

## Ausdrehen mit spezieller Spanfläche

Mit optimierter Spanbildung durch spezielle, runde Spanfläche. Zentrierte Ausführung für optimierte Kühlung und Spitzenhöhe in Verbindung mit passendem Halter. Geeignet ab Bohrungsdurchmesser 1,0 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 1,0 mm.

Schnittwerte (Start) // Cutting parameters (start)

$f$  0,02 mm/U  $V_c$  (Seite/Page 442)

Passende Klemmhalter auf Seite // Suitable toolholders on page

45, 46, 48, 54, 55, 57, 64, 65, 68,  
69, 70, 73, 75, 76, 79, 80, 81



SP  
HM  
R

Legende  
Legend 155

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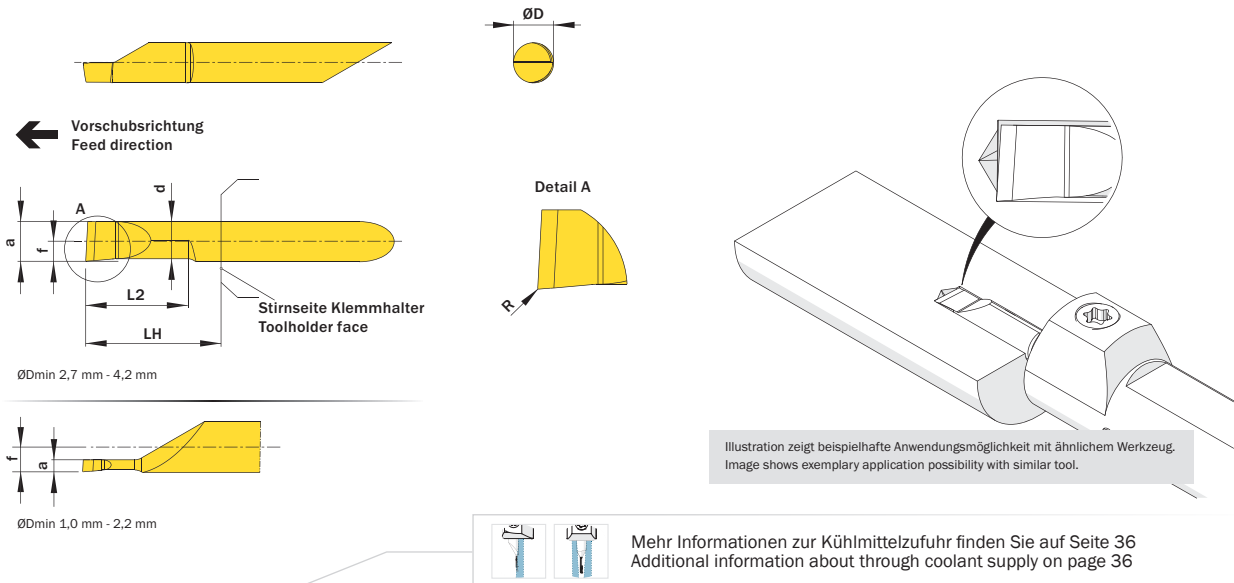


Illustration zeigt beispielhafte Anwendungsmöglichkeit mit ähnlichem Werkzeug.  
Image shows exemplary application possibility with similar tool.

