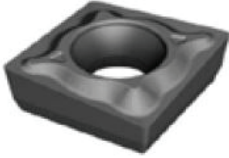
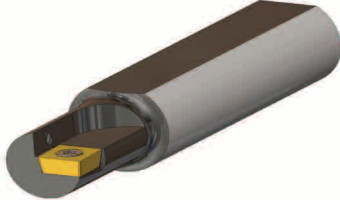
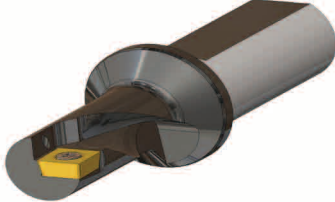
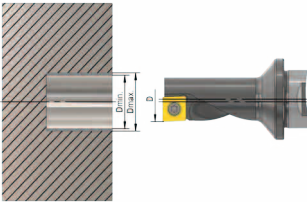




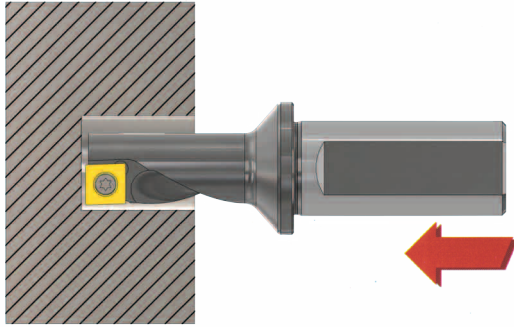
HD-TURN DRILL G2

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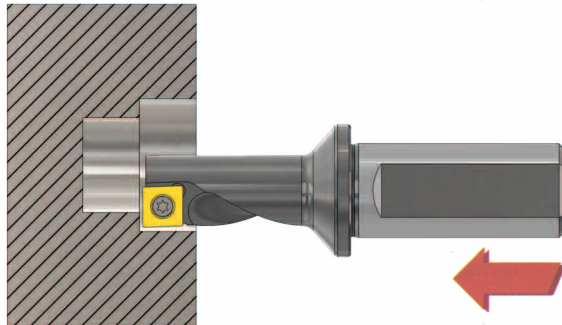
Contents HD-Turn Drill G2

Bezeichnung Designation	Darstellung Figure	Seite Page
XPNT XPET-ALU		5
6080MC..1,5 xD		7
6080MC..2,25xD		7
Zubehör Spare Parts		8
Schnittdaten Cutting Data		9-12
Bohren außer der Mitte Off-centre drilling		13

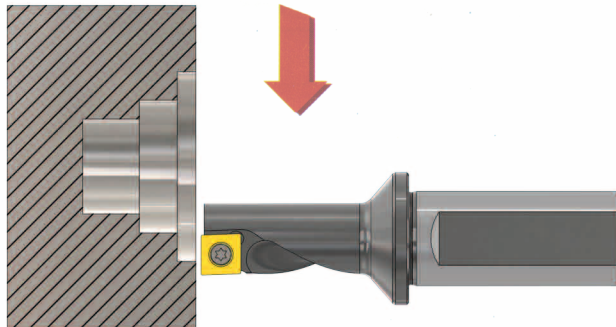
4 Maschinen Operationen - Nur ein Werkzeug
4 machining operations - only one tools



