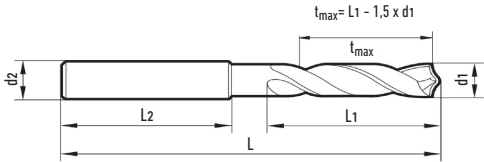


Tvrdokovový vrták 166500

bez vnitřního chlazení / 3xD

- úhel čela 140°
- tolerance průměru m7
- stopka válcová



P	M	K	N	S	H
●	○	●	○	○	○

Popis	Průměr (mm)	L (mm)	L1 (mm)	L2 (mm)	Stopka (mm)
V.03000413.B3	3,00	62,0	20,0	36,0	6,000
V.03100413.B3	3,10	62,0	20,0	36,0	6,000
V.03170413.B3	3,17	62,0	20,0	36,0	6,000
V.03200413.B3	3,20	62,0	20,0	36,0	6,000
V.03250413.B3	3,25	62,0	20,0	36,0	6,000
V.03300413.B3	3,30	62,0	20,0	36,0	6,000
V.03400413.B3	3,40	62,0	20,0	36,0	6,000
V.03500413.B3	3,50	62,0	20,0	36,0	6,000
V.03570413.B3	3,57	62,0	20,0	36,0	6,000
V.03600413.B3	3,60	62,0	20,0	36,0	6,000
V.03700413.B3	3,70	62,0	20,0	36,0	6,000
V.03800413.B3	3,80	66,0	24,0	36,0	6,000
V.03900413.B3	3,90	66,0	24,0	36,0	6,000
V.03970413.B3	3,97	66,0	24,0	36,0	6,000
V.04000413.B3	4,00	66,0	24,0	36,0	6,000
V.04100413.B3	4,10	66,0	24,0	36,0	6,000
V.04200413.B3	4,20	66,0	24,0	36,0	6,000
V.04300413.B3	4,30	66,0	24,0	36,0	6,000
V.04370413.B3	4,37	66,0	24,0	36,0	6,000
V.04400413.B3	4,40	66,0	24,0	36,0	6,000
V.04500413.B3	4,50	66,0	24,0	36,0	6,000
V.04600413.B3	4,60	66,0	24,0	36,0	6,000
V.04650413.B3	4,65	66,0	24,0	36,0	6,000
V.04700413.B3	4,70	66,0	24,0	36,0	6,000
V.04760413.B3	4,76	66,0	28,0	36,0	6,000
V.04800413.B3	4,80	66,0	28,0	36,0	6,000
V.04900413.B3	4,90	66,0	28,0	36,0	6,000
V.05000413.B3	5,00	66,0	28,0	36,0	6,000
V.05100413.B3	5,10	66,0	28,0	36,0	6,000
V.05160413.B3	5,16	66,0	28,0	36,0	6,000
V.05200413.B3	5,20	66,0	28,0	36,0	6,000
V.05300413.B3	5,30	66,0	28,0	36,0	6,000
V.05400413.B3	5,40	66,0	28,0	36,0	6,000
V.05500413.B3	5,50	66,0	28,0	36,0	6,000
V.05550413.B3	5,55	66,0	28,0	36,0	6,000
V.05560413.B3	5,56	66,0	28,0	36,0	6,000
V.05600413.B3	5,60	66,0	28,0	36,0	6,000
V.05700413.B3	5,70	66,0	28,0	36,0	6,000
V.05800413.B3	5,80	66,0	28,0	36,0	6,000
V.05900413.B3	5,90	66,0	28,0	36,0	6,000
V.05950413.B3	5,95	66,0	28,0	36,0	6,000
V.06000413.B3	6,00	66,0	28,0	36,0	6,000
V.06100413.B3	6,10	79,0	34,0	36,0	8,000
V.06200413.B3	6,20	79,0	34,0	36,0	8,000
V.06300413.B3	6,30	79,0	34,0	36,0	8,000
V.06350413.B3	6,35	79,0	34,0	36,0	8,000
V.06400413.B3	6,40	79,0	34,0	36,0	8,000
V.06500413.B3	6,50	79,0	34,0	36,0	8,000
V.06600413.B3	6,60	79,0	34,0	36,0	8,000
V.06700413.B3	6,70	79,0	34,0	36,0	8,000

