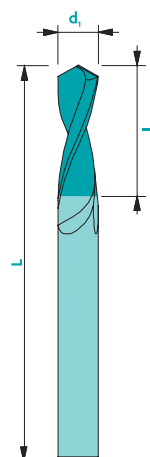


Spiralbohrer - Helix 24°

| Werkstoffe | Vc | Vc | Unbes- chichtet | beschichtet | Empfohlene Beschichtung* |
|-------------------------------|---------------|-------------|--------------------|-------------|-----------------------------|
| | unbeschichtet | beschichtet | | | |
| Stahl < 700 N/mm ² | 70 | 80 | □ | ■ | Tisi (BQ) |
| Stahl > 700 N/mm ² | 60 | 70 | □ | ■ | Tisi (BQ) |
| Nichtrostende Stähle | 20 | 40 | □ | □ | Tisi (BQ) |
| Gusseisen | 60 | 70 | □ | ■ | Tisi (BQ) |
| Kupfer | 100 | 130 | □ | □ | Solo (DA) |
| Messing - Bronze | 80 | 120 | ■ | ■ | Solo (DA) |
| Aluminium | 100 | 120 | □ | ■ | Solo (DA) |
| Gold - Silber | 80 | 100 | ■ | ■ | Solo (DA) |
| Platin - Palladium | - | 20 | - | □ | Solo (DA) |
| Superlegierungen | - | 25 | - | ■ | Trio (PO) |
| Titan | 40 | 60 | □ | □ | Rico (ZB) |

nicht geeignet - geeignet □ sehr geeignet ■

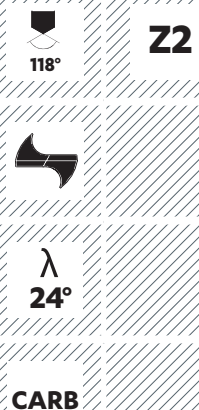


Toleranzen d₁; h5

| Art. n° | d ₁ | l ₁ | L | Beschichtung | |
|----------|----------------|----------------|----|--------------|-------|
| | | | | Unbesch. | Solo* |
| 348d0.30 | 0.30 | 5.0 | 30 | ▲ | ▲ |
| 348d0.35 | 0.35 | 5.0 | 30 | ▲ | ▲ |
| 348d0.40 | 0.40 | 6.0 | 30 | ▲ | ▲ |
| 348d0.45 | 0.45 | 6.0 | 30 | ▲ | ▲ |
| 348d0.50 | 0.50 | 6.0 | 30 | ▲ | ▲ |
| 348d0.55 | 0.55 | 6.0 | 30 | ▲ | ▲ |
| 348d0.60 | 0.60 | 6.0 | 30 | ▲ | ▲ |
| 348d0.65 | 0.65 | 6.0 | 30 | ▲ | ▲ |
| 348d0.70 | 0.70 | 6.0 | 30 | ▲ | ▲ |
| 348d0.75 | 0.75 | 6.0 | 30 | ▲ | ▲ |
| 348d0.80 | 0.80 | 7.0 | 30 | ▲ | ▲ |
| 348d0.85 | 0.85 | 7.0 | 30 | ▲ | ▲ |
| 348d0.90 | 0.90 | 7.0 | 30 | ▲ | ▲ |
| 348d0.95 | 0.95 | 7.0 | 30 | ▲ | ▲ |
| 348d1.00 | 1.00 | 7.0 | 30 | ▲ | ▲ |
| 348d1.05 | 1.05 | 8.0 | 30 | ▲ | ▲ |
| 348d1.10 | 1.10 | 8.0 | 30 | ▲ | ▲ |
| 348d1.15 | 1.15 | 8.0 | 30 | ▲ | ▲ |
| 348d1.20 | 1.20 | 8.0 | 30 | ▲ | ▲ |
| 348d1.25 | 1.25 | 8.0 | 30 | ▲ | ▲ |
| 348d1.30 | 1.30 | 8.0 | 30 | ▲ | ▲ |
| 348d1.35 | 1.35 | 8.0 | 30 | ▲ | ▲ |
| 348d1.40 | 1.40 | 8.0 | 30 | ▲ | ▲ |
| 348d1.45 | 1.45 | 8.0 | 30 | ▲ | ▲ |
| 348d1.50 | 1.50 | 8.0 | 30 | ▲ | ▲ |
| 348d1.55 | 1.55 | 9.0 | 38 | ▲ | ▲ |
| 348d1.60 | 1.60 | 9.0 | 38 | ▲ | ▲ |
| 348d1.65 | 1.65 | 9.0 | 38 | ▲ | ▲ |
| 348d1.70 | 1.70 | 9.0 | 38 | ▲ | ▲ |
| 348d1.75 | 1.75 | 9.0 | 38 | ▲ | ▲ |

