

DIAATEC

Diamanttechnik GmbH



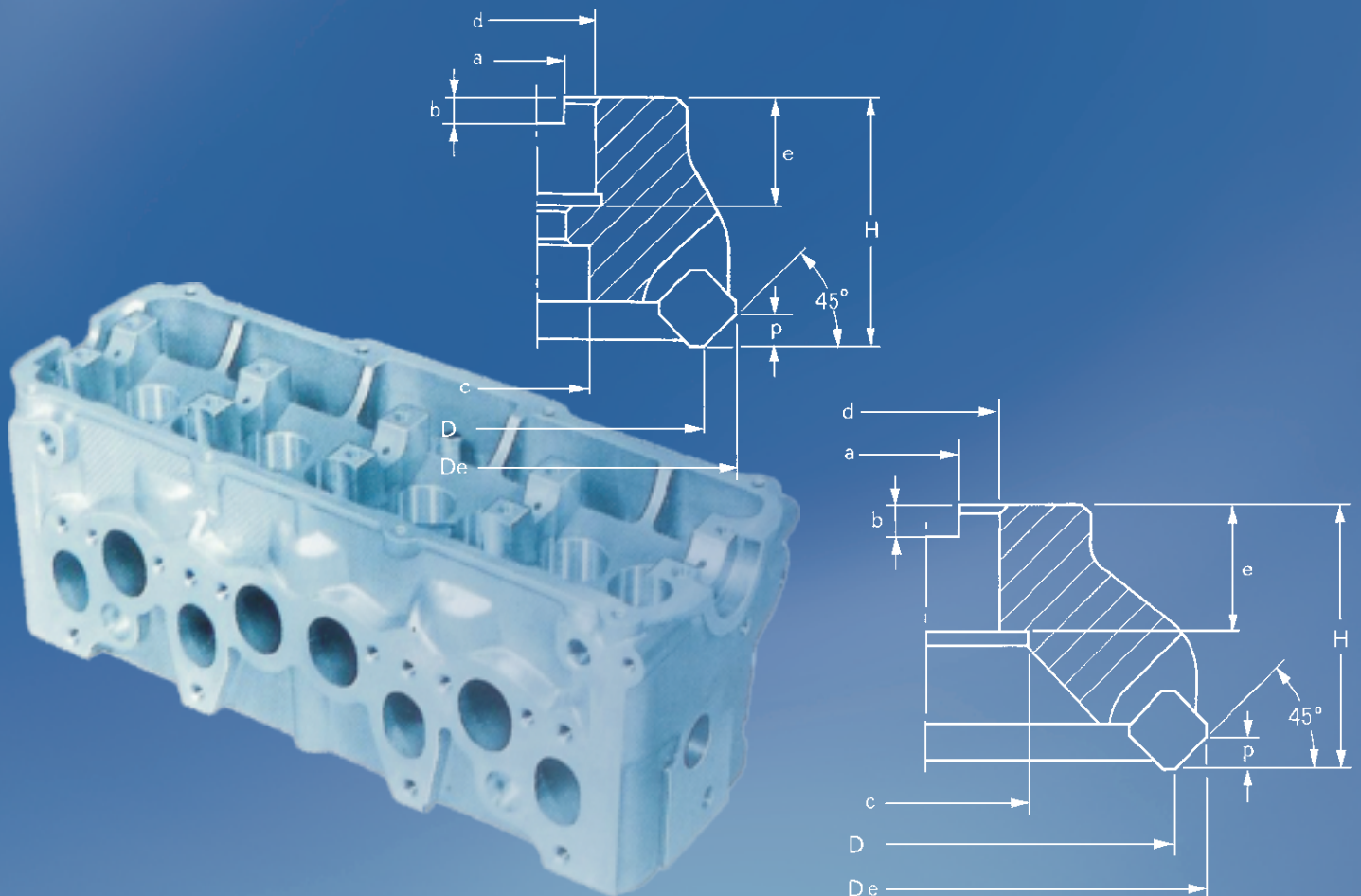
Ihr zuverlässiger Partner für Präzisionswerkzeuge



Your competent partner for precisions-tools



Votre partenaire fiable pour les outils de précision



Planfräser

einstellbar

einstellbar

mit hoher

Zähnezahl

Hinweise für Planfräser - EINSTELLBAR

Einstellschraube (SW 1,5 mm) lösen

Wendeplatten montieren, WPL-Schrauben anziehen.

Unter Voreinstellgerät oder Optik die Wendeplatten
nach der höchsten Wendeplatte ausrichten

**Beim Wendeplatten-Tausch zuerst die
Einstellschrauben (SW 1,5 mm) lösen, dann die Wendeplatten
wechseln**

um das optimale Ergebnis zu erzielen, sollte das Werkzeug vor dem Einsatz **gewuchtet** werden.

Schnittdaten-Richtwerte

HARTMETALL		F			R		
	Vc m/min	fz in mm	ap in mm	Vc m/min	fz in mm	ap in mm	
Stahl	350-120	0,05 - 0,10	0,1-2,0	180-100	0,15-0,20	4 - 8 mm	
VA-Stahl	250-100	0,05 - 0,10	0,1-2,0	160-70	0,15-0,20	4 - 8 mm	
Guss	300-120	0,05 - 0,10	0,1-2,0	220-100	0,15-0,20	4 - 8 mm	
NE-Metall	< 2000	0,05 - 0,10	0,1-2,0	< 2000	0,15-0,20	4 - 8 mm	

		C B N			P K D		
		F			F		
Guss	1600 - 500	0,08 - 0,15	0,2 - 1,5				
hochfeste Legierung	700 - 350	0,05 - 0,12	0,2 - 1,0				
Hart - bearb.	600 - 350	0,04 - 0,10	0,2 - 0,4				
NE-Metall				~ 3000	0,05 - 0,25	0,1 - 3,5	

VORTEILE

z.B. beim Einsatz mit
PKD -Wendeplatten

hoher
Vorschub

durch
grosse Schneidenanzahl

hervorragende
Oberflächen-
güten

Rz + Wf -Werte
werden gesenkt

Minderung
der
Gratbildung

nachträgliches Bürsten kann
meist entfallen

schnelle
Planlauf-
einstellung

keine aufwendigen
Einbauteile

Artikel-Nummer	Durchmesser	Zähnezahl		
PK 40 - 10 E	40	6		
PK 50 - 10 E	50	7		
PK 63 - 10 E	63	8		
PK 80 - 10 E	80	11		
PK 100 - 10 E	100	13		
PK 125 - 10 E	125	16		

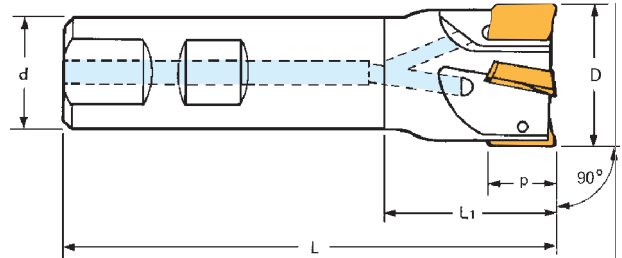
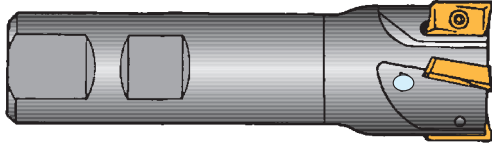
PKD -Wendeplatten

APKT 100305

ECKFRÄSER

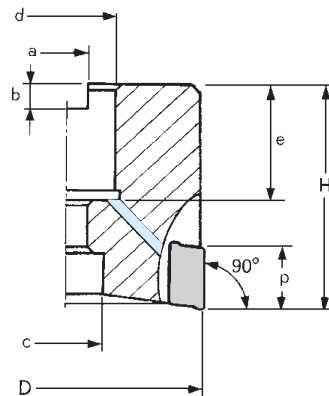
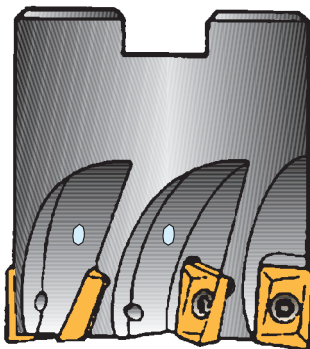
Shoulder milling cutters

ART. 740 W



Bestell-Nr Order No.	(mm) Abmessungen - Dimensions						Wendeplatte Insert	Ersatzteile Spare parts	
	D	d	L	L1	p	z		Screw	Key
740W-WD10	10	16	80	24	10	1	APHT APHX APKT 1003 ...	VT 25	BT 08
740W-WD12	12	16	80	24	10	1			
740W-WD14	14	16	80	24	10	1			
740W-WD16	16	16	85	25	10	2			
740W-WD18	18	20	85	25	10	2			
740W-WD20	20	20	90	25	10	3			
740W-WD22	22	25	95	25	10	3			
740W-WD25	25	25	95	25	10	4			
740W-WD28	28	25	95	25	10	4			
740W-WD30	30	25	95	25	10	4			
740W-WD32	32	25	95	25	10	5			
740W-WD40	40	32	110	26	10	6			
740W-WL D10	10	16	150	24	10	1			
740W-WL D12	12	16	150	24	10	1			
740W-WL D16	16	16	150	24	10	2			
740W-WL D20	20	20	150	25	10	3			
740W-WL D25	25	20	150	25	10	4			
740W-WL D32	32	25	150	26	10	5			

ART. 740 M



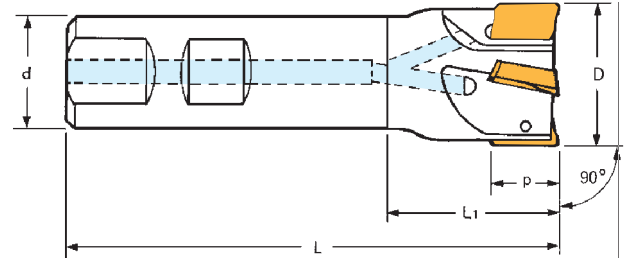
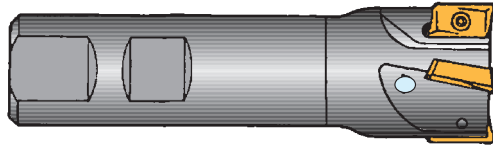
Bestell-Nr Order No.	(mm) Abmessungen - Dimensions									Wendeplatte Insert	Ersatzteile Spare parts	
	D	d	c	e	a	b	H	p	z		Screw	Key
740M-W-D40	40	22	17	21	10,4	6,3	40	10	6	APHT APHX APKT 1003 ...	VT 25	BT 08
740M-W-D50	50	22	17	21	10,4	6,3	40	10	7			
740M-W-D63	63	22	17	21	10,4	6,3	40	10	8			
740M-W-D80	80	27	20	22	12,4	7	50	10	11			

Kühlmittelbohrung - Coolant bores

ECKFRÄSER

Shoulder milling cutters

ART. 741W

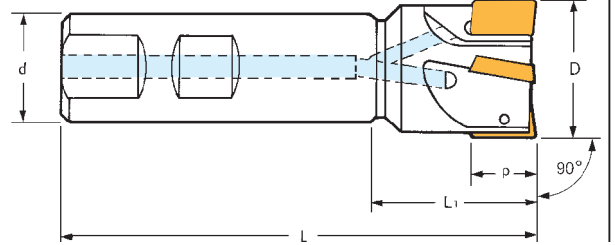
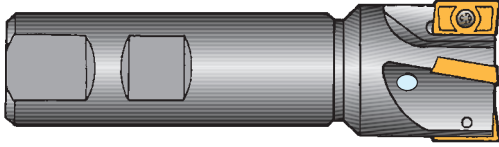


Bestell-Nr Order No.	(mm) Abmessungen - Dimensions						Wendeplatte Insert	Ersatzteile Spare parts	
	D	d	L	L1	p	z		Screw	Key
741W-WD9,7	9,7	16	80	20	10	1	APHT APHX APKT 1003 ...	VT 25	BT 08
741W-WD11,7	11,7	16	80	20	10	1			
741W-WD15,7	15,7	16	85	24	10	2			
741W-WD19,7	19,7	20	90	25	10	3			
741W-WD24,7	24,7	25	95	25	10	4			
741W-WD31,7	31,7	32	95	25	10	5			

ECKFRÄSER

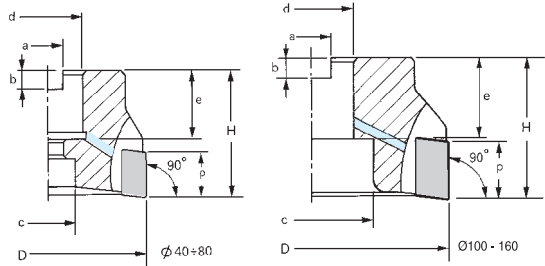
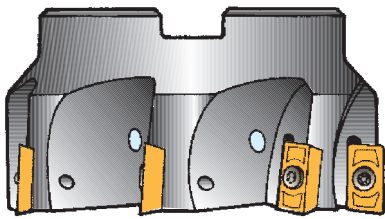
Shoulder milling cutters

ART. 730 W



Bestell-Nr Order No.	(mm) Abmessungen - Dimensions						Wendeplatte Insert	Ersatzteile Spare parts	
	D	d	L	L1	p	z		Screw	Key
730W-W D25	25	25	100	44	17	2	APFT APKT APHT 1604 ...	VT 40	CT 15
730W-W D32	32	32	110	50	17	3			
730W-W D40	40	32	115	45	17	4			
730WL-D22	22	20	200	60	17	2			
730WL-D25	25	25	200	60	17	2			
730WL-D32	32	25	200	60	17	3			

ART. 730 M



Bestell-Nr Order No.	(mm) Abmessungen - Dimensions									Wendeplatte Insert	Ersatzteile Spare parts	
	D	d	c	e	a	b	H	p	z		Screw	Key
730M-W D40	40	16	12	18	8,4	5,6	40	17	4	APFT APKT APHT 1604 ...	VT 40	CT 15
730M-W D50	50	22	18	21	10,4	6,3	40	17	5			
730M-W D63	63	22	18	21	10,4	6,3	40	17	6			
730M-W D80	80	27	20	22	12,4	7	50	17	7			
730M-W D100	100	32	45	26	14,4	8	50	17	8			
730M-W D125	125	40	56	38	16,4	9	63	17	9			
730M-W D160	160	40	87	32	16,4	9	63	17	10			



