

# Ausdrehen mit spezieller Spantreppe

Mit optimierter Spanbildung durch spezielle Spantreppe. Zentrierte Ausführung für optimierte Kühlung und Spitzenhöhe in Verbindung mit passendem Halter. Geeignet ab Bohrungsdurchmesser 2,7 mm.

## Boring with special chip former

Special chipformer for improved chip control. Centered edition with improved coolant supply and cutting edge positioning. For use in bores as of minimum bore diameter 2,7 mm.

Schnittwerte (Start) // Cutting parameters (start)

f  
**0,02 mm/U**

Vc  
**(Seite/Page 442)**

Passende Klemmhalter auf Seite // Suitable toolholders on page

41, 45, 46, 47, 48, 49, 54, 55, 57,  
58, 64, 65, 68, 69, 70, 73, 74, 75,  
76, 78, 79, 80, 81



SP  
HM  
R

Legende  
Legend **155**

Scan  
QR-Code

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[www.simtek.info/cp/1045](http://www.simtek.info/cp/1045)

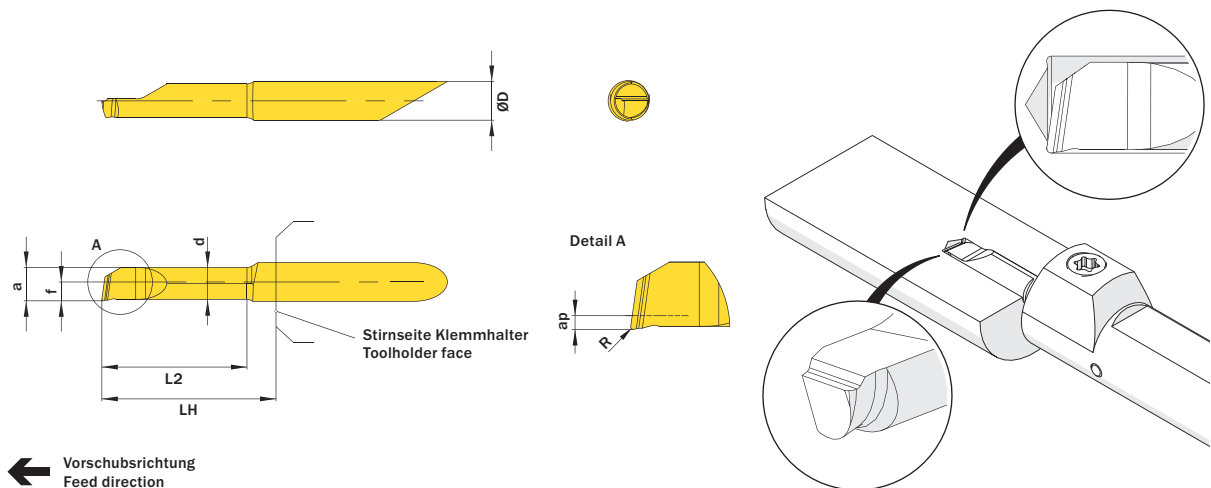


Abbildung zeigt / Drawing shows: A04.0C17.15.37.15 YER

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<br>You can find current availability and prices on <a href="http://www.simtek.com/webcode">www.simtek.com/webcode</a> | a    | ap  | d    | f    | LH   | Connectcode<br><a href="http://www.simtek.com/code">www.simtek.com/code</a> |
|------------------------------------------------------|------|-------------------------------------------|------|--------------------------------------------|------------------------------|-------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|-----|------|------|------|-----------------------------------------------------------------------------|
| mm                                                   | mm   | mm                                        | mm   |                                            |                              |                                                                               |                                                                                                                                                                                 | mm   | mm  | mm   | mm   | mm   |                                                                             |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 2,7 mm |      |                                           |      |                                            |                              |                                                                               |                                                                                                                                                                                 |      |     |      |      |      |                                                                             |
| 4,0                                                  | 10,2 | 2,7                                       | 0,15 | +                                          | A04.0C12.10.27.15 YER/L      | R AYE3 L AYE2                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 2,45 | 0,4 | 2,3  | 1,95 | 13,0 | R A04C.R L A04C.L                                                           |
| 4,0                                                  | 15,2 | 2,7                                       | 0,15 | +                                          | A04.0C12.15.27.15 YER/L      | R AUPY L AUPZ                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 2,45 | 0,4 | 2,3  | 1,95 | 18,0 | R A04C.R L A04C.L                                                           |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 3,2 mm |      |                                           |      |                                            |                              |                                                                               |                                                                                                                                                                                 |      |     |      |      |      |                                                                             |
| 4,0                                                  | 10,2 | 3,2                                       | 0,15 | +                                          | A04.0C15.10.32.15 YER/L      | R AYE5 L AYE4                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 2,95 | 0,4 | 2,8  | 1,95 | 13,0 | R A04C.R L A04C.L                                                           |
| 4,0                                                  | 15,2 | 3,2                                       | 0,15 | +                                          | A04.0C15.15.32.15 YER/L      | R AUPØ L AUP1                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 2,95 | 0,4 | 2,8  | 1,95 | 18,0 | R A04C.R L A04C.L                                                           |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 3,7 mm |      |                                           |      |                                            |                              |                                                                               |                                                                                                                                                                                 |      |     |      |      |      |                                                                             |
| 4,0                                                  | 10,2 | 3,7                                       | 0,15 | +                                          | A04.0C17.10.37.15 YER/L      | R AYE6 L AYE7                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 3,45 | 0,5 | 3,3  | 1,95 | 13,0 | R A04C.R L A04C.L                                                           |
| 4,0                                                  | 15,2 | 3,7                                       | 0,15 | +                                          | A04.0C17.15.37.15 YER/L      | R AUPT L AUPS                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 3,45 | 0,5 | 3,3  | 1,95 | 18,0 | R A04C.R L A04C.L                                                           |