| Art. n° | d ₁ | l ₁ | L | Beschichtung | |
|----------|----------------|----------------|----|--------------|-------|
| | | | | Unbesch. | Solo* |
| 348d1.80 | 1.80 | 9.0 | 38 | ▲ | ▲ |
| 348d1.85 | 1.85 | 9.0 | 38 | ▲ | ▲ |
| 348d1.90 | 1.90 | 9.0 | 38 | ▲ | ▲ |
| 348d1.95 | 1.95 | 9.0 | 38 | ▲ | ▲ |
| 348d2.00 | 2.00 | 9.0 | 38 | ▲ | ▲ |
| 348d2.05 | 2.05 | 9.0 | 38 | ▲ | ▲ |
| 348d2.10 | 2.10 | 9.0 | 38 | ▲ | ▲ |
| 348d2.15 | 2.15 | 10.0 | 40 | ▲ | ▲ |
| 348d2.20 | 2.20 | 10.0 | 40 | ▲ | ▲ |
| 348d2.25 | 2.25 | 10.0 | 40 | ▲ | ▲ |
| 348d2.30 | 2.30 | 10.0 | 40 | ▲ | ▲ |
| 348d2.35 | 2.35 | 10.0 | 40 | ▲ | ▲ |
| 348d2.40 | 2.40 | 11.0 | 43 | ▲ | ▲ |
| 348d2.45 | 2.45 | 11.0 | 43 | ▲ | ▲ |
| 348d2.50 | 2.50 | 11.0 | 43 | ▲ | ▲ |
| 348d2.55 | 2.55 | 11.0 | 43 | ▲ | ▲ |
| 348d2.60 | 2.60 | 11.0 | 43 | ▲ | ▲ |
| 348d2.65 | 2.65 | 11.0 | 43 | ▲ | ▲ |
| 348d2.70 | 2.70 | 12.0 | 46 | ▲ | ▲ |
| 348d2.75 | 2.75 | 12.0 | 46 | ▲ | ▲ |
| 348d2.80 | 2.80 | 12.0 | 46 | ▲ | ▲ |
| 348d2.85 | 2.85 | 12.0 | 46 | ▲ | ▲ |
| 348d2.90 | 2.90 | 12.0 | 46 | ▲ | ▲ |
| 348d2.95 | 2.95 | 12.0 | 46 | ▲ | ▲ |
| 348d3.00 | 3.00 | 12.0 | 46 | ▲ | ▲ |
| 348d3.05 | 3.05 | 14.0 | 49 | ▲ | ▲ |
| 348d3.10 | 3.10 | 14.0 | 49 | ▲ | ▲ |
| 348d3.15 | 3.15 | 14.0 | 49 | ▲ | ▲ |
| 348d3.20 | 3.20 | 14.0 | 49 | ▲ | ▲ |
| 348d3.25 | 3.25 | 14.0 | 49 | ▲ | ▲ |

Erhältlich unbeschichtet und beschichtet (Siehe Seite 308)



* Preise für ander Beschichtungen: kontaktieren Sie uns!

Um ein beschichtetes Werkzeug zu bestellen, fügen Sie den 2-stelligen Beschichtungscode an die Artikelnummer an.