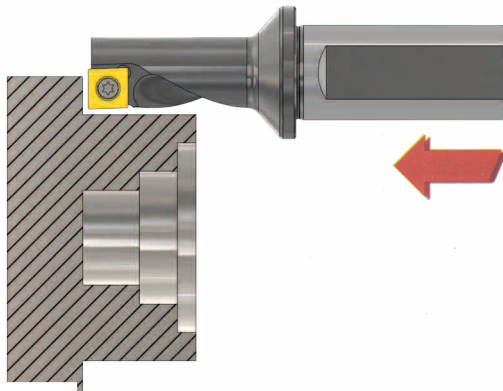
BOHREN INS VOLLE
DRILL FROM SOLID



DREHEN VON
INNENKONTUREN
INTERNAL CONTOURING



DREHEN VON
PLANKONTUREN
FACING OR TURNING

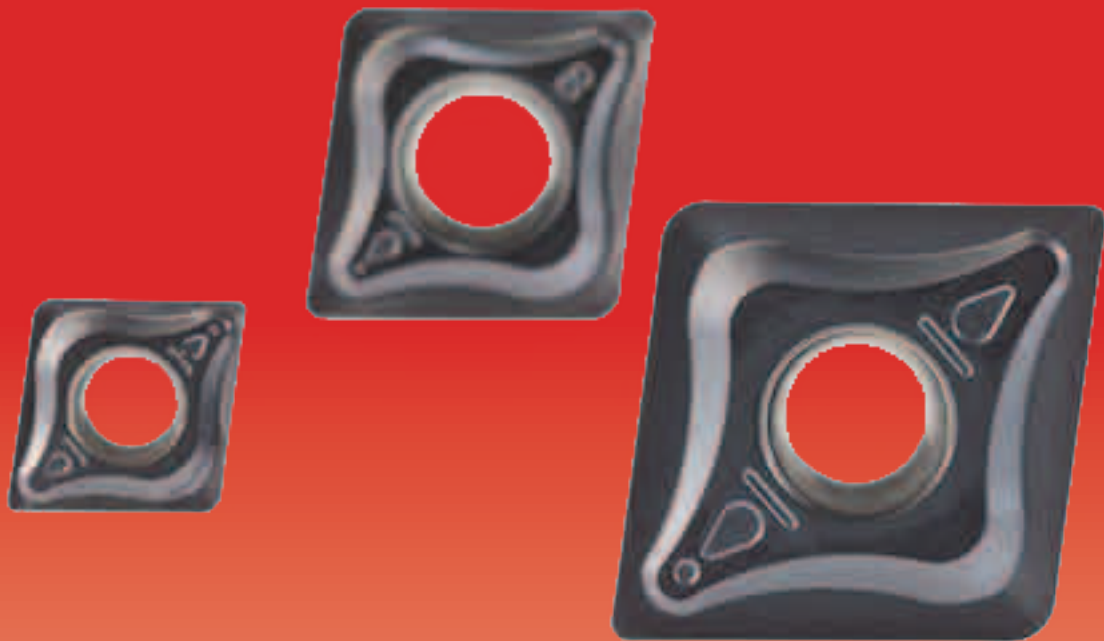


DREHEN VON
AUSSENKONTUREN
EXTERNAL CONTOURING



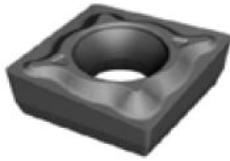
Wendeplatten HD-Turn Drill G2

Insert HD-Turn Drill G2

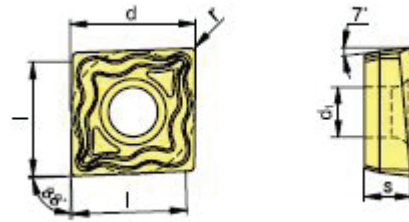


Wendeplatten HD-Turn Drill G2

Insert HD-Turn Drill G2



XPNT-Stahl
XPET-ALU



Bezeichnung Designation	Abmessungen Dimensions					Unbeschichtet Sorten uncoated grades				Beschichtet Sorten coated grades				
	l	d	s	d1	r		K10			PTT20	PTT35	PAP28	MTM10	KTE20
XPNT 040204 EL	4	4,5	1,8	2,1	0,4					■	■	■	■	
XPNT 040204 ER	4	4,5	1,8	2,1	0,4					■	■	■	■	
XPNT 050204 EN	5	5,8	2,1	2,25	0,4					■	■	■	■	
XPNT 060204 EN	6	6,5	2,92	2,5	0,4					■	■	■	■	
XPNT 070304 EN	7	7,6	3,87	2,8	0,4					■	■	■	■	
XPNT 080304 EN	8	8,5	3,87	3,4	0,4					■	■	■	■	
XPNT 090404 EN	9	9,6	4,66	3,4	0,4					■	■	■	■	
XPNT 100404 EN	10	10,6	4,66	4,4	0,4					■	■	■	■	
XPNT 100408 EN	10	10,6	4,66	4,4	0,8					■	■	■	■	
XPNT 130504 EN	12,5	13,5	5,45	5,3	0,4					■	■	■	■	
XPNT 130508 EN	12,5	13,5	5,45	5,3	0,8					■	■	■	■	
XPNT 170608 EN	16	17,5	6,25	5,3	0,8					■	■	■	■	