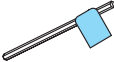
FASENFRÄSER 15°, 30°, 45°, 60°, 75°

Milling cutter for chamfering 15°, 30°, 45°, 60° and 75°

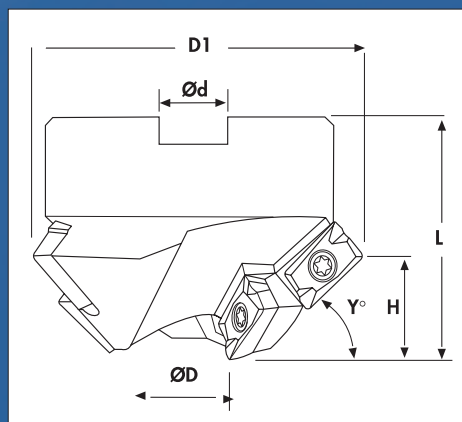


ART. **FB.035**

15° - 30° - 45° - 60° - 75°

Bestell-Nr Order No.	(mm) Abmessungen - Dimension										
	D	D1	d	L	Y°	H	Z	K			
FB.035.001	35	75	27	50	45°	21,5	6	3	APKT 1604 APFT 1604 APHX 1604	VT 40	BT 15
FB.035.002	35	62	27	50	60°	26,5	6	3			
FB.035.003	35	85	27	50	30°	15,0	6	3			
FB.035.004	35	90	27	50	15°	8,0	6	3			
FB.035.005	35	45	22	60	75°	29,5	6	3			

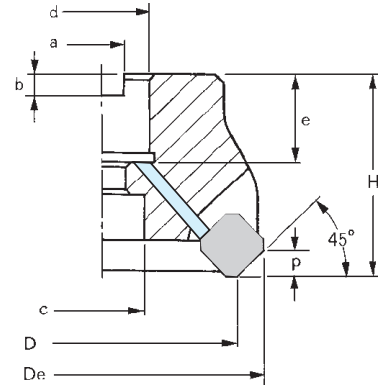
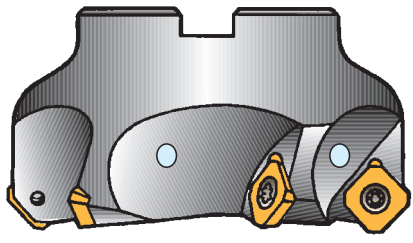
K = Vorschubfaktor / Factor of feed





PLANFRÄSER - 45°

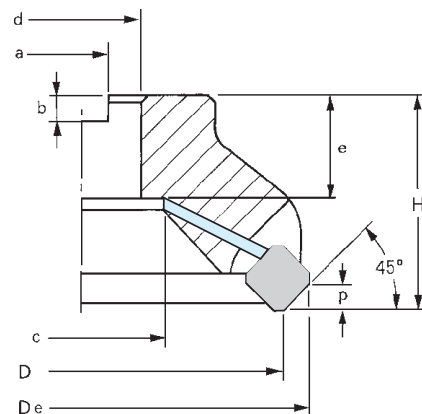
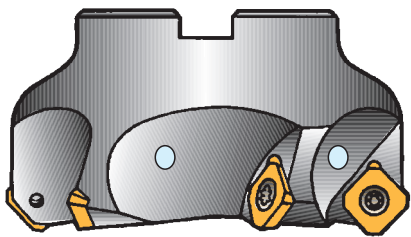
Face milling cutters (45°)



ART. 600 M



Bestell-Nr Order No.	(mm) Abmessungen - Dimensions										Wendeplatte Insert	Ersatzteile Spare parts	
	D	De	d	c	e	a	b	H	p	z		Screw	Key
600MW-D40-12	40	53	16	14	18	8,4	5,6	40	6	3	SEHW SEHX SEHT 1204 ...	VT 50 	CT 20 
600MW-D50-12	50	63	22	17	21	10,4	6,3	48	6	4			
600MW-D63-12	63	76	22	19	21	10,4	6,3	48	6	5			
600MW-D80-12	80	93	27	38	24	12,4	7	50	6	6			
600MW-D100-12	100	113	32	45	26	14,4	8	50	6	6			
600MW-D125-12	125	138	40	56	32	16,4	9	63	6	7			
600MW-D160-12	160	173	40	-	-	-	9	63	6	8			
600M-D200-12	200	213	60	-	-	-	13,5	63	6	12			
600M-D250-12	250	263	60	-	-	-	13,5	63	6	16			

ART. 670 M



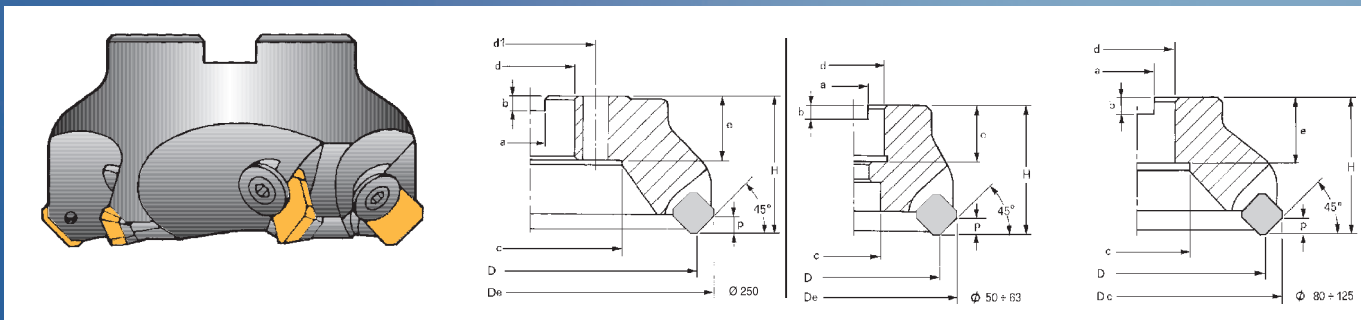
Codice d'ordine Bestell-Nr Order No.	(mm) Abmessungen - Dimensions										Wendeplatte Insert	Ersatzteile Spare parts	
	D	De	d	c	e	a	b	H	p	z		Screw	Key
670MW-D50-12	50	63	22	17	21	10,4	6,3	48	6	4	SDHT SDHW SDMT 1204 ...	VT 45 P 	CT 20 
670MW-D63-12	63	76	22	19	21	10,4	6,3	48	6	5			
670MW-D80-12	80	93	27	38	24	12,4	7	50	6	6			
670MW-D100-12	100	113	32	45	26	14,4	8	50	6	6			
670MW-D125-12	125	138	40	56	32	16,4	9	63	6	7			
670MW-D160-12	160	173	40	-	-	-	9	63	6	8			
670M-D200-12	200	213	60	-	-	-	13,5	63	6	12			
670M-D250-12	250	263	60	-	-	-	13,5	63	6	16			

W-W + M-W= Kuehlmittelbohrung - Coolant bores

PLANFRÄSER - 45°

Face milling cutters (45°)

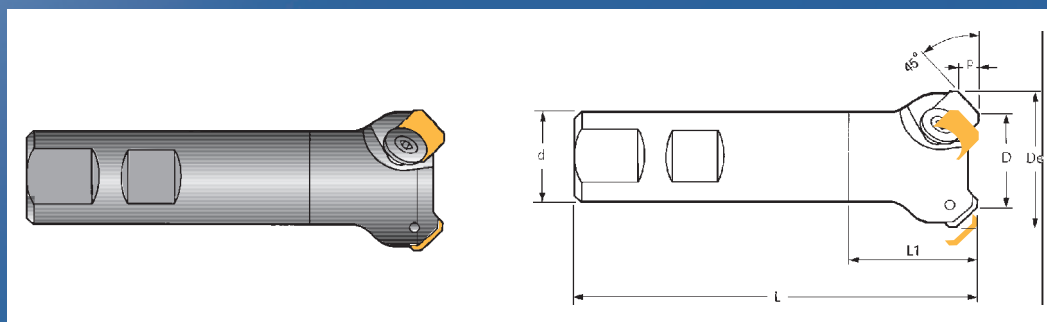
ART. 550 M



Bestell-Nr Order No.	(mm) Abmessungen - Dimensions											Wendeplatte Insert
	D	De	d	d1	c	e	a	b	H	p	z	
550M-D50-12	50	63	22	-	17	21	10,4	6,3	48	6	4	SEKN SEKR SEAN 1203...
550M-D63-12	63	76	22	-	19	21	10,4	6,3	40	6	5	
550M-D80-12	80	93	27	-	38	24	12,4	7	50	6	6	
550M-D100-12	100	113	32	-	45	26	14,4	8	50	6	6	
550M-D125-12	125	138	40	-	56	32	16,4	9	63	6	7	
550M-D160-12	160	173	40	66,7	86	32	16,4	9	63	6	7	
550M-D200-12	200	213	60	101,7	129	32	25,7	14	63	6	10	
550M-D250-12	250	263	60	101,7	178	32	25,7	14	63	6	13	

Ersatzteile - Spare parts

 Support AKE 12 4,	 Insert locking screw CVB 55	 Screw support VF 4	 Key CL 2	 Key ET 4
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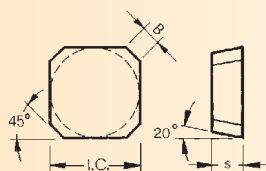
ART. 550 W

Bestell-Nr Order No.	(mm) Abmessungen - Dimensions							Wendeplatte Insert
	D	De	d	L	L1	p	z	
550W-D25-12	25	38	25	100	35	6	2	SEKN SEKR SEAN 1203...
550W-D32-12	32	45	25	110	44	6	3	
550W-D40-12	40	53	32	115	45	6	4	

Ersatzteile - Spare parts

 Support AKE 12,4	 Insert locking screw CVB 55 -C	 Screw support VF 4	 Key CL 2	 Key ET 4
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Wendeplatte
Insert



SEKN 1203...
SEKR 1203...
SEAN 1203...

I.C.

s

B

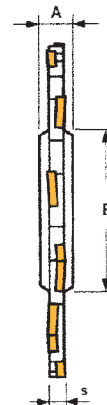
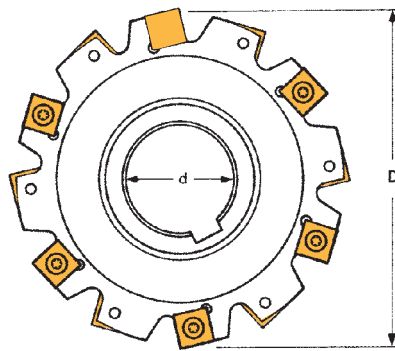
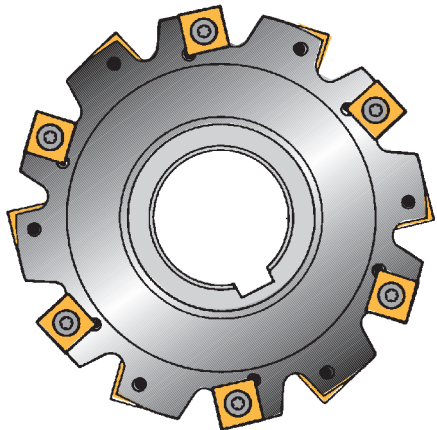
12,70

3,18

2,3

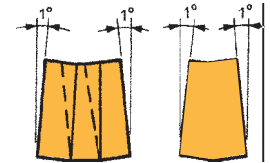
SCHEIBENFRÄSER



Grooving and cut-off mills



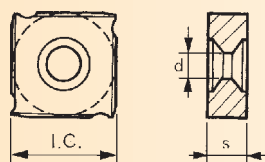
ART. 610

Axial winkel 3°
Radial winkel - 12°
Axial rake 3°
Radial rake - 12°



Bestell-Nr Order No.	(mm) Abmessungen - Dimensions									Ersatzteile Spare parts		
	D	d	s	A	B	Z	Fattore K	Max	Wendeplatte Insert	Screw	Key	
												
610-63-04	63	22	4	8	34	8	4	14	SNHX 1102T	VTX 3503	CT 09	
-05	63	22	5	8	34	8	4	14	SNHX 1103T	VTX 3504	CT 09	
-06	63	22	6	8	34	6	3	14	SNHX 1203T	VTX 405	CT 15	
610-80-04	80	22	4	8	34	10	5	22	SNHX 1102T	VTX 3503	CT 09	
-05	80	22	5	8	34	10	5	22	SNHX 1103T	VTX 3504	CT 09	
-06	80	22	6	8	34	8	4	22	SNHX 1203T	VTX 405	CT 15	
610-100-04	100	27	4	12	45	12	6	27	SNHX 1102T	VTX 3503	CT 09	
-05	100	27	5	12	45	12	6	27	SNHX 1103T	VTX 3504	CT 09	
-06	100	27	6	12	45	10	5	27	SNHX 1203T	VTX 405	CT 15	
-07	100	27	7	12	45	9	3	27	SNHX 1203T	VTX 405	CT 15	
-08	100	27	8	12	45	9	3	27	SNHX 1203T	VTX 405	CT 15	
-09	100	27	9	12	45	10	5	27	SNHX 1205T	VTX 408	CT 15	
-10	100	27	10	12	45	10	5	27	SNHX 1205T	VTX 408	CT 15	
610-125-04	125	32	4	12	58	14	7	33	SNHX 1102T	VTX 3503	CT 09	
-05	125	32	5	12	58	14	7	33	SNHX 1103T	VTX 3504	CT 09	
-06	125	32	6	12	58	12	6	33	SNHX 1203T	VTX 405	CT 15	
-07	125	32	7	12	58	12	4	33	SNHX 1203T	VTX 405	CT 15	
-08	125	32	8	12	58	12	4	33	SNHX 1203T	VTX 405	CT 15	
-09	125	32	9	12	58	12	6	33	SNHX 1205T	VTX 408	CT 15	
-10	125	32	10	12	58	12	6	33	SNHX 1205T	VTX 408	CT 15	
-12	125	32	12	12	58	12	4	33	SNHX 1205T	VTX 408	CT 15	
610-160-04	160	40	4	12	68	18	9	45	SNHX 1102T	VTX 3503	CT 09	
-05	160	40	5	12	68	18	9	45	SNHX 1103T	VTX 3504	CT 09	
-06	160	40	6	12	68	16	8	45	SNHX 1203T	VTX 405	CT 15	
-07	160	40	7	12	68	15	5	45	SNHX 1203T	VTX 405	CT 15	
-08	160	40	8	12	68	15	5	45	SNHX 1203T	VTX 405	CT 15	
-09	160	40	9	12	68	16	8	45	SNHX 1205T	VTX 408	CT 15	
-10	160	40	10	12	68	16	8	45	SNHX 1205T	VTX 408	CT 15	
-12	160	40	12	12	68	15	5	45	SNHX 1205T	VTX 408	CT 15	
-14	160	40	14	14	68	15	5	45	SNHX 1205T	VTX 408	CT 15	
610-200-04	200	50	4	12	72	18	9	63	SNHX 1102T	VTX 3503	CT 09	
-05	200	50	5	12	72	18	9	63	SNHX 1103T	VTX 3504	CT 09	
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-10	200	50	10	12	72	18	9	63	SNHX 1205T	VTX 408	CT 15	
-12	200	50	12	12	72	18	6	63	SNHX 1205T	VTX 408	CT 15	
-14	200	50	14	14	72	18	6	63	SNHX 1205T	VTX 408	CT 15	
610-250-08	250	50	8	12	72	24	8	88	SNHX 1203T	VTX 405	CT 15	
-10	250	50	10	12	72	24	12	88	SNHX 1205T	VTX 408	CT 15	
-12	250	50	12	12	72	24	8	88	SNHX 1205T	VTX 408	CT 15	
-14	250	50	14	14	72	24	8	88	SNHX 1205T	VTX 408	CT 15	

