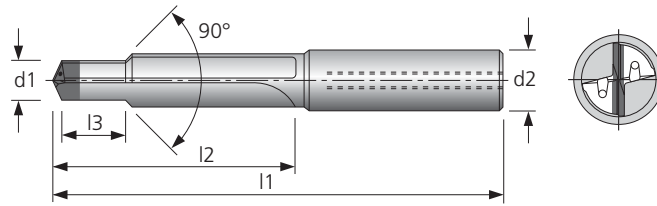


HAM 3296 Diamant-Vollhartmetall-Multi-Step-Drill
diamond solid carbide multi step drill

PKD Z 2 0° Nut Werk Norm
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
33-1320	●	●													●	●	●	●		

● sehr gut geeignet/very suitable ○ geeignet/suitable

Werkstoffgruppe Material group	ø	M5-M6-M8	M10-M14
Alu	V _c [m/min]	600	600
	f [mm/U]	0,100	0,150
	v _f [mm/min]	2580	2810
	n [1/min]	25800	18700
Alu > 9% Si	V _c [m/min]	400	400
	f [mm/U]	0,120	0,120
	v _f [mm/min]	2060	1500
	n [1/min]	17200	12500
NE-Metalle Cu-Leg.	V _c [m/min]	200	200
	f [mm/U]	0,150	0,200
	v _f [mm/min]	1290	1240
	n [1/min]	8600	6200
Graphit Faserverbund	V _c [m/min]	100	100
	f [mm/U]	0,080	0,150
	v _f [mm/min]	340	470
	n [1/min]	4300	3100