SANDVIK Coromant

2018

Yleistyökalut

TÄYDELLINEN VALIKOIMA YLEISKÄYTTÖISIÄ TYÖKALUJA

JYRSINTÄ
PORAUS
KIERTEYTYS
KALVINTA

Jyrsintä

CoroMill® Plura, täyskovametallinen varsijyrsin A4

Raskas rouhinta A5-A17
Keskiraskas rouhinta A19-A21
Rouhinta lastunmurtajalla A23
Sädevarsijyrsin muotojen koneistukseen A25-A27
Viistejyrsintä A29

Poraus

CoroDrill® 460 B2

Kovametallipora B3-B21
Porras- ja viistepora B22-B23

Tappikierteitys

CoroTap™ 200 C3

Metrinen C4-C6
Metrinen, hieno C7-C9
UNC C10-C11
UNF C12-C13
G C14

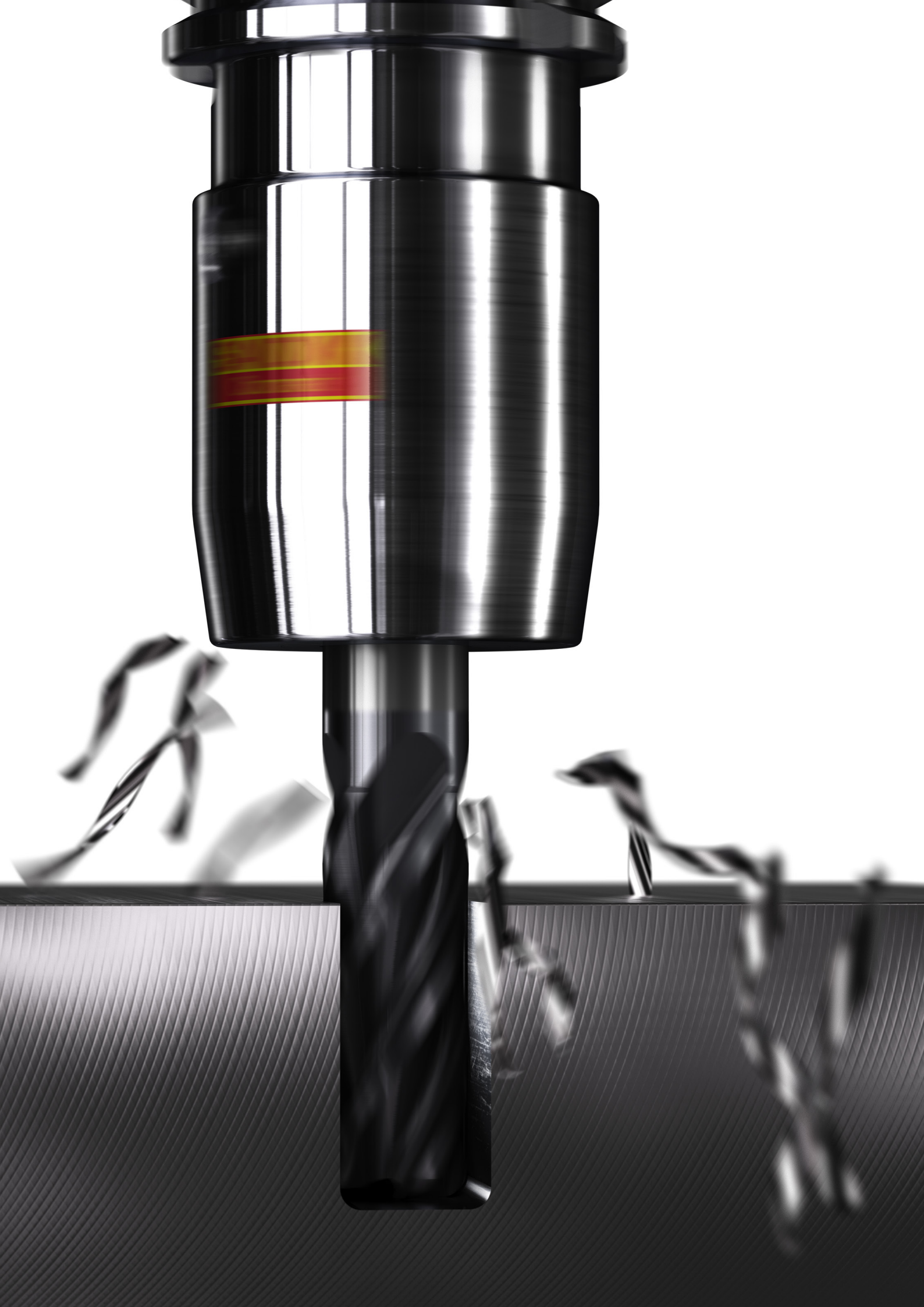
CoroTap™ 300 C15

Metrinen C16-C18
Metrinen, hieno C19-C21
UNC C22-C24
UNF C25-C27
G C28

Kalvinta

CoroReamer™ 435 D2

Pohjareikien koneistukseen D3-D4
Läpireikien koneistukseen D5-D6



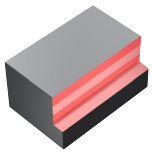
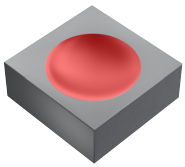
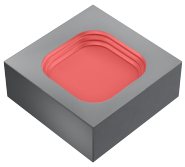
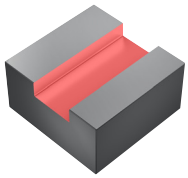
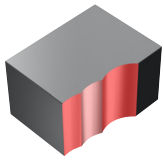
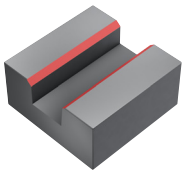
Jyrsintä

Työkalun valintaopas

CoroMill® Plura

Monipuolinen										P	M	K	N	S	H	O	Sivu
Raskas rouhinta	+++	++		++	+	+	++			•	•	•	•	•			A5-A17
2-leikkuinen	+++	+		+	+	+	++			•	•	•	•	•			
3-leikkuinen	++	++		+	+	+	++			•	•	•	•	•			
4-leikkuinen	+	+++		++	+	+	+			•	•	•	•	•			
Keskiraskas rouhinta	++	+++		+++	++	++	++			•	•	•	•	•			A19-A21
3-leikkuinen	++	++		++	++	++	++			•	•	•	•	•			
4-leikkuinen	+	+++		+++	++	++	+			•	•	•	•				
Rouhinta lastunmurtajalla	++	+++		++	++	++	+			•	•	•		•			A23
Muotojyrsintä			+++							•	•	•	•	•			A25-A27
Viistejyrsintä								+++	+++	•	•	•	•	•	•		A29

Menetelmätunnukset

Kulmajyrsintä 	Muotojyrsintä 	Taskujen jyrsintä 	Urajyrsintä 
Pistojyrsintä 	Vino sisäänsyöttö	Sisäviisteiden koneistus 	Nousuinterpolaatio
Ulkoviisteiden koneistus			

FIN

CoroMill® Plura, täyskovametallinen varsijyrsin

	Raskas rouhinta	Keskiraskas rouhinta	Rouhinta lastunmurtajalla	Sädevarsijyrsin muotojen koneistukseen	Viistejyrsintä
V					
Raaka-aine	Eri materiaaleille, kovuus ≤ 48 HRc	Eri materiaaleille, kovuus ≤ 48 HRc	Eri materiaaleille, kovuus ≤ 48 HRc	Eri materiaaleille, kovuus ≤ 48 HRc	Eri materiaaleille, kovuus ≤ 48 HRc
ISO-käyttöalue	P M K N S	P M K N S	P M K S	P M K N S	P M K N S H
D_c mm D_c tuumaa	1.00 - 25.00 .125 - 1.000	2.00 - 25.00 .125 - 1.000	6.00 - 20.00 .250 - 1.000	1.00 - 20.00 .063 - .750	1.00 - 8.00 .047 - .248
FHA	30°, 35°	45°	37°	30°	0°
ZEFP	2, 3, 4	3, 4	4	2, 4	2, 3, 4, 5, 6
RE mm RE, tuumaa	- -	- -	- -	0.50 - 10.00 .031 - .375	- -
CHW, mm CHW tuumaa	0.00 - 0.30 .000 - .012	0.00 - 0.20 .000 - .010	0.35 - 0.63 .014 - .031	- -	- -
Varsi	Lieriö Weldon	Weldon	Lieriö Weldon	Lieriö	Lieriö
BSG	DIN 6527 K DIN 6527 L COROMANT	DIN 6527 L	DIN 6527 L Sisäpuolinen	COROMANT	COROMANT Sisäpuolinen
Laatu	1630	1620, 1630	1640	1620, 1630	1620
Sisäpuolinen lastuamisnesteen syöttö	✗	✗	✗	✗	✗
Ulkopuolinen lastuamisnesteen syöttö	✓	✓	✓	✓	✓
Sivu	A5-A17	A19-A21	A23	A25-A27	A29

CoroMill® Plura

Monipuoliset, kustannustehokkaat ja suorituskykyiset varsijyrsimet

B

työkalut on suunniteltu vaihtelevien materiaalien ja muotojen ja erikokoisten kappaleiden tuottavaan ja varmaan koneistukseen. Niillä maksimoit koneen käyttöasteen.

Käyttöalue

- Raskas rouhinta
- Keskiraskas rouhinta
- Rouhinta lastunmurtajalla
- Muotojyrsintä
- Viisteiden ja kulmapyöristysten jyrsintä

C

ISO-käyttöalueet:

P M K N S H O

Haastavimmat koneistukset ja vaihtelevat tuotantotarpeet vaativat tarkimpia, tukevimpia ja monikäyttöisimpiä työkaluja. Ykkösvalinta tarkkaan, tukevaan ja kustannustehokkaaseen jyrsintään on monikäyttöinen CoroMill Plura -mallisto.

D

C

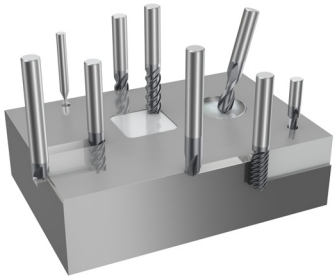
Räätälöidyt ratkaisut, sivu E36

www.sandvik.coromant.com/coromillplura

Tuotevalikoima

- Tehokkaat terälaadut kaikkiin materiaaleihin ja olosuhteisiin
- Tukevat geometriat eri jyrsintämenetelmiin
- Vaihtoehtoina lieriö- ja Weldon-varsi
- Suora teräsärmä, lastunjakourilla tai ilman
- Sädevarsijyrsimet ja jyrsimet viisteille ja kulmapyöristyksille
- Voidaan kunnostaa jopa kolmesti alkuperäistä vastaavaan kuntoon

E



E50

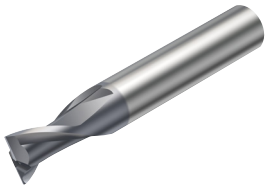
SANDVIK Coromant

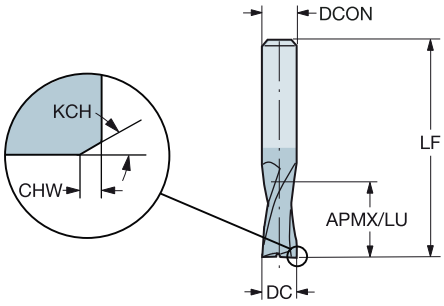
FIN

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	DIN 6527 K
TCDCON	h6





P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
1.0	3	3.5			3.5	2	1P220-0100-XA	1630	3.0	38.0
1.5	3	3.5			3.5	2	1P220-0150-XA	1630	3.0	38.0
1.8	6	3.5			3.5	2	1P220-0180-XA	1630	6.0	50.0
2.0	6	3.5			3.5	2	1P220-0200-XA	1630	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	2	1P220-0250-XA	1630	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	2	1P220-0280-XA	1630	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	2	1P220-0300-XA	1630	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	2	1P220-0350-XA	1630	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	2	1P220-0380-XA	1630	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	2	1P220-0400-XA	1630	6.0	54.0
4.5	6	5.5	0.13	45°	5.5	2	1P220-0450-XA	1630	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	2	1P220-0480-XA	1630	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	2	1P220-0500-XA	1630	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	2	1P220-0575-XA	1630	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	2	1P220-0600-XA	1630	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	2	1P220-0675-XA	1630	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	2	1P220-0700-XA	1630	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	2	1P220-0775-XA	1630	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	2	1P220-0800-XA	1630	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	2	1P220-0900-XA	1630	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	2	1P220-0970-XA	1630	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	2	1P220-1000-XA	1630	10.0	66.0
11.7	12	12.5	0.20	45°	12.5	2	1P220-1170-XA	1630	12.0	73.0
12.0	12	12.5	0.20	45°	12.5	2	1P220-1200-XA	1630	12.0	73.0
13.7	14	14.5	0.20	45°	14.5	2	1P220-1370-XA	1630	14.0	75.0
14.0	14	14.5	0.20	45°	14.5	2	1P220-1400-XA	1630	14.0	75.0
15.7	16	16.5	0.20	45°	16.5	2	1P220-1570-XA	1630	16.0	82.0
16.0	16	16.5	0.20	45°	16.5	2	1P220-1600-XA	1630	16.0	82.0
17.7	18	18.5	0.20	45°	18.5	2	1P220-1770-XA	1630	18.0	84.0
18.0	18	18.5	0.20	45°	18.5	2	1P220-1800-XA	1630	18.0	84.0
19.7	20	20.5	0.30	45°	20.5	2	1P220-1970-XA	1630	20.0	92.0
20.0	20	20.5	0.30	45°	20.5	2	1P220-2000-XA	1630	20.0	92.0

Tuumakoko

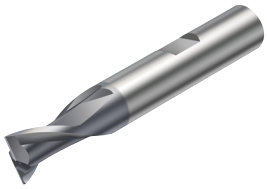
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.172	.003	45°	.172	2	1P220-0318-XA	1630	.125	1.500
.188	3/16	.250	.005	45°	.250	2	1P220-0476-XA	1630	.187	2.000
.250	1/4	.313	.005	45°	.313	2	1P220-0635-XA	1630	.250	2.000
.375	3/8	.469	.008	45°	.469	2	1P220-0953-XA	1630	.375	2.500
.500	1/2	.625	.008	45°	.625	2	1P220-1270-XA	1630	.500	3.000
.625	5/8	.750	.008	45°	.750	2	1P220-1588-XA	1630	.625	3.000
.750	3/4	1.000	.012	45°	1.000	2	1P220-1905-XA	1630	.750	4.000
1.000	1	1.250	.012	45°	1.250	2	1P220-2540-XA	1630	1.000	4.000

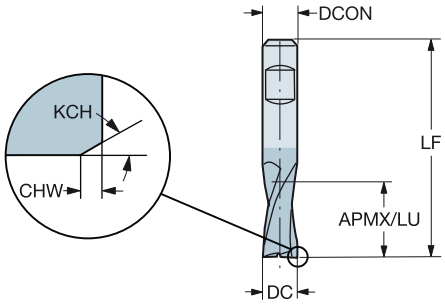
E3 E7 E45 E36 E58 E50

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	DIN 6527 K
TCDCON	h6





P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
1.8	6	3.5			3.5	2	1P220-0180-XB	1630	6.0	50.0
2.0	6	3.5			3.5	2	1P220-0200-XB	1630	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	2	1P220-0250-XB	1630	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	2	1P220-0280-XB	1630	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	2	1P220-0300-XB	1630	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	2	1P220-0350-XB	1630	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	2	1P220-0380-XB	1630	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	2	1P220-0400-XB	1630	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	2	1P220-0480-XB	1630	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	2	1P220-0500-XB	1630	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	2	1P220-0575-XB	1630	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	2	1P220-0600-XB	1630	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	2	1P220-0675-XB	1630	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	2	1P220-0700-XB	1630	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	2	1P220-0775-XB	1630	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	2	1P220-0800-XB	1630	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	2	1P220-0900-XB	1630	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	2	1P220-0970-XB	1630	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	2	1P220-1000-XB	1630	10.0	66.0
11.7	12	12.5	0.20	45°	12.5	2	1P220-1170-XB	1630	12.0	73.0
12.0	12	12.5	0.20	45°	12.5	2	1P220-1200-XB	1630	12.0	73.0
13.7	14	14.5	0.20	45°	14.5	2	1P220-1370-XB	1630	14.0	75.0
14.0	14	14.5	0.20	45°	14.5	2	1P220-1400-XB	1630	14.0	75.0
15.7	16	16.5	0.20	45°	16.5	2	1P220-1570-XB	1630	16.0	82.0
16.0	16	16.5	0.20	45°	16.5	2	1P220-1600-XB	1630	16.0	82.0
17.7	18	18.5	0.20	45°	18.5	2	1P220-1770-XB	1630	18.0	84.0
18.0	18	18.5	0.20	45°	18.5	2	1P220-1800-XB	1630	18.0	84.0
19.7	20	20.5	0.30	45°	20.5	2	1P220-1970-XB	1630	20.0	92.0
20.0	20	20.5	0.30	45°	20.5	2	1P220-2000-XB	1630	20.0	92.0

E3 E7 E45 E36 E58 E50

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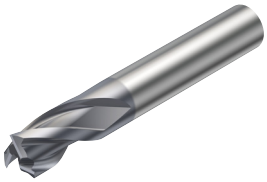
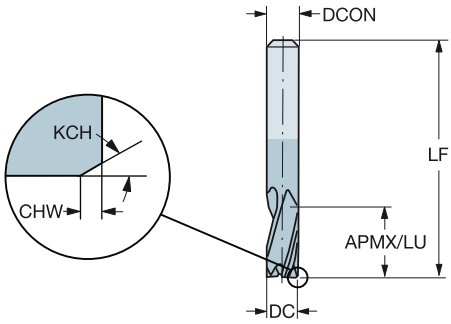
FIN

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	DIN 6527 K
TCDC	e8
TCDCON	h6





P M K N S

Metrinen

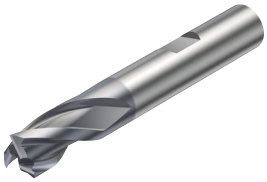
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
1.0	3	3.5			3.5	3	1P221-0100-XA	1630	3.0	38.0
1.5	3	3.5			3.5	3	1P221-0150-XA	1630	3.0	38.0
1.8	6	3.5			3.5	3	1P221-0180-XA	1630	6.0	50.0
2.0	6	3.5			3.5	3	1P221-0200-XA	1630	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	3	1P221-0250-XA	1630	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	3	1P221-0280-XA	1630	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	3	1P221-0300-XA	1630	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	3	1P221-0350-XA	1630	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	3	1P221-0380-XA	1630	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	3	1P221-0400-XA	1630	6.0	54.0
4.5	6	5.5	0.13	45°	5.5	3	1P221-0450-XA	1630	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	3	1P221-0480-XA	1630	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	3	1P221-0500-XA	1630	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	3	1P221-0575-XA	1630	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	3	1P221-0600-XA	1630	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	3	1P221-0675-XA	1630	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	3	1P221-0700-XA	1630	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	3	1P221-0775-XA	1630	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	3	1P221-0800-XA	1630	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	3	1P221-0900-XA	1630	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	3	1P221-0970-XA	1630	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	3	1P221-1000-XA	1630	10.0	66.0
11.7	12	12.5	0.20	45°	12.5	3	1P221-1170-XA	1630	12.0	73.0
12.0	12	12.5	0.20	45°	12.5	3	1P221-1200-XA	1630	12.0	73.0
13.7	14	14.5	0.20	45°	14.5	3	1P221-1370-XA	1630	14.0	75.0
14.0	14	14.5	0.20	45°	14.5	3	1P221-1400-XA	1630	14.0	75.0
15.7	16	16.5	0.20	45°	16.5	3	1P221-1570-XA	1630	16.0	82.0
16.0	16	16.5	0.20	45°	16.5	3	1P221-1600-XA	1630	16.0	82.0
17.7	18	18.5	0.20	45°	18.5	3	1P221-1770-XA	1630	18.0	84.0
18.0	18	18.5	0.20	45°	18.5	3	1P221-1800-XA	1630	18.0	84.0
19.7	20	20.5	0.30	45°	20.5	3	1P221-1970-XA	1630	20.0	92.0
20.0	20	20.5	0.30	45°	20.5	3	1P221-2000-XA	1630	20.0	92.0

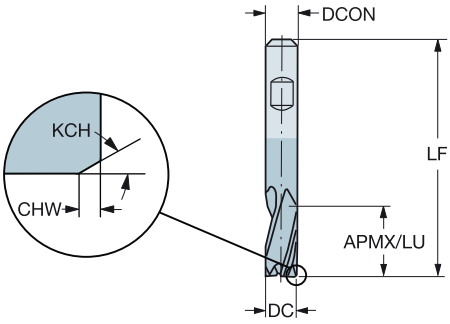
E3 E7 E45 E36 E58 E50

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	DIN 6527 K
TCDC	e8
TCDCON	h6





P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
1.8	6	3.5			3.5	3	1P221-0180-XB	1630	6.0	50.0
2.0	6	3.5			3.5	3	1P221-0200-XB	1630	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	3	1P221-0250-XB	1630	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	3	1P221-0280-XB	1630	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	3	1P221-0300-XB	1630	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	3	1P221-0350-XB	1630	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	3	1P221-0380-XB	1630	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	3	1P221-0400-XB	1630	6.0	54.0
4.5	6	5.5	0.13	45°	5.5	3	1P221-0450-XB	1630	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	3	1P221-0480-XB	1630	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	3	1P221-0500-XB	1630	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	3	1P221-0575-XB	1630	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	3	1P221-0600-XB	1630	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	3	1P221-0675-XB	1630	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	3	1P221-0700-XB	1630	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	3	1P221-0775-XB	1630	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	3	1P221-0800-XB	1630	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	3	1P221-0900-XB	1630	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	3	1P221-0970-XB	1630	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	3	1P221-1000-XB	1630	10.0	66.0
11.7	12	12.5	0.20	45°	12.5	3	1P221-1170-XB	1630	12.0	73.0
12.0	12	12.5	0.20	45°	12.5	3	1P221-1200-XB	1630	12.0	73.0
13.7	14	14.5	0.20	45°	14.5	3	1P221-1370-XB	1630	14.0	75.0
14.0	14	14.5	0.20	45°	14.5	3	1P221-1400-XB	1630	14.0	75.0
15.7	16	16.5	0.20	45°	16.5	3	1P221-1570-XB	1630	16.0	82.0
16.0	16	16.5	0.20	45°	16.5	3	1P221-1600-XB	1630	16.0	82.0
17.7	18	18.5	0.20	45°	18.5	3	1P221-1770-XB	1630	18.0	84.0
18.0	18	18.5	0.20	45°	18.5	3	1P221-1800-XB	1630	18.0	84.0
19.7	20	20.5	0.30	45°	20.5	3	1P221-1970-XB	1630	20.0	92.0
20.0	20	20.5	0.30	45°	20.5	3	1P221-2000-XB	1630	20.0	92.0

E3 E7 E45 E36 E58 E50

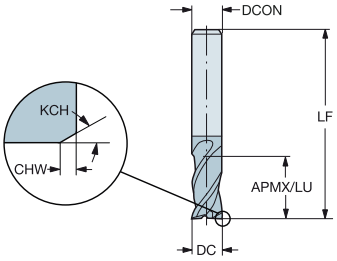
SANDVIK Coromant

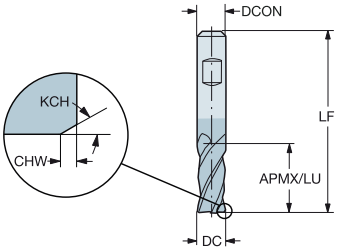
FIN

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

	1P222-XA	1P222-XB
FHA	35°	35°
BSG	DIN 6527 K	DIN 6527 K
TCDC	h10	h10
TCDCON	h6	h6





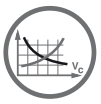
P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
2.0	6	4.5			4.5	4	1P222-0200-XB	1630	6.0	50.0
	6	4.5			4.5	4	1P222-0200-XA	1630	6.0	50.0
3.0	6	5.5	0.08	45°	5.0	4	1P222-0300-XB	1630	6.0	50.0
	6	5.5	0.08	45°	5.5	4	1P222-0300-XA	1630	6.0	50.0
4.0	6	8.5	0.13	45°	8.5	4	1P222-0400-XB	1630	6.0	54.0
	6	8.5	0.13	45°	8.5	4	1P222-0400-XA	1630	6.0	54.0
5.0	6	9.5	0.13	45°	9.5	4	1P222-0500-XB	1630	6.0	54.0
	6	9.5	0.13	45°	9.5	4	1P222-0500-XA	1630	6.0	54.0
6.0	6	10.5	0.13	45°	10.5	4	1P222-0600-XB	1630	6.0	54.0
	6	10.5	0.13	45°	10.5	4	1P222-0600-XA	1630	6.0	54.0
7.0	8	11.5	0.13	45°	11.5	4	1P222-0700-XB	1630	8.0	58.0
	8	11.5	0.13	45°	11.5	4	1P222-0700-XA	1630	8.0	58.0
8.0	8	12.5	0.13	45°	12.5	4	1P222-0800-XB	1630	8.0	58.0
	8	12.5	0.13	45°	12.5	4	1P222-0800-XA	1630	8.0	58.0
10.0	10	14.5	0.20	45°	14.5	4	1P222-1000-XB	1630	10.0	66.0
	10	14.5	0.20	45°	14.5	4	1P222-1000-XA	1630	10.0	66.0
12.0	12	16.5	0.20	45°	16.5	4	1P222-1200-XB	1630	12.0	73.0
	12	16.5	0.20	45°	16.5	4	1P222-1200-XA	1630	12.0	73.0
16.0	16	22.5	0.20	45°	22.5	4	1P222-1600-XB	1630	16.0	82.0
	16	22.5	0.20	45°	22.5	4	1P222-1600-XA	1630	16.0	82.0
20.0	20	26.5	0.30	45°	26.5	4	1P222-2000-XB	1630	20.0	92.0
	20	26.5	0.30	45°	26.5	4	1P222-2000-XA	1630	20.0	92.0
25.0	25	32.5	0.30	45°	32.5	4	1P222-2500-XB	1630	25.0	121.0
	25	32.5	0.30	45°	32.5	4	1P222-2500-XA	1630	25.0	121.0

Tuumakoko

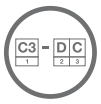
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.219	.003	45°	.219	4	1P222-0318-XA	1630	.125	1.500
.188	3/16	.375	.005	45°	.375	4	1P222-0476-XA	1630	.187	2.000
.250	1/4	.437	.005	45°	.437	4	1P222-0635-XA	1630	.250	2.000
.375	3/8	.625	.008	45°	.625	4	1P222-0953-XA	1630	.375	2.500
.500	1/2	.875	.008	45°	.875	4	1P222-1270-XA	1630	.500	3.000
.625	5/8	1.063	.008	45°	1.063	4	1P222-1588-XA	1630	.625	3.500
.750	3/4	1.250	.010	45°	1.250	4	1P222-1905-XA	1630	.750	4.000
1.000	1	1.687	.012	45°	1.687	4	1P222-2540-XA	1630	1.000	5.000


E3

E7

E45

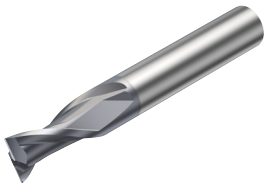
E36


E58

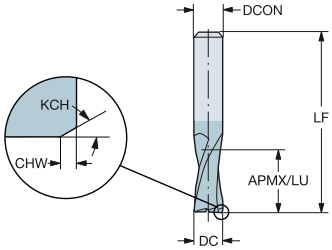
E50

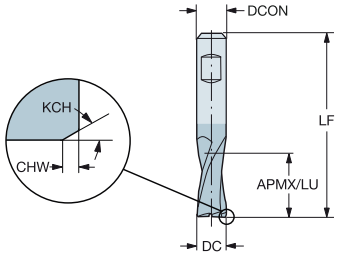
CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc



	1P230-XA	1P230-XB
FHA	30°	30°
BSG	DIN 6527 L	DIN 6527 L
TCDCON	h6	h6





P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
1.0	3	4.5			4.5	2	1P230-0100-XA	1630	3.0	38.0
1.5	3	4.5			4.5	2	1P230-0150-XA	1630	3.0	38.0
2.0	6	6.5			6.5	2	1P230-0200-XB	1630	6.0	57.0
	6	6.5			6.5	2	1P230-0200-XA	1630	6.0	57.0
2.5	6	7.5	0.08	45°	7.5	2	1P230-0250-XB	1630	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0250-XA	1630	6.0	57.0
3.0	6	7.5	0.08	45°	7.5	2	1P230-0300-XB	1630	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0300-XA	1630	6.0	57.0
3.5	6	7.5	0.08	45°	7.5	2	1P230-0350-XB	1630	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0350-XA	1630	6.0	57.0
4.0	6	8.5	0.13	45°	8.5	2	1P230-0400-XB	1630	6.0	57.0
	6	8.5	0.13	45°	8.5	2	1P230-0400-XA	1630	6.0	57.0
4.5	6	8.5	0.13	45°	8.5	2	1P230-0450-XB	1630	6.0	57.0
	6	8.5	0.13	45°	8.5	2	1P230-0450-XA	1630	6.0	57.0
5.0	6	10.5	0.13	45°	10.5	2	1P230-0500-XB	1630	6.0	57.0
	6	10.5	0.13	45°	10.5	2	1P230-0500-XA	1630	6.0	57.0
6.0	6	10.5	0.13	45°	10.5	2	1P230-0600-XB	1630	6.0	57.0
	6	10.5	0.13	45°	10.5	2	1P230-0600-XA	1630	6.0	57.0
7.0	8	13.5	0.13	45°	13.5	2	1P230-0700-XB	1630	8.0	63.0
	8	13.5	0.20	45°	13.5	2	1P230-0700-XA	1630	8.0	63.0
8.0	8	16.5	0.20	45°	16.5	2	1P230-0800-XB	1630	8.0	63.0
	8	16.5	0.20	45°	16.5	2	1P230-0800-XA	1630	8.0	63.0
9.0	10	16.5	0.20	45°	16.5	2	1P230-0900-XB	1630	10.0	72.0
	10	16.5	0.20	45°	16.5	2	1P230-0900-XA	1630	10.0	72.0
10.0	10	19.5	0.20	45°	19.5	2	1P230-1000-XB	1630	10.0	72.0
	10	19.5	0.20	45°	19.5	2	1P230-1000-XA	1630	10.0	72.0
11.0	12	22.5	0.20	45°	22.5	2	1P230-1100-XB	1630	12.0	83.0
	12	22.5	0.20	45°	22.5	2	1P230-1100-XA	1630	12.0	83.0
12.0	12	22.5	0.20	45°	22.5	2	1P230-1200-XB	1630	12.0	83.0
	12	22.5	0.20	45°	22.5	2	1P230-1200-XA	1630	12.0	83.0
14.0	14	22.5	0.20	45°	22.5	2	1P230-1400-XB	1630	14.0	83.0
	14	22.5	0.20	45°	22.5	2	1P230-1400-XA	1630	14.0	83.0
16.0	16	26.5	0.20	45°	26.5	2	1P230-1600-XB	1630	16.0	92.0
	16	26.5	0.20	45°	26.5	2	1P230-1600-XA	1630	16.0	92.0
18.0	18	26.5	0.20	45°	26.5	2	1P230-1800-XB	1630	18.0	92.0
	18	26.5	0.20	45°	26.5	2	1P230-1800-XA	1630	18.0	92.0
20.0	20	32.5	0.30	45°	32.5	2	1P230-2000-XB	1630	20.0	104.0
	20	32.5	0.30	45°	32.5	2	1P230-2000-XA	1630	20.0	104.0

E3 E7 E45 E36 E58 E50

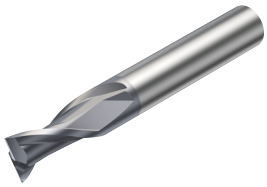
SANDVIK Coromant

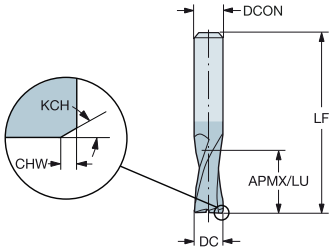
FIN

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	DIN 6527 L
TCDCON	h6





P M K N S

Tuumakoko

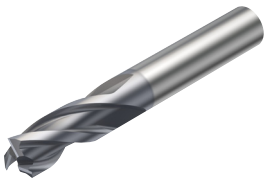
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.313	.003	45°	.313	2	1P230-0318-XA	1630	.125	1.500
.188	3/16	.406	.005	45°	.406	2	1P230-0476-XA	1630	.187	2.000
.250	1/4	.453	.005	45°	.453	2	1P230-0635-XA	1630	.250	2.500
.375	3/8	.687	.008	45°	.687	2	1P230-0953-XA	1630	.375	2.500
.500	1/2	.937	.008	45°	.937	2	1P230-1270-XA	1630	.500	3.000
.625	5/8	1.125	.008	45°	1.125	2	1P230-1588-XA	1630	.625	3.500
.750	3/4	1.219	.012	45°	1.219	2	1P230-1905-XA	1630	.750	4.000
1.000	1	1.625	.012	45°	1.625	2	1P230-2540-XA	1630	1.000	5.000

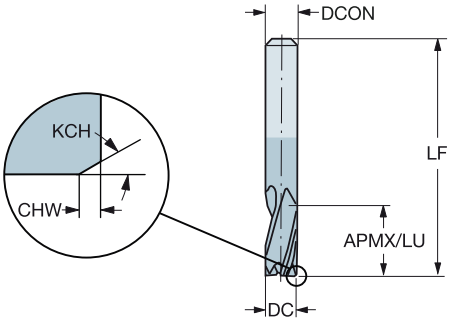
E3 E7 E45 E36 E58 E50

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	DIN 6527 L
TCDCON	h6





P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
1.0	3	4.5			4.5	3	1P231-0100-XA	1630	3.0	38.0
1.5	3	4.5			4.5	3	1P231-0150-XA	1630	3.0	38.0
2.0	6	6.5			6.5	3	1P231-0200-XA	1630	6.0	57.0
2.5	6	7.5	0.08	45°	7.5	3	1P231-0250-XA	1630	6.0	57.0
3.0	6	7.5	0.08	45°	7.5	3	1P231-0300-XA	1630	6.0	57.0
3.5	6	7.5	0.08	45°	7.5	3	1P231-0350-XA	1630	6.0	57.0
4.0	6	8.5	0.13	45°	8.5	3	1P231-0400-XA	1630	6.0	57.0
4.5	6	8.5	0.13	45°	8.5	3	1P231-0450-XA	1630	6.0	57.0
5.0	6	10.5	0.13	45°	10.5	3	1P231-0500-XA	1630	6.0	57.0
5.5	6	10.5	0.13	45°	10.5	3	1P231-0550-XA	1630	6.0	57.0
6.0	6	10.5	0.13	45°	10.5	3	1P231-0600-XA	1630	6.0	57.0
6.5	8	13.5	0.13	45°	13.5	3	1P231-0650-XA	1630	8.0	63.0
7.0	8	13.5	0.13	45°	13.5	3	1P231-0700-XA	1630	8.0	63.0
7.5	8	16.5	0.13	45°	16.5	3	1P231-0750-XA	1630	8.0	63.0
8.0	8	16.5	0.20	45°	16.5	3	1P231-0800-XA	1630	8.0	63.0
9.0	10	16.5	0.20	45°	16.5	3	1P231-0900-XA	1630	10.0	72.0
10.0	10	19.5	0.20	45°	19.5	3	1P231-1000-XA	1630	10.0	72.0
11.0	12	22.5	0.20	45°	22.5	3	1P231-1100-XA	1630	12.0	83.0
12.0	12	22.5	0.20	45°	22.5	3	1P231-1200-XA	1630	12.0	83.0
13.0	14	22.5	0.20	45°	22.5	3	1P231-1300-XA	1630	14.0	83.0
14.0	14	22.5	0.20	45°	22.5	3	1P231-1400-XA	1630	14.0	83.0
15.0	16	26.5	0.20	45°	26.5	3	1P231-1500-XA	1630	16.0	92.0
16.0	16	26.5	0.20	45°	26.5	3	1P231-1600-XA	1630	16.0	92.0
18.0	18	26.5	0.20	45°	26.5	3	1P231-1800-XA	1630	18.0	92.0
20.0	20	32.5	0.30	45°	32.5	3	1P231-2000-XA	1630	20.0	104.0

Tuumakoko

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.313	.003	45°	.313	3	1P231-0318-XA	1630	.125	1.500
.188	3/16	.406	.005	45°	.406	3	1P231-0476-XA	1630	.187	2.000
.250	1/4	.453	.005	45°	.453	3	1P231-0635-XA	1630	.250	2.500
.375	3/8	.687	.008	45°	.687	3	1P231-0953-XA	1630	.375	2.500
.500	1/2	.937	.008	45°	.937	3	1P231-1270-XA	1630	.500	3.000
.625	5/8	1.125	.008	45°	1.125	3	1P231-1588-XA	1630	.625	3.500
.750	3/4	1.219	.012	45°	1.219	3	1P231-1905-XA	1630	.750	4.000
1.000	1	1.625	.012	45°	1.625	3	1P231-2540-XA	1630	1.000	5.000

E3 E7 E45 E36 E58 E50

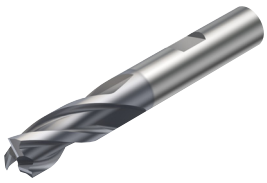
SANDVIK Coromant

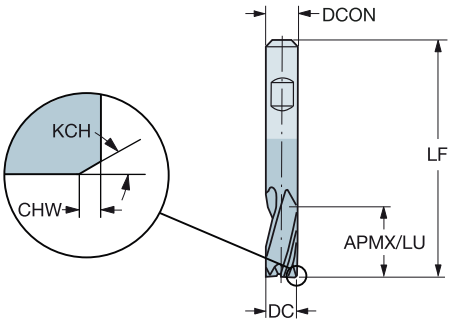
FIN

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	DIN 6527 L
TCDCON	h6





P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
4.5	6	8.5	0.13	45°	8.5	3	1P231-0450-XB	1630	6.0	57.0
5.0	6	10.5	0.13	45°	10.5	3	1P231-0500-XB	1630	6.0	57.0
5.5	6	10.5	0.13	45°	10.5	3	1P231-0550-XB	1630	6.0	57.0
6.0	6	10.5	0.13	45°	10.5	3	1P231-0600-XB	1630	6.0	57.0
6.5	8	13.5	0.13	45°	13.5	3	1P231-0650-XB	1630	8.0	63.0
7.0	8	13.5	0.13	45°	13.5	3	1P231-0700-XB	1630	8.0	63.0
7.5	8	16.5	0.13	45°	16.5	3	1P231-0750-XB	1630	8.0	63.0
8.0	8	16.5	0.20	45°	16.5	3	1P231-0800-XB	1630	8.0	63.0
9.0	10	16.5	0.20	45°	16.5	3	1P231-0900-XB	1630	10.0	72.0
10.0	10	19.5	0.20	45°	19.5	3	1P231-1000-XB	1630	10.0	72.0
11.0	12	22.5	0.20	45°	22.5	3	1P231-1100-XB	1630	12.0	83.0
12.0	12	22.5	0.20	45°	22.5	3	1P231-1200-XB	1630	12.0	83.0
13.0	14	22.5	0.20	45°	22.5	3	1P231-1300-XB	1630	14.0	83.0
14.0	14	22.5	0.20	45°	22.5	3	1P231-1400-XB	1630	14.0	83.0
15.0	16	26.5	0.20	45°	26.5	3	1P231-1500-XB	1630	16.0	92.0
16.0	16	26.5	0.20	45°	26.5	3	1P231-1600-XB	1630	16.0	92.0
18.0	18	26.5	0.20	45°	26.5	3	1P231-1800-XB	1630	18.0	92.0
20.0	20	32.5	0.30	45°	32.5	3	1P231-2000-XB	1630	20.0	104.0

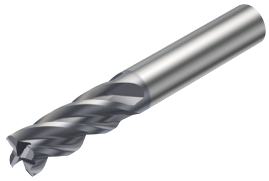
B C D E

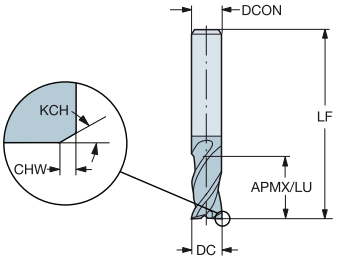
E3 E7 E45 E36 E58 E50

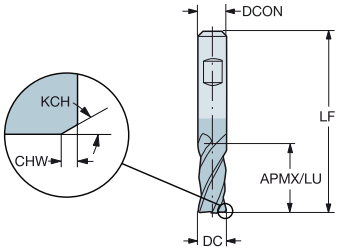
CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

	1P240-XA	1P240-XB
FHA	35°	35°
BSG	DIN 6527 L	DIN 6527 L
TCDC	h10	h10
TCDCON	h6	h6







P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
2.0	6	7.5			7.5	4	1P240-0200-XA	1630	6.0	57.0
3.0	6	8.5	0.08	45°	8.5	4	1P240-0300-XA	1630	6.0	57.0
3.5	6	10.5	0.08	45°	10.5	4	1P240-0350-XA	1630	6.0	57.0
4.0	6	11.5	0.13	45°	11.5	4	1P240-0400-XB	1630	6.0	57.0
	6	11.5	0.13	45°	11.5	4	1P240-0400-XA	1630	6.0	57.0
4.5	6	11.5	0.13	45°	11.5	4	1P240-0450-XB	1630	6.0	57.0
	6	11.5	0.13	45°	11.5	4	1P240-0450-XA	1630	6.0	57.0
5.0	6	13.5	0.13	45°	13.5	4	1P240-0500-XB	1630	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0500-XA	1630	6.0	57.0
5.5	6	13.5	0.13	45°	13.5	4	1P240-0550-XB	1630	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0550-XA	1630	6.0	57.0
6.0	6	13.5	0.13	45°	13.5	4	1P240-0600-XB	1630	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0600-XA	1630	6.0	57.0
6.5	8	16.5	0.13	45°	16.5	4	1P240-0650-XA	1630	8.0	63.0
7.0	8	16.5	0.13	45°	16.5	4	1P240-0700-XB	1630	8.0	63.0
	8	16.5	0.13	45°	16.5	4	1P240-0700-XA	1630	8.0	63.0
8.0	8	19.5	0.13	45°	19.5	4	1P240-0800-XB	1630	8.0	63.0
	8	19.5	0.13	45°	19.5	4	1P240-0800-XA	1630	8.0	63.0
9.0	10	19.5	0.13	45°	19.5	4	1P240-0900-XB	1630	10.0	72.0
	10	19.5	0.13	45°	19.5	4	1P240-0900-XA	1630	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	4	1P240-1000-XB	1630	10.0	72.0
	10	22.5	0.20	45°	22.5	4	1P240-1000-XA	1630	10.0	72.0
12.0	12	26.5	0.20	45°	26.5	4	1P240-1200-XB	1630	12.0	83.0
	12	26.5	0.20	45°	26.5	4	1P240-1200-XA	1630	12.0	83.0
14.0	14	26.5	0.20	45°	26.5	4	1P240-1400-XB	1630	14.0	83.0
	14	26.5	0.20	45°	26.5	4	1P240-1400-XA	1630	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	4	1P240-1600-XB	1630	16.0	92.0
	16	32.5	0.20	45°	32.5	4	1P240-1600-XA	1630	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	4	1P240-1800-XB	1630	18.0	92.0
	18	32.5	0.20	45°	32.5	4	1P240-1800-XA	1630	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	4	1P240-2000-XB	1630	20.0	104.0
	20	38.5	0.30	45°	38.5	4	1P240-2000-XA	1630	20.0	104.0
25.0	25	45.5	0.30	45°	45.5	4	1P240-2500-XB	1630	25.0	121.0
	25	45.5	0.30	45°	45.5	4	1P240-2500-XA	1630	25.0	121.0

Tuumakoko

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.359	.003	45°	.359	4	1P240-0318-XA	1630	.125	1.500
.188	3/16	.547	.005	45°	.547	4	1P240-0476-XA	1630	.187	2.000
.250	1/4	.562	.005	45°	.562	4	1P240-0635-XA	1630	.250	2.500
.375	3/8	.844	.008	45°	.844	4	1P240-0953-XA	1630	.375	3.000
.500	1/2	1.125	.008	45°	1.125	4	1P240-1270-XA	1630	.500	3.500
.625	5/8	1.313	.008	45°	1.313	4	1P240-1588-XA	1630	.625	4.000
.750	3/4	1.437	.012	45°	1.437	4	1P240-1905-XA	1630	.750	4.000
1.000	1	1.828	.012	45°	1.828	4	1P240-2540-XA	1630	1.000	5.000

E3 E7 E45 E36 E58 E50

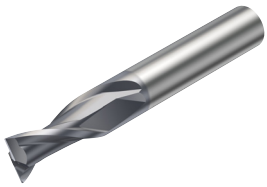
SANDVIK Coromant

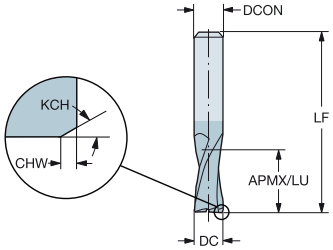
FIN

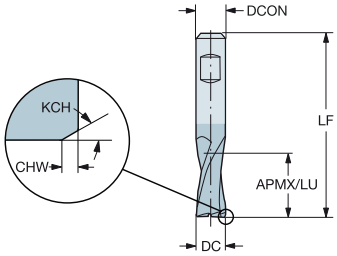
CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

	1P250-XA	1P250-XB
FHA	30°	30°
BSG	COROMANT	COROMANT
TCDCON	h6	h6







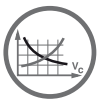
P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	DCON (Mitat, mm)	LF (Mitat, mm)
2.0	6	8.5			8.5	2	1P250-0200-XA	1630	6.0	57.0
2.5	6	12.5	0.08	45°	12.5	2	1P250-0250-XA	1630	6.0	57.0
3.0	6	12.5	0.08	45°	12.5	2	1P250-0300-XA	1630	6.0	57.0
4.0	6	14.5	0.13	45°	14.5	2	1P250-0400-XB	1630	6.0	57.0
	6	14.5	0.13	45°	14.5	2	1P250-0400-XA	1630	6.0	57.0
5.0	6	16.5	0.13	45°	16.5	2	1P250-0500-XB	1630	6.0	57.0
	6	16.5	0.13	45°	16.5	2	1P250-0500-XA	1630	6.0	57.0
6.0	6	19.5	0.13	45°	19.5	2	1P250-0600-XB	1630	6.0	57.0
	6	19.5	0.13	45°	19.5	2	1P250-0600-XA	1630	6.0	57.0
7.0	8	19.5	0.13	45°	19.5	2	1P250-0700-XA	1630	8.0	63.0
8.0	8	19.5	0.20	45°	19.5	2	1P250-0800-XB	1630	8.0	63.0
	8	19.5	0.20	45°	19.5	2	1P250-0800-XA	1630	8.0	63.0
9.0	10	21.5	0.20	45°	21.5	2	1P250-0900-XB	1630	10.0	72.0
	10	21.5	0.20	45°	21.5	2	1P250-0900-XA	1630	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	2	1P250-1000-XB	1630	10.0	72.0
	10	22.5	0.20	45°	22.5	2	1P250-1000-XA	1630	10.0	72.0
12.0	12	25.5	0.20	45°	25.5	2	1P250-1200-XB	1630	12.0	83.0
	12	25.5	0.20	45°	25.5	2	1P250-1200-XA	1630	12.0	83.0
14.0	14	30.5	0.20	45°	30.5	2	1P250-1400-XA	1630	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	2	1P250-1600-XB	1630	16.0	92.0
	16	32.5	0.20	45°	32.5	2	1P250-1600-XA	1630	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	2	1P250-1800-XB	1630	18.0	92.0
	18	32.5	0.20	45°	32.5	2	1P250-1800-XA	1630	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	2	1P250-2000-XB	1630	20.0	104.0
	20	38.5	0.30	45°	38.5	2	1P250-2000-XA	1630	20.0	104.0

Tuumakoko

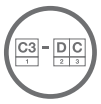
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	DCON (Mitat, tuumaa)	LF (Mitat, tuumaa)
.125	1/8	.359	.003	45°	.359	2	1P250-0318-XA	1630	.125	1.500
.188	3/16	.687	.005	45°	.687	2	1P250-0476-XA	1630	.187	2.000
.250	1/4	.813	.005	45°	.813	2	1P250-0635-XA	1630	.250	2.500
.375	3/8	.875	.008	45°	.875	2	1P250-0953-XA	1630	.375	3.000
.500	1/2	1.188	.008	45°	1.188	2	1P250-1270-XA	1630	.500	3.500
.625	5/8	1.484	.008	45°	1.484	2	1P250-1588-XA	1630	.625	4.000
.750	3/4	1.687	.012	45°	1.687	2	1P250-1905-XA	1630	.750	4.000
1.000	1	2.250	.012	45°	2.250	2	1P250-2540-XA	1630	1.000	5.000


E3

E7

E45

E36

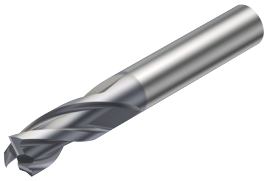

E58

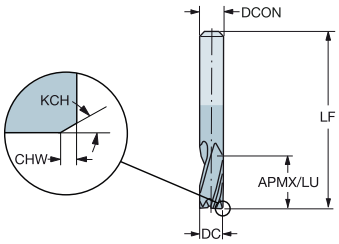
E50

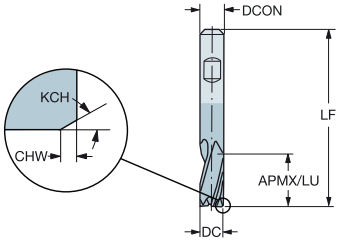
CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

	1P251-XA	1P251-XB
FHA	30°	30°
BSG	COROMANT	COROMANT
TCDCON	h6	h6







P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
2.0	6	8.5			8.5	3	1P251-0200-XA	1630	6.0	57.0
2.5	6	12.5	0.08	45°	12.5	3	1P251-0250-XA	1630	6.0	57.0
3.0	6	12.5	0.08	45°	12.5	3	1P251-0300-XA	1630	6.0	57.0
4.0	6	14.5	0.13	45°	14.5	3	1P251-0400-XB	1630	6.0	57.0
	6	14.5	0.13	45°	14.5	3	1P251-0400-XA	1630	6.0	57.0
5.0	6	16.5	0.13	45°	16.5	3	1P251-0500-XB	1630	6.0	57.0
	6	16.5	0.13	45°	16.5	3	1P251-0500-XA	1630	6.0	57.0
6.0	6	19.5	0.13	45°	19.5	3	1P251-0600-XB	1630	6.0	57.0
	6	19.5	0.13	45°	19.5	3	1P251-0600-XA	1630	6.0	57.0
7.0	8	19.5	0.13	45°	19.5	3	1P251-0700-XA	1630	8.0	63.0
8.0	8	19.5	0.20	45°	19.5	3	1P251-0800-XB	1630	8.0	63.0
	8	19.5	0.20	45°	19.5	3	1P251-0800-XA	1630	8.0	63.0
9.0	10	21.5	0.20	45°	21.5	3	1P251-0900-XB	1630	10.0	72.0
	10	21.5	0.20	45°	21.5	3	1P251-0900-XA	1630	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	3	1P251-1000-XB	1630	10.0	72.0
	10	22.5	0.20	45°	22.5	3	1P251-1000-XA	1630	10.0	72.0
12.0	12	25.5	0.20	45°	25.5	3	1P251-1200-XB	1630	12.0	83.0
	12	25.5	0.20	45°	25.5	3	1P251-1200-XA	1630	12.0	83.0
14.0	14	30.5	0.20	45°	30.5	3	1P251-1400-XA	1630	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	3	1P251-1600-XB	1630	16.0	92.0
	16	32.5	0.20	45°	32.5	3	1P251-1600-XA	1630	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	3	1P251-1800-XB	1630	18.0	92.0
	18	32.5	0.20	45°	32.5	3	1P251-1800-XA	1630	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	3	1P251-2000-XB	1630	20.0	104.0
	20	38.5	0.30	45°	38.5	3	1P251-2000-XA	1630	20.0	104.0

E3 E7 E45 E36 E58 E50

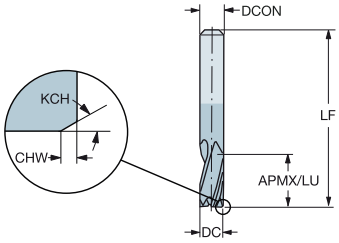
SANDVIK Coromant

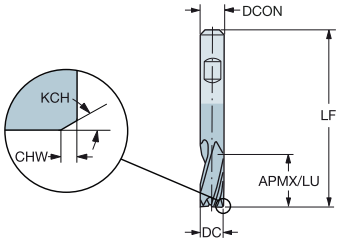
FIN

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

	1P260-XA	1P260-XB
FHA	30°	30°
BSG	COROMANT	COROMANT
TCDC	h10	h10
TCDCON	h6	h6





P M K N S

Metrinen

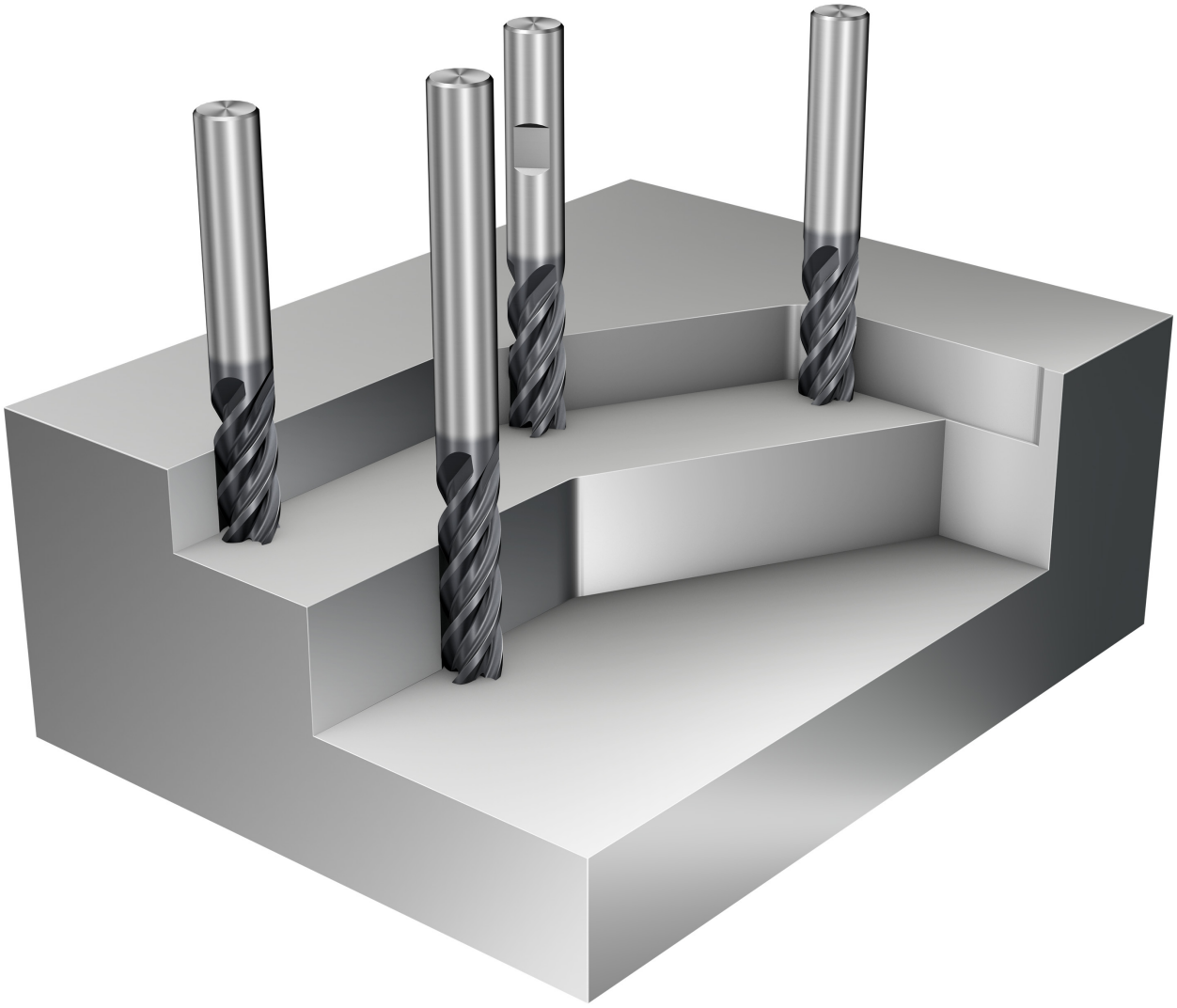
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
1.0	3	4.0			4.0	3	1P260-0100-XA	1620	3.0	38.0
1.5	3	6.0			6.0	3	1P260-0150-XA	1620	3.0	38.0
2.0	3	8.0			8.0	3	1P260-0200-XA	1620	3.0	38.0
3.0	3	12.0			12.0	3	1P260-0300-XA	1620	3.0	38.0
4.0	4	14.0			14.0	3	1P260-0400-XA	1620	4.0	50.0
5.0	6	16.0			16.0	3	1P260-0500-XB	1620	6.0	57.0
	6	16.0			16.0	3	1P260-0500-XA	1620	6.0	57.0
6.0	6	22.0			22.0	3	1P260-0600-XB	1620	6.0	65.0
	6	22.0			22.0	3	1P260-0600-XA	1620	6.0	65.0
8.0	8	28.0			28.0	3	1P260-0800-XB	1620	8.0	80.0
	8	28.0			28.0	3	1P260-0800-XA	1620	8.0	80.0
10.0	10	32.0	0.10	45°	32.0	3	1P260-1000-XB	1620	10.0	100.0
	10	32.0	0.10	45°	32.0	3	1P260-1000-XA	1620	10.0	100.0
12.0	12	38.0	0.10	45°	38.0	3	1P260-1200-XB	1620	12.0	100.0
	12	38.0	0.10	45°	38.0	3	1P260-1200-XA	1620	12.0	100.0
16.0	16	50.0	0.15	45°	50.0	3	1P260-1600-XB	1620	16.0	115.0
	16	50.0	0.15	45°	50.0	3	1P260-1600-XA	1620	16.0	115.0
20.0	20	50.0	0.15	45°	50.0	3	1P260-2000-XB	1620	20.0	125.0
	20	50.0	0.15	45°	50.0	3	1P260-2000-XA	1620	20.0	125.0

Tuumakoko

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.500			.500	3	1P260-0318-XA	1620	.125	2.000
.188	3/16	.625			.625	3	1P260-0476-XA	1620	.187	2.000
.250	1/4	.937			.937	3	1P260-0635-XA	1620	.250	2.500
.375	3/8	1.219	.004	45°	1.219	3	1P260-0953-XA	1620	.375	3.000
.500	1/2	1.594	.004	45°	1.594	3	1P260-1270-XA	1620	.500	3.500
.625	5/8	1.938	.006	45°	1.938	3	1P260-1588-XA	1620	.625	4.000
.750	3/4	2.313	.006	45°	2.313	3	1P260-1905-XA	1620	.750	5.000
1.000	1	2.500	.010	45°	2.500	3	1P260-2540-XA	1620	1.000	6.000

