32 | 4 | 400 | 0.380 | 1.40 | 12.8 | 3980 | 6050 | 108.5 |
| M | 25 | 3 | 450 | 0.400 | 1.50 | 15.0 | 5730 | 6875 | 154.5 |
| | 32 | 4 | 400 | 0.400 | 1.50 | 19.2 | 3980 | 6370 | 183.5 |
| XL | 25 | 3 | 400 | 0.380 | 1.40 | 10.0 | 5095 | 5810 | 81.5 |
| | 32 | 4 | 400 | 0.380 | 1.40 | 12.8 | 3980 | 6050 | 108.5 |
| M | 25 | 3 | 650 | 0.450 | 1.50 | 15.0 | 8275 | 11170 | 251.5 |
| | 32 | 4 | 550 | 0.450 | 1.50 | 19.2 | 5470 | 9845 | 283.5 |
| XL | 25 | 3 | 600 | 0.430 | 1.40 | 10.0 | 7640 | 9855 | 138.0 |
| | 32 | 4 | 500 | 0.430 | 1.40 | 12.8 | 4975 | 8555 | 153.5 |

Rundplattenfräser HX

Wendeplatten 12mm, mit integriertem Luft-/Kühlkanal

| | |
|-----------|--|
| HM | λ 0° γ -4° |
|-----------|--|



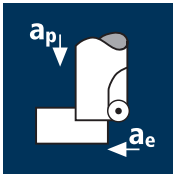
| | | | | | | | | | |
|--|--|------------------------|------------------------|---------------------|---------------------|--------------------|--|--|--------------|
| | | Rm 1100-1300 | Rm 1300-1500 | HRC 48-56 | HRC 56-60 | HRC > 60 | | | GG(G) |
|--|--|------------------------|------------------------|---------------------|---------------------|--------------------|--|--|--------------|

| Rundplattenfräser | | Lieferumfang: Fräserkörper inkl. Klemmschrauben für Wendeplatten montiert | | | | | | | |
|--------------------------|----|---|----|-----|----|--------------------|---|-------|---|
| Bestell-Nr. | d1 | d2 h6 | d3 | l1 | l3 | ap _{max.} | z | L-Typ | |
| W03150.252 | 25 | 25 | 24 | 124 | 65 | 1.7 | 2 | M | ● |
| W03195.252 | 25 | 25 | 24 | 210 | 65 | 1.7 | 2 | XL | ● |
| W03150.323 | 32 | 32 | 31 | 144 | 81 | 1.7 | 3 | M | ● |
| W03195.323 | 32 | 32 | 31 | 250 | 81 | 1.7 | 3 | XL | ● |
| | | | | | | | | | |
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| HX Wendeplatten 12mm | | Lieferumfang: Verpackungseinheit 10 Stk. | | | |
|-----------------------------|------|--|-----|--|---|
| Bestell-Nr. | D1 | r | D | | |
| W53210.012 | 12.0 | 6.0 | 4.8 | | ● |

| Zubehör | | Lieferumfang Klemmschrauben für Wendeplatten: Verpackungseinheit 10 Stk. | | | |
|-------------------|---|--|--|--|---|
| Bestell-Nr. | | | | | |
| W93110.012 | Drehmoment-Schraubendreher 4.25 Nm mit Klinge Torx TX 15 | | | | ● |
| W90111.013 | Wechselklinge zu Drehmoment-Schraubendreher Torx TX 15 | | | | ● |
| W90100.013 | Schraubendreher Torx TX 15 | | | | ● |
| W93500.012 | Klemmschrauben für Wendeplatten Torx TX 15 / M 4 x 8.5 | | | | ● |