Wendeplatte
Insert



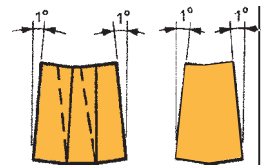
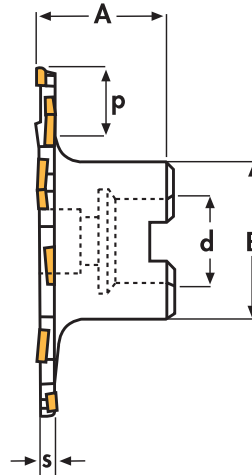
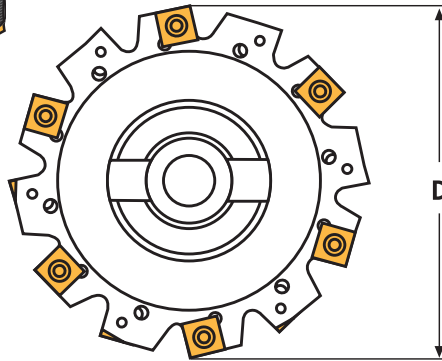
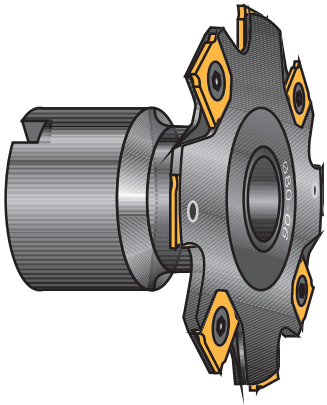
	a	s	d
SNHX 1102T			
SNHX 1103T	11,0	2,3	4,4
SNHX 1203T	11,0	2,7	4,4
SNHX 1205T	12,7	3,2	5,0
SNHX 1205T	12,7	5,4	5,0



SCHEIBENFRÄSER

Grooving and cut-off mills

ART. 610 M

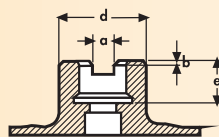
Axial winkel 3°
Radial winkel - 12°
Axial rake 3°
Radial rake - 12°



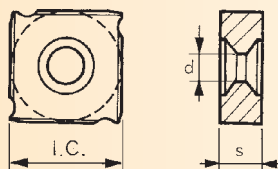
Bestell-Nr Order No.	(mm) Abmessungen - Dimensions								Wendeplatte Insert	Ersatzteile Spare parts	
	D	d	s	A	B	Z	K	Max Prof.		Screw	Key
	 										
610M-63-04	63	22	4	50	40	6	3	10,5	SNHX 1102T	VTX 3503	CT 09
-05	63	22	5	50	40	6	3	10,5	SNHX 1103T	VTX 3504	CT 09
-06	63	22	6	50	40	6	3	10,5	SNHX 1203T	VTX 405	CT 15
610M-80-04	80	22	4	50	40	8	4	20,2	SNHX 1102T	VTX 3503	CT 09
-05	80	22	5	50	40	8	4	20,2	SNHX 1103T	VTX 3504	CT 09
-06	80	22	6	50	40	8	4	20,2	SNHX 1203T	VTX 405	CT 15
610M-100-04	100	27	4	50	48	12	6	24,2	SNHX 1102T	VTX 3503	CT 09
-05	100	27	5	50	48	12	6	24,2	SNHX 1103T	VTX 3504	CT 09
-06	100	27	6	50	48	10	5	24,2	SNHX 1203T	VTX 405	CT 15
-10	100	27	10	50	48	10	5	24,2	SNHX 1205T	VTX 408	CT 15
610M-125-06	125	40	6	50	70	12	6	23,7	SNHX 1203T	VTX 405	CT 15
-10	125	40	10	50	70	12	6	23,7	SNHX 1205T	VTX 408	CT 15
610M-160-06	160	40	6	50	70	16	8	41,2	SNHX 1203T	VTX 405	CT 15
-10	160	40	10	50	70	16	8	41,2	SNHX 1205T	VTX 408	CT 15

Fraeser
Milling

Wendeplatte
Insert



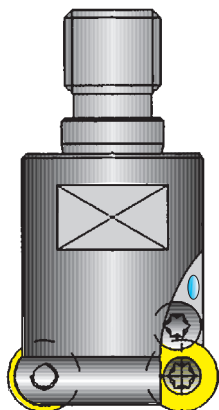
FRAESER MILLING	d	a	b	e
610M-63	22	10,4	6,3	21
610M-80	22	10,4	6,3	21
610M-100	27	12,4	7	23
610M-125	40	16,4	9	30
610M-160	40	16,4	9	30



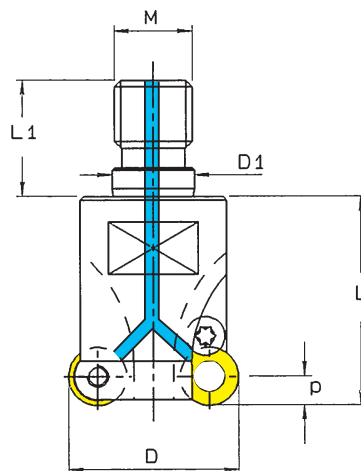
	i.C.	s	d
SNHX 1102T			
SNHX 1103T	11,0	2,3	4,4
SNHX 1203T	11,0	2,7	4,4
SNHX 1205T	12,7	3,2	5,0
	12,7	5,4	5,0

Einschraubfräser für Rund-WSP

Threaded type milling cutters






Art. **400 MO**

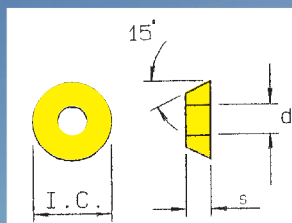


Order No. Bestell-Nr.	Dimension - Abmessungen							Insert Wendepatte
	D	L	M	D1	L1	p	z	
400MO D10-2	10	18	M6	6,5	14,5	2,5	2	RDHX 0501 MOT
400MO D20-5	20	30	M10	10,5	20	2,5	2	RDHX 0501 MOT
400MO D12-2	12	18	M6	6,5	14,5	3,5	2	RDHX 07T1 MOT
400MO D15-2	15	23	M8	8,5	17,5	3,5	2	RDHX 0702 MOT
400MO D15-3	15	23	M8	8,5	17,5	3,5	3	RDHX 0702 MOT
400MO D20-4	20	30	M10	10,5	20	3,5	4	RDHX 0702 MOT
400MO D25-5	25	35	M12	12,5	22	3,5	5	RDHX 0702 MOT
400MO D30-5	30	43	M16	17	24	3,5	5	RDHX 0702 MOT
400MO D20-2	20	30	M10	10,5	20	5	2	RDHX 1003 MOT
400MO D25-2	25	35	M12	12,5	22	5	2	RDHX 1003 MOT
400MO D25-3	25	35	M12	12,5	22	5	3	RDHX 1003 MOT
400MO D30-4	30	43	M16	17	24	5	4	RDHX 1003 MOT
400MO D35-4	35	43	M16	17	24	5	4	RDHX 1003 MOT
400MO D42-5	42	43	M16	17	24	5	5	RDHX 1003 MOT
400MO D24-2	24	35	M12	12,5	22	6	2	RDHX 12T3 MOT
400MO D35-3	35	43	M16	17	24	6	3	RDHX 12T3 MOT
400MO D42-4	42	43	M16	17	24	6	4	RDHX 12T3 MOT
400MO D32-2	32	43	M16	17	24	8	2	RDHX 1604 MOT

Spare parts - Ersatzteile

Order No. Bestell-Nr.	 Screw Schraube	 Clamp Spannklau	 Key Schlüssel
400MO D10-2	VT 18	-	BT 06
400MO D20-5	VT 18	-	BT 06
400MO D12-2	VT 2530	-	BT 07
400MO D15-2	VT 2530	-	BT 07
400MO D15-3	VT 2530	-	BT 07
400MO D20-4	VT 2530	-	BT 07
400MO D25-5	VT 2530	-	BT 07
400MO D30-5	VT 2530	-	BT 07
400MO D20-2	VT 35	-	BT 15
400MO D25-2	VT 35	-	BT 15
400MO D25-3	VT 35	-	BT 15
400MO D30-4	VT 35	-	BT 15
400MO D35-4	VT 35	-	BT 15
400MO D42-5	VT 35	-	BT 15
400MO D24-2	VT 35	-	BT 15
400MO D35-3	VT 35	-	BT 15
400MO D42-4	VT 35	-	BT 15
400MO D32-2	VT 45	CVB 45	BT 15

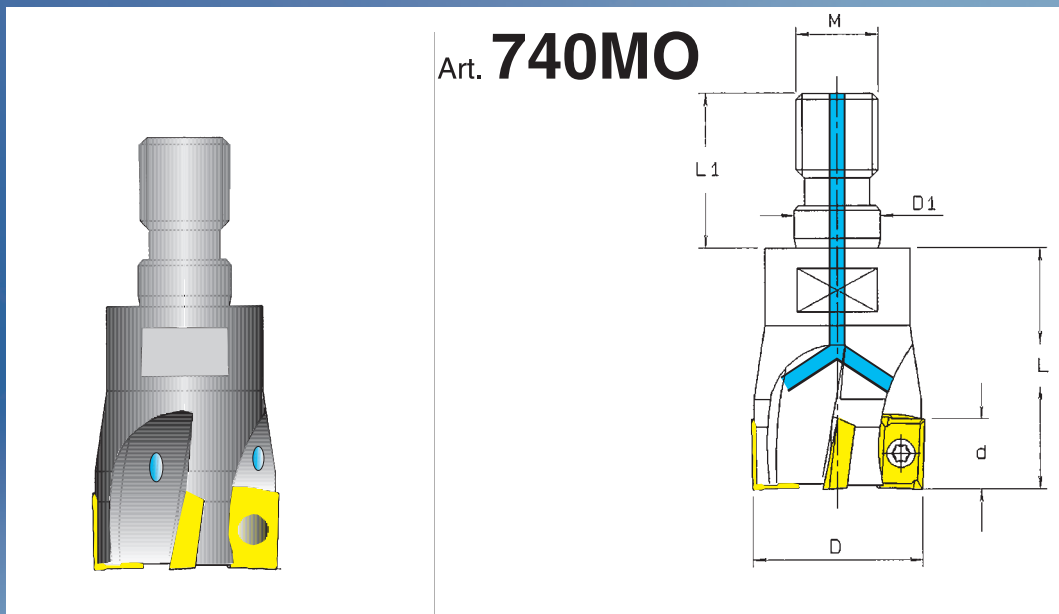
Insert
Wendepatte



	I.C.	s	d
RDHX 0501 MOT	5	1,28	2,1
RDHX 07T1 MOT	7	1,98	2,7
RDHX 0702 MOT	7	2,38	2,7
RDHX 1003 MOT	10	3,18	3,9
RDHX 12T3 MOT	12	3,97	3,9
RDHX 1604 MOT	16	4,76	5,2


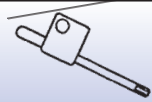
Einschraubfräser für Eck-WSP

Threaded shoulder milling cutters

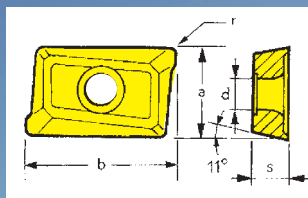


Order No. Bestell-Nr.	Dimension - Abmessungen							Insert Wendeplatte
	D	d	L	D1	M	z	L1	
740MO D10-1	10	10	20	6,5	M6	1	14,5	APHT APHX APKT 1003....
740MO D12-1	12	10	20	6,5	M6	1	14,5	
740MO D16-2	16	10	25	8,5	M8	2	17,5	
740MO D20-3	20	10	30	10,5	M10	3	20	
740MO D25-3	25	10	35	12,5	M12	3	22	
740MO D25-4	25	10	35	12,5	M12	4	22	
740MO D32-5	32	10	43	17	M16	5	24	

Spare parts - Ersatzteile

Order No. Bestell-Nr.		Screw Schraube		Key Schlüssel
740MO D10-1		VT 25		BT 08
740MO D12-1		VT 25		BT 08
740MO D16-2		VT 25		BT 08
740MO D20-3		VT 25		BT 08
740MO D25-3		VT 25		BT 08
740MO D25-4		VT 25		BT 08
740MO D32-5		VT 25		BT 08

Insert
Wendeplatte

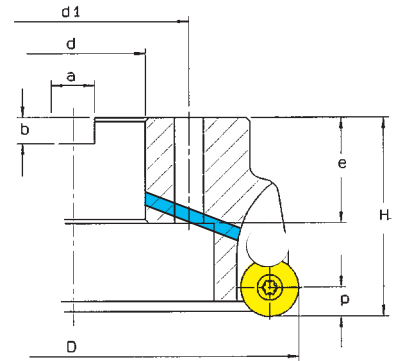
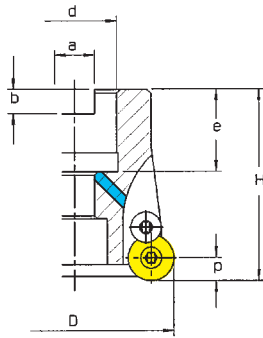
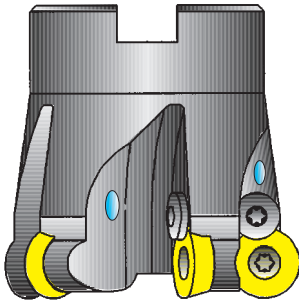


	a	b	s	d	r
APHT 1003...					
APHX 1003...	6,7	10,8	3,55	2,8	0,5
APKT 1003...					

