

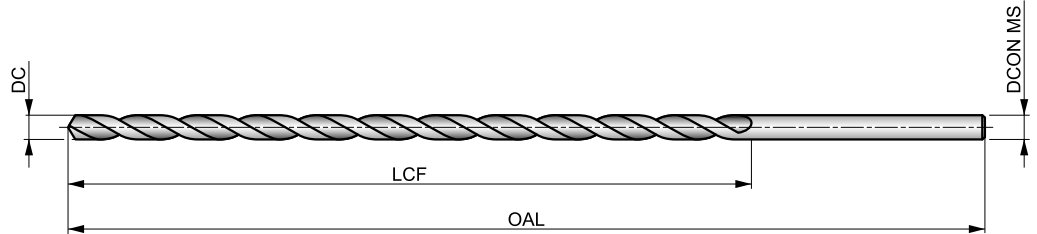


A125



Wiertło HSS, bardzo długie, odpuszczane parowo

Wiertło odpuszczane parowo, zalecane do bardzo głębokich lub trudno dostępnych otworów. Proste ostrze 118° zapewnia wytrzymałość i pozwala zredukować koszty dzięki łatwemu przeostrzeniu. Przeznaczone do różnorodnych materiałów. Powierzchnia wiertła odpuszczana parowo zatrzymuje płyn chłodzący i zapobiega przywieraniu wiórów podczas pracy narzędzia. Nie jest rekomendowane do wiercenia ręcznego.



HSS	BS 328	10×D
118°	ST	
λ 20-35°	R	DC h8

Zalecane grupy materiałowe, początkowe wartości dla prędkości skrawania (m/min) i posuwu (kod literowy). Tabele z posuwem na obrót można znaleźć począwszy od strony 175.

P1.1 ■ 21 E	P1.2 ■ 24 E	P1.3 ■ 25 E	P2.1 ■ 18 E	P2.2 ■ 16 C	P2.3 ■ 14 A	P3.1 ■ 9 C	P3.2 ■ 7 C	P3.3 ■ 6 A	P4.1 ■ 5 C	P4.2 ■ 4 A	P4.3 ■ 4 A	M1.1 ■ 12 C	M1.2 ■ 10 C
M2.1 ■ 11 C	M2.2 ■ 9 C	M3.1 ■ 5 E	M3.2 ■ 4 E	M3.3 ■ 4 E	M4.1 ■ 8 A	K1.1 ■ 22 G	K1.2 ■ 16 D	K1.3 ■ 12 D	K2.1 ■ 16 C	K2.2 ■ 13 C	K2.3 ■ 10 C	K3.1 ■ 14 C	K3.2 ■ 11 C
K3.3 ■ 9 C	K4.1 ■ 13 C	K4.2 ■ 10 C	K4.3 ■ 7 C	K4.4 ■ 6 C	K4.5 ■ 5 C	K5.1 ■ 15 C	K5.2 ■ 11 C	K5.3 ■ 9 C	N1.1 ■ 24 H	N1.2 ■ 18 H	N1.3 ■ 12 G	N2.1 ■ 34 F	N2.2 ■ 30 F
N2.3 ■ 22 F	N3.1 ■ 56 F	N3.2 ■ 33 G	N3.3 ■ 17 D	N4.1 ■ 30 H	N4.2 ■ 26 F	N4.3 ■ 10 D	S1.1 ■ 11 D	S1.2 ■ 9 B	S1.3 ■ 5 A	S2.1 ■ 5 C	S2.2 ■ 4 A	S3.1 ■ 4 C	S3.2 ■ 3 A
S4.1 ■ 3 C	S4.2 ■ 2 A												

DC <= 2,2mm; 5/64" wykończenie jasne

Produkt	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1251.4X160	-	1.40	0.0551	100.0	160.0	1.40
A1251.5X125	-	1.50	0.0591	80.0	125.0	1.50
A1251.5X160	-	1.50	0.0591	100.0	160.0	1.50
A1251/16X125	1/16	1.59	0.0625	80.0	125.0	1.59
A1251/16X160	1/16	1.59	0.0625	100.0	160.0	1.59
A1251.8X160	-	1.80	0.0709	100.0	160.0	1.80
A1255/64X125	5/64	1.98	0.0781	80.0	125.0	1.98
A1255/64X160	5/64	1.98	0.0781	100.0	160.0	1.98
A1252.0X125	-	2.00	0.0787	80.0	125.0	2.00
A1252.0X160	-	2.00	0.0787	100.0	160.0	2.00
A1252.2X160	-	2.20	0.0866	100.0	160.0	2.20
A1253/32X125	3/32	2.38	0.0938	80.0	125.0	2.38
A1253/32X160	3/32	2.38	0.0938	100.0	160.0	2.38
A1252.5X125	-	2.50	0.0984	80.0	125.0	2.50
A1252.5X160	-	2.50	0.0984	100.0	160.0	2.50
A1257/64X125	7/64	2.78	0.1094	80.0	125.0	2.78
A1257/64X160	7/64	2.78	0.1094	100.0	160.0	2.78
A1253.0X160	-	3.00	0.1181	100.0	160.0	3.00
A1253.0X200	-	3.00	0.1181	150.0	200.0	3.00
A1253.0X250	-	3.00	0.1181	200.0	250.0	3.00
A1251/8X160	1/8	3.18	0.1252	100.0	160.0	3.18
A1251/8X200	1/8	3.18	0.1252	150.0	200.0	3.18
A1251/8X250	1/8	3.18	0.1252	200.0	250.0	3.18
A1251/8X315	1/8	3.18	0.1252	250.0	310.0	3.18
A1253.3X160	-	3.30	0.1299	100.0	160.0	3.30
A1253.5X160	-	3.50	0.1378	100.0	160.0	3.50