Anwendung



Werkstoff

Werkzeugstahl gehärtet
42 - 48 HRC



Werkzeugstahl gehärtet
48 - 52 HRC



Werkzeugstahl gehärtet
52 - 56 HRC



Werkzeugstahl gehärtet
56 - 60 HRC

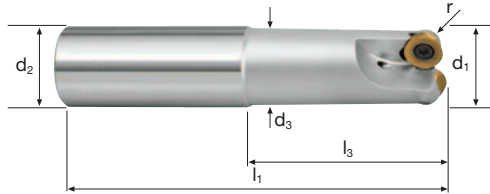


| L-Typ [mm] | d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|---------------|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| M | 25 | 2 | 100 | 0.350 | 1.44 | 15.0 | 1275 | 895 | 19.5 |
| | 32 | 3 | 100 | 0.350 | 1.44 | 19.2 | 995 | 1045 | 29.0 |
| XL | 25 | 2 | 90 | 0.320 | 1.11 | 10.0 | 1145 | 735 | 8.0 |
| | 32 | 3 | 90 | 0.320 | 1.11 | 12.8 | 895 | 860 | 12.0 |
| | | | | | | | | | |
| M | 25 | 2 | 80 | 0.330 | 1.37 | 15.0 | 1020 | 675 | 14.0 |
| | 32 | 3 | 80 | 0.330 | 1.37 | 19.2 | 795 | 785 | 20.5 |
| XL | 25 | 2 | 70 | 0.305 | 1.05 | 10.0 | 890 | 545 | 5.5 |
| | 32 | 3 | 70 | 0.305 | 1.05 | 12.8 | 695 | 635 | 8.5 |
| | | | | | | | | | |
| M | 25 | 2 | 50 | 0.315 | 1.30 | 15.0 | 635 | 400 | 8.0 |
| | 32 | 3 | 50 | 0.315 | 1.30 | 19.2 | 495 | 470 | 11.5 |
| XL | 25 | 2 | 40 | 0.290 | 1.00 | 10.0 | 510 | 295 | 3.0 |
| | 32 | 3 | 40 | 0.290 | 1.00 | 12.8 | 400 | 350 | 4.5 |
| | | | | | | | | | |
| M | 25 | 2 | 30 | 0.225 | 1.01 | 15.0 | 380 | 170 | 2.5 |
| | 32 | 3 | 30 | 0.225 | 1.01 | 19.2 | 300 | 205 | 4.0 |
| XL | 25 | 2 | 25 | 0.210 | 0.78 | 10.0 | 320 | 135 | 1.0 |
| | 32 | 3 | 25 | 0.210 | 0.78 | 12.8 | 250 | 160 | 1.5 |
| | | | | | | | | | |

Rundplattenfräser NX

Wendeplatten 12mm, mit integriertem Luft-/Kühlkanal

| | |
|----|------------------------------|
| HM | λ 0° γ 14° |
| | |
| | |
| | |



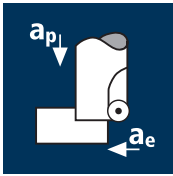
| | | | | | | | | | |
|-------------|----------------|-----------------|-----------------|--------------|--|--|--|--|-------|
| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | Rm 1300-1500 | HRC 48-56 | | | | | GG(G) |
|-------------|----------------|-----------------|-----------------|--------------|--|--|--|--|-------|

| Rundplattenfräser | | Lieferumfang: Fräserkörper inkl. Klemmschrauben für Wendeplatten montiert | | | | | | | |
|-------------------|----|---|----|-----|----|--------------------|---|-------|---|
| Bestell-Nr. | d1 | d2 h6 | d3 | l1 | l3 | ap _{max.} | z | L-Typ | |
| W03150.252 | 25 | 25 | 24 | 124 | 65 | 1.7 | 2 | M | ● |
| W03195.252 | 25 | 25 | 24 | 210 | 65 | 1.7 | 2 | XL | ● |
| W03150.323 | 32 | 32 | 31 | 144 | 81 | 1.7 | 3 | M | ● |
| W03195.323 | 32 | 32 | 31 | 250 | 81 | 1.7 | 3 | XL | ● |
| | | | | | | | | | |
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| NX Wendeplatten 12mm | | Lieferumfang: Verpackungseinheit 10 Stk. | | |
|----------------------|------|--|-----|---|
| Bestell-Nr. | D1 | r | D | |
| W53110.012 | 12.0 | 6.0 | 4.8 | ● |

| Zubehör | | Lieferumfang Klemmschrauben für Wendeplatten: Verpackungseinheit 10 Stk. | |
|-------------|--|--|---|
| Bestell-Nr. | | | |
| W93110.012 | Drehmoment-Schraubendreher 4.25 Nm mit Klinge Torx TX 15 | | ● |
| W90111.013 | Wechselklinge zu Drehmoment-Schraubendreher Torx TX 15 | | ● |
| W90100.013 | Schraubendreher Torx TX 15 | | ● |
| W93500.012 | Klemmschrauben für Wendeplatten Torx TX 15 / M 4 x 8.5 | | ● |