E3 E7 E45 E36 E58 E50

CoroMill® Plura, täyskovametallinen varsijyrsin keskiraskaaseen rouhintaan

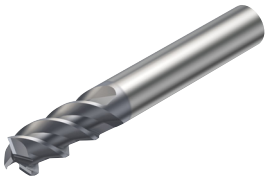


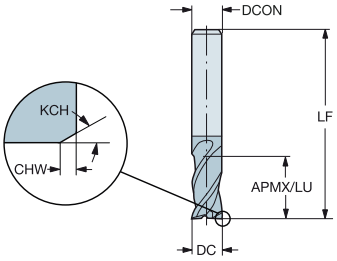
FIN

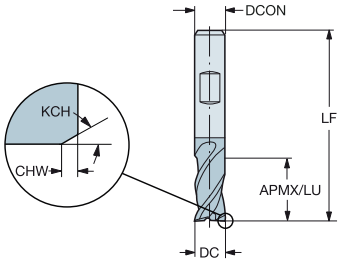
CoroMill® Plura, täyskovametallinen varsijyrsin keskiraskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

	1P330-XA	1P330-XB
FHA	45°	45°
BSG	DIN 6527 L	DIN 6527 L
TCDC	h10	h10
TCDCON	h6	h6







P M K N S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
2.0	6	6.0			6.0	3	1P330-0200-XB	1620	6.0	57.0
	6	6.0			6.0	3	1P330-0200-XA	1620	6.0	57.0
3.0	6	7.0			7.0	3	1P330-0300-XB	1620	6.0	57.0
	6	7.0			7.0	3	1P330-0300-XA	1620	6.0	57.0
4.0	6	8.0	0.10	45°	8.0	3	1P330-0400-XB	1620	6.0	57.0
	6	8.0	0.10	45°	8.0	3	1P330-0400-XA	1620	6.0	57.0
5.0	6	10.0	0.10	45°	10.0	3	1P330-0500-XB	1620	6.0	57.0
	6	10.0	0.10	45°	10.0	3	1P330-0500-XA	1620	6.0	57.0
6.0	6	10.0	0.10	45°	10.0	3	1P330-0600-XB	1620	6.0	57.0
	6	10.0	0.10	45°	10.0	3	1P330-0600-XA	1620	6.0	57.0
7.0	8	13.0	0.10	45°	13.0	3	1P330-0700-XB	1620	8.0	63.0
	8	13.0	0.10	45°	13.0	3	1P330-0700-XA	1620	8.0	63.0
8.0	8	16.0	0.10	45°	16.0	3	1P330-0800-XB	1620	8.0	63.0
	8	16.0	0.10	45°	16.0	3	1P330-0800-XA	1620	8.0	63.0
9.0	10	16.0	0.10	45°	16.0	3	1P330-0900-XB	1620	10.0	72.0
	10	16.0	0.10	45°	16.0	3	1P330-0900-XA	1620	10.0	72.0
10.0	10	19.0	0.10	45°	19.0	3	1P330-1000-XB	1620	10.0	72.0
	10	19.0	0.10	45°	19.0	3	1P330-1000-XA	1620	10.0	72.0
12.0	12	22.0	0.10	45°	22.0	3	1P330-1200-XB	1620	12.0	83.0
	12	22.0	0.10	45°	22.0	3	1P330-1200-XA	1620	12.0	83.0
14.0	14	22.0	0.15	45°	22.0	3	1P330-1400-XB	1620	14.0	83.0
	14	22.0	0.15	45°	22.0	3	1P330-1400-XA	1620	14.0	83.0
16.0	16	26.0	0.15	45°	26.0	3	1P330-1600-XB	1620	16.0	92.0
	16	26.0	0.15	45°	26.0	3	1P330-1600-XA	1620	16.0	92.0
18.0	18	26.0	0.15	45°	26.0	3	1P330-1800-XB	1620	18.0	92.0
	18	26.0	0.15	45°	26.0	3	1P330-1800-XA	1620	18.0	92.0
20.0	20	32.0	0.15	45°	32.0	3	1P330-2000-XB	1620	20.0	104.0
	20	32.0	0.15	45°	32.0	3	1P330-2000-XA	1620	20.0	104.0

Tuumakoko

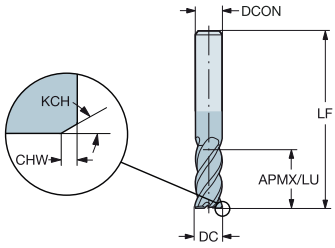
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.297			.297	3	1P330-0318-XA	1620	.125	1.500
.188	3/16	.375	.004	45°	.375	3	1P330-0476-XA	1620	.187	2.000
.250	1/4	.422	.004	45°	.422	3	1P330-0635-XA	1620	.250	2.500
.375	3/8	.719	.004	45°	.719	3	1P330-0953-XA	1620	.375	2.500
.500	1/2	.922	.004	45°	.922	3	1P330-1270-XA	1620	.500	3.000
.625	5/8	1.031	.006	45°	1.031	3	1P330-1588-XA	1620	.625	3.500
.750	3/4	1.219	.006	45°	1.219	3	1P330-1905-XA	1620	.750	4.000
1.000	1	1.594	.010	45°	1.594	3	1P330-2540-XA	1620	1.000	5.000

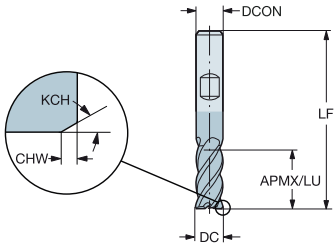
E3 E7 E45 E36 E58 E50

CoroMill® Plura, täyskovametallinen varsijyrsin keskiraskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

	1P341-XA	1P341-XB
FHA	45°	45°
BSG	DIN 6527 L	DIN 6527 L
TCDC	h10	h10
TCDCON	h6	h6





P M K S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
2.0	6	7.0			7.0	4	1P341-0200-XA	1620, 1630	6.0	57.0
3.0	6	8.0			8.0	4	1P341-0300-XA	1620, 1630	6.0	57.0
4.0	6	11.0	0.10	45°	11.0	4	1P341-0400-XA	1620, 1630	6.0	57.0
5.0	6	13.0	0.10	45°	13.0	4	1P341-0500-XA	1620, 1630	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	4	1P341-0600-XB	1630	6.0	57.0
	6	13.0	0.10	45°	13.0	4	1P341-0600-XA	1620, 1630	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	4	1P341-0800-XB	1630	8.0	63.0
	8	19.0	0.10	45°	19.0	4	1P341-0800-XA	1620, 1630	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	4	1P341-1000-XB	1630	10.0	72.0
	10	22.0	0.10	45°	22.0	4	1P341-1000-XA	1620, 1630	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	4	1P341-1200-XB	1630	12.0	83.0
	12	26.0	0.10	45°	26.0	4	1P341-1200-XA	1620, 1630	12.0	83.0
14.0	14	26.0	0.15	45°	26.0	4	1P341-1400-XB	1630	14.0	83.0
	14	26.0	0.15	45°	26.0	4	1P341-1400-XA	1620, 1630	14.0	83.0
16.0	16	32.0	0.15	45°	32.0	4	1P341-1600-XB	1630	16.0	92.0
	16	32.0	0.15	45°	32.0	4	1P341-1600-XA	1620, 1630	16.0	92.0
18.0	18	32.0	0.15	45°	32.0	5	1P341-1800-XA	1620, 1630	18.0	92.0
20.0	20	38.0	0.15	45°	38.0	5	1P341-2000-XB	1630	20.0	104.0
	20	38.0	0.15	45°	38.0	5	1P341-2000-XA	1620, 1630	20.0	104.0

Tuumakoko

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.313			.313	4	1P341-0318-XA	1630	.125	1.500
.188	3/16	.469	.004	45°	.469	4	1P341-0476-XA	1630	.187	2.000
.250	1/4	.531	.004	45°	.531	4	1P341-0635-XA	1630	.250	2.500
.375	3/8	.844	.006	45°	.844	4	1P341-0953-XA	1630	.375	3.000
.500	1/2	1.094	.006	45°	1.094	4	1P341-1270-XA	1630	.500	3.500
.625	5/8	1.313	.010	45°	1.313	5	1P341-1588-XA	1630	.625	4.000
.750	3/4	1.563	.010	45°	1.563	5	1P341-1905-XA	1630	.750	4.000
1.000	1	2.094	.010	45°	2.094	5	1P341-2540-XA	1630	1.000	5.000

E3 E7 E45 E36 E58 E50

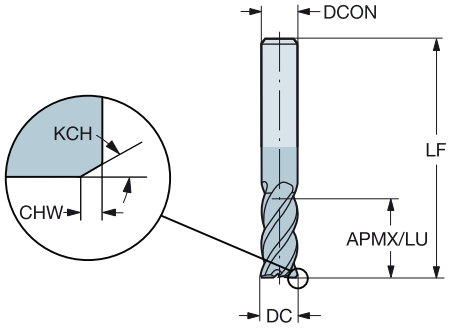
SANDVIK Coromant

FIN

CoroMill® Plura, täyskovametallinen varsijyrsin keskiraskaaseen rouhintaan

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	45°
BSG	COROMANT
TCDC	h10
TCDCON	h6



P M K S

Metrinen

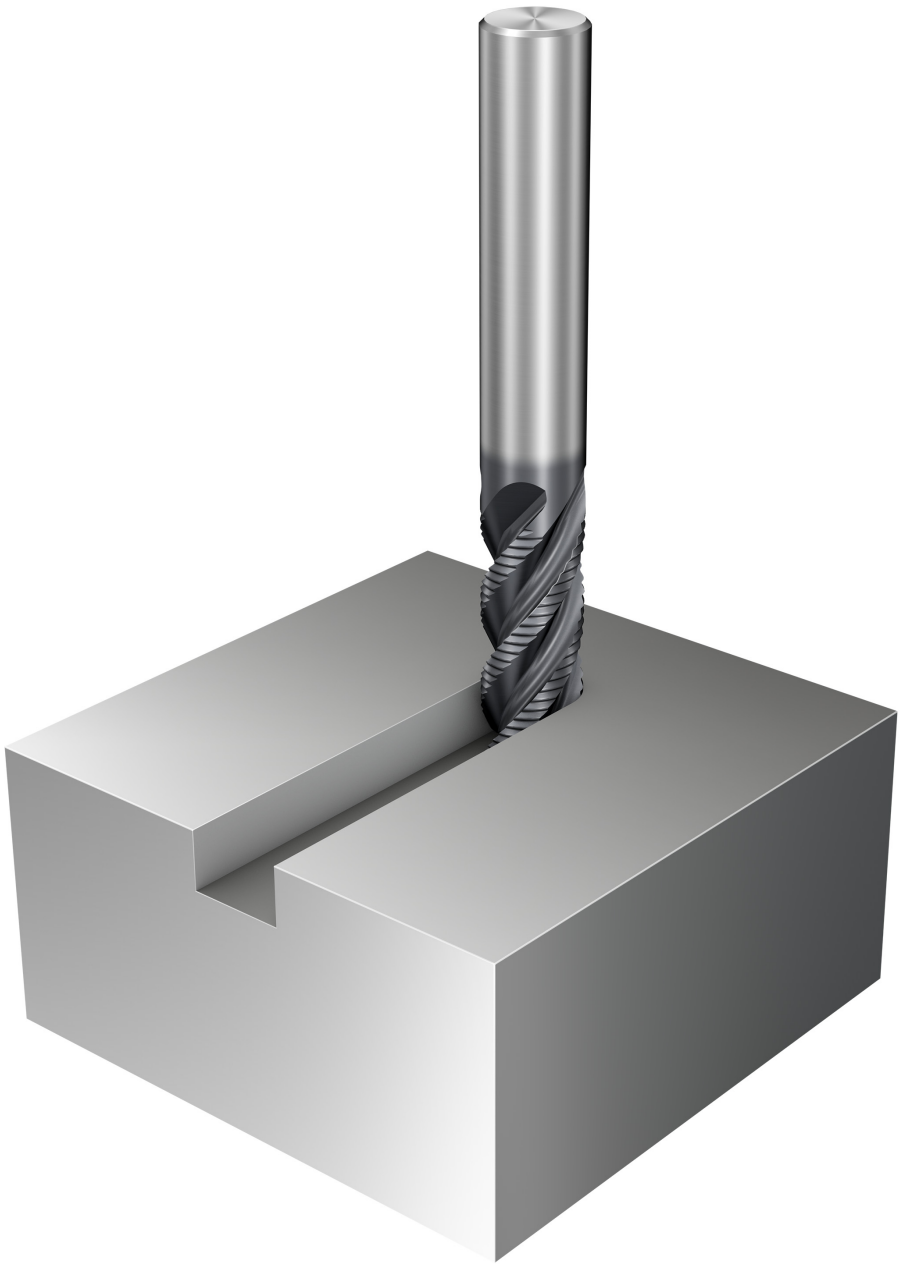
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
6.0	6	22.0	0.10	45°	22.0	4	1P360-0600-XA	1620	6.0	65.0
8.0	8	28.0	0.10	45°	28.0	4	1P360-0800-XA	1620	8.0	80.0
10.0	10	32.0	0.10	45°	32.0	4	1P360-1000-XA	1620	10.0	100.0
12.0	12	40.0	0.10	45°	40.0	4	1P360-1200-XA	1620	12.0	100.0
14.0	14	50.0	0.15	45°	50.0	4	1P360-1400-XA	1620	14.0	104.0
16.0	16	50.0	0.15	45°	50.0	5	1P360-1600-XA	1620	16.0	115.0
20.0	20	55.0	0.15	45°	55.0	5	1P360-2000-XA	1620	20.0	125.0
25.0	25	90.0	0.15	45°	90.0	8	1P360-2500-XA	1620	25.0	153.0

Tuumakoko

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.125	1/8	.500	.004	45°	.500	4	1P360-0318-XA	1620	.125	2.000
.188	3/16	.750	.004	45°	.750	4	1P360-0476-XA	1620	.187	2.500
.250	1/4	.875	.004	45°	.875	4	1P360-0635-XA	1620	.250	2.500
.375	3/8	1.219	.004	45°	1.219	4	1P360-0953-XA	1620	.375	4.000
.500	1/2	1.687	.006	45°	1.687	4	1P360-1270-XA	1620	.500	4.000
.625	5/8	2.000	.006	45°	2.000	5	1P360-1588-XA	1620	.625	5.000
.750	3/4	2.344	.006	45°	2.344	5	1P360-1905-XA	1620	.750	5.000
1.000	1	3.609	.010	45°	3.609	8	1P360-2540-XA	1620	1.000	7.000

E3 E7 E45 E36 E58 E50

CoroMill® Plura, täyskovametallinen varsijyrsin rouhintaan lastunmurtajalla

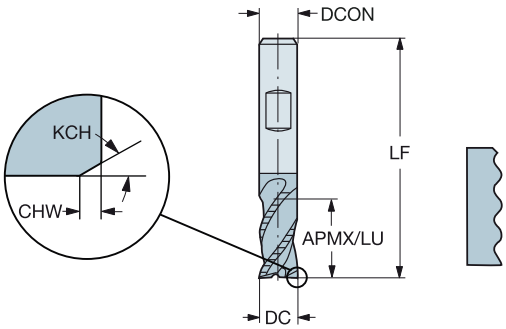


FIN

CoroMill® Plura, täyskovametallinen varsijyrsin rouhintaan lastunmurtajalla

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	37°
BSG	DIN 6527 L
TCDC	h12
TCDCON	h6

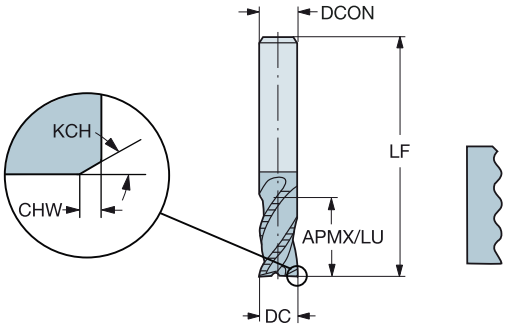


P M K S

Metrinen

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
6.0	6	13.0	0.35	35°	13.0	4	1P340-0600-XB	1640	6.0	57.0
8.0	8	19.0	0.45	35°	19.0	4	1P340-0800-XB	1640	8.0	63.0
10.0	10	22.0	0.50	35°	22.0	4	1P340-1000-XB	1640	10.0	72.0
12.0	12	26.0	0.50	35°	26.0	4	1P340-1200-XB	1640	12.0	83.0
14.0	14	26.0	0.50	35°	26.0	4	1P340-1400-XB	1640	14.0	83.0
16.0	16	32.0	0.55	35°	32.0	4	1P340-1600-XB	1640	16.0	92.0
18.0	18	32.0	0.50	35°	32.0	4	1P340-1800-XB	1640	18.0	92.0
20.0	20	38.0	0.63	35°	38.0	4	1P340-2000-XB	1640	20.0	104.0

FHA	37°
BSG	Internal
TCDC	h12
TCDCON	h6



P M K S

Tuumakoko

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.250	1/4	.531	.014	35°	.531	4	1P340-0635-XA	1640	.250	2.500
.375	3/8	.844	.018	35°	.844	4	1P340-0953-XA	1640	.375	3.000
.500	1/2	1.094	.020	35°	1.094	4	1P340-1270-XA	1640	.500	3.500
.625	5/8	1.313	.020	35°	1.313	4	1P340-1588-XA	1640	.625	4.000
.750	3/4	1.563	.022	35°	1.563	4	1P340-1905-XA	1640	.750	4.000
1.000	1	2.094	.031	35°	2.094	4	1P340-2540-XA	1640	1.000	5.000

E3 E7 E45 E36 E58 E50

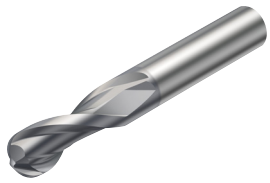
CoroMill® Plura, täyskovametallinen sädevarsijyrsin muotojyrsintään

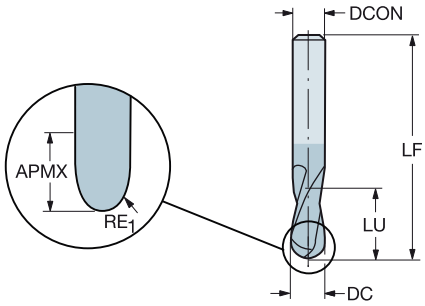
FIN

CoroMill® Plura, täyskovametallinen sädevarsijyrsin muotojyrsintään

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	COROMANT
TCDC	h7
TCDCON	h5
PSIR	0°





P M K N S

Metrinen

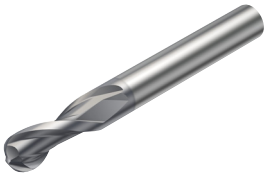
DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	**Tilauskoodi**	GRADE	Mitat, mm DCON	LF
1.0	3	3.0	0.50	3.0	2	**1B230-0100-XA**	1630	3.0	38.0
1.5	3	3.0	0.75	3.0	2	**1B230-0150-XA**	1630	3.0	38.0
2.0	3	6.0	1.00	6.0	2	**1B230-0200-XA**	1630	3.0	38.0
2.5	3	7.0	1.25	7.0	2	**1B230-0250-XA**	1630	3.0	38.0
3.0	3	7.0	1.50	7.0	2	**1B230-0300-XA**	1630	3.0	38.0
4.0	6	8.0	2.00	8.0	2	**1B230-0400-XA**	1630	6.0	57.0
5.0	6	10.0	2.50	10.0	2	**1B230-0500-XA**	1630	6.0	57.0
6.0	6	10.0	3.00	10.0	2	**1B230-0600-XA**	1630	6.0	57.0
7.0	8	13.0	3.50	13.0	2	**1B230-0700-XA**	1630	8.0	63.0
8.0	8	16.0	4.00	16.0	2	**1B230-0800-XA**	1630	8.0	63.0
9.0	10	16.0	4.50	16.0	2	**1B230-0900-XA**	1630	10.0	72.0
10.0	10	19.0	5.00	19.0	2	**1B230-1000-XA**	1630	10.0	72.0
12.0	12	22.0	6.00	22.0	2	**1B230-1200-XA**	1630	12.0	83.0
14.0	14	22.0	7.00	22.0	2	**1B230-1400-XA**	1630	14.0	83.0
16.0	16	26.0	8.00	26.0	2	**1B230-1600-XA**	1630	16.0	92.0
18.0	18	26.0	9.00	26.0	2	**1B230-1800-XA**	1630	18.0	92.0
20.0	20	32.0	10.00	32.0	2	**1B230-2000-XA**	1630	20.0	104.0

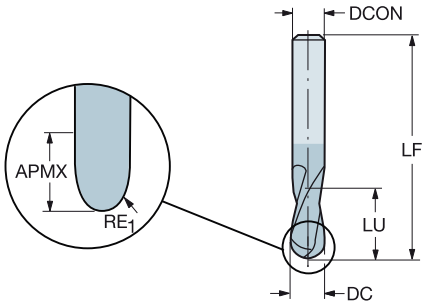
E3 E7 E45 E36 E58 E50

CoroMill® Plura, täyskovametallinen sädevarsijyrsin muotojyrsintään

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6
PSIR	0°





P M K N S

Tuumakoko

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.063	1/4	.125	.031	.125	2	1B231-0159-XA	1620	.250	3.000
.094	1/4	.188	.047	.188	2	1B231-0238-XA	1620	.250	3.000
.125	1/4	.250	.063	.250	2	1B231-0318-XA	1620	.250	3.000
.156	1/4	.313	.078	.313	2	1B231-0397-XA	1620	.250	3.000
.187	1/4	.375	.094	.375	2	1B231-0476-XA	1620	.250	3.000
.250	1/4	.500	.125	.500	2	1B231-0635-XA	1620	.250	3.000
.313	3/8	.625	.156	.625	2	1B231-0794-XA	1620	.375	3.500
.375	3/8	.750	.188	.750	2	1B231-0953-XA	1620	.375	3.500
.500	1/2	1.000	.250	1.000	2	1B231-1270-XA	1620	.500	4.000

Tuumakoko

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	DCX	LF
.063	1/4	.125	.031	.125	2	1B232-0159-XA	1620	.250		2.000
.094	1/4	.188	.047	.188	2	1B232-0238-XA	1620	.250		2.000
.125	1/4	.250	.063	.250	2	1B232-0318-XA	1620	.250		2.000
.156	1/4	.313	.078	.313	2	1B232-0397-XA	1620	.250		2.000
.187	1/4	.375	.094	.375	2	1B232-0476-XA	1620	.250		2.000
.250	1/4	.500	.125	.500	2	1B232-0635-XA	1620	.250		2.000
.313	3/8	.625	.156	.625	2	1B232-0794-XA	1620	.375		2.500
.375	3/8	.750	.188	.750	2	1B232-0953-XA	1620	.375		2.500
.500	1/2	1.000	.250	1.000	2	1B232-1270-XA	1620	.500		3.000
.625	5/8	1.250	.313	1.250	2	1B232-1588-XA	1620	.625	.625	3.500
.750	3/4	1.500	.375	1.500	2	1B232-1905-XA	1620	.750	.750	4.000

E3 E7 E45 E36 E58 E50

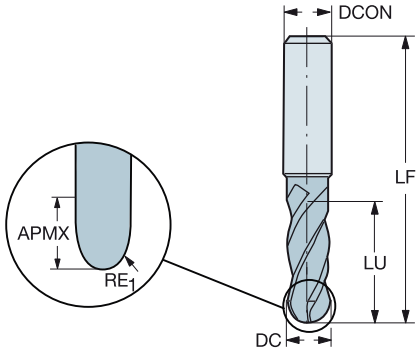
SANDVIK Coromant

FIN

CoroMill® Plura, täyskovametallinen sädevarsijyrsin muotojyrsintään

Eri materiaaleille, kovuus ≤ 48 HRc

FHA	30°
BSG	COROMANT
TCDC	h8
TCDCON	h6
PSIR	0°



P M K N S

Metrinen

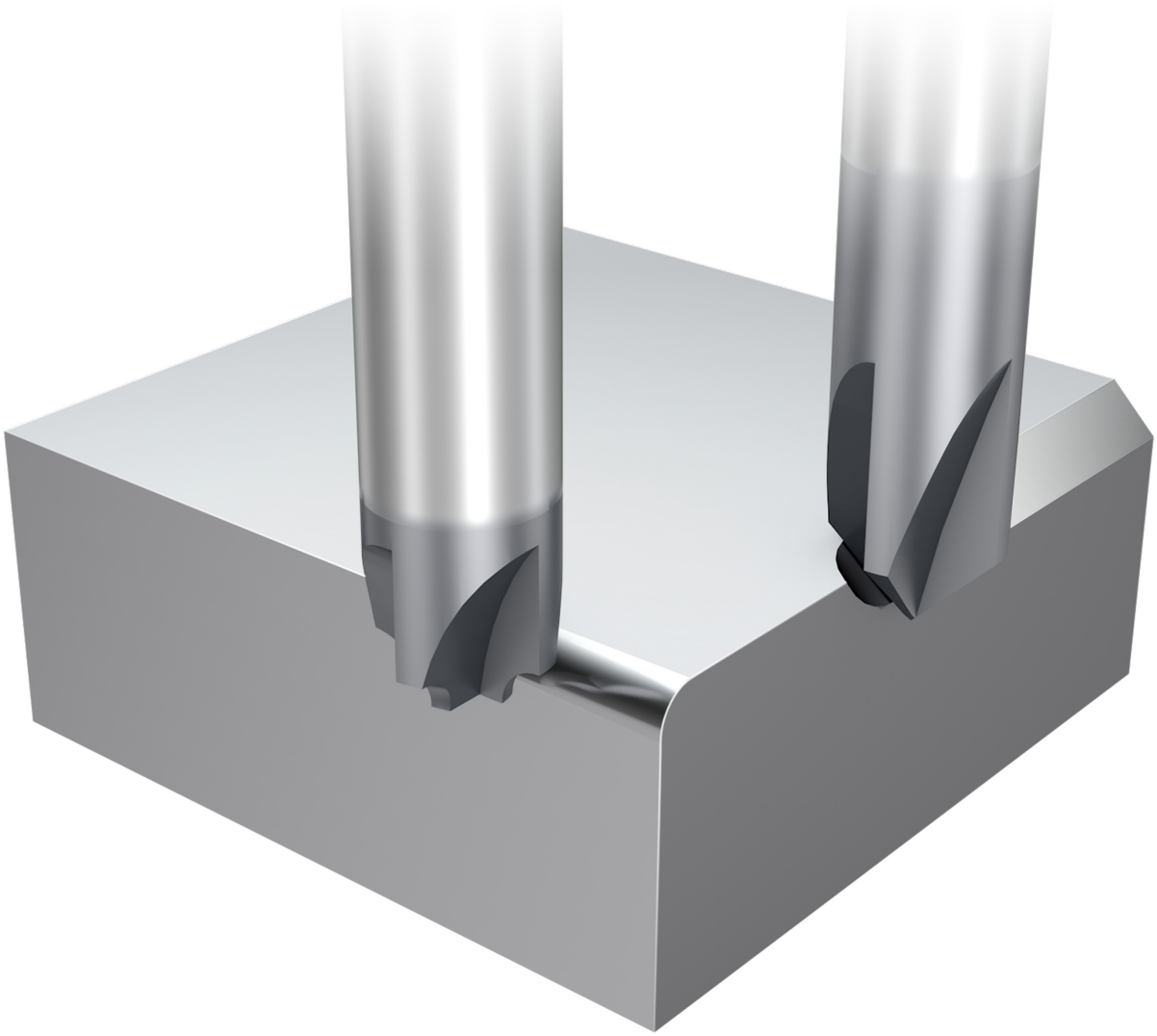
DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DCON	LF
3.0	6	8.0	1.50	8.0	4	1B240-0300-XA	1630	6.0	80.0
4.0	6	11.0	2.00	11.0	4	1B240-0400-XA	1630	6.0	80.0
5.0	6	13.0	2.50	13.0	4	1B240-0500-XA	1630	6.0	80.0
6.0	6	13.0	3.00	13.0	4	1B240-0600-XA	1630	6.0	80.0
7.0	8	16.0	3.50	16.0	4	1B240-0700-XA	1630	8.0	100.0
8.0	8	19.0	4.00	19.0	4	1B240-0800-XA	1630	8.0	100.0
10.0	10	22.0	5.00	22.0	4	1B240-1000-XA	1630	10.0	100.0
12.0	12	26.0	6.00	26.0	4	1B240-1200-XA	1630	12.0	100.0
16.0	16	32.0	8.00	32.0	4	1B240-1600-XA	1630	16.0	100.0
20.0	20	38.0	10.00	38.0	4	1B240-2000-XA	1630	20.0	125.0

Tuumakoko

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	LF
.063	1/4	.125	.031	.125	4	1B240-0159-XA	1630	.250	3.000
.094	1/4	.188	.047	.188	4	1B240-0238-XA	1630	.250	3.000
.125	1/4	.250	.063	.250	4	1B240-0318-XA	1630	.250	3.000
.156	1/4	.313	.078	.313	4	1B240-0397-XA	1630	.250	3.000
.187	1/4	.375	.094	.375	4	1B240-0476-XA	1630	.250	3.000
.250	1/4	.500	.125	.500	4	1B240-0635-XA	1630	.250	3.000
.313	3/8	.625	.156	.625	4	1B240-0794-XA	1630	.375	3.500
.375	3/8	.750	.188	.750	4	1B240-0953-XA	1630	.375	3.500
.500	1/2	1.000	.250	1.000	4	1B240-1270-XA	1630	.500	4.000

E3 E7 E45 E36 E58 E50

CoroMill® Plura, täyskovametallinen varsijyrsin viisteiden ja kulmapyöristysten jyrsintään

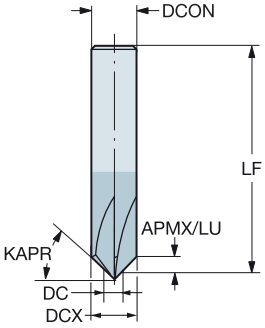


FIN

CoroMill® Plura, täyskovametallinen varsijyrsin viisteiden ja kulmapyöristysten jyrsintään

Eri materiaaleille, kovuus ≤ 48 HRc

TCDCON h6

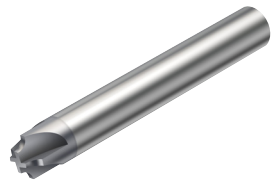


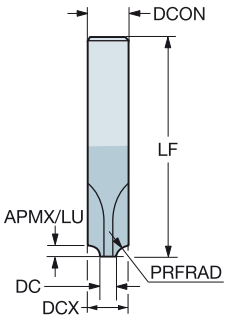
P M K N S H

Metrinen

KAPR	CZC_{MS}	APMX	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DC	DCX	DCON	LF	RPMX
45°	6.0	2.50	2.50	4	1C050-0100-045-XA	1620	1.00	6.0	6.0	56.50	80000
45°	8.0	3.00	3.00	5	1C050-0200-045-XA	1620	2.00	8.0	8.0	79.00	80000
45°	10.0	4.25	4.25	4	1C050-0150-045-XA	1620	1.50	10.0	10.0	99.20	80000
45°	12.0	4.50	4.50	6	1C050-0300-045-XA	1620	3.00	12.0	12.0	81.50	80000
60°	10.0	7.35	7.35	4	1C050-0150-060-XA	1620	1.50	10.0	10.0	98.70	80000

TCDCON h6





P M K N S H

Metrinen

PRFRAD	CZC_{MS}	APMX	LU	ZEFP	Tilauskoodi	GRADE	Mitat, mm DC	DCX	DCON	LF	RPMX
0.5	6.0	0.50	0.50	3	1U000-0400-050-XA	1620	4.00	6.0	6.0	57.00	80000
0.8		0.75	0.75	3	1U000-0400-075-XA	1620	4.00	6.0	6.0	57.00	80000
1.0	8.0	1.00	1.00	4	1U000-0400-100-XA	1620	4.00	8.0	8.0	63.00	80000
1.5		1.50	1.50	4	1U000-0400-150-XA	1620	4.00	8.0	8.0	63.00	80000
2.0	10.0	2.00	2.00	4	1U000-0500-200-XA	1620	5.00	10.0	10.0	72.00	80000
2.5		2.50	2.50	4	1U000-0500-250-XA	1620	5.00	10.0	10.0	72.00	80000
3.0	12.0	3.00	3.00	4	1U000-0500-300-XA	1620	5.00	12.0	12.0	83.00	80000
4.0	14.0	4.00	4.00	4	1U000-0600-400-XA	1620	6.00	14.0	14.0	83.00	80000
5.0	16.0	5.00	5.00	4	1U000-0600-500-XA	1620	6.00	16.0	16.0	92.00	80000
6.0	20.0	6.00	6.00	4	1U000-0800-600-XA	1620	8.00	20.0	20.0	104.00	80000

Tuumakoko

PRFRAD	CZC_{MS}	APMX	LU	ZEFP	Tilauskoodi	GRADE	Mitat, tuumaa DCON	DC	DCX	LF	RPMX
.031	1/8	.031	.031	2	1U000-0119-079-XA	1620	.125	.047	.125	1.500	80000
.062	1/4	.062	.062	3	1U000-0160-158-XA	1620	.250	.063	.250	2.000	80000
.094	3/8	.094	.094	3	1U000-0160-238-XA	1620	.375	.063	.313	2.500	80000
.125	1/2	.125	.125	4	1U000-0630-318-XA	1620	.500	.248	.500	3.000	48300
.188	5/8	.188	.188	4	1U000-0630-476-XA	1620	.625	.248	.625	3.500	25100

E3 E7 E45 E36 E58 E50

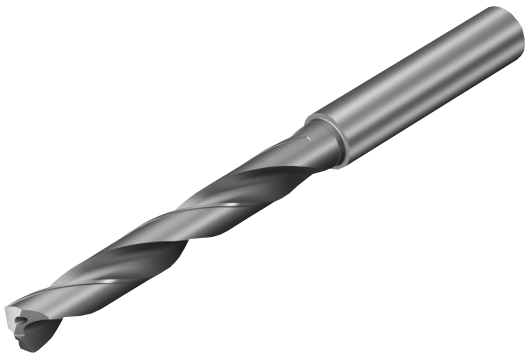
Poraus

CoroDrill® 460

Monikäyttöiset ja suorituskykyiset täyskovametalliporat

Käyttöalue

- Kaikille teollisuuden aloille, esim. yleiskoneistus, muotinvalmistus, auto- ja energiateollisuus
- Sisä- ja ulkopuolinen lastuamisnesteen syöttö



ISO-käyttöalueet:

P M K N S H

Ominaisuuksia ja etuja

- Hyvä tuottavuus ja ennakoitava kestoikä
- Hyvä hinta-laatu suhde
- Hyvä reiän laatu
- Alhaiset työkalukustannukset
- Voidaan kunnostaa uudenveroiseksi kolme kertaa
- 20 Bar nestepaine

Tuotevalikoima

Poramalli	Halkaisija	Syvyys	Lastuamisnesteen syöttö
Lieriö	3.00 - 20.00 mm (.118 - .787) inch	3xD & 5xD	Lastuamisnesteen syöttö & umpi
Lieriö	3.00 - 20.00 mm (.118 - .787) inch	8xD	Lastuamisnesteen syöttö
Porras- ja viistepora	3.35 - 17.50 mm .132 - .689 (inch)	3xD	Lastuamisnesteen syöttö

www.sandvik.coromant.com/corodrill460

Suosituksia

Käytä CoroChuck 930 istukoita ylläpitämään tuotannon tehokkuutta nopean työkalu-asetuksen ja vaihdon avulla. Istukka tarjoaa hyvän reiän pinnan, vähentää työkalun radiaalista heittoa ja lisää työkalun kestoikää.
Käytä sisäpuolista nestettä optimoimaan lastuamisen tehokkuutta ja lastunhallintaa, näin parannat tuottavuutta.

C

Räätälöidyt ratkaisut, sivu E36

Istukat – ks. Pyörivät työkalut -luettelo.

E50

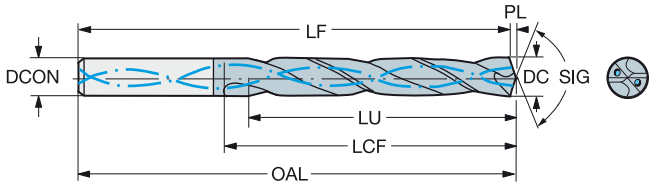
FIN

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
3.00	.118	9.4	.370	3	6	460.1-0300-009A1-XM	GC34	6.00	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	DIN 6537 K
3.00	.118	15.4	.606	5	6	460.1-0300-015A1-XM	GC34	6.00	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L
3.00	.118	24.4	.961	8	6	460.1-0300-023A1-XM	GC34	6.00	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016	COROMANT
3.05	.120	15.7	.618	5	6	460.1-0305-015A1-XM	GC34	6.00	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L
3.10	.122	9.7	.382	3	6	460.1-0310-009A1-XM	GC34	6.00	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	DIN 6537 K
3.10	.122	15.9	.626	5	6	460.1-0310-016A1-XM	GC34	6.00	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L
3.10	.122	25.2	.992	8	6	460.1-0310-023A1-XM	GC34	6.00	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016	COROMANT
3.15	.124	16.2	.638	5	6	460.1-0315-016A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.18	.125	10.0	.394	3	6	460.1-0318-010A1-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.18	.125	16.3	.642	5	6	460.1-0318-016A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.18	.125	25.9	1.020	8	6	460.1-0318-024A1-XM	GC34	6.00	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	COROMANT
3.20	.126	10.1	.398	3	6	460.1-0320-010A1-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.20	.126	16.5	.650	5	6	460.1-0320-016A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.20	.126	26.1	1.028	8	6	460.1-0320-024A1-XM	GC34	6.00	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	COROMANT
3.26	.128	16.8	.661	5	6	460.1-0326-016A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.30	.130	10.4	.409	3	6	460.1-0330-010A1-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.30	.130	17.0	.669	5	6	460.1-0330-017A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.30	.130	26.9	1.059	8	6	460.1-0330-025A1-XM	GC34	6.00	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	COROMANT
3.35	.132	17.2	.677	5	6	460.1-0335-017A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.38	.133	17.4	.685	5	6	460.1-0338-017A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.40	.134	10.7	.421	3	6	460.1-0340-010A1-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.40	.134	17.5	.689	5	6	460.1-0340-017A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.40	.134	27.7	1.091	8	6	460.1-0340-026A1-XM	GC34	6.00	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	COROMANT
3.45	.136	17.7	.697	5	6	460.1-0345-017A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.50	.138	11.0	.433	3	6	460.1-0350-011A1-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.50	.138	18.0	.709	5	6	460.1-0350-018A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.50	.138	28.5	1.122	8	6	460.1-0350-026A1-XM	GC34	6.00	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	COROMANT
3.57	.141	11.2	.441	3	6	460.1-0357-011A1-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.57	.141	18.4	.724	5	6	460.1-0357-018A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.57	.141	29.1	1.146	8	6	460.1-0357-027A1-XM	GC34	6.00	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	COROMANT
3.60	.142	11.3	.445	3	6	460.1-0360-011A1-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.60	.142	18.5	.728	5	6	460.1-0360-018A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.66	.144	18.8	.740	5	6	460.1-0366-018A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.70	.146	11.6	.457	3	6	460.1-0370-011A1-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.70	.146	19.0	.748	5	6	460.1-0370-019A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.70	.146	28.9	1.138	7	6	460.1-0370-028A1-XM	GC34	6.00	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	COROMANT
3.73	.147	19.2	.756	5	6	460.1-0373-019A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.80	.150	11.9	.469	3	6	460.1-0380-011A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	DIN 6537 K
3.80	.150	19.5	.768	5	6	460.1-0380-019A1-XM	GC34	6.00	.236	74	2.913	73.5	2.894	36	1.417	0.5	.020	DIN 6537 L
3.80	.150	30.9	1.217	8	6	460.1-0380-029A1-XM	GC34	6.00	.236	90	3.543	89.5	3.524	48	1.890	0.5	.020	COROMANT
3.86	.152	19.9	.783	5	6	460.1-0386-019A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
3.90	.154	12.3	.484	3	6	460.1-0390-012A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
3.90	.154	20.1	.791	5	6	460.1-0390-020A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
3.91	.154	20.1	.791	5	6	460.1-0391-020A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
3.97	.156	12.5	.492	3	6	460.1-0397-012A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
3.97	.156	20.4	.803	5	6	460.1-0397-020A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
3.97	.156	32.3	1.272	8	6	460.1-0397-030A1-XM	GC34	6.00	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	COROMANT
3.99	.157	20.5	.807	5	6	460.1-0399-020A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L

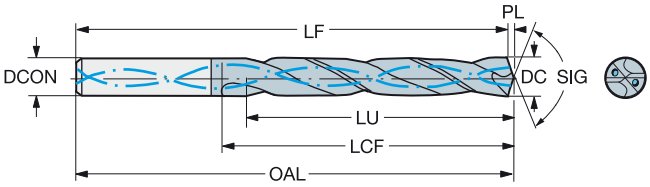
E8 E45 E36 E60 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	Mitat, mm, tuumaa DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
4.00	.157	12.6	.496	3	6	460.1-0400-012A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.00	.157	20.6	.811	5	6	460.1-0400-020A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.00	.157	32.6	1.283	8	6	460.1-0400-030A1-XM	GC34	6.00	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	COROMANT
4.04	.159	20.8	.819	5	6	460.1-0404-020A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.05	.159	12.7	.500	3	6	460.1-0405-012A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.05	.159	20.8	.819	5	6	460.1-0405-020A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.09	.161	21.0	.827	5	6	460.1-0409-020A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.10	.161	12.9	.508	3	6	460.1-0410-012A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.10	.161	21.1	.831	5	6	460.1-0410-021A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.10	.161	33.4	1.315	8	6	460.1-0410-031A1-XM	GC34	6.00	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	COROMANT
4.15	.163	21.4	.843	5	6	460.1-0415-021A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.20	.165	13.2	.520	3	6	460.1-0420-013A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.20	.165	21.6	.850	5	6	460.1-0420-021A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.20	.165	34.2	1.346	8	6	460.1-0420-032A1-XM	GC34	6.00	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	COROMANT
4.22	.166	21.7	.854	5	6	460.1-0422-021A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.25	.167	21.9	.862	5	6	460.1-0425-021A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.30	.169	13.5	.531	3	6	460.1-0430-013A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.30	.169	22.1	.870	5	6	460.1-0430-022A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.30	.169	35.0	1.378	8	6	460.1-0430-032A1-XM	GC34	6.00	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	COROMANT
4.31	.170	22.2	.874	5	6	460.1-0431-022A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.35	.171	22.4	.882	5	6	460.1-0435-022A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.37	.172	13.7	.539	3	6	460.1-0437-013A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.37	.172	22.5	.886	5	6	460.1-0437-022A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.37	.172	35.6	1.402	8	6	460.1-0437-033A1-XM	GC34	6.00	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	COROMANT
4.39	.173	22.6	.890	5	6	460.1-0439-022A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.40	.173	13.8	.543	3	6	460.1-0440-013A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.40	.173	22.6	.890	5	6	460.1-0440-022A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.45	.175	22.9	.902	5	6	460.1-0445-022A1-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.50	.177	14.2	.559	3	6	460.1-0450-014A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.50	.177	23.2	.913	5	6	460.1-0450-023A1-XM	GC34	6.00	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.50	.177	36.7	1.445	8	6	460.1-0450-034A1-XM	GC34	6.00	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	COROMANT
4.57	.180	23.5	.925	5	6	460.1-0457-023A1-XM	GC34	6.00	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.60	.181	14.5	.571	3	6	460.1-0460-014A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.60	.181	23.7	.933	5	6	460.1-0460-023A1-XM	GC34	6.00	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.60	.181	37.5	1.476	8	6	460.1-0460-035A1-XM	GC34	6.00	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	COROMANT
4.62	.182	23.8	.937	5	6	460.1-0462-023A1-XM	GC34	6.00	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.70	.185	14.6	.575	3	6	460.1-0470-014A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.70	.185	24.2	.953	5	6	460.1-0470-024A1-XM	GC34	6.00	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.70	.185	38.3	1.508	8	6	460.1-0470-035A1-XM	GC34	6.00	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	COROMANT
4.76	.187	15.0	.591	3	6	460.1-0476-014A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
4.76	.187	24.5	.965	5	6	460.1-0476-024A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
4.76	.187	38.8	1.528	8	6	460.1-0476-036A1-XM	GC34	6.00	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	COROMANT
4.80	.189	15.1	.594	3	6	460.1-0480-014A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
4.80	.189	24.7	.972	5	6	460.1-0480-024A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
4.80	.189	39.1	1.539	8	6	460.1-0480-036A1-XM	GC34	6.00	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	COROMANT
4.85	.191	25.0	.984	5	6	460.1-0485-024A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L

E8 E45 E36 E60 E50

SANDVIK Coromant

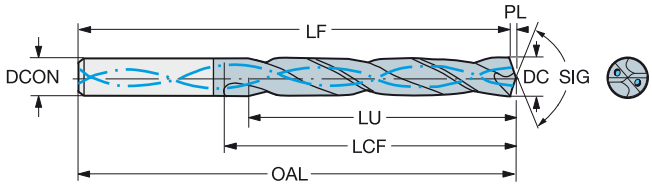
FIN

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
4.90	.193	15.4	.606	3	6	460.1-0490-015A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
4.90	.193	25.2	.992	5	6	460.1-0490-025A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
4.92	.194	25.3	.996	5	6	460.1-0492-025A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
4.98	.196	25.6	1.008	5	6	460.1-0498-025A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.00	.197	15.7	.618	3	6	460.1-0500-015A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
5.00	.197	25.7	1.012	5	6	460.1-0500-025A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.00	.197	40.7	1.602	8	6	460.1-0500-038A1-XM	GC34	6.00	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	COROMANT
5.05	.199	15.9	.626	3	6	460.1-0505-015A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
5.05	.199	26.0	1.024	5	6	460.1-0505-025A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.06	.199	26.0	1.024	5	6	460.1-0506-025A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.10	.201	16.0	.630	3	6	460.1-0510-015A1-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
5.10	.201	26.2	1.032	5	6	460.1-0510-026A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.10	.201	41.5	1.634	8	6	460.1-0510-038A1-XM	GC34	6.00	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	COROMANT
5.11	.201	26.3	1.035	5	6	460.1-0511-026A1-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.16	.203	16.2	.638	3	6	460.1-0516-016A1-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.16	.203	26.5	1.043	5	6	460.1-0516-026A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.16	.203	42.0	1.654	8	6	460.1-0516-039A1-XM	GC34	6.00	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	COROMANT
5.18	.204	26.7	1.051	5	6	460.1-0518-026A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.20	.205	16.4	.646	3	6	460.1-0520-016A1-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.20	.205	26.8	1.055	5	6	460.1-0520-026A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.20	.205	42.4	1.669	8	6	460.1-0520-039A1-XM	GC34	6.00	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	COROMANT
5.22	.206	26.9	1.059	5	6	460.1-0522-026A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.25	.207	27.0	1.063	5	6	460.1-0525-026A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.31	.209	27.3	1.075	5	6	460.1-0531-027A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.41	.213	27.8	1.094	5	6	460.1-0541-027A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.50	.217	17.3	.681	3	6	460.1-0550-017A1-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.50	.217	28.3	1.114	5	6	460.1-0550-028A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.50	.217	44.8	1.764	8	6	460.1-0550-041A1-XM	GC34	6.00	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	COROMANT
5.56	.219	17.5	.689	3	6	460.1-0556-017A1-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.56	.219	28.6	1.126	5	6	460.1-0556-028A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.56	.219	45.3	1.783	8	6	460.1-0556-042A1-XM	GC34	6.00	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	COROMANT
5.60	.220	17.6	.693	3	6	460.1-0560-017A1-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.60	.220	28.8	1.134	5	6	460.1-0560-028A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.61	.221	28.9	1.138	5	6	460.1-0561-028A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.65	.222	29.1	1.146	5	6	460.1-0565-028A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.70	.224	17.7	.697	3	6	460.1-0570-017A1-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.70	.224	29.3	1.154	5	6	460.1-0570-029A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.70	.224	46.4	1.827	8	6	460.1-0570-043A1-XM	GC34	6.00	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	COROMANT
5.75	.226	29.6	1.165	5	6	460.1-0575-029A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.79	.228	29.8	1.173	5	6	460.1-0579-029A1-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.80	.228	17.6	.693	3	6	460.1-0580-017A1-XM	GC34	6.00	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
5.80	.228	29.9	1.177	5	6	460.1-0580-029A1-XM	GC34	6.00	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
5.80	.228	47.3	1.862	8	6	460.1-0580-044A1-XM	GC34	6.00	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	COROMANT
5.90	.232	30.4	1.197	5	6	460.1-0590-030A1-XM	GC34	6.00	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
5.94	.234	30.6	1.205	5	6	460.1-0594-030A1-XM	GC34	6.00	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
5.95	.234	17.3	.681	2	6	460.1-0595-018A1-XM	GC34	6.00	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
5.95	.234	30.6	1.205	5	6	460.1-0595-030A1-XM	GC34	6.00	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
5.95	.234	48.5	1.909	8	6	460.1-0595-045A1-XM	GC34	6.00	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	COROMANT

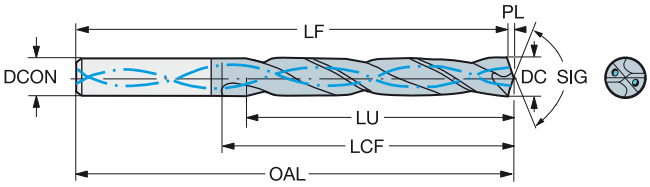
E8 E45 E36 E60 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
6.00	.236	18.9	.744	3	6	460.1-0600-018A1-XM	GC34	6.00	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
6.00	.236	30.9	1.217	5	6	460.1-0600-030A1-XM	GC34	6.00	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
6.00	.236	48.9	1.925	8	6	460.1-0600-045A1-XM	GC34	6.00	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	COROMANT
6.05	.238	19.0	.748	3	8	460.1-0605-018A1-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.05	.238	31.1	1.224	5	8	460.1-0605-030A1-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.10	.240	19.2	.756	3	8	460.1-0610-018A1-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.10	.240	31.4	1.236	5	8	460.1-0610-031A1-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.10	.240	49.7	1.957	8	8	460.1-0610-046A1-XM	GC34	8.00	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	COROMANT
6.15	.242	31.7	1.248	5	8	460.1-0615-031A1-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.20	.244	19.5	.768	3	8	460.1-0620-019A1-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.20	.244	31.9	1.256	5	8	460.1-0620-031A1-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.20	.244	50.5	1.988	8	8	460.1-0620-047A1-XM	GC34	8.00	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	COROMANT
6.25	.246	32.2	1.268	5	8	460.1-0625-031A1-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.30	.248	19.8	.780	3	8	460.1-0630-019A1-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.30	.248	32.4	1.276	5	8	460.1-0630-032A1-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.35	.250	20.0	.787	3	8	460.1-0635-019A1-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.35	.250	32.7	1.287	5	8	460.1-0635-032A1-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.35	.250	51.7	2.035	8	8	460.1-0635-048A1-XM	GC34	8.00	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	COROMANT
6.40	.252	20.1	.791	3	8	460.1-0640-019A1-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.40	.252	32.9	1.295	5	8	460.1-0640-032A1-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.50	.256	20.5	.807	3	8	460.1-0650-020A1-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.50	.256	33.5	1.319	5	8	460.1-0650-033A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.50	.256	53.0	2.087	8	8	460.1-0650-049A1-XM	GC34	8.00	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	COROMANT
6.53	.257	33.6	1.323	5	8	460.1-0653-033A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.60	.260	20.8	.819	3	8	460.1-0660-020A1-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.60	.260	34.0	1.339	5	8	460.1-0660-033A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.60	.260	53.8	2.118	8	8	460.1-0660-050A1-XM	GC34	8.00	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	COROMANT
6.63	.261	34.1	1.343	5	8	460.1-0663-033A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.70	.264	21.1	.831	3	8	460.1-0670-020A1-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.70	.264	34.5	1.358	5	8	460.1-0670-034A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.70	.264	54.6	2.150	8	8	460.1-0670-050A1-XM	GC34	8.00	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	COROMANT
6.75	.266	21.2	.835	3	8	460.1-0675-020A1-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.75	.266	34.7	1.366	5	8	460.1-0675-034A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.75	.266	55.0	2.165	8	8	460.1-0675-051A1-XM	GC34	8.00	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	COROMANT
6.76	.266	34.8	1.370	5	8	460.1-0676-034A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.80	.268	21.4	.843	3	8	460.1-0680-020A1-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.80	.268	35.0	1.378	5	8	460.1-0680-034A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.80	.268	55.4	2.181	8	8	460.1-0680-051A1-XM	GC34	8.00	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	COROMANT
6.85	.270	35.3	1.390	5	8	460.1-0685-034A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.90	.272	21.7	.854	3	8	460.1-0690-021A1-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.90	.272	35.5	1.398	5	8	460.1-0690-035A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.90	.272	56.2	2.213	8	8	460.1-0690-052A1-XM	GC34	8.00	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	COROMANT
6.91	.272	35.6	1.402	5	8	460.1-0691-035A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.00	.276	22.0	.866	3	8	460.1-0700-021A1-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
7.00	.276	36.0	1.417	5	8	460.1-0700-035A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.00	.276	57.0	2.244	8	8	460.1-0700-053A1-XM	GC34	8.00	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	COROMANT
7.04	.277	36.2	1.425	5	8	460.1-0704-035A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.10	.280	22.3	.878	3	8	460.1-0710-021A1-XM	GC34	8.00	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	DIN 6537 K

E8 E45 E36 E60 E50

SANDVIK Coromant

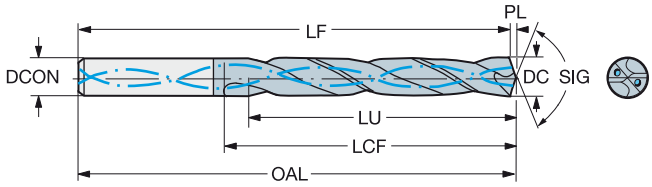
FIN

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

								Mitat, mm, tuumaa										
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
7.10	.280	36.5	1.437	5	8	460.1-0710-036A1-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.14	.281	22.5	.886	3	8	460.1-0714-021A1-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.14	.281	36.8	1.449	5	8	460.1-0714-036A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.14	.281	58.2	2.291	8	8	460.1-0714-054A1-XM	GC34	8.00	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	COROMANT
7.20	.283	37.1	1.461	5	8	460.1-0720-036A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.20	.283	58.7	2.311	8	8	460.1-0720-054A1-XM	GC34	8.00	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	COROMANT
7.25	.285	37.3	1.469	5	8	460.1-0725-036A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.30	.287	23.0	.906	3	8	460.1-0730-022A1-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.30	.287	37.6	1.480	5	8	460.1-0730-037A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.37	.290	37.9	1.492	5	8	460.1-0737-037A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.40	.291	23.3	.917	3	8	460.1-0740-022A1-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.40	.291	38.1	1.500	5	8	460.1-0740-037A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.40	.291	60.3	2.374	8	8	460.1-0740-056A1-XM	GC34	8.00	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	COROMANT
7.45	.293	38.3	1.508	5	8	460.1-0745-037A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.49	.295	38.6	1.520	5	8	460.1-0749-037A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.50	.295	23.6	.929	3	8	460.1-0750-023A1-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.50	.295	38.6	1.520	5	8	460.1-0750-038A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.50	.295	61.1	2.406	8	8	460.1-0750-056A1-XM	GC34	8.00	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	COROMANT
7.54	.297	23.7	.933	3	8	460.1-0754-023A1-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.54	.297	38.8	1.528	5	8	460.1-0754-038A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.54	.297	61.4	2.417	8	8	460.1-0754-057A1-XM	GC34	8.00	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	COROMANT
7.60	.299	23.9	.941	3	8	460.1-0760-023A1-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.60	.299	39.1	1.539	5	8	460.1-0760-038A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.60	.299	61.9	2.437	8	8	460.1-0760-057A1-XM	GC34	8.00	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	COROMANT
7.67	.302	39.5	1.555	5	8	460.1-0767-038A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.70	.303	24.2	.953	3	8	460.1-0770-023A1-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.70	.303	39.6	1.559	5	8	460.1-0770-039A1-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.70	.303	62.7	2.469	8	8	460.1-0770-058A1-XM	GC34	8.00	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	COROMANT
7.80	.307	24.6	.969	3	8	460.1-0780-023A1-XM	GC34	8.00	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.80	.307	40.2	1.583	5	8	460.1-0780-039A1-XM	GC34	8.00	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
7.80	.307	63.6	2.504	8	8	460.1-0780-059A1-XM	GC34	8.00	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	COROMANT
7.90	.311	24.9	.980	3	8	460.1-0790-024A1-XM	GC34	8.00	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.90	.311	40.7	1.602	5	8	460.1-0790-040A1-XM	GC34	8.00	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
7.94	.313	25.0	.984	3	8	460.1-0794-024A1-XM	GC34	8.00	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.94	.313	40.9	1.610	5	8	460.1-0794-040A1-XM	GC34	8.00	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
7.94	.313	64.7	2.547	8	8	460.1-0794-060A1-XM	GC34	8.00	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	COROMANT
8.00	.315	25.2	.992	3	8	460.1-0800-024A1-XM	GC34	8.00	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
8.00	.315	41.2	1.622	5	8	460.1-0800-040A1-XM	GC34	8.00	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
8.00	.315	65.2	2.567	8	8	460.1-0800-060A1-XM	GC34	8.00	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	COROMANT
8.03	.316	41.3	1.626	5	10	460.1-0803-040A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.05	.317	25.3	.996	3	10	460.1-0805-024A1-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.05	.317	41.4	1.630	5	10	460.1-0805-040A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.10	.319	25.5	1.004	3	10	460.1-0810-024A1-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.10	.319	41.7	1.642	5	10	460.1-0810-041A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.10	.319	66.0	2.598	8	10	460.1-0810-061A1-XM	GC34	10.00	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	COROMANT
8.15	.321	42.0	1.654	5	10	460.1-0815-041A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.20	.323	25.8	1.016	3	10	460.1-0820-025A1-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.20	.323	42.2	1.661	5	10	460.1-0820-041A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L