Produkt	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1253.5X200	-	3.50	0.1378	150.0	200.0	3.50
A1253.5X250	-	3.50	0.1378	200.0	250.0	3.50
A1259/64X160	9/64	3.57	0.1406	100.0	160.0	3.57
A1259/64X200	9/64	3.57	0.1406	150.0	200.0	3.57
A1259/64X315	9/64	3.57	0.1406	250.0	310.0	3.57
A1255/32X160	5/32	3.97	0.1563	100.0	160.0	3.97
A1255/32X200	5/32	3.97	0.1563	150.0	200.0	3.97
A1255/32X250	5/32	3.97	0.1563	200.0	250.0	3.97
A1255/32X315	5/32	3.97	0.1563	250.0	310.0	3.97
A1254.0X160	-	4.00	0.1575	100.0	160.0	4.00
A1254.0X200	-	4.00	0.1575	150.0	200.0	4.00
A1254.0X250	-	4.00	0.1575	200.0	250.0	4.00
A1254.0X315	-	4.00	0.1575	250.0	310.0	4.00
A12511/64X160	11/64	4.37	0.1719	100.0	160.0	4.37
A12511/64X200	11/64	4.37	0.1719	150.0	200.0	4.37
A12511/64X315	11/64	4.37	0.1719	250.0	310.0	4.37
A1254.5X160	-	4.50	0.1772	100.0	160.0	4.50
A1254.5X200	-	4.50	0.1772	150.0	200.0	4.50
A1254.5X250	-	4.50	0.1772	200.0	250.0	4.50
A1254.5X315	-	4.50	0.1772	250.0	310.0	4.50
A1253/16X160	3/16	4.76	0.1875	100.0	160.0	4.76
A1253/16X200	3/16	4.76	0.1875	150.0	200.0	4.76
A1253/16X250	3/16	4.76	0.1875	200.0	250.0	4.76
A1253/16X315	3/16	4.76	0.1875	250.0	310.0	4.76
A1253/16X400	3/16	4.76	0.1875	300.0	400.0	4.76
A1255.0X160	-	5.00	0.1969	100.0	160.0	5.00