Anwendung



Werkstoff

Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Stahl
1100 - 1300 N/mm²



Stahl
1300 - 1500 N/mm²



Werkstoff

Stahl
1500 - 1800 N/mm²



Gusseisen
GG(G)



| L-Typ [mm] | d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|---------------|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| M | 25 | 2 | 220 | 0.500 | 1.67 | 15.0 | 2800 | 2800 | 70.0 |
| | 32 | 3 | 220 | 0.500 | 1.67 | 19.2 | 2190 | 3285 | 105.5 |
| XL | 25 | 2 | 180 | 0.480 | 1.50 | 10.0 | 2290 | 2200 | 33.0 |
| | 32 | 3 | 180 | 0.480 | 1.50 | 12.8 | 1790 | 2580 | 49.5 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|------|------|
| M | 25 | 2 | 200 | 0.400 | 1.50 | 15.0 | 2545 | 2035 | 46.0 |
| | 32 | 3 | 200 | 0.400 | 1.50 | 19.2 | 1990 | 2390 | 69.0 |
| XL | 25 | 2 | 160 | 0.385 | 1.40 | 10.0 | 2035 | 1565 | 22.0 |
| | 32 | 3 | 160 | 0.385 | 1.40 | 12.8 | 1590 | 1835 | 33.0 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|------|------|
| M | 25 | 2 | 180 | 0.350 | 1.42 | 15.0 | 2290 | 1605 | 34.0 |
| | 32 | 3 | 180 | 0.350 | 1.42 | 19.2 | 1790 | 1880 | 51.5 |
| XL | 25 | 2 | 140 | 0.335 | 1.27 | 10.0 | 1785 | 1195 | 15.0 |
| | 32 | 3 | 140 | 0.335 | 1.27 | 12.8 | 1395 | 1400 | 23.0 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|------|------|
| M | 25 | 2 | 120 | 0.300 | 1.34 | 15.0 | 1530 | 920 | 18.5 |
| | 32 | 3 | 120 | 0.300 | 1.34 | 19.2 | 1195 | 1075 | 27.5 |
| XL | 25 | 2 | 100 | 0.290 | 1.20 | 10.0 | 1275 | 740 | 9.0 |
| | 32 | 3 | 100 | 0.290 | 1.20 | 12.8 | 995 | 865 | 13.5 |

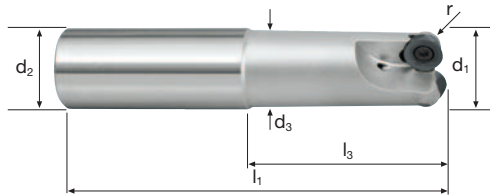
| L-Typ [mm] | d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|---------------|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| M | 25 | 2 | 100 | 0.250 | 1.25 | 15.0 | 1275 | 640 | 12.0 |
| | 32 | 3 | 100 | 0.250 | 1.25 | 19.2 | 995 | 745 | 18.0 |
| XL | 25 | 2 | 80 | 0.240 | 1.13 | 10.0 | 1020 | 490 | 5.5 |
| | 32 | 3 | 80 | 0.240 | 1.13 | 12.8 | 795 | 570 | 8.0 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|------|------|
| M | 25 | 2 | 180 | 0.500 | 1.67 | 15.0 | 2290 | 2290 | 57.5 |
| | 32 | 3 | 180 | 0.500 | 1.67 | 19.2 | 1790 | 2685 | 86.0 |
| XL | 25 | 2 | 140 | 0.480 | 1.50 | 10.0 | 1785 | 1715 | 25.5 |
| | 32 | 3 | 140 | 0.480 | 1.50 | 12.8 | 1395 | 2010 | 38.5 |

Rundplattenfräser SX

Wendeplatten 12mm, mit integriertem Luft-/Kühlkanal

| | |
|----|------------------------------|
| HM | λ 0° γ 19° |
| | |
| | |
| | |



