Axialeinstechen am Zapfen

Für die Herstellung von Axialeinstichen am Zapfen
und Kopierdrehen von axialen Konturen.
Geeignet ab Nutdurchmesser 6,0 mm.

Face Grooving on Pivots

For face grooving on pivots and copy turning of axial contours.
For use as of groove diameter 6,0 mm.

Schnittwerte (Start) // Cutting parameters (start)	
f **0,02 mm/U**	Vc **Seite/Page 442**

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SP HM | Legende / Legend **238**

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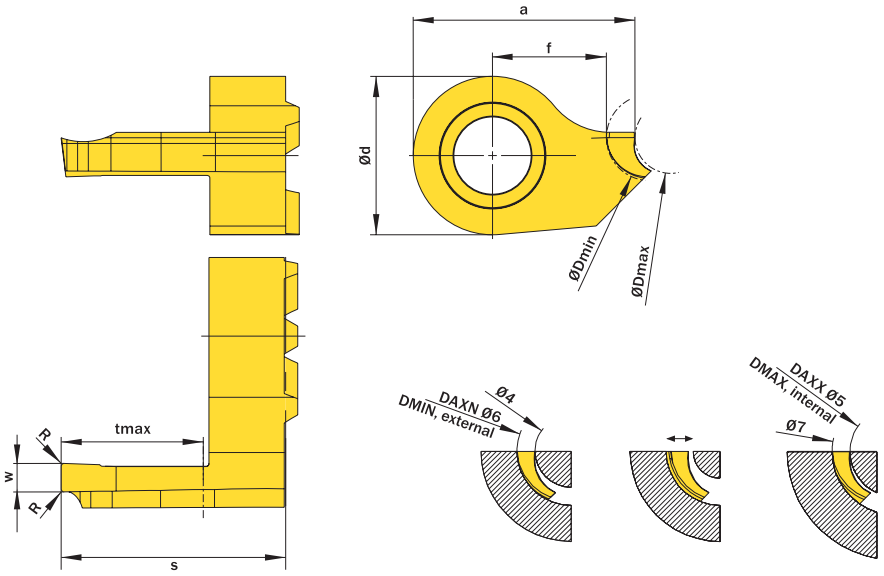

Abbildung zeigt / Drawing shows: D18.0620.100.02 AR

ØDmin ØDmin mm	ØDmax mm	w +0,03 mm	tmax mm	R mm	Artikelnummer Part number	Webcode www.simtek.com/webcode	Empfohlene Schneidstoffe / Recommended cutting grades (P K M N S H O)	a mm	Ød mm	f mm	S mm	Connectcode www.simtek.com/code	
▼ w = 1,0 mm													
6,0	5,0	1,0	5,0	0,1	**D18.0610.050.01 AR**	BHSC	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
7,0	6,0	1,0	5,0	0,1	**D18.0710.050.01 AR**	BHSE	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
8,0	7,0	1,0	5,0	0,1	**D18.0810.050.01 AR**	BHSG	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
9,0	8,0	1,0	5,0	0,1	**D18.0910.050.01 AR**	BHSJ	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
10,0	9,0	1,0	5,0	0,1	**D18.1010.050.01 AR**	BHSM	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
11,0	10,0	1,0	5,0	0,1	**D18.1110.050.01 AR**	BHSP	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
12,0	11,0	1,0	5,0	0,1	**D18.1210.050.01 AR**	BHSS	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
13,0	12,0	1,0	5,0	0,1	**D18.1310.050.01 AR**	BHSU	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
14,0	13,0	1,0	5,0	0,1	**D18.1410.050.01 AR**	BHSW	X800 X400 X600 GX79 X500 X400	16,5	11,0	10,0	15,8	D18.16.A.R	new
▼ w = 1,5 mm													
6,0	5,0	1,5	7,5	0,1	**D18.0615.075.01 AR**	BHSY	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new
7,0	6,0	1,5	7,5	0,1	**D18.0715.075.01 AR**	BHS0	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new
8,0	7,0	1,5	7,5	0,1	**D18.0815.075.01 AR**	BHS2	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new
9,0	8,0	1,5	7,5	0,1	**D18.0915.075.01 AR**	BHS4	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new
10,0	9,0	1,5	7,5	0,1	**D18.1015.075.01 AR**	BHS6	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new
11,0	10,0	1,5	7,5	0,1	**D18.1115.075.01 AR**	BHS8	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new
12,0	11,0	1,5	7,5	0,1	**D18.1215.075.01 AR**	BHTA	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new
13,0	12,0	1,5	7,5	0,1	**D18.1315.075.01 AR**	BHTC	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new
14,0	13,0	1,5	7,5	0,1	**D18.1415.075.01 AR**	BHTE	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,5	15,8	D18.16.A.R	new

Bestellbeispiel // Order example: **D18.0725.100.02 AR X800** (R = Rechte Ausführung // Right hand version, X800 = Schneidstoff // Grade)

Axialeinstechen am Zapfen

Für die Herstellung von Axialeinstichen am Zapfen
und Kopierdrehen von axialen Konturen.
Geeignet ab Nutdurchmesser 6,0 mm.

