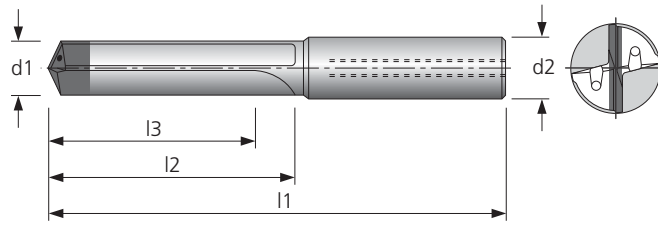


HAM 3297 Diamant-Vollhartmetall-Multidrill
diamond solid carbide multidrill

3 x D

PKD Z 2 0° Nut Werk Norm
3 x D Typ Werk 140° DIN 6535 HAK
SHRINK FIT



Material	Alu	Alu > 9% Si	Stahl < 800 N/mm ²	Stahl < 1200 N/mm ²	Stahl < 1600 N/mm ²	Stahl < 55 HRC	Stahl < 60 HRC	Stahl < 66 HRC	INOX < 800 N/mm ²	INOX > 800 N/mm ²	GG	GGG	hochw. Legierungen	Titan	NE Metalle Cu-Leg.	Graphit Faserverbund	MMS	max.	ohne	AIR
33-1240	●	●													●	●	●	●		

● sehr gut geeignet/very suitable ○ geeignet/suitable

Werkstoffgruppe Material group	Ø	4	6	8	10	12
Alu	V _C [m/min]	600	600	600	600	600
	f [mm/U]	0,100	0,180	0,250	0,300	0,400
	v _f [mm/min]	4770	5720	5980	5730	6360
	n [1/min]	47700	31800	23900	19100	15900
Alu > 9% Si	V _C [m/min]	400	400	400	400	400
	f [mm/U]	0,120	0,200	0,250	0,250	0,300
	v _f [mm/min]	3820	4240	3980	3180	3180
	n [1/min]	31800	21200	15900	12700	10600
NE-Metalle Cu-Leg.	V _C [m/min]	200	200	200	200	200
	f [mm/U]	0,150	0,250	0,300	0,400	0,500
	v _f [mm/min]	2390	2650	2400	2560	2650
	n [1/min]	15900	10600	8000	6400	5300
Graphit Faserverbund	V _C [m/min]	100	100	100	100	100
	f [mm/U]	0,040	0,060	0,080	0,100	0,120
	v _f [mm/min]	320	320	320	320	320
	n [1/min]	8000	5300	4000	3200	2700