Bezeichnung Designation	Abmessungen Dimensions					Unbeschichtet Sorten uncoated grades				Beschichtet Sorten coated grades				
	l	d	s	d1	r		K10			PTT20	PTT35	PAP28	MTM10	KTE20
XPET 040204 FL ALU	4	4,5	1,8	2,1	0,4		■							■
XPET 040204 FR ALU	4	4,5	1,8	2,1	0,4		■							■
XPET 050204 FN ALU	5	5,8	2,1	2,25	0,4		■							■
XPET 060204 FN ALU	6	6,5	2,92	2,5	0,4		■							■
XPET 070304 FN ALU	7	7,6	3,87	2,8	0,4		■							■
XPET 080304 FN ALU	8	8,5	3,87	3,4	0,4		■							■
XPET 090404 FN ALU	9	9,6	4,66	3,4	0,4		■							■
XPET 100404 FN ALU	10	10,6	4,66	4,4	0,4		■							■
XPET 100408 FN ALU	10	10,6	4,66	4,4	0,8		■							■
XPET 130504 FN ALU	12,5	13,5	5,45	5,3	0,4		■							■
XPET 130508 FN ALU	12,5	13,5	5,45	5,3	0,8		■							■
XPET 170608 FN ALU	16	17,5	6,25	5,3	0,8		■							■

■ auf Anfrage

Serie 6080MC.. HD-Turn Drill G2



Serie 6080MC.. HD-Turn Drill G2

Ausführung:

- Bohrstange aus speziellem Werkzeugstahl zum Bohren und Innen- / Aussendrehen
- geschliffener Schaft
- Innenkühlung

Execution:

- boring bars made of special tool-steel for drilling and turning
- grinded shaft
- inner coolant

Fig. A

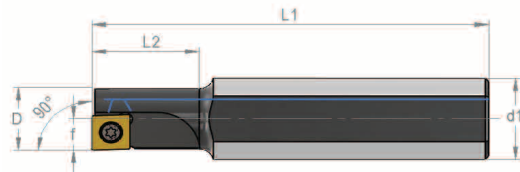


Fig. B

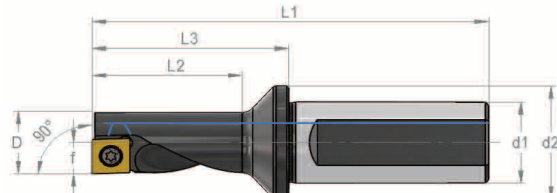


Abb. rechte Ausführung

Fig. A: 1,50 x D

Fig. B: 2,25 x D

Bestell-Nr.: Order Code:	Abmessungen / Dimension (mm)								Wendeplatte Insert	Schraube Screw	Schlüssel Key
	D	d1	d2	L1	L2	L3	f	Fig.			
6080MC 08L-1.50D 04	8	12		80	12		4	A	XPNT 0402..EL XPET 0402..FL	M-VTD18	M-BT06
6080MC 08L-2.25D 04	8	10	15	60	18	22	4	B			
6080MC 08R-1.50D 04	8	12		80	12		4	A	XPNT 0402..ER XPET 0402..FR	M-VTD18	M-BT06
6080MC 08R-2.25D 04	8	10	15	60	18	22	4	B			
6080MC 10R/L-1.50D 05	10	12		90	15		5	A	XPNT 0502.. XPET 0502..	M-VTD20	M-BT06
6080MC 10R/L-2.25D 05	10	12	18	69,5	22,5	27,5	5	B			
6080MC 12R/L-1.50D 06	12	16		100	18		6	A	XPNT 0602.. XPET 0602..	M-VTD22	M-BT07
6080MC 12R/L-2.25D 06	12	16	22	78	27	33	6	B			
6080MC 14R/L-1.50D 07	14	16		110	21		7	A	XPNT 0703.. XPET 0703..	M-VTD25	M-BT 08
6080MC 14R/L-2.25D 07	14	16	23	83,5	31,5	38,5	7	B			
6080MC 16R/L-1.50D 08	16	20		125	24		8	A	XPNT 0803.. XPET 0803..	M-VTD30	M-BT 09
6080MC 16R/L-2.25D 08	16	20	28	94	36	44	8	B			
6080MC 18R/L-1.50D 09	18	25		135	27		9	A	XPNT 0904.. XPET 0904..	M-VTD30	M-BT 09
6080MC 18R/L-2.25D 09	18	25	36		40,5	53,5	9	B			
6080MC 20R/L-1.50D 10	20	25		150	30		10	A	XPNT 1004.. XPET 1004..	M-VTD35	M-BT 15
6080MC 20R/L-2.25D 10	20	25	35	111	45	55	10	B			
6080MC 25R/L-1.50D 13	25	32		180	37,5			A	XPNT 1304.. XPET 1304..	M-VTD45	M-BT 20
6080MC 25R/L-2.25D 13	25	32	44	129	56,5	69		B			
6080MC 32R/L-1.50D 17	32	40		200	48		16	A	XPNT 1706.. XPET 1706..	M-VTD45	M-BT 20
6080MC 32R/L-2.25D 17	32	40	54	158	72	88	16	B			

