

Woodruff keyseat cutters

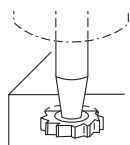
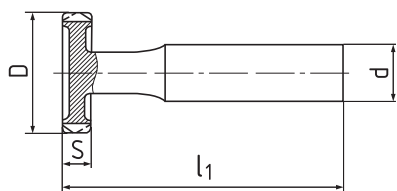


S ≤ 3

CZ Frézy pro drážky úsečových per

DE Schlitzfräser für Woodruffnuten

RU Фрезы для пазов сегментных шпонок



3201



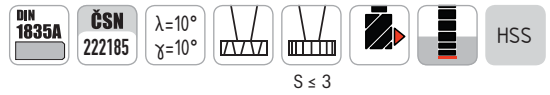
| D h 11 | d h 8 | S e 8 | l1 | Z | Dj* | 320100 |
|-----------|----------|----------|----|---|-----|---------|
| 7,5 | 6 | 1,5 | 48 | 8 | 7 | .070015 |
| 7,5 | 6 | 2 | 48 | 8 | 7 | .070020 |
| 10,8 | 8 | 1 | 45 | 8 | 10 | .100010 |
| 10,8 | 8 | 1,6 | 45 | 8 | 10 | .100016 |
| 10,8 | 8 | 2,5 | 45 | 8 | 10 | .100025 |
| 10,8 | 8 | 3 | 45 | 8 | 10 | .100030 |
| 14 | 8 | 3 | 45 | 8 | 13 | .130030 |
| 14 | 10 | 4 | 50 | 8 | 13 | .130040 |
| 17,2 | 10 | 1,6 | 50 | 8 | 16 | .160016 |
| 17,2 | 10 | 2 | 50 | 8 | 16 | .160020 |
| 17,2 | 10 | 3 | 50 | 8 | 16 | .160030 |
| 17,2 | 10 | 4 | 50 | 8 | 16 | .160040 |
| 17,2 | 12 | 5 | 60 | 8 | 16 | .160050 |
| 20,5 | 10 | 4 | 50 | 8 | 19 | .190040 |
| 20,5 | 12 | 5 | 60 | 8 | 19 | .190050 |
| 23,7 | 12 | 5 | 60 | 8 | 22 | .220050 |
| 23,7 | 12 | 6 | 60 | 8 | 22 | .220060 |

*) ČSN 30 1385

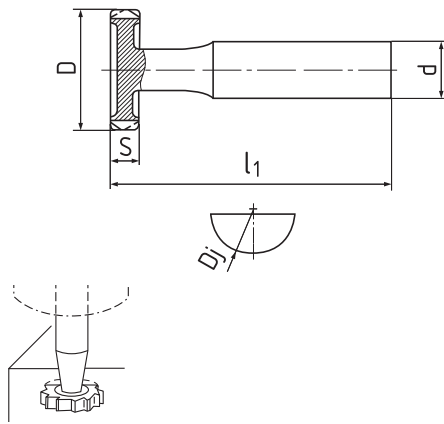
Cutting conditions | Řezné podmínky | Schnittbedingungen | Условия резания

| Material | A _p | A _e | V _c | f _z (mm/z) | | | | | |
|-------------------------------------|----------------|----------------|----------------|-----------------------|--------|-------|--------|--------|--------|
| | | | | Ø 7,5 | Ø 10,8 | Ø 14 | Ø 17,2 | Ø 20,5 | Ø 23,7 |
| P.1 ≤ 600 N/mm ² | 1xS | t1(DIN 6888) | 33 | 0,008 | 0,011 | 0,016 | 0,028 | 0,038 | 0,046 |
| P.2 ≤ 850 N/mm ² | 1xS | t1(DIN 6888) | 28 | 0,008 | 0,011 | 0,016 | 0,028 | 0,038 | 0,046 |
| P.3 ≤ 1100 N/mm ² | 1xS | t1(DIN 6888) | 22 | 0,008 | 0,011 | 0,016 | 0,028 | 0,038 | 0,046 |
| N.2 ≤ 600 N/mm ² | 1xS | t1(DIN 6888) | 45 | 0,01 | 0,014 | 0,021 | 0,036 | 0,049 | 0,060 |
| S.2 ≤ 1250 N/mm ² | 1xS | t1(DIN 6888) | 11 | 0,006 | 0,008 | 0,011 | 0,02 | 0,027 | 0,032 |

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- CZ** Frézy pro drážky úsečových per
- DE** Schlitzfräser für Woodruffnuten
- RU** Фрезы для пазов сегментных шпонок



3201



HSS/SC

| D h 11 | d h 8 | S e 8 | l1 | Z | Dj* | 320100 |
|-----------|----------|----------|----|----|-----|---------|
| 27 | 12 | 2 | 60 | 10 | 25 | .250020 |
| 27 | 12 | 3 | 60 | 10 | 25 | .250030 |
| 27 | 12 | 6 | 60 | 10 | 25 | .250060 |
| 30,2 | 12 | 6 | 60 | 10 | 28 | .280060 |
| 30,2 | 16 | 8 | 70 | 10 | 28 | .280080 |
| 34,5 | 16 | 6 | 70 | 10 | 32 | .320060 |
| 34,5 | 16 | 8 | 70 | 10 | 32 | .320080 |
| 41 | 16 | 8 | 70 | 10 | 38 | .380080 |
| 48,6 | 16 | 8 | 70 | 10 | 45 | .450080 |
| 48,6 | 16 | 10 | 70 | 10 | 45 | .450100 |

*) ČSN 30 1385

Cutting conditions | Řežné podmínky | Schnittbedingungen | Условия резания

| Material | A _p | A _e | V _c | f _z (mm/z) | | | | | |
|-------------------------------------|----------------|----------------|----------------|-----------------------|-------|--------|--------|-------|--------|
| | | | | Ø 23,7 | Ø 27 | Ø 30,2 | Ø 34,5 | Ø 41 | Ø 48,6 |
| P.1 ≤ 600 N/mm ² | 1xS | t1(DIN 6888) | 33 | 0,046 | 0,049 | 0,054 | 0,063 | 0,069 | 0,072 |
| P.2 ≤ 850 N/mm ² | 1xS | t1(DIN 6888) | 28 | 0,046 | 0,049 | 0,054 | 0,063 | 0,069 | 0,072 |
| P.3 ≤ 1100 N/mm ² | 1xS | t1(DIN 6888) | 22 | 0,046 | 0,049 | 0,054 | 0,063 | 0,069 | 0,072 |
| N.2 ≤ 600 N/mm ² | 1xS | t1(DIN 6888) | 45 | 0,060 | 0,064 | 0,07 | 0,082 | 0,09 | 0,094 |
| S.2 ≤ 1250 N/mm ² | 1xS | t1(DIN 6888) | 11 | 0,032 | 0,034 | 0,038 | 0,044 | 0,048 | 0,05 |