Face Grooving on Pivots

For face grooving on pivots and copy turning of axial contours.
For use as of groove diameter 6,0 mm.

Schnittwerte (Start) // Cutting parameters (start)	
f **0,02 mm/U**	Vc **Seite/Page 442**

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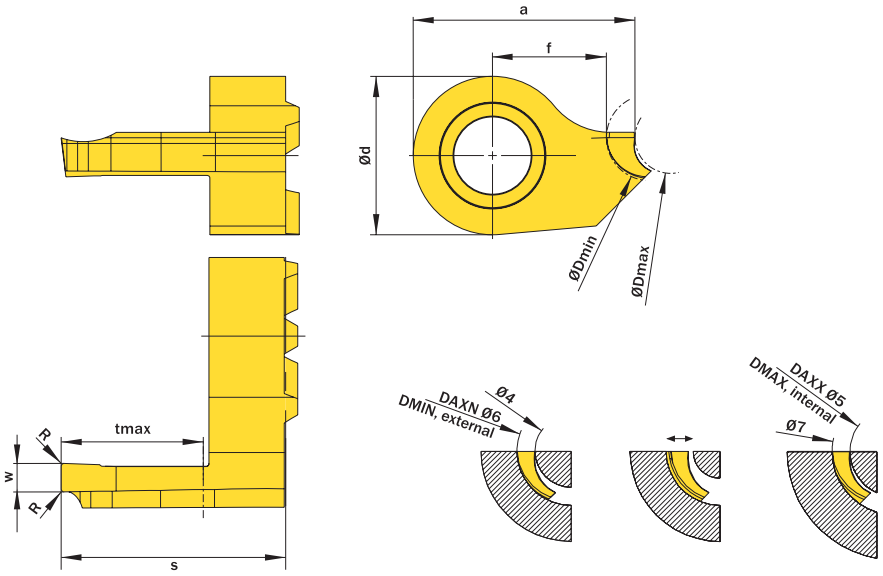

Abbildung zeigt / Drawing shows: D18.0620.100.02 AR

ØDmin ØDmin mm	ØDmax mm	w +0,03 mm	tmax mm	R mm	Artikelnummer Part number	Webcode www.simtek.com/webcode	Empfohlene Schneidstoffe / Recommended cutting grades (P K M N S H O)	a mm	Ød mm	f mm	S mm	Connectcode www.simtek.com/code	
▼ w = 2,0 mm													
6,0	5,0	2,0	10,0	0,2	**D18.0620.100.02 AR**	BHTG	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
7,0	6,0	2,0	10,0	0,2	**D18.0720.100.02 AR**	BHTJ	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
8,0	7,0	2,0	10,0	0,2	**D18.0820.100.02 AR**	BHTM	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
9,0	8,0	2,0	10,0	0,2	**D18.0920.100.02 AR**	BHTP	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
10,0	9,0	2,0	10,0	0,2	**D18.1020.100.02 AR**	BHTS	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
11,0	10,0	2,0	10,0	0,2	**D18.1120.100.02 AR**	BHTU	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
12,0	11,0	2,0	10,0	0,2	**D18.1220.100.02 AR**	BHTW	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
13,0	12,0	2,0	10,0	0,2	**D18.1320.100.02 AR**	BHTY	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
14,0	13,0	2,0	10,0	0,2	**D18.1420.100.02 AR**	BHT0	X800 X400 X600 GX79 X500 X400	16,5	11,0	9,0	15,8	D18.16.A.R	new
▼ w = 2,5 mm													
6,0	5,0	2,5	10,0	0,2	**D18.0625.100.02 AR**	BHT2	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new
7,0	6,0	2,5	10,0	0,2	**D18.0725.100.02 AR**	BHT4	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new
8,0	7,0	2,5	10,0	0,2	**D18.0825.100.02 AR**	BHT6	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new
9,0	8,0	2,5	10,0	0,2	**D18.0925.100.02 AR**	BHT8	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new
10,0	9,0	2,5	10,0	0,2	**D18.1025.100.02 AR**	BHUA	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new
11,0	10,0	2,5	10,0	0,2	**D18.1125.100.02 AR**	BHUC	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new
12,0	11,0	2,5	10,0	0,2	**D18.1225.100.02 AR**	BHUE	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new
13,0	12,0	2,5	10,0	0,2	**D18.1325.100.02 AR**	BHUG	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new
14,0	13,0	2,5	10,0	0,2	**D18.1425.100.02 AR**	BHUJ	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,5	15,8	D18.16.A.R	new

