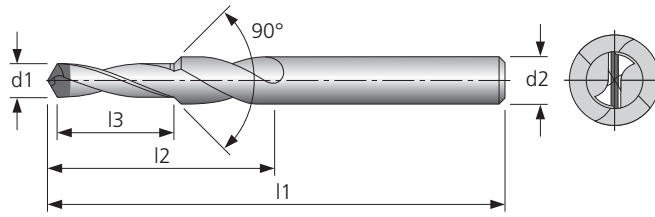


HAM 3328 Diamant-Vollhartmetall-Stufenbohrer
diamond solid carbide step drill

PKD Z 2 25° rechts Werk Norm
Typ N 120° HA
SHRINK FIT



Material	Alu	Alu > 9% Si	Stahl < 800 N/mm²	Stahl < 1200 N/mm²	Stahl < 1600 N/mm²	Stahl < 55 HRC	Stahl < 60 HRC	Stahl < 66 HRC	INOX < 800 N/mm²	INOX > 800 N/mm²	GG	GGG	hochw. Legierungen	Titan	NE Metalle Cu-Leg.	Graphit Faserverbund	MMS	max.	ohne	AIR
33-1200	●	●													●	●	●	●		

● sehr gut geeignet/very suitable ○ geeignet/suitable

Werkstoffgruppe Material group	ø	M4-M5	M6-M8	M10-M14
Alu	V _c [m/min]	600	600	600
	f [mm/U]	0,080	0,100	0,150
	v _f [mm/min]	3640	2580	2810
	n [1/min]	45500	25800	18700
Alu > 9% Si	V _c [m/min]	400	400	400
	f [mm/U]	0,100	0,120	0,120
	v _f [mm/min]	3030	2060	1500
	n [1/min]	30300	17200	12500
NE-Metalle Cu-Leg.	V _c [m/min]	200	200	200
	f [mm/U]	0,120	0,150	0,200
	v _f [mm/min]	1820	1290	1240
	n [1/min]	15200	8600	6200
Graphit Faserverbund	V _c [m/min]	140	140	140
	f [mm/U]	0,080	0,150	0,200
	v _f [mm/min]	850	900	880
	n [1/min]	10600	6000	4400