Bestellbeispiel / Orderexample: 6080MC 08 R-2.25D 04

Zubehör HD-Turn Drill G2

Spare parts HD-Turn Drill G2

Bezeichnung Designation 	Gewinde Thread size	Schlüsselgröße Key size 
M-VTD18	M1,8x3,6	M-BT06
M-VTD20	M2,0x4,3	M-BT06
M-VTD22	M2,2x5,0	M-BT07
M-VTD25	M2,5x6,0	M-BT08
M-VTD30	M3,0x7,0	M-BT09
M-VTD35	M3,5x8,6	M-BT15
M-VTD45	M4,5x10,5	M-BT20

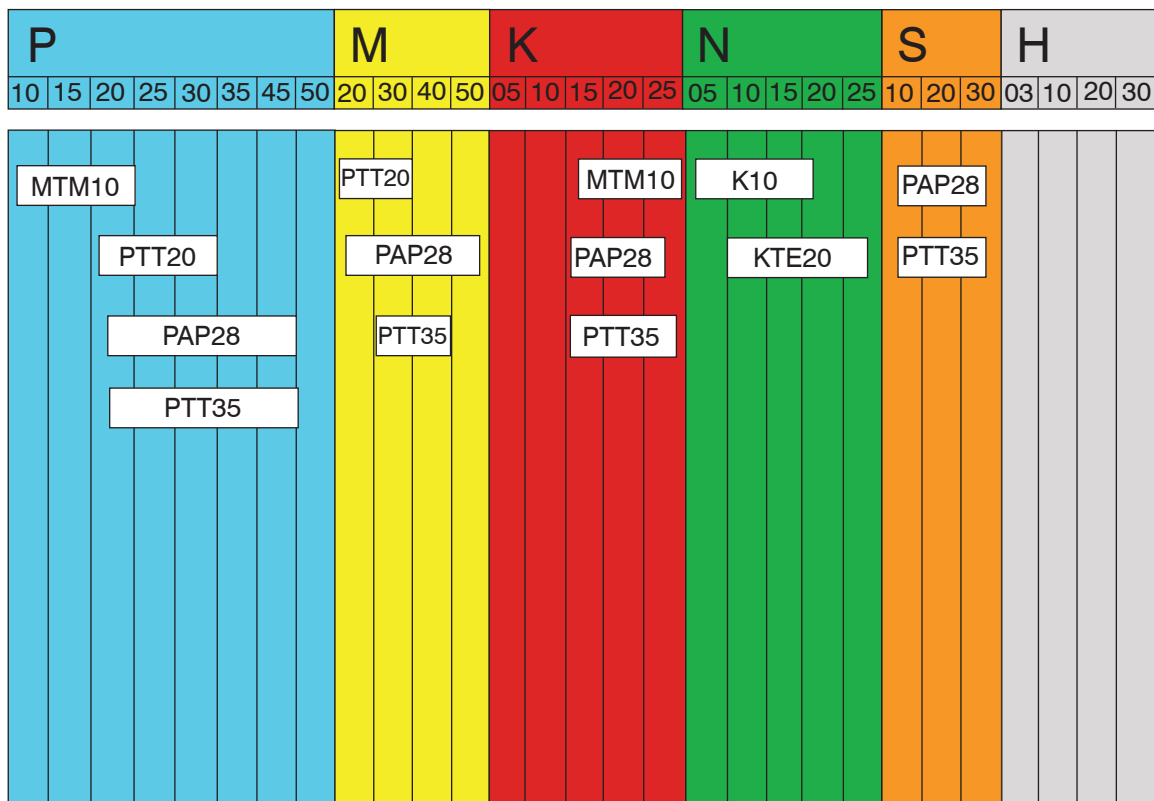
Schnittdaten HD-Turn Drill G2

Cutting Data HD-Turn Drill G2

Vc (m/min)	Alu Kunststoff	Alu	Alu Guss	Stahl < 500 N	Stahl < 750 N	Stahl < 900 N	Stahl < 1100 N	Stahl < 1400 N	Stahl < 55 HRC	Stahl < 60 HRC	Stahl < 65 HRC	Stahl < 67 HRC	Stahl < 70 HRC	INOX < 900 N	INOX > 900 N	GG(G)	TITAN	Graphit GFK CFK	Emulsion	MMS				
ISO-Code	N	N	N	P	P	P	P	P	H	H	H	H	H	M	M	K	S	N						
PTT20				270-90	270-90	270-70	170-60									250-120			■	□				