| 4,0                                                  | 20,3 | 3,7                                       | 0,15 | +                                          | A04.0C17.20.37.15 YER/L      | R ATUE L ATUF                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 3,45 | 0,5 | 3,3  | 1,95 | 23,0 | R A04C.R L A04C.L                                                           |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 4,2 mm |      |                                           |      |                                            |                              |                                                                               |                                                                                                                                                                                 |      |     |      |      |      |                                                                             |
| 4,0                                                  | 10,2 | 4,2                                       | 0,15 | +                                          | A04.0020.10.42.15 YER/L      | R AVUP L AW4V                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 3,95 | 0,5 | 3,8  | 1,95 | 13,0 | R A04C.R L A04C.L                                                           |
| 4,0                                                  | 15,2 | 4,2                                       | 0,15 | +                                          | A04.0020.15.42.15 YER/L      | R ASE4 L ASE5                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 3,95 | 0,5 | 3,8  | 1,95 | 18,0 | R A04C.R L A04C.L                                                           |
| 4,0                                                  | 15,2 | 4,2                                       | 0,4  | +                                          | A04.0020.15.42.40 YER        | A4XD                                                                          | X800 X400 GX79 X500 X400                                                                                                                                                        | 3,95 | 0,5 | 3,8  | 1,95 | 18,0 | A04C.R                                                                      |
| 4,0                                                  | 20,3 | 4,2                                       | 0,15 | +                                          | A04.0020.20.42.15 YER/L      | R ASE6 L ASE7                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 3,95 | 0,5 | 3,8  | 1,95 | 23,0 | R A04C.R L A04C.L                                                           |
| 4,0                                                  | 25,4 | 4,2                                       | 0,15 | +                                          | A04.0020.25.42.15 YER/L      | R AVUQ L AW4W                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 3,95 | 0,5 | 3,8  | 1,95 | 28,0 | R A04C.R L A04C.L                                                           |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 5,2 mm |      |                                           |      |                                            |                              |                                                                               |                                                                                                                                                                                 |      |     |      |      |      |                                                                             |
| 5,0                                                  | 10,2 | 5,2                                       | 0,2  | +                                          | A05.0025.10.52.20 YER/L      | R AS74 L AS75                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 4,95 | 0,6 | 4,75 | 2,45 | 13,0 | R A05.R L A05.L                                                             |
| 5,0                                                  | 10,2 | 5,2                                       | 0,4  | +                                          | A05.0025.10.52.40 YER/L      | R AY8B L A065                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 4,95 | 0,6 | 4,75 | 2,45 | 13,0 | R A05.R L A05.L                                                             |
| 5,0                                                  | 15,2 | 5,2                                       | 0,2  | +                                          | A05.0025.15.52.20 YER/L      | R AS77 L AS76                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 4,95 | 0,6 | 4,75 | 2,45 | 18,0 | R A05.R L A05.L                                                             |
| 5,0                                                  | 20,3 | 5,2                                       | 0,2  | +                                          | A05.0025.20.52.20 YER/L      | R ASE9 L ASE8                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 4,95 | 0,6 | 4,75 | 2,45 | 23,0 | R A05.R L A05.L                                                             |
| 5,0                                                  | 25,4 | 5,2                                       | 0,2  | +                                          | A05.0025.25.52.20 YER/L      | R ASFA L ASFB                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 4,95 | 0,6 | 4,75 | 2,45 | 28,0 | R A05.R L A05.L                                                             |
| 5,0                                                  | 30,5 | 5,2                                       | 0,2  | +                                          | A05.0025.30.52.20 YER/L      | R AS79 L AS78                                                                 | X800 X400 GX79 X500 X400                                                                                                                                                        | 4,95 | 0,6 | 4,75 | 2,45 | 33,0 | R A05.R L A05.L                                                             |

Bestellbeispiel // Order example: A05.0025.10.52.20 YER X800 (R = Rechte Ausführung // Right hand version, X800 = Schneidstoff // Grade)