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>www.simtek.com/webcode | Empfohlene<br>Schneidstoffe<br>Tagesaktuelle Verfügbarkeit<br>und Preise finden Sie auf<br>www.simtek.com/webcode<br><br>Recommended<br>cutting grades<br>You can find current<br>availability and prices on<br>www.simtek.com/webcode |      |      |      |      |      |   | a    | d    | f    | LH   | Connectcode<br>www.simtek.com/code |
|------------------------------------------------------|------|-------------------------------------------|------|--------------------------------------------|------------------------------|-----------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|------|------|------|------|---|------|------|------|------|------------------------------------|
| mm                                                   | mm   | mm                                        | mm   |                                            |                              |                                   | P                                                                                                                                                                                                                                      | K    | M    | N    | S    | H    | O | mm   | mm   | mm   | mm   |                                    |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 1,0 mm |      |                                           |      |                                            |                              |                                   |                                                                                                                                                                                                                                        |      |      |      |      |      |   |      |      |      |      |                                    |
| 4,0                                                  | 4,1  | 1,0                                       | 0,05 | +                                          | A04.8704.04.10.05 YS R       | AX3P                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 0,95 | 0,8  | 1,95 | 13,0 | A04C.R                             |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 1,2 mm |      |                                           |      |                                            |                              |                                   |                                                                                                                                                                                                                                        |      |      |      |      |      |   |      |      |      |      |                                    |
| 4,0                                                  | 6,1  | 1,2                                       | 0,05 | +                                          | A04.8705.06.12.05 YS R       | AX3Q                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 1,1  | 0,95 | 1,95 | 13,0 | A04C.R                             |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 1,4 mm |      |                                           |      |                                            |                              |                                   |                                                                                                                                                                                                                                        |      |      |      |      |      |   |      |      |      |      |                                    |
| 4,0                                                  | 6,1  | 1,4                                       | 0,05 | +                                          | A04.8706.06.14.05 YS R       | AX3N                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 1,3  | 1,15 | 1,95 | 13,0 | A04C.R                             |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 1,7 mm |      |                                           |      |                                            |                              |                                   |                                                                                                                                                                                                                                        |      |      |      |      |      |   |      |      |      |      |                                    |
| 4,0                                                  | 6,1  | 1,7                                       | 0,05 | +                                          | A04.8707.06.17.05 YS R       | AX9J                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 1,45 | 1,3  | 1,95 | 13,0 | A04C.R                             |
| 4,0                                                  | 6,1  | 1,7                                       | 0,1  | +                                          | A04.8707.06.17.10 YS R       | AX1X                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 1,45 | 1,3  | 1,95 | 13,0 | A04C.R                             |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 2,2 mm |      |                                           |      |                                            |                              |                                   |                                                                                                                                                                                                                                        |      |      |      |      |      |   |      |      |      |      |                                    |
| 4,0                                                  | 9,1  | 2,2                                       | 0,05 | +                                          | A04.8710.09.22.05 YS R       | AX3U                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 1,95 | 1,8  | 1,95 | 13,0 | A04C.R                             |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 2,7 mm |      |                                           |      |                                            |                              |                                   |                                                                                                                                                                                                                                        |      |      |      |      |      |   |      |      |      |      |                                    |
| 4,0                                                  | 10,2 | 2,7                                       | 0,05 | +                                          | A04.8712.10.27.05 YS R       | AX56                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 2,45 | 2,3  | 1,95 | 13,0 | A04C.R                             |
| 4,0                                                  | 10,2 | 2,7                                       | 0,1  | +                                          | A04.8712.10.27.10 YS R       | AX3M                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 2,45 | 2,3  | 1,95 | 13,0 | A04C.R                             |
| 4,0                                                  | 15,2 | 2,7                                       | 0,05 | +                                          | A04.8712.15.27.05 YS R       | AYCE                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 2,45 | 2,3  | 1,95 | 18,0 | A04C.R                             |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 3,2 mm |      |                                           |      |                                            |                              |                                   |                                                                                                                                                                                                                                        |      |      |      |      |      |   |      |      |      |      |                                    |
| 4,0                                                  | 10,2 | 3,2                                       | 0,05 | +                                          | A04.8715.10.32.05 YS R       | AX55                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 2,95 | 2,8  | 1,95 | 13,0 | A04C.R                             |
| 4,0                                                  | 10,2 | 3,2                                       | 0,1  | +                                          | A04.8715.10.32.10 YS R       | AX3T                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 2,95 | 2,8  | 1,95 | 13,0 | A04C.R                             |
| 4,0                                                  | 15,2 | 3,2                                       | 0,05 | +                                          | A04.8715.15.32.05 YS R       | AYCG                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 2,95 | 2,8  | 1,95 | 18,0 | A04C.R                             |
| ▼ ØDmin (Min. Bohrung) // ØDmin (min. bore) = 4,2 mm |      |                                           |      |                                            |                              |                                   |                                                                                                                                                                                                                                        |      |      |      |      |      |   |      |      |      |      |                                    |
| 4,0                                                  | 10,2 | 4,2                                       | 0,05 | +                                          | A04.8720.10.42.05 YS R       | AXYU                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 3,95 | 3,7  | 1,95 | 13,0 | A04C.R                             |
| 4,0                                                  | 15,2 | 4,2                                       | 0,05 | +                                          | A04.8720.15.42.05 YS R       | AX54                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 3,95 | 3,7  | 1,95 | 18,0 | A04C.R                             |
| 4,0                                                  | 15,2 | 4,2                                       | 0,1  | +                                          | A04.8720.15.42.10 YS R       | AX3S                              | X800                                                                                                                                                                                                                                   | X400 | X600 | GX79 | X500 | X400 |   | 3,95 | 3,7  | 1,95 | 18,0 | A04C.R                             |

Bestellbeispiel // Order example: A04.8715.10.32.10 YS R X800 (R = Rechte Ausführung // Right hand version, X800 = Schneidstoff // Grade)