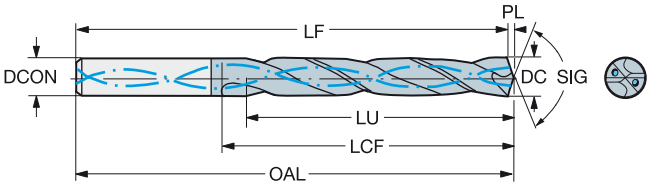
E8 E45 E36 E60 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
8.20	.323	66.8	2.630	8	10	460.1-0820-062A1-XM	GC34	10.00	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	COROMANT
8.25	.325	42.5	1.673	5	10	460.1-0825-041A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.30	.327	42.7	1.681	5	10	460.1-0830-042A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.33	.328	26.2	1.032	3	10	460.1-0833-025A1-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.33	.328	42.9	1.689	5	10	460.1-0833-042A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.33	.328	67.9	2.673	8	10	460.1-0833-062A1-XM	GC34	10.00	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	COROMANT
8.40	.331	26.4	1.039	3	10	460.1-0840-025A1-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.40	.331	43.2	1.701	5	10	460.1-0840-042A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.40	.331	68.4	2.693	8	10	460.1-0840-063A1-XM	GC34	10.00	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	COROMANT
8.43	.332	43.4	1.709	5	10	460.1-0843-042A1-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.50	.335	26.8	1.055	3	10	460.1-0850-026A1-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.50	.335	43.8	1.724	5	10	460.1-0850-043A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.50	.335	69.3	2.728	8	10	460.1-0850-064A1-XM	GC34	10.00	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	COROMANT
8.55	.337	44.0	1.732	5	10	460.1-0855-043A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.60	.339	27.1	1.067	3	10	460.1-0860-026A1-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.60	.339	44.3	1.744	5	10	460.1-0860-043A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.60	.339	70.1	2.760	8	10	460.1-0860-065A1-XM	GC34	10.00	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	COROMANT
8.61	.339	44.3	1.744	5	10	460.1-0861-043A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.65	.341	44.5	1.752	5	10	460.1-0865-043A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.70	.343	27.4	1.079	3	10	460.1-0870-026A1-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.70	.343	44.8	1.764	5	10	460.1-0870-044A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.70	.343	70.9	2.791	8	10	460.1-0870-065A1-XM	GC34	10.00	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	COROMANT
8.73	.344	27.5	1.083	3	10	460.1-0873-026A1-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.73	.344	44.9	1.768	5	10	460.1-0873-044A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.73	.344	71.1	2.799	8	10	460.1-0873-065A1-XM	GC34	10.00	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	COROMANT
8.80	.346	27.7	1.091	3	10	460.1-0880-026A1-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.80	.346	45.3	1.783	5	10	460.1-0880-044A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.80	.346	71.7	2.823	8	10	460.1-0880-066A1-XM	GC34	10.00	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	COROMANT
8.84	.348	45.5	1.791	5	10	460.1-0884-044A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.90	.350	28.0	1.102	3	10	460.1-0890-027A1-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.90	.350	45.8	1.803	5	10	460.1-0890-045A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.00	.354	28.3	1.114	3	10	460.1-0900-027A1-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
9.00	.354	46.3	1.823	5	10	460.1-0900-045A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.00	.354	73.3	2.886	8	10	460.1-0900-068A1-XM	GC34	10.00	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	COROMANT
9.05	.356	46.6	1.835	5	10	460.1-0905-045A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.09	.358	46.8	1.843	5	10	460.1-0909-045A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.10	.358	28.6	1.126	3	10	460.1-0910-027A1-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
9.10	.358	46.8	1.843	5	10	460.1-0910-046A1-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.13	.359	28.7	1.130	3	10	460.1-0913-027A1-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.13	.359	47.0	1.850	5	10	460.1-0913-046A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.13	.359	74.4	2.929	8	10	460.1-0913-068A1-XM	GC34	10.00	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	COROMANT
9.20	.362	47.4	1.866	5	10	460.1-0920-046A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.25	.364	47.6	1.874	5	10	460.1-0925-046A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.30	.366	29.3	1.154	3	10	460.1-0930-028A1-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.30	.366	47.9	1.886	5	10	460.1-0930-047A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.30	.366	75.8	2.984	8	10	460.1-0930-070A1-XM	GC34	10.00	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	COROMANT
9.35	.368	48.1	1.894	5	10	460.1-0935-047A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.40	.370	29.6	1.165	3	10	460.1-0940-028A1-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K

E8 E45 E36 E60 E50

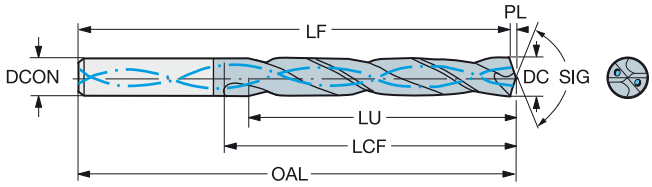
SANDVIK Coromant

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
9.40	.370	48.4	1.906	5	10	460.1-0940-047A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.50	.374	29.9	1.177	3	10	460.1-0950-029A1-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.50	.374	48.7	1.917	5	10	460.1-0950-048A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.50	.374	77.4	3.047	8	10	460.1-0950-071A1-XM	GC34	10.00	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	COROMANT
9.53	.375	30.0	1.181	3	10	460.1-0953-029A1-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.53	.375	48.6	1.913	5	10	460.1-0953-048A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.53	.375	77.6	3.055	8	10	460.1-0953-071A1-XM	GC34	10.00	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	COROMANT
9.58	.377	48.5	1.909	5	10	460.1-0958-048A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.60	.378	30.2	1.189	3	10	460.1-0960-029A1-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.60	.378	48.5	1.909	5	10	460.1-0960-048A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.65	.380	48.5	1.909	5	10	460.1-0965-048A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.70	.382	30.5	1.201	3	10	460.1-0970-029A1-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.70	.382	48.4	1.906	4	10	460.1-0970-049A1-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.80	.386	30.9	1.217	3	10	460.1-0980-029A1-XM	GC34	10.00	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
9.80	.386	48.3	1.902	4	10	460.1-0980-049A1-XM	GC34	10.00	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
9.80	.386	79.9	3.146	8	10	460.1-0980-074A1-XM	GC34	10.00	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	COROMANT
9.90	.390	31.2	1.228	3	10	460.1-0990-030A1-XM	GC34	10.00	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
9.90	.390	48.1	1.894	4	10	460.1-0990-050A1-XM	GC34	10.00	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
9.90	.390	80.7	3.177	8	10	460.1-0990-074A1-XM	GC34	10.00	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	COROMANT
9.92	.391	31.2	1.228	3	10	460.1-0992-030A1-XM	GC34	10.00	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
9.92	.391	48.1	1.894	4	10	460.1-0992-050A1-XM	GC34	10.00	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
9.92	.391	80.8	3.181	8	10	460.1-0992-074A1-XM	GC34	10.00	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	COROMANT
10.00	.394	31.5	1.240	3	10	460.1-1000-030A1-XM	GC34	10.00	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
10.00	.394	48.0	1.890	4	10	460.1-1000-050A1-XM	GC34	10.00	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
10.00	.394	81.5	3.209	8	10	460.1-1000-075A1-XM	GC34	10.00	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	COROMANT
10.05	.396	31.6	1.244	3	12	460.1-1005-030A1-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.05	.396	51.7	2.035	5	12	460.1-1005-050A1-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.08	.397	51.9	2.043	5	12	460.1-1008-050A1-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.10	.398	31.8	1.252	3	12	460.1-1010-030A1-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.10	.398	52.0	2.047	5	12	460.1-1010-051A1-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.20	.402	32.1	1.264	3	12	460.1-1020-031A1-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.20	.402	52.5	2.067	5	12	460.1-1020-051A1-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.20	.402	83.1	3.272	8	12	460.1-1020-077A1-XM	GC34	12.00	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	COROMANT
10.26	.404	52.8	2.079	5	12	460.1-1026-051A1-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.30	.406	32.4	1.276	3	12	460.1-1030-031A1-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.30	.406	53.0	2.087	5	12	460.1-1030-052A1-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.30	.406	83.9	3.303	8	12	460.1-1030-077A1-XM	GC34	12.00	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	COROMANT
10.32	.406	32.5	1.280	3	12	460.1-1032-031A1-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.32	.406	53.1	2.091	5	12	460.1-1032-052A1-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.32	.406	84.1	3.311	8	12	460.1-1032-077A1-XM	GC34	12.00	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	COROMANT
10.40	.409	32.7	1.287	3	12	460.1-1040-031A1-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.40	.409	53.5	2.106	5	12	460.1-1040-052A1-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.40	.409	84.7	3.335	8	12	460.1-1040-078A1-XM	GC34	12.00	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	COROMANT
10.45	.411	53.8	2.118	5	12	460.1-1045-052A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.49	.413	54.0	2.126	5	12	460.1-1049-052A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.50	.413	33.1	1.303	3	12	460.1-1050-032A1-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.50	.413	54.1	2.130	5	12	460.1-1050-053A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.50	.413	85.6	3.370	8	12	460.1-1050-079A1-XM	GC34	12.00	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	COROMANT

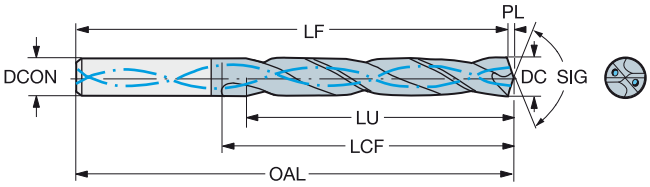
E8 E45 E36 E60 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	Mitat, mm, tuumaa DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
10.55	.415	54.3	2.138	5	12	460.1-1055-053A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.60	.417	33.4	1.315	3	12	460.1-1060-032A1-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.60	.417	54.6	2.150	5	12	460.1-1060-053A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.65	.419	54.8	2.157	5	12	460.1-1065-053A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.70	.421	55.1	2.169	5	12	460.1-1070-054A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.72	.422	33.7	1.327	3	12	460.1-1072-032A1-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.72	.422	55.2	2.173	5	12	460.1-1072-054A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.72	.422	87.3	3.437	8	12	460.1-1072-080A1-XM	GC34	12.00	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	COROMANT
10.75	.423	55.3	2.177	5	12	460.1-1075-054A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.90	.429	56.1	2.209	5	12	460.1-1090-055A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
11.00	.433	34.6	1.362	3	12	460.1-1100-033A1-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
11.00	.433	56.6	2.228	5	12	460.1-1100-055A1-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
11.00	.433	89.6	3.528	8	12	460.1-1100-083A1-XM	GC34	12.00	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	COROMANT
11.11	.437	35.0	1.378	3	12	460.1-1111-033A1-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.11	.437	57.2	2.252	5	12	460.1-1111-056A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.11	.437	90.5	3.563	8	12	460.1-1111-083A1-XM	GC34	12.00	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	COROMANT
11.20	.441	35.3	1.390	3	12	460.1-1120-034A1-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.20	.441	57.6	2.268	5	12	460.1-1120-056A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.20	.441	91.3	3.594	8	12	460.1-1120-084A1-XM	GC34	12.00	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	COROMANT
11.30	.445	57.4	2.260	5	12	460.1-1130-057A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.40	.449	35.9	1.413	3	12	460.1-1140-034A1-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.40	.449	57.3	2.256	5	12	460.1-1140-057A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.50	.453	36.2	1.425	3	12	460.1-1150-035A1-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.50	.453	57.2	2.252	4	12	460.1-1150-058A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.50	.453	93.7	3.689	8	12	460.1-1150-086A1-XM	GC34	12.00	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	COROMANT
11.51	.453	36.2	1.425	3	12	460.1-1151-035A1-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.51	.453	57.2	2.252	4	12	460.1-1151-058A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.51	.453	93.8	3.693	8	12	460.1-1151-086A1-XM	GC34	12.00	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	COROMANT
11.55	.455	57.1	2.248	4	12	460.1-1155-058A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.60	.457	36.5	1.437	3	12	460.1-1160-035A1-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.60	.457	57.1	2.248	4	12	460.1-1160-058A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.70	.461	57.0	2.244	4	12	460.1-1170-059A1-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.80	.465	37.2	1.465	3	12	460.1-1180-035A1-XM	GC34	12.00	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K
11.80	.465	56.8	2.236	4	12	460.1-1180-059A1-XM	GC34	12.00	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
11.80	.465	96.2	3.787	8	12	460.1-1180-089A1-XM	GC34	12.00	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	COROMANT
11.91	.469	37.5	1.476	3	12	460.1-1191-036A1-XM	GC34	12.00	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K
11.91	.469	56.7	2.232	4	12	460.1-1191-060A1-XM	GC34	12.00	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
11.91	.469	97.0	3.819	8	12	460.1-1191-089A1-XM	GC34	12.00	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	COROMANT
12.00	.472	37.8	1.488	3	12	460.1-1200-036A1-XM	GC34	12.00	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K
12.00	.472	56.6	2.228	4	12	460.1-1200-060A1-XM	GC34	12.00	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
12.00	.472	97.8	3.850	8	12	460.1-1200-090A1-XM	GC34	12.00	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	COROMANT
12.05	.474	37.9	1.492	3	14	460.1-1205-036A1-XM	GC34	14.00	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.05	.474	62.0	2.441	5	14	460.1-1205-060A1-XM	GC34	14.00	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.10	.476	38.1	1.500	3	14	460.1-1210-036A1-XM	GC34	14.00	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.20	.480	38.4	1.512	3	14	460.1-1220-037A1-XM	GC34	14.00	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.20	.480	62.4	2.457	5	14	460.1-1220-061A1-XM	GC34	14.00	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.20	.480	99.4	3.913	8	14	460.1-1220-092A1-XM	GC34	14.00	.551	202	7.953	200.2	7.882	151	5.945	1.8	.071	COROMANT
12.25	.482	62.3	2.453	5	14	460.1-1225-061A1-XM	GC34	14.00	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L

E8 E45 E36 E60 E50

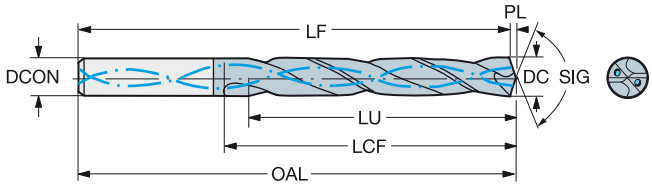
SANDVIK Coromant

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
12.30	.484	38.7	1.524	3	14	460.1-1230-037A1-XM	GC34	14.00	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.30	.484	62.2	2.449	5	14	460.1-1230-062A1-XM	GC34	14.00	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.30	.484	100.3	3.949	8	14	460.1-1230-092A1-XM	GC34	14.00	.551	202	7.953	200.2	7.882	151	5.945	1.8	.071	COROMANT
12.40	.488	62.1	2.445	5	14	460.1-1240-062A1-XM	GC34	14.00	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.50	.492	39.4	1.551	3	14	460.1-1250-038A1-XM	GC34	14.00	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.50	.492	62.0	2.441	4	14	460.1-1250-063A1-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.50	.492	101.9	4.012	8	14	460.1-1250-094A1-XM	GC34	14.00	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	COROMANT
12.60	.496	61.9	2.437	4	14	460.1-1260-063A1-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.70	.500	40.0	1.575	3	14	460.1-1270-038A1-XM	GC34	14.00	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.70	.500	61.8	2.433	4	14	460.1-1270-064A1-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.70	.500	103.5	4.075	8	14	460.1-1270-095A1-XM	GC34	14.00	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	COROMANT
12.75	.502	61.7	2.429	4	14	460.1-1275-064A1-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.80	.504	40.3	1.587	3	14	460.1-1280-038A1-XM	GC34	14.00	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.80	.504	61.6	2.425	4	14	460.1-1280-064A1-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.80	.504	104.3	4.106	8	14	460.1-1280-096A1-XM	GC34	14.00	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	COROMANT
12.90	.508	61.5	2.421	4	14	460.1-1290-065A1-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
13.00	.512	40.9	1.610	3	14	460.1-1300-039A1-XM	GC34	14.00	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
13.00	.512	61.4	2.417	4	14	460.1-1300-065A1-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
13.00	.512	105.9	4.169	8	14	460.1-1300-098A1-XM	GC34	14.00	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	COROMANT
13.10	.516	41.2	1.622	3	14	460.1-1310-039A1-XM	GC34	14.00	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.10	.516	61.3	2.413	4	14	460.1-1310-066A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.10	.516	106.7	4.201	8	14	460.1-1310-098A1-XM	GC34	14.00	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	COROMANT
13.25	.522	61.1	2.406	4	14	460.1-1325-066A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.30	.524	61.0	2.402	4	14	460.1-1330-067A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.40	.528	60.9	2.398	4	14	460.1-1340-067A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.49	.531	42.5	1.673	3	14	460.1-1349-041A1-XM	GC34	14.00	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.49	.531	60.8	2.394	4	14	460.1-1349-061A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.49	.531	110.0	4.331	8	14	460.1-1349-101A1-XM	GC34	14.00	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	COROMANT
13.50	.531	42.5	1.673	3	14	460.1-1350-041A1-XM	GC34	14.00	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.50	.531	60.8	2.394	4	14	460.1-1350-061A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.50	.531	110.0	4.331	8	14	460.1-1350-101A1-XM	GC34	14.00	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	COROMANT
13.55	.533	60.7	2.390	4	14	460.1-1355-061A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.65	.537	60.6	2.386	4	14	460.1-1365-061A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.70	.539	111.6	4.394	8	14	460.1-1370-103A1-XM	GC34	14.00	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	COROMANT
13.75	.541	60.5	2.382	4	14	460.1-1375-062A1-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.80	.543	43.4	1.709	3	14	460.1-1380-041A1-XM	GC34	14.00	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K
13.80	.543	60.4	2.378	4	14	460.1-1380-062A1-XM	GC34	14.00	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	DIN 6537 L
13.89	.547	43.3	1.705	3	14	460.1-1389-042A1-XM	GC34	14.00	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K
13.89	.547	60.3	2.374	4	14	460.1-1389-063A1-XM	GC34	14.00	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	DIN 6537 L
13.89	.547	113.2	4.457	8	14	460.1-1389-104A1-XM	GC34	14.00	.551	202	7.953	199.9	7.870	151	5.945	2.1	.083	COROMANT
14.00	.551	44.1	1.736	3	14	460.1-1400-042A1-XM	GC34	14.00	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K
14.00	.551	63.0	2.480	4	14	460.1-1400-063A1-XM	GC34	14.00	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	DIN 6537 L
14.00	.551	114.1	4.492	8	14	460.1-1400-105A1-XM	GC34	14.00	.551	202	7.953	199.9	7.870	151	5.945	2.1	.083	COROMANT
14.10	.555	68.9	2.713	4	16	460.1-1410-063A1-XM	GC34	16.00	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L
14.20	.559	115.7	4.555	8	16	460.1-1420-107A1-XM	GC34	16.00	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	COROMANT
14.25	.561	44.9	1.768	3	16	460.1-1425-043A1-XM	GC34	16.00	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	DIN 6537 K
14.25	.561	68.8	2.709	4	16	460.1-1425-071A1-XM	GC34	16.00	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L
14.25	.561	116.1	4.571	8	16	460.1-1425-107A1-XM	GC34	16.00	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	COROMANT

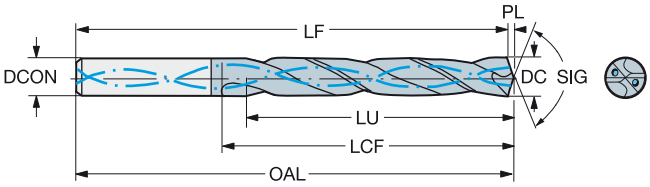
E8 E45 E36 E60 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	Mitat, mm, tuumaa DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
14.29	.563	45.0	1.772	3	16	460.1-1429-043A1-XM	GC34	16.00	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	DIN 6537 K
14.29	.563	68.7	2.705	4	16	460.1-1429-072A1-XM	GC34	16.00	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L
14.29	.563	116.4	4.583	8	16	460.1-1429-107A1-XM	GC34	16.00	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	COROMANT
14.30	.563	68.7	2.705	4	16	460.1-1430-072A1-XM	GC34	16.00	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L
14.50	.571	45.7	1.799	3	16	460.1-1450-044A1-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.50	.571	68.5	2.697	4	16	460.1-1450-073A1-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.50	.571	118.2	4.654	8	16	460.1-1450-109A1-XM	GC34	16.00	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	COROMANT
14.55	.573	68.5	2.697	4	16	460.1-1455-073A1-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.60	.575	68.4	2.693	4	16	460.1-1460-073A1-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.68	.578	46.2	1.819	3	16	460.1-1468-044A1-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.68	.578	68.3	2.689	4	16	460.1-1468-073A1-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.68	.578	119.7	4.713	8	16	460.1-1468-110A1-XM	GC34	16.00	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	COROMANT
14.70	.579	119.8	4.717	8	16	460.1-1470-110A1-XM	GC34	16.00	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	COROMANT
14.75	.581	68.3	2.689	4	16	460.1-1475-066A1-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.80	.583	46.6	1.835	3	16	460.1-1480-044A1-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.80	.583	68.2	2.685	4	16	460.1-1480-067A1-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
15.00	.591	47.2	1.858	3	16	460.1-1500-045A1-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
15.00	.591	68.0	2.677	4	16	460.1-1500-068A1-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
15.00	.591	122.2	4.811	8	16	460.1-1500-113A1-XM	GC34	16.00	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	COROMANT
15.08	.594	47.5	1.870	3	16	460.1-1508-045A1-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
15.08	.594	67.9	2.673	4	16	460.1-1508-068A1-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
15.08	.594	122.9	4.839	8	16	460.1-1508-113A1-XM	GC34	16.00	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	COROMANT
15.10	.594	47.6	1.874	3	16	460.1-1510-045A1-XM	GC34	16.00	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.10	.594	67.9	2.673	4	16	460.1-1510-068A1-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.10	.594	123.1	4.846	8	16	460.1-1510-113A1-XM	GC34	16.00	.630	227	8.937	224.7	8.846	172	6.772	2.3	.091	COROMANT
15.25	.600	67.8	2.669	4	16	460.1-1525-069A1-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.30	.602	67.7	2.665	4	16	460.1-1530-069A1-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.48	.609	48.7	1.917	3	16	460.1-1548-046A1-XM	GC34	16.00	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.48	.609	67.5	2.657	4	16	460.1-1548-070A1-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.48	.609	126.1	4.965	8	16	460.1-1548-116A1-XM	GC34	16.00	.630	227	8.937	224.7	8.846	172	6.772	2.3	.091	COROMANT
15.50	.610	48.8	1.921	3	16	460.1-1550-047A1-XM	GC34	16.00	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.50	.610	67.5	2.657	4	16	460.1-1550-070A1-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.50	.610	126.3	4.972	8	16	460.1-1550-116A1-XM	GC34	16.00	.630	227	8.937	224.7	8.846	172	6.772	2.3	.091	COROMANT
15.55	.612	67.5	2.657	4	16	460.1-1555-070A1-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.60	.614	67.4	2.654	4	16	460.1-1560-070A1-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.70	.618	127.9	5.035	8	16	460.1-1570-118A1-XM	GC34	16.00	.630	227	8.937	224.7	8.846	172	6.772	2.3	.091	COROMANT
15.80	.622	49.2	1.937	3	16	460.1-1580-047A1-XM	GC34	16.00	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
15.80	.622	67.2	2.646	4	16	460.1-1580-071A1-XM	GC34	16.00	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
15.88	.625	49.1	1.933	3	16	460.1-1588-048A1-XM	GC34	16.00	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
15.88	.625	67.1	2.642	4	16	460.1-1588-071A1-XM	GC34	16.00	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
15.88	.625	129.4	5.094	8	16	460.1-1588-119A1-XM	GC34	16.00	.630	227	8.937	224.6	8.843	172	6.772	2.4	.094	COROMANT
16.00	.630	49.0	1.929	3	16	460.1-1600-048A1-XM	GC34	16.00	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
16.00	.630	67.0	2.638	4	16	460.1-1600-072A1-XM	GC34	16.00	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
16.00	.630	130.4	5.134	8	16	460.1-1600-120A1-XM	GC34	16.00	.630	227	8.937	224.6	8.843	172	6.772	2.4	.094	COROMANT
16.08	.633	76.9	3.028	4	18	460.1-1608-072A1-XM	GC34	18.00	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	DIN 6537 L
16.10	.634	76.9	3.028	4	18	460.1-1610-072A1-XM	GC34	18.00	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	DIN 6537 L
16.27	.641	51.2	2.016	3	18	460.1-1627-049A1-XM	GC34	18.00	.709	123	4.843	120.6	4.748	73	2.874	2.4	.094	DIN 6537 K
16.27	.641	76.7	3.020	4	18	460.1-1627-081A1-XM	GC34	18.00	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	DIN 6537 L

E8 E45 E36 E60 E50

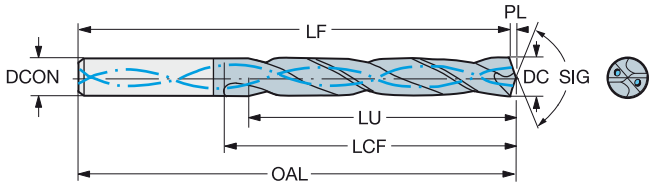
SANDVIK Coromant

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
16.30	.642	76.7	3.020	4	18	460.1-1630-073A1-XM	GC34	18.00	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	DIN 6537 L
16.50	.650	52.0	2.047	3	18	460.1-1650-050A1-XM	GC34	18.00	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
16.50	.650	76.5	3.012	4	18	460.1-1650-074A1-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
16.55	.652	76.5	3.012	4	18	460.1-1655-074A1-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
16.67	.656	52.5	2.067	3	18	460.1-1667-050A1-XM	GC34	18.00	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
16.67	.656	76.3	3.004	4	18	460.1-1667-075A1-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
16.75	.659	76.3	3.004	4	18	460.1-1675-075A1-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
16.80	.661	76.2	3.000	4	18	460.1-1680-076A1-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
16.90	.665	76.1	2.996	4	18	460.1-1690-076A1-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.00	.669	53.5	2.106	3	18	460.1-1700-051A1-XM	GC34	18.00	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
17.00	.669	76.0	2.992	4	18	460.1-1700-077A1-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.00	.669	138.5	5.453	8	18	460.1-1700-128A1-XM	GC34	18.00	.709	246	9.685	243.5	9.587	194	7.638	2.5	.098	COROMANT
17.07	.672	53.7	2.114	3	18	460.1-1707-051A1-XM	GC34	18.00	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
17.07	.672	75.9	2.988	4	18	460.1-1707-077A1-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.10	.673	75.9	2.988	4	18	460.1-1710-077A1-XM	GC34	18.00	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.30	.681	75.7	2.980	4	18	460.1-1730-078A1-XM	GC34	18.00	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.46	.687	55.0	2.165	3	18	460.1-1746-052A1-XM	GC34	18.00	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	DIN 6537 K
17.46	.687	75.5	2.972	4	18	460.1-1746-079A1-XM	GC34	18.00	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.50	.689	55.1	2.169	3	18	460.1-1750-053A1-XM	GC34	18.00	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	DIN 6537 K
17.50	.689	75.5	2.972	4	18	460.1-1750-079A1-XM	GC34	18.00	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.50	.689	142.6	5.614	8	18	460.1-1750-131A1-XM	GC34	18.00	.709	246	9.685	243.4	9.583	194	7.638	2.6	.102	COROMANT
17.55	.691	75.5	2.972	4	18	460.1-1755-079A1-XM	GC34	18.00	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.80	.701	75.2	2.961	4	18	460.1-1780-080A1-XM	GC34	18.00	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
17.86	.703	55.1	2.169	3	18	460.1-1786-054A1-XM	GC34	18.00	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
17.86	.703	75.1	2.957	4	18	460.1-1786-080A1-XM	GC34	18.00	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
17.90	.705	75.1	2.957	4	18	460.1-1790-081A1-XM	GC34	18.00	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
18.00	.709	56.7	2.232	3	18	460.1-1800-054A1-XM	GC34	18.00	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
18.00	.709	78.6	3.094	4	18	460.1-1800-081A1-XM	GC34	18.00	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
18.00	.709	146.7	5.776	8	18	460.1-1800-135A1-XM	GC34	18.00	.709	246	9.685	243.3	9.579	194	7.638	2.7	.106	COROMANT
18.26	.719	57.5	2.264	3	20	460.1-1826-055A1-XM	GC34	20.00	.787	131	5.157	128.3	5.051	79	3.110	2.7	.106	DIN 6537 K
18.26	.719	86.4	3.402	4	20	460.1-1826-082A1-XM	GC34	20.00	.787	153	6.024	150.3	5.917	101	3.976	2.7	.106	DIN 6537 L
18.35	.722	86.3	3.398	4	20	460.1-1835-083A1-XM	GC34	20.00	.787	153	6.024	150.3	5.917	101	3.976	2.7	.106	DIN 6537 L
18.50	.728	58.3	2.295	3	20	460.1-1850-056A1-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
18.50	.728	86.2	3.394	4	20	460.1-1850-083A1-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
18.50	.728	150.8	5.937	8	20	460.1-1850-139A1-XM	GC34	20.00	.787	269	10.591	266.2	10.480	215	8.465	2.8	.110	COROMANT
18.65	.734	58.7	2.311	3	20	460.1-1865-056A1-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
18.65	.734	86.1	3.390	4	20	460.1-1865-084A1-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
18.80	.740	59.2	2.331	3	20	460.1-1880-056A1-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
18.90	.744	85.9	3.382	4	20	460.1-1890-085A1-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
19.00	.748	59.8	2.354	3	20	460.1-1900-057A1-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
19.00	.748	85.8	3.378	4	20	460.1-1900-086A1-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
19.00	.748	154.8	6.094	8	20	460.1-1900-143A1-XM	GC34	20.00	.787	269	10.591	266.2	10.480	215	8.465	2.8	.110	COROMANT
19.05	.750	60.0	2.362	3	20	460.1-1905-057A1-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
19.05	.750	85.8	3.378	4	20	460.1-1905-086A1-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
19.25	.758	85.6	3.370	4	20	460.1-1925-087A1-XM	GC34	20.00	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	DIN 6537 L
19.30	.760	85.6	3.370	4	20	460.1-1930-087A1-XM	GC34	20.00	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	DIN 6537 L
19.50	.768	61.4	2.417	3	20	460.1-1950-059A1-XM	GC34	20.00	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	DIN 6537 K
19.50	.768	85.4	3.362	4	20	460.1-1950-088A1-XM	GC34	20.00	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	DIN 6537 L

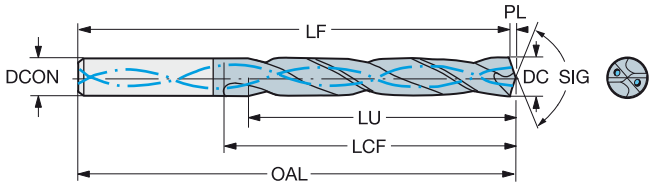
E8 E45 E36 E60 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
19.50	.768	158.9	6.256	8	20	460.1-1950-146A1-XM	GC34	20.00	.787	269	10.591	266.1	10.476	215	8.465	2.9	.114	COROMANT
19.55	.770	85.4	3.362	4	20	460.1-1955-088A1-XM	GC34	20.00	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	DIN 6537 L
19.80	.780	62.4	2.457	3	20	460.1-1980-059A1-XM	GC34	20.00	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	DIN 6537 K
19.80	.780	85.2	3.354	4	20	460.1-1980-089A1-XM	GC34	20.00	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	DIN 6537 L
20.00	.787	63.0	2.480	3	20	460.1-2000-060A1-XM	GC34	20.00	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	DIN 6537 K
20.00	.787	85.0	3.346	4	20	460.1-2000-090A1-XM	GC34	20.00	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	DIN 6537 L
20.00	.787	163.0	6.417	8	20	460.1-2000-150A1-XM	GC34	20.00	.787	269	10.591	266.0	10.472	215	8.465	3.0	.118	COROMANT

E8 E45 E36 E60 E50

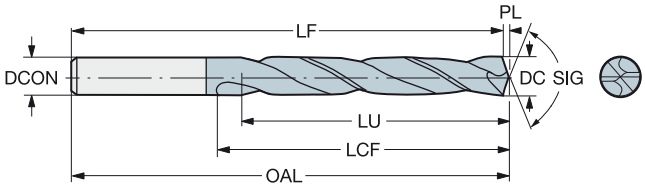
FIN

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Ulkopuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
3.00	.118	9.4	.370	3	6	460.1-0300-009A0-XM	GC34	6.00	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	DIN 6537 K
3.00	.118	15.4	.606	5	6	460.1-0300-015A0-XM	GC34	6.00	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L
3.10	.122	9.7	.382	3	6	460.1-0310-009A0-XM	GC34	6.00	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	DIN 6537 K
3.10	.122	15.9	.626	5	6	460.1-0310-016A0-XM	GC34	6.00	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L
3.18	.125	10.0	.394	3	6	460.1-0318-010A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.18	.125	16.3	.642	5	6	460.1-0318-016A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.20	.126	10.1	.398	3	6	460.1-0320-010A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.20	.126	16.5	.650	5	6	460.1-0320-016A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.30	.130	10.4	.409	3	6	460.1-0330-010A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.30	.130	17.0	.669	5	6	460.1-0330-017A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.40	.134	10.7	.421	3	6	460.1-0340-010A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.40	.134	17.5	.689	5	6	460.1-0340-017A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.50	.138	11.0	.433	3	6	460.1-0350-011A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.50	.138	18.0	.709	5	6	460.1-0350-018A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.57	.141	11.2	.441	3	6	460.1-0357-011A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.57	.141	18.4	.724	5	6	460.1-0357-018A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.60	.142	11.3	.445	3	6	460.1-0360-011A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.60	.142	18.5	.728	5	6	460.1-0360-018A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.70	.146	11.6	.457	3	6	460.1-0370-011A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.70	.146	19.0	.748	5	6	460.1-0370-019A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.73	.147	11.7	.461	3	6	460.1-0373-011A0-XM	GC34	6.00	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.80	.150	11.9	.469	3	6	460.1-0380-011A0-XM	GC34	6.00	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	DIN 6537 K
3.80	.150	19.5	.768	5	6	460.1-0380-019A0-XM	GC34	6.00	.236	74	2.913	73.5	2.894	36	1.417	0.5	.020	DIN 6537 L
3.90	.154	12.3	.484	3	6	460.1-0390-012A0-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
3.90	.154	20.1	.791	5	6	460.1-0390-020A0-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
3.97	.156	12.5	.492	3	6	460.1-0397-012A0-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
3.97	.156	20.4	.803	5	6	460.1-0397-020A0-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.00	.157	12.6	.496	3	6	460.1-0400-012A0-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.00	.157	20.6	.811	5	6	460.1-0400-020A0-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.10	.161	12.9	.508	3	6	460.1-0410-012A0-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.10	.161	21.1	.831	5	6	460.1-0410-021A0-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.20	.165	13.2	.520	3	6	460.1-0420-013A0-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.20	.165	21.6	.850	5	6	460.1-0420-021A0-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.30	.169	13.5	.531	3	6	460.1-0430-013A0-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.30	.169	22.1	.870	5	6	460.1-0430-022A0-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.37	.172	13.7	.539	3	6	460.1-0437-013A0-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.37	.172	22.5	.886	5	6	460.1-0437-022A0-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.40	.173	13.8	.543	3	6	460.1-0440-013A0-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.40	.173	22.6	.890	5	6	460.1-0440-022A0-XM	GC34	6.00	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.50	.177	14.2	.559	3	6	460.1-0450-014A0-XM	GC34	6.00	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.50	.177	23.2	.913	5	6	460.1-0450-023A0-XM	GC34	6.00	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.60	.181	14.5	.571	3	6	460.1-0460-014A0-XM	GC34	6.00	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.60	.181	23.7	.933	5	6	460.1-0460-023A0-XM	GC34	6.00	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.70	.185	14.6	.575	3	6	460.1-0470-014A0-XM	GC34	6.00	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.70	.185	24.2	.953	5	6	460.1-0470-024A0-XM	GC34	6.00	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.76	.187	15.0	.591	3	6	460.1-0476-014A0-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
4.76	.187	24.5	.965	5	6	460.1-0476-024A0-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
4.80	.189	15.1	.594	3	6	460.1-0480-014A0-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K

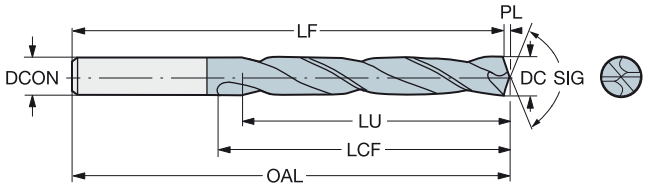
E14 E45 E36 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Ulkopuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
4.80	.189	24.7	.972	5	6	460.1-0480-024A0-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
4.90	.193	15.4	.606	3	6	460.1-0490-015A0-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
4.90	.193	25.2	.992	5	6	460.1-0490-025A0-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.00	.197	15.7	.618	3	6	460.1-0500-015A0-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
5.00	.197	25.7	1.012	5	6	460.1-0500-025A0-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.10	.201	16.0	.630	3	6	460.1-0510-015A0-XM	GC34	6.00	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
5.10	.201	26.2	1.032	5	6	460.1-0510-026A0-XM	GC34	6.00	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.16	.203	16.2	.638	3	6	460.1-0516-016A0-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.16	.203	26.5	1.043	5	6	460.1-0516-026A0-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.20	.205	16.4	.646	3	6	460.1-0520-016A0-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.20	.205	26.8	1.055	5	6	460.1-0520-026A0-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.50	.217	17.3	.681	3	6	460.1-0550-017A0-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.50	.217	28.3	1.114	5	6	460.1-0550-028A0-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.56	.219	17.5	.689	3	6	460.1-0556-017A0-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.56	.219	28.6	1.126	5	6	460.1-0556-028A0-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.60	.220	17.6	.693	3	6	460.1-0560-017A0-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.60	.220	28.8	1.134	5	6	460.1-0560-028A0-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.70	.224	17.7	.697	3	6	460.1-0570-017A0-XM	GC34	6.00	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.70	.224	29.3	1.154	5	6	460.1-0570-029A0-XM	GC34	6.00	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.80	.228	17.6	.693	3	6	460.1-0580-017A0-XM	GC34	6.00	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
5.80	.228	29.9	1.177	5	6	460.1-0580-029A0-XM	GC34	6.00	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
5.95	.234	17.3	.681	2	6	460.1-0595-018A0-XM	GC34	6.00	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
5.95	.234	30.6	1.205	5	6	460.1-0595-030A0-XM	GC34	6.00	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
6.00	.236	18.9	.744	3	6	460.1-0600-018A0-XM	GC34	6.00	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
6.00	.236	30.9	1.217	5	6	460.1-0600-030A0-XM	GC34	6.00	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
6.10	.240	19.2	.756	3	8	460.1-0610-018A0-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.10	.240	31.4	1.236	5	8	460.1-0610-031A0-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.20	.244	19.5	.768	3	8	460.1-0620-019A0-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.20	.244	31.9	1.256	5	8	460.1-0620-031A0-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.30	.248	19.8	.780	3	8	460.1-0630-019A0-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.30	.248	32.4	1.276	5	8	460.1-0630-032A0-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.35	.250	20.0	.787	3	8	460.1-0635-019A0-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.35	.250	32.7	1.287	5	8	460.1-0635-032A0-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.40	.252	20.1	.791	3	8	460.1-0640-019A0-XM	GC34	8.00	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.40	.252	32.9	1.295	5	8	460.1-0640-032A0-XM	GC34	8.00	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.50	.256	20.5	.807	3	8	460.1-0650-020A0-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.50	.256	33.5	1.319	5	8	460.1-0650-033A0-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.60	.260	20.8	.819	3	8	460.1-0660-020A0-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.60	.260	34.0	1.339	5	8	460.1-0660-033A0-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.70	.264	21.1	.831	3	8	460.1-0670-020A0-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.70	.264	34.5	1.358	5	8	460.1-0670-034A0-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.75	.266	21.2	.835	3	8	460.1-0675-020A0-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.75	.266	34.7	1.366	5	8	460.1-0675-034A0-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.80	.268	21.4	.843	3	8	460.1-0680-020A0-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.80	.268	35.0	1.378	5	8	460.1-0680-034A0-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.90	.272	21.7	.854	3	8	460.1-0690-021A0-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.90	.272	35.5	1.398	5	8	460.1-0690-035A0-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.00	.276	22.0	.866	3	8	460.1-0700-021A0-XM	GC34	8.00	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K

E14 E45 E36 E50

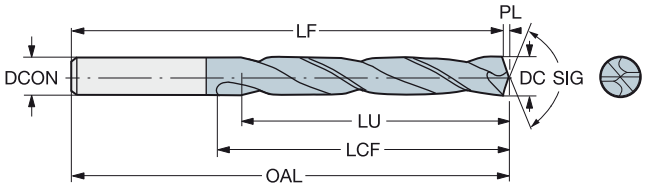
SANDVIK Coromant

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Ulkopuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
7.00	.276	36.0	1.417	5	8	460.1-0700-035A0-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.10	.280	22.3	.878	3	8	460.1-0710-021A0-XM	GC34	8.00	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	DIN 6537 K
7.10	.280	36.5	1.437	5	8	460.1-0710-036A0-XM	GC34	8.00	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.14	.281	22.5	.886	3	8	460.1-0714-021A0-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.14	.281	36.8	1.449	5	8	460.1-0714-036A0-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.30	.287	23.0	.906	3	8	460.1-0730-022A0-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.30	.287	37.6	1.480	5	8	460.1-0730-037A0-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.40	.291	23.3	.917	3	8	460.1-0740-022A0-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.40	.291	38.1	1.500	5	8	460.1-0740-037A0-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.50	.295	23.6	.929	3	8	460.1-0750-023A0-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.50	.295	38.6	1.520	5	8	460.1-0750-038A0-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.54	.297	23.7	.933	3	8	460.1-0754-023A0-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.54	.297	38.8	1.528	5	8	460.1-0754-038A0-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.60	.299	23.9	.941	3	8	460.1-0760-023A0-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.60	.299	39.1	1.539	5	8	460.1-0760-038A0-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.70	.303	24.2	.953	3	8	460.1-0770-023A0-XM	GC34	8.00	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.70	.303	39.6	1.559	5	8	460.1-0770-039A0-XM	GC34	8.00	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.80	.307	24.6	.969	3	8	460.1-0780-023A0-XM	GC34	8.00	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.80	.307	40.2	1.583	5	8	460.1-0780-039A0-XM	GC34	8.00	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
7.90	.311	24.9	.980	3	8	460.1-0790-024A0-XM	GC34	8.00	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.90	.311	40.7	1.602	5	8	460.1-0790-040A0-XM	GC34	8.00	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
7.94	.313	25.0	.984	3	8	460.1-0794-024A0-XM	GC34	8.00	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.94	.313	40.9	1.610	5	8	460.1-0794-040A0-XM	GC34	8.00	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
8.00	.315	25.2	.992	3	8	460.1-0800-024A0-XM	GC34	8.00	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
8.00	.315	41.2	1.622	5	8	460.1-0800-040A0-XM	GC34	8.00	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
8.10	.319	25.5	1.004	3	10	460.1-0810-024A0-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.10	.319	41.7	1.642	5	10	460.1-0810-041A0-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.20	.323	25.8	1.016	3	10	460.1-0820-025A0-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.20	.323	42.2	1.661	5	10	460.1-0820-041A0-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.33	.328	26.2	1.032	3	10	460.1-0833-025A0-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.33	.328	42.9	1.689	5	10	460.1-0833-042A0-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.40	.331	26.4	1.039	3	10	460.1-0840-025A0-XM	GC34	10.00	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.40	.331	43.2	1.701	5	10	460.1-0840-042A0-XM	GC34	10.00	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.50	.335	26.8	1.055	3	10	460.1-0850-026A0-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.50	.335	43.8	1.724	5	10	460.1-0850-043A0-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.60	.339	27.1	1.067	3	10	460.1-0860-026A0-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.60	.339	44.3	1.744	5	10	460.1-0860-043A0-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.70	.343	27.4	1.079	3	10	460.1-0870-026A0-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.70	.343	44.8	1.764	5	10	460.1-0870-044A0-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.73	.344	27.5	1.083	3	10	460.1-0873-026A0-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.73	.344	44.9	1.768	5	10	460.1-0873-044A0-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.80	.346	27.7	1.091	3	10	460.1-0880-026A0-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.80	.346	45.3	1.783	5	10	460.1-0880-044A0-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.90	.350	45.8	1.803	5	10	460.1-0890-045A0-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.00	.354	28.3	1.114	3	10	460.1-0900-027A0-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
9.00	.354	46.3	1.823	5	10	460.1-0900-045A0-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.10	.358	28.6	1.126	3	10	460.1-0910-027A0-XM	GC34	10.00	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
9.10	.358	46.8	1.843	5	10	460.1-0910-046A0-XM	GC34	10.00	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L

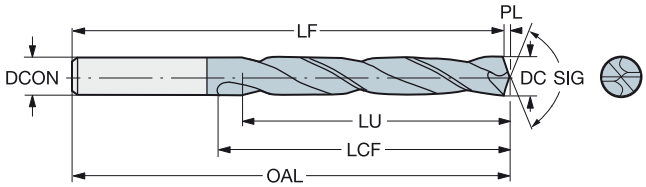
E14 E45 E36 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Ulkopuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

Mitat, mm, tuumaa

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
9.13	.359	28.7	1.130	3	10	460.1-0913-027A0-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.13	.359	47.0	1.850	5	10	460.1-0913-046A0-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.30	.366	29.3	1.154	3	10	460.1-0930-028A0-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.30	.366	47.9	1.886	5	10	460.1-0930-047A0-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.40	.370	29.6	1.165	3	10	460.1-0940-028A0-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.40	.370	48.4	1.906	5	10	460.1-0940-047A0-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.50	.374	29.9	1.177	3	10	460.1-0950-029A0-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.50	.374	48.7	1.917	5	10	460.1-0950-048A0-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.53	.375	30.0	1.181	3	10	460.1-0953-029A0-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.53	.375	48.6	1.913	5	10	460.1-0953-048A0-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.60	.378	30.2	1.189	3	10	460.1-0960-029A0-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.60	.378	48.5	1.909	5	10	460.1-0960-048A0-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.70	.382	30.5	1.201	3	10	460.1-0970-029A0-XM	GC34	10.00	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.70	.382	48.4	1.906	4	10	460.1-0970-049A0-XM	GC34	10.00	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.80	.386	30.9	1.217	3	10	460.1-0980-029A0-XM	GC34	10.00	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
9.80	.386	48.3	1.902	4	10	460.1-0980-049A0-XM	GC34	10.00	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
9.90	.390	31.2	1.228	3	10	460.1-0990-030A0-XM	GC34	10.00	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
9.90	.390	48.1	1.894	4	10	460.1-0990-050A0-XM	GC34	10.00	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
9.92	.391	31.2	1.228	3	10	460.1-0992-030A0-XM	GC34	10.00	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
9.92	.391	48.1	1.894	4	10	460.1-0992-050A0-XM	GC34	10.00	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
10.00	.394	31.5	1.240	3	10	460.1-1000-030A0-XM	GC34	10.00	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
10.00	.394	48.0	1.890	4	10	460.1-1000-050A0-XM	GC34	10.00	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
10.10	.398	31.8	1.252	3	12	460.1-1010-030A0-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.10	.398	52.0	2.047	5	12	460.1-1010-051A0-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.20	.402	32.1	1.264	3	12	460.1-1020-031A0-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.20	.402	52.5	2.067	5	12	460.1-1020-051A0-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.30	.406	32.4	1.276	3	12	460.1-1030-031A0-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.30	.406	53.0	2.087	5	12	460.1-1030-052A0-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.32	.406	32.5	1.280	3	12	460.1-1032-031A0-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.32	.406	53.1	2.091	5	12	460.1-1032-052A0-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.40	.409	32.7	1.287	3	12	460.1-1040-031A0-XM	GC34	12.00	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.40	.409	53.5	2.106	5	12	460.1-1040-052A0-XM	GC34	12.00	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.50	.413	33.1	1.303	3	12	460.1-1050-032A0-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.50	.413	54.1	2.130	5	12	460.1-1050-053A0-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.60	.417	33.4	1.315	3	12	460.1-1060-032A0-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.60	.417	54.6	2.150	5	12	460.1-1060-053A0-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.72	.422	33.7	1.327	3	12	460.1-1072-032A0-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.72	.422	55.2	2.173	5	12	460.1-1072-054A0-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.80	.425	34.0	1.339	3	12	460.1-1080-032A0-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
11.00	.433	34.6	1.362	3	12	460.1-1100-033A0-XM	GC34	12.00	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
11.00	.433	56.6	2.228	5	12	460.1-1100-055A0-XM	GC34	12.00	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
11.11	.437	35.0	1.378	3	12	460.1-1111-033A0-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.11	.437	57.2	2.252	5	12	460.1-1111-056A0-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.20	.441	35.3	1.390	3	12	460.1-1120-034A0-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.20	.441	57.6	2.268	5	12	460.1-1120-056A0-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.40	.449	35.9	1.413	3	12	460.1-1140-034A0-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.40	.449	57.3	2.256	5	12	460.1-1140-057A0-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.50	.453	36.2	1.425	3	12	460.1-1150-035A0-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K

E14 E45 E36 E50

SANDVIK Coromant

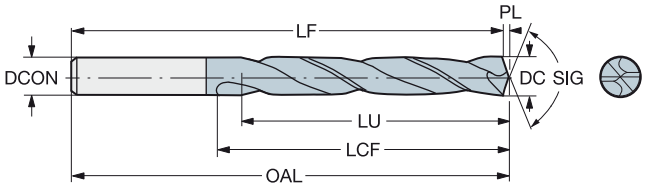
FIN

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Ulkopuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
11.50	.453	57.2	2.252	4	12	460.1-1150-058A0-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.51	.453	36.2	1.425	3	12	460.1-1151-035A0-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.51	.453	57.2	2.252	4	12	460.1-1151-058A0-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.60	.457	36.5	1.437	3	12	460.1-1160-035A0-XM	GC34	12.00	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.60	.457	57.1	2.248	4	12	460.1-1160-058A0-XM	GC34	12.00	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.80	.465	37.2	1.465	3	12	460.1-1180-035A0-XM	GC34	12.00	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K
11.80	.465	56.8	2.236	4	12	460.1-1180-059A0-XM	GC34	12.00	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
11.91	.469	37.5	1.476	3	12	460.1-1191-036A0-XM	GC34	12.00	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K
11.91	.469	56.7	2.232	4	12	460.1-1191-060A0-XM	GC34	12.00	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
12.00	.472	37.8	1.488	3	12	460.1-1200-036A0-XM	GC34	12.00	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K
12.00	.472	56.6	2.228	4	12	460.1-1200-060A0-XM	GC34	12.00	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
12.10	.476	38.1	1.500	3	14	460.1-1210-036A0-XM	GC34	14.00	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.10	.476	62.3	2.453	5	14	460.1-1210-061A0-XM	GC34	14.00	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.20	.480	38.4	1.512	3	14	460.1-1220-037A0-XM	GC34	14.00	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.20	.480	62.4	2.457	5	14	460.1-1220-061A0-XM	GC34	14.00	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.30	.484	38.7	1.524	3	14	460.1-1230-037A0-XM	GC34	14.00	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.30	.484	62.2	2.449	5	14	460.1-1230-062A0-XM	GC34	14.00	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.50	.492	39.4	1.551	3	14	460.1-1250-038A0-XM	GC34	14.00	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.50	.492	62.0	2.441	4	14	460.1-1250-063A0-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.70	.500	40.0	1.575	3	14	460.1-1270-038A0-XM	GC34	14.00	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.70	.500	61.8	2.433	4	14	460.1-1270-064A0-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.80	.504	40.3	1.587	3	14	460.1-1280-038A0-XM	GC34	14.00	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.80	.504	61.6	2.425	4	14	460.1-1280-064A0-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
13.00	.512	40.9	1.610	3	14	460.1-1300-039A0-XM	GC34	14.00	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
13.00	.512	61.4	2.417	4	14	460.1-1300-065A0-XM	GC34	14.00	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
13.10	.516	41.2	1.622	3	14	460.1-1310-039A0-XM	GC34	14.00	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.10	.516	61.3	2.413	4	14	460.1-1310-066A0-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.49	.531	42.5	1.673	3	14	460.1-1349-041A0-XM	GC34	14.00	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.49	.531	60.8	2.394	4	14	460.1-1349-061A0-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.50	.531	42.5	1.673	3	14	460.1-1350-041A0-XM	GC34	14.00	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.50	.531	60.8	2.394	4	14	460.1-1350-061A0-XM	GC34	14.00	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.80	.543	43.4	1.709	3	14	460.1-1380-041A0-XM	GC34	14.00	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K
13.80	.543	60.4	2.378	4	14	460.1-1380-062A0-XM	GC34	14.00	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	DIN 6537 L
13.89	.547	43.3	1.705	3	14	460.1-1389-042A0-XM	GC34	14.00	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K
13.89	.547	60.3	2.374	4	14	460.1-1389-063A0-XM	GC34	14.00	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	DIN 6537 L
14.00	.551	44.1	1.736	3	14	460.1-1400-042A0-XM	GC34	14.00	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K
14.00	.551	63.0	2.480	4	14	460.1-1400-063A0-XM	GC34	14.00	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	DIN 6537 L
14.25	.561	44.9	1.768	3	16	460.1-1425-043A0-XM	GC34	16.00	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	DIN 6537 K
14.25	.561	68.8	2.709	4	16	460.1-1425-071A0-XM	GC34	16.00	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L
14.29	.563	45.0	1.772	3	16	460.1-1429-043A0-XM	GC34	16.00	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	DIN 6537 K
14.29	.563	68.7	2.705	4	16	460.1-1429-072A0-XM	GC34	16.00	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L
14.50	.571	45.7	1.799	3	16	460.1-1450-044A0-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.50	.571	68.5	2.697	4	16	460.1-1450-073A0-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.68	.578	46.2	1.819	3	16	460.1-1468-044A0-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.68	.578	68.3	2.689	4	16	460.1-1468-073A0-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.80	.583	46.6	1.835	3	16	460.1-1480-044A0-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.80	.583	68.2	2.685	4	16	460.1-1480-067A0-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
15.00	.591	47.2	1.858	3	16	460.1-1500-045A0-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K

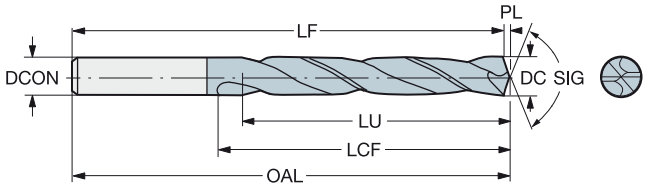
E14 E45 E36 E50

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Ulkopuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	Mitat, mm, tuumaa DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
15.00	.591	68.0	2.677	4	16	460.1-1500-068A0-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
15.08	.594	47.5	1.870	3	16	460.1-1508-045A0-XM	GC34	16.00	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
15.08	.594	67.9	2.673	4	16	460.1-1508-068A0-XM	GC34	16.00	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
15.10	.594	47.6	1.874	3	16	460.1-1510-045A0-XM	GC34	16.00	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.10	.594	67.9	2.673	4	16	460.1-1510-068A0-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.48	.609	48.7	1.917	3	16	460.1-1548-046A0-XM	GC34	16.00	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.48	.609	67.5	2.657	4	16	460.1-1548-070A0-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.50	.610	48.8	1.921	3	16	460.1-1550-047A0-XM	GC34	16.00	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.50	.610	67.5	2.657	4	16	460.1-1550-070A0-XM	GC34	16.00	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.80	.622	49.2	1.937	3	16	460.1-1580-047A0-XM	GC34	16.00	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
15.80	.622	67.2	2.646	4	16	460.1-1580-071A0-XM	GC34	16.00	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
15.88	.625	49.1	1.933	3	16	460.1-1588-047A0-XM	GC34	16.00	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
15.88	.625	67.1	2.642	4	16	460.1-1588-071A0-XM	GC34	16.00	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
16.00	.630	49.0	1.929	3	16	460.1-1600-048A0-XM	GC34	16.00	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
16.00	.630	67.0	2.638	4	16	460.1-1600-072A0-XM	GC34	16.00	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
16.27	.641	51.2	2.016	3	18	460.1-1627-049A0-XM	GC34	18.00	.709	123	4.843	120.6	4.748	73	2.874	2.4	.094	DIN 6537 K
16.27	.641	76.7	3.020	4	18	460.1-1627-081A0-XM	GC34	18.00	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	DIN 6537 L
16.50	.650	52.0	2.047	3	18	460.1-1650-050A0-XM	GC34	18.00	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
16.50	.650	76.5	3.012	4	18	460.1-1650-074A0-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
16.67	.656	52.5	2.067	3	18	460.1-1667-050A0-XM	GC34	18.00	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
16.67	.656	76.3	3.004	4	18	460.1-1667-075A0-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.00	.669	53.5	2.106	3	18	460.1-1700-051A0-XM	GC34	18.00	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
17.00	.669	76.0	2.992	4	18	460.1-1700-077A0-XM	GC34	18.00	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.07	.672	53.7	2.114	3	18	460.1-1707-051A0-XM	GC34	18.00	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
17.46	.687	55.0	2.165	3	18	460.1-1746-052A0-XM	GC34	18.00	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	DIN 6537 K
17.46	.687	75.5	2.972	4	18	460.1-1746-079A0-XM	GC34	18.00	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.50	.689	55.1	2.169	3	18	460.1-1750-053A0-XM	GC34	18.00	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	DIN 6537 K
17.50	.689	75.5	2.972	4	18	460.1-1750-079A0-XM	GC34	18.00	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.80	.701	55.2	2.173	3	18	460.1-1780-053A0-XM	GC34	18.00	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
17.80	.701	75.2	2.961	4	18	460.1-1780-080A0-XM	GC34	18.00	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
17.86	.703	55.1	2.169	3	18	460.1-1786-054A0-XM	GC34	18.00	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
17.86	.703	75.1	2.957	4	18	460.1-1786-080A0-XM	GC34	18.00	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
18.00	.709	56.7	2.232	3	18	460.1-1800-054A0-XM	GC34	18.00	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
18.00	.709	78.6	3.094	4	18	460.1-1800-081A0-XM	GC34	18.00	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
18.26	.719	57.5	2.264	3	20	460.1-1826-055A0-XM	GC34	20.00	.787	131	5.157	128.3	5.051	79	3.110	2.7	.106	DIN 6537 K
18.26	.719	86.4	3.402	4	20	460.1-1826-082A0-XM	GC34	20.00	.787	153	6.024	150.3	5.917	101	3.976	2.7	.106	DIN 6537 L
18.50	.728	58.3	2.295	3	20	460.1-1850-056A0-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
18.50	.728	86.2	3.394	4	20	460.1-1850-083A0-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
18.65	.734	58.7	2.311	3	20	460.1-1865-056A0-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
18.65	.734	86.1	3.390	4	20	460.1-1865-084A0-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
19.00	.748	59.8	2.354	3	20	460.1-1900-057A0-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
19.00	.748	85.8	3.378	4	20	460.1-1900-086A0-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
19.05	.750	60.0	2.362	3	20	460.1-1905-057A0-XM	GC34	20.00	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
19.05	.750	85.8	3.378	4	20	460.1-1905-086A0-XM	GC34	20.00	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
19.50	.768	61.4	2.417	3	20	460.1-1950-059A0-XM	GC34	20.00	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	DIN 6537 K
19.50	.768	85.4	3.362	4	20	460.1-1950-088A0-XM	GC34	20.00	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	DIN 6537 L
19.80	.780	62.4	2.457	3	20	460.1-1980-059A0-XM	GC34	20.00	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	DIN 6537 K
19.80	.780	85.2	3.354	4	20	460.1-1980-089A0-XM	GC34	20.00	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	DIN 6537 L

E14 E45 E36 E50

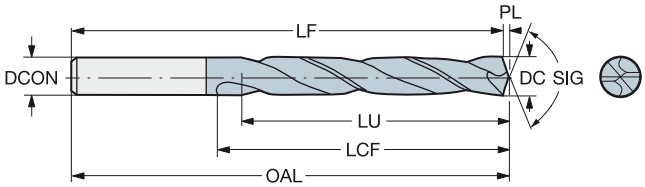
SANDVIK Coromant

CoroDrill® 460 -täyskovametallipora

Vaihtelevien materiaalien koneistukseen

Ulkopuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
								Mitat, mm, tuumaa										
20.00	.787	63.0	2.480	3	20	**460.1-2000-060A0-XM**	GC34	20.00	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	DIN 6537 K
20.00	.787	85.0	3.346	4	20	**460.1-2000-090A0-XM**	GC34	20.00	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	DIN 6537 L

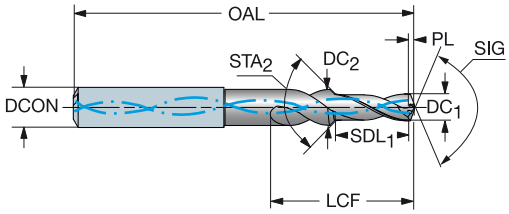
E14 E45 E36 E50

CoroDrill® 460 -täyskovametalli porras- ja viistepora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

