

# Ausdrehen, Hartbearbeitung und WIPER-Geometrie

In Verbindung mit einem CBN-Schneidstoff besonders geeignet für die Hartbearbeitung ab Bohrungsdurchmesser 6,2 mm.

## Boring, Hard Part Turning plus WIPER-Geometry

First choice for hard part turning applications in bores as of bore diameter 6,2 mm in combination with our CBN grades.

Schnittwerte (Start) // Cutting parameters (start)

|           |                  |
|-----------|------------------|
| f         | Vc               |
| 0,02 mm/U | (Seite/Page 442) |

Passende Klemmhalter auf Seite // Suitable toolholders on page

41, 42, 43, 45, 47, 49, 50, 51, 55,  
56, 58, 59, 60, 64, 65, 66, 67, 68,  
69, 70, 71, 74, 75, 76, 77, 78, 79,  
80, 81

Vergleichbare Werkzeuge auf Seite // Similar tools on page

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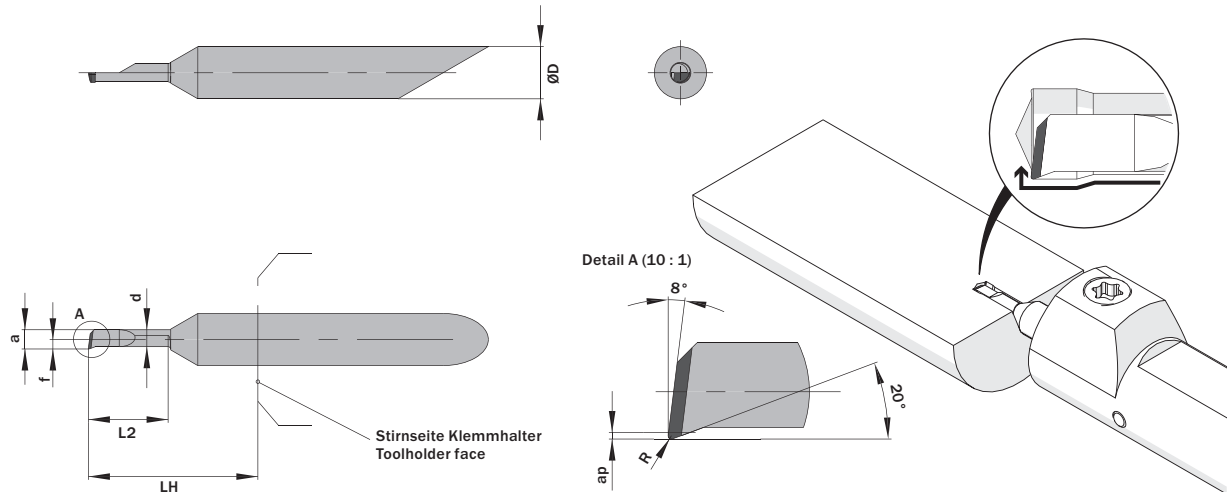
Legende  
Legend 155Oder besuchen Sie // Or Visit  
[www.simtek.info/cp/1063](http://www.simtek.info/cp/1063)

Abbildung zeigt / Drawing shows: A04.1807.06.17.10 YUR / L

Mehr Informationen zur Kühlmittelzufuhr finden Sie auf Seite 36  
Additional information about through coolant supply on page 36

| ØD | L2 | ØDmin (Min. Bohrung)<br>ØDmin (min. bore) | R  | Kühlmittelzufuhr<br>Through coolant supply | Artikelnummer<br>Part number | Webcode<br><a href="http://www.simtek.com/webcode">www.simtek.com/webcode</a> | Empfohlene<br>Schneidstoffe<br>Recommended cutting grades                                                                                                                                                                                                                  | a  | ap | d  | f  | LH | Connectcode<br><a href="http://www.simtek.com/code">www.simtek.com/code</a> |
|----|----|-------------------------------------------|----|--------------------------------------------|------------------------------|-------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|----|----|----|----|-----------------------------------------------------------------------------|
| mm | mm | mm                                        | mm |                                            |                              |                                                                               | <p>Tagessaktuelle Verfügbarkeit<br/>und Preise finden Sie auf<br/><a href="http://www.simtek.com/webcode">www.simtek.com/webcode</a></p> <p>You can find current<br/>availability and prices on<br/><a href="http://www.simtek.com/webcode">www.simtek.com/webcode</a></p> | mm | mm | mm | mm | mm |                                                                             |

Fortgesetzte Tabelle  
Continued TableVerwandte Werkzeuge finden Sie auch auf der vorhergehenden Seite!  
Related items can be found on the previous page as well!

▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 5,2 mm

|     |      |     |     |   |                         |               |      |      |      |      |      |      |                 |
|-----|------|-----|-----|---|-------------------------|---------------|------|------|------|------|------|------|-----------------|
| 5,0 | 10,2 | 5,2 | 0,2 | + | A05.1825.10.52.20 YUR/L | R AHH5 L AHHM | CBN8 | 4,95 | 0,26 | 4,25 | 2,45 | 13,0 | R A05.R L A05.L |
| 5,0 | 15,2 | 5,2 | 0,2 | + | A05.1825.15.52.20 YUR/L | R AD1K L AE8S | CBN8 | 4,95 | 0,26 | 4,25 | 2,45 | 18,0 | R A05.R L A05.L |
| 5,0 | 20,3 | 5,2 | 0,2 | + | A05.1825.20.52.20 YUR/L | R AHAX L AM28 | CBN8 | 4,95 | 0,26 | 4,25 | 2,45 | 23,0 | R A05.R L A05.L |
| 5,0 | 25,4 | 5,2 | 0,2 | + | A05.1825.25.52.20 YUR/L | R AA87 L ADPG | CBN8 | 4,95 | 0,26 | 4,25 | 2,45 | 28,0 | R A05.R L A05.L |
| 5,0 | 30,5 | 5,2 | 0,2 | + | A05.1825.30.52.20 YUR/L | R ADNS L ABNV | CBN8 | 4,95 | 0,26 | 4,25 | 2,45 | 33,0 | R A05.R L A05.L |
| 5,0 | 40,6 | 5,2 | 0,2 | + | A05.1825.40.52.20 YUR/L | R AJBN L AF1T | CBN8 | 4,95 | 0,26 | 4,25 | 2,45 | 43,0 | R A05.R L A05.L |

▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 6,2 mm

|     |      |     |     |   |                         |               |      |      |      |      |      |      |                 |
|-----|------|-----|-----|---|-------------------------|---------------|------|------|------|------|------|------|-----------------|
| 6,0 | 15,2 | 6,2 | 0,2 | + | A06.1830.15.62.20 YUR/L | R ADEW L APKD | CBN8 | 5,95 | 0,31 | 5,25 | 2,95 | 18,0 | R A06.R L A06.L |
| 6,0 | 20,3 | 6,2 | 0,2 | + | A06.1830.20.62.20 YUR/L | R AEWG L AD88 | CBN8 | 5,95 | 0,31 | 5,25 | 2,95 | 23,0 | R A06.R L A06.L |
| 6,0 | 25,4 | 6,2 | 0,2 | + | A06.1830.25.62.20 YUR/L | R ACXE L AH4U | CBN8 | 5,95 | 0,31 | 5,25 | 2,95 | 28,0 | R A06.R L A06.L |
| 6,0 | 30,5 | 6,2 | 0,2 | + | A06.1830.30.62.20 YUR/L | R AEJ9 L AGTA | CBN8 | 5,95 | 0,31 | 5,25 | 2,95 | 33,0 | R A06.R L A06.L |
| 6,0 | 35,6 | 6,2 | 0,2 | + | A06.1830.35.62.20 YUR/L | R ANYT L ANN5 | CBN8 | 5,95 | 0,31 | 5,25 | 2,95 | 38,0 | R A06.R L A06.L |
| 6,0 | 40,6 | 6,2 | 0,2 | + | A06.1830.40.62.20 YUR/L | R AJ2Z L AP2G | CBN8 | 5,95 | 0,31 | 5,25 | 2,95 | 43,0 | R A06.R L A06.L |

▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 7,2 mm

|     |      |     |     |   |                         |               |      |      |      |      |      |      |                 |
|-----|------|-----|-----|---|-------------------------|---------------|------|------|------|------|------|------|-----------------|
| 7,0 | 25,4 | 7,2 | 0,2 | + | A07.1835.25.72.20 YUR/L | R ABD2 L AKEW | CBN8 | 6,95 | 0,36 | 6,25 | 3,45 | 28,0 | R A07.R L A07.L |
| 7,0 | 30,5 | 7,2 | 0,2 | + | A07.1835.30.72.20 YUR/L | R ACBJ L AJG9 | CBN8 | 6,95 | 0,36 | 6,25 | 3,45 | 33,0 | R A07.R L A07.L |
| 7,0 | 35,6 | 7,2 | 0,2 | + | A07.1835.35.72.20 YUR/L | R ADK7 L AK9F | CBN8 | 6,95 | 0,36 | 6,25 | 3,45 | 38,0 | R A07.R L A07.L |
| 7,0 | 40,6 | 7,2 | 0,2 | + | A07.1835.40.72.20 YUR/L | R AK5S L AF7V | CBN8 | 6,95 | 0,36 | 6,25 | 3,45 | 43,0 | R A07.R L A07.L |
| 7,0 | 50,8 | 7,2 | 0,2 | + | A07.1835.50.72.20 YUR/L | R ADDS L AD9D | CBN8 | 6,95 | 0,36 | 6,25 | 3,45 | 53,0 | R A07.R L A07.L |

Bestellbeispiel // Order example: A05.1825.10.52.20 YUR CBN8 (R = Rechte Ausführung // Right hand version, CBN8 = Schneidstoff // Grade)