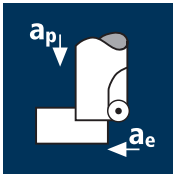
| | | | | | | | | | |
|-------------|----------------|--|--|--|--|--|-------------------|----------------|------------|
| Rm < 850 | Rm 850-1100 | | | | | | Inox Stainless | Ti Titanium | Tool Steel |
|-------------|----------------|--|--|--|--|--|-------------------|----------------|------------|

| Rundplattenfräser | | Lieferumfang: Fräserkörper inkl. Klemmschrauben für Wendeplatten montiert | | | | | | | |
|-------------------|----|---|----|-----|----|--------------------|---|-------|---|
| Bestell-Nr. | d1 | d2 h6 | d3 | l1 | l3 | ap _{max.} | z | L-Typ | |
| W03150.252 | 25 | 25 | 24 | 124 | 65 | 1.7 | 2 | M | ● |
| W03195.252 | 25 | 25 | 24 | 210 | 65 | 1.7 | 2 | XL | ● |
| W03150.323 | 32 | 32 | 31 | 144 | 81 | 1.7 | 3 | M | ● |
| W03195.323 | 32 | 32 | 31 | 250 | 81 | 1.7 | 3 | XL | ● |
| | | | | | | | | | |
| | | | | | | | | | |
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| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

| SX Wendeplatten 12mm | | Lieferumfang: Verpackungseinheit 10 Stk. | | |
|----------------------|------|--|-----|---|
| Bestell-Nr. | D1 | r | D | |
| W53310.012 | 12.0 | 6.0 | 4.8 | ● |

| Zubehör | | Lieferumfang Klemmschrauben für Wendeplatten: Verpackungseinheit 10 Stk. | | |
|-------------|--|--|--|---|
| Bestell-Nr. | | | | |
| W93110.012 | Drehmoment-Schraubendreher 4.25 Nm mit Klinge Torx TX 15 | | | ● |
| W90111.013 | Wechselklinge zu Drehmoment-Schraubendreher Torx TX 15 | | | ● |
| W90100.013 | Schraubendreher Torx TX 15 | | | ● |
| W93500.012 | Klemmschrauben für Wendeplatten Torx TX 15 / M 4 x 8.5 | | | ● |

Anwendung



Werkstoff

Nichtrostender Stahl
ferritisch/martensitisch



Nichtrostender Stahl
[Cr-Ni/1.4301]



Nichtrostender Stahl
[Cr-Ni-Mo-.../1.4571]



Hitzebeständiger Stahl
[17-4 PH]



| L-Typ [mm] | d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|---------------|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| M | 25 | 2 | 160 | 0.380 | 1.14 | 15.0 | 2035 | 1545 | 26.5 |
| | 32 | 3 | 160 | 0.380 | 1.14 | 19.2 | 1590 | 1815 | 39.5 |
| XL | 25 | 2 | 140 | 0.360 | 0.90 | 10.0 | 1785 | 1285 | 11.5 |
| | 32 | 3 | 140 | 0.360 | 0.90 | 12.8 | 1395 | 1505 | 17.5 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|------|------|
| M | 25 | 2 | 120 | 0.340 | 1.03 | 15.0 | 1530 | 1040 | 16.0 |
| | 32 | 3 | 120 | 0.340 | 1.03 | 19.2 | 1195 | 1220 | 24.0 |
| XL | 25 | 2 | 100 | 0.325 | 0.81 | 10.0 | 1275 | 830 | 6.5 |
| | 32 | 3 | 100 | 0.325 | 0.81 | 12.8 | 995 | 970 | 10.0 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|------|------|
| M | 25 | 2 | 130 | 0.305 | 1.03 | 15.0 | 1655 | 1010 | 15.5 |
| | 32 | 3 | 130 | 0.305 | 1.03 | 19.2 | 1295 | 1185 | 23.5 |
| XL | 25 | 2 | 110 | 0.290 | 0.81 | 10.0 | 1400 | 810 | 6.5 |
| | 32 | 3 | 110 | 0.290 | 0.81 | 12.8 | 1095 | 955 | 10.0 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|-----|------|
| M | 25 | 2 | 100 | 0.230 | 0.80 | 15.0 | 1275 | 585 | 7.0 |
| | 32 | 3 | 100 | 0.230 | 0.80 | 19.2 | 995 | 685 | 10.5 |
| XL | 25 | 2 | 80 | 0.215 | 0.63 | 10.0 | 1020 | 440 | 3.0 |
| | 32 | 3 | 80 | 0.215 | 0.63 | 12.8 | 795 | 515 | 4.0 |