Popis	Průměr (mm)	L (mm)	L1 (mm)	L2 (mm)	Stopka (mm)
V.06750413.B3	6,75	79,0	34,0	36,0	8,000
V.06800413.B3	6,80	79,0	34,0	36,0	8,000
V.06900413.B3	6,90	79,0	34,0	36,0	8,000
V.07000413.B3	7,00	79,0	34,0	36,0	8,000
V.07100413.B3	7,10	79,0	41,0	36,0	8,000
V.07140413.B3	7,14	79,0	41,0	36,0	8,000
V.07200413.B3	7,20	79,0	41,0	36,0	8,000
V.07300413.B3	7,30	79,0	41,0	36,0	8,000
V.07400413.B3	7,40	79,0	41,0	36,0	8,000
V.07500413.B3	7,50	79,0	41,0	36,0	8,000
V.07540413.B3	7,54	79,0	41,0	36,0	8,000
V.07600413.B3	7,60	79,0	41,0	36,0	8,000
V.07700413.B3	7,70	79,0	41,0	36,0	8,000
V.07800413.B3	7,80	79,0	41,0	36,0	8,000
V.07900413.B3	7,90	79,0	41,0	36,0	8,000
V.07940413.B3	7,940	79,0	41,0	36,0	8,000
V.08000413.B3	8,00	79,0	41,0	36,0	8,000
V.08100413.B3	8,10	89,0	47,0	40,0	10,000
V.08200413.B3	8,20	89,0	47,0	40,0	10,000
V.08300413.B3	8,30	89,0	47,0	40,0	10,000
V.08330413.B3	8,33	89,0	47,0	40,0	10,000
V.08400413.B3	8,40	89,0	47,0	40,0	10,000
V.08500413.B3	8,50	89,0	47,0	40,0	10,000
V.08600413.B3	8,60	89,0	47,0	40,0	10,000
V.08700413.B3	8,70	89,0	47,0	40,0	10,000
V.08730413.B3	8,73	89,0	47,0	40,0	10,000
V.08800413.B3	8,80	89,0	47,0	40,0	10,000
V.08900413.B3	8,90	89,0	47,0	40,0	10,000
V.09000413.B3	9,00	89,0	47,0	40,0	10,000
V.09100413.B3	9,10	89,0	47,0	40,0	10,000
V.09130413.B3	9,13	89,0	47,0	40,0	10,000
V.09200413.B3	9,20	89,0	47,0	40,0	10,000
V.09250413.B3	9,25	89,0	47,0	40,0	10,000
V.09300413.B3	9,30	89,0	47,0	40,0	10,000
V.09400413.B3	9,40	89,0	47,0	40,0	10,000
V.09500413.B3	9,50	89,0	47,0	40,0	10,000
V.09520413.B3	9,52	89,0	47,0	40,0	10,000
V.09600413.B3	9,60	89,0	47,0	40,0	10,000
V.09700413.B3	9,70	89,0	47,0	40,0	10,000
V.09800413.B3	9,80	89,0	47,0	40,0	10,000
V.09900413.B3	9,90	89,0	47,0	40,0	10,000
V.09920413.B3	9,92	89,0	47,0	40,0	10,000
V.10000413.B3	10,00	89,0	47,0	40,0	10,000
V.10100413.B3	10,10	102,0	55,0	45,0	12,000
V.10200413.B3	10,20	102,0	55,0	45,0	12,000
V.10300413.B3	10,30	102,0	55,0	45,0	12,000
V.10320413.B3	10,32	102,0	55,0	45,0	12,000
V.10400413.B3	10,40	102,0	55,0	45,0	12,000
V.10500413.B3	10,50	102,0	55,0	45,0	12,000
V.10600413.B3	10,60	102,0	55,0	45,0	12,000

Popis	Průměr (mm)	L (mm)	L1 (mm)	L2 (mm)	Stopka (mm)
V.10700413.B3	10,70	102,0	55,0	45,0	12,000
V.10800413.B3	10,80	102,0	55,0	45,0	12,000
V.10900413.B3	10,90	102,0	55,0	45,0	12,000
V.11000413.B3	11,00	102,0	55,0	45,0	12,000
V.11100413.B3	11,10	102,0	55,0	45,0	12,000
V.11110413.B3	11,11	102,0	55,0	45,0	12,000
V.11200413.B3	11,20	102,0	55,0	45,0	12,000
V.11300413.B3	11,30	102,0	55,0	45,0	12,000
V.11400413.B3	11,40	102,0	55,0	45,0	12,000
V.11500413.B3	11,50	102,0	55,0	45,0	12,000
V.11600413.B3	11,60	102,0	55,0	45,0	12,000
V.11700413.B3	11,70	102,0	55,0	45,0	12,000
V.11800413.B3	11,80	102,0	55,0	45,0	12,000
V.11900413.B3	11,90	102,0	55,0	45,0	12,000
V.11910413.B3	11,91	102,0	55,0	45,0	12,000
V.12000413.B3	12,00	102,0	55,0	45,0	12,000
V.12100413.B3	12,10	107,0	60,0	45,0	14,000
V.12200413.B3	12,20	107,0	60,0	45,0	14,000
V.12300413.B3	12,30	107,0	60,0	45,0	14,000
V.12400413.B3	12,40	107,0	60,0	45,0	14,000
V.12500413.B3	12,50	107,0	60,0	45,0	14,000
V.12700413.B3	12,70	107,0	60,0	45,0	14,000
V.12800413.B3	12,80	107,0	60,0	45,0	14,000
V.13000413.B3	13,00	107,0	60,0	45,0	14,000
V.13100413.B3	13,10	107,0	60,0	45,0	14,000
V.13500413.B3	13,50	107,0	60,0	45,0	14,000
V.13700413.B3	13,70	107,0	60,0	45,0	14,000
V.13800413.B3	13,80	107,0	60,0	45,0	14,000
V.14000413.B3	14,00	107,0	60,0	45,0	14,000
V.14100413.B3	14,10	115,0	65,0	48,0	16,000
V.14200413.B3	14,20	115,0	65,0	48,0	16,000
V.14290413.B3	14,29	115,0	65,0	48,0	16,000
V.14500413.B3	14,50	115,0	65,0	48,0	16,000
V.14700413.B3	14,70	115,0	65,0	48,0	16,000
V.15000413.B3	15,00	115,0	65,0	48,0	16,000
V.15100413.B3	15,10	115,0	65,0	48,0	16,000
V.15200413.B3	15,20	115,0	65,0	48,0	16,000
V.15500413.B3	15,50	115,0	65,0	48,0	16,000
V.15700413.B3	15,70	115,0	65,0	48,0	16,000
V.15800413.B3	15,80	115,0	65,0	48,0	16,000
V.16000413.B3	16,00	115,0	65,0	48,0	16,000
V.16500413.B3	16,50	123,0	73,0	48,0	18,000
V.17000413.B3	17,00	123,0	73,0	48,0	18,000
V.17500413.B3	17,50	123,0	73,0	48,0	18,000
V.18000413.B3	18,00	123,0	73,0	48,0	18,000
V.18500413.B3	18,50	131,0	79,0	50,0	20,000
V.19000413.B3	19,00	131,0	79,0	50,0	20,000
V.19500413.B3	19,50	131,0	79,0	50,0	20,000
V.20000413.B3	20,00	131,0	79,0	50,0	20,000

