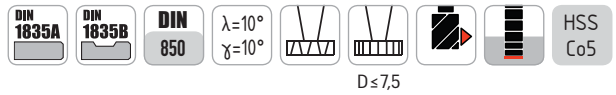


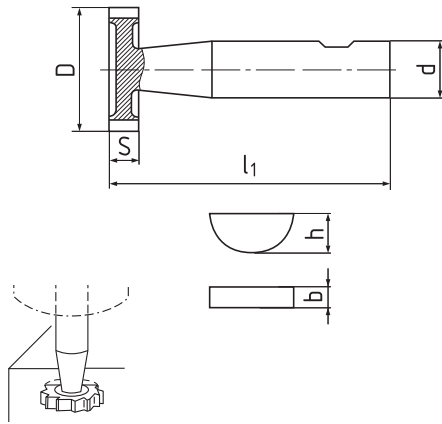
# Woodruff keyseat cutters



**CZ** Frézy pro drážky úsečových per

**DE** Schlitzfräser für Woodruffnuten

**RU** Фрезы для пазов сегментных шпонок



**3200**



**3200**



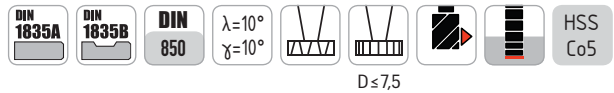
| D<br>h 12 | d<br>h 6 | S<br>e 8 | l1 | Z  | b   | h   | 320005  | 320015  |
|-----------|----------|----------|----|----|-----|-----|---------|---------|
| 4,5       | 6        | 1        | 50 | 6  | 1   | 1,4 | .045010 | .045010 |
| 7,5       | 6        | 1,5      | 50 | 6  | 1,5 | 2,6 | .075015 | .075015 |
| 7,5       | 6        | 2        | 50 | 6  | 2   | 2,6 | .075020 | .075020 |
| 10,5      | 6        | 2        | 50 | 6  | 2   | 3,7 | .105020 | .105020 |
| 10,5      | 6        | 2,5      | 50 | 6  | 2,5 | 3,7 | .105025 | .105025 |
| 10,5      | 6        | 3        | 50 | 6  | 3   | 3,7 | .105030 | .105030 |
| 13,5*     | 10       | 2        | 56 | 6  |     |     | .135020 | .135020 |
| 13,5      | 10       | 3        | 56 | 6  | 3   | 5   | .135030 | .135030 |
| 13,5      | 10       | 4        | 56 | 6  | 4   | 5   | .135040 | .135040 |
| 16,5      | 10       | 3        | 56 | 6  | 3   | 6,5 | .165030 | .165030 |
| 16,5      | 10       | 4        | 56 | 6  | 4   | 6,5 | .165040 | .165040 |
| 16,5      | 10       | 5        | 56 | 6  | 5   | 6,5 | .165050 | .165050 |
| 19,5*     | 10       | 3        | 63 | 8  |     |     | .195030 | .195030 |
| 19,5      | 10       | 4        | 63 | 8  | 4   | 7,5 | .195040 | .195040 |
| 19,5      | 10       | 5        | 63 | 8  | 5   | 7,5 | .195050 | .195050 |
| 19,5      | 10       | 6        | 63 | 8  | 6   | 7,5 | .195060 | .195060 |
| 22,5*     | 10       | 4        | 63 | 8  |     |     | .225040 | .225040 |
| 22,5      | 10       | 5        | 63 | 8  | 5   | 9   | .225050 | .225050 |
| 22,5      | 10       | 6        | 63 | 8  | 6   | 9   | .225060 | .225060 |
| 22,5      | 10       | 8        | 63 | 8  | 8   | 9   | .225080 | .225080 |
| 25,5*     | 10       | 5        | 63 | 10 |     |     | .255050 | .255050 |
| 25,5      | 10       | 6        | 63 | 10 | 6   | 10  | .255060 | .255060 |
| 25,5*     | 10       | 8        | 63 | 8  | 8   | 10  | .255080 | .255080 |

\*) ≠ DIN 850, ≠ DIN 6888

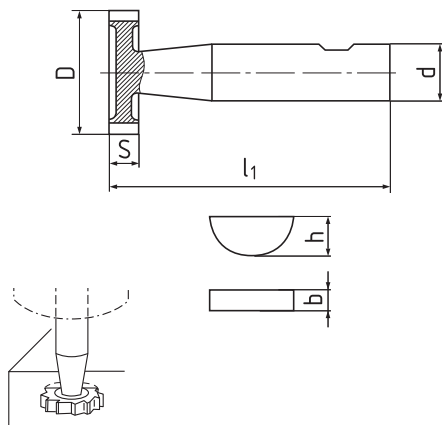
## Cutting conditions | Řežné podmínky | Schnittbedingungen | Условия резания