Aufsteckfräser für Rund - WSP




Shell copy milling cutters

Art. 400M

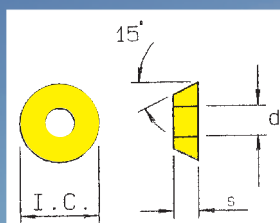


Order No. Bestell-Nr.	Dimension - Abmessungen									Insert Wendepatte
	D	d	d1	e	a	b	H	p	z	
400M-05212	52	22	-	22	10,4	6,3	50	6	5	RDHX 12T3 MOT
400M-05216	52	22	-	22	10,4	6,3	50	8	4	RDHX 1604 MOT
400M-06612	66	27	-	28	12,4	7	50	6	6	RDHX 12T3 MOT
400M-06616	66	27	-	28	12,4	7	50	8	5	RDHX 1604 MOT
400M-08012	80	27	-	28	12,4	7	50	6	7	RDHX 12T3 MOT
400M-08016	80	27	-	28	12,4	7	50	8	6	RDHX 1604 MOT
400M-10016	100	32	-	31	14,4	8	55	8	7	RDHX 1604 MOT
400M-12516	125	40	-	41	16,4	9	55	8	8	RDHX 1604 MOT
400M-16016	160	40	66,7	41	16,4	9	55	8	9	RDHX 1604 MOT

Spare parts - Ersatzteile

Order No. Bestell-Nr.	 Screw Schraube	 Clamp Spannklaue	 Key Schlüssel
400M-05212	VT 35	-	CVB 35
400M-05216	VT 45	CVB 45	-
400M-06612	VT 35	-	CVB 35
400M-06616	VT 45	CVB 45	-
400M-08012	VT 35	-	CVB 35
400M-08016	VT 45	CVB 45	-
400M-10016	VT 45	CVB 45	-
400M-12516	VT 45	CVB 45	-
400M-16016	VT 45	CVB 45	-

Insert
Wendepatte

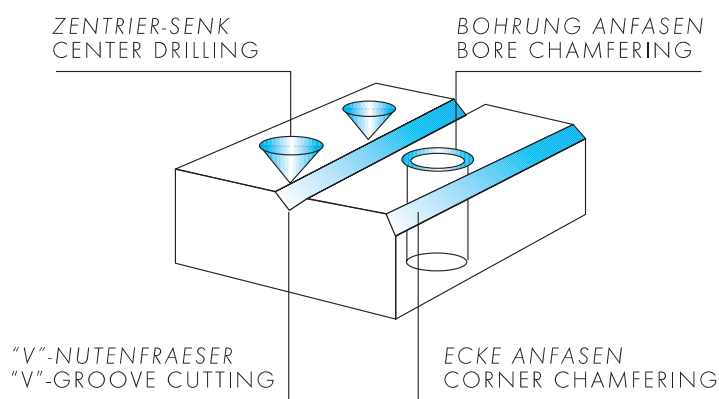
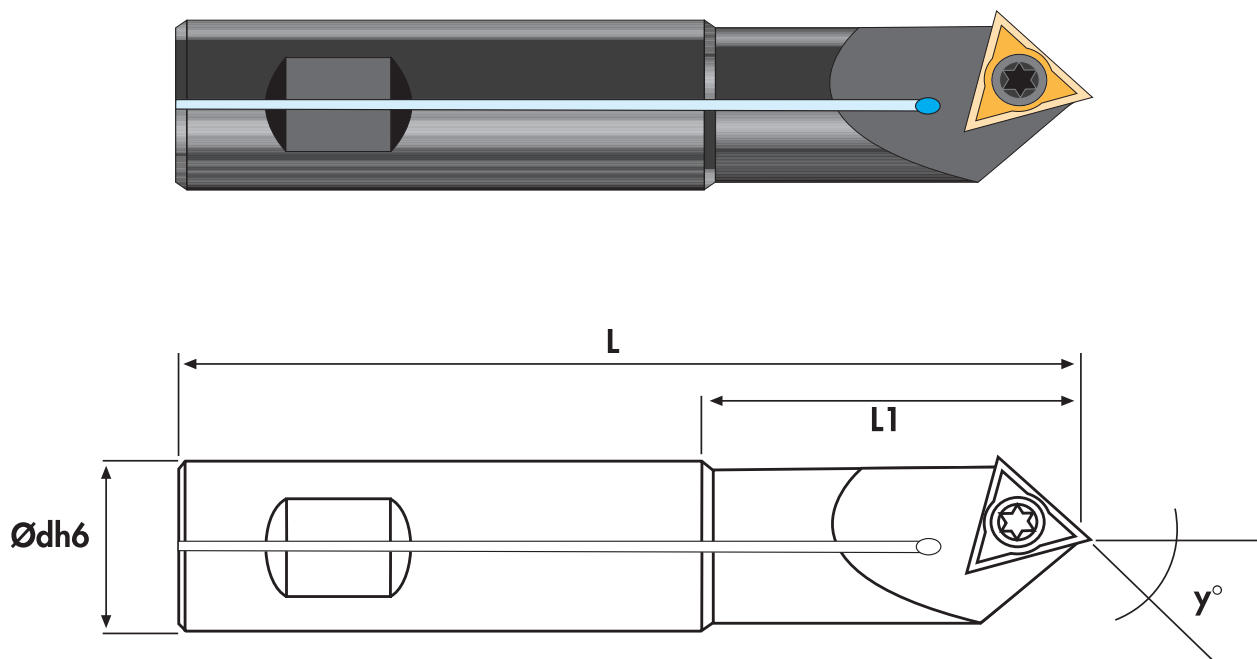




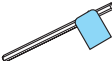
	I.C.	s	d
RDHX 12T3 MOT	12	3,97	3,9
RDHX 1604 MOT	16	4,76	5,2

FAS - und ZENTRIERFRÄSER - 45°

Center drilling, chamfering and V grooving 45°

ART. 311 W



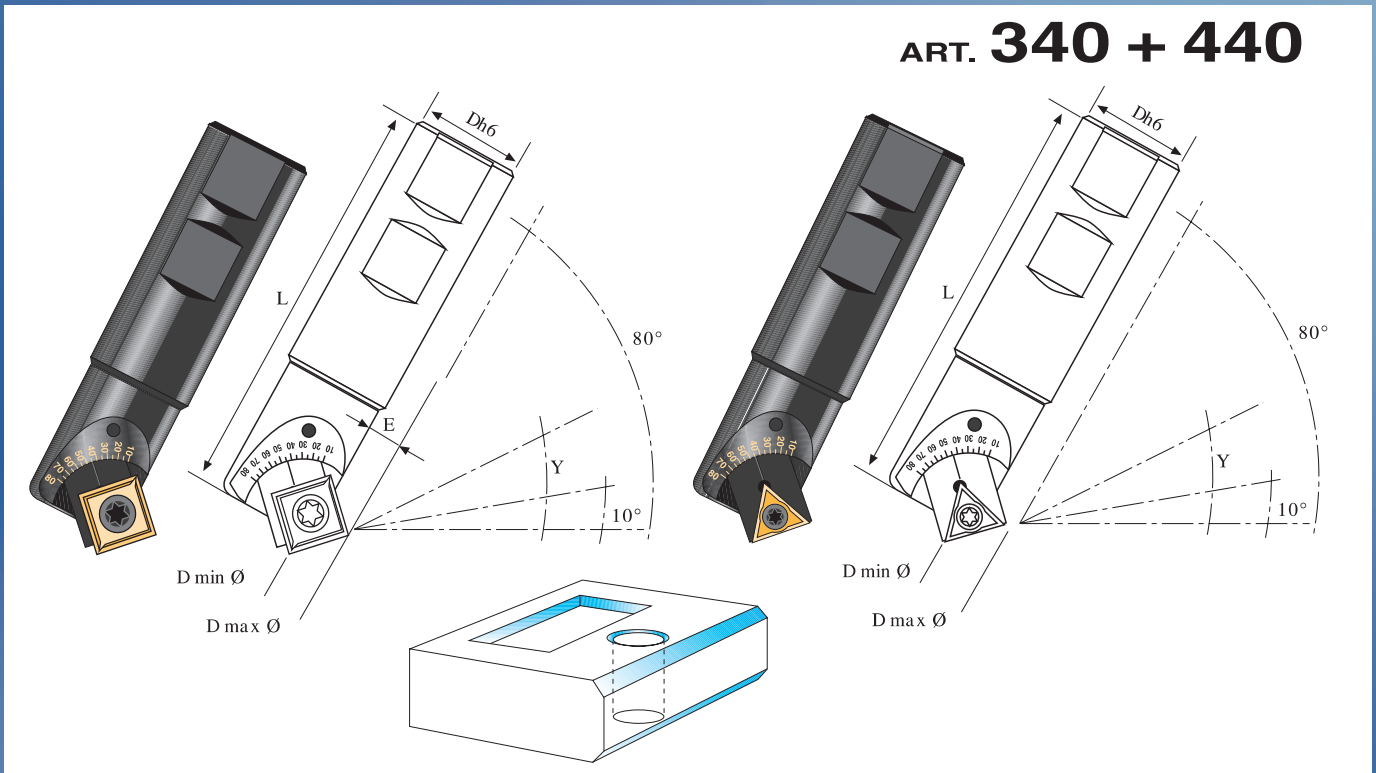
Bestell-Nr. Order No.	(mm) Abmessungen - Dimensions									
	dh6	L	L1	γ°	Z	D.min	D.max			
311.020 WW	20	115	40	45°	1	0,2	20	TCMX 16T3ZR	VT 40	BT 15
311.020 WWL	20	150	60	45°	1	0,2	20			
311.020 WXL	20	200	80	45°	1	0,2	20			

W-W = Kuehlmittelbohrung
W-W = Coolant Bores

FASENFRÄSER winkelverstellbar 10° bis 80°

Milling cutter for chamfering-flaring 10° to 80°

ART. **340 + 440**



Mit Kassette TCMT 16T3 ... With Triangle pocket TCMT 16T3 ...

Bestell-Nr Order No.	(mm) Abmessungen - Dimensions									
	D h6	L	Y	D. min. Ø	D. max. Ø					
340 W 025	25	100	10°	Ø 5	Ø 32	T16	TCMT 16T3...	VT 40	M6-16	BT 15
	25	100	20°	Ø 6	Ø 33					
	25	100	30°	Ø 7	Ø 34					
	25	100	40°	Ø 10	Ø 33					
	25	100	45°	Ø 11	Ø 33					
	25	100	50°	Ø 13	Ø 32					
	25	100	60°	Ø 16	Ø 31					
	25	100	70°	Ø 19	Ø 29					
	25	100	80°	Ø 23	Ø 27					
340 WL 025	25	150	"	"	"					
340 WXL 025	25	200	"	"	"					

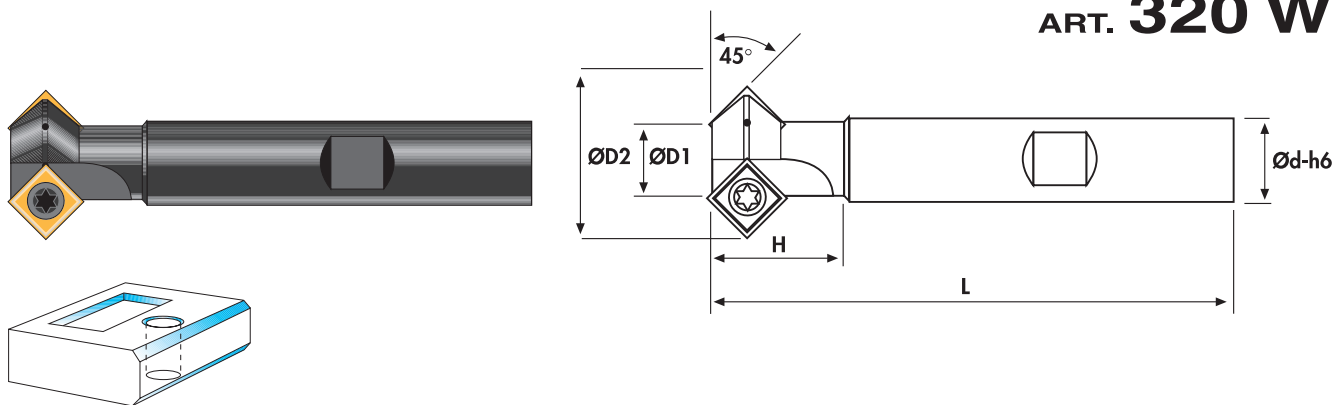
Mit Kassette SCMT 1204 ... With Square pocket SCMT 1204 ...