TCHA H9
SIG 140°



P M K N S H

DC1	DC"	DC2	DC"	SDL	SDL"	STA	LU	LU"	CZCMS	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
												Mitat, mm, tuumaa										
3.35	.132	4.52	.178	9.40	.370	90°	10.5	.413	6	460.2-0335-010A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	19	.748	0.5	.020	COROMANT
3.40	.134	4.59	.181	9.40	.370	90°	10.5	.413	6	460.2-0340-010A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	19	.748	0.5	.020	COROMANT
3.70	.146	5.00	.197	10.40	.409	90°	11.5	.453	6	460.2-0370-011A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	21	.827	0.5	.020	COROMANT
3.80	.150	5.13	.202	10.30	.405	90°	11.5	.453	6	460.2-0380-011A1-XM	GC34	6.00	.236	66	2.598	65.5	2.579	21	.827	0.5	.020	COROMANT
4.25	.167	5.74	.226	12.30	.484	90°	13.6	.535	6	460.2-0425-013A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	COROMANT
4.30	.169	5.81	.229	12.20	.480	90°	13.6	.535	6	460.2-0430-013A1-XM	GC34	6.00	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	COROMANT
4.65	.183	6.28	.247	13.20	.519	90°	14.7	.579	8	460.2-0465-014A1-XM	GC34	8.00	.315	79	3.110	78.3	3.083	26	1.024	0.7	.028	COROMANT
5.00	.197	6.75	.266	14.10	.555	90°	15.7	.618	8	460.2-0500-015A1-XM	GC34	8.00	.315	79	3.110	78.3	3.083	27	1.063	0.7	.028	COROMANT
5.10	.201	6.89	.271	14.10	.555	90°	15.7	.618	8	460.2-0510-015A1-XM	GC34	8.00	.315	79	3.110	78.3	3.083	28	1.102	0.7	.028	COROMANT
5.30	.209	7.16	.282	15.10	.594	90°	16.8	.661	8	460.2-0530-016A1-XM	GC34	8.00	.315	79	3.110	78.2	3.079	29	1.142	0.8	.031	COROMANT
5.50	.217	7.43	.293	16.00	.629	90°	17.8	.701	8	460.2-0550-017A1-XM	GC34	8.00	.315	79	3.110	78.2	3.079	30	1.181	0.8	.031	COROMANT
5.56	.219	7.51	.296	16.00	.629	90°	17.8	.701	8	460.2-0556-017A1-XM	GC34	8.00	.315	79	3.110	78.2	3.079	31	1.220	0.8	.031	COROMANT
6.60	.260	8.91	.351	18.80	.740	90°	21.0	.827	10	460.2-0660-020A1-XM	GC34	10.00	.394	89	3.504	88.0	3.465	36	1.417	1.0	.039	COROMANT
6.75	.266	9.11	.359	18.80	.740	90°	21.0	.827	10	460.2-0675-020A1-XM	GC34	10.00	.394	89	3.504	88.0	3.465	36	1.417	1.0	.039	COROMANT
6.85	.270	9.25	.364	19.80	.779	90°	22.0	.866	10	460.2-0685-021A1-XM	GC34	10.00	.394	89	3.504	88.0	3.465	37	1.457	1.0	.039	COROMANT
6.90	.272	9.32	.367	19.80	.779	90°	22.0	.866	10	460.2-0690-021A1-XM	GC34	10.00	.394	89	3.504	88.0	3.465	37	1.457	1.0	.039	COROMANT
7.00	.276	9.45	.372	19.80	.779	90°	22.0	.866	10	460.2-0700-021A1-XM	GC34	10.00	.394	89	3.504	88.0	3.465	38	1.496	1.0	.039	COROMANT
7.25	.285	9.79	.385	20.70	.814	90°	23.1	.909	10	460.2-0725-022A1-XM	GC34	10.00	.394	89	3.504	87.9	3.461	39	1.535	1.1	.043	COROMANT
7.30	.287	9.86	.388	20.70	.814	90°	23.1	.909	10	460.2-0730-022A1-XM	GC34	10.00	.394	89	3.504	87.9	3.461	39	1.535	1.1	.043	COROMANT
7.40	.291	9.99	.393	20.70	.814	90°	23.1	.909	10	460.2-0740-022A1-XM	GC34	10.00	.394	89	3.504	87.9	3.461	40	1.575	1.1	.043	COROMANT
8.00	.315	10.80	.425	22.60	.889	90°	25.2	.992	12	460.2-0800-024A1-XM	GC34	12.00	.472	102	4.016	100.8	3.969	43	1.693	1.2	.047	COROMANT
8.50	.335	11.48	.452	24.50	.964	90°	27.3	1.075	12	460.2-0850-026A1-XM	GC34	12.00	.472	102	4.016	100.7	3.965	46	1.811	1.3	.051	COROMANT
8.60	.339	11.61	.457	24.50	.964	90°	27.3	1.075	12	460.2-0860-026A1-XM	GC34	12.00	.472	102	4.016	100.7	3.965	46	1.811	1.3	.051	COROMANT
8.70	.343	11.75	.463	24.50	.964	90°	27.3	1.075	12	460.2-0870-026A1-XM	GC34	12.00	.472	102	4.016	100.7	3.965	46	1.811	1.3	.051	COROMANT
9.00	.354	12.15	.478	25.40	1.000	90°	28.3	1.114	14	460.2-0900-027A1-XM	GC34	14.00	.551	112	4.409	110.7	4.358	48	1.890	1.3	.051	COROMANT
9.25	.364	12.49	.492	26.40	1.039	90°	29.4	1.157	14	460.2-0925-028A1-XM	GC34	14.00	.551	112	4.409	110.6	4.354	50	1.969	1.4	.055	COROMANT
9.30	.366	12.56	.494	26.40	1.039	90°	29.4	1.157	14	460.2-0930-028A1-XM	GC34	14.00	.551	112	4.409	110.6	4.354	50	1.969	1.4	.055	COROMANT
10.25	.404	13.84	.545	29.20	1.149	90°	32.5	1.280	14	460.2-1025-031A1-XM	GC34	14.00	.551	112	4.409	110.5	4.350	55	2.165	1.5	.059	COROMANT
10.30	.406	13.91	.548	29.20	1.149	90°	32.5	1.280	14	460.2-1030-031A1-XM	GC34	14.00	.551	112	4.409	110.5	4.350	55	2.165	1.5	.059	COROMANT
10.40	.409	14.04	.553	29.20	1.149	90°	32.5	1.280	16	460.2-1040-031A1-XM	GC34	16.00	.630	124	4.882	122.5	4.823	55	2.165	1.5	.059	COROMANT
10.50	.413	14.18	.558	30.20	1.188	90°	33.6	1.323	16	460.2-1050-032A1-XM	GC34	16.00	.630	124	4.882	122.4	4.819	56	2.205	1.6	.063	COROMANT
10.80	.425	14.58	.574	30.10	1.185	90°	33.6	1.323	16	460.2-1080-032A1-XM	GC34	16.00	.630	124	4.882	122.4	4.819	57	2.244	1.6	.063	COROMANT
11.00	.433	14.85	.585	31.10	1.224	90°	34.6	1.362	16	460.2-1100-033A1-XM	GC34	16.00	.630	124	4.882	122.4	4.819	58	2.283	1.6	.063	COROMANT
11.20	.441	15.12	.595	32.00	1.259	90°	35.7	1.406	16	460.2-1120-034A1-XM	GC34	16.00	.630	124	4.882	122.3	4.815	60	2.362	1.7	.067	COROMANT
11.50	.453	15.53	.611	33.00	1.299	90°	36.7	1.445	16	460.2-1150-035A1-XM	GC34	16.00	.630	124	4.882	122.3	4.815	61	2.402	1.7	.067	COROMANT
12.00	.472	16.20	.638	33.90	1.334	90°	37.8	1.488	18	460.2-1200-036A1-XM	GC34	18.00	.709	131	5.157	129.2	5.087	64	2.520	1.8	.071	COROMANT
12.10	.476	16.34	.643	33.90	1.334	90°	37.8	1.488	18	460.2-1210-036A1-XM	GC34	18.00	.709	131	5.157	129.2	5.087	64	2.520	1.8	.071	COROMANT
12.20	.480	16.47	.648	34.90	1.374	90°	38.8	1.528	18	460.2-1220-037A1-XM	GC34	18.00	.709	131	5.157	129.2	5.087	65	2.559	1.8	.071	COROMANT
12.25	.482	16.54	.651	34.90	1.374	90°	38.8	1.528	18	460.2-1225-037A1-XM	GC34	18.00	.709	131	5.157	129.2	5.087	65	2.559	1.8	.071	COROMANT
12.50	.492	16.88	.665	35.80	1.409	90°	39.9	1.571	18	460.2-1250-038A1-XM	GC34	18.00	.709	131	5.157	129.1	5.083	67	2.638	1.9	.075	COROMANT
13.10	.516	17.69	.696	36.70	1.444	90°	41.0	1.614	18	460.2-1310-039A1-XM	GC34	18.00	.709	142	5.591	140.0	5.512	69	2.717	2.0	.079	COROMANT
13.50	.531	18.23	.718	38.60	1.519	90°	43.0	1.693	20	460.2-1350-041A1-XM	GC34	20.00	.787	142	5.591	140.0	5.512	72	2.835	2.0	.079	COROMANT
14.00	.551	18.90	.744	39.60	1.559	90°	44.1	1.736	20	460.2-1400-042A1-XM	GC34	20.00	.787	142	5.591	139.9	5.508	74	2.913	2.1	.083	COROMANT
14.10	.555	19.04	.750	39.50	1.555	90°	44.1	1.736	20	460.2-1410-042A1-XM	GC34	20.00	.787	142	5.591	139.9	5.508	74	2.913	2.1	.083	COROMANT
14.20	.559	19.17	.755	40.50	1.594	90°	45.1	1.776	20	460.2-1420-043A1-XM	GC34	20.00	.787	142	5.591	139.9	5.508	75	2.953	2.1	.083	COROMANT
14.25	.561	19.24	.757	40.50	1.594	90°	45.1	1.776	20	460.2-1425-043A1-XM	GC34	20.00	.787	142	5.591	139.9	5.508	75	2.953	2.1	.083	COROMANT
14.50	.571	19.58	.771	41.50	1.633	90°	46.2	1.819	20	460.2-1450-044A1-XM	GC34	20.00	.787	142	5.591	139.8	5.504	77	3.032	2.2	.087	COROMANT
15.00	.591	20.00	.787	42.50	1.673	90°	47.2	1.858	20	460.2-1500-045A1-XM	GC34	20.00	.787	142	5.591	139.8	5.504	79	3.110	2.2	.087	COROMANT

E8 E45 E36 E50

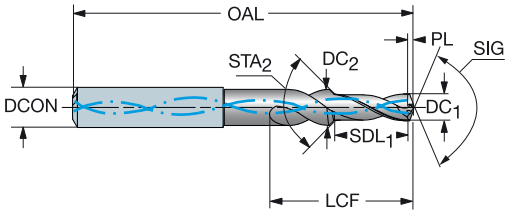
SANDVIK Coromant

CoroDrill® 460 -täyskovametalli porras- ja viistepora

Vaihtelevien materiaalien koneistukseen

Sisäpuolinen lastuamisnesteen syöttö

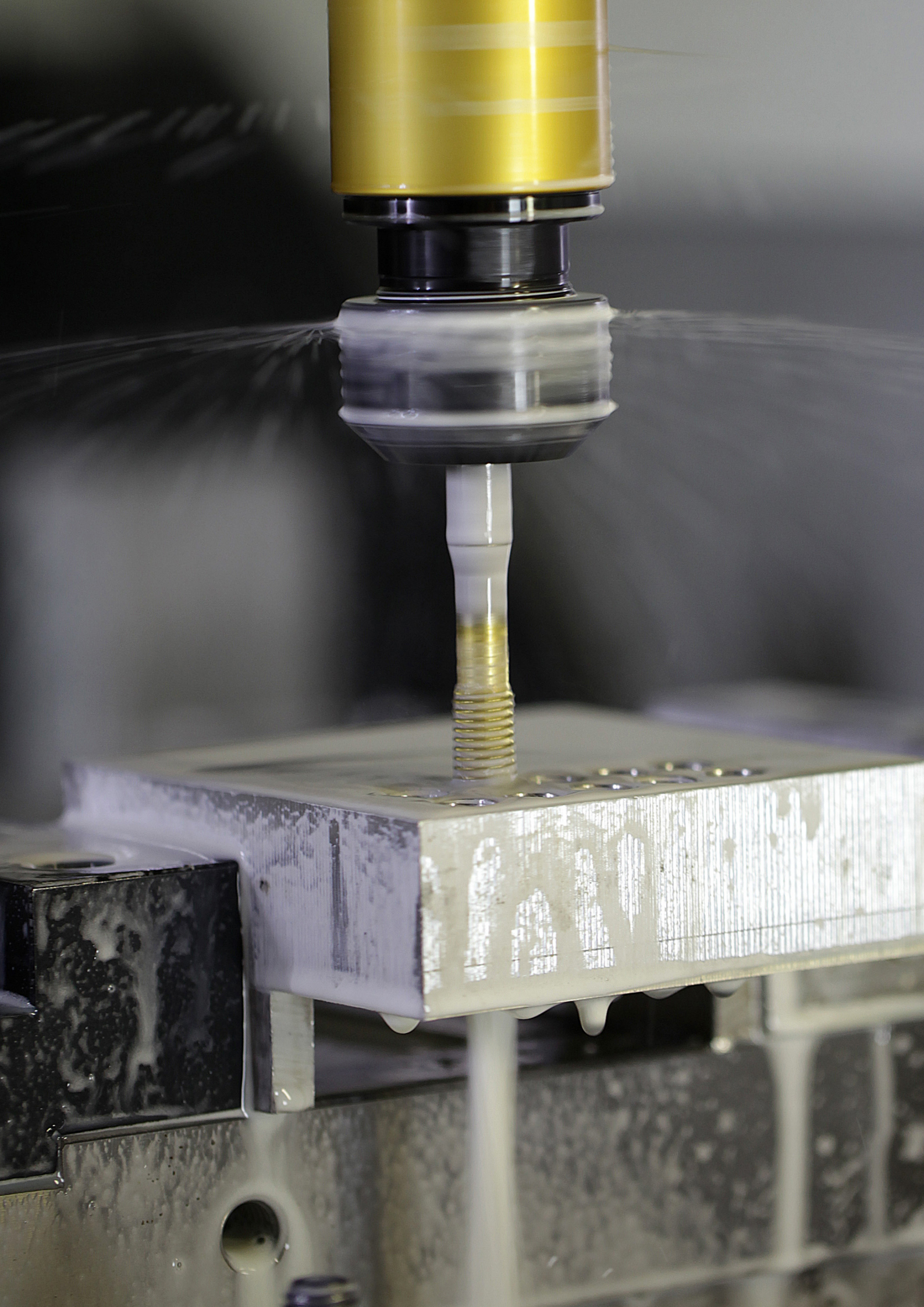
TCHA H9
SIG 140°



P M K N S H

												Mitat, mm, tuumaa										
DC_1	DC"	DC_2	DC"	SDL	SDL"	STA	LU	LU"	CZC_{MS}	**Tilauskoodi**	GRADE	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
15.10	.594	20.00	.787	42.60	1.677	90°	47.3	1.862	20	**460.2-1510-045A1-XM**	GC34	20.00	.787	142	5.591	139.7	5.500	79	3.110	2.3	.091	COROMANT
15.50	.610	20.00	.787	44.80	1.763	90°	49.3	1.941	20	**460.2-1550-047A1-XM**	GC34	20.00	.787	142	5.591	139.7	5.500	81	3.189	2.3	.091	COROMANT
15.60	.614	20.00	.787	44.80	1.763	90°	49.3	1.941	20	**460.2-1560-047A1-XM**	GC34	20.00	.787	142	5.591	139.7	5.500	81	3.189	2.3	.091	COROMANT
15.70	.618	20.00	.787	44.90	1.767	90°	49.3	1.941	20	**460.2-1570-047A1-XM**	GC34	20.00	.787	142	5.591	139.7	5.500	81	3.189	2.3	.091	COROMANT
16.50	.650	20.00	.787	48.30	1.901	90°	52.5	2.067	20	**460.2-1650-050A1-XM**	GC34	20.00	.787	142	5.591	139.5	5.492	84	3.307	2.5	.098	COROMANT
17.50	.689	20.00	.787	51.80	2.039	90°	55.6	2.189	20	**460.2-1750-053A1-XM**	GC34	20.00	.787	142	5.591	139.4	5.488	87	3.425	2.6	.102	COROMANT

E8 E45 E36 E50



Tappikierteitys

	Metrinen	Metrinen, hieno	UNC	UNF	G	Metrinen	Metrinen, hieno
CoroTap™	200	200	200	200	200	300	300
Kierteitysalue	M2 - M30	M4 - M30	No.2-1", No.4-1"	No.8-1", No.4-1"	No.1/8-1"	M2 - M64	M4 - M30
ISO-käyttöalue	P M K N S	P M K N S	P M K N S	P M K N S	P M K N S	P M K N S	P M K N S
Läpi- tai pohjareikä							
THCHT	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3, E 1.5-2	C 2-3, E 1.5-2
TCTR	6H, 6G	6H	2B, 3BX	2B, 3BX	NORMAL	6H,6G	6H
ULDR	2.5-3.0 xD	2.5 xD	2.5 xD	2.5 xD	2.5 xD	2.5-3.0 xD	2.5 xD
BSG	DIN 371 DIN 376 DIN 371/ANSI	DIN 374 DIN 374/ANSI	DIN 2184-1 DIN 2184-1/ANSI	DIN 2184-1 DIN 2184-1/ANSI	DIN 5156	DIN 371 DIN 376 DIN 371/ANSI DIN 376/ANSI	DIN 374 DIN 374/ANSI
Sisäpuolinen lastuamisnesteen syöttö	✗	✗	✗	✗	✗	✗	✗
Ulkopuolinen lastuamisnesteen syöttö	✓	✓	✓	✓	✓	✓	✓
Sivu	C4-C6	C7-C9	C10-C11	C12-C13	C14	C16-C18	C19-C21

	UNC	UNF	G
CoroTap™	300	300	300
Kierteitysalue	No.4-1", No.2-1"	No.4-1", No.8 - 1"	1/8-1.1/2
ISO-käyttöalue	P M K N S	P M K N S	P M K N S
Läpi- tai pohjareikä			
THCHT	C 2-3, E 1.5-2	C 2-3, E 1.5-2	C 2-3
TCTR	2B, 3BX	2B, 3BX	NORMAL
ULDR	2.5 xD	2.5 xD	2.5 xD
BSG	DIN 2184-1 DIN 2184-1/ANSI	DIN 2184-1 DIN 2184-1/ANSI	DIN 5156
Sisäpuolinen lastuamisnesteen syöttö	✗	✗	✗
Ulkopuolinen lastuamisnesteen syöttö	✓	✓	✓
Sivu	C22-C24	C25-C27	C28

CoroTap™ 200

Käyttöalueet

- Ainoastaan läpireikien koneistukseen
- Laaja valikoima eri kierremuotoja ja standardeja
- Materiaalista riippuen maks. 3 x D

ISO-käyttöalueet:

P M K N S

Edut ja ominaisuudet

- B-viisteellä (3.5–5 kierrettä) saadaan hyvä prosessivarmuus
- Teräsärmän käsittely pienentää aksiaalivoimia ja vääntömomenttia, juohevoittaa lastuamista, vähentää teräsärmien murtumariskiä, parantaa pinnankarheutta, pidentää kestoikää ja tehostaa lastunmuodostusta
- Pulveripikateräksisten kierretappien valtteja ovat lujuus, kulumiskestävyys ja kestoikä
- Saatavana erilaisia pinnoitteita ja laatuja

- Hiottu lastua työntävä kärki
- Työntävät lastuja edellään
- Käytetään läpireikien koneistukseen

C

Räätälöidyt ratkaisut, sivu E36

www.sandvik.coromant.com/corotap200

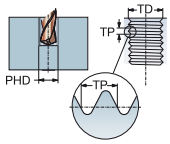
CoroChuck™ 970 -istukat Pyörivät työkalut -luettelossa.

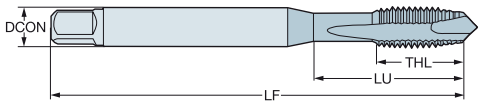
CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: metrinen

DIN 371, DIN 376

ULDR 2.5
SUBSTRATE HSS-PM





P M K N S

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
M 2	0.40	9.00	2.80 x 2.10	B	6H	T200-XM100DA-M2	C110, C150, C145	2.8	2.00	45.0	6.0	2	DIN 371
		.354						.110	.079	1.772	.236		
M 2.5	0.45	12.50	2.80 x 2.10	B	6H	T200-XM100DA-M2.5	C110, C150, C145	2.8	2.50	50.0	8.0	2	DIN 371
		.492						.110	.098	1.969	.315		
M 3	0.50	18.00	3.50 x 2.70	B	6H	T200-XM100DA-M3	C110, C150, C145	3.5	3.00	56.0	8.9	3	DIN 371
		.709						.138	.118	2.205	.350		
M 3.5	0.60	20.00	4.00 x 3.00	B	6H	T200-XM100DA-M3.5	C110, C150, C145	4.0	3.50	56.0	10.8	3	DIN 371
		.787						.157	.138	2.205	.425		
M 4	0.70	21.00	4.50 x 3.40	B	6H	T200-XM100DA-M4	C110, C150, C145	4.5	4.00	63.0	11.7	3	DIN 371
		.827						.177	.157	2.480	.461		
M 4.5	0.75	25.00	6.00 x 4.90	B	6H	T200-XM100DA-M4.5	C110, C150, C145	6.0	4.50	70.0	13.0	3	DIN 371
		.984						.236	.177	2.756	.512		
M 5	0.80	25.00	6.00 x 4.90	B	6H	T200-XM100DA-M5	C110, C150, C145	6.0	5.00	70.0	12.6	3	DIN 371
		.984						.236	.197	2.756	.496		
M 6	1.00	30.00	6.00 x 4.90	B	6H	T200-XM100DA-M6	C110, C150, C145	6.0	6.00	80.0	14.5	3	DIN 371
		1.181						.236	.236	3.150	.571		
M 7	1.00	30.00	7.00 x 5.50	B	6H	T200-XM100DA-M7	C110, C150, C145	7.0	7.00	80.0	14.5	3	DIN 371
		1.181						.276	.276	3.150	.571		
M 8	1.25	35.00	8.00 x 6.20	B	6H	T200-XM100DA-M8	C110, C150, C145	8.0	8.00	90.0	17.4	3	DIN 371
		1.378						.315	.315	3.543	.685		
M 10	1.50	39.00	10.00 x 8.00	B	6H	T200-XM100DA-M10	C110, C150, C145	10.0	10.00	100.0	19.2	3	DIN 371
		1.535						.394	.394	3.937	.756		
M 3	0.50	37.00	2.20 x 1.80	B	6H	T200-XM101DA-M3	C110, C150, C145	2.2	3.00	56.0	10.0	3	DIN 376
		1.457						.087	.118	2.205	.394		
M 4	0.70	43.00	2.80 x 2.10	B	6H	T200-XM101DA-M4	C110, C150, C145	2.8	4.00	63.0	11.9	3	DIN 376
		1.693						.110	.157	2.480	.469		
M 5	0.80	49.00	3.50 x 2.70	B	6H	T200-XM101DA-M5	C110, C150, C145	3.5	5.00	70.0	13.2	3	DIN 376
		1.929						.138	.197	2.756	.520		
M 6	1.00	59.00	4.50 x 3.40	B	6H	T200-XM101DA-M6	C110, C150, C145	4.5	6.00	80.0	15.1	3	DIN 376
		2.323						.177	.236	3.150	.594		
M 8	1.25	67.00	6.00 x 4.90	B	6H	T200-XM101DA-M8	C110, C150, C145	6.0	8.00	90.0	18.0	3	DIN 376
		2.638						.236	.315	3.543	.709		
M 10	1.50	77.00	7.00 x 5.50	B	6H	T200-XM101DA-M10	C110, C150, C145	7.0	10.00	100.0	20.0	3	DIN 376
		3.032						.276	.394	3.937	.787		
M 12	1.75	83.00	9.00 x 7.00	B	6H	T200-XM101DA-M12	C110, C150, C145	9.0	12.00	110.0	23.0	3	DIN 376
		3.268						.354	.472	4.331	.906		
M 14	2.00	81.00	11.00 x 9.00	B	6H	T200-XM101DA-M14	C110, C150, C145	11.0	14.00	110.0	25.0	3	DIN 376
		3.189						.433	.551	4.331	.984		
M 16	2.00	68.00	12.00 x 9.00	B	6H	T200-XM101DA-M16	C110, C150, C145	12.0	16.00	110.0	25.0	3	DIN 376
		2.677						.472	.630	4.331	.984		
M 18	2.50	81.00	14.00 x 11.00	B	6H	T200-XM101DA-M18	B110, B145, B150	14.0	18.00	125.0	30.0	4	DIN 376
		3.189						.551	.709	4.921	1.181		
M 20	2.50	95.00	16.00 x 12.00	B	6H	T200-XM101DA-M20	B110, B145, B150	16.0	20.00	140.0	30.0	4	DIN 376
		3.740						.630	.787	5.512	1.181		

E28 E41 E45 E36 E59 E38

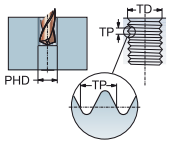
FIN

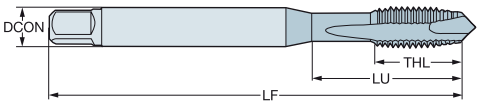
CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: metrinen

DIN 371, DIN 376

ULDR 2.5
SUBSTRATE HSS-PM





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
M 22	2.50	93.00	18.00 x 14.50	B	6H	T200-XM101DA-M22	B110, B145, B150	18.0	22.00	140.0	34.0	4	DIN 376
		3.661						*.709*	*.866*	*5.512*	*1.339*		
M 24	3.00	113.00	18.00 x 14.50	B	6H	T200-XM101DA-M24	B110, B145, B150	18.0	24.00	160.0	38.0	4	DIN 376
		4.449						*.709*	*.945*	*6.299*	*1.496*		
M 27	3.00	97.00	20.00 x 16.00	B	6H	T200-XM101DA-M27	B110, B145, B150	20.0	27.00	160.0	38.0	4	DIN 376
		3.819						*.787*	*1.063*	*6.299*	*1.496*		
M 30	3.50	115.00	22.00 x 18.00	B	6H	T200-XM101DA-M30	B110, B145, B150	22.0	30.00	180.0	45.0	4	DIN 376
		4.528						*.866*	*1.181*	*7.087*	*1.772*		
M 3	0.50	18.00	3.50 x 2.70	B	6G	T200-XM104DA-M3	C110, C145, C150	3.5	3.00	56.0	8.9	3	DIN 371
		.709						*.138*	*.118*	*2.205*	*.350*		
M 4	0.70	21.00	4.50 x 3.40	B	6G	T200-XM104DA-M4	C110, C145, C150	4.5	4.00	63.0	12.0	3	DIN 371
		.827						*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	B	6G	T200-XM104DA-M5	C110, C145, C150	6.0	5.00	70.0	13.0	3	DIN 371
		.984						*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	B	6G	T200-XM104DA-M6	C110, C145, C150	6.0	6.00	80.0	15.0	3	DIN 371
		1.181						*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	B	6G	T200-XM104DA-M8	C110, C145, C150	8.0	8.00	90.0	18.0	3	DIN 371
		1.378						*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	B	6G	T200-XM104DA-M10	C110, C145, C150	10.0	10.00	100.0	20.0	3	DIN 371
		1.535						*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	B	6G	T200-XM105DA-M12	C110, C145, C150	9.0	12.00	110.0	23.0	3	DIN 376
		3.268						*.354*	*.472*	*4.331*	*.906*		
M 16	2.00	68.00	12.00 x 9.00	B	6G	T200-XM105DA-M16	C110, C145, C150	12.0	16.00	110.0	25.0	3	DIN 376
		2.677						*.472*	*.630*	*4.331*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	B	6G	T200-XM105DA-M20	B110, B145, B150	16.0	20.00	140.0	30.0	4	DIN 376
		3.740						*.630*	*.787*	*5.512*	*1.181*		

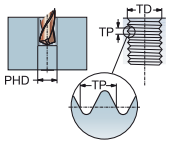
E28 E41 E45 E36 E59 E38

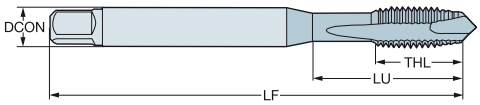
CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: metrinen

DIN 371/ANSI

ULDR 2.5
SUBSTRATE HSS-PM





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
M 4	0.70	21.50	.168 x .131	B	6H	T200-XM100AA-M4	C110, C145, C150	4.3	4.00	63.0	13.6	3	DIN 371/ANSI
		.846						*.168*	*.157*	*2.480*	*.535*		
M 5	0.80	28.00	.194 x .152	B	6H	T200-XM100AA-M5	C110, C145, C150	4.9	5.00	70.0	14.6	3	DIN 371/ANSI
		1.102						*.194*	*.197*	*2.756*	*.575*		
M 6	1.00	25.00	.255 x .191	B	6H	T200-XM100AA-M6	C110, C145, C150	6.5	6.00	80.0	15.9	3	DIN 371/ANSI
		.984						*.255*	*.236*	*3.150*	*.626*		
M 8	1.25	34.00	.318 x .238	B	6H	T200-XM100AA-M8	C110, C145, C150	8.1	8.00	90.0	18.9	3	DIN 371/ANSI
		1.339						*.318*	*.315*	*3.543*	*.744*		
M 10	1.50	38.50	.381 x .286	B	6H	T200-XM100AA-M10	C110, C145, C150	9.7	10.00	100.0	21.0	3	DIN 371/ANSI
		1.516						*.381*	*.394*	*3.937*	*.827*		
M 12	1.75	81.82	.367 x .275	B	6H	T200-XM101AA-M12	C110, C145, C150	9.3	12.00	110.0	23.1	3	DIN 376/ANSI
		3.221						*.367*	*.472*	*4.331*	*.909*		
M 14	2.00	80.30	.429 x .322	B	6H	T200-XM101AA-M14	C110, C145, C150	10.9	14.00	110.0	23.1	3	DIN 376/ANSI
		3.161						*.429*	*.551*	*4.331*	*.909*		
M 16	2.00	65.78	.480 x .360	B	6H	T200-XM101AA-M16	C110, C145, C150	12.2	16.00	110.0	23.1	3	DIN 376/ANSI
		2.590						*.480*	*.630*	*4.331*	*.909*		
M 18	2.50	79.00	.542 x .406	B	6H	T200-XM101AA-M18	C110, C145, C150	13.8	18.00	125.0	30.0	4	DIN 376/ANSI
		3.110						*.542*	*.709*	*4.921*	*1.181*		
M 20	2.50	92.47	.652 x .489	B	6H	T200-XM101AA-M20	C110, C145, C150	16.6	20.00	140.0	30.0	4	DIN 376/ANSI
		3.641						*.652*	*.787*	*5.512*	*1.181*		

E28 E41 E45 E36 E59 E38

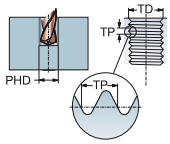
FIN

CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: metrinen taajakierre

DIN 374

ULDR 2.5
SUBSTRATE HSS-PM



P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
MF 4x0.5	0.50	43.00	2.80 x 2.10	B	6H	T200-XM100DB-M4X050	C110, C145, C150	2.8	4.00	63.0	11.9	3	DIN 374
		1.693						*.110*	*.157*	*2.480*	*.469*		
MF 5x0.5	0.50	49.00	3.50 x 2.70	B	6H	T200-XM100DB-M5X050	C110, C145, C150	3.5	5.00	70.0	13.2	3	DIN 374
		1.929						*.138*	*.197*	*2.756*	*.520*		
MF 6x0.75	0.75	59.00	4.50 x 3.40	B	6H	T200-XM100DB-M6X075	C110, C145, C150	4.5	6.00	80.0	15.1	3	DIN 374
		2.323						*.177*	*.236*	*3.150*	*.594*		
MF 8x0.75	0.75	57.00	6.00 x 4.90	B	6H	T200-XM100DB-M8X075	C110, C145, C150	6.0	8.00	80.0	14.9	3	DIN 374
		2.244						*.236*	*.315*	*3.150*	*.587*		
MF 8x1	1.00	67.00	6.00 x 4.90	B	6H	T200-XM100DB-M8X100	C110, C145, C150	6.0	8.00	90.0	18.0	3	DIN 374
		2.638						*.236*	*.315*	*3.543*	*.709*		
MF 10x0.75	0.75	67.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X075	C110, C145, C150	7.0	10.00	90.0	17.6	3	DIN 374
		2.638						*.276*	*.394*	*3.543*	*.693*		
MF 10x1	1.00	67.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X100	C110, C145, C150	7.0	10.00	90.0	17.6	3	DIN 374
		2.638						*.276*	*.394*	*3.543*	*.693*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X125	C110, C145, C150	7.0	10.00	100.0	19.8	3	DIN 374
		3.032						*.276*	*.394*	*3.937*	*.780*		
MF 12x1	1.00	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X100	C110, C145, C150	9.0	12.00	100.0	21.0	3	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X125	C110, C145, C150	9.0	12.00	100.0	21.0	3	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X150	C110, C145, C150	9.0	12.00	100.0	21.0	3	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		
MF 14x1	1.00	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X100	C110, C145, C150	11.0	14.00	100.0	21.0	3	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		
MF 14x1.25	1.25	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X125	C110, C145, C150	11.0	14.00	100.0	21.0	3	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X150	C110, C145, C150	11.0	14.00	100.0	21.0	3	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		
MF 16x1	1.00	58.00	12.00 x 9.00	B	6H	T200-XM100DB-M16X100	C110, C145, C150	12.0	16.00	100.0	21.0	3	DIN 374
		2.283						*.472*	*.630*	*3.937*	*.827*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	B	6H	T200-XM100DB-M16X150	C110, C145, C150	12.0	16.00	100.0	21.0	3	DIN 374
		2.283						*.472*	*.630*	*3.937*	*.827*		
MF 18x1	1.00	66.00	14.00 x 11.00	B	6H	T200-XM100DB-M18X100	B110, B145, B150	14.0	18.00	110.0	24.0	4	DIN 374
		2.598						*.551*	*.709*	*4.331*	*.945*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	B	6H	T200-XM100DB-M18X150	B110, B145, B150	14.0	18.00	110.0	24.0	4	DIN 374
		2.598						*.551*	*.709*	*4.331*	*.945*		
MF 20x1	1.00	80.00	16.00 x 12.00	B	6H	T200-XM100DB-M20X100	B110, B145, B150	16.0	20.00	125.0	24.0	4	DIN 374
		3.150						*.630*	*.787*	*4.921*	*.945*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	B	6H	T200-XM100DB-M20X150	B110, B145, B150	16.0	20.00	125.0	24.0	4	DIN 374
		3.150						*.630*	*.787*	*4.921*	*.945*		
MF 22x1.5	1.50	78.00	18.00 x 14.50	B	6H	T200-XM100DB-M22X150	B110, B145, B150	18.0	22.00	125.0	25.0	4	DIN 374
		3.071						*.709*	*.866*	*4.921*	*.984*		
MF 24x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M24X150	B110, B145, B150	18.0	24.00	140.0	28.0	4	DIN 374
		3.661						*.709*	*.945*	*5.512*	*1.102*		

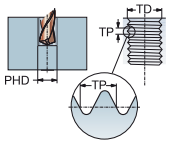
E28 E41 E45 E36 E59 E38

CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: metrinen taajakierre

DIN 374

ULDR 2.5
SUBSTRATE HSS-PM



P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
MF 24x2	2.00	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M24X200	B110, B145, B150	18.0	24.00	140.0	28.0	4	DIN 374
		3.661						*.709*	*.945*	*5.512*	*1.102*		
MF 25x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M25X150	B110, B145, B150	18.0	25.00	140.0	28.0	4	DIN 374
		3.661						*.709*	*.984*	*5.512*	*1.102*		
MF 26x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M26X150	B110, B145, B150	18.0	26.00	140.0	28.0	4	DIN 374
		3.661						*.709*	*1.024*	*5.512*	*1.102*		
MF 27x1.5	1.50	77.00	20.00 x 16.00	B	6H	T200-XM100DB-M27X150	B110, B145, B150	20.0	27.00	140.0	28.0	4	DIN 374
		3.032						*.787*	*1.063*	*5.512*	*1.102*		
MF 27x2	2.00	77.00	20.00 x 16.00	B	6H	T200-XM100DB-M27X200	B110, B145, B150	20.0	27.00	140.0	28.0	4	DIN 374
		3.032						*.787*	*1.063*	*5.512*	*1.102*		
MF 28x1.5	1.50	77.00	20.00 x 16.00	B	6H	T200-XM100DB-M28X150	B110, B145, B150	20.0	28.00	140.0	28.0	4	DIN 374
		3.032						*.787*	*1.102*	*5.512*	*1.102*		
MF 30x1.5	1.50	85.00	22.00 x 18.00	B	6H	T200-XM100DB-M30X150	B110, B145, B150	22.0	30.00	150.0	28.0	4	DIN 374
		3.346						*.866*	*1.181*	*5.906*	*1.102*		
MF 30x2	2.00	85.00	22.00 x 18.00	B	6H	T200-XM100DB-M30X200	B110, B145, B150	22.0	30.00	150.0	28.0	4	DIN 374
		3.346						*.866*	*1.181*	*5.906*	*1.102*		

E28 E41 E45 E36 E59 E38

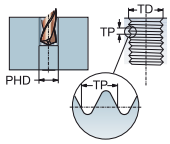
FIN

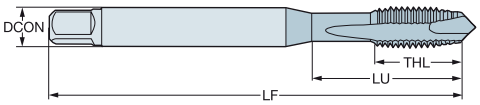
CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: metrinen taajakierre

DIN 374/ANSI

ULDR 2.5
SUBSTRATE HSS-PM





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
MF 8x1	1.00	34.00	.318 x .238	B	6H	**T200-XM100AB-M8X100**	C110, C145, C150	8.1	8.00	90.0	18.7	3	DIN 374/ANSI
		1.339						*.318*	*.315*	*3.543*	*.736*		
MF 10x1	1.00	37.50	.381 x .286	B	6H	**T200-XM100AB-M10X100**	C110, C145, C150	9.7	10.00	90.0	18.0	3	DIN 374/ANSI
		1.476						*.381*	*.394*	*3.543*	*.709*		
MF 14x1.5	1.50	70.30	.429 x .322	B	6H	**T200-XM101AB-M14X150**	C110, C145, C150	10.9	14.00	100.0	21.1	3	DIN 374/ANSI
		2.768						*.429*	*.551*	*3.937*	*.831*		
MF 18x1.5	1.50	64.00	.542 x .406	B	6H	**T200-XM101AB-M18X150**	C110, C145, C150	13.8	18.00	110.0	23.9	4	DIN 374/ANSI
		2.520						*.542*	*.709*	*4.331*	*.941*		

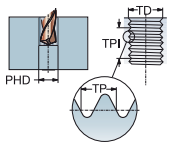
E28 E41 E45 E36 E59 E38

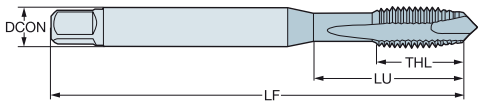
CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: UNC

DIN 2184-1

ULDR 2.5
SUBSTRATE HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNC #4-40	40.00	18.00	3.50 x 2.70	B	2B	T200-XM100DE-4-40	C110, C145, C150	3.5	2.84	56.0	8.5	3	DIN 2184-1
		.709						*.138*	*.112*	*2.205*	*.335*		
UNC #5-40	40.00	18.00	3.50 x 2.70	B	2B	T200-XM100DE-5-40	C110, C145, C150	3.5	3.18	56.0	9.5	3	DIN 2184-1
		.709						*.138*	*.125*	*2.205*	*.374*		
UNC #6-32	32.00	20.00	4.00 x 3.00	B	2B	T200-XM100DE-6-32	C110, C145, C150	4.0	3.51	56.0	10.4	3	DIN 2184-1
		.787						*.157*	*.138*	*2.205*	*.409*		
UNC #8-32	32.00	21.00	4.50 x 3.40	B	2B	T200-XM100DE-8-32	C110, C145, C150	4.5	4.17	63.0	11.4	3	DIN 2184-1
		.827						*.177*	*.164*	*2.480*	*.449*		
UNC #10-24	24.00	25.00	6.00 x 4.90	B	2B	T200-XM100DE-10-24	C110, C145, C150	6.0	4.83	70.0	13.0	3	DIN 2184-1
		.984						*.236*	*.190*	*2.756*	*.512*		
UNC #12-24	24.00	30.00	6.00 x 4.90	B	2B	T200-XM100DE-12-24	C110, C145, C150	6.0	5.49	80.0	15.0	3	DIN 2184-1
		1.181						*.236*	*.216*	*3.150*	*.591*		
UNC 1/4-20	20.00	30.00	7.00 x 5.50	B	2B	T200-XM100DE-1/4	C110, C145, C150	7.0	6.35	80.0	14.1	3	DIN 2184-1
		1.181						*.276*	*.250*	*3.150*	*.555*		
UNC 5/16-18	18.00	35.00	8.00 x 6.20	B	2B	T200-XM100DE-5/16	C110, C145, C150	8.0	7.94	90.0	17.4	3	DIN 2184-1
		1.378						*.315*	*.313*	*3.543*	*.685*		
UNC 3/8-16	16.00	39.00	10.00 x 8.00	B	2B	T200-XM100DE-3/8	C110, C145, C150	10.0	9.53	100.0	18.9	3	DIN 2184-1
		1.535						*.394*	*.375*	*3.937*	*.744*		
UNC 7/16-14	14.00	76.00	8.00 x 6.20	B	2B	T200-XM101DE-7/16	C110, C145, C150	8.0	11.11	100.0	20.0	3	DIN 2184-1
		2.992						*.315*	*.438*	*3.937*	*.787*		
UNC 1/2-13	13.00	83.00	9.00 x 7.00	B	2B	T200-XM101DE-1/2	C110, C145, C150	9.0	12.70	110.0	23.0	3	DIN 2184-1
		3.268						*.354*	*.500*	*4.331*	*.906*		
UNC 5/8-11	11.00	68.00	12.00 x 9.00	B	2B	T200-XM101DE-5/8	C110, C145, C150	12.0	15.88	110.0	25.0	3	DIN 2184-1
		2.677						*.472*	*.625*	*4.331*	*.984*		
UNC 3/4-10	10.00	81.00	14.00 x 11.00	B	2B	T200-XM101DE-3/4	B110, B145, B150	14.0	19.05	125.0	30.0	4	DIN 2184-1
		3.189						*.551*	*.750*	*4.921*	*1.181*		
UNC 7/8-9	9.00	93.00	18.00 x 14.50	B	2B	T200-XM101DE-7/8	B110, B145, B150	18.0	22.23	140.0	34.0	4	DIN 2184-1
		3.661						*.709*	*.875*	*5.512*	*1.339*		
UNC 1"-8	8.00	113.00	18.00 x 14.50	B	2B	T200-XM101DE-1	B110, B145, B150	18.0	25.40	160.0	38.0	4	DIN 2184-1
		4.449						*.709*	*1.000*	*6.299*	*1.496*		

E28 E41 E45 E36 E59 E38

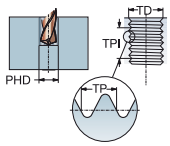
FIN

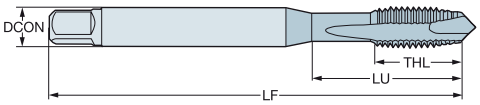
CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: UNC

DIN 2184-1/ANSI

ULDR 2.5
SUBSTRATE HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNC #2-56	56.00	11.99	.141 x .110	B	3BX	T200-XM100AE-2-56	C110, C145, C150	3.6	2.18	45.0	7.0	2	DIN 2184-1/ANSI
		.472						.141	.086	1.772	.276		
UNC #4-40	40.00	17.00	.141 x .110	B	3BX	T200-XM100AE-4-40	C110, C145, C150	3.6	2.84	56.0	9.5	3	DIN 2184-1/ANSI
		.669						.141	.112	2.205	.374		
UNC #5-40	40.00	17.50	.141 x .110	B	3BX	T200-XM100AE-5-40	C110, C145, C150	3.6	3.51	56.0	8.9	3	DIN 2184-1/ANSI
		.689						.141	.138	2.205	.350		
UNC #6-32	32.00	20.50	.141 x .110	B	3BX	T200-XM100AE-6-32	C110, C145, C150	3.6	3.51	56.0	11.6	3	DIN 2184-1/ANSI
		.807						.141	.138	2.205	.457		
UNC #8-32	32.00	21.50	.168 x .131	B	3BX	T200-XM100AE-8-32	C110, C145, C150	4.3	4.17	63.0	13.6	3	DIN 2184-1/ANSI
		.846						.168	.164	2.480	.535		
UNC #10-24	24.00	28.00	.194 x .152	B	3BX	T200-XM100AE-10-24	C110, C145, C150	4.9	4.83	70.0	14.8	3	DIN 2184-1/ANSI
		1.102						.194	.190	2.756	.583		
UNC #12-24	24.00	29.00	.220 x .165	B	3BX	T200-XM100AE-12-24	C110, C145, C150	5.6	5.49	80.0	14.0	3	DIN 2184-1/ANSI
		1.142						.220	.216	3.150	.551		
UNC 1/4-20	20.00	25.00	.255 x .191	B	3BX	T200-XM100AE-1/4	C110, C145, C150	6.5	6.35	80.0	15.9	3	DIN 2184-1/ANSI
		.984						.255	.250	3.150	.626		
UNC 5/16-18	18.00	34.00	.318 x .238	B	3BX	T200-XM100AE-5/16	C110, C145, C150	8.1	7.94	90.0	19.0	3	DIN 2184-1/ANSI
		1.339						.318	.313	3.543	.748		
UNC 3/8-16	16.00	38.50	.381 x .286	B	3BX	T200-XM100AE-3/8	C110, C145, C150	9.7	9.53	100.0	21.3	3	DIN 2184-1/ANSI
		1.516						.381	.375	3.937	.839		
UNC 7/16-14	14.00	72.59	.323 x .242	B	3BX	T200-XM101AE-7/16	C110, C145, C150	8.2	11.11	100.0	20.1	3	DIN 2184-1/ANSI
		2.858						.323	.438	3.937	.791		
UNC 1/2-13	13.00	81.82	.367 x .275	B	3BX	T200-XM101AE-1/2	C110, C145, C150	9.3	12.70	110.0	23.1	3	DIN 2184-1/ANSI
		3.221						.367	.500	4.331	.909		
UNC 9/16-12	12.00	80.30	.429 x .322	B	3BX	T200-XM101AE-9/16	C110, C145, C150	10.9	14.29	110.0	23.1	3	DIN 2184-1/ANSI
		3.161						.429	.563	4.331	.909		
UNC 5/8-11	11.00	65.78	.480 x .360	B	3BX	T200-XM101AE-5/8	C110, C145, C150	12.2	15.88	110.0	23.1	3	DIN 2184-1/ANSI
		2.590						.480	.625	4.331	.909		
UNC 3/4-10	10.00	77.47	.590 x .442	B	3BX	T200-XM101AE-3/4	C110, C145, C150	15.0	19.05	125.0	30.0	4	DIN 2184-1/ANSI
		3.050						.590	.750	4.921	1.181		
UNC 7/8-9	9.00	90.95	.697 x .523	B	3BX	T200-XM101AE-7/8	C110, C145, C150	17.7	22.23	140.0	34.0	4	DIN 2184-1/ANSI
		3.581						.697	.875	5.512	1.339		
UNC 1"-8	8.00	95.43	.800 x .600	B	3BX	T200-XM101AE-1	C110, C145, C150	20.3	25.40	160.0	36.1	4	DIN 2184-1/ANSI
		3.757						.800	1.000	6.299	1.421		

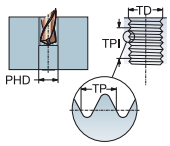
E28 E41 E45 E36 E59 E38

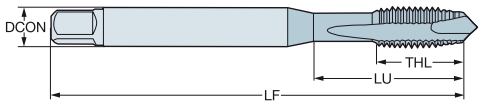
CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: UNF

DIN 2184-1

ULDR 2.5
SUBSTRATE HSS-PM





P M K N S

								Mitat, mm, tuumaa					
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	**Tilauskoodi**	GRADE	DCON	TD	LF	THL	NOF	BSG
UNF #8-36	36.00	21.00	4.50 x 3.40	B	2B	T200-XM100DF-8-36	C110, C145, C150	4.5	4.17	63.0	11.4	3	DIN 2184-1
		.827						*.177*	*.164*	*2.480*	*.449*		
UNF #10-32	32.00	25.00	6.00 x 4.90	B	2B	T200-XM100DF-10-32	C110, C145, C150	6.0	4.83	70.0	12.2	3	DIN 2184-1
		.984						*.236*	*.190*	*2.756*	*.480*		
UNF 1/4-28	28.00	30.00	7.00 x 5.50	B	2B	T200-XM100DF-1/4	C110, C145, C150	7.0	6.35	80.0	14.1	3	DIN 2184-1
		1.181						*.276*	*.250*	*3.150*	*.555*		
UNF 5/16-24	24.00	35.00	8.00 x 6.20	B	2B	T200-XM100DF-5/16	C110, C145, C150	8.0	7.94	90.0	17.4	3	DIN 2184-1
		1.378						*.315*	*.313*	*3.543*	*.685*		
UNF 3/8-24	24.00	39.00	10.00 x 8.00	B	2B	T200-XM100DF-3/8	C110, C145, C150	10.0	9.53	100.0	18.9	3	DIN 2184-1
		1.535						*.394*	*.375*	*3.937*	*.744*		
UNF 7/16-20	20.00	76.00	8.00 x 6.20	B	2B	T200-XM101DF-7/16	C110, C145, C150	8.0	11.11	100.0	20.0	3	DIN 2184-1
		2.992						*.315*	*.438*	*3.937*	*.787*		
UNF 1/2-20	20.00	83.00	9.00 x 7.00	B	2B	T200-XM101DF-1/2	C110, C145, C150	9.0	12.70	110.0	23.0	3	DIN 2184-1
		3.268						*.354*	*.500*	*4.331*	*.906*		
UNF 5/8-18	18.00	68.00	12.00 x 9.00	B	2B	T200-XM101DF-5/8	C110, C145, C150	12.0	15.88	110.0	25.0	3	DIN 2184-1
		2.677						*.472*	*.625*	*4.331*	*.984*		
UNF 3/4-16	16.00	81.00	14.00 x 11.00	B	2B	T200-XM101DF-3/4	B110, B145, B150	14.0	19.05	125.0	30.0	4	DIN 2184-1
		3.189						*.551*	*.750*	*4.921*	*1.181*		
UNF 7/8-14	14.00	93.00	18.00 x 14.50	B	2B	T200-XM101DF-7/8	B110, B145, B150	18.0	22.23	140.0	34.0	4	DIN 2184-1
		3.661						*.709*	*.875*	*5.512*	*1.339*		
UNF 1"-12	12.00	113.00	18.00 x 14.50	B	2B	T200-XM101DF-1	B110, B145, B150	18.0	25.40	160.0	38.0	4	DIN 2184-1
		4.449						*.709*	*1.000*	*6.299*	*1.496*		

E28 E41 E45 E36 E59 E38

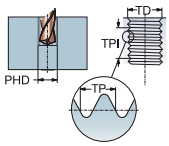
FIN

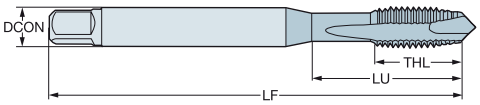
CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: UNF

DIN 2184-1/ANSI

ULDR 2.5
SUBSTRATE HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNF #4-48	48.00	17.00	.141 x .110	B	3BX	T200-XM100AF-4-48	C110, C145, C150	3.6	2.84	56.0	9.4	3	DIN 2184-1/ANSI
		.669						*.141*	*.112*	*2.205*	*.370*		
UNF #6-40	40.00	20.50	.141 x .110	B	3BX	T200-XM100AF-6-40	C110, C145, C150	3.6	3.51	56.0	11.5	3	DIN 2184-1/ANSI
		.807						*.141*	*.138*	*2.205*	*.453*		
UNF #8-36	36.00	21.50	.168 x .131	B	3BX	T200-XM100AF-8-36	C110, C145, C150	4.3	4.17	63.0	13.5	3	DIN 2184-1/ANSI
		.846						*.168*	*.164*	*2.480*	*.531*		
UNF #10-32	32.00	28.00	.194 x .152	B	3BX	T200-XM100AF-10-32	C110, C145, C150	4.9	4.83	70.0	14.7	3	DIN 2184-1/ANSI
		1.102						*.194*	*.190*	*2.756*	*.579*		
UNF #12-28	28.00	29.00	.220 x .165	B	3BX	T200-XM100AF-12-28	C110, C145, C150	5.6	5.49	80.0	14.0	3	DIN 2184-1/ANSI
		1.142						*.220*	*.216*	*3.150*	*.551*		
UNF 1/4-28	28.00	25.00	.255 x .191	B	3BX	T200-XM100AF-1/4	C110, C145, C150	6.5	6.35	80.0	15.7	3	DIN 2184-1/ANSI
		.984						*.255*	*.250*	*3.150*	*.618*		
UNF 5/16-24	24.00	34.00	.318 x .238	B	3BX	T200-XM100AF-5/16	C110, C145, C150	8.1	7.94	90.0	18.8	3	DIN 2184-1/ANSI
		1.339						*.318*	*.313*	*3.543*	*.740*		
UNF 3/8-24	24.00	37.50	.381 x .286	B	3BX	T200-XM100AF-3/8	C110, C145, C150	9.7	9.53	90.0	20.1	3	DIN 2184-1/ANSI
		1.476						*.381*	*.375*	*3.543*	*.791*		
UNF 7/16-20	20.00	72.59	.323 x .242	B	3BX	T200-XM101AF-7/16	C110, C145, C150	8.2	11.11	100.0	20.1	3	DIN 2184-1/ANSI
		2.858						*.323*	*.438*	*3.937*	*.791*		
UNF 1/2-20	20.00	71.82	.367 x .275	B	3BX	T200-XM101AF-1/2	C110, C145, C150	9.3	12.70	100.0	21.1	3	DIN 2184-1/ANSI
		2.828						*.367*	*.500*	*3.937*	*.831*		
UNF 9/16-18	18.00	70.30	.429 x .322	B	3BX	T200-XM101AF-9/16	C110, C145, C150	10.9	14.29	100.0	21.1	3	DIN 2184-1/ANSI
		2.768						*.429*	*.563*	*3.937*	*.831*		
UNF 5/8-18	18.00	55.78	.480 x .360	B	3BX	T200-XM101AF-5/8	C110, C145, C150	12.2	15.88	100.0	21.1	3	DIN 2184-1/ANSI
		2.196						*.480*	*.625*	*3.937*	*.831*		
UNF 3/4-16	16.00	62.47	.590 x .442	B	3BX	T200-XM101AF-3/4	C110, C145, C150	15.0	19.05	110.0	23.9	4	DIN 2184-1/ANSI
		2.459						*.590*	*.750*	*4.331*	*.941*		
UNF 7/8-14	14.00	75.95	.697 x .523	B	3BX	T200-XM101AF-7/8	C110, C145, C150	17.7	22.23	125.0	23.9	4	DIN 2184-1/ANSI
		2.990						*.697*	*.875*	*4.921*	*.941*		
UNF 1"-12	12.00	75.43	.800 x .600	B	3BX	T200-XM101AF-1-12	C110, C145, C150	20.3	25.40	140.0	26.9	4	DIN 2184-1/ANSI
		2.970						*.800*	*1.000*	*5.512*	*1.059*		

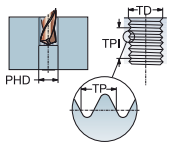
E28 E41 E45 E36 E59 E38

CoroTap™ 200 kierretappi, lastua työntävä läpireikä

Kierremuoto: G

DIN 5156

ULDR 2.5
SUBSTRATE HSS-PM



P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	Mitat, mm, tuumaa DCON	TD	LF	THL	NOF	BSG
G 1/8-28	28.00	67.00	7.00 x 5.50	B	NORMAL	T200-XM100DK-1/8	C110, C145, C150	7.0	9.73	90.0	18.0	3	DIN 5156
		2.638						*.276*	*.383*	*3.543*	*.709*		
G 1/4-19	19.00	71.00	11.00 x 9.00	B	NORMAL	T200-XM100DK-1/4	C110, C145, C150	11.0	13.16	100.0	21.0	3	DIN 5156
		2.795						*.433*	*.518*	*3.937*	*.827*		
G 3/8-19	19.00	58.00	12.00 x 9.00	B	NORMAL	T200-XM100DK-3/8	C110, C145, C150	12.0	16.66	100.0	21.0	4	DIN 5156
		2.283						*.472*	*.656*	*3.937*	*.827*		
G 1/2-14	14.00	80.00	16.00 x 12.00	B	NORMAL	T200-XM100DK-1/2	B110, B145, B150	16.0	20.96	125.0	24.0	4	DIN 5156
		3.150						*.630*	*.825*	*4.921*	*.945*		
G 5/8-14	14.00	78.00	18.00 x 14.50	B	NORMAL	T200-XM100DK-5/8	B110, B145, B150	18.0	22.91	125.0	24.0	4	DIN 5156
		3.071						*.709*	*.902*	*4.921*	*.945*		
G 3/4-14	14.00	77.00	20.00 x 16.00	B	NORMAL	T200-XM100DK-3/4	B110, B145, B150	20.0	26.44	140.0	28.0	4	DIN 5156
		3.032						*.787*	*1.041*	*5.512*	*1.102*		
G 7/8-14	14.00	85.00	22.00 x 18.00	B	NORMAL	T200-XM100DK-7/8	B110, B145, B150	22.0	30.20	150.0	28.0	4	DIN 5156
		3.346						*.866*	*1.189*	*5.906*	*1.102*		
G 1"-11	11.00	93.00	25.00 x 20.00	B	NORMAL	T200-XM100DK-1	B110, B145, B150	25.0	33.25	160.0	30.0	4	DIN 5156
		3.661						*.984*	*1.309*	*6.299*	*1.181*		

E28 E41 E45 E36 E59 E38

CoroTap™ 300

Käyttöalueet

- Soveltuu pohjareikien kierteitykseen
- Laaja valikoima eri kierremuotoja ja standardeja
- Syvyys maks. 3 x halkaisija

ISO-käyttöalueet:

P M K N S

Edut ja ominaisuudet

- Lastu-uran malli varmistaa tasaisen rintakulman ja lastuamisen jatkuvuuden
- Kierukkakulmaltaan isojen tappien takaviiste pienentää vääntömomenttia ja teräsärmien murtumia
- Iso kierukkakulma tehostaa lastunpoistoa ja parantaa mahdollisuuksia kierteittää pohjareikiä jopa syvyydelle 3 × halkaisija
- Pieni kierukkakulma parantaa särmälujuutta ja sopii lyhyiksi katkeavien lastujen ansiosta sitkeiden materiaalien ja pohjareikien kierteitykseen
- Pulveripikateräksisten kierretappien valtteja ovat lujuus, kulumiskestävyys ja kestoikä
- Täyskovametallisilla kierretapeilla saadaan pitkä kestoikä ja hyvä tuottavuus

- Kierretapit joissa hiotut nousevat urat
- Nousevat urat johtavat ulos reiästä
- Paras vaihtoehto pohjareikiin
- Eri nousukulmia eri tarkoituksiin
- Uraa käytetään sekä lastuamisnesteen syöttöön että lastunpoistoon
- Eri kierteityssyvyyksiä työstä ja geometriasta riippuen

C

Räätälöidyt ratkaisut, sivu E36

www.sandvik.coromant.com/corotap300

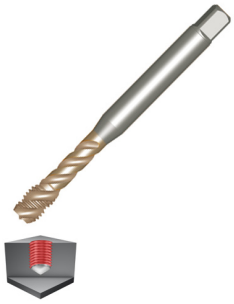
CoroChuck™ 970 -istukat Pyörivät työkalut -luettelossa.