PTT35				250-70	250-70	180-60	160-50							180-90		230-90	110-30		■	□				
PAP28				230-50	230-50	160-50	150-50							160-50		180-90	90-30		■	□				
MTM10				270-90	270-90	270-70	170-60									250-120			■	□				
KTE20	180-50	1800-70	1350-70																■	□				
K10	180-50	1800-70	1350-70																■	□				
																			■ geeignet	□ bedingt geeignet				

HM-Qualitäten HM-Grades

← Schnittgeschwindigkeit - Verschleissfestigkeit / cutting speed - wear resistance
Vorschub - Zähigkeit / advance-toughness →

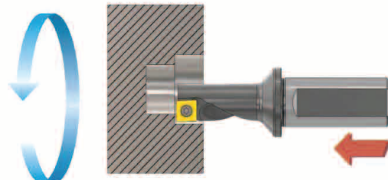


- P** MTM10, PTT20, PAP28, PTT35
- M** PTT20, PAP28, PTT35
- K** GG: MTM10
GGG: PAP28, PTT35
- N** K10, KTE20
- S** PAP28, PTT35

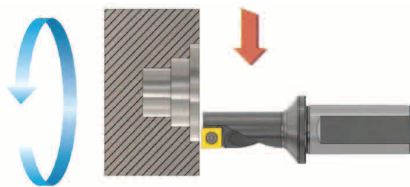
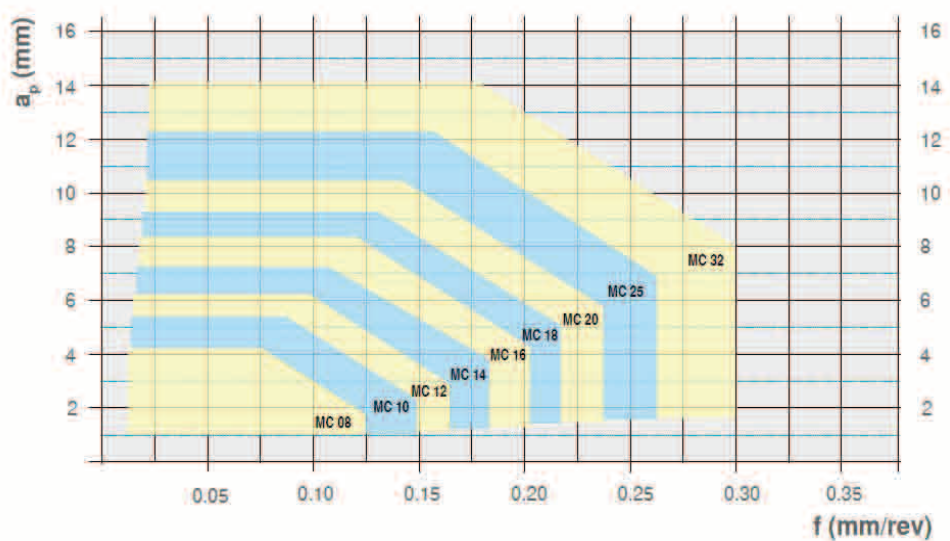
Schnittdaten HD-Turn Drill G2