Spiralbohrer - Helix 24°



Erhältlich unbeschichtet und beschichtet
(Siehe Seite 308)



118°

Z2

λ
24°

CARB

| Art. n° | d ₁ | l ₁ | L | Beschichtung | |
|-----------|----------------|----------------|-----|--------------|-------|
| | | | | Unbesch. | Solo* |
| 348d3.30 | 3.30 | 14.0 | 49 | ▲ | ▲ |
| 348d3.35 | 3.35 | 14.0 | 49 | ▲ | ▲ |
| 348d3.40 | 3.40 | 15.0 | 52 | ▲ | ▲ |
| 348d3.45 | 3.45 | 15.0 | 52 | ▲ | ▲ |
| 348d3.50 | 3.50 | 15.0 | 52 | ▲ | ▲ |
| 348d3.55 | 3.55 | 15.0 | 52 | ▲ | ▲ |
| 348d3.60 | 3.60 | 15.0 | 52 | ▲ | ▲ |
| 348d3.65 | 3.65 | 15.0 | 52 | ▲ | ▲ |
| 348d3.70 | 3.70 | 15.0 | 52 | ▲ | ▲ |
| 348d3.75 | 3.75 | 15.0 | 52 | ▲ | ▲ |
| 348d3.80 | 3.80 | 17.0 | 55 | ▲ | ▲ |
| 348d3.85 | 3.85 | 17.0 | 55 | ▲ | ▲ |
| 348d3.90 | 3.90 | 17.0 | 55 | ▲ | ▲ |
| 348d3.95 | 3.95 | 17.0 | 55 | ▲ | ▲ |
| 348d4.00 | 4.00 | 17.0 | 55 | ▲ | ▲ |
| 348d4.05 | 4.05 | 17.0 | 55 | ▲ | ▲ |
| 348d4.10 | 4.10 | 17.0 | 55 | ▲ | ▲ |
| 348d4.15 | 4.15 | 17.0 | 55 | ▲ | ▲ |
| 348d4.20 | 4.20 | 17.0 | 55 | ▲ | ▲ |
| 348d4.25 | 4.25 | 17.0 | 55 | ▲ | ▲ |
| 348d4.30 | 4.30 | 18.0 | 58 | ▲ | ▲ |
| 348d4.35 | 4.35 | 18.0 | 58 | ▲ | ▲ |
| 348d4.40 | 4.40 | 18.0 | 58 | ▲ | ▲ |
| 348d4.45 | 4.45 | 18.0 | 58 | ▲ | ▲ |
| 348d4.50 | 4.50 | 18.0 | 58 | ▲ | ▲ |
| 348d4.55 | 4.55 | 18.0 | 58 | ▲ | ▲ |
| 348d4.60 | 4.60 | 18.0 | 58 | ▲ | ▲ |
| 348d4.65 | 4.65 | 18.0 | 58 | ▲ | ▲ |
| 348d4.70 | 4.70 | 18.0 | 58 | ▲ | ▲ |
| 348d4.75 | 4.75 | 18.0 | 58 | ▲ | ▲ |
| 348d4.80 | 4.80 | 20.0 | 62 | ▲ | ▲ |
| 348d4.85 | 4.85 | 20.0 | 62 | ▲ | ▲ |
| 348d4.90 | 4.90 | 20.0 | 62 | ▲ | ▲ |
| 348d4.95 | 4.95 | 20.0 | 62 | ▲ | ▲ |
| 348d5.00 | 5.00 | 20.0 | 62 | ▲ | ▲ |
| 348d5.10 | 5.10 | 20.0 | 62 | ▲ | ▲ |
| 348d5.20 | 5.20 | 20.0 | 62 | ▲ | ▲ |
| 348d5.30 | 5.30 | 20.0 | 62 | ▲ | ▲ |
| 348d5.40 | 5.40 | 21.0 | 66 | ▲ | ▲ |
| 348d5.50 | 5.50 | 21.0 | 66 | ▲ | ▲ |
| 348d5.60 | 5.60 | 21.0 | 66 | ▲ | ▲ |
