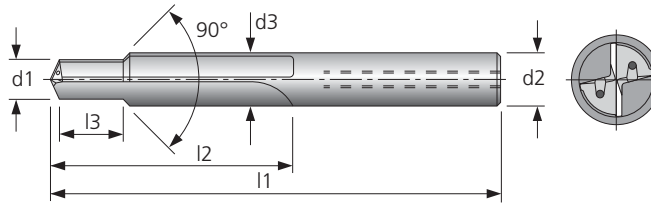


HAM 296 Multidrill

Vollhartmetall-Stufenbohrer
solid carbide step drill

VHM Z 2 0° Nut Werk Norm
 Typ Werk 140° DIN 6535 HAK
 HPC SHRINK FIT
 DIN 6535 HBK DIN 6535 HEK



Material	Alu	Alu > 9% Si	Stahl < 800 N/mm²	Stahl < 1200 N/mm²	Stahl < 1600 N/mm²	Stahl < 55 HRC	Stahl < 60 HRC	Stahl < 66 HRC	INOX < 800 N/mm²	INOX > 800 N/mm²	GG	GGG	hochw. Legierungen	Titan	NE Metalle Cu-Leg.	Graphit Faser-verbund	MMS	max.	ohne	AIR
30-2120	●	●									●	○		●	●		●	●		

● sehr gut geeignet/very suitable ○ geeignet/suitable

Werkstoffgruppe Material group	ø	M4 - M5	M6 - M8	M10-M12	M14-M16	M18-M20
Alu	V _c [m/min]	300	300	300	300	300
	f [mm/U]	0,100	0,150	0,200	0,300	0,350
	v _f [mm/min]	2270	1940	1880	2040	1860
	n [1/min]	22700	12900	9400	6800	5300
Alu > 9% Si	V _c [m/min]	250	250	250	250	250
	f [mm/U]	0,100	0,150	0,200	0,300	0,350
	v _f [mm/min]	1890	1620	1560	1710	1540
	n [1/min]	18900	10800	7800	5700	4400
GG	V _c [m/min]	100	100	100	100	100
	f [mm/U]	0,080	0,100	0,200	0,250	0,300
	v _f [mm/min]	610	430	620	580	540
	n [1/min]	7600	4300	3100	2300	1800
GGG	V _c [m/min]	70	70	70	70	70
	f [mm/U]	0,060	0,100	0,150	0,200	0,250
	v _f [mm/min]	320	300	330	320	300
	n [1/min]	5300	3000	2200	1600	1200
NE-Metalle Cu-Leg.	V _c [m/min]	130	130	130	130	130
	f [mm/U]	0,100	0,150	0,200	0,300	0,350
	v _f [mm/min]	990	840	820	900	810
	n [1/min]	9900	5600	4100	3000	2300