Cutting Data HD-Turn Drill G2

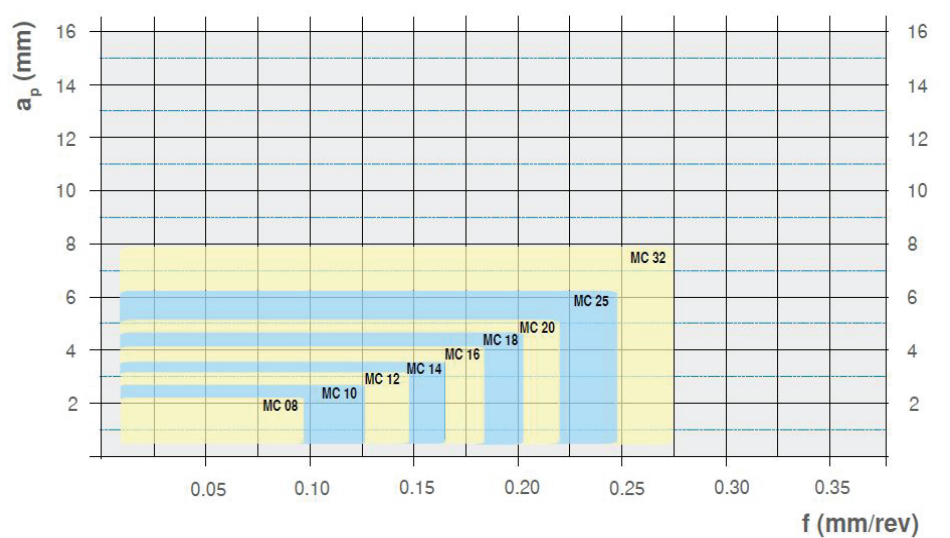
Schnitttiefe / Vorschub - 1,50xD
Depth of cut / feed rate - 1,50xD



Drehen von Innenkonturen
Turning of internal profiles



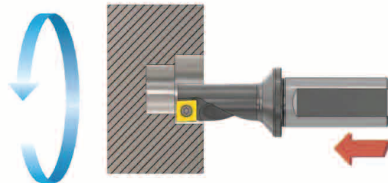
Plandrehen
Facing operations



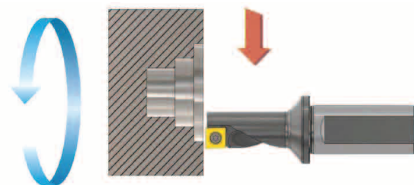
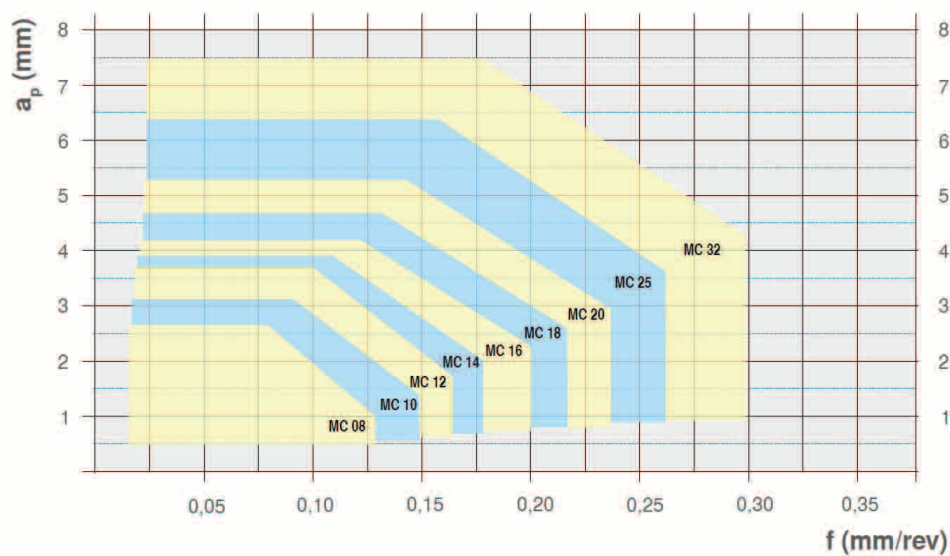
Schnittdaten HD-Turn Drill G2