| 348d5.70 | 5.70 | 21.0 | 66 | ▲ | ▲ |
| 348d5.80 | 5.80 | 21.0 | 66 | ▲ | ▲ |
| 348d5.90 | 5.90 | 21.0 | 66 | ▲ | ▲ |
| 348d6.00 | 6.00 | 21.0 | 66 | ▲ | ▲ |
| 348d6.10 | 6.10 | 23.0 | 70 | ▲ | ▲ |
| 348d6.20 | 6.20 | 23.0 | 70 | ▲ | ▲ |
| 348d6.30 | 6.30 | 23.0 | 70 | ▲ | ▲ |
| 348d6.40 | 6.40 | 23.0 | 70 | ▲ | ▲ |
| 348d6.50 | 6.50 | 23.0 | 70 | ▲ | ▲ |
| 348d6.60 | 6.60 | 23.0 | 70 | ▲ | ▲ |
| 348d6.70 | 6.70 | 23.0 | 70 | ▲ | ▲ |
| 348d6.80 | 6.80 | 25.0 | 74 | ▲ | ▲ |
| 348d6.90 | 6.90 | 25.0 | 74 | ▲ | ▲ |
| 348d7.00 | 7.00 | 25.0 | 74 | ▲ | ▲ |
| 348d7.10 | 7.10 | 25.0 | 74 | ▲ | ▲ |
| 348d7.20 | 7.20 | 25.0 | 74 | ▲ | ▲ |
| 348d7.30 | 7.30 | 25.0 | 74 | ▲ | ▲ |
| 348d7.40 | 7.40 | 25.0 | 74 | ▲ | ▲ |
| 348d7.50 | 7.50 | 25.0 | 74 | ▲ | ▲ |
| 348d7.60 | 7.60 | 27.0 | 79 | ▲ | ▲ |
| 348d7.70 | 7.70 | 27.0 | 79 | ▲ | ▲ |
| 348d7.80 | 7.80 | 27.0 | 79 | ▲ | ▲ |
| 348d7.90 | 7.90 | 27.0 | 79 | ▲ | ▲ |
| 348d8.00 | 8.00 | 27.0 | 79 | ▲ | ▲ |
| 348d8.10 | 8.10 | 27.0 | 79 | ▲ | ▲ |
| 348d8.20 | 8.20 | 27.0 | 79 | ▲ | ▲ |
| 348d8.30 | 8.30 | 27.0 | 79 | ▲ | ▲ |
| 348d8.40 | 8.40 | 27.0 | 79 | ▲ | ▲ |
| 348d8.50 | 8.50 | 27.0 | 79 | ▲ | ▲ |
| 348d8.80 | 8.80 | 29.0 | 84 | ▲ | ▲ |
| 348d9.00 | 9.00 | 29.0 | 84 | ▲ | ▲ |
| 348d9.20 | 9.20 | 29.0 | 84 | ▲ | ▲ |
| 348d9.50 | 9.50 | 29.0 | 84 | ▲ | ▲ |
| 348d9.80 | 9.80 | 31.0 | 89 | ▲ | ▲ |
| 348d10.00 | 10.00 | 31.0 | 89 | ▲ | ▲ |
| 348d10.20 | 10.20 | 31.0 | 89 | ▲ | ▲ |
| 348d10.50 | 10.50 | 31.0 | 89 | ▲ | ▲ |
| 348d11.00 | 11.00 | 33.0 | 95 | ▲ | ▲ |
| 348d11.50 | 11.50 | 33.0 | 95 | ▲ | ▲ |
| 348d12.00 | 12.00 | 35.0 | 102 | ▲ | ▲ |
| 348d12.50 | 12.50 | 35.0 | 102 | ▲ | ▲ |
| 348d13.00 | 13.00 | 35.0 | 102 | ▲ | ▲ |
| 348d13.50 | 13.50 | 37.0 | 107 | ▲ | ▲ |
| 348d14.00 | 14.00 | 37.0 | 107 | ▲ | ▲ |
| 348d16.00 | 16.00 | 38.0 | 115 | ▲ | ▲ |

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