Produkt	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1255.0X200	–	5.00	0.1969	150.0	200.0	5.00
A1255.0X250	–	5.00	0.1969	200.0	250.0	5.00
A1255.0X315	–	5.00	0.1969	250.0	310.0	5.00
A1255.0X400	–	5.00	0.1969	300.0	400.0	5.00
A12513/64X200	13/64	5.16	0.2031	150.0	200.0	5.16
A12513/64X250	13/64	5.16	0.2031	200.0	250.0	5.16
A12513/64X315	13/64	5.16	0.2031	250.0	310.0	5.16
A1255.5X200	–	5.50	0.2165	150.0	200.0	5.50
A1255.5X250	–	5.50	0.2165	200.0	250.0	5.50
A1255.5X315	–	5.50	0.2165	250.0	310.0	5.50
A1257/32X200	7/32	5.56	0.2188	150.0	200.0	5.56
A1257/32X250	7/32	5.56	0.2188	200.0	250.0	5.56
A1257/32X315	7/32	5.56	0.2188	250.0	310.0	5.56
A12515/64X200	15/64	5.95	0.2344	150.0	200.0	5.95
A12515/64X250	15/64	5.95	0.2344	200.0	250.0	5.95
A12515/64X315	15/64	5.95	0.2344	250.0	310.0	5.95
A1256.0X200	–	6.00	0.2362	150.0	200.0	6.00
A1256.0X250	–	6.00	0.2362	200.0	250.0	6.00
A1256.0X315	–	6.00	0.2362	250.0	310.0	6.00
A1256.0X400	–	6.00	0.2362	300.0	400.0	6.00
A1251/4X200	1/4	6.35	0.2500	150.0	200.0	6.35
A1251/4X250	1/4	6.35	0.2500	200.0	250.0	6.35
A1251/4X315	1/4	6.35	0.2500	250.0	310.0	6.35
A1251/4X400	1/4	6.35	0.2500	300.0	400.0	6.35
A1251/4X500	1/4	6.35	0.2500	400.0	460.0	6.35
A1256.5X200	–	6.50	0.2559	150.0	200.0	6.50
A1256.5X250	–	6.50	0.2559	200.0	250.0	6.50
A1256.5X315	–	6.50	0.2559	250.0	310.0	6.50
A12517/64X200	17/64	6.75	0.2656	150.0	200.0	6.75
A12517/64X250	17/64	6.75	0.2656	200.0	250.0	6.75
A12517/64X315	17/64	6.75	0.2656	250.0	310.0	6.75
A12517/64X500	17/64	6.75	0.2656	400.0	460.0	6.75
A1257.0X200	–	7.00	0.2756	150.0	200.0	7.00
A1257.0X250	–	7.00	0.2756	200.0	250.0	7.00
A1257.0X315	–	7.00	0.2756	250.0	310.0	7.00
A1259/32X200	9/32	7.14	0.2813	150.0	200.0	7.14
A1259/32X250	9/32	7.14	0.2813	200.0	250.0	7.14
A1259/32X315	9/32	7.14	0.2813	250.0	310.0	7.14
A1259/32X500	9/32	7.14	0.2813	400.0	460.0	7.14
A1257.5X200	–	7.50	0.2953	150.0	200.0	7.50
A1257.5X250	–	7.50	0.2953	200.0	250.0	7.50
A1257.5X315	–	7.50	0.2953	250.0	310.0	7.50
A12519/64X315	19/64	7.54	0.2969	250.0	310.0	7.54
A12519/64X500	19/64	7.54	0.2969	400.0	460.0	7.54
A1255/16X200	5/16	7.94	0.3125	150.0	200.0	7.94
A1255/16X250	5/16	7.94	0.3125	200.0	250.0	7.94
A1255/16X315	5/16	7.94	0.3125	250.0	310.0	7.94
A1255/16X400	5/16	7.94	0.3125	300.0	400.0	7.94
A1255/16X500	5/16	7.94	0.3125	400.0	460.0	7.94
A1258.0X250	–	8.00	0.3150	200.0	250.0	8.00
A1258.0X315	–	8.00	0.3150	250.0	310.0	8.00
A1258.0X400	–	8.00	0.3150	300.0	400.0	8.00
A12521/64X315	21/64	8.33	0.3281	250.0	310.0	8.33
A12521/64X500	21/64	8.33	0.3281	400.0	460.0	8.33
A1258.5X250	–	8.50	0.3346	200.0	250.0	8.50
A1258.5X315	–	8.50	0.3346	250.0	310.0	8.50
A12511/32X250	11/32	8.73	0.3438	200.0	250.0	8.73
A12511/32X315	11/32	8.73	0.3438	250.0	310.0	8.73
A12511/32X400	11/32	8.73	0.3438	300.0	400.0	8.73
A12511/32X500	11/32	8.73	0.3438	400.0	460.0	8.73
A1259.0X250	–	9.00	0.3543	200.0	250.0	9.00
A1259.0X315	–	9.00	0.3543	250.0	310.0	9.00
A1259.0X400	–	9.00	0.3543	300.0	400.0	9.00
A12523/64X315	23/64	9.13	0.3594	250.0	310.0	9.13
A12523/64X500	23/64	9.13	0.3594	400.0	460.0	9.13
A1259.5X250	–	9.50	0.3740	200.0	250.0	9.50
A1259.5X315	–	9.50	0.3740	250.0	310.0	9.50
A1253/8X250	3/8	9.52	0.3750	200.0	250.0	9.52
A1253/8X315	3/8	9.52	0.3750	250.0	310.0	9.52
A1253/8X400	3/8	9.52	0.3750	300.0	400.0	9.52

