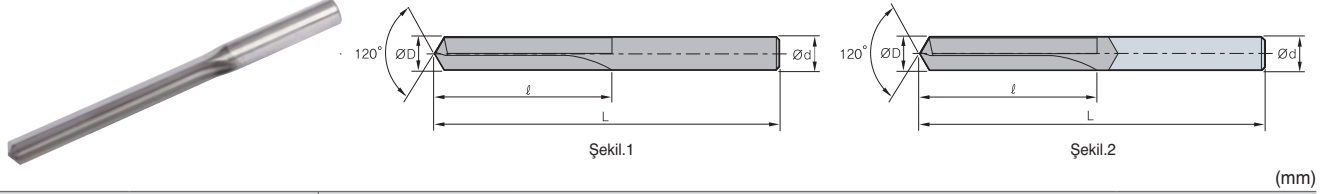


Burnishing Drill

Tavsiye edilen kesme koşulları

İş parçası	Kesme hızı Vc (m/dak)	İlerleme, fn (mm/dev)				
		Ø2.0~Ø3.0	Ø3.5~Ø5.0	Ø5.5~Ø8.0	Ø8.5~Ø12	Ø12.5~Ø18
Alüminyum alaşımları, Bakır alaşımları	30~60	0.02~0.05	0.03~0.10	0.04~0.15	0.05~0.20	0.05~0.30
Kalıp döküm için Alüminyum alaşımları	50~80	0.02~0.05	0.03~0.10	0.04~0.15	0.05~0.20	0.05~0.30
Dökme demir (GD) Sfero döküm	25~60	0.01~0.04	0.02~0.08	0.05~0.12	0.05~0.20	0.05~0.30
Demir (GCD)	20~50	0.01~0.03	0.02~0.05	0.03~0.08	0.04~0.12	0.05~0.15

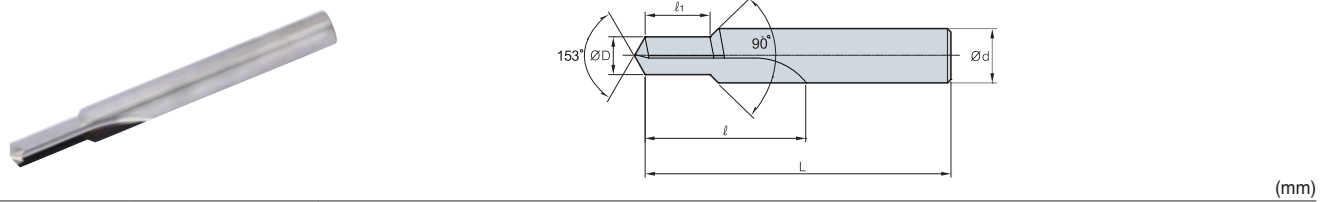
Burnishing Drill-BDS



Kod	ØD	Ød	ℓ	L	Şekil.	
BDS	040S	4.0	4.0	35	80	1
	050S	5.0	5.0	40	85	1
	060S	6.0	6.0	50	95	1
	070S	7.0	7.0	55	100	1
	080S	8.0	8.0	65	110	1
	090S	9.0	9.0	70	120	1
	100S	10.0	10.0	80	130	1
	110S	11.0	11.0	90	140	1
	120B	12.0	12.0	95	150	2
	130B	13.0	16.0	105	160	2
	140B	14.0	16.0	110	170	2
	150B	15.0	16.0	120	185	2
	160B	16.0	16.0	125	190	2

Step Burnishing Drill-BDT

Kılavuz delikleri için



Kod	ØD	Ød	ℓ	ℓ ₁	L	Tap	
BDT	M05080-ℓ 1	4.2	6.0	35	9~15	90	M5XP0.8
	M06100-ℓ 1	5.0	7.0	40	11~18	95	M6XP1.0
	M08125-ℓ 1	6.8	10.0	50	15~24	105	M8XP1.25
	M10125-ℓ 1	8.8	12.0	55	17~30	110	M10XP1.25
	M10150-ℓ 1	8.5	12.0	55	17~30	110	M10XP1.5
	M12125-ℓ 1	10.8	14.0	60	19~36	120	M12XP1.25
	M12150-ℓ 1	10.5	14.0	60	19~36	120	M12XP1.5
	M12175-ℓ 1	10.3	14.0	60	19~36	120	M12XP1.75

Matkaplar

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