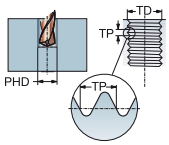
CoroTap™ 300 -kierretappi, nousevat lastu-urat

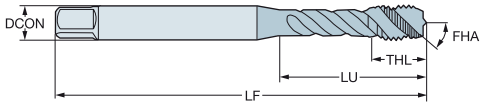
Kierremuoto: metrinen

DIN 371, DIN 376

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM







P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
M 2	0.40	9.00	2.80 x 2.10	C	6H	T300-XM100DA-M2	C110, C145, C150	2.8	2.00	45.0	4.0	3	DIN 371
		.354						.110	.079	1.772	.157		
M 2.5	0.45	12.50	2.80 x 2.10	C	6H	T300-XM100DA-M2.5	C110, C145, C150	2.8	2.50	50.0	4.0	3	DIN 371
		.492						.110	.098	1.969	.157		
M 3	0.50	18.00	3.50 x 2.70	C	6H	T300-XM100DA-M3	C110, C145, C150	3.5	3.00	56.0	5.9	3	DIN 371
		.709						.138	.118	2.205	.232		
M 3.5	0.60	20.00	4.00 x 3.00	C	6H	T300-XM100DA-M3.5	C110, C145, C150	4.0	3.50	56.0	6.3	3	DIN 371
		.787						.157	.138	2.205	.248		
M 4	0.70	21.00	4.50 x 3.40	C	6H	T300-XM100DA-M4	C110, C145, C150	4.5	4.00	63.0	6.7	3	DIN 371
		.827						.177	.157	2.480	.264		
M 5	0.80	21.00	6.00 x 4.90	C	6H	T300-XM100DA-M5	C110, C145, C150	6.0	5.00	70.0	7.7	3	DIN 371
		.827						.236	.197	2.756	.303		
M 6	1.00	31.00	6.00 x 4.90	C	6H	T300-XM100DA-M6	C110, C145, C150	6.0	6.00	80.0	10.0	3	DIN 371
		1.220						.236	.236	3.150	.394		
M 7	1.00	31.00	7.00 x 5.50	C	6H	T300-XM100DA-M7	C110, C145, C150	7.0	7.00	80.0	10.0	3	DIN 371
		1.220						.276	.276	3.150	.394		
M 8	1.25	35.00	8.00 x 6.20	C	6H	T300-XM100DA-M8	C110, C145, C150	8.0	8.00	90.0	11.6	3	DIN 371
		1.378						.315	.315	3.543	.457		
M 10	1.50	39.00	10.00 x 8.00	C	6H	T300-XM100DA-M10	C110, C145, C150	10.0	10.00	100.0	15.1	3	DIN 371
		1.535						.394	.394	3.937	.594		
M 6	1.00	59.00	4.50 x 3.40	C	6H	T300-XM101DA-M6	C110, C145, C150	4.5	6.00	80.0	10.0	3	DIN 376
		2.323						.177	.236	3.150	.394		
M 8	1.25	67.00	6.00 x 4.90	C	6H	T300-XM101DA-M8	C110, C145, C150	6.0	8.00	90.0	12.0	3	DIN 376
		2.638						.236	.315	3.543	.472		
M 10	1.50	77.00	7.00 x 5.50	C	6H	T300-XM101DA-M10	C110, C145, C150	7.0	10.00	100.0	15.0	3	DIN 376
		3.032						.276	.394	3.937	.591		
M 12	1.75	83.00	9.00 x 7.00	C	6H	T300-XM101DA-M12	C110, C145, C150	9.0	12.00	110.0	16.0	3	DIN 376
		3.268						.354	.472	4.331	.630		
M 14	2.00	81.00	11.00 x 9.00	C	6H	T300-XM101DA-M14	C110, C145, C150	11.0	14.00	110.0	20.0	3	DIN 376
		3.189						.433	.551	4.331	.787		
M 16	2.00	68.00	12.00 x 9.00	C	6H	T300-XM101DA-M16	C110, C145, C150	12.0	16.00	110.0	20.0	4	DIN 376
		2.677						.472	.630	4.331	.787		
M 18	2.50	81.00	14.00 x 11.00	C	6H	T300-XM101DA-M18	B110, B145, B150	14.0	18.00	125.0	25.0	4	DIN 376
		3.189						.551	.709	4.921	.984		
M 20	2.50	95.00	16.00 x 12.00	C	6H	T300-XM101DA-M20	B110, B145, B150	16.0	20.00	140.0	25.0	4	DIN 376
		3.740						.630	.787	5.512	.984		
M 22	2.50	93.00	18.00 x 14.50	C	6H	T300-XM101DA-M22	B110, B145, B150	18.0	22.00	140.0	25.0	4	DIN 376
		3.661						.709	.866	5.512	.984		
M 24	3.00	113.00	18.00 x 14.50	C	6H	T300-XM101DA-M24	B110, B145, B150	18.0	24.00	160.0	30.0	4	DIN 376
		4.449						.709	.945	6.299	1.181		
M 27	3.00	97.00	20.00 x 16.00	C	6H	T300-XM101DA-M27	B110, B145, B150	20.0	27.00	160.0	30.0	4	DIN 376
		3.819						.787	1.063	6.299	1.181		
M 30	3.50	115.00	22.00 x 18.00	C	6H	T300-XM101DA-M30	B110, B145, B150	22.0	30.00	180.0	36.0	4	DIN 376
		4.528						.866	1.181	7.087	1.417		
M 33	3.50	113.00	25.00 x 20.00	C	6H	T300-XM101DA-M33	B110, B145, B150	25.0	33.00	180.0	36.0	4	DIN 376
		4.449						.984	1.299	7.087	1.417		
M 36	4.00	131.00	28.00 x 22.00	C	6H	T300-XM101DA-M36	B110, B145, B150	28.0	36.00	200.0	40.0	4	DIN 376
		5.157						1.102	1.417	7.874	1.575		
M 39	4.00	102.00	32.00 x 24.00	C	6H	T300-XM101DA-M39	B145, B150	32.0	39.00	200.0	40.0	4	DIN 376
		4.016						1.260	1.535	7.874	1.575		

E30 E41 E45 E36 E59 E38

SANDVIK Coromant

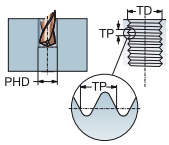
FIN

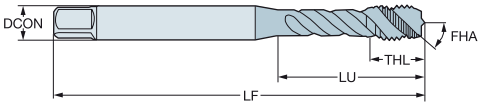
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: metrinen

DIN 371, DIN 376

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	Mitat, mm, tuumaa DCON	TD	LF	THL	NOF	BSG
M 42	4.50	102.00	32.00 x 24.00	C	6H	T300-XM101DA-M42	B145, B150	32.0	42.00	200.0	45.0	4	DIN 376
		4.016						*1.260*	*1.654*	*7.874*	*1.772*		
M 48	5.00	147.00	36.00 x 29.00	C	6H	T300-XM101DA-M48	B145, B150	36.0	48.00	250.0	50.0	4	DIN 376
		5.787						*1.417*	*1.890*	*9.843*	*1.969*		
M 52	5.00	120.00	40.00 x 32.00	C	6H	T300-XM101DA-M52	B145, B150	40.0	52.00	250.0	50.0	5	DIN 376
		4.724						*1.575*	*2.047*	*9.843*	*1.969*		
M 56	5.50	120.00	40.00 x 32.00	C	6H	T300-XM101DA-M56	B145, B150	40.0	56.00	250.0	55.0	5	DIN 376
		4.724						*1.575*	*2.205*	*9.843*	*2.165*		
M 64	6.00	178.00	50.00 x 39.00	C	6H	T300-XM101DA-M64	B145, B150	50.0	64.00	315.0	60.0	6	DIN 376
		7.008						*1.969*	*2.520*	*12.402*	*2.362*		
M 3	0.50	18.00	3.50 x 2.70	E	6H	T300-XM102DA-M3	C110, C145, C150	3.5	3.00	56.0	5.9	3	DIN 371
		.709						*.138*	*.118*	*2.205*	*.232*		
M 4	0.70	21.00	4.50 x 3.40	E	6H	T300-XM102DA-M4	C110, C145, C150	4.5	4.00	63.0	6.7	3	DIN 371
		.827						*.177*	*.157*	*2.480*	*.264*		
M 5	0.80	21.00	6.00 x 4.90	E	6H	T300-XM102DA-M5	C110, C145, C150	6.0	5.00	70.0	7.7	3	DIN 371
		.827						*.236*	*.197*	*2.756*	*.303*		
M 6	1.00	31.00	6.00 x 4.90	E	6H	T300-XM102DA-M6	C110, C145, C150	6.0	6.00	80.0	10.0	3	DIN 371
		1.220						*.236*	*.236*	*3.150*	*.394*		
M 8	1.25	35.00	8.00 x 6.20	E	6H	T300-XM102DA-M8	C110, C145, C150	8.0	8.00	90.0	11.6	3	DIN 371
		1.378						*.315*	*.315*	*3.543*	*.457*		
M 10	1.50	39.00	10.00 x 8.00	E	6H	T300-XM102DA-M10	C110, C145, C150	10.0	10.00	100.0	15.1	3	DIN 371
		1.535						*.394*	*.394*	*3.937*	*.594*		
M 12	1.75	83.00	9.00 x 7.00	E	6H	T300-XM103DA-M12	C110, C145, C150	9.0	12.00	110.0	16.0	3	DIN 376
		3.268						*.354*	*.472*	*4.331*	*.630*		
M 14	2.00	81.00	11.00 x 9.00	E	6H	T300-XM103DA-M14	C110, C145, C150	11.0	14.00	110.0	20.0	3	DIN 376
		3.189						*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	68.00	12.00 x 9.00	E	6H	T300-XM103DA-M16	C110, C145, C150	12.0	16.00	110.0	20.0	4	DIN 376
		2.677						*.472*	*.630*	*4.331*	*.787*		
M 20	2.50	95.00	16.00 x 12.00	E	6H	T300-XM103DA-M20	B110, B145, B150	16.0	20.00	140.0	25.0	4	DIN 376
		3.740						*.630*	*.787*	*5.512*	*.984*		
M 3	0.50	18.00	3.50 x 2.70	C	6G	T300-XM104DA-M3	C110, C145, C150	3.5	3.00	56.0	5.9	3	DIN 371
		.709						*.138*	*.118*	*2.205*	*.232*		
M 4	0.70	21.00	4.50 x 3.40	C	6G	T300-XM104DA-M4	C110, C145, C150	4.5	4.00	63.0	6.7	3	DIN 371
		.827						*.177*	*.157*	*2.480*	*.264*		
M 5	0.80	25.00	6.00 x 4.90	C	6G	T300-XM104DA-M5	C110, C145, C150	6.0	5.00	70.0	7.7	3	DIN 371
		.984						*.236*	*.197*	*2.756*	*.303*		
M 6	1.00	31.00	6.00 x 4.90	C	6G	T300-XM104DA-M6	C110, C145, C150	6.0	6.00	80.0	10.0	3	DIN 371
		1.220						*.236*	*.236*	*3.150*	*.394*		
M 8	1.25	35.00	8.00 x 6.20	C	6G	T300-XM104DA-M8	C110, C145, C150	8.0	8.00	90.0	12.0	3	DIN 371
		1.378						*.315*	*.315*	*3.543*	*.472*		
M 10	1.50	39.00	10.00 x 8.00	C	6G	T300-XM104DA-M10	C110, C145, C150	10.0	10.00	100.0	15.1	3	DIN 371
		1.535						*.394*	*.394*	*3.937*	*.594*		
M 12	1.75	83.00	9.00 x 7.00	C	6G	T300-XM105DA-M12	C110, C145, C150	9.0	12.00	110.0	16.0	3	DIN 376
		3.268						*.354*	*.472*	*4.331*	*.630*		
M 14	2.00	81.00	11.00 x 9.00	C	6G	T300-XM105DA-M14	C110, C145, C150	11.0	14.00	110.0	20.0	3	DIN 376
		3.189						*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	68.00	12.00 x 9.00	C	6G	T300-XM105DA-M16	C110, C145, C150	12.0	16.00	110.0	20.0	4	DIN 376
		2.677						*.472*	*.630*	*4.331*	*.787*		
M 20	2.50	95.00	16.00 x 12.00	C	6G	T300-XM105DA-M20	B110, B145, B150	16.0	20.00	140.0	25.0	4	DIN 376
		3.740						*.630*	*.787*	*5.512*	*.984*		

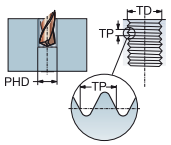
E30 E41 E45 E36 E59 E38

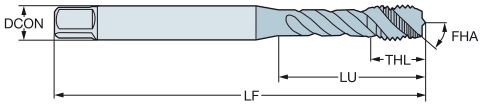
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: metrinen

DIN 371/ANSI, DIN 376/ANSI

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
M 4	0.70	21.50	.194 x .152	C	6H	T300-XM100AA-M4	C110, C145, C150	4.9	4.00	63.0	8.4	3	DIN 371/ANSI
		.846						*.194*	*.157*	*2.480*	*.331*		
M 5	0.80	28.00	.194 x .152	C	6H	T300-XM100AA-M5	C110, C145, C150	4.9	5.00	70.0	8.6	3	DIN 371/ANSI
		1.102						*.194*	*.197*	*2.756*	*.339*		
M 6	1.00	25.50	.255 x .191	C	6H	T300-XM100AA-M6	C110, C145, C150	6.5	6.00	80.0	11.4	3	DIN 371/ANSI
		1.004						*.255*	*.236*	*3.150*	*.449*		
M 8	1.25	33.50	.318 x .238	C	6H	T300-XM100AA-M8	C110, C145, C150	8.1	8.00	90.0	12.9	3	DIN 371/ANSI
		1.319						*.318*	*.315*	*3.543*	*.508*		
M 10	1.50	38.50	.381 x .286	C	6H	T300-XM100AA-M10	C110, C145, C150	9.7	10.00	100.0	16.1	3	DIN 371/ANSI
		1.516						*.381*	*.394*	*3.937*	*.634*		
M 12	1.75	81.82	.367 x .275	C	6H	T300-XM101AA-M12	C110, C145, C150	9.3	12.00	110.0	18.0	3	DIN 376/ANSI
		3.221						*.367*	*.472*	*4.331*	*.709*		
M 14	2.00	80.30	.429 x .322	C	6H	T300-XM101AA-M14	C110, C145, C150	10.9	14.00	110.0	20.1	3	DIN 376/ANSI
		3.161						*.429*	*.551*	*4.331*	*.791*		
M 16	2.00	65.78	.480 x .360	C	6H	T300-XM101AA-M16	C110, C145, C150	12.2	16.00	110.0	20.1	4	DIN 376/ANSI
		2.590						*.480*	*.630*	*4.331*	*.791*		
M 18	2.50	79.00	.542 x .406	C	6H	T300-XM101AA-M18	C110, C145, C150	13.8	18.00	125.0	24.9	4	DIN 376/ANSI
		3.110						*.542*	*.709*	*4.921*	*.980*		
M 20	2.50	92.47	.652 x .489	C	6H	T300-XM101AA-M20	C110, C145, C150	16.6	20.00	140.0	24.9	4	DIN 376/ANSI
		3.641						*.652*	*.787*	*5.512*	*.980*		
M 4	0.70	21.50	.168 x .131	E	6H	T300-XM102AA-M4	C110, C145, C150	4.3	4.00	63.0	8.4	3	DIN 371/ANSI
		.846						*.168*	*.157*	*2.480*	*.331*		
M 5	0.80	28.00	.194 x .152	E	6H	T300-XM102AA-M5	C110, C145, C150	4.9	5.00	70.0	8.6	3	DIN 371/ANSI
		1.102						*.194*	*.197*	*2.756*	*.339*		
M 6	1.00	25.50	.255 x .191	E	6H	T300-XM102AA-M6	C110, C145, C150	6.5	6.00	80.0	11.4	3	DIN 371/ANSI
		1.004						*.255*	*.236*	*3.150*	*.449*		
M 8	1.25	33.50	.318 x .238	E	6H	T300-XM102AA-M8	C110, C145, C150	8.1	8.00	90.0	12.9	3	DIN 371/ANSI
		1.319						*.318*	*.315*	*3.543*	*.508*		
M 10	1.50	38.50	.381 x .286	E	6H	T300-XM102AA-M10	C110, C145, C150	9.7	10.00	100.0	16.1	3	DIN 371/ANSI
		1.516						*.381*	*.394*	*3.937*	*.634*		
M 12	1.75	81.82	.367 x .275	E	6H	T300-XM103AA-M12	C110, C145, C150	9.3	12.00	110.0	18.0	3	DIN 376/ANSI
		3.221						*.367*	*.472*	*4.331*	*.709*		
M 14	2.00	80.30	.429 x .322	E	6H	T300-XM103AA-M14	C110, C145, C150	10.9	14.00	110.0	20.1	3	DIN 376/ANSI
		3.161						*.429*	*.551*	*4.331*	*.791*		
M 16	2.00	65.78	.480 x .360	E	6H	T300-XM103AA-M16	C110, C145, C150	12.2	16.00	110.0	20.1	4	DIN 376/ANSI
		2.590						*.480*	*.630*	*4.331*	*.791*		
M 18	2.50	79.00	.542 x .406	E	6H	T300-XM103AA-M18	C110, C145, C150	13.8	18.00	125.0	24.9	4	DIN 376/ANSI
		3.110						*.542*	*.709*	*4.921*	*.980*		
M 20	2.50	92.47	.652 x .489	E	6H	T300-XM103AA-M20	C110, C145, C150	16.6	20.00	140.0	24.9	4	DIN 376/ANSI
		3.641						*.652*	*.787*	*5.512*	*.980*		

E30 E41 E45 E36 E59 E38

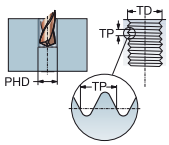
FIN

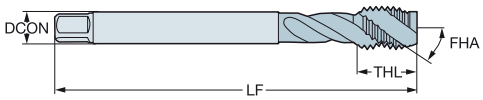
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: metrinen taajakierre

DIN 374

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
MF 4x0.5	0.50	43.00	2.80 x 2.10	C	6H	T300-XM100DB-M4X050	C110, C145, C150	2.8	4.00	63.0	6.8	3	DIN 374
		1.693						*.110*	*.157*	*2.480*	*.268*		
MF 5x0.5	0.50	49.00	3.50 x 2.70	C	6H	T300-XM100DB-M5X050	C110, C145, C150	3.5	5.00	70.0	8.2	3	DIN 374
		1.929						*.138*	*.197*	*2.756*	*.323*		
MF 6x0.75	0.75	59.00	4.50 x 3.40	C	6H	T300-XM100DB-M6X075	C110, C145, C150	4.5	6.00	80.0	10.0	3	DIN 374
		2.323						*.177*	*.236*	*3.150*	*.394*		
MF 8x0.75	0.75	57.00	6.00 x 4.90	C	6H	T300-XM100DB-M8X075	C110, C145, C150	6.0	8.00	80.0	13.0	3	DIN 374
		2.244						*.236*	*.315*	*3.150*	*.512*		
MF 8x1	1.00	67.00	6.00 x 4.90	C	6H	T300-XM100DB-M8X100	C110, C145, C150	6.0	8.00	90.0	13.0	3	DIN 374
		2.638						*.236*	*.315*	*3.543*	*.512*		
MF 10x0.75	0.75	67.00	7.00 x 5.50	C	6H	T300-XM100DB-M10X075	C110, C145, C150	7.0	10.00	90.0	13.0	3	DIN 374
		2.638						*.276*	*.394*	*3.543*	*.512*		
MF 10x1	1.00	67.00	7.00 x 5.50	C	6H	T300-XM100DB-M10X100	C110, C145, C150	7.0	10.00	90.0	13.0	3	DIN 374
		2.638						*.276*	*.394*	*3.543*	*.512*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6H	T300-XM100DB-M10X125	C110, C145, C150	7.0	10.00	100.0	15.0	3	DIN 374
		3.032						*.276*	*.394*	*3.937*	*.591*		
MF 12x1	1.00	73.00	9.00 x 7.00	C	6H	T300-XM100DB-M12X100	C110, C145, C150	9.0	12.00	100.0	15.0	3	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.591*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6H	T300-XM100DB-M12X125	C110, C145, C150	9.0	12.00	100.0	15.0	3	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.591*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6H	T300-XM100DB-M12X150	C110, C145, C150	9.0	12.00	100.0	15.0	3	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.591*		
MF 14x1	1.00	71.00	11.00 x 9.00	C	6H	T300-XM100DB-M14X100	C110, C145, C150	11.0	14.00	100.0	15.0	3	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.591*		
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6H	T300-XM100DB-M14X125	C110, C145, C150	11.0	14.00	100.0	15.0	3	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.591*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6H	T300-XM100DB-M14X150	C110, C145, C150	11.0	14.00	100.0	15.0	3	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.591*		
MF 16x1	1.00	58.00	12.00 x 9.00	C	6H	T300-XM100DB-M16X100	C110, C145, C150	12.0	16.00	100.0	15.0	4	DIN 374
		2.283						*.472*	*.630*	*3.937*	*.591*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6H	T300-XM100DB-M16X150	C110, C145, C150	12.0	16.00	100.0	15.0	4	DIN 374
		2.283						*.472*	*.630*	*3.937*	*.591*		
MF 18x1	1.00	66.00	14.00 x 11.00	C	6H	T300-XM100DB-M18X100	B110, B145, B150	14.0	18.00	110.0	17.0	4	DIN 374
		2.598						*.551*	*.709*	*4.331*	*.669*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6H	T300-XM100DB-M18X150	B110, B145, B150	14.0	18.00	110.0	17.0	4	DIN 374
		2.598						*.551*	*.709*	*4.331*	*.669*		
MF 20x1	1.00	80.00	16.00 x 12.00	C	6H	T300-XM100DB-M20X100	B110, B145, B150	16.0	20.00	125.0	17.0	4	DIN 374
		3.150						*.630*	*.787*	*4.921*	*.669*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6H	T300-XM100DB-M20X150	B110, B145, B150	16.0	20.00	125.0	17.0	4	DIN 374
		3.150						*.630*	*.787*	*4.921*	*.669*		
MF 22x1.5	1.50	78.00	18.00 x 14.50	C	6H	T300-XM100DB-M22X150	B110, B145, B150	18.0	22.00	125.0	17.0	4	DIN 374
		3.071						*.709*	*.866*	*4.921*	*.669*		
MF 24x1.5	1.50	93.00	18.00 x 14.50	C	6H	T300-XM100DB-M24X150	B110, B145, B150	18.0	24.00	140.0	20.0	4	DIN 374
		3.661						*.709*	*.945*	*5.512*	*.787*		

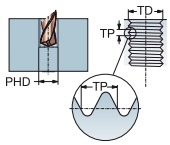
E30 E41 E45 E36 E59 E38

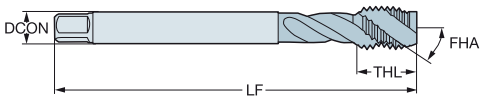
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: metrinen taajakierre

DIN 374

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
MF 24x2	2.00	93.00	18.00 x 14.50	C	6H	T300-XM100DB-M24X200	B110, B145, B150	18.0	24.00	140.0	20.0	4	DIN 374
		3.661						*.709*	*.945*	*5.512*	*.787*		
MF 25x1.5	1.50	93.00	18.00 x 14.50	C	6H	T300-XM100DB-M25X150	B110, B145, B150	18.0	25.00	140.0	20.0	4	DIN 374
		3.661						*.709*	*.984*	*5.512*	*.787*		
MF 26x1.5	1.50	93.00	18.00 x 14.50	C	6H	T300-XM100DB-M26X150	B110, B145, B150	18.0	26.00	140.0	20.0	4	DIN 374
		3.661						*.709*	*1.024*	*5.512*	*.787*		
MF 27x1.5	1.50	77.00	20.00 x 16.00	C	6H	T300-XM100DB-M27X150	B110, B145, B150	20.0	27.00	140.0	20.0	4	DIN 374
		3.032						*.787*	*1.063*	*5.512*	*.787*		
MF 27x2	2.00	77.00	20.00 x 16.00	C	6H	T300-XM100DB-M27X200	B110, B145, B150	20.0	27.00	140.0	20.0	4	DIN 374
		3.032						*.787*	*1.063*	*5.512*	*.787*		
MF 28x1.5	1.50	77.00	20.00 x 16.00	C	6H	T300-XM100DB-M28X150	B110, B145, B150	20.0	28.00	140.0	20.0	4	DIN 374
		3.032						*.787*	*1.102*	*5.512*	*.787*		
MF 30x1.5	1.50	85.00	22.00 x 18.00	C	6H	T300-XM100DB-M30X150	B110, B145, B150	22.0	30.00	150.0	20.0	4	DIN 374
		3.346						*.866*	*1.181*	*5.906*	*.787*		
MF 30x2	2.00	85.00	22.00 x 18.00	C	6H	T300-XM100DB-M30X200	B110, B145, B150	22.0	30.00	150.0	20.0	4	DIN 374
		3.346						*.866*	*1.181*	*5.906*	*.787*		

E30 E41 E45 E36 E59 E38

SANDVIK Coromant

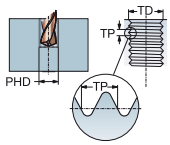
FIN

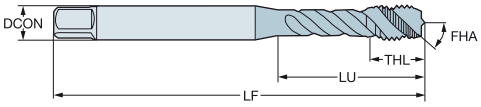
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: metrinen taajakierre

DIN 374/ANSI

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
MF 8x1	1.00	33.50	.318 x .238	C	6H	T300-XM100AB-M8X100	C110, C145, C150	8.1	8.00	90.0	12.8	3	DIN 374/ANSI
		1.319						*.318*	*.315*	*3.543*	*.504*		
MF 10x1	1.00	37.50	.381 x .286	C	6H	T300-XM100AB-M10X100	C110, C145, C150	9.7	10.00	90.0	13.0	3	DIN 374/ANSI
		1.476						*.381*	*.394*	*3.543*	*.512*		
MF 14x1.5	1.50	70.30	.429 x .322	C	6H	T300-XM101AB-M14X150	C110, C145, C150	10.9	14.00	100.0	15.0	3	DIN 374/ANSI
		2.768						*.429*	*.551*	*3.937*	*.591*		
MF 18x1.5	1.50	64.00	.542 x .406	C	6H	T300-XM101AB-M18X150	C110, C145, C150	13.8	18.00	110.0	17.0	4	DIN 374/ANSI
		2.520						*.542*	*.709*	*4.331*	*.669*		
MF 8x1	1.00	33.50	.318 x .238	E	6H	T300-XM102AB-M8X100	C110, C145, C150	8.1	8.00	90.0	12.8	3	DIN 374/ANSI
		1.319						*.318*	*.315*	*3.543*	*.504*		
MF 10x1	1.00	37.50	.381 x .286	E	6H	T300-XM102AB-M10X100	C110, C145, C150	9.7	10.00	90.0	13.0	3	DIN 374/ANSI
		1.476						*.381*	*.394*	*3.543*	*.512*		
MF 14x1.5	1.50	70.30	.429 x .322	E	6H	T300-XM103AB-M14X150	C110, C145, C150	10.9	14.00	100.0	15.0	3	DIN 374/ANSI
		2.768						*.429*	*.551*	*3.937*	*.591*		
MF 18x1.5	1.50	64.00	.542 x .406	E	6H	T300-XM103AB-M18X150	C110, C145, C150	13.8	18.00	110.0	17.0	4	DIN 374/ANSI
		2.520						*.542*	*.709*	*4.331*	*.669*		

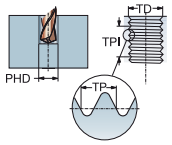
E30 E41 E45 E36 E59 E38

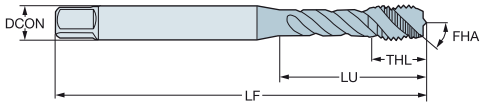
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: UNC

DIN 2184-1

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNC #4-40	40.00	18.00	3.50 x 2.70	C	2B	T300-XM100DE-4-40	C110, C145, C150	3.5	2.84	56.0	5.6	3	DIN 2184-1
		.709						*.138*	*.112*	*2.205*	*.220*		
UNC #5-40	40.00	18.00	3.50 x 2.70	C	2B	T300-XM100DE-5-40	C110, C145, C150	3.5	3.18	56.0	5.6	3	DIN 2184-1
		.709						*.138*	*.125*	*2.205*	*.220*		
UNC #6-32	32.00	20.00	4.00 x 3.00	C	2B	T300-XM100DE-6-32	C110, C145, C150	4.0	3.51	56.0	6.5	3	DIN 2184-1
		.787						*.157*	*.138*	*2.205*	*.256*		
UNC #8-32	32.00	21.00	4.50 x 3.40	C	2B	T300-XM100DE-8-32	C110, C145, C150	4.5	4.17	63.0	6.5	3	DIN 2184-1
		.827						*.177*	*.164*	*2.480*	*.256*		
UNC #10-24	24.00	25.00	6.00 x 4.90	C	2B	T300-XM100DE-10-24	C110, C145, C150	6.0	4.83	70.0	8.0	3	DIN 2184-1
		.984						*.236*	*.190*	*2.756*	*.315*		
UNC #12-24	24.00	30.00	6.00 x 4.90	C	2B	T300-XM100DE-12-24	C110, C145, C150	6.0	5.49	80.0	10.0	3	DIN 2184-1
		1.181						*.236*	*.216*	*3.150*	*.394*		
UNC 1/4-20	20.00	30.00	7.00 x 5.50	C	2B	T300-XM100DE-1/4	C110, C145, C150	7.0	6.35	80.0	10.0	3	DIN 2184-1
		1.181						*.276*	*.250*	*3.150*	*.394*		
UNC 5/16-18	18.00	35.00	8.00 x 6.20	C	2B	T300-XM100DE-5/16	C110, C145, C150	8.0	7.94	90.0	12.0	3	DIN 2184-1
		1.378						*.315*	*.313*	*3.543*	*.472*		
UNC 3/8-16	16.00	39.00	10.00 x 8.00	C	2B	T300-XM100DE-3/8	C110, C145, C150	10.0	9.53	100.0	15.0	3	DIN 2184-1
		1.535						*.394*	*.375*	*3.937*	*.591*		
UNC 7/16-14	14.00	75.75	8.00 x 6.20	C	2B	T300-XM101DE-7/16	C110, C145, C150	8.0	11.11	100.0	15.0	3	DIN 2184-1
		2.982						*.315*	*.438*	*3.937*	*.591*		
UNC 1/2-13	13.00	82.75	9.00 x 7.00	C	2B	T300-XM101DE-1/2	C110, C145, C150	9.0	12.70	110.0	18.0	3	DIN 2184-1
		3.258						*.354*	*.500*	*4.331*	*.709*		
UNC 5/8-11	11.00	67.75	12.00 x 9.00	C	2B	T300-XM101DE-5/8	C110, C145, C150	12.0	15.88	110.0	20.0	4	DIN 2184-1
		2.667						*.472*	*.625*	*4.331*	*.787*		
UNC 3/4-10	10.00	80.75	14.00 x 11.00	C	2B	T300-XM101DE-3/4	B110, B145, B150	14.0	19.05	125.0	25.0	4	DIN 2184-1
		3.179						*.551*	*.750*	*4.921*	*.984*		
UNC 7/8-9	9.00	92.75	18.00 x 14.50	C	2B	T300-XM101DE-7/8	B110, B145, B150	18.0	22.23	140.0	25.0	4	DIN 2184-1
		3.652						*.709*	*.875*	*5.512*	*.984*		
UNC 1"-8	8.00	112.75	18.00 x 14.50	C	2B	T300-XM101DE-1	B110, B145, B150	18.0	25.40	160.0	30.0	4	DIN 2184-1
		4.439						*.709*	*1.000*	*6.299*	*1.181*		

E30 E41 E45 E36 E59 E38

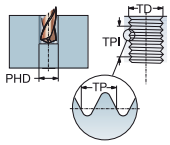
FIN

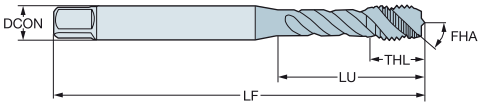
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: UNC

DIN 2184-1/ANSI

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNC #2-56	56.00	11.99	.141 x .110	C	3BX	T300-XM100AE-2-56	C110, C145, C150	3.6	2.18	45.0	4.0	3	DIN 2184-1/ANSI
		.472						.141	.086	1.772	.157		
UNC #4-40	40.00	17.50	.141 x .110	C	3BX	T300-XM100AE-4-40	C110, C145, C150	3.6	2.84	56.0	7.1	3	DIN 2184-1/ANSI
		.689						.141	.112	2.205	.280		
UNC #5-40	40.00	17.50	.141 x .110	C	3BX	T300-XM100AE-5-40	C110, C145, C150	3.6	3.18	56.0	6.6	3	DIN 2184-1/ANSI
		.689						.141	.125	2.205	.260		
UNC #6-32	32.00	20.50	.141 x .110	C	3BX	T300-XM100AE-6-32	C110, C145, C150	3.6	3.51	56.0	7.2	3	DIN 2184-1/ANSI
		.807						.141	.138	2.205	.283		
UNC #8-32	32.00	21.50	.168 x .131	C	3BX	T300-XM100AE-8-32	C110, C145, C150	4.3	4.17	63.0	7.7	3	DIN 2184-1/ANSI
		.846						.168	.164	2.480	.303		
UNC #10-24	24.00	28.00	.194 x .152	C	3BX	T300-XM100AE-10-24	C110, C145, C150	4.9	4.83	70.0	9.1	3	DIN 2184-1/ANSI
		1.102						.194	.190	2.756	.358		
UNC #12-24	24.00	25.50	.220 x .165	C	3BX	T300-XM100AE-12-24	C110, C145, C150	5.6	5.49	80.0	9.9	3	DIN 2184-1/ANSI
		1.004						.220	.216	3.150	.390		
UNC 1/4-20	20.00	25.00	.255 x .191	C	3BX	T300-XM100AE-1/4	C110, C145, C150	6.5	6.35	80.0	11.0	3	DIN 2184-1/ANSI
		.984						.255	.250	3.150	.433		
UNC 5/16-18	18.00	34.00	.318 x .238	C	3BX	T300-XM100AE-5/16	C110, C145, C150	8.1	7.94	90.0	13.1	3	DIN 2184-1/ANSI
		1.339						.318	.313	3.543	.516		
UNC 3/8-16	16.00	39.00	.381 x .286	C	3BX	T300-XM100AE-3/8	C110, C145, C150	9.7	9.53	100.0	16.8	3	DIN 2184-1/ANSI
		1.535						.381	.375	3.937	.661		
UNC 7/16-14	14.00	72.59	.323 x .242	C	3BX	T300-XM101AE-7/16	C110, C145, C150	8.2	11.11	100.0	15.0	3	DIN 2184-1/ANSI
		2.858						.323	.438	3.937	.591		
UNC 1/2-13	13.00	81.82	.367 x .275	C	3BX	T300-XM101AE-1/2	C110, C145, C150	9.3	12.70	110.0	18.0	3	DIN 2184-1/ANSI
		3.221						.367	.500	4.331	.709		
UNC 9/16-12	12.00	80.30	.429 x .322	C	3BX	T300-XM101AE-9/16	C110, C145, C150	10.9	14.29	110.0	20.1	3	DIN 2184-1/ANSI
		3.161						.429	.563	4.331	.791		
UNC 5/8-11	11.00	65.78	.480 x .360	C	3BX	T300-XM101AE-5/8	C110, C145, C150	12.2	15.88	110.0	20.1	4	DIN 2184-1/ANSI
		2.590						.480	.625	4.331	.791		
UNC 3/4-10	10.00	77.47	.590 x .442	C	3BX	T300-XM101AE-3/4	C110, C145, C150	15.0	19.05	125.0	24.9	4	DIN 2184-1/ANSI
		3.050						.590	.750	4.921	.980		
UNC 7/8-9	9.00	90.95	.697 x .523	C	3BX	T300-XM101AE-7/8	C110, C145, C150	17.7	22.23	140.0	24.9	4	DIN 2184-1/ANSI
		3.581						.697	.875	5.512	.980		
UNC 1"-8	8.00	95.43	.800 x .600	C	3BX	T300-XM101AE-1	C110, C145, C150	20.3	25.40	160.0	30.0	4	DIN 2184-1/ANSI
		3.757						.800	1.000	6.299	1.181		
UNC #2-56	56.00	15.00	.141 x .110	E	3BX	T300-XM102AE-2-56	C110, C145, C150	3.6	2.18	45.0	4.0	3	DIN 2184-1/ANSI
		.591						.141	.086	1.772	.157		
UNC #4-40	40.00	17.50	.141 x .110	E	3BX	T300-XM102AE-4-40	C110, C145, C150	3.6	2.84	56.0	7.1	3	DIN 2184-1/ANSI
		.689						.141	.112	2.205	.280		
UNC #5-40	40.00	17.50	.141 x .110	E	3BX	T300-XM102AE-5-40	C110, C145, C150	3.6	3.18	56.0	6.6	3	DIN 2184-1/ANSI
		.689						.141	.125	2.205	.260		
UNC #6-32	32.00	20.50	.141 x .110	E	3BX	T300-XM102AE-6-32	C110, C145, C150	3.6	3.51	56.0	7.2	3	DIN 2184-1/ANSI
		.807						.141	.138	2.205	.283		
UNC #8-32	32.00	21.50	.168 x .131	E	3BX	T300-XM102AE-8-32	C110, C145, C150	4.3	4.17	63.0	7.7	3	DIN 2184-1/ANSI
		.846						.168	.164	2.480	.303		

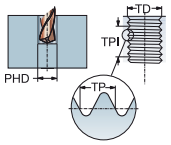
E30 E41 E45 E36 E59 E38

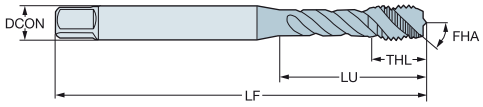
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: UNC

DIN 2184-1/ANSI

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNC #10-24	24.00	28.00	.194 x .152	E	3BX	T300-XM102AE-10-24	C110, C145, C150	4.9	4.83	70.0	9.1	3	DIN 2184-1/ANSI
		1.102						*.194*	*.190*	*2.756*	*.358*		
UNC #12-24	24.00	24.80	.255 x .191	E	3BX	T300-XM102AE-12-24	C110, C145, C150	6.5	5.49	80.0	9.9	3	DIN 2184-1/ANSI
		.976						*.255*	*.216*	*3.150*	*.390*		
UNC 1/4-20	20.00	25.00	.255 x .191	E	3BX	T300-XM102AE-1/4	C110, C145, C150	6.5	6.35	80.0	11.0	3	DIN 2184-1/ANSI
		.984						*.255*	*.250*	*3.150*	*.433*		
UNC 5/16-18	18.00	34.00	.318 x .238	E	3BX	T300-XM102AE-5/16	C110, C145, C150	8.1	7.94	90.0	13.1	3	DIN 2184-1/ANSI
		1.339						*.318*	*.313*	*3.543*	*.516*		
UNC 3/8-16	16.00	39.00	.381 x .286	E	3BX	T300-XM102AE-3/8	C110, C145, C150	9.7	9.53	100.0	16.8	3	DIN 2184-1/ANSI
		1.535						*.381*	*.375*	*3.937*	*.661*		
UNC 7/16-14	14.00	72.59	.323 x .242	E	3BX	T300-XM103AE-7/16	C110, C145, C150	8.2	11.11	100.0	15.0	3	DIN 2184-1/ANSI
		2.858						*.323*	*.438*	*3.937*	*.591*		
UNC 1/2-13	13.00	81.82	.367 x .275	E	3BX	T300-XM103AE-1/2	C110, C145, C150	9.3	12.70	110.0	18.0	3	DIN 2184-1/ANSI
		3.221						*.367*	*.500*	*4.331*	*.709*		
UNC 9/16-12	12.00	80.30	.429 x .322	E	3BX	T300-XM103AE-9/16	C110, C145, C150	10.9	14.29	110.0	20.1	3	DIN 2184-1/ANSI
		3.161						*.429*	*.563*	*4.331*	*.791*		
UNC 5/8-11	11.00	65.78	.480 x .360	E	3BX	T300-XM103AE-5/8	C110, C145, C150	12.2	15.88	110.0	20.1	4	DIN 2184-1/ANSI
		2.590						*.480*	*.625*	*4.331*	*.791*		
UNC 3/4-10	10.00	77.47	.590 x .442	E	3BX	T300-XM103AE-3/4	C110, C145, C150	15.0	19.05	125.0	24.9	4	DIN 2184-1/ANSI
		3.050						*.590*	*.750*	*4.921*	*.980*		
UNC 7/8-9	9.00	90.95	.697 x .523	E	3BX	T300-XM103AE-7/8	C110, C145, C150	17.7	22.23	140.0	24.9	4	DIN 2184-1/ANSI
		3.581						*.697*	*.875*	*5.512*	*.980*		
UNC 1"-8	8.00	95.43	.800 x .600	E	3BX	T300-XM103AE-1	C110, C145, C150	20.3	25.40	160.0	30.0	4	DIN 2184-1/ANSI
		3.757						*.800*	*1.000*	*6.299*	*1.181*		

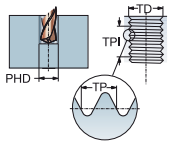
E30 E41 E45 E36 E59 E38

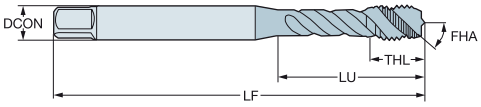
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: UNF

DIN 2184-1

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNF #8-36	36.00	21.00	4.50 x 3.40	C	2B	T300-XM100DF-8-36	C110, C145, C150	4.5	4.17	63.0	6.5	3	DIN 2184-1
		.827						*.177*	*.164*	*2.480*	*.256*		
UNF #10-32	32.00	25.00	6.00 x 4.90	C	2B	T300-XM100DF-10-32	C110, C145, C150	6.0	4.83	70.0	7.3	3	DIN 2184-1
		.984						*.236*	*.190*	*2.756*	*.287*		
UNF 1/4-28	28.00	30.00	7.00 x 5.50	C	2B	T300-XM100DF-1/4	C110, C145, C150	7.0	6.35	80.0	10.0	3	DIN 2184-1
		1.181						*.276*	*.250*	*3.150*	*.394*		
UNF 5/16-24	24.00	35.00	8.00 x 6.20	C	2B	T300-XM100DF-5/16	C110, C145, C150	8.0	7.94	90.0	12.0	3	DIN 2184-1
		1.378						*.315*	*.313*	*3.543*	*.472*		
UNF 3/8-24	24.00	39.00	10.00 x 8.00	C	2B	T300-XM100DF-3/8	C110, C145, C150	10.0	9.53	100.0	15.0	3	DIN 2184-1
		1.535						*.394*	*.375*	*3.937*	*.591*		
UNF 7/16-20	20.00	75.75	8.00 x 6.20	C	2B	T300-XM101DF-7/16	C110, C145, C150	8.0	11.11	100.0	15.0	3	DIN 2184-1
		2.982						*.315*	*.438*	*3.937*	*.591*		
UNF 1/2-20	20.00	83.00	9.00 x 7.00	C	2B	T300-XM101DF-1/2	C110, C145, C150	9.0	12.70	110.0	18.0	3	DIN 2184-1
		3.268						*.354*	*.500*	*4.331*	*.709*		
UNF 5/8-18	18.00	67.75	12.00 x 9.00	C	2B	T300-XM101DF-5/8	C110, C145, C150	12.0	15.88	110.0	20.0	4	DIN 2184-1
		2.667						*.472*	*.625*	*4.331*	*.787*		
UNF 3/4-16	16.00	77.50	14.00 x 11.00	C	2B	T300-XM101DF-3/4	B110, B145, B150	14.0	19.05	125.0	25.0	4	DIN 2184-1
		3.051						*.551*	*.750*	*4.921*	*.984*		
UNF 7/8-14	14.00	92.75	18.00 x 14.50	C	2B	T300-XM101DF-7/8	B110, B145, B150	18.0	22.23	140.0	25.0	4	DIN 2184-1
		3.652						*.709*	*.875*	*5.512*	*.984*		
UNF 1"-12	12.00	113.00	18.00 x 14.50	C	2B	T300-XM101DF-1	B110, B145, B150	18.0	25.40	160.0	30.0	4	DIN 2184-1
		4.449						*.709*	*1.000*	*6.299*	*1.181*		

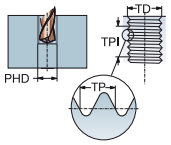
E30 E41 E45 E36 E59 E38

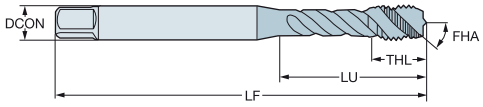
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: UNF

DIN 2184-1/ANSI

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNF #4-48	48.00	17.50	.141 x .110	C	3BX	T300-XM100AF-4-48	C110, C145, C150	3.6	2.84	56.0	7.1	3	DIN 2184-1/ANSI
		.689						.141	.112	2.205	.280		
UNF #6-40	40.00	20.50	.141 x .110	C	3BX	T300-XM100AF-6-40	C110, C145, C150	3.6	3.51	56.0	7.1	3	DIN 2184-1/ANSI
		.807						.141	.138	2.205	.280		
UNF #8-36	36.00	21.50	.168 x .131	C	3BX	T300-XM100AF-8-36	C110, C145, C150	4.3	4.17	63.0	7.7	3	DIN 2184-1/ANSI
		.846						.168	.164	2.480	.303		
UNF #10-32	32.00	28.00	.194 x .152	C	3BX	T300-XM100AF-10-32	C110, C145, C150	4.9	4.83	70.0	8.9	3	DIN 2184-1/ANSI
		1.102						.194	.190	2.756	.350		
UNF #12-28	28.00	31.00	.220 x .165	C	3BX	T300-XM100AF-12-28	C110, C145, C150	5.6	5.49	80.0	9.9	3	DIN 2184-1/ANSI
		1.220						.220	.216	3.150	.390		
UNF 1/4-28	28.00	25.00	.255 x .191	C	3BX	T300-XM100AF-1/4	C110, C145, C150	6.5	6.35	80.0	10.8	3	DIN 2184-1/ANSI
		.984						.255	.250	3.150	.425		
UNF 5/16-24	24.00	34.00	.318 x .238	C	3BX	T300-XM100AF-5/16	C110, C145, C150	8.1	7.94	90.0	12.9	3	DIN 2184-1/ANSI
		1.339						.318	.313	3.543	.508		
UNF 3/8-24	24.00	37.50	.381 x .286	C	3BX	T300-XM100AF-3/8	C110, C145, C150	9.7	9.53	90.0	15.0	3	DIN 2184-1/ANSI
		1.476						.381	.375	3.543	.591		
UNF 7/16-20	20.00	72.59	.367 x .275	C	3BX	T300-XM101AF-7/16	C110, C145, C150	9.3	11.11	100.0	15.0	3	DIN 2184-1/ANSI
		2.858						.367	.438	3.937	.591		
UNF 1/2-20	20.00	71.82	.367 x .275	C	3BX	T300-XM101AF-1/2	C110, C145, C150	9.3	12.70	100.0	18.0	3	DIN 2184-1/ANSI
		2.828						.367	.500	3.937	.709		
UNF 9/16-18	18.00	70.30	.429 x .322	C	3BX	T300-XM101AF-9/16	C110, C145, C150	10.9	14.29	100.0	19.1	3	DIN 2184-1/ANSI
		2.768						.429	.563	3.937	.752		
UNF 5/8-18	18.00	55.78	.480 x .360	C	3BX	T300-XM101AF-5/8	C110, C145, C150	12.2	15.88	100.0	20.1	4	DIN 2184-1/ANSI
		2.196						.480	.625	3.937	.791		
UNF 3/4-16	16.00	62.47	.590 x .442	C	3BX	T300-XM101AF-3/4	C110, C145, C150	15.0	19.05	110.0	24.9	4	DIN 2184-1/ANSI
		2.459						.590	.750	4.331	.980		
UNF 7/8-14	14.00	75.95	.697 x .523	C	3BX	T300-XM101AF-7/8	C110, C145, C150	17.7	22.23	125.0	24.9	4	DIN 2184-1/ANSI
		2.990						.697	.875	4.921	.980		
UNF 1"-12	12.00	75.43	.800 x .600	C	3BX	T300-XM101AF-1-12	C110, C145, C150	20.3	25.40	140.0	26.9	4	DIN 2184-1/ANSI
		2.970						.800	1.000	5.512	1.059		
UNF #4-48	48.00	17.50	.141 x .110	E	3BX	T300-XM102AF-4-48	C110, C145, C150	3.6	2.84	56.0	7.1	3	DIN 2184-1/ANSI
		.689						.141	.112	2.205	.280		
UNF #6-40	40.00	20.50	.141 x .110	E	3BX	T300-XM102AF-6-40	C110, C145, C150	3.6	3.51	56.0	7.1	3	DIN 2184-1/ANSI
		.807						.141	.138	2.205	.280		
UNF #8-36	36.00	21.50	.168 x .131	E	3BX	T300-XM102AF-8-36	C110, C145, C150	4.3	4.17	63.0	7.7	3	DIN 2184-1/ANSI
		.846						.168	.164	2.480	.303		
UNF #10-32	32.00	28.00	.194 x .152	E	3BX	T300-XM102AF-10-32	C110, C145, C150	4.9	4.83	70.0	8.9	3	DIN 2184-1/ANSI
		1.102						.194	.190	2.756	.350		
UNF #12-28	28.00	31.00	.220 x .165	E	3BX	T300-XM102AF-12-28	C110, C145, C150	5.6	5.49	80.0	9.9	3	DIN 2184-1/ANSI
		1.220						.220	.216	3.150	.390		
UNF 1/4-28	28.00	25.00	.255 x .191	E	3BX	T300-XM102AF-1/4	C110, C145, C150	6.5	6.35	80.0	10.8	3	DIN 2184-1/ANSI
		.984						.255	.250	3.150	.425		
UNF 5/16-24	24.00	34.00	.318 x .238	E	3BX	T300-XM102AF-5/16	C110, C145, C150	8.1	7.94	90.0	12.9	3	DIN 2184-1/ANSI
		1.339						.318	.313	3.543	.508		

E30 E41 E45 E36 E59 E38

SANDVIK Coromant

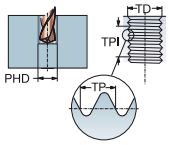
FIN

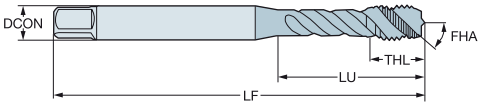
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: UNF

DIN 2184-1/ANSI

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-PM





P M K N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Tilauskoodi	GRADE	DCON	TD	LF	THL	NOF	BSG
								Mitat, mm, tuumaa					
UNF 3/8-24	24.00	37.50	.381 x .286	E	3BX	T300-XM102AF-3/8	C110, C145, C150	9.7	9.53	90.0	15.0	3	DIN 2184-1/ANSI
		1.476						*.381*	*.375*	*3.543*	*.591*		
UNF 7/16-20	20.00	72.59	.323 x .242	E	3BX	T300-XM103AF-7/16	C110, C145, C150	8.2	11.11	100.0	15.0	3	DIN 2184-1/ANSI
		2.858						*.323*	*.438*	*3.937*	*.591*		
UNF 1/2-20	20.00	71.82	.367 x .275	E	3BX	T300-XM103AF-1/2	C110, C145, C150	9.3	12.70	100.0	18.0	3	DIN 2184-1/ANSI
		2.828						*.367*	*.500*	*3.937*	*.709*		
UNF 9/16-18	18.00	70.30	.429 x .322	E	3BX	T300-XM103AF-9/16	C110, C145, C150	10.9	14.29	100.0	19.1	3	DIN 2184-1/ANSI
		2.768						*.429*	*.563*	*3.937*	*.752*		
UNF 5/8-18	18.00	55.78	.480 x .360	E	3BX	T300-XM103AF-5/8	C110, C145, C150	12.2	15.88	100.0	20.1	4	DIN 2184-1/ANSI
		2.196						*.480*	*.625*	*3.937*	*.791*		
UNF 3/4-16	16.00	62.47	.590 x .442	E	3BX	T300-XM103AF-3/4	C110, C145, C150	15.0	19.05	110.0	24.9	4	DIN 2184-1/ANSI
		2.459						*.590*	*.750*	*4.331*	*.980*		
UNF 7/8-14	14.00	75.95	.697 x .523	E	3BX	T300-XM103AF-7/8	C110, C145, C150	17.7	22.23	125.0	24.9	4	DIN 2184-1/ANSI
		2.990						*.697*	*.875*	*4.921*	*.980*		
UNF 1"-12	12.00	75.43	.800 x .600	E	3BX	T300-XM103AF-1-12	C110, C145, C150	20.3	25.40	140.0	26.9	4	DIN 2184-1/ANSI
		2.970						*.800*	*1.000*	*5.512*	*1.059*		

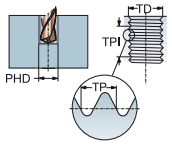
E30 E41 E45 E36 E59 E38

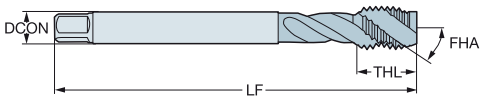
CoroTap™ 300 -kierretappi, nousevat lastu-urat

Kierremuoto: G

DIN 5156

ULDR	2.5
FHA	45°
SUBSTRATE	HSS-E





P M K N S

								Mitat, mm, tuumaa					
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	**Tilauskoodi**	GRADE	DCON	TD	LF	THL	NOF	BSG
G 1/8-28	28.00	67.00	7.00 x 5.50	C	NORMAL	**T300-XM100DK-1/8**	C110, C145, C150	7.0	9.73	90.0	13.0	3	DIN 5156
		2.638						*.276*	*.383*	*3.543*	*.512*		
G 1/4-19	19.00	71.00	11.00 x 9.00	C	NORMAL	**T300-XM100DK-1/4**	C110, C145, C150	11.0	13.16	100.0	15.0	3	DIN 5156
		2.795						*.433*	*.518*	*3.937*	*.591*		
G 3/8-19	19.00	58.00	12.00 x 9.00	C	NORMAL	**T300-XM100DK-3/8**	C110, C145, C150	12.0	16.66	100.0	15.0	4	DIN 5156
		2.283						*.472*	*.656*	*3.937*	*.591*		
G 1/2-14	14.00	80.00	16.00 x 12.00	C	NORMAL	**T300-XM100DK-1/2**	B110, B145, B150	16.0	20.96	125.0	18.0	4	DIN 5156
		3.150						*.630*	*.825*	*4.921*	*.709*		
G 5/8-14	14.00	78.00	18.00 x 14.50	C	NORMAL	**T300-XM100DK-5/8**	B110, B145, B150	18.0	22.91	125.0	18.0	4	DIN 5156
		3.071						*.709*	*.902*	*4.921*	*.709*		
G 3/4-14	14.00	77.00	20.00 x 16.00	C	NORMAL	**T300-XM100DK-3/4**	B110, B145, B150	20.0	26.44	140.0	20.0	4	DIN 5156
		3.032						*.787*	*1.041*	*5.512*	*.787*		
G 7/8-14	14.00	85.00	22.00 x 18.00	C	NORMAL	**T300-XM100DK-7/8**	B110, B145, B150	22.0	30.20	150.0	20.0	4	DIN 5156
		3.346						*.866*	*1.189*	*5.906*	*.787*		
G 1"-11	11.00	93.00	25.00 x 20.00	C	NORMAL	**T300-XM100DK-1**	B110, B145, B150	25.0	33.25	160.0	22.0	4	DIN 5156
		3.661						*.984*	*1.309*	*6.299*	*.866*		
G 1.1/8-11	11.00	101.00	28.00 x 22.00	C	NORMAL	**T300-XM100DK-1.1/8**	B110, B145, B150	28.0	37.90	170.0	22.0	4	DIN 5156
		3.976						*1.102*	*1.492*	*6.693*	*.866*		
G 1.1/4-11	11.00	72.00	32.00 x 24.00	C	NORMAL	**T300-XM100DK-1.1/4**	B110, B145, B150	32.0	41.91	170.0	22.0	4	DIN 5156
		2.835						*1.260*	*1.650*	*6.693*	*.866*		
G 1.1/2-11	11.00	87.00	36.00 x 29.00	C	NORMAL	**T300-XM100DK-1.1/2**	B110, B145, B150	36.0	47.80	190.0	23.0	4	DIN 5156
		3.425						*1.417*	*1.882*	*7.480*	*.906*		

E30 E41 E45 E36 E59 E38

Kalvinta

CoroReamer™ 435

Monipuolinen ja suorituskykyinen kalvin laajalti eri materiaaleille

B

Edut ja ominaisuudet

- Isot lastuamisarvot, hyvä tuottavuus
- Johdonmukaisesti käyttäytyvä ja tuottava, säästää aikaa ja kustannuksia
- Erittäin hyvä pinnankarheus
- Tarkka keskitys takaa pitkän kestoiän ja hyvän mittatarkkuuden
- Täyskovametallinen työkalurunko antaa hyvän tukevuuden
- Läpijäähdytys parantaa lastunpoistoa ja hidastaa kulumista

ISO-käyttöalueet:

P K N

C

C

Räätälöidyt ratkaisut, sivu E36

www.sandvik.coromant.com/cororeamer435

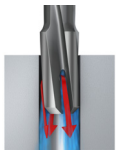
D

työkalut on suunniteltu vaihtelevien materiaalien ja muotojen ja erikokoisten kappaleiden tuottavaan ja varmaan koneistukseen. Niillä maksimoit koneen käyttöasteen.

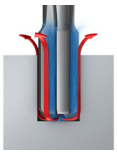
Urageometria perustuu voimakkaasti epäsymmetriseen jakoon

Erittäin voimakkaasti epäsymmetrisessä urajaossa uran mitta on siis kullekin hampaalle eri suuruinen. Koska mikään terä ei ole täsmälleen päinvastaisella puolella kuin jokin toinen terä, reiän ympyrämäisyyspoikkeama on erittäin pieni.