Produkt	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1253/8X500	3/8	9.52	0.3750	400.0	460.0	9.52
A12525/64X315	25/64	9.92	0.3906	250.0	310.0	9.92
A12525/64X500	25/64	9.92	0.3906	400.0	460.0	9.92
A12510.0X250	–	10.00	0.3937	200.0	250.0	10.00
A12510.0X315	–	10.00	0.3937	250.0	310.0	10.00
A12510.0X400	–	10.00	0.3937	300.0	400.0	10.00
A12513/32X250	13/32	10.32	0.4063	200.0	250.0	10.32
A12513/32X315	13/32	10.32	0.4063	250.0	310.0	10.32
A12513/32X500	13/32	10.32	0.4063	400.0	460.0	10.32
A12510.5X250	–	10.50	0.4134	200.0	250.0	10.50
A12510.5X315	–	10.50	0.4134	250.0	310.0	10.50
A12510.5X400	–	10.50	0.4134	300.0	400.0	10.50
A12527/64X315	27/64	10.72	0.4219	250.0	310.0	10.72
A12511.0X250	–	11.00	0.4331	200.0	250.0	11.00
A12511.0X315	–	11.00	0.4331	250.0	310.0	11.00
A12511.0X400	–	11.00	0.4331	300.0	400.0	11.00
A1257/16X250	7/16	11.11	0.4375	200.0	250.0	11.11
A1257/16X315	7/16	11.11	0.4375	250.0	310.0	11.11
A1257/16X400	7/16	11.11	0.4375	300.0	400.0	11.11
A1257/16X500	7/16	11.11	0.4375	400.0	460.0	11.11
A12529/64X315	29/64	11.51	0.4531	250.0	310.0	11.51
A12529/64X500	29/64	11.51	0.4531	400.0	460.0	11.51
A12515/32X250	15/32	11.91	0.4688	200.0	250.0	11.91
A12515/32X315	15/32	11.91	0.4688	250.0	310.0	11.91
A12515/32X500	15/32	11.91	0.4688	400.0	460.0	11.91
A12512.0X250	–	12.00	0.4724	200.0	250.0	12.00
A12512.0X315	–	12.00	0.4724	250.0	310.0	12.00
A12512.0X400	–	12.00	0.4724	300.0	400.0	12.00
A12531/64X315	31/64	12.30	0.4844	250.0	310.0	12.30
A12531/64X500	31/64	12.30	0.4844	400.0	460.0	12.30
A1251/2X250	1/2	12.70	0.5000	200.0	250.0	12.70
A1251/2X315	1/2	12.70	0.5000	250.0	310.0	12.70
A1251/2X400	1/2	12.70	0.5000	300.0	400.0	12.70
A1251/2X500	1/2	12.70	0.5000	400.0	460.0	12.70
A12513.0X315	–	13.00	0.5118	250.0	310.0	13.00
A12513.0X400	–	13.00	0.5118	300.0	400.0	13.00
A12533/64X315	33/64	13.10	0.5156	250.0	310.0	13.10
A12533/64X500	33/64	13.10	0.5156	400.0	460.0	13.10
A12517/32X315	17/32	13.49	0.5313	250.0	310.0	13.49
A12517/32X500	17/32	13.49	0.5313	400.0	460.0	13.49
A12535/64X315	35/64	13.89	0.5469	250.0	310.0	13.89
A12535/64X500	35/64	13.89	0.5469	400.0	460.0	13.89
A12514.0X315	–	14.00	0.5512	250.0	310.0	14.00
A12514.0X400	–	14.00	0.5512	300.0	400.0	14.00
A1259/16X315	9/16	14.29	0.5625	250.0	310.0	14.29
A1259/16X500	9/16	14.29	0.5625	400.0	460.0	14.29
A12537/64X315	37/64	14.68	0.5781	250.0	310.0	14.68
A12519/32X315	19/32	15.08	0.5938	250.0	310.0	15.08
A12519/32X500	19/32	15.08	0.5938	400.0	460.0	15.08
A12539/64X315	39/64	15.48	0.6094	250.0	310.0	15.48
A12539/64X500	39/64	15.48	0.6094	400.0	460.0	15.48
A1255/8X315	5/8	15.88	0.6250	250.0	310.0	15.88
A1255/8X500	5/8	15.88	0.6250	400.0	460.0	15.88
A12521/32X315	21/32	16.67	0.6563	250.0	310.0	16.67
A12521/32X500	21/32	16.67	0.6563	400.0	460.0	16.67
A12511/16X315	11/16	17.46	0.6875	250.0	310.0	17.46
A12511/16X500	11/16	17.46	0.6875	400.0	460.0	17.46
A12523/32X315	23/32	18.26	0.7188	250.0	310.0	18.26
A12523/32X500	23/32	18.26	0.7188	400.0	460.0	18.26
A1253/4X315	3/4	19.05	0.7500	250.0	310.0	19.05
A1253/4X500	3/4	19.05	0.7500	400.0	460.0	19.05
A12525/32X500	25/32	19.84	0.7813	400.0	460.0	19.84
A12513/16X500	13/16	20.64	0.8125	400.0	460.0	20.64
A1257/8X500	7/8	22.22	0.8750	400.0	460.0	22.22
A12515/16X500	15/16	23.81	0.9375	400.0	460.0	23.81
A1251X500	1"	25.40	1.0000	400.0	460.0	25.40