

Katalog-Nr. Cat.-No.

6085

P1	Stahl Steel < 500 N/mm ²	■ v _c = 20–60 m/min
P2	Stahl Steel 500–1000 N/mm ²	■ v _c = 20–50 m/min
P3	Stahl Steel > 1000 N/mm ²	□ v _c = 15–30 m/min
M1	Rostfreie austenitische Stähle Stainless steel austenitic	■ v _c = 10–20 m/min ²⁾
M2	Rostfreie martensitische Stähle Stainless steel martensitic	□ v _c = 10–20 m/min ²⁾
K1	Grauguss Grey cast iron	
K2	Sphäroguss Nodular cast iron	□ v _c = 20–50 m/min
N1	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 20–60 m/min
N2	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 20–60 m/min
N3	Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si	
N4	Graphit Graphite	
S1	Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm ²	□ v _c = 8–15 m/min ²⁾
S2	Titanlegierungen hochfest Titanium alloys high strength > 900 N/mm ²	
H1	Hartguss und Harte Stähle Chilled steel and Hardened steel 45–55 HRC	

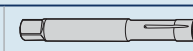
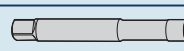
UNF Gewinde (fein) ASME-B1.1

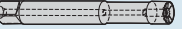
UNF thread (fine) ASME-B1.1

Vollhartmetall-Wechselkopf-Set
Solid carbide indexable nib set



Schaft
Shank



Nennmaß Nominal Size	d ₁	P	Z	2BX Typ SX³⁾	l ₁	l ₂	l ₃	d ₂	□	No.	Ident No.		empfohlener Kernlochdurch- messer recommended drill size	
				Ident No.								No.-IK		Ident No.
UNF 5/16	7,938	24	5	7248873	90	8,5	35	8	6,2	Size No. 2	9115324	Size No. 2-C	9124006	7,45
UNF 3/8	9,525	24	5	7248874	100	10	40	10	8	Size No. 3	9115325	Size No. 3-C	9123970	9,00
UNF 7/16	11,113	20	5	7248875	100	12	45	11	9	Size No. 4	9115326	Size No. 4-C	9126424	10,50
UNF 1/2	12,7	20	5	7248876	110	13	50	12	9	Size No. 6	9115328	Size No. 6-C	9126425	12,10
UNF 9/16	14,288	18	6	7248877	110	13,5	–	12	9	Size No. 7	9115329	Size No. 7-C	9124024	13,60
UNF 5/8	15,875	18	6	7248878	110	13,5	–	12	9	Size No. 8	9115330	Size No. 8-C	9124043	15,20
UNF 3/4	19,05	16	7	7248879	125	16,5	–	16	12	Size No. 10	9115332	Size No. 10-C	9126426	18,30
Vollhartmetall-Wechselkopf-Set Solid carbide indexable nib set					Schaft Shank									
UNF 5/16	7,938	24	5	7248933	90	8,5	35	8	6,2	–	–	Size No. 2-I	7074833	7,45
UNF 3/8	9,525	24	5	7248934	100	10	40	10	8	–	–	Size No. 3-I	7074834	9,00
UNF 7/16	11,113	20	5	7248935	100	12	45	11	9	–	–	Size No. 4-I	7074835	10,50
UNF 1/2	12,7	20	5	7248936	110	13	50	12	9	–	–	Size No. 6-I	7074837	12,10
UNF 9/16	14,288	18	6	7248937	110	13,5	–	12	9	–	–	Size No. 7-I	7074838	13,60
UNF 5/8	15,875	18	6	7248938	110	13,5	–	12	9	–	–	Size No. 8-I	7074839	15,20
UNF 3/4	19,05	16	7	7248939	125	16,5	–	16	12	–	–	Size No. 10-I	7074841	18,30

¹⁾ Anschnittform C auf Anfrage verfügbar
Chamfer form C on request available

²⁾ Schneidöl wird empfohlen
Cutting oil is recommended

³⁾ mit Kühlschmiernuten with coolant grooves

■ = Hauptanwendung First choice
□ = Nebenanwendung Second choice

Zubehör siehe Seite 131
Spare parts see page 131

Weitere Toleranzen, Längen, Anschnittformen auf Anfrage.
Further tolerances, lengths, chamfer forms on request.