Läpireikä



Umpireikä



E

E50

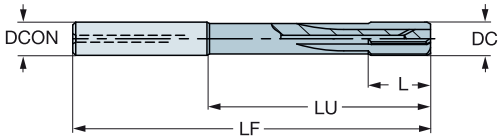
FIN

CoroReamer™ 435 -täyskovametallikalvin

Vaihtelevien materiaalien koneistukseen

Pohjareikien koneistukseen

CNSC	1
CXSC	1
SUBSTRATE	HF
COATING	UNCOATED



P K N

							Mitat, mm, tuumaa															
DC	DC"	LU	LU"	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
3.97	.156	39.00	1.535	6	435.B-0397-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
3.98	.157	39.00	1.535	6	435.B-0398-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
3.99	.157	39.00	1.535	6	435.B-0399-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.00	.157	39.00	1.535	6	435.B-0400-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.01	.158	39.00	1.535	6	435.B-0401-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.02	.158	39.00	1.535	6	435.B-0402-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.03	.159	39.00	1.535	6	435.B-0403-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.39	2.929	0.3	.012	3.80	.150	COROMANT
4.50	.177	39.00	1.535	6	435.B-0450-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.32	2.926	0.3	.012	4.30	.169	COROMANT
4.97	.196	39.00	1.535	6	435.B-0497-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
4.98	.196	39.00	1.535	6	435.B-0498-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
4.99	.196	39.00	1.535	6	435.B-0499-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.00	.197	39.00	1.535	6	435.B-0500-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.01	.197	39.00	1.535	6	435.B-0501-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.02	.198	39.00	1.535	6	435.B-0502-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.03	.198	39.00	1.535	6	435.B-0503-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.24	2.923	0.3	.012	4.80	.189	COROMANT
5.50	.217	39.00	1.535	6	435.B-0550-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.17	2.920	0.3	.012	5.30	.209	COROMANT
5.97	.235	39.00	1.535	6	435.B-0597-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
5.98	.235	39.00	1.535	6	435.B-0598-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
5.99	.236	39.00	1.535	6	435.B-0599-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.00	.236	39.00	1.535	6	435.B-0600-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.01	.237	39.00	1.535	6	435.B-0601-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.02	.237	39.00	1.535	6	435.B-0602-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.03	.237	39.00	1.535	6	435.B-0603-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.09	2.917	0.3	.012	5.80	.228	COROMANT
6.50	.256	64.00	2.520	8	435.B-0650-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	99.02	3.898	0.3	.012	6.30	.248	COROMANT
7.00	.276	64.00	2.520	8	435.B-0700-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
7.50	.295	64.00	2.520	8	435.B-0750-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.87	3.893	0.3	.012	7.30	.287	COROMANT
7.97	.314	64.00	2.520	8	435.B-0797-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
7.98	.314	64.00	2.520	8	435.B-0798-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
7.99	.315	64.00	2.520	8	435.B-0799-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.00	.315	64.00	2.520	8	435.B-0800-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.01	.315	64.00	2.520	8	435.B-0801-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.02	.316	64.00	2.520	8	435.B-0802-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
8.03	.316	64.00	2.520	8	435.B-0803-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
8.50	.335	60.00	2.362	10	435.B-0850-A1-XF	H10F	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.72	3.887	0.3	.012	8.30	.327	COROMANT
9.00	.354	60.00	2.362	10	435.B-0900-A1-XF	H10F	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT
9.50	.374	80.00	3.150	10	435.B-0950-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT
9.97	.393	80.00	3.150	10	435.B-0997-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
9.98	.393	80.00	3.150	10	435.B-0998-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
9.99	.393	80.00	3.150	10	435.B-0999-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.00	.394	80.00	3.150	10	435.B-1000-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	435.B-1001-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.02	.394	80.00	3.150	10	435.B-1002-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT
10.03	.395	80.00	3.150	10	435.B-1003-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT
10.50	.413	75.00	2.953	12	435.B-1050-A1-XF	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.42	4.662	0.3	.012	10.30	.406	COROMANT

Tasahalkaisijoilla reiän toleranssi H7.

Desimaalihalkaisijoilla (tarkkuus +0.004 mm) saadaan tarkemmin toleroitu reikä.

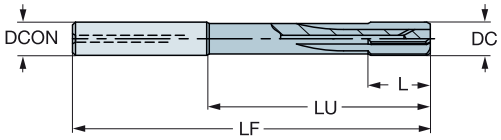
E32 E45 E36 E60 E50

CoroReamer™ 435 -täyskovametallikalvin

Vaihtelevien materiaalien koneistukseen

Pohjareikien koneistukseen

CNSC	1
CXSC	1
SUBSTRATE	HF
COATING	UNCOATED



P K N

DC	DC"	LU	LU"	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
							Mitat, mm, tuumaa														
11.00	.433	75.00	2.953	12	**435.B-1100-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT
11.50	.453	75.00	2.953	12	**435.B-1150-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.27	4.656	0.3	.012	11.30	.445	COROMANT
11.97	.471	75.00	2.953	12	**435.B-1197-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
11.98	.472	75.00	2.953	12	**435.B-1198-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
11.99	.472	75.00	2.953	12	**435.B-1199-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.00	.472	75.00	2.953	12	**435.B-1200-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.01	.473	75.00	2.953	12	**435.B-1201-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.02	.473	75.00	2.953	12	**435.B-1202-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT
12.03	.474	75.00	2.953	12	**435.B-1203-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT
13.00	.512	85.00	3.346	14	**435.B-1300-A1-XF**	H10F	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT
14.00	.551	85.00	3.346	14	**435.B-1400-A1-XF**	H10F	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	**435.B-1500-A1-XF**	H10F	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	**435.B-1600-A1-XF**	H10F	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT
17.00	.669	102.00	4.016	18	**435.B-1700-A1-XF**	H10F	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.45	5.805	0.3	.012	16.80	.661	COROMANT
18.00	.709	102.00	4.016	18	**435.B-1800-A1-XF**	H10F	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT
19.00	.748	100.00	3.937	20	**435.B-1900-A1-XF**	H10F	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	147.14	5.793	0.3	.012	18.80	.740	COROMANT
20.00	.787	100.00	3.937	20	**435.B-2000-A1-XF**	H10F	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT

Tasahalkaisijoilla reiän toleranssi H7.

Desimaalihalkaisijoilla (tarkkuus +0.004 mm) saadaan tarkemmin toleroitu reikä.

E32 E45 E36 E60 E50

SANDVIK Coromant

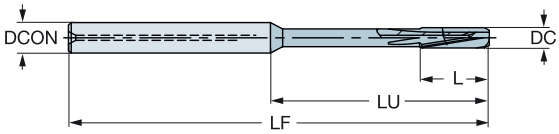
FIN

CoroReamer™ 435 -täyskovametallikalvin

Vaihtelevien materiaalien koneistukseen

Läpireikien koneistukseen

FHA	10°
CNSC	1
CXSC	2
SUBSTRATE	HF
COATING	UNCOATED



P K N

DC	DC"	LU	LU"	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
							Mitat, mm, tuumaa														
3.97	.156	39.00	1.535	6	435.T-0397-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
3.98	.157	39.00	1.535	6	435.T-0398-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
3.99	.157	39.00	1.535	6	435.T-0399-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.00	.157	39.00	1.535	6	435.T-0400-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.01	.158	39.00	1.535	6	435.T-0401-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.02	.158	39.00	1.535	6	435.T-0402-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.03	.159	39.00	1.535	6	435.T-0403-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.39	2.929	0.3	.012	3.80	.150	COROMANT
4.50	.177	39.00	1.535	6	435.T-0450-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.32	2.926	0.3	.012	4.30	.169	COROMANT
4.97	.196	39.00	1.535	6	435.T-0497-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
4.98	.196	39.00	1.535	6	435.T-0498-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
4.99	.196	39.00	1.535	6	435.T-0499-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.00	.197	39.00	1.535	6	435.T-0500-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.01	.197	39.00	1.535	6	435.T-0501-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.02	.198	39.00	1.535	6	435.T-0502-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.03	.198	39.00	1.535	6	435.T-0503-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.24	2.923	0.3	.012	4.80	.189	COROMANT
5.50	.217	39.00	1.535	6	435.T-0550-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.17	2.920	0.3	.012	5.30	.209	COROMANT
5.97	.235	39.00	1.535	6	435.T-0597-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
5.98	.235	39.00	1.535	6	435.T-0598-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
5.99	.236	39.00	1.535	6	435.T-0599-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.00	.236	39.00	1.535	6	435.T-0600-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.01	.237	39.00	1.535	6	435.T-0601-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.02	.237	39.00	1.535	6	435.T-0602-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.03	.237	39.00	1.535	6	435.T-0603-A1-XF	H10F	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.09	2.917	0.3	.012	5.80	.228	COROMANT
6.50	.256	64.00	2.520	8	435.T-0650-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	99.02	3.898	0.3	.012	6.30	.248	COROMANT
7.00	.276	64.00	2.520	8	435.T-0700-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
7.97	.314	64.00	2.520	8	435.T-0797-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
7.98	.314	64.00	2.520	8	435.T-0798-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
7.99	.315	64.00	2.520	8	435.T-0799-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.00	.315	64.00	2.520	8	435.T-0800-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.01	.315	64.00	2.520	8	435.T-0801-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.02	.316	64.00	2.520	8	435.T-0802-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
8.03	.316	64.00	2.520	8	435.T-0803-A1-XF	H10F	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
8.50	.335	60.00	2.362	10	435.T-0850-A1-XF	H10F	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.72	3.887	0.3	.012	8.30	.327	COROMANT
9.00	.354	60.00	2.362	10	435.T-0900-A1-XF	H10F	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT
9.50	.374	80.00	3.150	10	435.T-0950-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT
9.97	.393	80.00	3.150	10	435.T-0997-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
9.98	.393	80.00	3.150	10	435.T-0998-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
9.99	.393	80.00	3.150	10	435.T-0999-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.00	.394	80.00	3.150	10	435.T-1000-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	435.T-1001-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.02	.394	80.00	3.150	10	435.T-1002-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT
10.03	.395	80.00	3.150	10	435.T-1003-A1-XF	H10F	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT
10.50	.413	75.00	2.953	12	435.T-1050-A1-XF	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.42	4.662	0.3	.012	10.30	.406	COROMANT
11.00	.433	75.00	2.953	12	435.T-1100-A1-XF	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT

Tasahalkaisijoilla reiän toleranssi H7.

Desimaalihalkaisijoilla (tarkkuus +0.004 mm) saadaan tarkemmin toleroitu reikä.

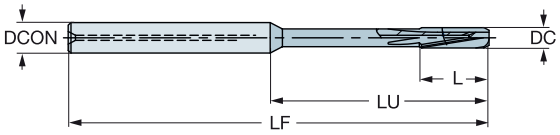
E32 E45 E36 E60 E50

CoroReamer™ 435 -täyskovametallikalvin

Vaihtelevien materiaalien koneistukseen

Läpireikien koneistukseen

FHA	10°
CNSC	1
CXSC	2
SUBSTRATE	HF
COATING	UNCOATED



P K N

DC	DC"	LU	LU"	CZC_{MS}	Tilauskoodi	GRADE	DCON	DCON"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
							Mitat, mm, tuumaa														
11.50	.453	75.00	2.953	12	**435.T-1150-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.27	4.656	0.3	.012	11.30	.445	COROMANT
11.97	.471	75.00	2.953	12	**435.T-1197-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
11.98	.472	75.00	2.953	12	**435.T-1198-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
11.99	.472	75.00	2.953	12	**435.T-1199-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.00	.472	75.00	2.953	12	**435.T-1200-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.01	.473	75.00	2.953	12	**435.T-1201-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.02	.473	75.00	2.953	12	**435.T-1202-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT
12.03	.474	75.00	2.953	12	**435.T-1203-A1-XF**	H10F	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT
13.00	.512	85.00	3.346	14	**435.T-1300-A1-XF**	H10F	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT
14.00	.551	85.00	3.346	14	**435.T-1400-A1-XF**	H10F	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	**435.T-1500-A1-XF**	H10F	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	**435.T-1600-A1-XF**	H10F	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT
17.00	.669	102.00	4.016	18	**435.T-1700-A1-XF**	H10F	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.45	5.805	0.3	.012	16.80	.661	COROMANT
18.00	.709	102.00	4.016	18	**435.T-1800-A1-XF**	H10F	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT
19.00	.748	100.00	3.937	20	**435.T-1900-A1-XF**	H10F	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	147.14	5.793	0.3	.012	18.80	.740	COROMANT
20.00	.787	100.00	3.937	20	**435.T-2000-A1-XF**	H10F	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT

Tasahalkaisijoilla reiän toleranssi H7.

Desimaalihalkaisijoilla (tarkkuus +0.004 mm) saadaan tarkemmin toleroitu reikä.

E32 E45 E36 E60 E50

SANDVIK Coromant

Yleistä

Lastuamisarvot E3

Räätälöidyt ratkaisut E36

ISO 13399 E45

Yleisjyrsinnän kaavoja E48

IFind E49

Kunnostus E50

Coromantin kierrätysjärjestelmä (CRC) E51

Turvallisuustiedot E52

Raaka-aineiden vertailutaulukko E53

Koodiavaimet

CoroMill® Plura E58
CoroTap™ E59

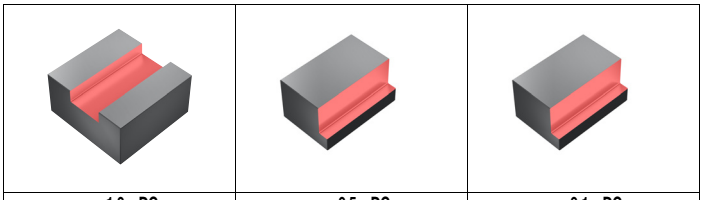
Lastuamisnesteen syöttötapa E60

Aakkosellinen hakemisto E61

FIN

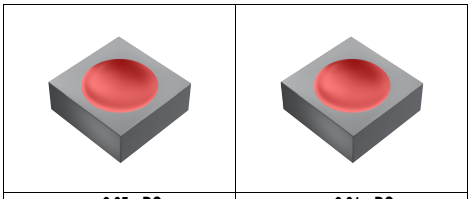
Lastuamisnopeussuositukset

CoroMill® Plura, täyskovametallinen varsijyrsin raskaaseen rouhintaan
CoroMill® Plura, täyskovametallinen varsijyrsin keskiraskaaseen rouhintaan
CoroMill® Plura, täyskovametallinen varsijyrsin rouhintaan lastunmurtajalla



					a_e = 1.0 x DC, a_p = 0.5 x DC			a_e = 0.5 x DC, a_p = 1.0 x DC			a_e = 0.1 x DC, a_p = 1.5 x DC		
ISO	MC-nro	CMC	Raaka-aine	HB	f_z*	v_c m/min	v_c jalkaa/min	f_z*	v_c m/min	v_c jalkaa/min	f_z*	v_c m/min	v_c jalkaa/min
P	P1.2.Z.AN	01.2	Seostamaton teräs	190	F52	145	476	F47	175	574	F55	290	951
	P2.2.Z.AN	02.2	Niukkaseosteinen teräs	240	F52	110	361	F47	135	443	F55	200	656
	P3.0.Z.HT	03.21	Runsasseosteinen teräs	380	F52	80	262	F47	100	328	F55	170	558
M	P5.0.Z.AN	05.11	Ferriittiset/martensiittiset ruostumattomat teräkset	200	F52	65	213	F47	80	262	F55	150	492
	M1.0.Z.AQ	05.21	Austeniittinen ruostumaton teräs	200	F51	65	213	F46	80	262	F54	120	394
	M3.2.Z.AQ	05.51	Ferriittis-austeniittiset ruostumattomat teräkset (duplex)	260	F51	55	180	F46	70	230	F54	90	295
K	K1.1.C.NS	07.2	Adusoitu valurauta	200	F52	140	459	F47	165	541	F55	150	492
	K2.1.C.UT	08.2	Harmaa valurauta	180	F52	130	427	F47	150	492	F55	200	656
	K3.2.C.UT	09.2	Pallografiittivalurauta	215	F52	125	410	F47	145	476	F55	155	509
N	N1.2.Z.AG	30.12	Alumiinipohjaiset seokset	100	F53	680	2231	F50	835	2740	F56	950	3117
	N1.3.C.UT	30.21	Alumiinipohjaiset seokset	75	F53	230	755	F50	305	1001	F56	410	1345
	N1.4.C.NS	30.42	Alumiinipohjaiset seokset	130	F53	100	328	F50	130	427	F56	195	640
	N3.2.C.UT	33.2	Kupari ja kupariseokset	90	F53	130	427	F50	170	558	F56	245	804
S	S1.0.U.AG	20.12	Rautapohjaiset superseokset	280	F51	30	98	F46	40	131	F54	50	164
	S2.0.Z.AG	20.22	Nikkelipohjaiset superseokset	350	F51	30	98	F46	40	131	F54	60	197
	S4.2.Z.AN	23.22	Titaanipohjaiset seokset	320	F51	40	131	F46	50	164	F54	100	328

CoroMill® Plura, täyskovametallinen sädevarsijyrsin muotojyrsintään



					a_p = 0.05 x DC			a_p = 0.01 x DC		
ISO	MC-nro	CMC	Raaka-aine	HB	f_z*	v_c m/min	v_c jalkaa/min	f_z*	v_c m/min	v_c jalkaa/min
P	P1.2.Z.AN	01.2	Seostamaton teräs	190	F07	245	804	F37	295	968
	P2.2.Z.AN	02.2	Niukkaseosteinen teräs	240	F07	180	591	F37	215	705
	P3.0.Z.HT	03.21	Runsasseosteinen teräs	380	F07	120	394	F37	140	459
M	P5.0.Z.AN	05.11	Ferriittiset/martensiittiset ruostumattomat teräkset	200	F07	100	328	F37	110	361
	M1.0.Z.AQ	05.21	Austeniittinen ruostumaton teräs	200	F11	90	295	F43	110	361
	M3.2.Z.AQ	05.51	Ferriittis-austeniittiset ruostumattomat teräkset (duplex)	260	F11	80	262	F43	90	295
K	K1.1.C.NS	07.2	Adusoitu valurauta	200	F07	180	591	F37	215	705
	K2.1.C.UT	08.2	Harmaa valurauta	180	F07	205	673	F37	245	804
	K3.2.C.UT	09.2	Pallografiittivalurauta	215	F07	165	541	F37	200	656
N	N1.2.Z.AG	30.12	Alumiinipohjaiset seokset	100	F12	1345	4413	F45	1345	4413
	N1.3.C.UT	30.21	Alumiinipohjaiset seokset	75	F12	920	3018	F45	1105	3625
	N1.4.C.NS	30.42	Alumiinipohjaiset seokset	130	F12	330	1083	F45	395	1296
	N3.2.C.UT	33.2	Kupari ja kupariseokset	90	F12	520	1706	F45	625	2051
S	S1.0.U.AG	20.12	Rautapohjaiset superseokset	280	F11	50	164	F43	70	230
	S2.0.Z.AG	20.22	Nikkelipohjaiset superseokset	350	F11	40	131	F43	55	180
	S4.2.Z.AN	23.22	Titaanipohjaiset seokset	320	F11	80	262	F43	105	344

*Syöttösuositukset: vertaa -koodia vastaavaan koodiin s. E5

Lastuamisnopeussuositukset

CoroMill® Plura, täyskovametallinen varsijyrsin viisteiden ja kulmapyöristysten jyrsintään

a_e = 0.1 x DC

a_p = 0.1 x DC

ISO	MC-nro	CMC	Raaka-aine	HB	f_z*	v_c m/min	v_c jalkaa/min
P	P1.2.Z.AN	01.2	Seostamaton teräs	190	F06	320	1050
	P2.2.Z.AN	02.2	Niukkaseosteinen teräs	240	F06	220	722
	P3.0.Z.HT	03.21	Runsasseosteinen teräs	380	F06	130	427
M	P5.0.Z.AN	05.11	Ferriittiset/martensiittiset ruostumattomat teräkset	200	F06	90	295
	M1.0.Z.AQ	05.21	Austeniittinen ruostumaton teräs	200	F10	110	361
	M3.2.Z.AQ	05.51	Ferriittis-austeniittiset ruostumattomat teräkset (duplex)	260	F10	70	230
K	K1.1.C.NS	07.2	Adusoitu valurauta	200	F06	240	787
	K2.1.C.UT	08.2	Harmaa valurauta	180	F06	240	787
	K3.2.C.UT	09.2	Pallografiittivalurauta	215	F06	215	705
N	N1.2.Z.AG	30.12	Alumiinipohjaiset seokset	100	F24	2300	7546
	N1.3.C.UT	30.21	Alumiinipohjaiset seokset	75	F24	370	1214
	N1.4.C.NS	30.42	Alumiinipohjaiset seokset	130	F24	240	787
	N3.2.C.UT	33.2	Kupari ja kupariseokset	90	F24	680	2231
S	S1.0.U.AG	20.12	Rautapohjaiset superseokset	280	F10	50	164
	S2.0.Z.AG	20.22	Nikkelipohjaiset superseokset	350	F10	50	164
	S4.2.Z.AN	23.22	Titaanipohjaiset seokset	320	F10	90	295
H	H1.1.Z.HA	04.1	Teräs – kovuusluokka 50	50HRC	F10	70	230

*Syöttösuositukset: vertaa -koodia vastaavaan koodiin s. E5

SANDVIK Coromant

FIN

Syöttösuositukset

CoroMill® Plura

Metrinen

D_c	mm	0.500	1.000	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
F1	mm/terä	-	0.0100	0.0200	0.0200	0.0200	0.0400	0.0400	0.0600	0.0600	0.0700	0.0700	0.0800	0.0800	0.1000	0.1100	0.1100	0.1200	0.1200	0.1200	0.1200	0.1200
F2	mm/terä	-	0.010	0.030	0.040	0.040	0.050	0.050	0.080	0.080	0.110	0.120	0.120	0.120	0.120	0.140	0.140	0.140	0.160	0.170	0.190	0.190
F3	mm/terä	-	0.020	0.040	0.050	0.060	0.080	0.080	0.120	0.120	0.140	0.140	0.140	0.140	0.140	0.140	0.140	0.160	0.210	0.210	0.240	0.240
F4	mm/terä	0.010	0.010	0.020	0.020	0.020	0.030	0.030	0.050	0.050	0.060	0.060	0.070	0.070	0.080	0.090	0.090	0.100	0.100	0.100	0.100	0.100
F5	mm/terä	0.010	0.010	0.020	0.030	0.030	0.040	0.040	0.070	0.070	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.120	0.120	0.140	0.160	0.160
F6	mm/terä	-	0.020	0.030	0.040	0.050	0.070	0.070	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.150	0.180	0.200	0.200	0.200
F7	mm/terä	0.010	0.020	0.030	0.050	0.060	0.080	0.080	0.120	0.120	0.150	0.150	0.150	0.150	0.150	0.160	0.160	0.180	0.200	0.200	0.250	0.250
F8	mm/terä	0.010	0.010	0.020	0.020	0.020	0.020	0.020	0.040	0.040	0.050	0.050	0.060	0.060	0.060	0.070	0.070	0.080	0.080	0.080	0.080	0.080
F9	mm/terä	0.010	0.010	0.020	0.020	0.020	0.040	0.040	0.060	0.060	0.080	0.080	0.080	0.080	0.080	0.100	0.100	0.100	0.100	0.110	0.130	0.130
F10	mm/terä	-	0.020	0.020	0.030	0.040	0.060	0.060	0.080	0.080	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.140	0.160	0.160	0.160
F11	mm/terä	0.015	0.020	0.030	0.040	0.050	0.060	0.060	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.140	0.140	0.150	0.160	0.160	0.200	0.200
F12	mm/terä	0.035	0.060	0.080	0.100	0.130	0.180	0.180	0.260	0.260	0.330	0.330	0.330	0.330	0.350	0.380	0.380	0.400	0.430	0.440	0.500	0.500
F13	mm/terä	-	-	0.016	0.024	0.032	0.072	0.076	0.095	0.096	0.143	0.150	0.180	0.191	0.210	0.238	0.240	0.270	0.286	0.300	0.375	0.375
F14	mm/terä	-	-	0.012	0.018	0.024	0.060	0.064	0.079	0.080	0.124	0.130	0.156	0.165	0.182	0.206	0.208	0.234	0.248	0.260	0.325	0.325
F15	mm/terä	-	-	0.008	0.012	0.016	0.036	0.038	0.048	0.048	0.071	0.075	0.090	0.095	0.105	0.119	0.120	0.135	0.143	0.150	0.188	0.188
F16	mm/terä	-	-	-	-	-	0.072	0.076	0.086	0.086	0.114	0.120	0.144	0.152	0.168	0.191	0.192	0.216	0.229	0.240	-	-
F17	mm/terä	-	-	-	-	-	0.060	0.064	0.071	0.072	0.099	0.104	0.125	0.132	0.146	0.165	0.166	0.187	0.198	0.208	-	-
F18	mm/terä	-	-	-	-	-	0.036	0.038	0.048	0.048	0.057	0.060	0.072	0.076	0.084	0.095	0.096	0.108	0.114	0.120	-	-
F19	mm/terä	-	-	-	-	-	0.070	0.070	0.080	0.080	0.080	0.080	0.090	0.090	0.100	0.100	0.100	0.150	0.150	0.160	0.190	0.190
F20	mm/terä	-	-	-	-	-	0.060	0.060	0.060	0.060	0.070	0.070	0.070	0.070	0.080	0.080	0.080	0.130	0.130	0.140	0.160	0.160
F21	mm/terä	-	-	-	-	-	0.040	0.040	0.050	0.050	0.050	0.050	0.060	0.060	0.070	0.070	0.070	0.120	0.120	0.130	0.150	0.150
F22	mm/terä	-	0.020	0.040	0.040	0.040	0.072	0.072	0.110	0.110	0.130	0.130	0.150	0.150	0.180	0.200	0.200	0.220	0.220	0.220	0.220	0.220
F23	mm/terä	-	0.030	0.060	0.070	0.070	0.100	0.100	0.170	0.170	0.220	0.220	0.220	0.220	0.220	0.260	0.260	0.260	0.310	0.310	0.350	0.350
F24	mm/terä	-	0.040	0.070	0.070	0.110	0.150	0.150	0.200	0.200	0.260	0.260	0.260	0.260	0.260	0.260	0.260	0.330	0.440	0.440	0.440	0.440
F25	mm/terä	-	0.010	0.010	0.010	0.020	0.020	0.020	0.030	0.030	0.040	0.040	0.050	0.050	0.060	0.070	0.070	-	-	-	-	-
F26	mm/terä	-	0.010	0.020	0.020	0.030	0.040	0.040	0.060	0.060	0.080	0.080	0.100	0.100	0.120	0.140	0.140	-	-	-	-	-
F27	mm/terä	-	-	0.020	0.024	0.028	0.035	0.036	0.042	0.043	0.048	0.050	0.057	0.059	0.063	0.070	0.070	0.077	0.080	0.083	0.100	-
F28	mm/terä	-	-	0.024	0.030	0.036	0.047	0.049	0.058	0.059	0.067	0.070	0.080	0.084	0.090	0.099	0.100	0.110	0.115	0.120	0.145	-
F29	mm/terä	-	-	0.028	0.035	0.041	0.054	0.056	0.067	0.067	0.077	0.080	0.093	0.098	0.107	0.119	0.120	0.133	0.140	0.147	0.180	-
F30	mm/terä	-	-	0.020	0.023	0.025	0.030	0.031	0.035	0.035	0.039	0.040	0.047	0.049	0.053	0.060	0.060	0.067	0.070	0.073	0.090	-
F31	mm/terä	-	-	0.020	0.023	0.025	0.037	0.040	0.051	0.052	0.063	0.067	0.076	0.079	0.084	0.093	0.093	0.102	0.107	0.111	0.133	-
F32	mm/terä	-	-	0.020	0.023	0.026	0.044	0.047	0.061	0.062	0.076	0.080	0.090	0.094	0.100	0.109	0.110	0.120	0.125	0.130	0.200	-
F33	mm/terä	-	-	0.020	0.020	0.020	0.020	0.021	0.027	0.028	0.033	0.035	0.038	0.040	0.042	0.045	0.045	0.048	0.050	0.052	0.060	-
F34	mm/terä	-	-	0.024	0.026	0.029	0.033	0.034	0.037	0.038	0.041	0.042	0.048	0.050	0.054	0.060	0.060	0.066	0.069	0.072	0.087	-
F35	mm/terä	-	-	0.030	0.033	0.035	0.040	0.041	0.045	0.045	0.049	0.050	0.070	0.077	0.091	0.110	0.111	0.131	0.142	0.152	0.203	-
F36	mm/terä	0.010	0.010	0.020	0.030	0.040	0.050	0.050	0.080	0.080	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.150	0.150	0.200	0.200
F37	mm/terä	-	0.030	0.050	0.080	0.100	0.120	0.120	0.150	0.150	0.200	0.200	0.200	0.200	0.200	0.200	0.200	0.200	0.250	0.250	0.250	0.250
F38	mm/terä	0.020	0.020	0.040	0.040	0.050	0.070	0.070	0.110	0.110	0.130	0.130	0.150	0.150	0.180	0.200	0.200	0.220	0.220	0.220	0.220	0.220
F39	mm/terä	0.020	0.030	0.060	0.070	0.070	0.100	0.100	0.160	0.160	0.220	0.220	0.220	0.220	0.220	0.260	0.260	0.260	0.310	0.310	0.350	0.350
F40	mm/terä	-	-	-	0.070	0.100	0.160	0.160	0.250	0.250	0.300	0.300	0.350	0.350	0.400	0.500	0.500	0.600	0.700	0.700	0.700	0.700
F41	mm/terä	-	-	-	0.060	0.080	0.130	0.130	0.200	0.200	0.240	0.240	0.280	0.280	0.320	0.400	0.400	0.480	0.560	0.560	0.560	0.560
F42	mm/terä	0.020	0.010	0.020	0.020	0.040	0.045	0.045	0.060	0.060	0.090	0.090	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.160	0.160
F43	mm/terä	-	0.020	0.040	0.065	0.080	0.100	0.100	0.120	0.120	0.160	0.160	0.160	0.160	0.160	0.160	0.160	0.160	0.200	0.200	0.200	0.200
F44	mm/terä	-	0.030	0.060	0.070	0.090	0.120	0.120	0.180	0.180	0.235	0.235	0.260	0.260	0.260	0.260	0.260	0.280	0.330	0.330	0.440	0.440
F45	mm/terä	-	0.070	0.110	0.175	0.220	0.260	0.260	0.330	0.330	0.440	0.440	0.440	0.440	0.440	0.440	0.440	0.440	0.500	0.500	0.500	0.500
F46	mm/terä	-	0.001	0.003	0.005	0.008	0.013	0.013	0.020	0.020	0.027	0.027	0.035	0.035	0.040	0.050	0.050	0.055	0.060	0.060	0.080	0.080
F47	mm/terä	-	0.002	0.004	0.008	0.012	0.020	0.020	0.030	0.030	0.040	0.040	0.050	0.050	0.060	0.070	0.070	0.080	0.090	0.090	0.115	0.115
F48	mm/terä	-	0.001	0.004	0.007	0.011	0.017	0.017	0.027	0.027	0.036	0.036	0.047	0.047	0.053	0.067	0.067	0.073	0.080	0.080	0.106	0.106
F49	mm/terä	-	0.003	0.005	0.011	0.016	0.027	0.027	0.040	0.040	0.053	0.053	0.067	0.067	0.080	0.093	0.093	0.011	0.120	0.120	0.153	0.153
F50	mm/terä	-	0.003	0.005	0.010	0.015	0.025	0.025	0.040	0.040	0.050	0.050	0.065	0.065	0.080	0.090	0.090	0.105	0.120	0.120	0.155	0.155
F51	mm/terä	-	0.002	0.005	0.009	0.013	0.020	0.020	0.023	0.023	0.035	0.035	0.040	0.040	0.050	0.055	0.055	0.060	0.070	0.070	0.080	0.080
F52	mm/terä	-	0.003	0.007	0.013	0.020	0.030	0.030	0.040	0.040	0.050	0.050	0.060	0.060	0.070	0.080	0.080	0.090	0.100	0.100	0.110	0.110
F53	mm/terä	-	0.004	0.009	0.017	0.025	0.040	0.040	0.045	0.045	0.065	0.065	0.080	0.080	0.090	0.105	0.105	0.120	0.130	0.130	0.140	0.140
F54	mm/terä	-	0.002	0.006	0.010	0.016	0.027	0.027	0.041	0.041	0.055	0.055	0.072	0.072	0.082	0.103	0.103	0.113	0.123	0.123	0.164	0.164
F55	mm/terä	-	0.004	0.008	0.016	0.025	0.041	0.041	0.062	0.062	0.082	0.082	0.103	0.103	0.123	0.144	0.144	0.164	0.185	0.185	0.236	0.236
F56	mm/terä	-	0.006	0.010	0.021	0.031	0.051	0.051	0.082	0.082	0.103	0.103	0.133	0.133	0.164	0.185	0.185	0.215	0.246	0.246	0.318	0.318

Syöttösuositukset

CoroMill® Plura

Tuumakoko

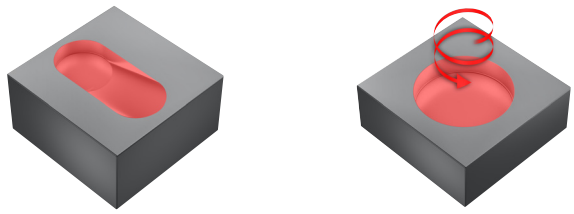
D_c	tuumaa	.020	.039	.079	.118	.157	.236	.250	.313	.315	.375	.394	.472	.500	.551	.625	.630	.709	.750	.787	.984	1.000
F1	tuumaa/terä	-	.0004	.0008	.0008	.0008	.0016	.0016	.0024	.0024	.0028	.0028	.0031	.0031	.0039	.0043	.0043	.0047	.0047	.0047	.0047	.0047
F2	tuumaa/terä	-	.0004	.0012	.0016	.0016	.0020	.0020	.0031	.0031	.0043	.0047	.0047	.0047	.0047	.0055	.0055	.0055	.0063	.0067	.0075	.0075
F3	tuumaa/terä	-	.0008	.0016	.0020	.0024	.0031	.0031	.0047	.0047	.0055	.0055	.0055	.0055	.0055	.0055	.0055	.0063	.0083	.0083	.0094	.0094
F4	tuumaa/terä	.0004	.0004	.0008	.0008	.0008	.0012	.0012	.0020	.0020	.0024	.0024	.0028	.0028	.0031	.0035	.0035	.0039	.0039	.0039	.0039	.0039
F5	tuumaa/terä	.0004	.0004	.0008	.0012	.0012	.0016	.0016	.0028	.0028	.0039	.0039	.0039	.0039	.0039	.0047	.0047	.0047	.0047	.0055	.0063	.0063
F6	tuumaa/terä	-	.0008	.0012	.0016	.0020	.0028	.0028	.0039	.0039	.0047	.0047	.0047	.0047	.0047	.0047	.0047	.0059	.0071	.0079	.0079	.0079
F7	tuumaa/terä	.0004	.0008	.0012	.0020	.0024	.0031	.0031	.0047	.0047	.0059	.0059	.0059	.0059	.0059	.0063	.0063	.0071	.0079	.0079	.0098	.0098
F8	tuumaa/terä	.0004	.0004	.0008	.0008	.0008	.0008	.0008	.0016	.0016	.0020	.0020	.0024	.0024	.0024	.0028	.0028	.0031	.0031	.0031	.0031	.0031
F9	tuumaa/terä	.0004	.0004	.0008	.0008	.0008	.0016	.0016	.0024	.0024	.0031	.0031	.0031	.0031	.0031	.0039	.0039	.0039	.0039	.0043	.0051	.0051
F10	tuumaa/terä	-	.0008	.0008	.0012	.0016	.0024	.0024	.0031	.0031	.0039	.0039	.0039	.0039	.0039	.0039	.0047	.0047	.0055	.0063	.0063	.0063
F11	tuumaa/terä	.0006	.0008	.0012	.0016	.0020	.0024	.0024	.0039	.0039	.0047	.0047	.0047	.0047	.0047	.0055	.0055	.0059	.0063	.0063	.0079	.0079
F12	tuumaa/terä	.0014	.0024	.0031	.0039	.0051	.0071	.0071	.0102	.0102	.0130	.0130	.0130	.0130	.0138	.0150	.0150	.0157	.0169	.0173	.0197	.0197
F13	tuumaa/terä	-	-	.0006	.0009	.0013	.0028	.0030	.0038	.0038	.0056	.0059	.0071	.0075	.0083	.0094	.0094	.0106	.0113	.0118	.0148	.0148
F14	tuumaa/terä	-	-	.0005	.0007	.0009	.0024	.0025	.0031	.0031	.0049	.0051	.0061	.0065	.0072	.0081	.0082	.0092	.0098	.0102	.0128	.0128
F15	tuumaa/terä	-	-	.0003	.0005	.0006	.0014	.0015	.0019	.0019	.0028	.0030	.0035	.0038	.0041	.0047	.0047	.0053	.0056	.0059	.0074	.0074
F16	tuumaa/terä	-	-	-	-	-	.0028	.0030	.0034	.0034	.0045	.0047	.0057	.0060	.0066	.0075	.0076	.0085	.0090	.0094	-	-
F17	tuumaa/terä	-	-	-	-	-	.0024	.0025	.0028	.0028	.0039	.0041	.0049	.0052	.0057	.0065	.0066	.0074	.0078	.0082	-	-
F18	tuumaa/terä	-	-	-	-	-	.0014	.0015	.0019	.0019	.0023	.0024	.0028	.0030	.0033	.0038	.0038	.0043	.0045	.0047	-	-
F19	tuumaa/terä	-	-	-	-	-	.0028	.0028	.0031	.0031	.0031	.0031	.0035	.0035	.0039	.0039	.0039	.0059	.0059	.0063	.0075	.0075
F20	tuumaa/terä	-	-	-	-	-	.0024	.0024	.0024	.0024	.0028	.0028	.0028	.0028	.0031	.0031	.0031	.0051	.0051	.0055	.0063	.0063
F21	tuumaa/terä	-	-	-	-	-	.0016	.0016	.0020	.0020	.0020	.0020	.0024	.0024	.0028	.0028	.0028	.0047	.0047	.0051	.0059	.0059
F22	tuumaa/terä	-	.0008	.0016	.0016	.0016	.0028	.0028	.0043	.0043	.0051	.0051	.0059	.0059	.0071	.0079	.0079	.0087	.0087	.0087	.0087	.0087
F23	tuumaa/terä	-	.0012	.0024	.0028	.0028	.0039	.0039	.0067	.0067	.0087	.0087	.0087	.0087	.0087	.0102	.0102	.0102	.0122	.0122	.0138	.0138
F24	tuumaa/terä	-	.0016	.0028	.0028	.0043	.0059	.0059	.0079	.0079	.0102	.0102	.0102	.0102	.0102	.0102	.0102	.0130	.0173	.0173	.0173	.0173
F25	tuumaa/terä	-	.0004	.0004	.0004	.0008	.0008	.0008	.0012	.0012	.0016	.0016	.0020	.0020	.0024	.0028	.0028	-	-	-	-	-
F26	tuumaa/terä	-	.0004	.0008	.0008	.0012	.0016	.0016	.0024	.0024	.0031	.0031	.0039	.0039	.0047	.0055	.0055	-	-	-	-	-
F27	tuumaa/terä	-	-	.0008	.0009	.0011	.0014	.0014	.0017	.0017	.0019	.0020	.0022	.0023	.0025	.0027	.0028	.0030	.0032	.0033	.0039	-
F28	tuumaa/terä	-	-	.0009	.0012	.0014	.0019	.0019	.0023	.0023	.0026	.0028	.0031	.0033	.0035	.0039	.0039	.0043	.0045	.0047	.0057	-
F29	tuumaa/terä	-	-	.0011	.0014	.0016	.0021	.0022	.0026	.0026	.0030	.0031	.0037	.0039	.0042	.0047	.0047	.0052	.0055	.0058	.0071	-
F30	tuumaa/terä	-	-	.0008	.0009	.0010	.0012	.0012	.0014	.0014	.0015	.0016	.0018	.0019	.0021	.0023	.0024	.0026	.0028	.0029	.0035	-
F31	tuumaa/terä	-	-	.0008	.0009	.0010	.0015	.0016	.0020	.0020	.0025	.0026	.0030	.0031	.0033	.0037	.0037	.0040	.0042	.0044	.0052	-
F32	tuumaa/terä	-	-	.0008	.0009	.0010	.0017	.0019	.0024	.0024	.0030	.0031	.0035	.0037	.0039	.0043	.0043	.0047	.0049	.0051	.0079	-
F33	tuumaa/terä	-	-	.0008	.0008	.0008	.0008	.0008	.0011	.0011	.0013	.0014	.0015	.0016	.0016	.0018	.0018	.0019	.0020	.0020	.0024	-
F34	tuumaa/terä	-	-	.0009	.0010	.0011	.0013	.0013	.0015	.0015	.0016	.0017	.0019	.0020	.0021	.0023	.0024	.0026	.0027	.0028	.0034	-
F35	tuumaa/terä	-	-	.0012	.0013	.0014	.0016	.0016	.0018	.0018	.0019	.0020	.0028	.0030	.0036	.0043	.0044	.0052	.0056	.0060	.0080	-
F36	tuumaa/terä	.0004	.0004	.0008	.0012	.0016	.0020	.0020	.0031	.0031	.0039	.0039	.0047	.0047	.0047	.0047	.0047	.0047	.0059	.0059	.0079	.0079
F37	tuumaa/terä	.0000	.0012	.0020	.0031	.0039	.0047	.0047	.0059	.0059	.0079	.0079	.0079	.0079	.0079	.0079	.0079	.0079	.0098	.0098	.0098	.0098
F38	tuumaa/terä	.0008	.0008	.0016	.0016	.0020	.0028	.0028	.0043	.0043	.0051	.0051	.0059	.0059	.0071	.0079	.0079	.0087	.0087	.0087	.0087	.0087
F39	tuumaa/terä	.0008	.0012	.0024	.0028	.0028	.0039	.0039	.0063	.0063	.0087	.0087	.0087	.0087	.0087	.0102	.0102	.0102	.0122	.0122	.0138	.0138
F40	tuumaa/terä	-	-	-	.0028	.0039	.0063	.0063	.0098	.0098	.0118	.0118	.0138	.0138	.0157	.0197	.0197	.0236	.0276	.0276	.0276	.0276
F41	tuumaa/terä	-	-	-	.0024	.0031	.0051	.0051	.0079	.0079	.0094	.0094	.0110	.0110	.0126	.0157	.0157	.0189	.0220	.0220	.0220	.0220
F42	tuumaa/terä	.0008	.0004	.0008	.0008	.0016	.0018	.0018	.0024	.0024	.0035	.0035	.0039	.0039	.0039	.0039	.0039	.0039	.0047	.0047	.0063	.0063
F43	tuumaa/terä	-	.0008	.0016	.0026	.0031	.0039	.0039	.0047	.0047	.0063	.0063	.0063	.0063	.0063	.0063	.0063	.0063	.0079	.0079	.0079	.0079
F44	tuumaa/terä	-	.0012	.0024	.0028	.0035	.0047	.0047	.0071	.0071	.0093	.0093	.0102	.0102	.0102	.0102	.0102	.0110	.0130	.0130	.0173	.0173
F45	tuumaa/terä	-	.0028	.0043	.0069	.0087	.0102	.0102	.0130	.0130	.0173	.0173	.0173	.0173	.0173	.0173	.0173	.0173	.0197	.0197	.0197	.0197
F46	tuumaa/terä	-	.0001	.0001	.0002	.0003	.0005	.0005	.0008	.0008	.0011	.0011	.0014	.0014	.0016	.0020	.0020	.0022	.0024	.0024	.0031	.0031
F47	tuumaa/terä	-	.0002	.0002	.0003	.0005	.0008	.0008	.0012	.0012	.0016	.0016	.0020	.0020	.0024	.0028	.0028	.0031	.0035	.0035	.0045	.0045
F48	tuumaa/terä	-	.0001	.0002	.0003	.0004	.0007	.0007	.0011	.0011	.0014	.0014	.0019	.0019	.0021	.0026	.0026	.0029	.0031	.0031	.0042	.0042
F49	tuumaa/terä	-	.0001	.0002	.0004	.0006	.0010	.0010	.0016	.0016	.0021	.0021	.0026	.0026	.0031	.0037	.0037	.0004	.0047	.0047	.0060	.0060
F50	tuumaa/terä	-	.0001	.0002	.0004	.0006	.0010	.0010	.0016	.0016	.0020	.0020	.0026	.0026	.0031	.0035	.0035	.0041	.0047	.0047	.0061	.0061
F51	tuumaa/terä	-	.0002	.0002	.0004	.0005	.0008	.0008	.0009	.0009	.0014	.0014	.0016	.0016	.0020	.0022	.0022	.0024	.0028	.0028	.0031	.0031
F52	tuumaa/terä	-	.0001	.0003	.0005	.0008	.0012	.0012	.0016	.0016	.0020	.0020	.0024	.0024	.0028	.0031	.0031	.0035	.0039	.0039	.0043	.0043
F53	tuumaa/terä	-	.0002	.0004	.0007	.0010	.0016	.0016	.0018	.0018	.0026	.0026	.0031	.0031	.0035	.0041	.0041	.0047	.0051	.0051	.0055	.0055
F54	tuumaa/terä	-	.0002	.0002	.0004	.0006	.0010	.0010	.0016	.0016	.0022	.0022	.0028	.0028	.0032	.0040	.0040	.0044	.0048	.0048	.0065	.0065
F55	tuumaa/terä	-	.0002	.0003	.0006	.0010	.0016	.0016	.0024	.0024	.0032	.0032	.0040	.0040	.0048	.0056	.0056	.0065	.0073	.0073	.0093	.0093
F56	tuumaa/terä	-	.0002	.0004	.0008	.0012	.0020	.0020	.0032	.0032	.0040	.0040	.0052	.0052	.0065	.0073	.0073	.0085	.0097	.0097	.0125	.0125

SANDVIK Coromant

FIN

Suurin sisäänmenokulma

CoroMill® Plura



ISO	Raaka-aine	Terien lukumäärä (ZEFP) ≤ 2	3	4	5	≥ 6
P	Teräs (Kovuus <300HB)	9	7	5	5	≤ 4
	Teräs (Kovuus >300HB)	7	5	4	3	≤ 3
M	Ruostumaton teräs	5	5	5	4	≤ 4
K	Valurauta	10	10	8	6	≤ 5
N	Ei-rauta-aineet	15	12	10	10	≤ 10
S	Superseokset ja titaani	5	5	4	4	≤ 3
H	Kovat aineet	2	2	1.5	1.5	≤ 1.5
O	Ei ISO	15	12	10	10	≤ 10

Jyrsintälaadut

	P	M	K	N	S	H	O	Märkänä	Kuivana	Kuvaus
1620	+	++	+	++		+		✔	✔	Monikäyttöinen laatu, samankaltainen kuin 1630. Toimii useimmissa materiaaleissa. Erittäin kulumiskestävä. Laatua 1630 vahvempi ISO S- ja ISO M -materiaalien koneistuksessa. Suositellaan kuivakoneistusta.
1630	++	+	++	+	+		+	✔	✔	Monikäyttöinen laatu, samankaltainen kuin 1620. Toimii useimmissa materiaaleissa. Laatua 1620 vahvempi ISO P- ja ISO K -materiaalien koneistuksessa. Suositellaan kuivakoneistusta.
1640	+	++	+		++			✔	✔	Erittäin sitkeä laatu isoille lastukuormille (iso a). Toimii useimmissa materiaaleissa. Toimii hyvin märkänä. Sopii ei-tukeviin olosuhteisiin.

CoroDrill® 460

Sisäinen lastuamisnestekanava, metriset

2 – 3 x DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) m/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	100-125-150
	P1.1.Z.AN	C = 0,1–0,25 %	125	100-125-150
	P1.2.Z.AN	C = 0,25–0,55 %	150	88-110-132
	P1.3.Z.AN	C = 0,55–0,80 %	170	88-110-132
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	88-110-132
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	88-110-132
	P2.5.Z.HT.1	Nuorrutettu	275	60-75-90
	P2.5.Z.HT.2	Nuorrutettu	350	52-65-78
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	76-95-114
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	52-65-78
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	88-110-132
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	200	76-95-114
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	32-40-48
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	32-40-48
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	28-35-42
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	28-35-42
	M1.0.C.UT	Austeniittinen	200	32-40-48
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	32-40-48
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	28-35-42
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	64-80-96
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	88-110-132
	K2.2.C.UT	Suuri murtolujuus	245	88-110-132
	K2.3.C.UT	Austeniittinen	175	64-80-96
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	64-80-96
	K3.2.C.UT	Ferriittinen Perliittinen	215	64-80-96
	K3.3.C.UT	Perliittinen	265	64-80-96
	K3.5.C.UT	Austeniittinen	190	64-80-96
	K5.1.C.NS	Austemperoitu	300	64-80-96
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Puhdas kauppatitaani	60	200-250-300
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	200-250-300
	N1.3.C.UT	Valettu, ei-vanheneva	75	200-250-300
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	160-200-240
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	120-150-180
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	176-220-264
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	100-125-150
S		**Titaani**		
	S4.1.Z.UT		200	44-55-66
	S4.2.Z.AN		320	32-40-48
	S4.4.Z.AN		330	32-40-48
H	H1.1.Z.HA	Erikoiskova teräs: Nuorrutettu	50HRC	24-30-36
	H2.0.C.UT.4	Kokillikarkaistu valu	64HRC	20-25-30

FIN

CoroDrill® 460

Sisäinen lastuamisnestekanava, metriset

2 – 3 x DC

Poran halkaisija, mm							
3	4	6	8	10	12	16	20
Syöttö , mm/kierr. (min.-aloitus-maks.)							
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
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0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
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0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
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0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
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0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288

CoroDrill® 460

Sisäinen lastuamisnestekanava, metriset

4 – 5 × DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) m/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	100-125-150
	P1.1.Z.AN	C = 0,1–0,25 %	125	100-125-150
	P1.2.Z.AN	C = 0,25–0,55 %	150	88-110-132
	P1.3.Z.AN	C = 0,55–0,80 %	170	88-110-132
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	88-110-132
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	88-110-132
	P2.5.Z.HT.1	Nuorrutettu	275	60-75-90
	P2.5.Z.HT.2	Nuorrutettu	350	52-65-78
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	76-95-114
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	52-65-78
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	88-110-132
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	200	76-95-114
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	32-40-48
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	32-40-48
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	28-35-42
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	28-35-42
	M1.0.C.UT	Austeniittinen	200	32-40-48
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	32-40-48
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	28-35-42
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	64-80-96
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	88-110-132
	K2.2.C.UT	Suuri murtolujuus	245	88-110-132
	K2.3.C.UT	Austeniittinen	175	64-80-96
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	64-80-96
	K3.2.C.UT	Ferriittinen Perliittinen	215	64-80-96
	K3.3.C.UT	Perliittinen	265	64-80-96
	K3.5.C.UT	Austeniittinen	190	64-80-96
	K5.1.C.NS	Austemperoitu	300	64-80-96
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Puhdas kauppatitaani	60	200-250-300
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	200-250-300
	N1.3.C.UT	Valettu, ei-vanheneva	75	200-250-300
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	160-200-240
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	120-150-180
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	176-220-264
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	100-125-150
S		**Titaani**		
	S4.1.Z.UT		200	44-55-66
	S4.2.Z.AN		320	32-40-48
	S4.4.Z.AN		330	32-40-48
H	H1.1.Z.HA	Erikoiskova teräs: Nuorrutettu	50HRC	24-30-36
	H2.0.C.UT.4	Kokillikarkaistu valu	64HRC	20-25-30

SANDVIK Coromant

FIN

CoroDrill® 460

Sisäinen lastuamisnestekanava, metriset

4 – 5 × DC

Poran halkaisija, mm							
3	4	6	8	10	12	16	20
Syöttö , mm/kierr. (min.-aloitus-maks.)							
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
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0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288

CoroDrill® 460

Sisäinen lastuamisnestekanava, metriset

7 – 8 × DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) m/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	104-130-156
	P1.1.Z.AN	C = 0,1–0,25 %	125	104-130-156
	P1.2.Z.AN	C = 0,25–0,55 %	150	88-110-132
	P1.3.Z.AN	C = 0,55–0,80 %	170	88-110-132
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	88-110-132
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	88-110-132
	P2.5.Z.HT.1	Nuorrutettu	275	72-90-108
	P2.5.Z.HT.2	Nuorrutettu	350	64-80-96
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	80-100-120
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	64-80-96
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	88-110-132
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤5 %)	200	80-100-120
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	24-30-36
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	24-30-36
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	20-25-30
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	20-25-30
	M1.0.C.UT	Austeniittinen	200	24-30-36
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	24-30-36
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	20-25-30
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	60-75-90
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	92-115-138
	K2.2.C.UT	Pieni murtolujuus	245	92-115-138
	K2.3.C.UT	Austeniittinen	175	60-75-90
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	60-75-90
	K3.2.C.UT	Ferriittinen Perliittinen	215	60-75-90
	K3.3.C.UT	Perliittinen	265	60-75-90
	K3.5.C.UT	Austeniittinen	190	60-75-90
	K5.1.C.NS	Austemperoitu	300	60-75-90
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Kaupallisesti puhdas	60	216-270-324
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	216-270-324
	N1.3.C.UT	Valettu, ei-vanheneva	75	216-270-324
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	144-180-216
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	72-90-108
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	176-220-264
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	100-125-150

FIN

CoroDrill® 460

Sisäinen lastuamisnestekanava, metriset

7 – 8 × DC

Poran halkaisija, mm							
3	4	6	8	10	12	16	20
Syöttö , mm/kierr. (min.-aloitus-maks.)							
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.120-0.150-0.180	0.144-0.180-0.216	0.200-0.250-0.300	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.440-0.550-0.660	0.464-0.580-0.696
0.120-0.150-0.180	0.144-0.180-0.216	0.200-0.250-0.300	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.440-0.550-0.660	0.464-0.580-0.696
0.120-0.150-0.180	0.144-0.180-0.216	0.200-0.250-0.300	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.440-0.550-0.660	0.464-0.580-0.696
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408

CoroDrill® 460

Ulkoinen lastuamisnestekanava, metriset

2 – 3 x DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) m/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	80-100-125
	P1.1.Z.AN	C = 0,1–0,25 %	125	80-100-125
	P1.2.Z.AN	C = 0,25–0,55 %	150	70.4-88-110
	P1.3.Z.AN	C = 0,55–0,80 %	170	70.4-88-110
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	70.4-88-110
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	70.4-88-110
	P2.5.Z.HT.1	Nuorrutettu	275	48-60-75
	P2.5.Z.HT.2	Nuorrutettu	350	61.6-52-65
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	60.8-76-95
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	41.6-52-65
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	70.4-88-110
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	200	60.8-76-95
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	22.4-28-35
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	22.4-28-35
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	19.2-24-30
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	19.2-24-30
	M1.0.C.UT	Austeniittinen	200	22.4-28-35
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	22.4-28-35
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	19.2-24-30
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	51.2-64-80
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	70.4-88-110
	K2.2.C.UT	Suuri murtolujuus	245	70.4-88-110
	K2.3.C.UT	Austeniittinen	175	51.2-64-80
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	51.2-64-80
	K3.2.C.UT	Ferriittinen Perliittinen	215	51.2-64-80
	K3.3.C.UT	Perliittinen	265	51.2-64-80
	K3.5.C.UT	Austeniittinen	190	51.2-64-80
	K5.1.C.NS	Austemperoitu	300	51.2-64-80
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Puhdas kauppatitaani	60	160-200-250
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	160-200-250
	N1.3.C.UT	Valettu, ei-vanheneva	75	160-200-250
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	128-160-200
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	96-120-150
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	140.8-176-220
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	80-100-125
S		**Titaani**		
	S4.1.Z.UT		200	32.5-44-55
	S4.2.Z.AN		320	25.6-32-40
	S4.4.Z.AN		330	25.6-32-40
H	H1.1.Z.HA	Erikoiskova teräs: Nuorrutettu	50HRC	19.2-24-30
	H2.0.C.UT.4	Kokillikarkaistu valu	64HRC	16-20-25

FIN

CoroDrill® 460

Ulkoinen lastuamisnestekanava, metriset

2 – 3 x DC

Poran halkaisija, mm							
3	4	6	8	10	12	16	20
Syöttö , mm/kierr. (min.-aloitus-maks.)							
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.16-0.20-0.24	0.184-0.230-0.276	0.192-0.240-0.288
0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.16-0.20-0.24	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.16-0.20-0.24	0.184-0.230-0.276	0.192-0.240-0.288

CoroDrill® 460

Ulkoinen lastuamisnestekanava, metriset

4 – 5 × DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) m/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	80-100-125
	P1.1.Z.AN	C = 0,1–0,25 %	125	80-100-125
	P1.2.Z.AN	C = 0,25–0,55 %	150	70.4-88-110
	P1.3.Z.AN	C = 0,55–0,80 %	170	70.4-88-110
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	70.4-88-110
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	70.4-88-110
	P2.5.Z.HT.1	Nuorrutettu	275	48-60-75
	P2.5.Z.HT.2	Nuorrutettu	350	41.6-52-65
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	60.8-76-95
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	41.6-52-65
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	70.4-88-110
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	200	60.8-76-95
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	22.4-28-35
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	22.4-28-35
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	19.2-24-30
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	19.2-24-30
	M1.0.C.UT	Austeniittinen	200	22.4-28-35
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	22.4-28-35
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	19.2-24-30
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	51.2-64-80
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	70.4-88-110
	K2.2.C.UT	Suuri murtolujuus	245	70.4-88-110
	K2.3.C.UT	Austeniittinen	175	51.2-64-80
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	51.2-64-80
	K3.2.C.UT	Ferriittinen Perliittinen	215	51.2-64-80
	K3.3.C.UT	Perliittinen	265	51.2-64-80
	K3.5.C.UT	Austeniittinen	190	51.2-64-80
	K5.1.C.NS	Austemperoitu	300	51.2-64-80
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Puhdas kauppatitaani	60	160-200-250
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	160-200-250
	N1.3.C.UT	Valettu, ei-vanheneva	75	160-200-250
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	128-160-200
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	96-120-150
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	140.8-176-220
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	80-100-125
S		**Titaani**		
	S4.1.Z.UT		200	32.5-44-55
	S4.2.Z.AN		320	25.6-32-40
	S4.4.Z.AN		330	25.6-32-40
H	H1.1.Z.HA	Erikoiskova teräs: Nuorrutettu	50HRC	19.2-24-30
	H2.0.C.UT.4	Kokillikarkaistu valu	64HRC	16-20-25

SANDVIK Coromant

FIN

CoroDrill® 460

Ulkoinen lastuamisnestekanava, metriset

4 – 5 × DC

Poran halkaisija, mm							
3	4	6	8	10	12	16	20
Syöttö , mm/kierr. (min.-aloitus-maks.)							
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

2 – 3 x DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) ft/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	328-410-492
	P1.1.Z.AN	C = 0,1–0,25 %	125	328-410-492
	P1.2.Z.AN	C = 0,25–0,55 %	150	289-361-433
	P1.3.Z.AN	C = 0,55–0,80 %	170	289-361-433
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	289-361-433
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	289-361-433
	P2.5.Z.HT.1	Nuorrutettu	275	197-246-295
	P2.5.Z.HT.2	Nuorrutettu	350	171-213-256
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	249-312-374
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	171-213-256
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	289-361-433
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	200	249-312-374
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	105-131-157
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	105-131-157
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	92-115-138
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	92-115-138
	M1.0.C.UT	Austeniittinen	200	105-131-157
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	105-131-157
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	92-115-138
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	210-262-315
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	289-361-433
	K2.2.C.UT	Suuri murtolujuus	245	289-361-433
	K2.3.C.UT	Austeniittinen	175	210-262-315
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	210-262-315
	K3.2.C.UT	Ferriittinen Perliittinen	215	210-262-315
	K3.3.C.UT	Perliittinen	265	210-262-315
	K3.5.C.UT	Austeniittinen	190	210-262-315
	K5.1.C.NS	Austemperoitu	300	210-262-315
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Puhdas kauppatitaani	60	656-820-984
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	656-820-984
	N1.3.C.UT	Valettu, ei-vanheneva	75	656-820-984
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	525-656-787
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	394-492-591
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	577-722-866
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	328-410-492
S		**Titaani**		
	S4.1.Z.UT		200	144-180-217
	S4.2.Z.AN		320	105-121-157
	S4.4.Z.AN		330	105-121-157
H	H1.1.Z.HA	Erikoiskova teräs: Nuorrutettu	50HRC	79-98-118
	H2.0.C.UT.4	Kokillikarkaistu valu	64HRC	66-82-98

FIN

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

2 – 3 x DC

Poran halkaisija, tuumaa							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Syöttö , tuumaa/kierr. (min.-aloitus-maks.)							
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