Tvrdokovový vrták 166500

bez vnitřního chlazení / 3xD



Řezné podmínky

	Typ materiálu	Pevnost v tahu (N/mm ²) Tvrdost	v _c (m/min.)	Posuv (mm/ot.)		
				3,0 - 7,9	8,0 - 15,9	16,0 - 20,0
P	Konstrukční ocel	≤500	130	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
		≤1000	110	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400
	Automatová ocel	≤850	145	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630
		≤1000	110	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
	Nelegovaná kalená ocel	≤700	120	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
		≤850	110	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
		≤1000	105	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
	Legovaná kalená ocel	≤1000	105	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
		≤1400	100	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400
	Nelegovaná cementovaná ocel	≤850	130	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630
	Legovaná cementovaná ocel	≤1000	120	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
		≤1400	85	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315
	Nitridovaná ocel	≤1000	100	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400
		≤1400	90	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315
	Nástrojová ocel	≤850	65	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400
		≤1400	55	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315
M	Nerezová ocel	≤900	40	0,063 - 0,080 - 0,100	0,125 - 0,160	0,200 - 0,250
	austenititická	≤1100	15	0,063 - 0,080 - 0,100	0,125 - 0,160	0,200 - 0,250
	Martenzitická	≤1500	35	0,050 - 0,063 - 0,080	0,100 - 0,125	0,160 - 0,200
H	Kalená ocel	≤48 HRC	40	0,050 - 0,063 - 0,080	0,100 - 0,125	0,160 - 0,200
		≤66 HRC	20	0,040 - 0,050 - 0,063	0,080 - 0,100	0,125 - 0,160
K	Litina	≤240 HB	210	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630
		≤350 HB	155	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630
	Temperovaná litina	≤240 HB	155	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
		≤350 HB	125	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
	Tvrzená litina	≤350 HB	35	0,050 - 0,063 - 0,080	0,100 - 0,125	0,160 - 0,200
S	Titan a slitiny Titanu	≤850	15	0,063 - 0,080 - 0,100	0,125 - 0,160	0,200 - 0,250
		≤1400	15	0,050 - 0,063 - 0,080	0,100 - 0,125	0,160 - 0,200
N	Hliník a slitiny hliníku	≤400	260	0,160 - 0,200 - 0,315	0,315 - 0,500	0,500 - 0,630
	Kovaný hliník	≤650	260	0,160 - 0,200 - 0,315	0,315 - 0,500	0,500 - 0,630
	Slitiny hliníku ≤ 10 % Si	≤600	220	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630
		> 10 % Si	180	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630
	Hořčík a slitiny hořčíku	≤400	260	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630
	Měď	≤500	105	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
		≤600	270	0,160 - 0,200 - 0,250	0,315 - 0,400	0,500 - 0,630
	Mosaz	≤600	180	0,125 - 0,160 - 0,200	0,250 - 0,315	0,400 - 0,500
		≤600	105	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400
	Bronz	≤850	85	0,100 - 0,125 - 0,160	0,200 - 0,250	0,315 - 0,400
		≤850	80	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315
	Bronz	≤1000	60	0,080 - 0,100 - 0,125	0,160 - 0,200	0,250 - 0,315