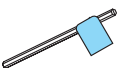
Bestell-Nr Order No.	(mm) Abmessungen - Dimensions										
	D h6	L	Y	D. min. Ø	D. max. Ø	E					
440 W 025	25	100	10°	Ø 7,5	Ø 30	2,7	S 12	SCMT 1204...	VT 40S	M6-16	BT 20
	25	100	20°	Ø 10	Ø 32	3,6					
	25	100	30°	Ø 13	Ø 32,5	4,3					
	25	100	40°	Ø 16,5	Ø 33,5	4,5					
	25	100	45°	Ø 17,5	Ø 33,5	4,6					
	25	100	50°	Ø 19	Ø 33,5	4,6					
	25	100	60°	Ø 22	Ø 33,5	4,3					
	25	100	70°	Ø 24,5	Ø 33,5	3,8					
	25	100	80°	Ø 27	Ø 31	3					
440 WL 025	25	150	"	"	"	"					
440 WXL 025	25	200	"	"	"	"					

FRÄSER zum SPITZSENKEN 30°, 45° und 60°

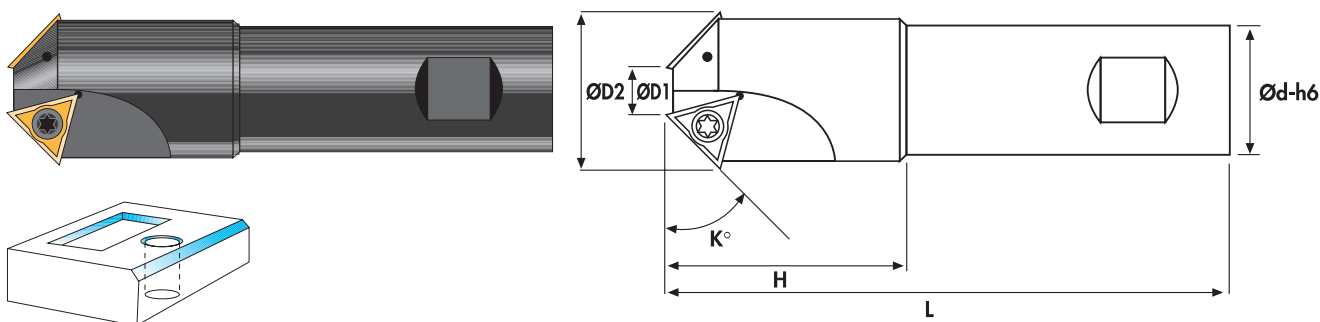
Milling cutter for chamfering 30°, 45° and 60°



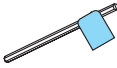
ART. 320 W



Bestell-Nr. Order No.	(mm) Abmessungen - Dimensions								
	ØD1	ØD2	L	H	Ødh6	Z			
320.002 W	2	25,5	80	30	12	1	CPMT 05T1	VT 25	BT 08
320.004 W	4	10,7	80	28	12	1	SCMT 0602	VT 25	BT 08
320.011 W	11	20,7	80	32	12	2	SCMT 09T3	VT 40	BT 15
320.012 W	12	23,7	100	37	20	1			
320.016 W	16	28,8	100	32	16	2			
320.025 W	30	42,3	100	32	20	3			
Lange Ausführung / Long models									
320.012 WL	12	23,7	200	37	20	1	SCMT 09T3	VT 40	BT 15
320.016 WL	16	28,8	200	32	16	2			
320.025 WL	30	42,3	200	32	20	3			

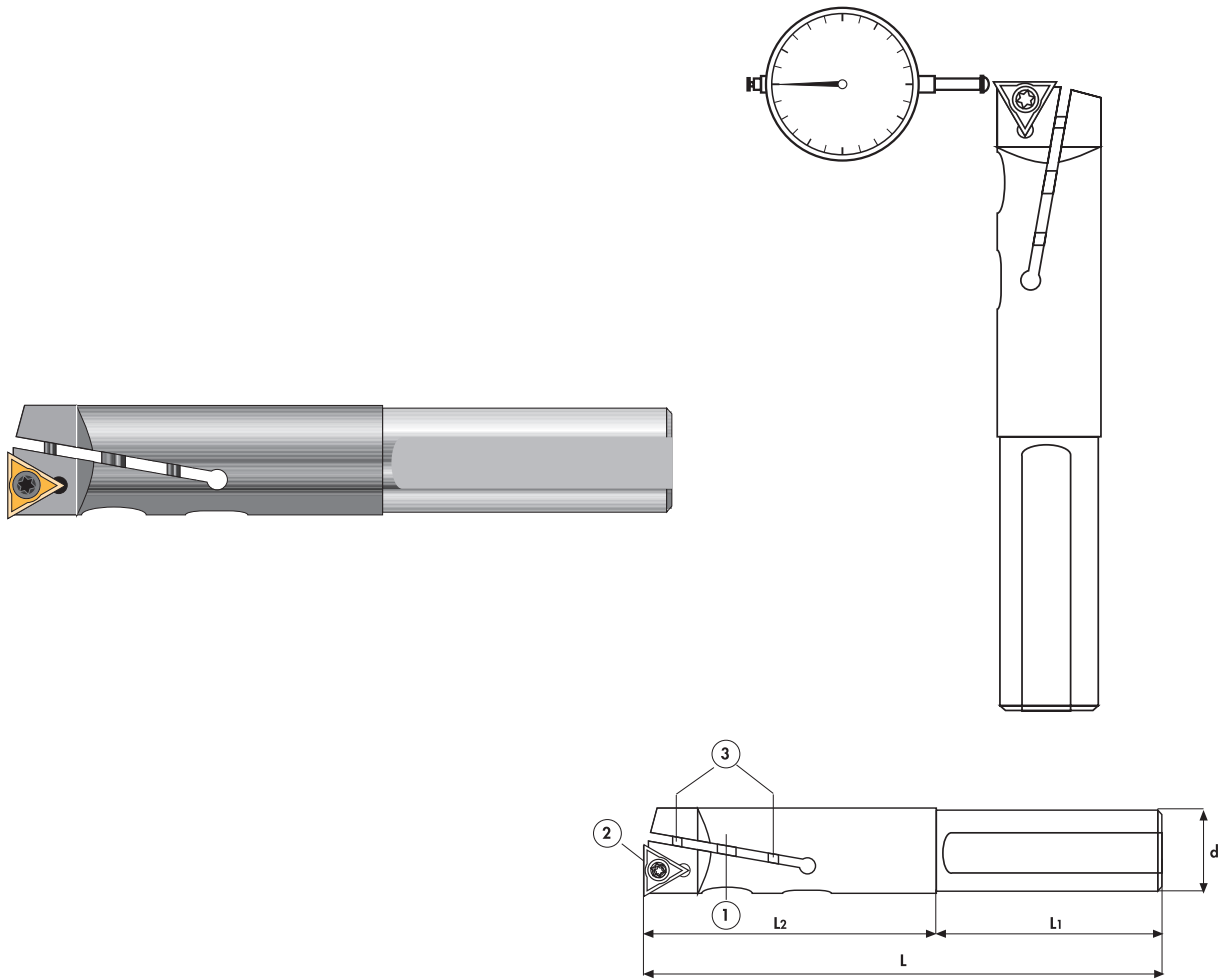
ART. 300 W



Bestell-Nr. Order No.	(mm) Abmessungen - Dimensions									
	ØD1	ØD2	L	H	Ødh6	Y°	Z			
300 - 45°										
300.016 W	11,2	16,4	70	20	12	45°	1	TCMT 1102	VT 25	BT 08
300.021 W	6,2	21,0	90	35	20	45°	2			
300.032 W	10,4	32,5	95	39	25	45°	2			
310 - 60°										
310.016 W	15,4	16,4	70	20	12	60°	1	TCMT 1102	VT 25	BT 08
310.027 W	15,8	26,8	90	35	20	60°	2			
310.032 W	20,0	35	95	39	25	60°	2			
315 - 30°										
315.032 W	6	32	95	38	20	30°	2	TCMT 16T3...	VT 40	BT 15

einstellbare FEINBOHRSTANGEN

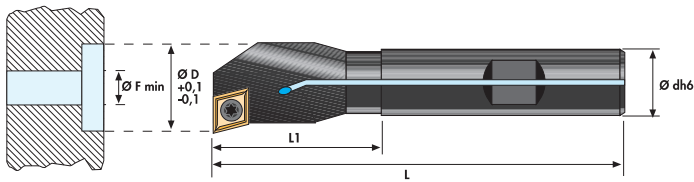
Adjustment boring bars





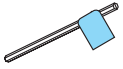
Bestell-Nr. Order No.	(mm) Abmessungen - Dimension						zug schraube adjust.screw 1	wpl.schraube inserts screw 2	druckschraube clamp sciew 3	wendeplatte inserts
	L	L ₁	L ₂	d	D _{min}	D _{max}				
R.A.I. 06	85	65	20	8	06 mm	07 mm	RE 11	VT 24	BL 11	WCMT 0201...
R.A.I. 07	90	65	25	8	07 mm	08 mm	RE 9	VT 20	BL 9	TPGX 0601 ..L
R.A.I. 08	90	65	25	8	08 mm	10 mm	RE 10	VT 20	BL 10	TPGX 0601 ..L
R.A.I. 10	100	70	30	10	10 mm	12 mm	RE 0	VT 20	BL 0	TPGX 0802 ..L
R.A.I. 12	105	70	30	12	12 mm	15 mm	RE 1	VT 20	BL 1	TPGX 0802 ..L
R.A.I. 15	110	60	50	16	15 mm	20 mm	RE 2	VT 20	BL 2	TPGX 0802 ..L
R.A.I. 20	120	60	60	20	20 mm	25 mm	RE 3	VT 25	BL 3	TCMT 1102 ...
R.A.I. 25	140	70	70	25	25 mm	30 mm	RE 4	VT 40	BL 4	TCMT 16T3 ...
R.A.I. 30	160	70	90	25	30 mm	35 mm	RE 5	VT 40	BL 5	TCMT 16T3 ...
R.A.I. 35	170	70	100	32	35 mm	40 mm	RE 6	VT 40	BL 6	TCMT 16T3 ...
R.A.I. 40	190	70	120	32	40 mm	45 mm	RE 7	VT 40	BL 7	TCMT 16T3 ...
R.A.I. 45	220	70	150	32	45 mm	50 mm	RE 8	VT 40	BL 10	TCMT 16T3 ...
Extralange Ausführung / Extralong models										
R.A.I. 12 SL	130	70	60	12	12 mm	15 mm	RE 1	VT 20	BL 1	TPGX 0802 ..L
R.A.I. 15 SL	140	70	70	16	15 mm	20 mm	RE 2	VT 20	BL 2	TPGX 0802 ..L
R.A.I. 20 SL	150	70	80	20	20 mm	25 mm	RE 3	VT 25	BL 3	TCMT 1102 ...
R.A.I. 25 SL	170	70	100	25	25 mm	30 mm	RE 4	VT 40	BL 4	TCMT 16T3 ...
R.A.I. 30 SL	190	70	120	25	30 mm	35 mm	RE 5	VT 40	BL 5	TCMT 16T3 ...
R.A.I. 35 SL	220	70	150	32	35 mm	40 mm	RE 6	VT 40	BL 6	TCMT 16T3 ...

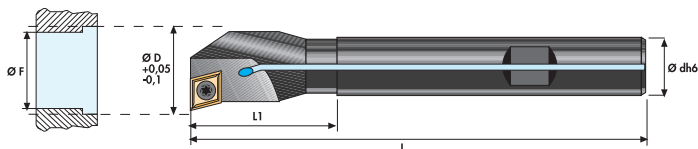
SENKUNGSFRÄSER u. zum Aufbohren

Spot facing milling cutter and boring milling cutter



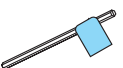


ART. **380 W**

Bestell-Nr. Order No.	(mm) Abmessungen - Dimensions								
	Ø D	L	L1	dh 6	Ø F min	Z			
380 WW D.10	10	85	15	12	4	1	CCGT 060204 CCMT 060204	VT 25	BT 08
380 WW D.11	11	85	15	12	4	1			
380 WW D.12	12	85	18	12	4	1			
380 WW D.13	13	85	23	12	5	1			
380 WW D.14	14	85	23	12	5	1			
380 WW D.15	15	85	30	12	5	1			
380 WW D.16	16	85	30	12	5	1			
380 WW D.17	17	95	30	16	5	1	CCGT 09T304 CCMT 09T304	VT 40	BT 15
380 WW D.18	18	95	40	16	5	1			
380 WW D.19	19	95	40	16	5	1			
380 WW D.20	20	95	40	16	5	1			
380 WW D.21	21	95	42	16	5	1			
380 WW D.22	22	95	42	16	6	1			
380 WW D.23	23	95	42	16	6	1			
380 WW D.24	24	95	42	16	6	1			
380 WW D.25	25	95	42	16	8	1			
380 WW D.26	26	120	56	20	8	1			
380 WW D.27	27	120	56	20	8	1			
380 WW D.28	28	120	56	20	10	1			
380 WW D.29	29	120	56	20	10	1			
380 WW D.30	30	120	56	20	10	1			
380 WW D.31	31	120	56	20	12	1			
380 WW D.32	32	120	56	20	12	1			
380 WW D.33	33	120	56	20	12	1			

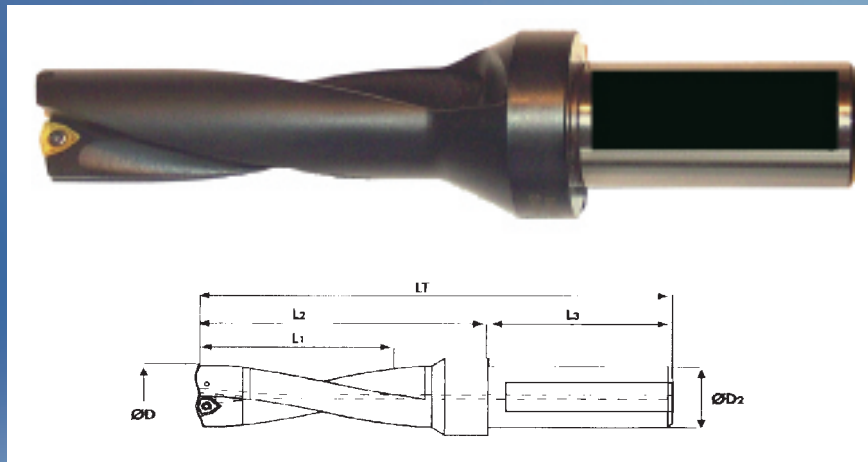



ART. **385 W**

Bestell-Nr. Order No.	(mm) Abmessungen - Dimensions								
	Ø D	L	L1	dh 6	Ø F	Z			
385 WW D.10	9,8	90	23	8	8	1	CCGT 060204 CCMT 060204	VT 25	BT 08
385 WW D.11	10,8	105	24	10	10	1			
385 WW D.12	11,8	105	25	10	10	1			
385 WW D.13	12,8	105	26	10	10	1			
385 WW D.14	13,8	110	27	12	10	1			
385 WW D.15	14,8	120	28	12	12	1			
385 WW D.16	15,8	125	29	12	12	1			
385 WW D.17	16,8	140	30	16	16	1			
385 WW D.18	17,8	140	31	16	16	1			
385 WW D.19	18,8	150	32	16	16	1			
385 WW D.20	19,8	150	33	16	16	1	CCGT 09T304 CCMT 09T304	VT 40	BT 15
385 WW D.21	20,8	160	34	16	16	1			
385 WW D.22	21,8	160	35	20	16	1			
385 WW D.23	22,8	165	36	20	20	1			
385 WW D.24	23,8	170	37	20	20	1			
385 WW D.25	24,8	180	38	20	20	1			
385 WW D.26	25,8	185	39	20	20	1			
385 WW D.27	26,8	190	40	20	20	1			
385 WW D.28	27,8	190	41	20	20	1			
385 WW D.29	28,8	200	42	20	20	1			
385 WW D.30	29,8	200	43	25	20	1			
385 WW D.31	30,8	200	44	25	25	1			
385 WW D.32	31,8	200	45	25	25	1			