Werkstoff

Titanlegierungen ausg.
>300 HB
[Ti6Al4V]



Stahl
< 850 N/mm²



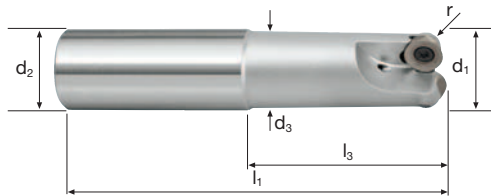
| L-Typ [mm] | d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|---------------|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| M | 25 | 2 | 55 | 0.210 | 0.74 | 15.0 | 700 | 295 | 3.5 |
| | 32 | 3 | 55 | 0.210 | 0.74 | 19.2 | 545 | 345 | 5.0 |
| XL | 25 | 2 | 45 | 0.200 | 0.59 | 10.0 | 575 | 230 | 1.5 |
| | 32 | 3 | 45 | 0.200 | 0.59 | 12.8 | 450 | 270 | 2.0 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|------|------|
| M | 25 | 2 | 220 | 0.475 | 1.54 | 15.0 | 2800 | 2660 | 61.5 |
| | 32 | 3 | 220 | 0.475 | 1.54 | 19.2 | 2190 | 3120 | 92.5 |
| XL | 25 | 2 | 180 | 0.450 | 1.42 | 10.0 | 2290 | 2060 | 29.5 |
| | 32 | 3 | 180 | 0.450 | 1.42 | 12.8 | 1790 | 2415 | 44.0 |

Rundplattenfräser ZX

Wendepplatten 12mm, mit integriertem Luft-/Kühlkanal

HM λ 0°
 γ 13°



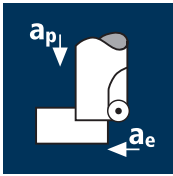
| | | | | | | | | | |
|-------------|----------------|--|--|--|--|--|-------------------|----------------|----------------------|
| Rm < 850 | Rm 850-1100 | | | | | | Inox Stainless | Ti Titanium | Nickel-Alloys HSS |
|-------------|----------------|--|--|--|--|--|-------------------|----------------|----------------------|

| Rundplattenfräser | | Lieferumfang: Fräserkörper inkl. Klemmschrauben für Wendepplatten montiert | | | | | | | |
|-------------------|----|--|----|-----|----|--------------------|---|-------|---|
| Bestell-Nr. | d1 | d2 h6 | d3 | l1 | l3 | ap _{max.} | z | L-Typ | |
| W03150.252 | 25 | 25 | 24 | 124 | 65 | 1.7 | 2 | M | ● |
| W03195.252 | 25 | 25 | 24 | 210 | 65 | 1.7 | 2 | XL | ● |
| W03150.323 | 32 | 32 | 31 | 144 | 81 | 1.7 | 3 | M | ● |
| W03195.323 | 32 | 32 | 31 | 250 | 81 | 1.7 | 3 | XL | ● |
| | | | | | | | | | |
| | | | | | | | | | |
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| ZX Wendepplatten 12mm | | Lieferumfang: Verpackungseinheit 10 Stk. | | |
|-----------------------|------|--|-----|---|
| Bestell-Nr. | D1 | r | D | |
| W53410.012 | 12.0 | 6.0 | 4.8 | ● |

| Zubehör | | Lieferumfang Klemmschrauben für Wendepplatten: Verpackungseinheit 10 Stk. | | |
|-------------|--|---|--|---|
| Bestell-Nr. | | | | |
| W93110.012 | Drehmoment-Schraubendreher 4.25 Nm mit Klinge Torx TX 15 | | | ● |
| W90111.013 | Wechselklinge zu Drehmoment-Schraubendreher Torx TX 15 | | | ● |
| W90100.013 | Schraubendreher Torx TX 15 | | | ● |
| W93500.012 | Klemmschrauben für Wendepplatten Torx TX 15 / M 4 x 8.5 | | | ● |