Cutting Data HD-Turn Drill G2

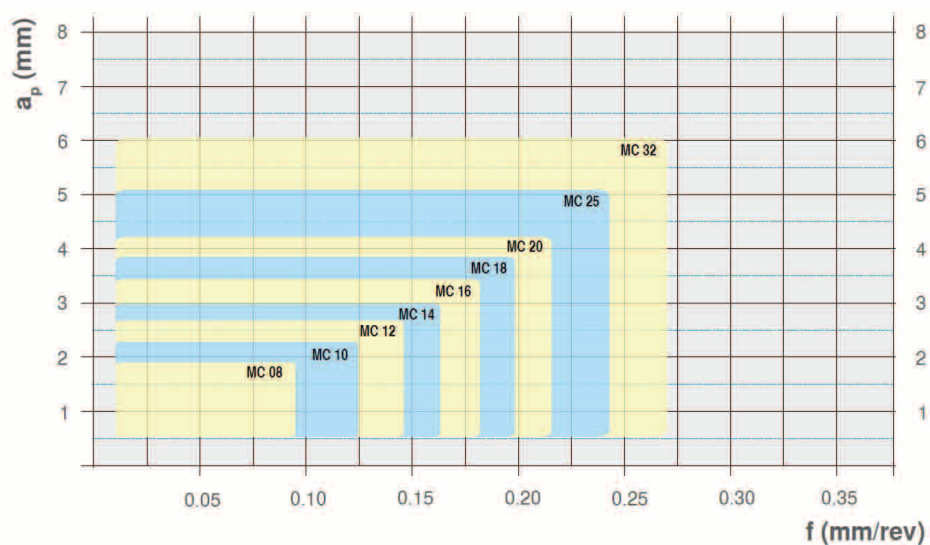
Schnitttiefe / Vorschub - 2,25xD
Depth of cut / feed rate - 2,25xD