Wendeplatten - Vollbohrer

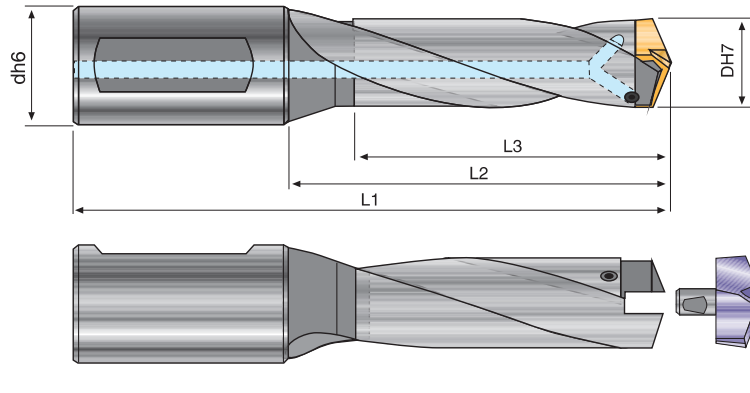
Insert - Drilling



Art.Nr.	Durchm.	D 1	D 2	LT	L 1	L 2	L 3	Wendeplatten
	mm	mm	mm	mm	mm	mm	mm	
160-30	16			134,0	49,0	80,0		 WCMT 030208
165-30	16,5			135,5	50,5	81,5		
170-30	17			137,0	52,0	83,0		
175-30	17,5			138,5	54,5	84,5		
180-30	18	32	25	140,0	56,0	86,0	54	
185-30	18,5			141,5	57,5	87,5		
190-30	19			143,0	59,0	89		
195-30	19,5			144,5	60,5	90,5		
200-30	20			146,0	62,0	92,0		
205-30	20,5			147,5	63,5	93,5		
210-30	21			149,0	65,0	95,0		WCMT 040208
215-30	21,5			150,5	66,5	96,5		
220-30	22			152,0	68,0	98,5		
225-30	22,5			153,5	69,5	96,5		
230-30	23	32	25	155,0	71,0	101,0	54	
235-30	23,5			156,5	72,5	102,5		
240-30	24			158,0	74,0	104,0		
245-30	24,5			159,5	75,5	105,5		
250-30	25			161,0	77,0	107		
255-30	25,5			162,5	78,5	108,5		
260-30	26			164,0	80,0	110,0		WCMT 050308
265-30	26,5			165,5	81,5	111,5		
270-30	27	32	25	167,0	83,0	113,0	54	
280-30	28			170,0	86,0	116,0		
290-30	29			173,0	89,0	119,0		
300-30	30			180,0	92,0	122,0		
310-30	31			183,0	95,0	125,0		
320-30	32			186,0	98,0	128,0		WCMT 06T308
330-30	33			189,0	101,0	131,0		
340-30	34			192,0	104,0	134,0		
350-30	35			195,0	107,0	137,0		
360-30	36	49	32	198,0	110,0	140,0	58	
370-30	37			201,0	113,0	143,0		
380-30	38			204,0	116,0	146,0		
390-30	39			207,0	119,0	149,0		
400-30	40			210,0	122,0	152,0		
410-30	4			213,0	125,0	155,0		

VOLLBOHRER mit Wechselplatte

MODEL : Drill modular type, cylindrical shank 3XD-5XD-7XD with interchangeable insert in solid carbide coated
 MODEL : Vollbohrer, zylindrischer Schaft 3XD-5XD-7XD mit austauschbarer Hartmetall-Wendepatte, beschichtet






N.B.: IT'S IMPORTANT ALWAYS TO REPLACE THE SCREW GIVEN IN THE EQUIPMENT EVERY TIME THAT THE INSERT HAS TO BE CHANGED.

N.B.: ES IST WICHTIG, WENN DIE WENDEPLATTE AUSGETAUSCHT SEIN SOLLTE, AUCH DIE SCHRAUBE, DIE IN DER DOTATION GEGEBEN IST IMMER ZU ERSETZEN.




Material and cutting conditions Material und Schneidebedingungen	Ø 8 - 25		Ø 25 - 32		Ø 32 - 40		Ø 40 - 50	
	m/ min.	mm/ rev	m/ min.	mm/ rev	m/ min.	mm/ rev	m/ min.	mm/ rev
Gray cast iron Formbares Graugussisen	50 - 70	0,20 - 0,45	50 - 80	0,35 - 0,55	60 - 90	0,34 - 0,58	80 - 100	0,38 - 0,60
Nodular cast iron Kohlenstoff-Nodulargussisen	40 - 65	0,22 - 0,45	45 - 75	0,32 - 0,52	50 - 80	0,35 - 0,62	70 - 100	0,38 - 0,60
Carbon steel Karbonstahl	55 - 70	0,16 - 0,40	60 - 85	0,20 - 0,40	70 - 90	0,22 - 0,48	75 - 95	0,25 - 0,54
Alloyed steel Legierter Stahl	50 - 75	0,15 - 0,40	55 - 80	0,18 - 0,40	60 - 90	0,25 - 0,47	65 - 95	0,27 - 0,52
Hardened steel Gehaerteter Stahl	40 - 50	0,12 - 0,28	40 - 50	0,16 - 0,35	40 - 60	0,20 - 0,38	40 - 60	0,22 - 0,42
Stainless steel Rostfreier Stahl	35 - 50	0,10 - 0,22	35 - 50	0,15 - 0,28	40 - 55	0,18 - 0,30	40 - 55	0,22 - 0,32

N.B.: The YIDI drill is made of steel excellent and especially wear-resistant and can be used for a very long time. The flute length is 3 - 5 or 7 times the diameter. T= 3 times the diameter. P= 5 times the diameter. H= 7 times the diameter.
 N.B.: Der Vollbohrer YIDI ist aus hochwertigem und gegen Abnutzung besonders widerstandsfähigem Stahl und kann sehr lange Zeit verwendet werden. Die Spiral-länge ist 3 - 5 oder 7 mal den Durchmesser erhaltlich. T= 3 mal Durchmesser. P= 5 mal Durchmesser. H= 7 mal Durchmesser.

Bestell-Nr. Order No.	Abmessungen - Dimensions									Wendepatte d1 h7 Insert d1 h7	 TiAlN			
	dh6	T (3 x Dia.)			P (5 x Dia.)			H (7 x Dia.)						
		L1	L2	L3	L1	L2	L3	L1	L2					L3

YIDI 080	10,0	80	35	24	96	51	40	117	72	56	ID 08,0	ID 08,1	ID 08,2	ID 08,3	ID 08,4	M 2,5	1,3
YIDI 085		82	37	26	100	55	45	122	77	60	ID 08,5	ID 08,6	ID 08,7	ID 08,8	ID 08,9	"	"
YIDI 090		85	40	27	105	60	47	126	81	67	ID 09,0	ID 09,1	ID 09,2	ID 09,3	ID 09,4	"	"
YIDI 095	12,0	95	47	37	115	67	57	140	92	77	ID 09,5	ID 09,6	ID 09,7	ID 09,8	ID 09,9	"	"
YIDI 100											ID 10,0	ID 10,1	ID 10,2	ID 10,3	ID 10,4	"	"
YIDI 105											ID 10,5	ID 10,6	ID 10,7	ID 10,8	ID 10,9	"	"
YIDI 110	16,0	100	52	42	125	77	67	150	102	87	ID 11,0	ID 11,1	ID 11,2	ID 11,3	ID 11,4	"	"
YIDI 115											ID 11,5	ID 11,6	ID 11,7	ID 11,8	ID 11,9	"	"
YIDI 120											ID 12,0	ID 12,1	ID 12,2	ID 12,3	ID 12,4	M 3	1,5
YIDI 125	16,0	110	62	45	140	92	75	175	127	100	ID 12,5	ID 12,6	ID 12,7	ID 12,8	ID 12,9	"	"
YIDI 130											ID 13,0	ID 13,1	ID 13,2	ID 13,3	ID 13,4	"	"
YIDI 135											ID 13,5	ID 13,6	ID 13,7	ID 13,8	ID 13,9	"	"
YIDI 140	20,0	115	67	50	145	97	80	180	132	105	ID 14,0	ID 14,1	ID 14,2	ID 14,3	ID 14,4	"	"
YIDI 145											ID 14,5	ID 14,6	ID 14,7	ID 14,8	ID 14,9	"	"
YIDI 150											ID 15,0	ID 15,1	ID 15,2	ID 15,3	ID 15,4	"	"
YIDI 155											ID 15,5	ID 15,6	ID 15,7	ID 15,8	ID 15,9	"	"

VOLLBOHRER mit Wechselplatte

Bestell-Nr. Order No.	Abmessungen - Dimensions									Wendeplatte d1 h7 Insert d1 h7				
	dh6	T (3 x Dia.)			P (5 x Dia.)			H (7 x Dia.)						
		L1	L2	L3	L1	L2	L3	L1	L2					L3

YIDI 160	20,0	130	80	55	150	100	89	190	140	123	ID16.0	ID16.1	ID16.2	ID16.3	ID16.4	M3	1.5
YIDI 165											ID16.5	ID16.6	ID16.7	ID16.8	ID16.9	"	"
YIDI 170											ID17.0	ID17.1	ID17.2	ID17.3	ID17.4	"	"
YIDI 175		130	80	55	160	110	100	190	140	123	ID17.5	ID17.6	ID17.7	ID17.8	ID17.9	"	"
YIDI 180											ID18.0	ID18.1	ID18.2	ID18.3	ID18.4	"	"
YIDI 185											ID18.5	ID18.6	ID18.7	ID18.8	ID18.9	"	"
YIDI 190	140	90	63	170	120	100	210	160	138	ID19.0	ID19.1	ID19.2	ID19.3	ID19.4	"	"	
YIDI 195										ID19.5	ID19.6	ID19.7	ID19.8	ID19.9	"	"	
YIDI 200										ID20.0	ID20.1	ID20.2	ID20.3	ID20.4	M4	2.0	
YIDI 205	25,0	150	94	69	190	134	110	230	174	153	ID20.5	ID20.6	ID20.7	ID20.8	ID20.9	"	"
YIDI 210											ID21.0	ID21.1	ID21.2	ID21.3	ID21.4	"	"
YIDI 215											ID21.5	ID21.6	ID21.7	ID21.8	ID21.9	"	"
YIDI 220		160	104	75	200	144	121	240	184	168	ID22.0	ID22.1	ID22.2	ID22.3	ID22.4	"	"
YIDI 225											ID22.5	ID22.6	ID22.7	ID22.8	ID22.9	"	"
YIDI 230											ID23.0	ID23.1	ID23.2	ID23.3	ID23.4	"	"
YIDI 235	32,0	170	110	83	220	160	133	270	210	183	ID23.5	ID23.6	ID23.7	ID23.8	ID23.9	"	"
YIDI 240											ID24.0	ID24.1	ID24.2	ID24.3	ID24.4	"	"
YIDI 245											ID24.5	ID24.6	ID24.7	ID24.8	ID24.9	"	"
YIDI 250		180	120	90	240	180	144	290	230	198	ID25.0	ID25.1	ID25.2	ID25.3	ID25.4	"	"
YIDI 255											ID25.5	ID25.6	ID25.7	ID25.8	ID25.9	"	"
YIDI 260											ID26.0	ID26.1	ID26.2	ID26.3	ID26.4	"	"
YIDI 265	32,0	190	130	97	250	190	155	300	240	213	ID26.5	ID26.6	ID26.7	ID26.8	ID26.9	"	"
YIDI 270											ID27.0	ID27.1	ID27.2	ID27.3	ID27.4	"	"
YIDI 275											ID27.5	ID27.6	ID27.7	ID27.8	ID27.9	"	"
YIDI 280		200	140	105	260	200	165	320	260	228	ID28.0	ID28.1	ID28.2	ID28.3	ID28.4	M5	2.5
YIDI 285											ID28.5	ID28.6	ID28.7	ID28.8	ID28.9	"	"
YIDI 290											ID29.0	ID29.1	ID29.2	ID29.3	ID29.4	"	"
YIDI 295	40,0	210	150	110	270	210	177	340	280	243	ID29.5	ID29.6	ID29.7	ID29.8	ID29.9	"	"
YIDI 300											ID30.0	ID30.1	ID30.2	ID30.3	ID30.4	"	"
YIDI 305											ID30.5	ID30.6	ID30.7	ID30.8	ID30.9	"	"
YIDI 310		230	160	118	300	230	188	360	290	258	ID31.0	ID31.1	ID31.2	ID31.3	ID31.4	"	"
YIDI 315											ID31.5	ID31.6	ID31.7	ID31.8	ID31.9	"	"
YIDI 320											ID32.0	ID32.1	ID32.2	ID32.3	ID32.4	M6	3.0
YIDI 325	40,0	210	150	110	270	210	177	340	280	243	ID32.5	ID32.6	ID32.7	ID32.8	ID32.9	"	"
YIDI 330											ID33.0	ID33.1	ID33.2	ID33.3	ID33.4	"	"
YIDI 335											ID33.5	ID33.6	ID33.7	ID33.8	ID33.9	"	"
YIDI 340		230	160	118	300	230	188	360	290	258	ID34.0	ID34.1	ID34.2	ID34.3	ID34.4	"	"
YIDI 345											ID34.5	ID34.6	ID34.7	ID34.8	ID34.9	"	"
YIDI 350											ID35.0	ID35.1	ID35.2	ID35.3	ID35.4	"	"
YIDI 355	40,0	250	180	125	310	240	199	380	310	273	ID35.5	ID35.6	ID35.7	ID35.8	ID35.9	"	"
YIDI 360											ID36.0	ID36.1	ID36.2	ID36.3	ID36.4	"	"
YIDI 365											ID36.5	ID36.6	ID36.7	ID36.8	ID36.9	"	"
YIDI 370		250	180	125	310	240	199	380	310	273	ID37.0	ID37.1	ID37.2	ID37.3	ID37.4	"	"
YIDI 375											ID37.5	ID37.6	ID37.7	ID37.8	ID37.9	"	"
YIDI 380											ID38.0	ID38.1	ID38.2	ID38.3	ID38.4	"	"
YIDI 385	40,0	280	210	132	320	250	210	400	330	288	ID38.5	ID38.6	ID38.7	ID38.8	ID38.9	"	"
YIDI 390											ID39.0	ID39.1	ID39.2	ID39.3	ID39.4	"	"
YIDI 395											ID39.5	ID39.6	ID39.7	ID39.8	ID39.9	"	"
YIDI 400		270	200	138	340	270	221	420	350	303	ID40.0	ID40.1	ID40.2	ID40.3	ID40.4	M8	4.0
YIDI 405											ID40.5	ID40.6	ID40.7	ID40.8	ID40.9	"	"
YIDI 410											ID41.0	ID41.1	ID41.2	ID41.3	ID41.4	"	"
YIDI 415	40,0	270	200	138	340	270	221	420	350	303	ID41.5	ID41.6	ID41.7	ID41.8	ID41.9	"	"
YIDI 420											ID42.0	ID42.1	ID42.2	ID42.3	ID42.4	"	"
YIDI 425											ID42.5	ID42.6	ID42.7	ID42.8	ID42.9	"	"
YIDI 430		270	200	145	340	270	232	420	350	318	ID43.0	ID43.1	ID43.2	ID43.3	ID43.4	"	"
YIDI 435											ID43.5	ID43.6	ID43.7	ID43.8	ID43.9	"	"
YIDI 440											ID44.0	ID44.1	ID44.2	ID44.3	ID44.4	"	"
YIDI 445	40,0	280	210	153	370	300	243	460	390	333	ID44.5	ID44.6	ID44.7	ID44.8	ID44.9	"	"
YIDI 450											ID45.0	ID45.1	ID45.2	ID45.3	ID45.4	"	"
YIDI 455											ID45.5	ID45.6	ID45.7	ID45.8	ID45.9	"	"
YIDI 460		280	210	160	370	300	255	460	390	348	ID46.0	ID46.1	ID46.2	ID46.3	ID46.4	"	"
YIDI 465											ID46.5	ID46.6	ID46.7	ID46.8	ID46.9	"	"
YIDI 470											ID47.0	ID47.1	ID47.2	ID47.3	ID47.4	"	"
YIDI 475	40,0	300	230	167	390	320	265	490	420	363	ID47.5	ID47.6	ID47.7	ID47.8	ID47.9	"	"
YIDI 480											ID48.0	ID48.1	ID48.2	ID48.3	ID48.4	"	"
YIDI 485											ID48.5	ID48.6	ID48.7	ID48.8	ID48.9	"	"
YIDI 490		300	230	167	390	320	265	490	420	363	ID49.0	ID49.1	ID49.2	ID49.3	ID49.4	"	"
YIDI 495											ID49.5	ID49.6	ID49.7	ID49.8	ID49.9	"	"
YIDI 500											ID50.0	ID50.1	ID50.2	ID50.3	ID50.4	"	"