4 – 5 × DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) ft/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	328-410-492
	P1.1.Z.AN	C = 0,1–0,25 %	125	328-410-492
	P1.2.Z.AN	C = 0,25–0,55 %	150	289-361-433
	P1.3.Z.AN	C = 0,55–0,80 %	170	289-361-433
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	289-361-433
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	289-361-433
	P2.5.Z.HT.1	Nuorrutettu	275	197-246-295
	P2.5.Z.HT.2	Nuorrutettu	350	171-213-256
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	249-312-374
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	171-213-256
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	289-361-433
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	200	249-312-374
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	105-131-157
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	105-131-157
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	92-115-138
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	92-115-138
	M1.0.C.UT	Austeniittinen	200	105-131-157
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	105-131-157
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	92-115-138
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	210-262-315
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	289-361-433
	K2.2.C.UT	Suuri murtolujuus	245	289-361-433
	K2.3.C.UT	Austeniittinen	175	210-262-315
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	210-262-315
	K3.2.C.UT	Ferriittinen Perliittinen	215	210-262-315
	K3.3.C.UT	Perliittinen	265	210-262-315
	K3.5.C.UT	Austeniittinen	190	210-262-315
	K5.1.C.NS	Austemperoitu	300	210-262-315
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Puhdas kauppatitaani	60	656-820-984
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	656-820-984
	N1.3.C.UT	Valettu, ei-vanheneva	75	656-820-984
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	525-656-787
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	394-492-591
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	577-722-866
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	328-410-492
S		**Titaani**		
	S4.1.Z.UT		200	144-180-217
	S4.2.Z.AN		320	105-121-157
	S4.4.Z.AN		330	105-121-157
H	H1.1.Z.HA	Erikoiskova teräs: Nuorrutettu	50HRC	79-98-118
	H2.0.C.UT.4	Kokillikarkaistu valu	64HRC	66-82-98

FIN

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

4 – 5 × DC

Poran halkaisija, tuumaa							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Syöttö , tuumaa/kierr. (min.-aloitus-maks.)							
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

7 – 8 × DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) ft/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	341-427-512
	P1.1.Z.AN	C = 0,1–0,25 %	125	341-427-512
	P1.2.Z.AN	C = 0,25–0,55 %	150	289-361-433
	P1.3.Z.AN	C = 0,55–0,80 %	170	289-361-433
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	289-361-433
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	289-361-433
	P2.5.Z.HT.1	Nuorrutettu	275	236-295-354
	P2.5.Z.HT.2	Nuorrutettu	350	210-262-315
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	262-328-394
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	210-262-315
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	289-361-433
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤5 %)	200	262-328-394
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	79-98-118
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	79-98-118
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	66-82-98
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	66-82-98
	M1.0.C.UT	Austeniittinen	200	79-98-118
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	79-98-118
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	66-82-98
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	197-246-295
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	302-377-453
	K2.2.C.UT	Suuri murtolujuus	245	302-377-453
	K2.3.C.UT	Austeniittinen	175	197-246-295
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	197-246-295
	K3.2.C.UT	Ferriittinen Perliittinen	215	197-246-295
	K3.3.C.UT	Perliittinen	265	197-246-295
	K3.5.C.UT	Austeniittinen	190	197-246-295
	K5.1.C.NS	Austemperoitu	300	197-246-295
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Kaupallisesti puhdas	60	709-886-1063
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	709-886-1063
	N1.3.C.UT	Valettu, ei-vanheneva	75	709-886-1063
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	472-591-709
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	236-295-354
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	577-722-866
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	328-410-492

SANDVIK Coromant

FIN

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

7 – 8 × DC

Poran halkaisija, tuumaa							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Syöttö , tuumaa/kierr. (min.-aloitus-maks.)							
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0047-.0059-.0071	.0057-.0071-.0085	.0079-.0098-.0118	.0104-.0130-.0156	.0132-.0165-.0198	.0151-.0189-.0227	.0173-.0217-.0260	.0183-.0228-.0274
.0047-.0059-.0071	.0057-.0071-.0085	.0079-.0098-.0118	.0104-.0130-.0156	.0132-.0165-.0198	.0151-.0189-.0227	.0173-.0217-.0260	.0183-.0228-.0274
.0047-.0059-.0071	.0057-.0071-.0085	.0079-.0098-.0118	.0104-.0130-.0156	.0132-.0165-.0198	.0151-.0189-.0227	.0173-.0217-.0260	.0183-.0228-.0274
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

2 – 3 x DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) ft/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	262-328-410
	P1.1.Z.AN	C = 0,1–0,25 %	125	262-328-410
	P1.2.Z.AN	C = 0,25–0,55 %	150	289-361-433
	P1.3.Z.AN	C = 0,55–0,80 %	170	231-289-361
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	231-289-361
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	231-289-361
	P2.5.Z.HT.1	Nuorrutettu	275	157-197-246
	P2.5.Z.HT.2	Nuorrutettu	350	136-171-213
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	199-249-312
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	136-171-213
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	231-289-361
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	200	199-249-312
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	73-92-115
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	73-92-115
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	63-79-98
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	63-79-98
	M1.0.C.UT	Austeniittinen	200	73-92-115
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	73-92-115
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	63-79-98
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	168-210-262
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	231-289-361
	K2.2.C.UT	Suuri murtolujuus	245	231-289-361
	K2.3.C.UT	Austeniittinen	175	168-210-262
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	168-210-262
	K3.2.C.UT	Ferriittinen Perliittinen	215	168-210-262
	K3.3.C.UT	Perliittinen	265	168-210-262
	K3.5.C.UT	Austeniittinen	190	210-262-315
	K5.1.C.NS	Austemperoitu	300	168-210-262
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Puhdas kauppatitaani	60	525-656-820
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	525-656-820
	N1.3.C.UT	Valettu, ei-vanheneva	75	525-656-820
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	420-525-656
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	315-394-492
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	462-577-722
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	262-328-410
S		**Titaani**		
	S4.1.Z.UT		200	115-144-180
	S4.2.Z.AN		320	84-105-131
	S4.4.Z.AN		330	84-105-131
H	H1.1.Z.HA	Erikoiskova teräs: Nuorrutettu	50HRC	63-79-98
	H2.0.C.UT.4	Kokillikarkaistu valu	64HRC	52-66-82

FIN

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

2 – 3 x DC

Poran halkaisija, tuumaa							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Syöttö , tuumaa/kierr. (min.-aloitus-maks.)							
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

4 – 5 × DC

ISO	MC-nro	Raaka-aine	Kovuus Brinell HB	Lastuamisnopeus (V_c) ft/min
P		**Seostamaton teräs**		(min.–aloitus–maks.)
	P1.1.Z.AN	C = 0.05–0.10 %	125	262-328-410
	P1.1.Z.AN	C = 0,1–0,25 %	125	262-328-410
	P1.2.Z.AN	C = 0,25–0,55 %	150	289-361-433
	P1.3.Z.AN	C = 0,55–0,80 %	170	231-289-361
		Runsashiilinen teräs		
	P1.3.Z.AN	Seostamaton työkaluteräs	210	231-289-361
		Niukkaseosteinen teräs		
	P2.1.Z.AN	Karkaisematon	175	231-289-361
	P2.5.Z.HT.1	Nuorrutettu	275	157-197-246
	P2.5.Z.HT.2	Nuorrutettu	350	136-171-213
		Runsasseosteinen teräs		
	P3.0.Z.AN	Hehkutettu	200	199-249-312
	P3.0.Z.HT.1	Karkaistu työkaluteräs	300	136-171-213
		Teräsvalut		
	P1.5.C.UT	Seostamaton	150	231-289-361
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	200	199-249-312
M		**Ruostumaton teräs**		
	M1.0.Z.AQ	Austeniittinen	200	73-92-115
	M2.0.Z.AQ	Superausteniittiset, Ni ≥ 20 %	200	73-92-115
	M3.1.Z.AQ	Duplex (austeniittis-ferriittinen)	230	63-79-98
	M3.2.Z.AQ	Duplex (austeniittis-ferriittinen)	260	63-79-98
	M1.0.C.UT	Austeniittinen	200	73-92-115
	M2.0.C.AQ	Superausteniittiset, Ni ≥ 20 %	200	73-92-115
	M3.1.C.AQ	Duplex (austeniittis-ferriittinen)	230	63-79-98
K		**Adusoitu valurauta**		
	K1.1.C.NS	Ferriittinen Perliittinen	200	168-210-262
		Harmaa valurauta		
	K2.1.C.UT	Pieni murtolujuus	180	231-289-361
	K2.2.C.UT	Suuri murtolujuus	245	231-289-361
	K2.3.C.UT	Austeniittinen	175	168-210-262
		Pallografiittivalurauta		
	K3.1.C.UT	Ferriittinen	155	168-210-262
	K3.2.C.UT	Ferriittinen Perliittinen	215	168-210-262
	K3.3.C.UT	Perliittinen	265	168-210-262
	K3.5.C.UT	Austeniittinen	190	168-210-262
	K5.1.C.NS	Austemperoitu	300	168-210-262
N		**Alumiinipohjaiset seokset**		
	N1.2.Z.UT	Puhdas kauppatitaani	60	525-656-820
	N1.2.Z.AG	AlSi-seokset, Si ≤ 1 %	100	525-656-820
	N1.3.C.UT	Valettu, ei-vanheneva	75	525-656-820
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	90	420-525-656
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	130	315-394-492
		Kuparipohjaiset seokset		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	110	462-577-722
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	100	262-328-410
S		**Titaani**		
	S4.1.Z.UT		200	115-144-180
	S4.2.Z.AN		320	84-105-131
	S4.4.Z.AN		330	84-105-131
H	H1.1.Z.HA	Erikoiskova teräs: Nuorrutettu	50HRC	63-79-98
	H2.0.C.UT.4	Kokillikarkaistu valu	64HRC	52-66-82

FIN

CoroDrill® 460

Sisäinen lastuamisnestekanava, tuumamitat

4 – 5 × DC

Poran halkaisija, tuumaa							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Syöttö , tuumaa/kierr. (min.-aloitus-maks.)							
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0041-.0051-.0061	.0047-.0059-.0071	.0063-.0079-.0094	.0082-.0102-.0123	.0104-.0130-.0156	.0120-.0150-.0180	.0135-.0169-.0203	.0142-.0177-.0213
.0031-.0039-.0047	.0036-.0045-.0054	.0048-.0060-.0072	.0063-.0079-.0094	.0079-.0098-.0118	.0088-.0110-.0132	.0101-.0126-.0151	.0107-.0134-.0161
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113
.0022-.0028-.0033	.0025-.0031-.0038	.0034-.0042-.0051	.0044-.0055-.0066	.0054-.0067-.0080	.0063-.0079-.0094	.0072-.0091-.0109	.0076-.0094-.0113

CoroTap™

CoroTap™ 200

Metriset arvot

				T200-XM								
				Laatu B110/C110			Laatu B145/C145			Laatu B150/C150		
				ULDR			ULDR			ULDR		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-nro	Raaka-aine	HB	v_c m/min			v_c m/min			v_c m/min		
P		**Seostamaton teräs**										
	P1.1.Z.AN		125	43	35	30	31	25	21	31	25	21
	P1.1.Z.HT		190	41	34	29	27	22	19	27	22	19
	P1.2.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.2.Z.HT		210	31	26	22	20	16	14	20	16	14
	P1.3.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.3.Z.HT		300	21	17	15	12	10	9	12	10	9
		Niukkaseosteinen teräs										
	P2.1.Z.AN		175	39	32	27	22	18	15	22	18	15
	P2.2.Z.AN		240	31	26	22	20	16	14	20	16	14
	P2.3.Z.AN		260	21	17	15	12	10	9	12	10	9
	P2.5.Z.HT.1		285	21	17	15	12	10	9	12	10	9
		Runsasseosteinen teräs										
	P3.0.Z.AN		200	31	26	22	20	16	14	20	16	14
	P3.0.Z.HT.1		380	10	8	7	6	5	4	6	5	4
	P3.1.Z.AN		250	31	26	22	20	16	14	20	16	14
		Teräsvalut										
	P1.5.C.UT		150	39	32	27	22	18	15	22	18	15
	P2.6.C.UT		200	31	26	22	20	16	14	20	16	14
		Ferriittiset/martensiittiset ruostumattomat teräkset										
	P5.0.Z.HT.1		330	32	26	22	20	16	14	20	16	14
	P5.0.Z.PH		330	12	10	9	5	4	3			
M		**Austeniittinen ruostumaton teräs**										
	M1.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M1.0.C.UT		230	10	8	7	7	6	5	-	-	-
		Superausteniittinen ruostumaton teräs										
	M2.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M2.0.C.AQ		260	10	8	7	7	6	5	-	-	-
		Ferriittis-austeniittiset ruostumattomat teräkset (duplex)										
	M3.1.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.2.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.1.C.AQ		230	6	5	4	5	4	3	-	-	-
K		**Adusoitu valurauta**										
	K1.1.C.NS		200	24	20	17	18	15	13	18	15	13
		Harmaa valurauta										
	K2.1.C.UT		180	23	19	16	18	15	13	18	15	13
	K2.2.C.UT		245	16	13	11	10	8	7	10	8	7
	K2.3.C.UT		175	24	20	17	18	15	13	18	15	13
		Pallografiittivalurauta										
	K3.1.C.UT		155	24	20	17	18	15	13	18	15	13
	K3.2.C.UT		215	24	20	17	18	15	13	18	15	13
	K3.3.C.UT		265	24	20	17	18	15	13	18	15	13
	K3.5.C.UT		190	24	20	17	18	15	13	18	15	13
	K5.1.C.NS	**Austemperoitu pallografiittivalurauta**	300	16	13	11	10	8	7	10	8	7
N		**Alumiinipohjaiset seokset**										
	N1.2.Z.UT		60	49	40	34	-	-	-	43	35	30
	N1.2.Z.AG		100	49	40	34	-	-	-	43	35	30
	N1.3.C.UT		75	49	40	34	-	-	-	43	35	30
	N1.3.C.AG		90	31	25	21	-	-	-	24	20	17
	N1.4.C.NS		130	21	18	15	-	-	-	18	15	13
		Kuparipohjaiset seokset										
	N3.3.U.UT		110	46	38	32	-	-	-	37	30	26
	N3.1.U.UT		100	18	15	13	-	-	-	15	12	10
S		**Rautapohjaiset superseokset**										
	S1.0.U.AN		200	9	8	6	-	-	-	6	5	4
		Nikkelipohjaiset superseokset										
	S2.0.Z.UT		275	9	8	6	-	-	-	6	5	4
	S2.0.Z.AN		250	9	8	6	-	-	-	6	5	4
	S2.1.Z.AN		125	23	19	16	-	-	-	15	12	10
		Titaanipohjaiset seokset										
	S4.1.Z.UT		200	21	18	15	-	-	-	18	15	13

SANDVIK Coromant

FIN

CoroTap™

CoroTap™ 200

Tuuma-arvot

				T200-XM								
				Laatu B110/C110			Laatu B145/C145			Laatu B150/C150		
				ULDR			ULDR			ULDR		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-nro	Raaka-aine	HB	v_c ft/min			v_c ft/min			v_c ft/min		
P		**Seostamaton teräs**										
	P1.1.Z.AN		125	140	115	98	100	82	70	100	82	70
	P1.1.Z.HT		190	134	110	94	88	72	62	88	72	62
	P1.2.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.2.Z.HT		210	102	84	72	64	52	45	64	52	45
	P1.3.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.3.Z.HT		300	70	57	49	40	33	28	40	33	28
		Niukkaseosteinen teräs										
	P2.1.Z.AN		175	126	103	88	72	59	51	72	59	51
	P2.2.Z.AN		240	102	84	72	64	52	45	64	52	45
	P2.3.Z.AN		260	70	57	49	40	33	28	40	33	28
	P2.5.Z.HT.1		285	70	57	49	40	33	28	40	33	28
		Runsasseosteinen teräs										
	P3.0.Z.AN		200	102	84	72	64	52	45	64	52	45
	P3.0.Z.HT.1		380	32	26	22	20	16	14	20	16	14
	P3.1.Z.AN		250	102	84	72	64	52	45	64	52	45
		Teräsvalut										
	P1.5.C.UT		150	126	103	88	72	59	51	72	59	51
	P2.6.C.UT		200	102	84	72	64	52	45	64	52	45
		Ferriittiset/martensiittiset ruostumattomat teräkset										
	P5.0.Z.HT.1		330	104	85	73	64	52	45	64	52	45
	P5.0.Z.PH		330	40	33	28	16	13	11	-	-	-
M		**Austeniittinen ruostumaton teräs**										
	M1.0.Z.AQ		200	32	26	22	24	20	17	-	-	-
	M1.0.C.UT		230	32	26	22	24	20	17	-	-	-
		Superausteniittinen ruostumaton teräs										
	M2.0.Z.AQ		200	32	26	22	24	20	17	-	-	-
	M2.0.C.AQ		260	32	26	22	24	20	17	-	-	-
		Ferriittis-austeniittiset ruostumattomat teräkset (duplex)										
	M3.1.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.2.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.1.C.AQ		230	20	16	14	16	13	11	-	-	-
K		**Adusoitu valurauta**										
	K1.1.C.NS		200	80	66	56	60	49	42	60	49	42
		Harmaa valurauta										
	K2.1.C.UT		180	74	61	52	60	49	42	60	49	42
	K2.2.C.UT		245	52	43	36	32	26	22	32	26	22
	K2.3.C.UT		175	80	66	56	60	49	42	60	49	42
		Pallografiittivalurauta										
	K3.1.C.UT		155	80	66	56	60	49	42	60	49	42
	K3.2.C.UT		215	80	66	56	60	49	42	60	49	42
	K3.3.C.UT		265	80	66	56	60	49	42	60	49	42
	K3.5.C.UT		190	80	66	56	60	49	42	60	49	42
	K5.1.C.NS	**Austemperoitu pallografiittivalurauta**	300	52	43	36	32	26	22	32	26	22
N		**Alumiinipohjaiset seokset**										
	N1.2.Z.UT		60	161	131	112	-	-	-	140	115	98
	N1.2.Z.AG		100	161	131	112	-	-	-	140	115	98
	N1.3.C.UT		75	161	131	112	-	-	-	140	115	98
	N1.3.C.AG		90	100	82	70	-	-	-	80	66	56
	N1.4.C.NS		130	70	57	49	-	-	-	60	49	42
		Kuparipohjaiset seokset										
	N3.3.U.UT		110	150	123	105	-	-	-	120	98	84
	N3.1.U.UT		100	60	49	42	-	-	-	48	39	34
S		**Rautapohjaiset superseokset**										
	S1.0.U.AN		200	30	25	21	-	-	-	20	16	14
		Nikkelipohjaiset superseokset										
	S2.0.Z.UT		275	30	25	21	-	-	-	20	16	14
	S2.0.Z.AN		250	30	25	21	-	-	-	20	16	14
	S2.1.Z.AN		125	74	61	52	-	-	-	48	39	34
		Titaanipohjaiset seokset										
	S4.1.Z.UT		200	70	57	49	-	-	-	60	49	42

CoroTap™

CoroTap™ 300

Metriset arvot

				T300-XM								
				Laatu B110/C110			Laatu B145/C145			Laatu B150/C150		
				ULDR			ULDR			ULDR		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-nro	Raaka-aine	HB	v_c m/min			v_c m/min			v_c m/min		
P		**Seostamaton teräs**										
	P1.1.Z.AN		125	43	35	30	31	25	21	31	25	21
	P1.1.Z.HT		190	41	34	29	27	22	19	27	22	19
	P1.2.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.2.Z.HT		210	31	26	22	20	16	14	20	16	14
	P1.3.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.3.Z.HT		300	21	17	15	12	10	9	12	10	9
		Niukkaseosteinen teräs										
	P2.1.Z.AN		175	39	32	27	22	18	15	22	18	15
	P2.2.Z.AN		240	31	26	22	20	16	14	20	16	14
	P2.3.Z.AN		260	21	17	15	12	10	9	12	10	9
	P2.5.Z.HT.1		285	21	17	15	12	10	9	12	10	9
		Runsasseosteinen teräs										
	P3.0.Z.AN		200	31	26	22	20	16	14	20	16	14
	P3.0.Z.HT.1		380				6	5	4			
	P3.1.Z.AN		250	31	26	22	20	16	14	20	16	14
		Teräsvalut										
	P1.5.C.UT		150	39	32	27	22	18	15	22	18	15
	P2.6.C.UT		200	31	26	22	20	16	14	20	16	14
		Ferriittiset/martensiittiset ruostumattomat teräkset										
	P5.0.Z.HT.1		330	32	26	22	20	16	14	20	16	14
	P5.0.Z.PH		330	12	10	9	5	4	3	-	-	-
M		**Austeniittinen ruostumaton teräs**										
	M1.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M1.0.C.UT		230	10	8	7	7	6	5	-	-	-
		Superausteniittinen ruostumaton teräs										
	M2.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M2.0.C.AQ		260	10	8	7	7	6	5	-	-	-
	M3.1.Z.AQ	**Ferriittis-austeniittiset ruostumattomat teräkset (duplex)**	200	6	5	4	5	4	3	-	-	-
	M3.2.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.1.C.AQ		230	6	5	4	5	4	3	-	-	-
K		**Adusoitu valurauta**										
	K1.1.C.NS		200	24	20	17	18	15	13	-	-	-
		Harmaa valurauta										
	K2.1.C.UT		180	23	19	16	18	15	13	-	-	-
	K2.2.C.UT		245	16	13	11	10	8	7	-	-	-
	K2.3.C.UT		175	24	20	17	18	15	13	-	-	-
		Pallografiittivalurauta										
	K3.1.C.UT		155	24	20	17	18	15	13	-	-	-
	K3.2.C.UT		215	24	20	17	18	15	13	-	-	-
	K3.3.C.UT		265	24	20	17	18	15	13	-	-	-
	K3.5.C.UT		190	24	20	17	18	15	13	-	-	-
	K5.1.C.NS	**Austemperoitu pallografiittivalurauta**	300	16	13	11	10	8	7	-	-	-
N		**Alumiinipohjaiset seokset**										
	N1.2.Z.UT		60	49	40	34	-	-	-	43	35	30
	N1.2.Z.AG		100	49	40	34	-	-	-	43	35	30
	N1.3.C.UT		75	49	40	34	-	-	-	43	35	30
	N1.3.C.AG		90	31	25	21	-	-	-	24	20	17
	N1.4.C.NS		130	21	18	15	-	-	-	18	15	13
		Kuparipohjaiset seokset										
	N3.3.U.UT		110	-	-	-	-	-	-	-	-	-
	N3.1.U.UT		100	-	-	-	-	-	-	-	-	-
S		**Rautapohjaiset superseokset**										
	S1.0.U.AN		200	9	8	6	-	-	-	6	5	4
		Nikkelipohjaiset superseokset										
	S2.0.Z.UT		275	9	8	6	-	-	-	6	5	4
	S2.0.Z.AN		250	9	8	6	-	-	-	6	5	4
	S2.1.Z.AN		125	23	19	16	-	-	-	15	12	10
		Titaanipohjaiset seokset										
	S4.1.Z.UT		200	21	18	15	-	-	-	18	15	13

SANDVIK Coromant

FIN

CoroTap™

CoroTap™ 300

Tuuma-arvot

				T300-XM								
				Laatu B110/C110			Laatu B145/C145			Laatu B150/C150		
				ULDR			ULDR			ULDR		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC-nro	Raaka-aine	HB	v_c ft/min			v_c ft/min			v_c ft/min		
P		**Seostamaton teräs**										
	P1.1.Z.AN		125	140	115	98	100	82	70	100	82	70
	P1.1.Z.HT		190	134	110	94	88	72	62	88	72	62
	P1.2.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.2.Z.HT		210	102	84	72	64	52	45	64	52	45
	P1.3.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.3.Z.HT		300	70	57	49	40	33	28	40	33	28
		Niukkaseosteinen teräs										
	P2.1.Z.AN		175	126	103	88	72	59	51	72	59	51
	P2.2.Z.AN		240	102	84	72	64	52	45	64	52	45
	P2.3.Z.AN		260	70	57	49	40	33	28	40	33	28
	P2.5.Z.HT.1		285	70	57	49	40	33	28	40	33	28
		Runsasseosteinen teräs										
	P3.0.Z.AN		200	102	84	72	64	52	45	64	52	45
	P3.0.Z.HT.1		380				20	16	14			
	P3.1.Z.AN		250	102	84	72	64	52	45	64	52	45
		Teräsvalut										
	P1.5.C.UT		150	126	103	88	72	59	51	72	59	51
	P2.6.C.UT		200	102	84	72	64	52	45	64	52	45
		Ferriittiset/martensiittiset ruostumattomat teräkset										
	P5.0.Z.HT.1		330	104	85	73	64	52	45	64	52	45
	P5.0.Z.PH		330	40	33	28	16	13	11	-	-	-
M		**Austeniittinen ruostumaton teräs**										
	M1.0.Z.AQ		200	32	26	22	24	20	17	-	-	-
	M1.0.C.UT		230	32	26	22	24	20	17	-	-	-
		Superausteniittinen ruostumaton teräs										
	M2.0.Z.AQ		200	32	26	22	24	20	17	-	-	-
	M2.0.C.AQ		260	32	26	22	24	20	17	-	-	-
		Ferriittis-austeniittiset ruostumattomat teräkset (duplex)										
	M3.1.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.2.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.1.C.AQ		230	20	16	14	16	13	11	-	-	-
K		**Adusoitu valurauta**										
	K1.1.C.NS		200	80	66	56	60	49	42	-	-	-
		Harmaa valurauta										
	K2.1.C.UT		180	74	61	52	60	49	42	-	-	-
	K2.2.C.UT		245	52	43	36	32	26	22	-	-	-
	K2.3.C.UT		175	80	66	56	60	49	42	-	-	-
		Pallografiittivalurauta										
	K3.1.C.UT		155	80	66	56	60	49	42	-	-	-
	K3.2.C.UT		215	80	66	56	60	49	42	-	-	-
	K3.3.C.UT		265	80	66	56	60	49	42	-	-	-
	K3.5.C.UT		190	80	66	56	60	49	42	-	-	-
	K5.1.C.NS	**Austemperoitu pallografiittivalurauta**	300	52	43	36	32	26	22	-	-	-
N		**Alumiinipohjaiset seokset**										
	N1.2.Z.UT		60	161	131	112	-	-	-	140	115	98
	N1.2.Z.AG		100	161	131	112	-	-	-	140	115	98
	N1.3.C.UT		75	161	131	112	-	-	-	140	115	98
	N1.3.C.AG		90	100	82	70	-	-	-	80	66	56
	N1.4.C.NS		130	70	57	49	-	-	-	60	49	42
		Kuparipohjaiset seokset										
	N3.3.U.UT		110	-	-	-	-	-	-	-	-	-
	N3.1.U.UT		100	-	-	-	-	-	-	-	-	-
S		**Rautapohjaiset superseokset**										
	S1.0.U.AN		200	30	25	21	-	-	-	20	16	14
		Nikkelipohjaiset superseokset										
	S2.0.Z.UT		275	30	25	21	-	-	-	20	16	14
	S2.0.Z.AN		250	30	25	21	-	-	-	20	16	14
	S2.1.Z.AN		125	74	61	52	-	-	-	48	39	34
		Titaanipohjaiset seokset										
	S4.1.Z.UT		200	70	57	49	-	-	-	60	49	42

CoroReamer™ 435 -kalvimen lastuamisarvot

Metriset arvot

CoroReamer™ 435 -XF					Ø mm					
ISO	MC-nro	Raaka-aine	N/mm²	Käyttötiedot	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
P		**Seostamaton teräs**								
				v_c m/min				30		
	P1.1.Z.AN	C = 0.10–0.25 %	428	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P.1..Z.AN	Nuorrutettu	639	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P1.2.Z.AN	C = 0.25–0.55 %	639	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P1.2.Z.HT		708	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P1.3.Z.AN	C = 0.55–0.80 %	639	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P1.3.Z.HT		991	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
		Niukkaseosteinen teräs								
				v_c m/min				30		
	P2.1.Z.AN	Karkaisematon	591	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P2.2.Z.AN	Hehkutettu	811	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P2.3.Z.AN		867	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				15		
	P2.5.Z.HT	Nuorrutettu	961	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
		Teräsvalut								
				v_c m/min				30		
	P1.5.C.UT	Seostamaton	503	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	674	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
		Runsasseosteinen teräs								
				v_c m/min				20		
	P3.0.Z.AN	Hehkutettu	674	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				15		
	P3.0.Z.HT		1282	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P3.1.Z.AN	Hehkutettu pikateräs	839	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				15		
	P5.0.Z.HT		1114	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P5.0.Z.PH		503	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.30	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30

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CoroReamer™ 435 -kalvimen lastuamisarvot

Tuuma-arvot

CoroReamer™ 435 -XF					Ø tuumaa					
ISO	MC-nro	Raaka-aine	N/mm²	Käyttötiedot	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
P		**Seostamaton teräs**								
				v_c ft/min			98			
	P1.1.Z.AN	C = 0.10–0.25 %	428	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			98			
	P.1..Z.AN	Nuorrutettu	639	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			98			
	P1.2.Z.AN	C = 0.25–0.55 %	639	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			98			
	P1.2.Z.HT		708	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			98			
	P1.3.Z.AN	C = 0.55–0.80 %	639	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			66			
	P1.3.Z.HT		991	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
		Niukkaseosteinen teräs								
				v_c ft/min			98			
	P2.1.Z.AN	Karkaisematon	591	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			66			
	P2.2.Z.AN	Hehkutettu	811	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			66			
	P2.3.Z.AN		867	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			49			
	P2.5.Z.HT	Nuorrutettu	961	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
		Teräsvalut								
				v_c ft/min			98			
	P1.5.C.UT	Seostamaton	503	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			66			
	P2.6.C.UT	Niukkaseosteinen (seosaineita ≤ 5 %)	674	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
		Runsasseosteinen teräs								
				v_c ft/min			66			
	P3.0.Z.AN	Hehkutettu	674	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			49			
	P3.0.Z.HT		1282	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			66			
	P3.1.Z.AN	Hehkutettu pikateräs	839	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			49			
	P5.0.Z.HT		1114	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			98			
	P5.0.Z.PH		503	tuumaa/kierr.	.006	.007	.008	.008	.012	.012
				Työvara	.004	.004	.008	.008	.008	.012

CoroReamer™ 435 -kalvimen lastuamisarvot

Metriset arvot

CoroReamer™ 435 -XF					Ø mm					
ISO	MC-nro	Raaka-aine	N/mm²	Käyttötiedot	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
K		**Adusoitu valurauta**								
				v_c m/min				30		
	K1.1.C.NS	Ferriittinen Perliittinen	428	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
		Harmaa valurauta								
				v_c m/min				30		
	K2.1.C.UT	Pieni murtolujuus	639	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	K2.2.C.UT	Suuri murtolujuus	639	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	K2.3.C.UT		708	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
		Pallografiittivalurauta								
				v_c m/min				20		
	K3.1.C.UT	Ferriittinen	639	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	K3.2.C.UT	Perliittinen	991	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	K3.3.C.UT	Perliittinen	503	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	K3.5.C.UT		591	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
N		**Alumiiniseokset**								
				v_c m/min				50		
	N1.2.Z.UT	Taottu tai taottu ja kylmäkäsitelty, ei-vanheneva	400	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				50		
	N1.2.Z.AG	Taottu tai taottu ja vanhennettu	650	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				50		
	N1.3.C.UT	Valettu, ei-vanheneva	600	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				50		
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	700	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				30		
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	700	f_n mm/kierr.	0.15	0.15	0.15	0.20	0.20	0.30
				Työvara	0.10	0.10	0.20	0.20	0.20	0.30
		Kuparipohjaiset seokset								
				v_c m/min				50		
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	550	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				50		
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	1350	f_n mm/kierr.	0.15	0.18	0.20	0.20	0.25	0.30
				Työvara	0.10	0.10	0.15	0.20	0.20	0.30
O		**Muovit**								
				v_c m/min				40		
				f_n mm/kierr.	0.15	0.15	0.15	0.35	0.35	0.40
				Työvara	0.15	0.15	0.20	0.20	0.20	0.30

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FIN

CoroReamer™ 435 -kalvimen lastuamisarvot

Tuuma-arvot

CoroReamer™ 435 -XF					Ø tuumaa					
ISO	MC-nro	Raaka-aine	N/mm²	Käyttötiedot	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
K		**Adusoitu valurauta**								
				v_c ft/min			98			
	K1.1.C.NS	Ferriittinen Perliittinen	428	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.008	.008	.008	.012
		Harmaa valurauta								
				v_c ft/min			98			
	K2.1.C.UT	Pieni murtolujuus	639	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004		.008	.008	.008	.012
				v_c ft/min			98			
	K2.2.C.UT	Suuri murtolujuus	639	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			98			
	K2.3.C.UT		708	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.008	.008	.008	.012
		Pallografiittivalurauta								
				v_c ft/min			66			
	K3.1.C.UT	Ferriittinen	639	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			66			
	K3.2.C.UT	Perliittinen	991	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			66			
	K3.3.C.UT	Perliittinen	503	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.008	.008	.008	.012
				v_c ft/min			66			
	K3.5.C.UT		591	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.008	.008	.008	.012
N		**Alumiiniseokset**								
				v_c ft/min			164			
	N1.2.Z.UT	Taottu tai taottu ja kylmäkäsitelty, ei-vanheneva	400	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.006	.008	.008	.012
				v_c ft/min			164			
	N1.2.Z.AG	Taottu tai taottu ja vanhennettu	650	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.006	.008	.008	.012
				v_c ft/min			164			
	N1.3.C.UT	Valettu, ei-vanheneva	600	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.006	.008	.008	.012
				v_c ft/min			164			
	N1.3.C.AG	Valettu tai valettu ja vanhennettu	700	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.006	.008	.008	.012
				v_c ft/min			98			
	N1.4.C.NS	AlSi-valuseokset, Si ≥ 13 %	700	tuumaa/kierr.	.006	.006	.006	.008	.008	.012
				Työvara	.004	.004	.008	.008	.008	.012
		Kuparipohjaiset seokset								
				v_c ft/min			164			
	N3.3.U.UT	Hyvin lastuttavat kuparipohjaiset seokset (Pb > 1 %)	550	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.006	.008	.008	.012
				v_c ft/min			164			
	N3.1.U.UT	Lyijyttömät kupariseokset (myös elektrolyyttikupari)	1350	tuumaa/kierr.	.006	.007	.008	.008	.010	.012
				Työvara	.004	.004	.006	.008	.008	.012
O		**Muovit**								
				v_c ft/min			131			
				tuumaa/kierr.	.006	.006	.006	.014	.014	.016
				Työvara	.006	.006	.008	.008	.008	.012

C

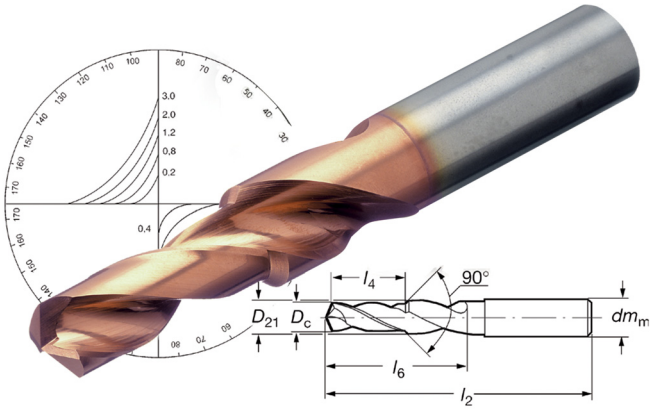
B

Räätälöidyt ratkaisut

Jos tarvitsemaasi tuotetta ei löydy vakiovalikoimastamme, voimme tietenkin suunnitella ja valmistaa yksilöllisesti juuri vaatimuksiisi sopivan työkalun. Tällöin valittavissasi on Tailor Made -mittatilausratkaisu tai erikoistyökalu riippuen työvaiheen vaativuudesta ja työkappaleen ominaisuuksista.

C

D

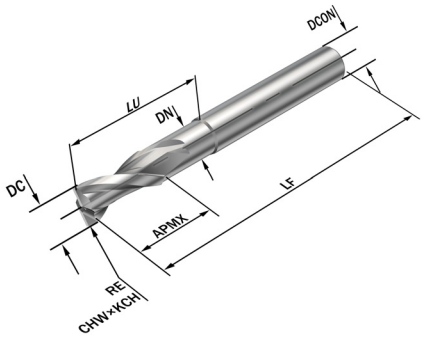


E

FIN

Mittatilausterät

Tailor Made valikoima kattaa yleisimmät räätälöityjen työkalujen tarpeet. Olipa kyse halkaisijasta, pituuesta, kiinnityksestä tai muusta parametristä, Tailor Made valikoima tarjoaa laatukkaat räätälöidyt tuotteet nopealla toimitusajalla.



Tilaaminen: Ota yhteys paikalliseen Sandvik Coromant toimittajaasi tai tutustu valikoimaan nettisivuilla:www.sandvik.coromant.com/tailormade

Speciaalityökalut

Tapauksissa joissa Tailor Made valikoimasta ei löydy ratkaisua, voimme tarjota Sandvik Coromant yhteistyötä speciaalityökalujen suunnitteluun.

Tilaaminen: Ota yhteys paikalliseen Sandvik Coromant toimittajaasi.

Kierretapit

Raaka-aine

HSS-E	HSS-PM
Kobolttiseosteinen pikateräs	Pulveripikateräs

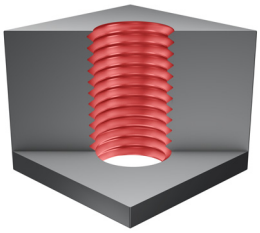
Laatu/pinnoite

C110/B110	C145/B145
Optimaalinen yhdistelmä kovuutta ja hankauskulumisen kestoa	Höyrypäästetty, suojaa työkalua ja estää irtosärmänmuodostusta

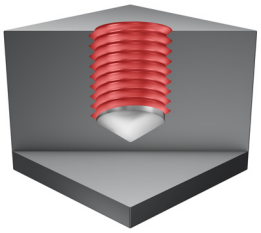
C150/B150
Pinnoittamaton, vähentää pehmeiden materiaalien tarttumista

Reikätyyppi

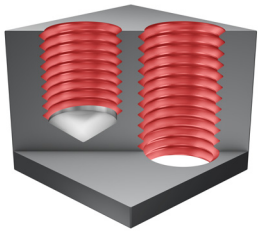
Läpireikä



Umpireikä



Läpi- tai pohjareikä



FIN

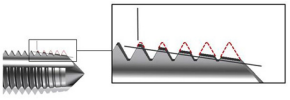
YLEISIÄ OHJEITA KIERTEITYKSEEN

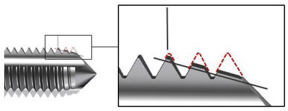
Tappikierteityksen tulos riippuu useista keskeisistä tekijöistä, jotka vaikuttavat myös valmiin tuotteen laatuun. Hyvään tulokseen päästään seuraavasti:1. Valitse kierretappi lastuttavan aineen ja reiän tyypin perusteella (esim. läpireikä), ks. materiaalitaulukko.2. Varmista kiinnityksen tukevuus – sivuliikkeet voivat katkaista kierretapin tai pilata kierteiden laadun.3. Valitse oikean kokoinen pora ko. luettelosivulta. Muista, että manglaavat kierretapit edellyttävät erikokoisia poria. Väärin valittu pora tai heikot olosuhteet voivat aiheuttaa työkappaleen työstökarkenemista, joka heikentää kierretapin suorituskykyä.4. Käytä sopivaa lastuamisnopeutta, ks. tuoteluettelo tai ohjattu tuotehaku. 5. Käytä työhön sopivaa lastuamisnestettä.6. Varmista juoheva tapin syöttö sisään reikään, sillä epätasainen syöttö voi aiheuttaa reiän suuhun kellomaisen muotovirheen.

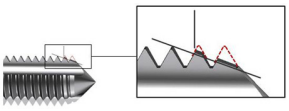
B

Etuviisteen tyyppi

C







Viistemuoto B = 3.5–5 x kierrettä

Pitkä viiste:Suuri vääntömomenttiParas pinnankarheusOhuet lastutAlhainen paine viisteessäPidempi terän kestoikäYleisin lastua työntävän kärjen yhteydessä

Viistemuoto C = 2 – 3 x kierrettä

Keskipitkä viiste:Pieni vääntömomenttiHyvä pinnankarheusTavanomainen lastunpaksuusTavanomainen paine viisteessäNormaali kestoikäYleisinVakioviiste pohjareikien koneistukseenYleisin nousullisten lastu-urien yhteydessä

Viistemuoto E = 1.5–2 x kierrettä

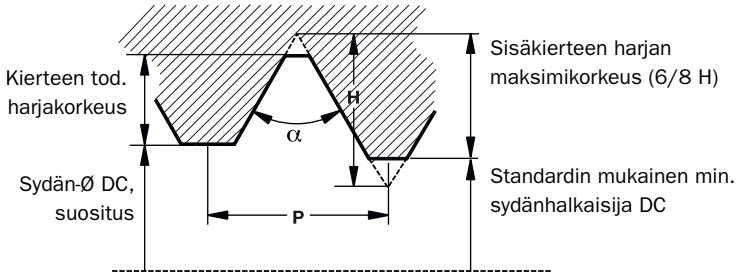
Lyhyt viiste:Pieni vääntömomenttiHyvä pinnankarheusPaksut lastutKorkea paine viisteessäLyhyt kestoikäErikoismalliKäytetään, kun kierre ulottuu erittäin lähelle reiän pohjaa

D

Harjakorkeus prosentteina?

Esimerkki pätee 60°:n ISO- ja UTS-kierteisiin

Kierteen harjan korkeus prosentteina ilmaisee sisäkierteen todellisen korkeuden ja maksimikorkeuden välisen suhteen



Esimerkki: M8 × 1.25

Standardin mukainen kierteen maksimiharjakorkeus on 6/8 H. H = 0,866 × P (H = peruskolmion korkeus) (P = kierteen nousu)

Kierteen maksimiharjakorkeus: 6/8 * (0,866 × 1,25) = 0.811 mm Kierteen todellinen harjakorkeus, kun sydänhalkaisija on DC 6,9 mm: (8 – 6,9) / 2 = 0,55 mm Kierteen harjakorkeus on siten (0,55 / 0,81) x 100 = 68 %

E

KIERRETAPPILUOKAT 2B & 3B: UNIFIED-TUUMAKIERTEET

	TPI		Kierretapin raja-arvot	
Terän koko	UNC	UNF	Luokka 2B	Luokka 3B
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	TPI		Kierretapin raja-arvot	
Terän koko	UNC	UNF	Luokka 2B	Luokka 3B
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1"	8		H6	H4
1"		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

FIN

Reikäkokosuositukset

Reikäkoko-opas

Tässä ohjeessa annetaan suositukset sopivan kierrereiän halkaisijan valitsemisesta.
Valittava reiän halkaisija riippuu poramallista ja koneistettavasta materiaalista.
Huomaa, että reiän halkaisija voi poiketa poran koosta riippuen poran toleranssista. Tarkin reikä saadaan käyttämällä korkeatasoista, tarkasti toleroitua täyskovametalliporaa. Tällä tavoin voidaan valita pora, joka on lähempänä tässä oppaassa annettua reiän maksimihalkaisijaa.
Poikkeustapauksissa, esim. porattaessa erittäin sitkeää materiaalia, voidaan poran kestoiän pidentämiseksi valita suurempi reiän halkaisija.
Kierteen lujuus pysyy edelleen hyvänä, mutta kierre jää vakiotoleranssin ulkopuolelle.
Tarkempia teknisiä tietoja on saatavissa osoitteessa www.sandvik.coromant.com

B

M

DIN 13			Metrinen		Tuumaa	
TDZ		TP	PHD	PHDX	PHD	PHDX *5H/6H
M 1*	x	0.25	0.75	0.785	.0295	.0309
M 1.1*	x	0.25	0.85	0.885	.0335	.0348
M 1.2*	x	0.25	0.95	0.985	.0374	.0388
M 1.4*	x	0.30	1.10	1.142	.0433	.0450
M 1.6	x	0.35	1.25	1.321	.0492	.0520
M 1.8	x	0.35	1.45	1.521	.0571	.0599
M 2	x	0.40	1.60	1.679	.0630	.0661
M 2.2	x	0.45	1.75	1.838	.0689	.0724
M 2.3	x	0.40	1.85	1.938	.0728	.0763
M 2.5	x	0.45	2.05	2.138	.0807	.0842
M 2.6	x	0.45	2.15	2.238	.0846	.0881
M 3	x	0.50	2.50	2.599	.0984	.1023
M 3.5	x	0.60	2.90	3.010	.1142	.1185
M 4	x	0.70	3.30	3.422	.1299	.1347
M 4.5	x	0.75	3.70	3.878	.1457	.1527
M 5	x	0.80	4.20	4.334	.1654	.1706
M 6	x	1.00	5.00	5.153	.1969	.2029
M 7	x	1.00	6.00	6.153	.2362	.2422
M 8	x	1.25	6.80	6.912	.2677	.2721
M 9	x	1.25	7.80	7.912	.3071	.3115
M 10	x	1.50	8.50	8.676	.3346	.3416
M 11	x	1.50	9.50	9.676	.3740	.3809
M 12	x	1.75	10.20	10.441	.4016	.4111
M 14	x	2.00	12.00	12.210	.4724	.4807
M 16	x	2.00	14.00	14.210	.5512	.5594
M 18	x	2.50	15.50	15.744	.6102	.6198
M 20	x	2.50	17.50	17.744	.6890	.6986
M 22	x	2.50	19.50	19.744	.7677	.7773
M 24	x	3.00	21.00	21.252	.8268	.8367
M 27	x	3.00	24.00	24.252	.9449	.9548
M 30	x	3.50	26.50	26.771	1.0433	1.0540
M 33	x	3.50	29.50	29.771	1.1614	1.1721
M 36	x	4.00	32.00	32.270	1.2598	1.2705
M 39	x	4.00	35.00	35.270	1.3780	1.3886
M 42	x	4.50	37.50	37.799	1.4764	1.4881
M 45	x	4.50	40.50	40.799	1.5945	1.6063
M 48	x	5.00	43.00	43.297	1.6929	1.7046
M 52	x	5.00	47.00	47.297	1.8504	1.8621
M 56	x	5.50	50.50	50.796	1.9882	1.9998
M 64	x	6.00	58.00	58.305	2.2835	2.2955

C

D

E

E45

ISO 13399

Reikäkokosuositukset

Lastuavat kierretapit

MF

DIN 13			Metrinen		Tuumaa	
TDZ		TP	PHD	PHDX 6H	PHD	PHDX 6H
MF 2.5	x	0.35	2.15	2.221	.0846	.0874
MF 3.0	x	0.35	2.65	2.721	.1043	.1071
MF 3.5	x	0.35	3.15	3.221	.1240	.1268
MF 4.0	x	0.50	3.50	3.599	.1378	.1417
MF 4.5	x	0.50	4.00	4.099	.1575	.1614
MF 5.0	x	0.50	4.50	4.599	.1772	.1811
MF 5.5	x	0.50	5.00	5.099	.1969	.2007
MF 6.0	x	0.75	5.25	5.378	.2047	.2117
MF 7.0	x	0.75	6.25	6.378	.2441	.2511
MF 8.0	x	0.50	7.50	7.599	.2953	.2992
MF 8.0	x	0.75	7.25	7.378	.2835	.2905
MF 8.0	x	1.00	7.00	7.153	.2756	.2816
MF 9.0	x	0.75	8.25	8.378	.3228	.3298
MF 9.0	x	1.00	8.00	8.153	.3150	.3210
MF 10	x	0.75	9.25	9.378	.3622	.3692
MF 10	x	1.00	9.00	9.153	.3543	.3604
MF 10	x	1.25	8.80	8.912	.3465	.3509
MF 11	x	0.75	10.25	10.378	.4016	.4086
MF 11	x	1.00	10.00	10.153	.3937	.3997
MF 12	x	1.00	11.00	11.153	.4331	.4391
MF 12	x	1.25	10.75	10.912	.4252	.4296
MF 12	x	1.50	10.50	10.676	.4134	.4203
MF 14	x	1.00	13.00	13.153	.5118	.5178
MF 14	x	1.25	12.75	12.912	.5039	.5083
MF 14	x	1.50	12.50	12.676	.4921	.4991
MF 15	x	1.00	14.00	14.153	.5512	.5572
MF 15	x	1.50	13.50	13.676	.5315	.5384
MF 16	x	1.00	15.00	15.153	.5906	.5966
MF 16	x	1.25	14.80	14.912	.5827	.5871
MF 16	x	1.50	14.50	14.676	.5709	.5778
MF 17	x	1.00	16.00	16.153	.6299	.6359
MF 17	x	1.50	15.50	15.676	.6102	.6172
MF 18	x	1.00	17.00	17.153	.6693	.6753
MF 18	x	1.50	16.50	16.676	.6496	.6565
MF 20	x	1.00	19.00	19.153	.7480	.7541
MF 20	x	1.50	18.50	18.676	.7283	.7353
MF 20	x	2.00	18.00	18.210	.7087	.7169
MF 22	x	1.00	21.00	21.153	.8268	.8328
MF 22	x	1.50	20.50	20.676	.8071	.8140
MF 22	x	2.00	20.00	20.210	.7874	.7957
MF 24	x	1.00	23.00	23.153	.9055	.9115
MF 24	x	1.50	22.50	22.676	.8858	.8928
MF 24	x	2.00	22.00	22.210	.8661	.8744
MF 25	x	1.00	24.00	24.153	.9449	.9509
MF 25	x	1.50	23.50	23.676	.9252	.9321
MF 25	x	2.00	23.00	23.210	.9055	.9138
MF 27	x	1.00	26.00	26.153	1.0236	1.0296
MF 27	x	1.50	25.50	25.676	1.0039	1.0109
MF 27	x	2.00	25.00	25.210	.9843	.9925
MF 28	x	1.00	27.00	27.153	1.0630	1.0690
MF 28	x	1.50	26.50	26.676	1.0433	1.0502
MF 28	x	2.00	26.00	26.210	1.0236	1.0319
MF 30	x	1.00	29.00	29.153	1.1417	1.1478
MF 30	x	1.50	28.50	28.676	1.1220	1.1290
MF 30	x	2.00	28.00	28.210	1.1024	1.1106
MF 30	x	3.00	27.00	27.252	1.0630	1.0729
MF 32	x	1.50	30.50	30.676	1.2008	1.2077
MF 32	x	2.00	30.00	30.210	1.1811	1.1894
MF 33	x	1.50	31.50	31.676	1.2402	1.2471
MF 33	x	2.00	31.00	31.210	1.2205	1.2287
MF 33	x	3.00	30.00	30.252	1.1811	1.1910
MF 35	x	1.50	33.50	33.676	1.3189	1.3258
MF 36	x	1.50	34.50	34.676	1.3583	1.3652

FIN

Reikäkokosuositukset

Lastuavat kierretapit

UNC

ASME B1.1			Metrinen			Tuumaa		
TDZ		TPI	PHD	PHDX 2B	PHDX 3B	PHD	PHDX 2B	PHDX 3B
Nr. 1	-	64	1.55	1.582	1.582	.0610	.0623	.0623
Nr. 2	-	56	1.85	1.872	1.872	.0728	.0737	.0737
Nr. 3	-	48	2.10	2.146	2.146	.0827	.0845	.0845
Nr. 4	-	40	2.35	2.385	2.385	.0925	.0939	.0939
Nr. 5	-	40	2.65	2.697	2.697	.1043	.1062	.1062
Nr. 6	-	32	2.85	2.896	2.896	.1122	.1140	.1140
Nr. 8	-	32	3.50	3.531	3.528	.1378	.1390	.1389
Nr. 10	-	24	3.90	3.962	3.950	.1535	.1560	.1555
Nr. 12	-	24	4.50	4.597	4.590	.1772	.1810	.1807
1/4	-	20	5.10	5.268	5.250	.2008	.2074	.2067
5/16	-	18	6.60	6.734	6.680	.2598	.2651	.2630
3/8	-	16	8.00	8.164	8.082	.3150	.3214	.3182
7/16	-	14	9.40	9.550	9.441	.3701	.3760	.3717
1/2	-	13	10.80	11.013	10.881	.4252	.4336	.4284
9/16	-	12	12.20	12.456	12.301	.4803	.4904	.4843
5/8	-	11	13.50	13.868	13.693	.5315	.5460	.5391
3/4	-	10	16.50	16.833	16.324	.6496	.6627	.6427
7/8	-	9	19.50	19.748	19.520	.7677	.7775	.7685
1	-	8	22.25	22.598	22.344	.8760	.8897	.8797
1 1/8	-	7	25.00	25.349	25.082	.9843	.9980	.9875
1 1/4	-	7	28.00	28.524	28.258	1.1024	1.1230	1.1125
1 3/8	-	6	30.75	31.120	30.851	1.2106	1.2252	1.2146
1 1/2	-	6	34.00	34.295	34.026	1.3386	1.3502	1.3396
1 3/4	-	5	39.50	39.814	39.560	1.5551	1.5675	1.5575
2	-	4.5	45.00	45.598	45.367	1.7717	1.7952	1.7861

UNF

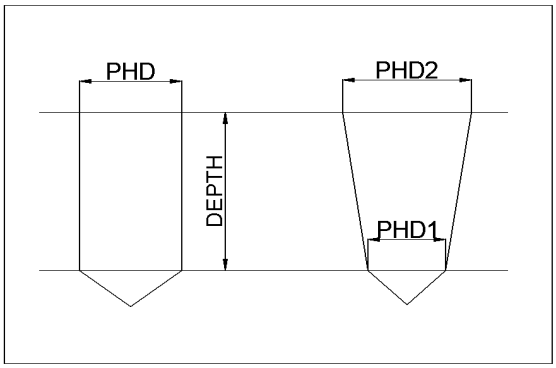
ASME B1.1			Metrinen			Tuumaa		
TDZ		TPI	PHD	PHDX 2B	PHDX 3B	PHD	PHDX 2B	PHDX 3B
Nr.1	-	72	1.55	1.613	1.613	.0610	.0635	.0635
Nr.2	-	64	1.85	1.913	1.913	.0728	.0753	.0753
Nr.3	-	56	2.15	2.197	2.197	.0846	.0865	.0865
Nr.4	-	48	2.40	2.459	2.459	.0945	.0968	.0968
Nr.5	-	44	2.70	2.741	2.741	.1063	.1079	.1079
Nr.6	-	40	2.95	3.023	3.012	.1161	.1190	.1186
Nr.8	-	36	3.50	3.607	3.597	.1378	.1420	.1416
Nr. 10	-	32	4.10	4.166	4.168	.1614	.1640	.1641
Nr. 12	-	28	4.60	4.724	4.717	.1811	.1860	.1857
1/4	-	28	5.50	5.580	5.563	.2165	.2197	.2190
5/16	-	24	6.90	7.038	6.995	.2717	.2771	.2754
3/8	-	24	8.50	8.626	8.565	.3346	.3396	.3372
7/16	-	20	9.90	10.030	9.947	.3898	.3949	.3916
1/2	-	20	11.50	11.618	11.524	.4528	.4574	.4537
9/16	-	18	12.90	13.084	12.969	.5079	.5151	.5106
5/8	-	18	14.50	14.671	14.554	.5709	.5776	.5730
3/4	-	16	17.50	17.689	17.546	.6890	.6964	.6908
7/8	-	14	20.40	20.663	20.493	.8031	.8135	.8068
1	-	12	23.25	23.569	23.363	.9154	.9279	.9198
1 1/8	-	12	26.50	26.744	26.538	1.0433	1.0529	1.0448
1 1/4	-	12	29.50	29.919	29.713	1.1614	1.1779	1.1698
1 3/8	-	12	32.75	33.094	32.888	1.2894	1.3029	1.2948
1 1/2	-	12	36.00	36.269	36.063	1.4173	1.4279	1.4198

Reikäkokosuositukset

Lastuavat kierretapit

G

DIN-ISO 228			Metrinen		Tuumaa	
TDZ		TPI	PHD	PHDX	PHD	PHDX
G 1/16	-	28	6.80	6.843	.2677	.2694
G 1/8	-	28	8.80	8.848	.3465	.3483
G 1/4	-	19	11.80	11.890	.4646	.4681
G 3/8	-	19	15.25	15.395	.6004	.6061
G 1/2	-	14	19.00	19.173	.7480	.7548
G 5/8	-	14	21.00	21.129	.8268	.8319
G 3/4	-	14	24.50	24.659	.9646	.9708
G 7/8	-	14	28.25	28.419	1.1122	1.1189
G 1	-	11	30.75	30.932	1.2106	1.2178
G 11/8	-	11	35.50	35.580	1.3976	1.4008
G 11/4	-	11	39.50	39.593	1.5551	1.5588
G 11/2	-	11	45.25	45.486	1.7815	1.7908



FIN

Uusi standardi helpottaa koneistajan työtä

ISO 13399 on kansainvälinen standardi, joka yksinkertaistaa lastuavia työkaluja koskevaa tiedonsiirtoa. Tämä näkyy hiukan aiemmasta poikkeavina parametreina ja työkalukuvauksina.
Käytössä on nyt ensimmäistä kertaa vakioitu tapa esittää lastuavien työkalujen tuotetietoja. Kun alalla on käytössä yhteiset parametrit ja määritelmät, työkalutietojen siirto ohjelmistosta toiseen tulee helpoksi.

Mitä hyötyä siitä on?
Periaatteessa tämä tarkoittaa sitä, että omat järjestelmäsi puhuvat nyt samaa kieltä meidän ohjelmistojemme kanssa. Voit ladata tuotetietoja verkkosivuiltamme ja hyödyntää niitä suoraan tuotantokäytössä omissa CAD-/CAM-ohjelmistoissasi. Tietoja ei tarvitse kaivella erikseen tuoteluetteloista ja tulkita eri järjestelmien ymmärtämään muotoon. Ajansäästö tulee olemaan huomattava!