| Material                            | A <sub>p</sub> | A <sub>e</sub> | V <sub>c</sub> | f <sub>z</sub> (mm/z) |       |        |        |        |        |
|-------------------------------------|----------------|----------------|----------------|-----------------------|-------|--------|--------|--------|--------|
|                                     |                |                |                | Ø 4,5                 | Ø 7,5 | Ø 10,5 | Ø 13,5 | Ø 16,5 | Ø 19,5 |
| <b>P.1</b> ≤ 600 N/mm <sup>2</sup>  | 1xS            | t1(DIN 6888)   | 33             | 0,006                 | 0,008 | 0,01   | 0,015  | 0,025  | 0,035  |
| <b>P.2</b> ≤ 850 N/mm <sup>2</sup>  | 1xS            | t1(DIN 6888)   | 28             | 0,006                 | 0,008 | 0,01   | 0,015  | 0,025  | 0,035  |
| <b>P.3</b> ≤ 1100 N/mm <sup>2</sup> | 1xS            | t1(DIN 6888)   | 22             | 0,006                 | 0,008 | 0,01   | 0,015  | 0,025  | 0,035  |
| <b>N.2</b> ≤ 600 N/mm <sup>2</sup>  | 1xS            | t1(DIN 6888)   | 45             | 0,008                 | 0,01  | 0,013  | 0,02   | 0,033  | 0,046  |
| <b>S.2</b> ≤ 1250 N/mm <sup>2</sup> | 1xS            | t1(DIN 6888)   | 11             | 0,004                 | 0,006 | 0,007  | 0,011  | 0,018  | 0,025  |

# Woodruff keyseat cutters



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- DE** Schlitzfräser für Woodruffnuten
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**3200**

**3200**



| D<br>h 12 | d<br>h 6 | S<br>e 8 | l1 | Z  | b  | h  | 320005  | 320015  |
|-----------|----------|----------|----|----|----|----|---------|---------|
| 28,5      | 10       | 6        | 63 | 10 | 6  | 11 | .285060 | .285060 |
| 28,5      | 10       | 8        | 63 | 10 | 8  | 11 | .285080 | .285080 |
| 28,5      | 12       | 10       | 71 | 10 | 10 | 11 | .285100 | .285100 |
| 32,5*     | 12       | 6        | 71 | 10 |    |    | .325060 | .325060 |
| 32,5      | 12       | 7        | 71 | 10 |    |    |         | .325070 |
| 32,5      | 12       | 8        | 71 | 10 | 8  | 13 | .325080 | .325080 |
| 32,5      | 12       | 10       | 71 | 10 | 10 | 13 | .325100 | .325100 |
| 38,5*     | 12       | 8        | 71 | 10 |    |    | .385080 | .385080 |
| 45,5*     | 12       | 8        | 71 | 12 |    |    | .455080 | .455080 |
| 45,5      | 12       | 10       | 71 | 12 | 10 | 16 | .455100 | .455100 |

\*) \* DIN 850, \* DIN 6888

## Cutting conditions | Řežné podmínky | Schnittbedingungen | Условия резания

| Material                            | A <sub>p</sub> | A <sub>e</sub> | V <sub>c</sub> | f <sub>z</sub> (mm/z) |        |        |        |        |        |
|-------------------------------------|----------------|----------------|----------------|-----------------------|--------|--------|--------|--------|--------|
|                                     |                |                |                | Ø 19,5                | Ø 22,5 | Ø 25,5 | Ø 28,5 | Ø 32,5 | Ø 45,5 |
| <b>P.1</b> ≤ 600 N/mm <sup>2</sup>  | 1xS            | t1(DIN 6888)   | 33             | 0,035                 | 0,04   | 0,045  | 0,05   | 0,06   | 0,07   |
| <b>P.2</b> ≤ 850 N/mm <sup>2</sup>  | 1xS            | t1(DIN 6888)   | 28             | 0,035                 | 0,04   | 0,045  | 0,05   | 0,06   | 0,07   |
| <b>P.3</b> ≤ 1100 N/mm <sup>2</sup> | 1xS            | t1(DIN 6888)   | 22             | 0,035                 | 0,04   | 0,045  | 0,05   | 0,06   | 0,07   |
| <b>N.2</b> ≤ 600 N/mm <sup>2</sup>  | 1xS            | t1(DIN 6888)   | 45             | 0,046                 | 0,052  | 0,059  | 0,065  | 0,078  | 0,091  |
| <b>S.2</b> ≤ 1250 N/mm <sup>2</sup> | 1xS            | t1(DIN 6888)   | 11             | 0,025                 | 0,028  | 0,032  | 0,035  | 0,042  | 0,049  |

HSS/SC