ANWENDUNGSHINWEISE

für PKD - Werkzeuge

Sie erhalten von uns folgende
Werkzeuge, für spanende Bearbeitung,
mit PKD - Schneiden

Drehwerkzeuge

Div. Wendschneiplatten
Div. Drehmeißel

Bohrwerkzeuge

Spiralbohrer, Stufenbohrer
Div. Senker

Reibwerkzeuge

Div. Reibahlen

Fräswerkzeuge

Div. Wendschneiplatten
Div. Fräser

Die PKD - Werkzeuge eignen sich,
bei entsprechender Schneidegeometrie,
zur Bearbeitung folgender Materialien

Aluminium

Alle Sorten, besonders
hoch Si-haltige Gußlegierungen

Nichteisenmetalle

Kupfer und deren Legierungen
Zink, etc.

Edelmetalle

Gold, Silber, Platin, etc

Kunststoffe

PVC, Nylon, Hartgewebe, etc.
Polymerbeton

CFK & GFK

Kohlefaser verstärkte Kunststoffe
Glasfaser verstärkte Kunststoffe

MMC

Metall Matrix Composition

Holzwerkstoffe

Spanplatten, Hartholz,
MDF, etc.

Mineralwerkstoffe

Grüner Keramik, Graphit,
naturstein, etc.

DIAATEC

Diamanttechnik GmbH

VORTEILE

z.B. Beim Einsatz mit
PKD - Wendeplatten

**Hoher
Vorschub**

**Durch
große Schneideanzahl**

**Hervorragende
Oberflächen-
güte**

**R z + Wf - Werte
werden gesenkt**

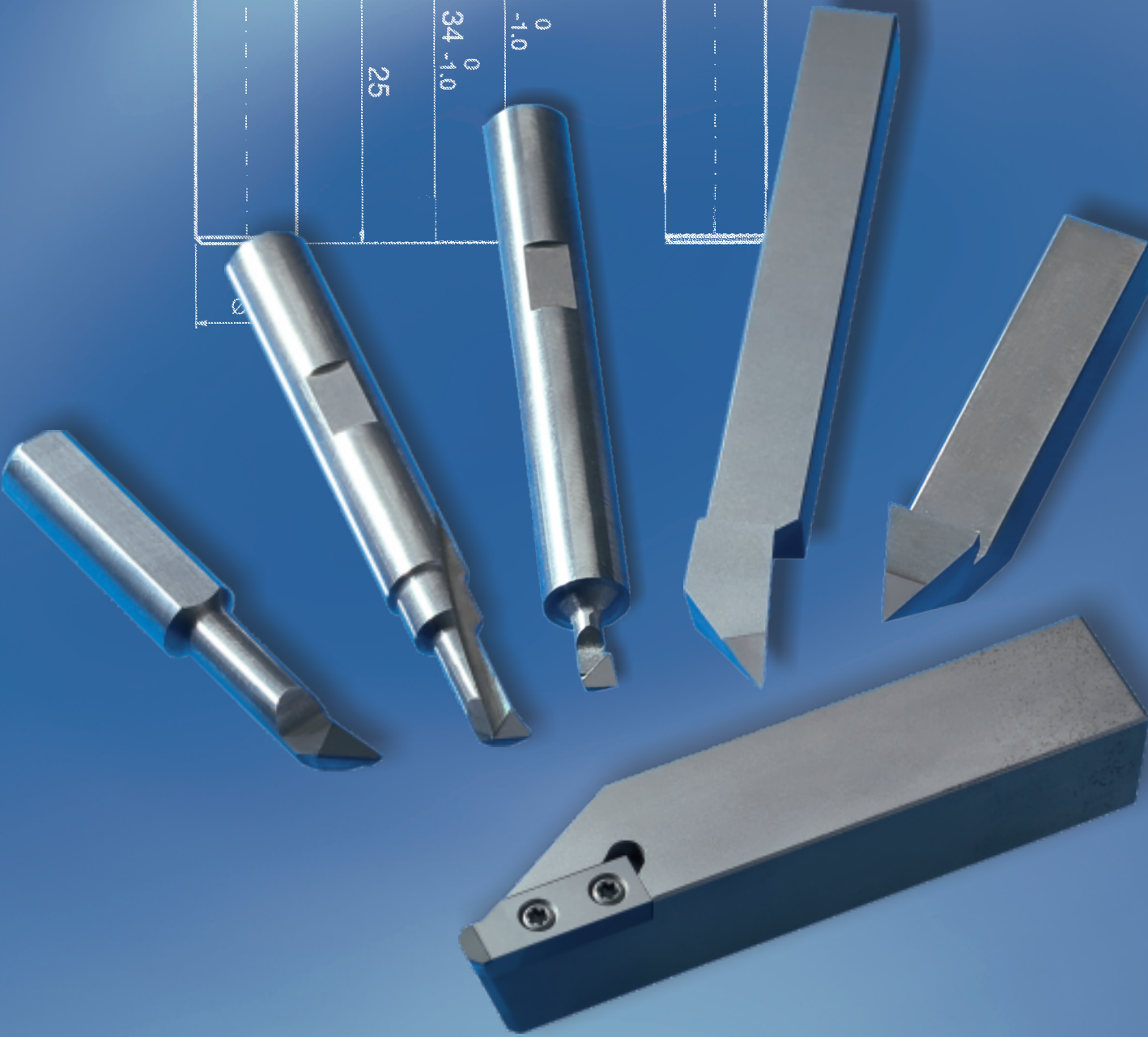
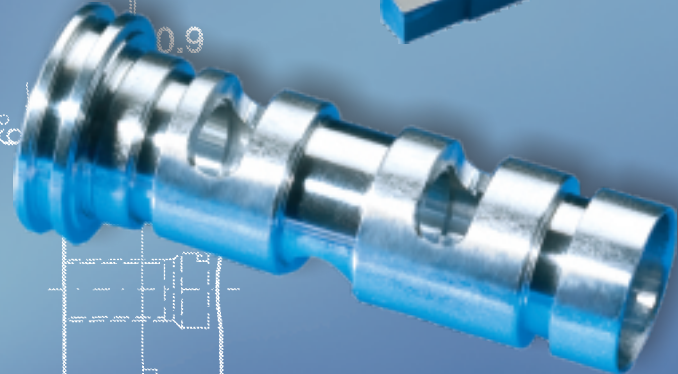
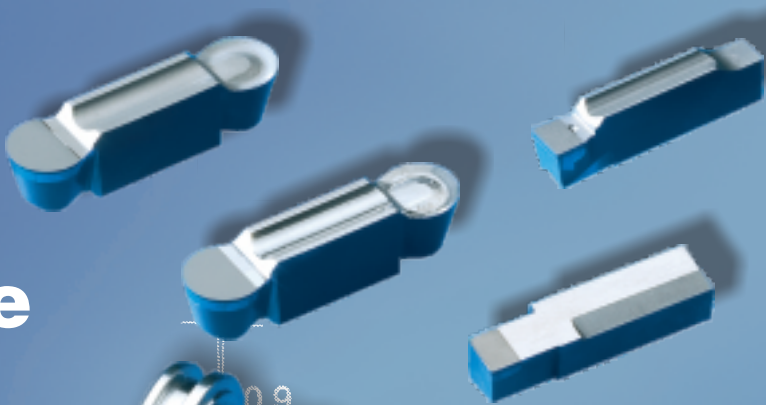
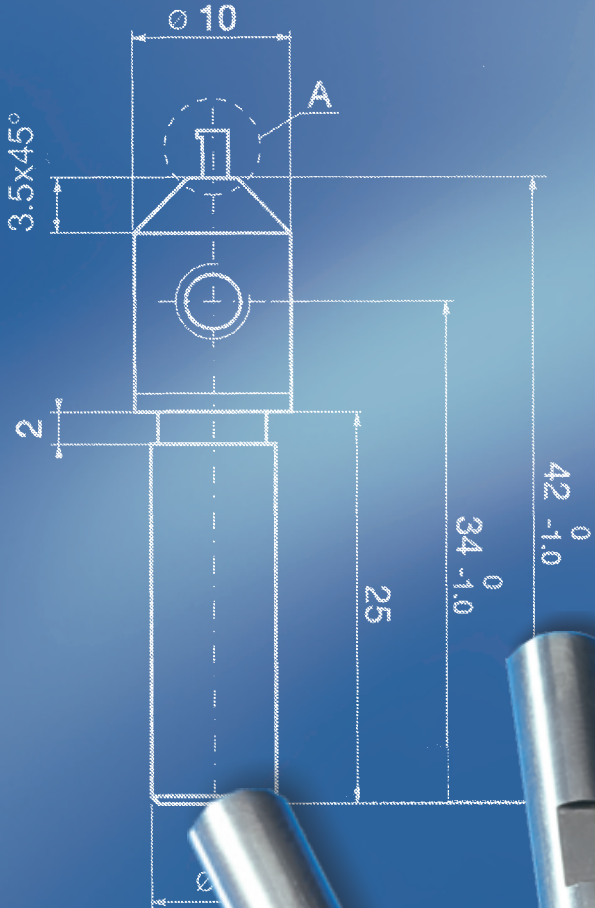
**Minderung
der
Gratbildung**

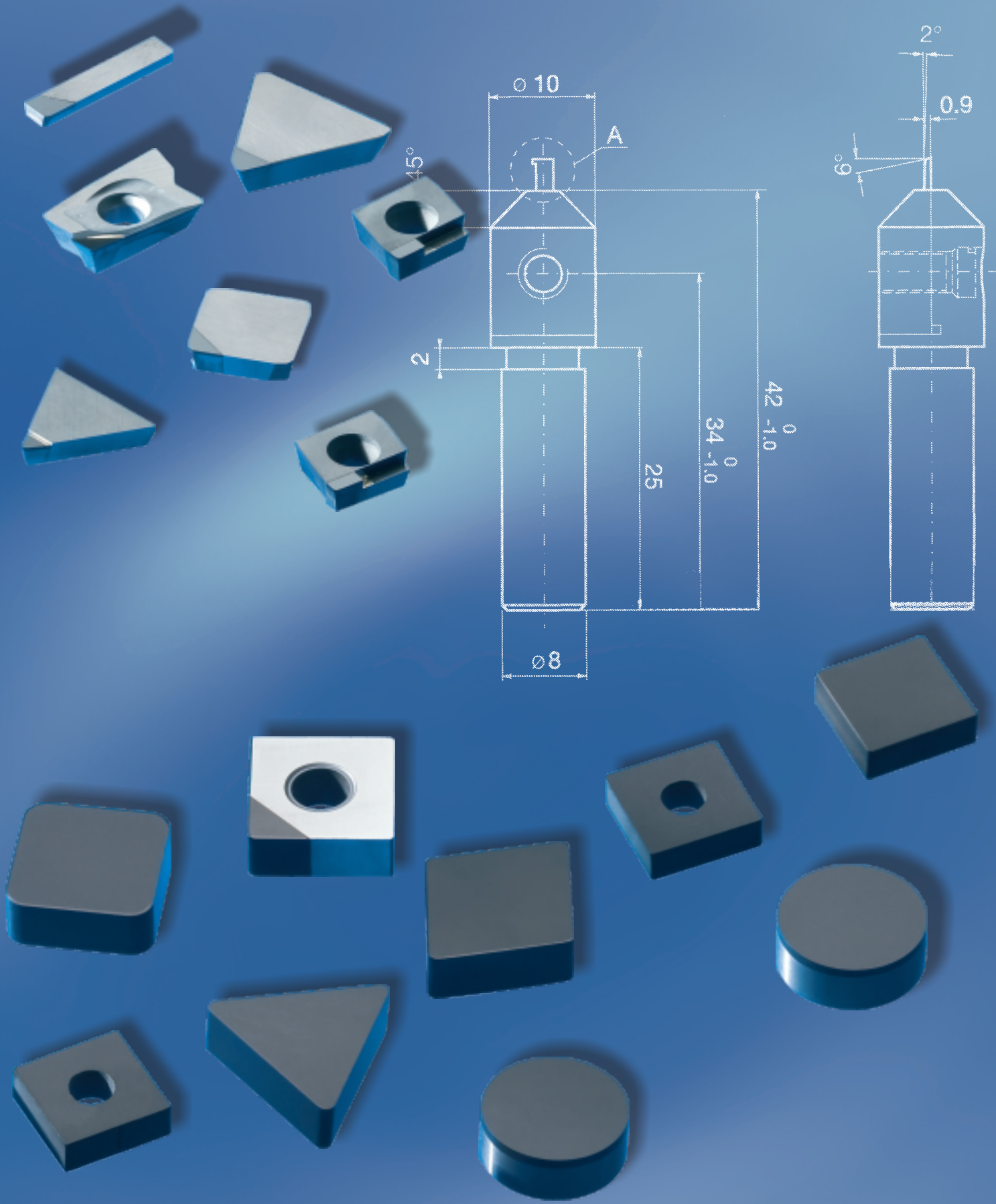
**Nachträgliches Bürsten
kann meist
entfallen**

