

Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining						
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>← $f = 0,04-0,06$</p> <p>$ap = 0,15-0,5$ mm</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>← $f = 0,05-0,1$</p> <p>$ap = 0,15-0,5$ mm</p>	
P	M	K							
N	S	H							
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P	M	K							
N	S	H							
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P	M	K							
N	S	H							

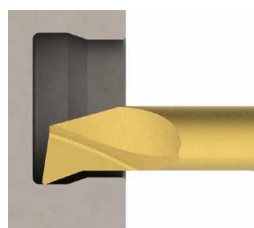
Vorschubbereich f [mm/U]
Feed rate f [mm/rev]

$f = 0,01-0,03$



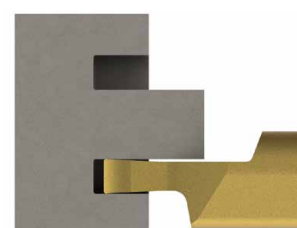
Einstechen
Grooving

$f = 0,02-0,05$
 $ap = 0,15-0,5$ mm



Längsdrehen
Side Turning

$f = 0,02-0,05$



Axialeinstechen
Face Grooving

Geometrien und Vorschübe - Mini

Geometries and feed rates - Mini

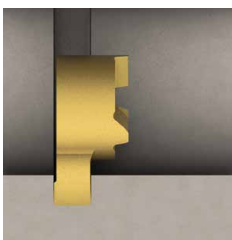


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P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>↓ $f = 0,015-0,05$</p> <p>↔ $ap = 0,03-0,07^*$</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>← $f = 0,05-0,15$</p> <p>← $ap = 0,05-0,35$</p>	
P	M	K							
N	S	H							
	<table border="1"> <tr> <td>P</td> <td>M</td> <td>K</td> </tr> <tr> <td>N</td> <td>S</td> <td>H</td> </tr> </table>	P	M	K	N	S	H	<p>← $f = 0,05-0,15$</p> <p>← $ap = 0,2-0,75^*$</p>	
P	M	K							
N	S	H							

*Systemabhängig / System dependent

Vorschubbereich f [mm/U]
Feed rate f [mm/rev]

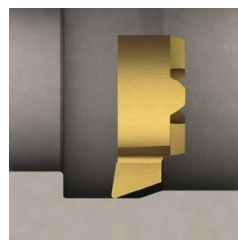
$f = 0,01-0,05$



Einstecken
Grooving

$f = 0,03-0,1$

$ap = 0,1-0,5 \text{ mm}$



Längsdrehen
Side Turning

$f = 0,01-0,08$



Axialeinstecken
Face Grooving



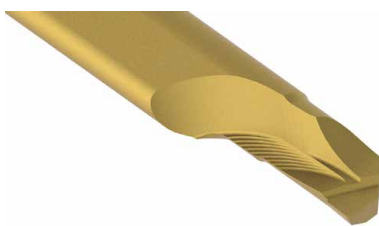
R/L105.B0...1

Geometrie mit Spantreppe für bessere Spankontrolle

- Ausdrehen mit großen Zustellungen
- Für allgemeine Stähle
- Mit Schleppschneide für höhere Vorschübe
- Bessere Spankontrolle
- Bohren in allgemeinen Stählen
- Bei problematischen Anwendungen mit dem Ziel Prozesssicherheit
- Auch bei langspanenden Werkstoffen

Geometry with chipbreaker for better chip control

- Turning with large infeeds
- For general steels
- With trailing cutting edge for higher feeds
- Better chip control
- Drilling in general steels
- For problematic applications with the aim of process reliability
- Also for long-chipping materials



