

CARBIDE REAMER SERT METAL RAYBA



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Dia/Çap Ø mm H7	CODE KOD	Flute lenght Helis boyu	Overall lenght tamboy	Shank Dia sap çapı Ø mm	EURO
2	220020	12	58	2	20.00
3	220030	12	58	3	20.00
4	220040	18	63	4	26.00
5	220050	22	75	5	33.00
6	220060	25	75	6	38.00
7	220070	25	75	7	44.00
8	220080	28	82	8	45.00
9	220090	35	100	9	60.00
10	220100	35	100	10	70.00
11	220110	35	100	11	80.00
12	220120	35	100	12	80.00

TECHNIC / TEKNİK

SPEED & FEED RECOMMENDATIONS FOR CARBIDE REAMERS SERT METAL RAYBALARDA ÖNERİLEN DEVİR & İLERLEME DEĞERLERİ

Workpiece material	FEED - KESME HIZI	FEED RATE ACCORDING TO REAMER DIAMETER mm / revolution							
		RAYBA ÇAPLARINA GÖRE İLERLEME (devir başına ilerleme) mm/ devir							
İşlenen Malzeme Türü	m/min - m/dak.	Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12
STEEL - ÇELİK < 200 HB	14-24 m/min - m/dak.	0.035	0.060	0.070	0.080	0.100	0.120	0.150	0.180
STEEL - ÇELİK 200-300 HB	9-14 m/min - m/dak.	0.030	0.050	0.060	0.075	0.090	0.140	0.012	0.150
STEEL - ÇELİK 300-350 HB	6-9 m/min - m/dak.	0.020	0.030	0.040	0.060	0.080	0.090	0.100	0.130
STEEL - ÇELİK 38-45 HRC	5-7 m/min - m/dak.	0.015	0.020	0.030	0.050	0.060	0.070	0.080	0.100
STAINLESS STEEL PASLANMAZ ÇELİK	5-10 m/min - m/dak.	0.025	0.030	0.035	0.040	0.050	0.060	0.060	0.080
CAST IRON - DÖKÜM	8-25 m/min - m/dak.	0.035	0.060	0.080	0.095	0.110	0.140	0.150	0.180
CUPPER BRONZE BRASS BAKIR BRONZ PİRİNÇ	20-30 m/min - m/dak.	0.035	0.060	0.080	0.095	0.110	0.140	0.160	0.180
ALUMINIUM ALUMINYUM	20-50 m/min - m/dak.	0.035	0.060	0.100	0.110	0.130	0.160	0.180	0.200

STOCK REMOVAL RECOMMENDED IN THE HOLE TO BE REAMED RAYBALANACAK DELİKTE BIRAKILMASI GEREKEN TALAŞ MİKTARI

Reamer Diameter Rayba çapı	Ø Stock removal recommended on diameter Çaptaki raybalama payı mm
1.0-3.0	0.07-0.15
3.1-6.0	0.15-0.20
6.1-10.0	0.20-0.30
10.1-13.0	0.25-0.35