B

C

D

E

Lyhyt nimi	Suositeltu nimi
ADJLN	Alempi säätöraja
ADJLX	Ylempi säätöraja
ADJRG	Säätöalue
ALP	Aksiaalinen päästökulma
AN	Päästökulma isompi
ANN	Päästökulma pienempi
APMX	Maks. lastuamissyvyys
APMX_EFW	Maks. lastuamissyvyys – pistosyöttö
APMX_FFW	Maks. lastuamissyvyys – sivuttaissyöttö
AZ	Piston maksimisyvyys
B	Varren leveys
BAWS	Työkappaleen puoleinen runkokulma
BAMS	Koneen puoleinen runkokulma
BBD	Tasapainotettu malli
BBR	Tasapainotettu testaamalla
BCH	Kulmaviisteen pituus
BD	Rungon halkaisija
BHTA	Rungon kartiokulma
BN	Rintapinnan viisteen leveys
BS	Wiper-särmän pituus
BSG	Standardi
BSR	Wiper-särmän säde
CDX	Maks. lastuamissyvyys
CEMR	Lastuavan särmän pääsäde
CF	Pisteviiste
CHBA	Runkoviisteen kulma
CHBL	Runkoviisteen pituus
CHW	Nirkon viisteen leveys
CICT	Teräluku
$CICT_E$	Teräluku – otsasijat
$CICT_P$	Teräluku – kehäsija
$CICT_S$	Teräluku – sivusijat
$CICT_T$	Teräluku – yhteensä
CND	Nestekanavan lähtöpään halkaisija
CNSC	Sisäisen lastuamisnestekanavan tyyppi
CNT	Nestekanavan lähtöpään kierrekoko
COATING	Pinnoite
CP	Maks. lastuamisnesteen paine
CRKS	Ohjausnupin kierrekoko
CRNT	Rad. nestekanavan lähtöpään kierrekoko
CTPT	Koneistusvaihe
CUTDIA	Työkappaleen maks. katkaisuhalkaisija
CW	Lastuamisleveys
CWN	Min. lastuamisleveys
CWTOLL	Lastuamisleveyden alatoleranssi
CWTOLU	Lastuamisleveyden ylätoleranssi
CWX	Leikkuuleveys maks.
CXSC	Nestekanavan mallikoodi
CZC	Kiinnityksen kokokoodi
CZC_{MS}	Kiinnityksen kokokoodi, koneen puoli
CZC_{WS}	Työkappaleen puoleinen kiinnityksen kokokoodi
D1	Kiinnitysreiän halkaisija
DAH	Pääsyreiän halkaisija
DAXIN	Aksiaaliuran min. sisähalkaisija

DAXN	Aksiaaliuran min. ulkohalkaisija
DAXX	Aksiaaliuran maks. ulkohalkaisija
DBC	pulttireikäkehän halkaisija
DC	Jyrsimen halkaisija
DCB	Liitoskoon halkaisija
DCBN	Kiinnityspesän min. halkaisija
DCBX	Kiinnityspesän maks. halkaisija
DCF	Lastuamishalkaisija tasokosketuksessa
DCIN	Sis. lastuamishalkaisija
DCN	Min. lastuamishalkaisija
DCON	Kiinnityshalkaisija
$DCON_{MS}$	Liitoshalkaisija koneen puoli
$DCON_{WS}$	Liitoshalkaisija työkappaleen puoli
DCPS	Ohjelmoitava mikrosiru
$DCSF_{MS}$	Koneen puoleisen kosketuspinnan halkaisija
$DCSF_{WS}$	Työkappaleen puoleisen kosketuspinnan halkaisija
DCX	Maks. lastuamishalkaisija
DHUB	Navan halkaisija
DIX	Työkalunvaihtajan maks. törmäyshalkaisija
DMIN	Min. reiän halkaisija
DMM	Varren halkaisija
DN	Kaulan halkaisija
DRVCT	Veto-osien määrä
DSGN	Malli
EPSR	Kärkikulma
FHA	Lastu-uran nousukulma
FLGT	Laipan paksuus
FTDZ	Kierteen halkaisijan kokoon
H	Varren korkeus
HA	Teoreettinen kierteen korkeus
HB	Kierteen korkeuden ero
HBH	Pään pohjan siirtokorkeus
HC	Kierteen todellinen korkeus
HF	Toiminnallinen korkeus
HRY	Alin kohta perustasosta
HTB	Rungon korkeus
HTH	Korkeus
IC	Sisään piirretty ympyrä
INSL	Terän pituus
INSUC	Terän käyttökoodi
IZC	Terän kokokoodi
KAPR	Asetuskulma
KAPR_EFW	Asetuskulma – pistosyöttö
KCH	Kulmaviiste
KRINS	Pääasetuskulma
KWW	Kiilauran leveys
L	Teräsärmän pituus
LAMS	Viettokulma
LB	Työkalun pituus
LCF	Lastu-uran pituus
LCOX	Maks. leikkuupituus
LE	Teräsärmän tehollinen pituus
LF	Kokonaispituus
LFN	Työkalun minimipituus
LH	Pään pituus
LPR	Ylityspituus
LS	Varren pituus
LSC	Kiinnityspituus
LSCN	Min. kiinnityspituus
LSCS	Etäisyys kiinnityksen alkuun
LSCX	Maks. kiinnityspituus
LSD	Varren hukkapituus
LU	Maks. pituus
LU_BFW	Käyttökelpoinen pituus – takatasaus
LUX	Maks. käyttökelpoinen pituus
MHD	Kiinnitysreiän etäisyys
MIID	Mittaterän tunnus
$MIID_E$	Mittaterän tunnus – otsasija
$MIID_S$	Mittaterän tunnus – sivusija
$MIID_C$	Mittaterän tunnus – keskiösija
$MIID_P$	Mittaterän tunnus – kehäsija
$MIID_I$	Mittaterän tunnus – välisija
MMCC	Normi asetetulle momentille
MMCX	Maks. lastuamismomentti
NOF	Lastu-urien määrä
NT	Hammasluku
OAH	Kokonaiskorkeus
OAL	Kokonaispituus
OAW	Kokonaisleveys

SANDVIK Coromant

FIN

OH	Suositeltu vapaapituus
OHN	Min. vapaapituus
OHX	Maks. vapaapituus
ORDCODE	Tilauskoodi
PCL	Lieriön ulkokehän pituus
PDX	Profiilin etäisyys ex
PDY	Profiilin etäisyys ey
PHD	Alkureikä
PHDX	Maksimi alkureikä
PL	Kärkipituus
PNA	Muototerän kärkikulma
PRFRAD	Profiilin säde
PRSPC	Muotospesifikaatio
PSIR	Asetuslisäkulma
PSIRL	Vasenkätinen pääasetuskulma
PSIRR	Oikeakätinen pääasetuskulma
PSW	Esikoneistetun uran leveys
RADH	Säteittäinen rungon korkeus
RADW	Säteittäinen rungon leveys
RAR	Oik. päästökulma
RE	Nirkonsäde
REL	Nirkonsäde vas.
RER	Nirkonsäde oik.
RETOLL	Kulmapyöristyksen alatoleranssi
RETOLU	Kulmapyöristyksen ylätoleranssi
RGL	Uudelleenhiontapituus
RMPX	Suurin sisäänmenokulma
RPMX	Maks. karanopeus
S	Terän paksuus
SDL	Porrashalkaisijan pituus
SIG	Kärkikulma
SPTL	Jakolinja
SSC	Teräsijan kokokoodi
SSC_E	Teräsijan kokokoodi – otsasija
SSC_P	Teräsijan kokokoodi – kehäsija
SSC_S	Teräsijan kokokoodi – sivusija
STA	Viisteellinen porras
SUBSTRATE	Perusaine
TCDC	Lastuamishalkaisijan toleranssiluokka
TCDCON	Kiinnityksen halkaisijatoleranssi
TCDMM	Varren halkaisijan toleranssi
TCHA	Mahdollinen reiän toleranssi
TCHAL	Mahdollinen alin toleranssi
TCHAU	Mahdollinen ylin toleranssi
TCT	Työkaluluokka
TCTR	Kierteen toleranssiluokka
TD	Kierteen halkaisija
TDZ	Kierteen halkaisija
TFLA	Kierteytysistukan liikematka eteenpäin
TFLB	Kierteytysistukan liikematka taaksepäin
TG	Kartion jyrkkyys
THBTP	Kierteen takapäästö
THCA	Kierteen nousun korjauskulma
THCHT	Etuviisteen tyyppi
THFT	Kierremuoto
THFTS	Kierremuoto, standardisarja
THL	Kierteen pituus
THUB	Navan paksuus
TP	Kierteen nousu
TPI	Kierrettä/tuuma
TPIN	Kierrettä/tuuma min.
TPIX	Kierrettä/tuuma maks.
TPN	Kierteen min. nousu
TPT	Kierreprofiilin tyyppi
TPX	Kierteen maksiminousu
TRMAX	Kierteitysalue maks.
TQ	momentti
TSYC	Työkalun mallikoodi
TTP	Kierre
ULDR	Ulottuvuuden ja halkaisijan suhdeluku
VCX	Maks. lastuamisnopeus
W1	Terän leveys
WB	Rungon leveys
WF	Toiminnallinen leveys
WFCIRP	Toiminallinen leveys referenssipisteeseen
WSC	Kiinnitysleveys
WT	Nimikkeen paino
ZEFF	Tehollisia särmiä otsassa
ZEFP	Kehällä tehollisten teräsärmien lukumäärä (ZEFP)
ZWX	Wiper -terien enimmäismäärä

Muuntotaulukko

SI > Imperial

Etäisyys

1 metri = 39.370 tuumaa
1 metri = 3.281 jalkaa
1 millimetri = 0.039 tuumaa

B

Paino

1 kilogramma = 2.205 naulaa
1 kilogramma = 35.274 unssia

Kiristysmomentti

1 newtonmetri (Nm) = 0.738 jalkapaunaa (ft-lbs)

1 newtonmetri (Nm) = 8.851 tuumapaunaa (in-lbs)

Imperial > SI

Etäisyys

1 tuuma = 25.4 millimetriä
1 jalka = 0.3 metriä
1 jalka = 304.8 millimetriä

Paino

1 naula = 0.45 kilogrammaa
1 unssi = 28.35 grammaa

Kiristysmomentti

1 jalkapauna (ft-lbf) = 1.4 Newtonmetriä (Nm)

1 tuumapauna (in-lbf) = 0.1 Newtonmetriä (Nm)

Laskukaavoja ja määritelmiä:

C

	Metrinen	Imperial
v_c = lastuamisnopeus	m/min (metriä minuutissa)	ft/min (jalkaa minuutissa)
n = karanopeus	kierr./min (kierrosta minuutissa)	
v_f = pöytäsyöttö	mm/min	tuumaa/min
= terien kokonaismäärä		
z_c = tehollisten terien lukumäärä		
f_z = teräkohtainen syöttö	mm/z	tuumaa/z
f_n = syöttö/kierros	mm/kierr.	tuumaa/kierr.
h_{ex} = maks. lastunpaksuus	mm	tuumaa
a_p = lastuamissyvyys	mm	tuumaa
l_a = terän leveys	mm	tuumaa
a_e = lastuamisleveys	mm	tuumaa
a_e/D_c % = lastuamisleveys/jyrsimen halk.	%	%
T = koneistusaika	min.	min.
Q = lastuvirta	cm^3/min	$tuumaa^3$/min
nap = ylimenojen määrä		
tpi = kierrettä/tuuma		
k_c = ominaislastuamisvoima	N/mm^2	lbs/in^2
R_a = pinnankarheus	µm	µin

D

Terän koko

iC = sisäpuolinen kehä tuumina

E

△ = teräsärmän pituus, mm

FIN

IFind

Kätevimmät sovelluksemme samassa paketissa

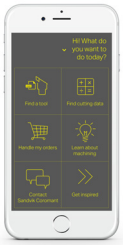
Asioit verkossa, teet töitä niin tien päällä kuin konepajalla. Missä tahansa liikutkin, IFind kokoaa tarvitsemasi toiminnot kätevästi samaan sovellukseen.

Sovelluksen avulla voit helposti hakea työkaluja, ratkaisuja ja tietoa aina tarpeen mukaan. Löydät IFindista myös työkalusuositukset, verkkokaupan, tilausten seurannan ja uusia koneistusvinkkejä. Mitä haluat tehdä tänään?

Kaikki IFind-sovelluksen toiminnot ovat käytettävissä kaikissa soveltuvissa laitteissa.

Available on the App Store

ANDROID APP ON Google play



Kunnostus

Kunnostuspalvelumme on enemmän kuin perinteinen uudelleenhionta.
Luotettavasti kerrasta kertaan palautettu alkuperäinen suorituskyky tuo selkeää säästöä koneistuskustannuksiin.

Tarjontamme

100%

Luotettavuus
Spesialistimme ovat aina käytettävissäsi, kun kaipaat koneistusasiantuntijan tukea.

x3

Alkuperäinen suorituskyky
Työkalu voidaan kunnostaa alkuperäistä vastaavaan laatuun jopa kolme kertaa.

50%

Säästöt
Kunnostuspalvelu säästää työkalukustannuksia jopa 50 %.

Kunnostettavat tuotteet

Poraus

Jyrsintä

Kalvinta

Kunnostettavat työkaluperheet ja tuotteet on merkitty omilla sivuillaan.

Lisätietoja

Kunnostettavien työkalujen pakkaus
Tilaa sopiva laatikko:- Pieni (300 x 200 x 138 mm) Tuote-nro: 6949557- Keskikoinen (400 x 300 x 138 mm) Tuote-nro: 6949558
Samassa laatikossa voi lähettää kaikkia Sandvik Coromantin työkaluja.

Kunnostuspalvelu
- Ensin tarkastetaan työkalun kunnostuskelpoisuus. Jos kunnostus ei ole mahdollista, työkalu palautetaan lähettäjälle.
- Tehdyt kunnostukset merkitään työkalun varteen laserilla.
- Työkalut palautetaan alkuperäisessä pakkauksessa.

Miten kunnostus käytännössä tapahtuu?
- Terägeometria palautetaan uuden veroiseksi.
- Poran pituus lyhenee.
- Varsijyrsin lyhenee ja halkaisija pienenee.- Minimihalkaisija on noin 0.9 x Dc.
- Kalvinten toleranssi pysyy samana.

Kysy hintoja Sandvik Coromant -edustajaltasi.

FIN

Ajattelethan ympäristöä

Tule mukaan Coromant -kierrätysjärjestelmään (CRC)

Coromant-kierrätysjärjestelmä (CRC) on kattava käytettyjen kovametalliterien käsittelypalvelu, jonka Sandvik Coromant tarjoaa kaikille asiakkailleen. Kulutamme yhä enemmän uusiutumattomia luonnonvaroja, joten kaikkien teollisten tuotantolaitosten velvollisuus on käyttää raaka-aineita taloudellisesti.
Sandvik Coromant kantaa oman kortensa kekoon ottamalla vastaan asiakkaittensa käyttämät kovametalliterät ja kierrättämällä ne mahdollisimman ympäristöystävällisellä tavalla.
Kaikki koneistamolla käytetyt kovametalliterät kerätään lopulta yhteen kuljetuslaatikkoon. Kun teriä on kertynyt tarpeeksi, ne siirretään kuljetuslaatikkoon. Kun minimimäärä (50 kg) on tullut täyteen, ota yhteys Coromant-osastoon, josta saat lisätietoja.

CRC-järjestelmän edut puhuvat puolestaan:

- Maailmanlaajuinen kierrätysjärjestelmä ilman välikäsiä.
- Sekä loppukäyttäjille että välittäjille.
- Yksinkertainen keräilysäiliöihin ja kuljetuslaatikoihin perustuva käytäntö.
- Jätettä syntyy vähemmän, joten ympäristön kuormitus pienenee.
- Raaka-aineet tulevat tarkemmin hyödynnetyksi.
- Otamme vastaan myös muiden valmistajien kovametalliteriä.

Tilaa keräilysäiliö kutakin sorvia, pora- tai jyrsinkonetta tai koneistuskeskusta kohti. Suosittelemme kutakin koneistustyöpistettä kohti yhtä terienkeräilysäiliötä sekä erillistä laatikkoa täyskovametallityökaluja varten.

	Tilausnumerot
Keräilysäiliö:	91617
Täyskovametallityökalujen kuljetuslaatikko (puinen):	92994
Terienkuljetuslaatikko (puinen):	92995

Turvallisuustiedot

Kovametallin hiomiseen liittyvät turvallisuustiedot

Raaka-aineet

Pitimet sisältävät pääraaka-aineensa raudan (Fe) ohella pieniä määriä seosaineita, esim. kromia, nikkeliä,mangaania, molybdeeniä ja piitä.

B

Kovametallin pääraaka-aineet ovat volframikarbidi ja koboltti. Lisäksi kovametallit saattavat sisältää seuraavien alkuaineiden karbidi- ja karbonitridiyhdisteitä: titaani, tantaali, niobi, kromi, molybdeeni ja vanadiini.

Altistumistavat

Kun kovametallista aihiota tai tuotetta hiotaan tai kuumennetaan, syntyy terveydelle vaarallisia aineita sisältäviä pölyä tai höyryjä, jotka voivat joutua hengitysteihin tai ruuansulatuskanavaan tai kosketukseen ihon tai silmien kanssa.

Lyhytaikaisen altistuksen haittavaikutukset

Kovametallipöly on hengitettynä myrkyllistä. Pölyn hengittäminen voi aiheuttaa hengitystiehyissä ärsytystä ja tulehduksia. Yhtä aikaa sisään hengitetyn koboltti- ja volframikarbidipölyn on huomattu aiheuttavan enemmän akuutteja reaktioita kuin pelkän kobolttipitoisen pölyn.

Ihokosketus voi aiheuttaa ärsytystä ja kutinaa. Herkistyneillä henkilöillä voi ilmetä allergisia reaktioita.

Pitkäaikaisen altistuksen haittavaikutukset

Kobolttipitoisen ilman pitkäaikainen hengittäminen voi aiheuttaa tukoksen hengitystiehyissä. Runsaasti kobolttia sisältävän ilman pitkäaikainen hengittäminen saattaa aiheuttaa keuhkofibroosin tai keuhkosyövän. Epidemiologiset tutkimukset osoittavat, että korkeille volframikarbidi-/kobolttipitoisuuksille altistuneilla työntekijöillä on tavanomaista suurempi riski sairastua keuhkosyöpään.

C

Koboltti ja nikkeli ovat voimakkaasti ihoa herkistäviä aineita. Toistuva tai jatkuva altistuminen niille voi aiheuttaa ärsytysreaktioita.

R-lausekkeet

Myrkyllistä: Pitkäaikainen altistus hengitysteitse voi aiheuttaa vakavaa haittaa terveydelle.

Myrkyllistä hengitettynä.

Rajallista näyttöä karsinogeenisista vaikutuksista.

Altistuminen hengitysteitse tai ihokosketus voi aiheuttaa herkistymistä.

Varotoimet

Ehkäise pölynmuodostusta ja vältä pölyn hengittämistä. Käytä kohdepoistoa, joka riittää vähentämään altistusta selvästi työ peräiselle altistumiselle määriteltyjen raja-arvojen alapuolelle.

D

Käytä viranomaisten hyväksymiä hengityssuojaimia, mikäli kohdeilmanvaihtoa ei ole tai se ei ole riittävä.

Käytä tarvittaessa suojalaseja.

Vältä toistuvaa ihokosketusta. Käytä suojakäsineitä. Pese kätesi huolellisesti, kun olet käsitellyt haitallisia aineita.

Käytä asianmukaista suojavaatetusta. Pese vaatteet tarpeen mukaan.

Älä syö, juo tai tupakoi työalueella. Pese paljaana ollut iho huolellisesti ennen syömistä, juomista tai tupakointia.

E

FIN

Raaka-aineiden vertailutaulukko

ISO	MC	CMC	Maa									
			Eurooppa	Saksa	Iso-Britannia		Ruotsi	Yhdysvallat	Ranska	Italia	Espanja	Japani
			Standardi									
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
P	Seostamaton teräs											
	P1.1.Z.AN	01.1	S235JR G2	1.0038	4360 40 C	-	1311	A570.36	E 24-2 Ne	-	-	STKM 12A;C
	P1.1.Z.AN	01.1	S235J2 G3	1.0116	4360 40 B	-	1312	A573-81 65	E 24-U	Fe37-3	-	-
	P1.1.Z.AN	01.1	C15	1.0401	080M15	-	1350	1015	CC12	C15C16	F.111	-
	P1.1.Z.AN	01.1	C22	1.0402	050A20	2C/2D	1450	1020	CC20	C20C21	F.112	-
	P1.1.Z.AN	01.1	C15E	1.1141	080M15	32C	1370	1015	XC12	C16	C15K	S15C
	P1.1.Z.AN	01.1	C25E	1.1158	-	-	-	1025	-	-	-	S25C
	P1.1.Z.AN	01.1	S380N	1.8900	4360 55 E	-	2145	A572-60	-	FeE390KG	-	-
	P1.1.Z.AN	01.1	17MnV7	1.0870	4360 55 E	-	2142	A572-60	NFA 35-501 E 36	-	-	-
	P1.1.Z.AN	02.1	55Si7	1.0904	250A53	45	2085	9255	55S7	55Si8	56Si7	-
	P1.1.Z.AN	02.2	-	-	-	-	2090	9255	55S7	-	-	-
	P1.2.Z.AN	01.2	C35	1.0501	060A35	-	1550	1035	CC35	C35	F.113	-
	P1.2.Z.AN	01.2	C45	1.0503	080M46	-	1650	1045	CC45	C45	F.114	-
	P1.2.Z.AN	01.2	40Mn4	1.1157	150M36	15	-	1039	35M5	-	-	-
	P1.2.Z.AN	01.2	36MN5	1.1167	-	-	2120	1335	40M5	-	36Mn5	SMn438(H)
	P1.2.Z.AN	01.2	28Mn6	1.1170	150M28	14A	-	1330	20M5	C28Mn	-	SCMn1
	P1.2.Z.AN	01.2	C35G	1.1183	060A35	-	1572	1035	XC38TS	C36	-	S35C
	P1.2.Z.AN	01.2	C45E	1.1191	080M46	-	1672	1045	XC42	C45	C45K	S45C
	P1.2.Z.AN	01.2	C53G	1.1213	060A52	-	1674	1050	XC48TS	C53	-	S50C
	P1.2.Z.AN	01.3	C55	1.0535	070M55	-	1655	1055	-	C55	-	-
	P1.2.Z.AN	01.3	C55E	1.1203	070M55	-	-	1055	XC55	C50	C55K	S55C
	P1.2.Z.AN	02.1	S275J2G3	1.0144	4360 43C	-	1412	A573-81	E 28-3	-	-	SM 400A;B;C
	P1.2.Z.AN	02.1	S355J2G3+C2	1.0570	4360 50B	-	2132	-	E36-3	Fe52BFN/Fe52CFN	-	SM490A;B;C;YA;YB
	P1.2.Z.AN	02.1	S355J2G3	1.0841	150 M 19	-	2172	5120	20 MC 5	Fe52	F-431	-
	P1.3.Z.AN	01.3	C60E	1.0601	080A62	43D	-	1060	CC55	C60	-	-
	P1.3.Z.AN	01.3	C60E	1.1221	080A62	43D	1678	1060	XC60	C60	-	S58C
	P1.3.Z.AN	01.4	C101E	1.1274	060 A 96	-	1870	1095	XC 100	-	F-5117	-
	P1.3.Z.AN	01.4	C101u	1.1545	BW 1A	-	1880	W 1	Y105	C36KU	F-5118	SK 3
	P1.3.Z.AN	01.4	C105W1	-	BW2	-	2900	W210	Y120	C120KU	F.515	SUP4
	P1.3.Z.AN	02.1	S340 MGC	1.0961	-	-	-	9262	60SC7	60SiCr8	60SiCr8	-
	P1.4.Z.AN	01.1	11SMn30	1.0715	230M07	-	1912	1213	S250	CF9SMn28	11SMn28	SUM22
	P1.4.Z.AN	01.1	11SMnPb30	1.0718	-	-	1914	12L13	S250Pb	CF9SMnPb28	11SMnPb28	SUM22L
	P1.4.Z.AN	01.1	10SPb20	1.0722	-	-	-	-	10PbF2	CF10SPb20	10SPb20	-
	P1.4.Z.AN	01.1	11SMn37	1.0736	240M07	1B	-	1215	S 300	CF9SMn36	12SMn35	-
	P1.4.Z.AN	01.1	11SMnPb37	1.0737	-	-	1926	12L14	S300Pb	CF9SMnPb36	12SMnP35	-
	P1.4.Z.AN	01.2	35S20	1.0726	212M36	8M	1957	1140	35MF4	-	F210G	-
Teräs	P1.5.C.UT	01.1	GC16E	1.1142	030A04	1A	1325	1115	-	-	-	-
	Niukkaseosteinen teräs											
	P2.1.Z.AN	02.1	16Mo3	1.5415	1501-240	-	2912	A204Gr.A	15D3	16Mo3KW	16Mo3	-
	P2.1.Z.AN	02.1	14Ni6	1.5622	-	-	-	A350LF5	16N6	14Ni6	15Ni6	-
	P2.1.Z.AN	02.1	21NiCrMo2	1.6523	805M20	362	2506	8620	20NCD2	20NiCrMo2	20NiCrMo2	SNCM220(H)
	P2.1.Z.AN	02.1	17CrNiMo6	1.6587	820A16	-	-	-	18NCD6	-	14NiCrMo13	-
	P2.1.Z.AN	02.1	15Cr3	1.7015	523M15	-	-	5015	12C3	-	-	SCr415(H)
	P2.1.Z.AN	02.1	55Cr3	1.7176	527A60	48	-	5155	55C3	-	-	SUP9(A)
	P2.1.Z.AN	02.1	15CrMo5	1.7262	-	-	2216	-	12CD4	-	12CrMo4	SCM415(H)
	P2.1.Z.AN	02.1	13CrMo4-5	1.7335	1501-620Gr27	-	-	A182 F11;F12	15CD3.5 15CD4.5	14CrMo4 5	14CrMo45	-
	P2.1.Z.AN	02.1	10CrMo9 10	1.7380	1501-622 Gr.31;45	-	2218	A182 F.22	12CD9, 10	12CrMo9, 10	TU.H	-
	P2.1.Z.AN	02.1	14MoV6 3	1.7715	1503-660-440	-	-	-	-	-	13MoCrV6	-
	P2.1.Z.AN	02.1	50CoMo4	1.7228	823M30	33	2512	-	-	653M31	-	-
	P2.1.Z.AN	02.2	14NiCr10	1.5732	-	-	-	3415	14NC11	16NiCr11	15NiCr11	SNC415(H)
	P2.1.Z.AN	02.2	14NiCr14	1.5752	655M13; A12	36A	-	3415;3310	12NC15	-	-	SNC815(H)
	P2.1.Z.AN	02.1/02.2	16MnCr5	1.7131	(527M20)	-	2511	5115	16MC5	16MnCr5	16MnCr5	-
	P2.1.Z.AN	02.1/02.2	34CrMo4	1.7220	708A37	19B	2234	4137;4135	35CD4	35CrMo4	34CrMo4	SCM432;SCCRM3
	P2.1.Z.AN	02.1/02.2	41CrMo4	1.7223	708M40	19A	2244	4140;4142	42CD4TS	41CrMo4	42CrMo4	SCM 440
	P2.1.Z.AN	02.1/02.2	42CrMo4	1.7225	708M40	19A	2244	4140	42CD4	42CrMo4	42CrMo4	SCM440(H)
	P2.1.Z.AN	03.11	14NiCrMo134	1.6657	832M13	36C	-	-	-	15NiCrMo13	14NiCrMo131	-
	P2.2.Z.AN	02.1	31CrMo12	1.8515	722 M 24	-	2240	-	30 CD 12	30CrMo12	F-1712	-
	P2.2.Z.AN	02.1	39CrMoV13 9	1.8523	897M39	40C	-	-	-	36CrMoV12	-	-
	P2.2.Z.AN	02.1	41CrS4	1.7039	524A14	-	2092	L1	-	105WCR 5	-	-
	P2.2.Z.AN	02.1	50NiCr13	1.2721	-	-	2550	L6	55NCV6	-	F-528	-
	P2.2.Z.AN	03.11	45WCrV7	1.2542	BS1	-	2710	S1	-	45WCrV8KU	45WCrSi8	-
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	36CrNiMo4	1.6511	816M40	110	-	9840	40NCD3	38NiCrMo4(KB)	35NiCrMo4	-
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	34CrNiMo6	1.6582	817M40	24	2541	4340	35NCD6	35NiCrMo6(KB)	-	-
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	34Cr4	1.7033	530A32	18B	-	5132	32C4	34Cr4(KB)	35Cr4	SCr430(H)
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	41Cr4	1.7035	530A40	18	-	5140	42C4	41Cr4	42Cr4	SCr440(H)
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	32CrMo12	1.7361	722M24	40B	2240	-	30CD12	32CrMo12	F.124.A	-
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	51CrV4	1.8159	735A50	47	2230	6150	50CV4	50CrV4	51CrV4	SUP10
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	41CrAlMo7	1.8509	905M39	41B	2940	-	40CAD6, 12	41CrAlMo7	41CrAlMo7	-
	P2.3.Z.AN	02.1	100Cr6	1.3505	534A99	31	2258	52100	100C6	100Cr6	F.131	SUJ2

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ISO	MC	CMC	Maa									
			Eurooppa	Saksa	Iso-Britannia		Ruotsi	Yhdysvallat	Ranska	Italia	Espanja	Japani
			Standardi									
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
P	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	105WCr6	1.2419	-	-	2140	-	105WC13	10WCr6	105WCr5	SKS31
	P2.3.Z.AN/H1.2.Z.HA	-	-	-	-	-	-	-	-	107WCr5KU	-	SKS2, SKS3
	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	-	1.2714	-	-	-	L6	55NCDV7	-	F.520.S	SKT4
	P2.3.Z.AN/H1.3.Z.HA	02.1/02.2	100Cr6	1.2067	BL3	-	-	L3	Y100C6	-	100Cr6	-
	P2.4.Z.AN	02.1	16MnCr5	1.7139	-	-	2127	-	-	-	-	-
	P2.5.Z.HT	02.1	16Mo5	1.5423	1503-245-420	-	-	4520	-	16Mo5	16Mo5	-
	P2.5.Z.HT	02.1	40NiCrMo8-4	1.6562	311-Type 7	-	-	8740	-	40NiCrMo2(KB)	40NiCrMo2	SNCM240
	P2.5.Z.HT	02.1	42Cr4	1.7045	-	-	2245	5140	-	-	42Cr4	SCr440
	P2.5.Z.HT	02.1	31NiCrMo14	1.5755	830 M 31	-	2534	-	-	-	F-1270	-
	P2.5.Z.HT	02.2	36NiCr6	1.5710	640A35	111A	-	3135	35NC6	-	-	SNC236
	P2.6.C.UT	02.1	22Mo4	1.5419	605A32	-	2108	8620	-	-	F520.S	-
	P2.6.C.UT	02.1/02.2	25CrMo4	1.7218	1717CDS110	-	2225	4130	25CD4	25CrMo4(KB)	AM26CrMo4	SCM420;SCM430
	P2.6.C.UT	06.2	-	-	-	-	2223	-	-	-	-	-
	Runsasseosteinen teräs											
	P3.0.Z.AN	03.11	X210Cr12	1.2080	BD3	-	-	D3	Z200C12	X210Cr13KU X250Cr12KU	X210Cr12	SKD1
	P3.0.Z.AN	03.11	X43Cr13	1.2083	-	-	2314	-	-	-	-	-
	P3.0.Z.AN	03.11	X40CrMoV5 1	1.2344	BH13	-	2242	H13	Z40CDV5	X35CrMoV05KU X40CrMoV511KU	X40CrMoV5	SKD61
	P3.0.Z.AN	03.11	X100CrMoV5 1	1.2363	BA2	-	2260	A2	Z100CDV5	X100CrMoV51KU	X100CrMoV5	SKD12
	P3.0.Z.AN	03.11	X210CrW12	1.2436	-	-	2312	-	-	X215CrW12 1KU	X210CrW12	SKD2
	P3.0.Z.AN	03.11	X30WCrV9 3	1.2581	BH21	-	-	H21	Z30WCV9	X28W09KU X30WCrV9 3KU	X30WCrV9	SKD5
	P3.0.Z.AN	03.11	X165CrMoV 12	1.2601	-	-	2310	-	-	X165CrMoW12KU	X160CrMoV12	-
	P3.0.Z.AN	03.21	X155CrMoV12-1	1.2379	-	-	2736	HNV3	-	-	-	-
	P3.0.Z.HT	03.11	X8Ni9	1.5662	1501-509;510	-	-	ASTM A353	-	X10Ni9	XBNi09	-
	P3.0.Z.HT	03.11	12Ni19	1.5680	-	-	-	2515	Z18N5	-	-	-
	P3.1.Z.AN	03.11	S6-5-2	1.3343	4959BA2	-	2715	D3	Z40CSD10	15NiCrMo13	-	SUH3
	P3.1.Z.AN	03.13	-	-	BM 2	-	2722	M 2	Z85WDCV	HS 6-5-2-2	F-5603.	SKH 51
	P3.1.Z.AN	03.13	HS 6-5-2-5	1.3243	BM 35	-	2723	M 35	6-5-2-5	HS 6-5-2-5	F-5613	SKH 55
	P3.1.Z.AN	03.13	HS 2-9-2	1.3348	-	-	2782	M 7	-	HS 2-9-2	F-5607	-
	P3.2.C.AQ	06.33	G-X120Mn12	1.3401	Z120M12	-	2183	L3	Z120M12	XG120Mn12	X120Mn12	SCMnH/1
	Ferriittiset/martensiittiset ruostumattomat teräkset											
Teräs	P5.0.Z.AN	05.11/15.11	X10CrAL13	1.4724	403S17	-	-	405	Z10C13	X10CrAl12	F.311	SUS405
	P5.0.Z.AN	05.11/15.11	X10CrAL18	1.4742	430S15	60	-	430	Z10CAS18	X8Cr17	F.3113	SUS430
	P5.0.Z.AN	05.11/15.11	X10CrAL2-4	1.4762	-	-	2322	446	Z10CAS24	X16Cr26	-	SUH446
	P5.0.Z.AN	05.11/15.11	X1CrMoTi18-2	1.4521	-	-	2326	S44400	-	-	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr13	1.4000	403S17	-	2301	403	Z6C13	X6Cr13	F.3110	SUS403
	P5.0.Z.AN/P5.0.Z.HT	-	X7Cr14	1.4001	-	-	-	-	-	-	F.8401	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X10Cr13	1.4006	410S21	56A	2302	410	Z10C14	X12Cr13	F.3401	SUS410
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr17	1.4016	430S15	960	2320	430	Z8C17	X8Cr17	F3113	SUS430
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrAL13	1.4002	405S17	-	-	405	Z8CA12	X6CrAl13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X20Cr13	1.4021	420S37	-	2303	420	Z20C13	X20Cr13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrMo17-1	1.4113	434S17	-	2325	434	Z8CD17.01	X8CrMo17	-	SUS434
	P5.0.Z.HT	03.11	X45CrS9-3-1	1.4718	401S45	52	-	HW3	Z45CS9	X45GrSi8	F322	SUH1
	P5.0.Z.HT	05.11/15.11	X85CrMoV18-2	1.4748	443S65	59	-	HNV6	Z80CSN20.02	X80CrSiNi20	F.320B	SUH4
	P5.0.Z.HT	05.11/15.11	X20CrMoV12-1	1.4922	-	-	2317	-	-	X20CrMoNi 12 01	-	-
	P5.0.Z.PH	05.11/15.11	X12CrS13	1.4005	416 S 21	-	2380	416	Z11CF13	X12 CrS 13	F-3411	SUS 416
	P5.0.Z.PH	05.11/15.11	X46Cr13	1.4034	420S45	56D	2304	-	Z40CM	X40Cr14	F.3405	SUS420J2
	P5.0.Z.PH	05.11/15.11	X19CrNi17-2	1.4057	431S29	57	2321	431	Z15CNi6.02	X16CrNi16	F.3427	SUS431
	P5.0.Z.PH	05.12/15.12	X5CrNiCuNb16-4	1.4542 1.4548	-	-	-	630	Z7CNU17-04	-	-	-
	P5.0.Z.PH	15.21	X4 CrNiMo16-5	1.4418	-	-	2387	-	Z6CND16-04-01	-	-	-
	P5.1.Z.AN/P5.0.Z.HT	05.11/15.11	X14CrMoS17	1.4104	-	-	2383	430F	Z10CF17	X10CrS17	F.3117	SUS430F
					Kauppanimet							
	P2.1.Z.AN	02.1			OVAKO 520M (Ovako Steel)							
	P2.2.Z.AN	02.1		1.0045	FORMAX (Uddeholm Tooling)							
	P2.2.Z.AN	02.1			IMACRO NIT (Imatra Steel)							
	P2.5.Z.HT	02.2			INEXA 482 (XM) (Inexa Profil)							
	P1.2.Z.AN				S355J2G3(XM)							
	P1.2.Z.AN				C45(XM)							
	P1.2.Z.AN				16MnCrS5(XM)							
	P2.5.Z.HT				INEXA280(XM)							
	P2.5.Z.HT	02.2			070M20(XM)							
	P2.5.Z.HT	02.2			HARDOX 500 (SSAB – Swedish Steel Corp.)							
	P2.5.Z.HT				WELDOX 700 (SSAB – Swedish Steel Corp.)							

FIN

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ISO	MC	CMC	Maa Eurooppa	Saksa	Iso-Britannia		Ruotsi	Yhdysvallat	Ranska	Italia	Espanja	Japani
			Standardi DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
M	**Austeniittinen ruostumaton teräs**											
	M1.0.Z.AQ	05.11/15.11	X3CrNiMo13-4	1.4313	425C11	-	2385	CA6-NM	Z4CND13.4M Z38C13M	(G)X6CrNi304	-	SCS5
	M1.0.Z.AQ/M1.0.C.UT	05.11/15.11	X53CrMnNiN21-9	1.4871	349S54	-	-	EV8	Z52CMN21.09	X53CrMnNiN21 9	-	SUH35, SUH36
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiN18-10	1.4311	304S62	-	2371	304LN	Z2CN18.10	-	-	SUS304LN
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-13-3	1.4429	-	-	2375	316LN	Z2CND17.13	-	-	SUS316LN
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo17-12-2	1.4404	316S13	-	2348	316L	Z2CND17-12	X2CrNiMo1712	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-14-3	1.4435	316S13	-	2353	316L	Z2CND17.12	X2CrNiMo17 12	-	SCS16, SUS316L
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X3CrNiMo17-3-3	1.4436	316S33	-	2343, 2347	316	Z6CND18-12-03	X8CrNiMo1713	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-15-4	1.4438	317S12	-	2367	317L	Z2CND19.15	X2CrNiMo18 16	-	SUS317L
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiNb18-10	1.4550	347S17	58F	2338	347	Z6CNNb18.10	X6CrNiNb18 11	F.3552 F.3524	SUS347
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiMoTi17-12-2	1.4571	320S17	58J	2350	316Ti	Z6NDT17.12	X6CrNiMoTi17 12	F.3535	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X10CrNiMoNb 18-12	1.4583	-	-	-	318	Z6CNDNb17 13B	X6CrNiMoNb17 13	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X15CrNiSi20-12	1.4828	309S24	-	-	309	Z15CNS20.12	-	-	SUH309
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-11-2	1.4406	301S21	58C	2370	308	Z1NCDU25.20	-	F.8414	SCS17
	M1.0.Z.AQ	05.21/15.21	X1CrNiMoCuN20-18-7	1.4547	-	-	2378	S31254	Z1CNDU20-18-06AZ	-	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X9CrNi18-8	1.4310	-	-	2331	301	Z12CN17.07	X12CrNi17 07	F.3517	SUS301
	M1.0.Z.PH	05.22/15.22	X7CrNiAL17-7	1.4568 1.4504	316S111	-	-	17-7PH	Z8CNA17-07	X2CrNiMo1712	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNi19-11	1.4306	304S11 304S12	-	2352	304L	Z2CN18-10	X2CrNi18 11	-	-
	M1.1.Z.AQ	05.21/15.21	-	-	304S31	58E	2332, 2333	304	Z6CN18.09	X5CrNi18 10	F.3504 F.3541	SUS304
	M1.1.Z.AQ	05.21/15.21	X5CrNi18-10	1.4301	304S15	58E	2332	304	Z6CN18.09	X5CrNi18 10	F.3551	SUS304
	M1.1.Z.AQ	05.21/15.21	X5CrNiMo17-2-2	1.4401	316S16	58J	2347	316	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316
	M1.1.Z.AQ	05.21/15.21	X6CrNiTi18-10	1.4541	321S12	58B	2337	321	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523	SUS321
	M1.2.Z.AQ	05.21/15.21	X8CrNiS18-9	1.4305	303S21	58M	2346	303	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303
	Super austenniittinen (Ni>20%) ruostumaton teräs											
	M2.0.C.AQ	20.11	G-X40NiCrSi36-18	1.4865	330C11	-	-	-	-	XG50NiCr39 19	-	SCH15
	M2.0.Z.AQ	05.21/15.21	X1NiCrMoCu25-20-5	1.4539	-	-	2562	UNS V 0890A	Z2 NCDU25-20	-	-	-
	M2.0.Z.AQ	05.21/15.21	X8CrNi25-21	1.4845	310S24	-	2361	310S	Z12CN25 20	X6CrNi25 20	F.331	SUH310
	M2.0.Z.AQ	20.11	X12NiCrSi36 16	1.4864	-	-	-	330	Z12NCS35.16	F-3313	-	SUH330
	M2.0.Z.AQ	05.23/15.23	X1NiCrMoCu31-27-4	1.4563	-	-	2584	NO8028	Z1NCDU31-27-03	-	-	-
	Ferriittis-austeniittiset ruostumattomat teräkset (duplex)											
	M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X2CrNiN23-4	1.4362	-	-	2376	S31500	-	-	-	-
	M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X8CrNiMo27-5	-	-	-	2324	S32900	-	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiN23-4	-	-	-	2327	S32304	Z2CN23-04AZ	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	-	-	-	-	2328	-	-	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiMoN22-53	-	-	-	2377	S31803	Z2CND22-05-03	-	-	-
					Kauppanimet							
	M1.1.Z.AQ	05.21/15.21			SANMAC 304 (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21		1.0045	SANMAC 304L (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21			SANMAC 316 (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21			SANMAC 316L (Sandvik Steel)							
	M1.0.Z.AQ	05.23/15.23			254 SMO							
	M2.0.Z.AQ	05.23/15.23			654 SMO							
	M3.2.Z.AQ	05.52/15.52			SANMAC SAF 2205 (Sandvik Steel)							
	M3.2.Z.AQ	05.52/15.52			SANMAC SAF 2507 (Sandvik Steel)							

Ruostumaton teräs

Raaka-aineiden vertailutaulukko

ISO	MC	CMC	Maa Eurooppa	Saksa	Iso-Britannia		Ruotsi	Yhdysvallat	Ranska	Italia	Espanja	Japani
			Standardi									
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
K	**Adusoitu valurauta**											
	K1.1.C.NS	07.1	-	-	8 290/6	-	0814	-	MN 32-8	-	-	FCMB310
	K1.1.C.NS	07.1	EN-GJMB350-10	0.8135	B 340/12	-	0815	32510	MN 35-10	-	-	FCMW330
	K1.1.C.NS	07.2	EN-GJMB450-6	0.8145	P 440/7	-	0852	40010	Mn 450	GMN 45	-	FCMW370
	K1.1.C.NS	07.2	EN-GJMB550-4	0.8155	P 510/4	-	0854	50005	MP 50-5	GMN 55	-	FCMP490
					P 570/3		0858	70003	MP 60-3			FCMP540
	K1.1.C.NS	07.2	EN-GJMB650-2	0.8165	P570/3	-	0856	A220-70003	Mn 650-3	GMN 65	-	FCMP590
	K1.1.C.NS	07.3	EN-GJMB700-2	0.8170	P690/2	-	0862	A220-80002	Mn700-2	GMN 70	-	FCMP690
	Harmaa valurauta											
	K2.1.C.UT	08.1	-	-	-	-	0100	-	-	-	-	-
	K2.1.C.UT	08.1	EN-GJL-100	0.6010	-	-	0110	No 20 B	Ft 10 D	-	-	FC100
	K2.1.C.UT	08.1	EN-GJL-150	0.6015	Grade 150	-	0115	No 25 B	Ft 15 D	G 15	FG 15	FC150
	K2.1.C.UT	08.1	EN-GJL-200	0.6020	Grade 220	-	0120	No 30 B	Ft 20 D	G 20	-	FC200
	K2.1.C.UT	08.2	EN-GJL-250	0.6025	Grade 260	-	0125	No 35 B	Ft 25 D	G 25	FG 25	FC250
	K2.1.C.UT	08.2	EN-JLZ	0.6040	Grade 400	-	0140	No 55 B	Ft 40 D	-	-	-
	K2.2.C.UT	08.2	EN-GJL-300	0.6030	Grade 300	-	0130	No 45 B	Ft 30 D	G 30	FG 30	FC300
	K2.2.C.UT	08.2	EN-GJL-350	0.6035	Grade 350	-	0135	No 50 B	Ft 35 D	G 35	FG 35	FC350
	K2.3.C.UT	08.3	GGL-NiCr20-2	0.6660	L-NiCuCr202	-	0523	A436 Type 2	L-NC 202	-	-	-
Valurauta	**Pallografiittivalurauta**											
	K3.1.C.UT	09.1	EN-GJS-400-15	0.7040	SNG 420/12	-	0717-02	60-40-18	FCS 400-12	GS 370-17	FGE 38-17	FCD400
	K3.1.C.UT	09.1	EN-GJS-400-18-LT	0.7043	SNG 370/17	-	0717-12	-	FGS 370-17	-	-	-
	K3.1.C.UT	09.1	EN-GJS-350-22-LT	0.7033	-	-	0717-15	-	-	-	-	-
	K3.1.C.UT	09.1	EN-GJS-800-7	0.7050	SNG 500/7	-	0727	80-55-06	FGS 500-7	GS 500	FGE 50-7	FCD500
	K3.2.C.UT	09.2	EN-GJS-600-3	0.7060	SNG 600/3	-	0732-03	-	FGS 600-3	-	-	FCD600
	K3.3.C.UT	09.2	EN-GJS-700-2	0.7070	SNG 700/2	-	0737-01	100-70-03	FGS 700-2	GS 700-2	FGS 70-2	FCD700
	K3.5.C.UT	-	EN-GJSA-XNiCr20-2	0.7660	Grade S6	-	0776	A43D2	S-NC 202	-	-	-
	Tylppägrafiittirauta											
	K4.1.C.UT	-	EN-GJV-300									
	K4.1.C.UT	-	EN-GJV-350									
	K4.2.C.UT	-	EN-GJV-400									
	K4.2.C.UT	-	EN-GJV-450									
	K4.2.C.UT	-	EN-GJV-500									
	Austemperoitu pallografiittivalurauta											
	K5.1.C.NS	-	EN-GJS-800-8	-	-	-	-	ASTM A897 No. 1	-	-	-	-
	K5.1.C.NS	-	EN-GJS-1000-5	-	-	-	-	ASTM A897 No. 2	-	-	-	-
	K5.2.C.NS	-	EN-GJS-1200-2	-	-		-	ASTM A897 No. 3	-	-	-	-
	K5.2.C.NS	-	EN-GJS-1400-1	-	-	-	-	ASTM A897 No. 4	-	-	-	-
	K5.3.C.NS	-	-	-	-	-	-	ASTM A897 No. 5	-	-	-	-

FIN

Raaka-aineiden vertailutaulukko

ISO	MC	CMC	Maa Eurooppa	Saksa	Iso-Britannia		Ruotsi	Yhdysvallat	Ranska	Italia	Espanja	Japani
			Standardi DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
N	**Alumiinipohjaiset seokset**											
Ei-rauta-aineet	N1.3.C.AG	30.21	G-AlSI9MGWA	3.2373	-	-	4251	SC64D	A-S7G	-	-	C4BS
	N1.3.C.UT	30.21	G-ALMG5	-	LM5	-	4252	GD-AlSI12	A-SU12	-	-	AC4A
	N1.3.C.UT/N1.3.C.AG	30.21/30.22	-	-	LM25	-	4244	356.1	-	-	-	A5052
	N1.3.C.UT	-	GD-AlSi12	-	-	-	4247	A413.0	-	-	-	A6061
	N1.3.C.AG	-	GD-AlSi8Cu3	-	LM24	-	4250	A380.1	-	-	-	A7075
	N1.3.C.UT	-	G-AlSi12(Cu)	-	LM20	-	4260	A413.1	-	-	-	ADC12
	N1.3.C.UT	-	G-AlSi12	-	LM6	-	4261	A413.2	-	-	-	-
	N1.3.C.AG	-	G-AlSi10Mg(Cu)	-	LM9	-	4253	A360.2	-	-	-	-
S	**Nikkelipohjaiset seokset**											
Kuumalujat superseokset	S2.0.Z.AG	20.22	S-NiCr13A16MoNb	LW2 4670	mar-46	-	-	5391	NC12AD	-	-	-
	S2.0.C.UT	20.24	NiCo15Cr10MoAlTi	LW2 4674	-	-	-	AMS 5397	-	-	-	-
	S2.0.Z.AG	20.22	NiFe35Cr14MoTi	LW2.4662	-	-	-	5660	ZSNCDT42	-	-	-
	S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	HR8	-	-	5383	NC19eNB	-	-	-
	S2.0.Z.AG	20.22	NiCr20TiAk	2.4631	Hr401.601	-	-	-	NC20TA	-	-	-
	S2.0.Z.AG	20.22	NiCr19Co11MoTi	2.4973	-	-	-	AMS 5399	NC19KDT	-	-	-
	S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	-	-	-	AMS 5544	NC20K14	-	-	-
	S2.0.Z.AN	20.21	-	2.4603	-	-	-	5390A	NC22FeD	-	-	-
	S2.0.Z.AN	20.21	NiCr22Mo9Nb	2.4856	-	-	-	5666	NC22FeDNB	-	-	-
	S2.0.Z.AN	20.21	NiCr20Ti	2.4630	HR5.203-4	-	-	-	NC20T	-	-	-
	S2.0.Z.AG	20.22	NiCu30AL3Ti	2.4375	3072-76	-	-	4676	-	-	-	-
	Kobolttipohjaiset											
	-	-	CoCr20W15Ni	-	-	-	-	5537C, AMS	KC20WN	-	-	-
	S3.0.Z.AG	20.32	CoCr22W14Ni	LW2.4964	-	-	-	5772	KC22WN	-	-	-
	Titaaniseokset											
	S4.2.Z.AN	23.22	TiAl5Sn2.5	3.7115.1	TA14/17	-	-	UNS R54520	T-A5E UNS R56400	-	-	-
	S4.2.Z.AN	23.22	TiAl6V4	3.7165.1	TA10-13/TA28	-	-	UNS R56401	T-A6V	-	-	-
	S4.3.Z.AN	23.22	TiAl5V5Mo5Cr3	-	-	-	-	-	-	-	-	-
	S4.2.Z.AN	23.22	TiAl4Mo4Sn4Si0.5	3.7185	-	-	-	-	-	-	-	-
			Kauppanimet									
			Rautapohjaiset seokset									
	S2.0.Z.UT/S2.0.Z.AN	20.11	Incoloy 800									
			Nikkelipohjaiset seokset									
	S2.0.Z.AN	20.2	Haynes 600									
	S2.0.Z.AN	20.2	Nimocast PD16									
	S2.0.Z.AG	20.2	Nimonic PE 13									
	S2.0.Z.AG	20.2	Rene 95									
	S2.0.Z.AN	20.21	Hastelloy C									
	S2.0.Z.AN	20.21	Incoloy 825									
	S2.0.Z.AN	20.21	Inconel 600									
	S2.0.Z.AN	20.21	Monet 400									
	S2.0.Z.AG	20.22	Inconel 700									
	S2.0.Z.AG	S2.0.Z.AG	Inconel 718									
	S2.0.Z.AG	20.22	Mar – M 432									
	S2.0.Z.AG	20.22	Nimonic 901									
	S2.0.Z.AG	20.22	Waspaloy									
	S2.0.C.NS	20.24	Jessop G 64									
			Kobolttipohjaiset									
	S3.0.Z.AG	20.3	Ilmavastus 213									
	S3.0.Z.AG	20.3	Jetalloy 209									
H	**Karkaistut raaka-aineet**											
Karkaistut raaka-aineet	H1.2.Z.HA	04.1	X100CrMo13	1.4108	-	-	2258 08	440A	-	-	-	C4BS
	H1.3.Z.HA	04.1	X110CrMoV15	1.4111	-	-	2534 05	610	-	-	-	AC4A
	H1.2.Z.HA	04.1	X65CrMo14	-	-	-	2541 06	0-2	-	-	-	AC4A

CoroMill Plura koodiavain

2	S	3	4	0	-	1200	-	200	-	M	A	1640
1	2	3	4	5		6		7	8	9	10	11

1	Sarja
1:	Monipuolinen
2:	Optimoija

2	Otsan geometria
S:	Suora, kulmapyöristys, poraava
F:	Suora, kulmapyöristys, ei-poraava
P:	Suora, poraava
N:	Suora, ei-poraava
B:	Sädevarsijyrsin
C:	viistejyrsin
H:	Jyrsin suurelle syötölle
U:	Viiste ja säde
T:	Sorvausjyrsintä

3	Lastu-uran nousukulma
0:	0°<FHA≤15°
1:	15°<FHA≤25°
2:	25°<FHA≤35°
3:	35°<FHA≤45°
4:	45°<FHA≤55°
5:	55°<FHA≤65°

4	Työkalumallin keskim. lastuamispituus (APMX/DC)
0:	0-0.5 x DC
1:	0.6-1.0 x DC
2:	1.1-1.5 x DC
3:	1.6-2.0 x DC
4:	2.1-2.5 x DC
5:	2.6-3.0 x DC
6:	3.1-3.5 x DC
7:	3.6-4.0 x DC
8:	4.1-5.0 x DC
9:	> 5.0 x DC

5	Juokseva numero, erottaa työkalumallien koodit

6	Lastuamishalkaisija (DC), 1/100.
	Esim. 1200 = 12.00 mm

7	Nirkonsäde, viiste tai viisteen säde, 1/100.
	Esim. Nirkonsäde 200 = 2 mm. Esim. Viiste 045 = 45°

8	Lastuamisnesteen syöttö
-	Ei nestekanavaa
C:	Nesteen suihkutus radiaalisuunnassa
A:	Nesteen suihkutus aksiaalisuunnassa

9	Pääasiallinen ISO-materiaali
P:	ISO P
K:	ISO K
M:	ISO M
S:	ISO S
H:	ISO H
N:	ISO N
O:	ISO O
X:	Useita

10	Varsi
A:	Lieriö
B:	Weldon
C:	Lieriö tasolla
D:	Weldon-varsi ja kevennetty kaula
Y:	iLock
F:	iLock ja kevennetty kaula
G:	Alikokoinen

11	Laatu

FIN

Kierretappien koodiavain

T200	-	S	D	100	D	A	-	M3
1		2	3	4	5	6		7

1 Tuoteperhe

2 ISO-materiaali		
P	=	Teräs
M	=	Ruostumaton teräs
K	=	Valurauta
S	=	Kuumalujat superseokset
H	=	Karkaistut aineet
N	=	Ei-rauta-aineet
X	=	Monimateriaali

3 Materiaalin vaativuus		
E	=	Helppo
M	=	Keskiraskas
D	=	Vaikeat

4 Numero
1 0 0
Oma numero:vahvistettu tai suora varsieri viiste, työkalu, nesteensyöttö jne.

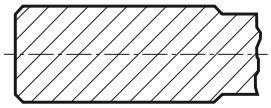
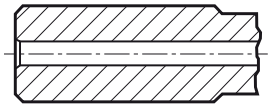
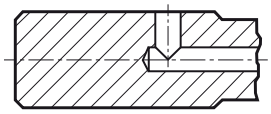
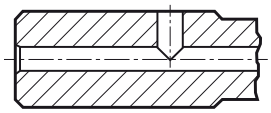
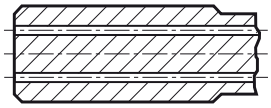
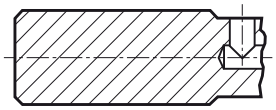
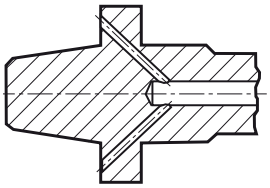
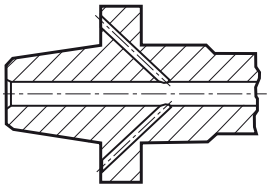
5 Standardi		
D	=	DIN
A	=	ANSI & DIN/ANSI
J	=	JIS
I	=	ISO

6 Kierremuoto		
A	=	M
B	=	MF
C	=	MJ
D	=	UN
E	=	UNC
F	=	UNF
G	=	UNEF
H	=	UNJC
I	=	UNJF
J	=	UNS
K	=	G
L	=	NPT
M	=	NPTF
N	=	NPSF
O	=	NPSM
P	=	EGM
Q	=	EGMF
R	=	EGUNC
S	=	EGUNF
T	=	PG
U	=	R
V	=	Rc
X	=	Rp
Y	=	BA
Z	=	EGUNJF

7 Mitta Jako vain tarvittaessa, esim. MF.	
M3	
M10x125	(ei desimaaleja jakomitassa)

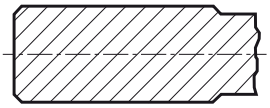
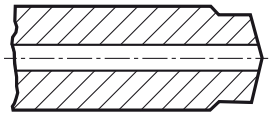
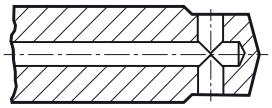
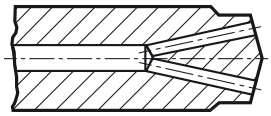
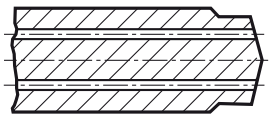
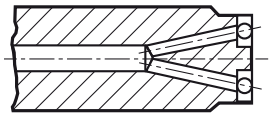
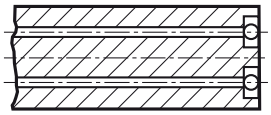
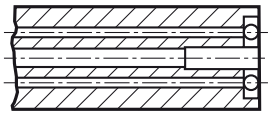
CNSC

Sisäisen lastuamisnestekanavan tyyppi

Koodi	Kuvaus	Kuva
0	Ei nestekanavaa	
1	Keskiön läpi	
2	Radiaalinen	
3	Keskiön läpi ja radiaalinen	
4	Keskiön molemmin puolin	
5	Radiaalinen, ennen liitäntäkappaletta	
6	Laipan läpi	
7	Laipan ja keskiön läpi	
8	Ulkokehällä olevien urien kautta	

CXSC

Nestekanavan mallikoodi

Koodi	Kuvaus	Kuva
0	Ei nestekanavaa	
1	Keskiön läpi	
2	Radiaalinen	
3	Vino ulostulo	
4	Keskiön molemmin puolin	
5	Vino ulostulo, säädettävät suuttimet	
6	Keskiön molemmin puolin, säädettävät suuttimet	
7	Ulkokehällä olevien urien kautta	
8	Keskiön läpi tai keskiön molemmin puolin, säädettävät suuttimet	

Koodi	Sivu
1B230-XA	A25
1B231-XA	A26
1B232-XA	A26
1B240-XA	A27
1C050-XA	A29
1P220-XA	A5
1P220-XB	A6
1P221-XA	A7
1P221-XB	A8
1P222-XA	A9
1P222-XB	A9
1P230-XA	A10, A11
1P230-XB	A10
1P231-XA	A12
1P231-XB	A13
1P240-XA	A14
1P240-XB	A14
1P250-XA	A15
1P250-XB	A15
1P251-XA	A16
1P251-XB	A16
1P260-XA	A17
1P260-XB	A17
1P330-XA	A19
1P330-XB	A19
1P340-XA	A23
1P340-XB	A23
1P341-XA	A20
1P341-XB	A20
1P360-XA	A21
1U000-XA	A29
435.B..A1-XF	D3, D4
435.T..A1-XF	D5, D6
460.1..A0-XM (3xD)	B15-B21
460.1..A0-XM (5xD)	B15-B21
460.1..A1-XM (3xD)	B3-B14
460.1..A1-XM (5xD)	B3-B14
460.1..A1-XM (8xD)	B3-B14
460.2..A1-XM	B22, B23
T	
T200-XM100AA	C6
T200-XM100AB	C9
T200-XM100AE	C11
T200-XM100AF	C13
T200-XM100DA	C4
T200-XM100DB-MF	C7, C8
T200-XM100DE	C10
T200-XM100DF	C12
T200-XM100DK	C14
T200-XM101AA	C6
T200-XM101AB	C9
T200-XM101AE	C11
T200-XM101AF	C13
T200-XM101DA	C4, C5
T200-XM101DE	C10
T200-XM101DF	C12
T200-XM104DA	C5
T200-XM105DA	C5
T300-XM100AA	C18
T300-XM100AB	C21
T300-XM100AE	C23
T300-XM100AF	C26
T300-XM100DA	C16
T300-XM100DB	C19, C20
T300-XM100DE	C22
T300-XM100DF	C25
T300-XM100DK	C28
T300-XM101AA	C18
T300-XM101AB	C21
T300-XM101AE	C23
T300-XM101AF	C26
T300-XM101DA	C16, C17
T300-XM101DE	C22
T300-XM101DF	C25
T300-XM102AA	C18
T300-XM102AB	C21
T300-XM102AE	C23, C24
T300-XM102AF	C26, C27
T300-XM102DA	C17
T300-XM103AA	C18
T300-XM103AB	C21
T300-XM103AE	C24
T300-XM103AF	C27
T300-XM103DA	C17
T300-XM104DA	C17
T300-XM105DA	C17