Anwendung



Werkstoff

Nichtrostender Stahl
[Cr-Ni/1.4301]



Nichtrostender Stahl
[Cr-Ni-Mo-.../1.4571]



Hitzebeständiger Stahl
Duplex Stahl
[1.4462]
[17-4 PH]



Titanlegierungen ausg.
>300 HB
[Ti6Al4V]



Werkstoff

PM-Schnellarbeitsstahl
geglüht
[Böhler S390]
[ASP 2023]



Nickelbasislegierungen
[Inconel 718]
[Hastelloy B-3]
[Nimonic 90]



| L-Typ [mm] | d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|---------------|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| M | 25 | 2 | 130 | 0.360 | 1.00 | 15.0 | 1655 | 1190 | 18.0 |
| | 32 | 3 | 130 | 0.360 | 1.00 | 19.2 | 1295 | 1400 | 27.0 |
| XL | 25 | 2 | 110 | 0.340 | 0.80 | 10.0 | 1400 | 950 | 7.5 |
| | 32 | 3 | 110 | 0.340 | 0.80 | 12.8 | 1095 | 1115 | 11.5 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|------|------|
| M | 25 | 2 | 140 | 0.325 | 1.00 | 15.0 | 1785 | 1160 | 17.5 |
| | 32 | 3 | 140 | 0.325 | 1.00 | 19.2 | 1395 | 1360 | 26.0 |
| XL | 25 | 2 | 120 | 0.305 | 0.80 | 10.0 | 1530 | 935 | 7.5 |
| | 32 | 3 | 120 | 0.305 | 0.80 | 12.8 | 1195 | 1095 | 11.0 |

| | | | | | | | | | |
|----|----|---|-----|-------|------|------|------|-----|------|
| M | 25 | 2 | 110 | 0.235 | 0.80 | 15.0 | 1400 | 660 | 8.0 |
| | 32 | 3 | 110 | 0.235 | 0.80 | 19.2 | 1095 | 770 | 12.0 |
| XL | 25 | 2 | 100 | 0.220 | 0.64 | 10.0 | 1275 | 560 | 3.5 |
| | 32 | 3 | 100 | 0.220 | 0.64 | 12.8 | 995 | 655 | 5.5 |

| | | | | | | | | | |
|----|----|---|----|-------|------|------|-----|-----|-----|
| M | 25 | 2 | 60 | 0.215 | 0.75 | 15.0 | 765 | 330 | 3.5 |
| | 32 | 3 | 60 | 0.215 | 0.75 | 19.2 | 595 | 385 | 5.5 |
| XL | 25 | 2 | 50 | 0.205 | 0.60 | 10.0 | 635 | 260 | 1.5 |
| | 32 | 3 | 50 | 0.205 | 0.60 | 12.8 | 495 | 305 | 2.5 |

| L-Typ [mm] | d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|---------------|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| M | 25 | 2 | 80 | 0.250 | 0.90 | 15.0 | 1020 | 510 | 7.0 |
| | 32 | 3 | 80 | 0.250 | 0.90 | 19.2 | 795 | 595 | 10.5 |
| XL | 25 | 2 | 70 | 0.240 | 0.72 | 10.0 | 890 | 425 | 3.0 |
| | 32 | 3 | 70 | 0.240 | 0.72 | 12.8 | 695 | 500 | 4.5 |

| | | | | | | | | | |
|----|----|---|----|-------|------|------|-----|-----|-----|
| M | 25 | 2 | 35 | 0.145 | 0.80 | 10.0 | 445 | 130 | 1.0 |
| | 32 | 3 | 35 | 0.145 | 0.80 | 12.8 | 350 | 150 | 1.5 |
| XL | 25 | 2 | 30 | 0.135 | 0.64 | 10.0 | 380 | 105 | 0.5 |
| | 32 | 3 | 30 | 0.135 | 0.64 | 12.8 | 300 | 120 | 1.0 |