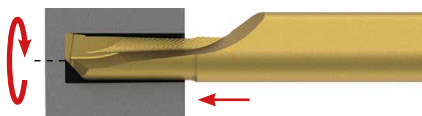
R/L105.B0...2

Universalgeometrie

- Ausdrehen mit großen Zustellungen
- Leichtschneidende Universalgeometrie auch für rostfreie Stähle
- Mit Schleppschneide für höhere Vorschübe
- Weniger Schnittdruck, auch für dünnwandige Bauteile
- Zum Bohren in Stahl und NE-Metallen

Universal geometry

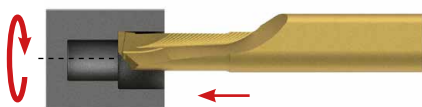
- Turning with large infeeds
- Easy cutting universal geometry also for stainless steels
- With trailing cutting edge for higher feeds
- Less cutting pressure, suitable even for thin-walled components
- For drilling in steel and non-ferrous metals



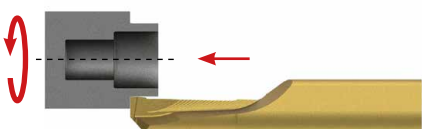
Bohren ins Volle mit ebenem Bohrungsgrund
Drilling into the solid and achieving a flat hole bottom



Drehen von Plankonturen
Turning of face profiles



Drehen von Innenkonturen
Turning of internal profiles



Drehen von Außenkonturen
Turning of external profiles

Vorschübe R/L105.BO...

Feed Rates R/L105.BO...



Ausdrehen Stahl Boring Steel		Schnitttiefe ap (mm) Depth of cut ap (mm)					
		0,5	1	1,5	2	2,5	3
		Vorschub f [mm/U] Feed rate f [mm/rev]					
R/L105.BO.30.20.045.1	1,5*D	0,03-0,05	0,02-0,03				
R/L105.BO.30.20.075.1	2,5*D	0,03-0,05	0,02-0,03				
R/L105.BO.40.20.060.1	1,5*D	0,04-0,06	0,04-0,06	0,04-0,06			
R/L105.BO.40.20.100.1	2,5*D	0,04-0,06	0,04-0,06	0,04-0,06			
R/L105.BO.50.20.075.1	1,5*D	0,05-0,08	0,05-0,08	0,04-0,07	0,04-0,07		
R/L105.BO.50.20.125.1	2,5*D	0,05-0,08	0,05-0,08	0,04-0,07	0,04-0,07		
R/L105.BO.60.20.090.1	1,5*D	0,07-0,1	0,07-0,1	0,07-0,1	0,07-0,1	0,05-0,08	
R/L105.BO.60.20.150.1	2,5*D	0,07-0,1	0,07-0,1	0,07-0,1	0,07-0,1	0,05-0,08	
R/L105.BO.70.20.105.1	1,5*D	0,08-0,1	0,07-0,1	0,07-0,1	0,07-0,1	0,07-0,08	0,05-0,07
R/L105.BO.70.20.175.1	2,5*D	0,08-0,1	0,07-0,1	0,07-0,1	0,07-0,1	0,07-0,08	0,05-0,07

Vorschubwerte für rostfreie Materialien: Minimal-Werte wählen.

Feed rates for stainless materials: Select minimum values.

Bohren Stahl Drilling Steel		Vorschub f [mm/U] Feed rate f [mm/rev]
R/L105.BO.30.20.045.2	1,5*D	0,01-0,02
R/L105.BO.30.20.075.2	2,5*D	0,01-0,02
R/L105.BO.40.20.060.2	1,5*D	0,01-0,02
R/L105.BO.40.20.100.2	2,5*D	0,01-0,02
R/L105.BO.50.20.075.2	1,5*D	0,02-0,04
R/L105.BO.50.20.125.2	2,5*D	0,02-0,04
R/L105.BO.60.20.090.2	1,5*D	0,03-0,05
R/L105.BO.60.20.150.2	2,5*D	0,03-0,05
R/L105.BO.70.20.105.2	1,5*D	0,03-0,05
R/L105.BO.70.20.175.2	2,5*D	0,03-0,05