Bestellbeispiel // Order example: **D18.0725.100.02 AR X800** (R = Rechte Ausführung // Right hand version, X800 = Schneidstoff // Grade)

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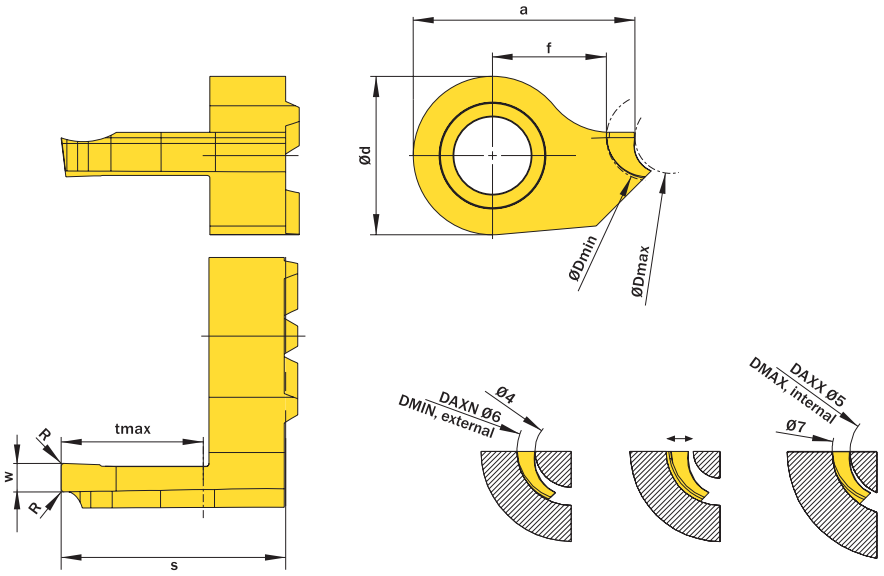

Abbildung zeigt / Drawing shows: D18.0620.100.02 AR

ØDmin ØDmin mm	ØDmax mm	w +0,03 mm	tmax mm	R mm	Artikelnummer Part number	Webcode www.simtek.com/webcode	Empfohlene Schneidstoffe / Recommended cutting grades (P K M N S H O)	a mm	Ød mm	f mm	S mm	Connectcode www.simtek.com/code	
▼ w = 3,0 mm													
6,0	5,0	3,0	10,0	0,2	**D18.0630.100.02 AR**	BHUM	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
7,0	6,0	3,0	10,0	0,2	**D18.0730.100.02 AR**	BHUP	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
8,0	7,0	3,0	10,0	0,2	**D18.0830.100.02 AR**	BHUS	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
9,0	8,0	3,0	10,0	0,2	**D18.0930.100.02 AR**	BHUU	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
10,0	9,0	3,0	10,0	0,2	**D18.1030.100.02 AR**	BHUW	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
11,0	10,0	3,0	10,0	0,2	**D18.1130.100.02 AR**	BHUY	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
12,0	11,0	3,0	10,0	0,2	**D18.1230.100.02 AR**	BHU0	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
13,0	12,0	3,0	10,0	0,2	**D18.1330.100.02 AR**	BHU2	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
14,0	13,0	3,0	10,0	0,2	**D18.1430.100.02 AR**	BHU4	X800 X400 X600 GX79 X500 X400	16,5	11,0	8,0	15,8	D18.16.A.R	new
▼ w = 4,0 mm													
6,0	5,0	4,0	10,0	0,2	**D18.0640.100.02 AR**	BHU6	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new
7,0	6,0	4,0	10,0	0,2	**D18.0740.100.02 AR**	BHU8	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new
8,0	7,0	4,0	10,0	0,2	**D18.0840.100.02 AR**	BHVA	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new
9,0	8,0	4,0	10,0	0,2	**D18.0940.100.02 AR**	BHVC	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new
10,0	9,0	4,0	10,0	0,2	**D18.1040.100.02 AR**	BHVE	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new
11,0	10,0	4,0	10,0	0,2	**D18.1140.100.02 AR**	BHVG	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new
12,0	11,0	4,0	10,0	0,2	**D18.1240.100.02 AR**	BHVJ	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new
13,0	12,0	4,0	10,0	0,2	**D18.1340.100.02 AR**	BHVM	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new
14,0	13,0	4,0	10,0	0,2	**D18.1440.100.02 AR**	BHVP	X800 X400 X600 GX79 X500 X400	17,5	11,0	8,0	15,8	D18.16.A.R	new

Bestellbeispiel // Order example: **D18.0725.100.02 AR X800** (R = Rechte Ausführung // Right hand version, X800 = Schneidstoff // Grade)