**Schnelle
Planlauf-
einstellung**

**Keine aufwendigen
Einbauteile**

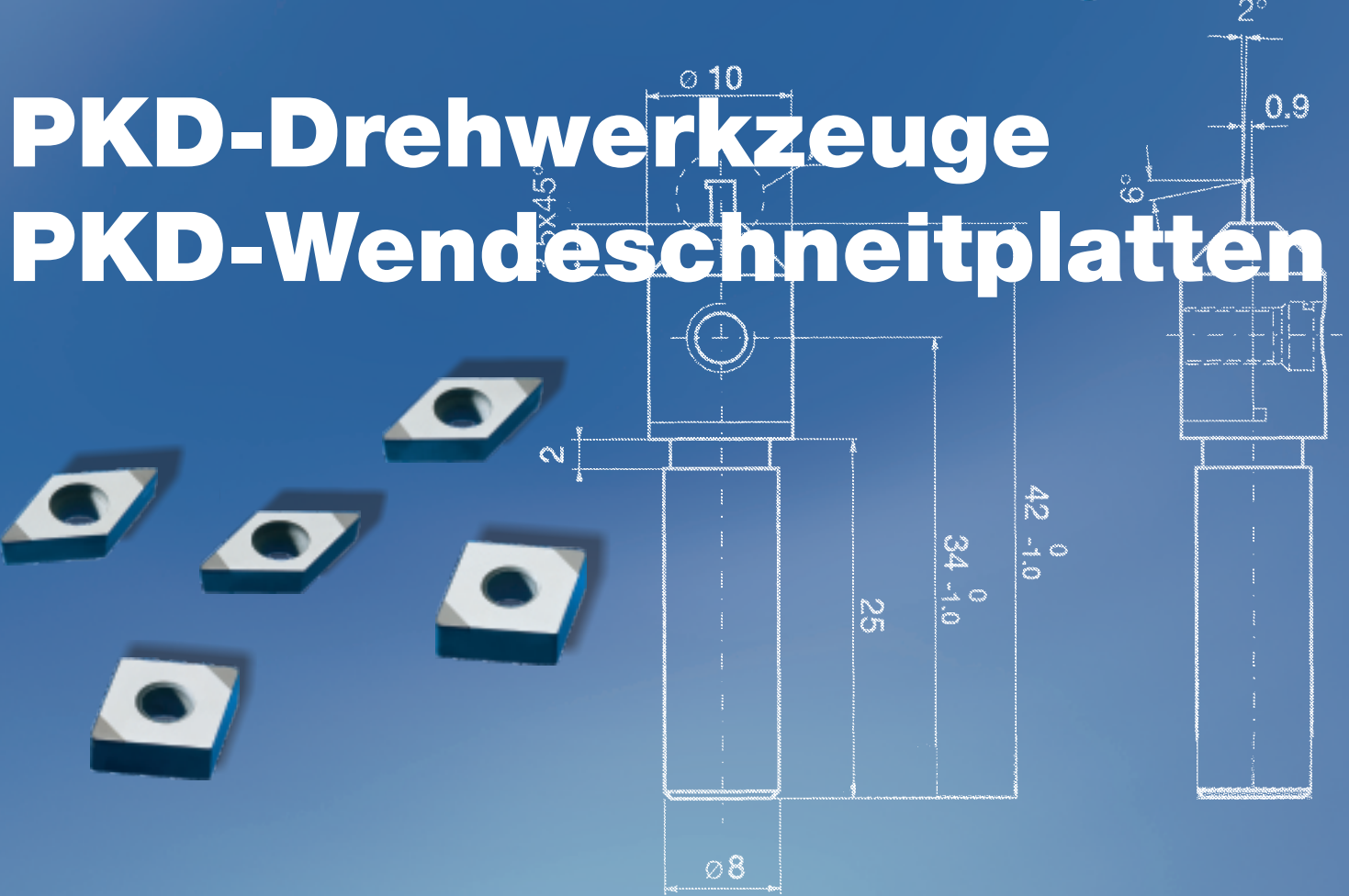
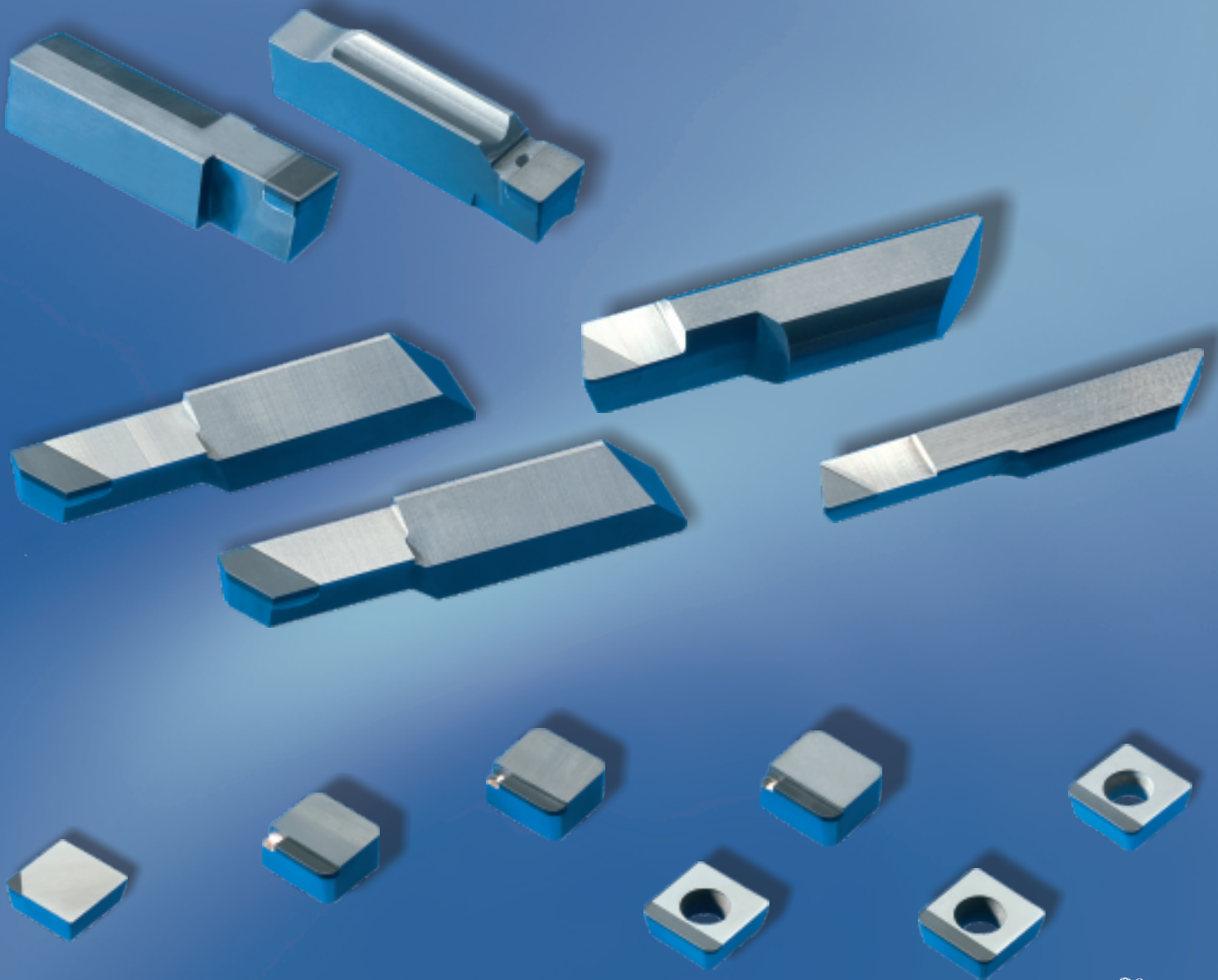
PKD- Dreh- und Stech-Werkzeuge





CBN-Wende- und Fullface-Platten

PKD-Drehwerkzeuge PKD-Wendeschneitplatten



PKD-3D- RADIUSFRÄSER

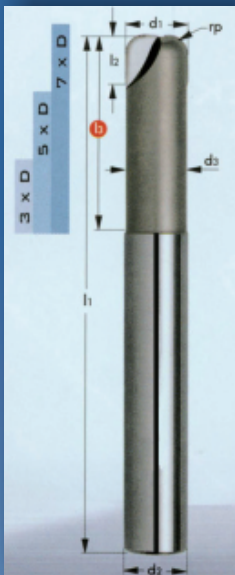
mit Kugelstirn, 3xD-5xD-7xD



d1 h7	r± 0,005	l3	d2 h6	d3	l1	l2	z
• 3	1,5	9	6	2,5	75	2,5	2
• 3	1,5	15	6	2,5	75	2,5	2
• 3	1,5	21	6	2,5	75	2,5	2
• 4	2,0	12	6	3,5	75	2,5	2
• 4	2,0	20	6	3,5	75	2,5	2
• 4	2,0	28	6	3,5	75	2,5	2
• 5	2,5	15	6	4,4	75	3,0	2
• 5	2,5	25	6	4,4	75	3,0	2
• 5	2,5	35	6	4,4	75	3,0	2
• 6	3,0	18	6	5,4	100	6,0	2
• 6	3,0	30	6	5,4	100	6,0	2
• 6	3,0	42	6	5,4	100	6,0	2
• 8	4,0	24	8	7,2	100	7,0	2
• 8	4,0	40	8	7,2	100	7,0	2
• 10	5,0	30	10	9,0	100	8,0	2
• 10	5,0	50	10	9,0	100	8,0	2
• 12	6,0	36	12	11,0	105	9,0	2
• 12	6,0	60	12	11,0	105	9,0	2

PKD-SCHAFTFRÄSER

mit Eckenradius, 3xD-5xD-7xD



d1 h7	rp± 0,005			l3	d2 h6	d3	l1	l2	z	
• 3	0,3			9	6	2,5	75	2,5	2	
• 3	0,3			15	6	2,5	75	2,5	2	
• 3	0,3	0,5		21	6	2,5	75	2,5	2	
• 4	0,3			12	6	3,5	75	2,5	2	
• 4	0,3			20	6	3,5	75	2,5	2	
• 4	0,3	0,5		28	6	3,5	75	2,5	2	
• 5	0,3			15	6	4,4	75	3,0	2	
• 5	0,3			25	6	4,4	75	3,0	2	
• 5	0,3	0,5		35	6	4,4	75	3,0	2	
• 6	0,3	0,5	1,0	18	6	5,4	100	6,0	2	
• 6	0,3	0,5	1,0	30	6	5,4	100	6,0	2	
• 6	0,3	0,5	1,0	42	6	5,4	100	6,0	2	
• 8	0,3	0,5	1,0	24	8	7,2	100	7,0	2	
• 8	0,3	0,5	1,0	40	8	7,2	100	7,0	2	
• 10		0,5	1,0	1,5	30	10	9,0	100	8,0	2
• 10		0,5	1,0	1,5	50	10	9,0	100	8,0	2
• 12		0,5	1,0	1,5	36	12	11,0	105	9,0	2
• 12		0,5	1,0	1,5	60	12	11,0	105	9,0	2

PKD-SCHAFTFRÄSER

3xD-5xD-7xD



d1 h7	l3	d2 h6	d3	l1	l2	z
• 3	9	6	2,9	75	2,5	2
• 3	15	6	2,9	75	2,5	2
• 3	21	6	2,9	75	2,5	2
• 4	12	6	3,8	75	2,5	2
• 4	20	6	3,8	75	2,5	2
• 4	28	6	3,8	75	2,5	2
• 5	15	6	4,8	75	3,0	2
• 5	25	6	4,8	75	3,0	2
• 5	35	6	4,8	75	3,0	2
• 6	18	6	5,8	100	6,0	2
• 6	30	6	5,8	100	6,0	2
• 6	42	6	5,8	100	6,0	2
• 8	24	8	7,7	100	7,0	2
• 8	40	8	7,7	100	7,0	2
• 10	30	10	9,7	100	8,0	2
• 10	50	10	9,7	100	8,0	2
• 12	36	12	11,7	105	9,0	2
• 12	60	12	11,7	105	9,0	2

PKD-SCHAFTFRÄSER

mit 15/20 mm PKD-Schneidenlänge



d1 h10	l2	d2 h6	l1	l3	z
• 6	7	6	55	8	2
• 6	15	6	54	18	2
• 6	20	6	54	23	2
• 8	7	8	58	8	2
• 8	15	8	58	18	2
• 8	20	8	58	23	2
• 10	7	10	65	8	2
• 10	15	10	66	18	2
• 10	20	10	66	23	2
• 12	7	12	72	8	2
• 12	15	12	73	18	2
• 12	20	12	73	23	2
• 16	15	16	82	18	2
• 16	20	16	82	23	2
• 20	20	20	92	23	2

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SCHNITTDATEN

$$n \text{ [tr/min]} = \frac{V_c \text{ [m/min]} \times 1000}{\pi \times D_1 \text{ [mm]}}$$

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

Typische Einsatzparameter

WERKSTOFF MATERIAL	SCHNITTGESCHWINDIGKEIT [m/min]	VORSCHUB [mm]	SCHNITTtieFE [mm]
DREHEN & AUSSPINDELN			
Aluminiumlegierungen, Kupfer, Messing und ihre Legierungen	300 - 1000	0,05 - 0,5	bis zu 10,0
Gesintertes Hartmetall	10 - 30	0,1 - 0,2	bis zu 2,0
"Grünes" Hartmetall	50 - 200	0,1 - 0,5	bis zu 5,0
Glas- und Kohlefaser- verstärkte Kunststoffe	100 - 600	0,05 - 0,5	bis zu 5,0
"Grüne" Keramiken	100 - 600	bis zu 0,2	bis zu 2,0
Faserverstärkte Kunststoffe	50 - 150	0,1 - 0,5	bis zu 3,0
FRÄSEN & SÄGEN			
Aluminiumlegierungen	500 - 3000	0,1 - 0,5*	bis zu 5,0
Span- und Faserplatten, sowie Kunststoffe	2000 - 3000	0,1 - 0,5*	bis zu 15,0
			*mm/Zahn

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