Drehen von Innenkonturen
Turning of internal profiles



Plandrehen
Facing operations



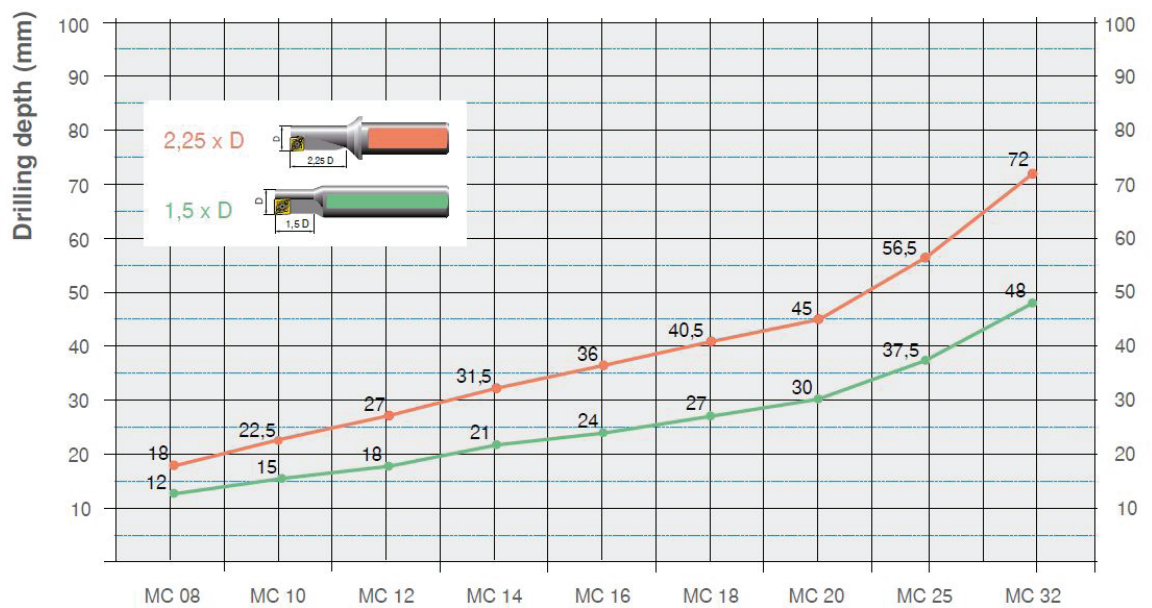
Schnittdaten HD-Turn Drill G2

Cutting Data HD-Turn Drill G2

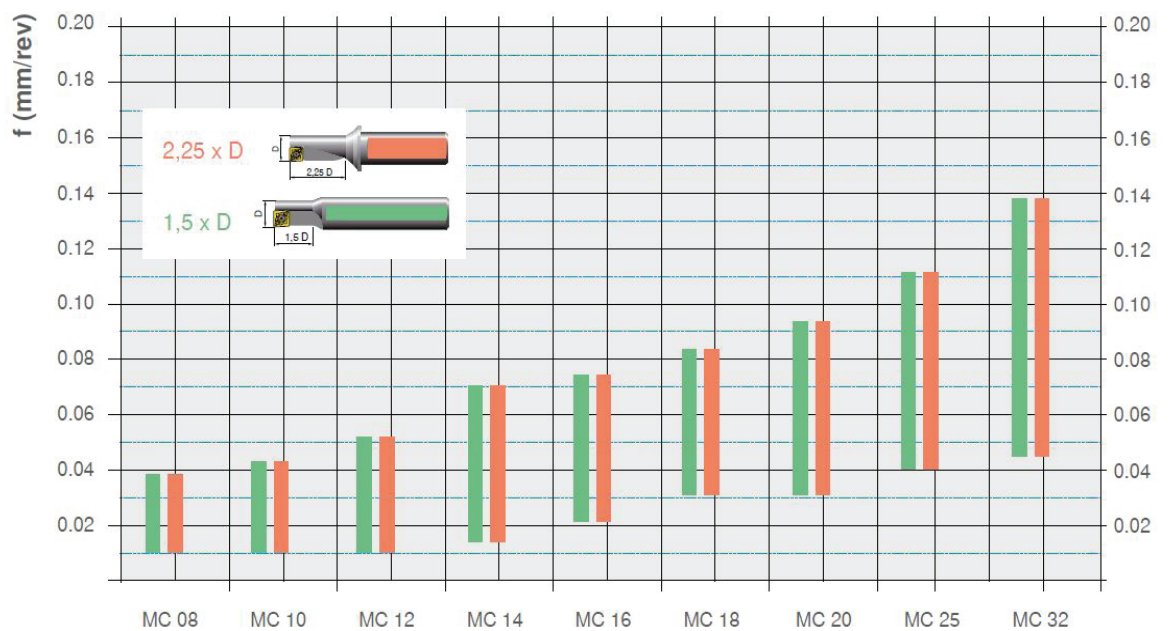
Bohrtiefe / Vorschub

Drilling depth / feed rate

Bohrtiefe
Drilling depth



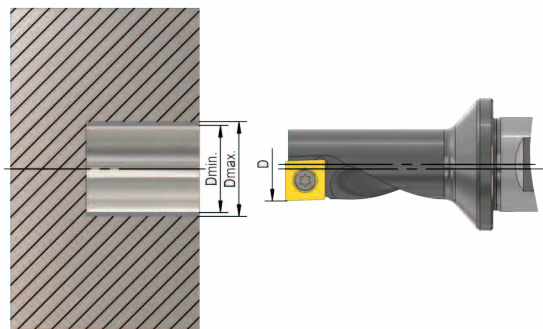
Bohrvorschub
Drilling feed rate



Bohren außer der Mitte HD-Turn Drill G2

Off-centre drilling HD-Turn Drill G2

Werkzeug typ Type of tool	D	Werkstück Bohrdurchmesser	
		Dmin (mm)	Dmax (mm)
6080MC 08R/L.... 04	8	7,85	8,30
6080MC 10R/L.... 05	10	9,85	10,50
6080MC 12R/L.... 06	12	11,85	12,50
6080MC 14R/L.... 07	14	13,85	14,50
6080MC 16R/L.... 08	16	15,85	16,50
6080MC 18R/L.... 09	18	17,85	18,50
6080MC 20R/L.... 10	20	19,80	20,50
6080MC 25R/L.... 13	25	24,80	25,80
6080MC 32R/L.... 17	32	31,80	33,00



Dank dem Speziellen Werkzeug design und der Form der Wendeplatte ist außermittiges Bohren möglich.

Thanks to the special design of the holder and the indexable inserts off centre drilling is possible.

