

Schnittdaten für CoroDrill® 870

< 6 x DC

Metrische Werte

ISO	MC-Nr.	CMC- Nr.	Werkstoff	Brinell Härte (HB)	Schnittgeschwindigkeit (V _C) m/min entsprechend Bohrerdurchmesser						
					10.00-20.99mm			21.00-33.00mm			
					Min.	Emp- fehl.	Max.	Min.	Emp- fehl.	Max.	
P	P1.1.Z.AN P1.2.Z.AN P1.3.Z.AN P1.5.C.UT	01.1	Unlegierter Stahl C=0.10-0.25%	125	Sorte 4234						
		01.2	C=0.25-0.55%	190	80	120	160	80	120	160	
		01.3	C=0.55-0.80%	190	70	100	130	70	100	130	
		06.1	Gegossen - unbehandelt	150	80	110	140	80	110	140	
	P2.1.Z.AN P2.2.Z.AN P2.4.Z.AN P2.5.Z.HT P2.6.C.UT	02.1	Niedriglegierter Stahl Geglüht	175	80	110	140	80	110	140	
		02.1	Geglüht	240	80	110	140	80	110	140	
		02.1	Geglüht	225	80	110	140	80	110	140	
		02.2	Vergütet	330	70	100	130	50	75	100	
		06.2	Gegossen - unbehandelt	200	70	100	130	70	100	130	
		P3.0.Z.AN P3.0.Z.HT	03.11	Hochlegierter Stahl Geglüht	200	60	80	100	60	80	100
	03.21		Vergütet	380	40	60	80	40	60	80	
	P5.0.Z.AN P5.0.Z.HT	05.11	Ferritisch/martensitischer rostfreier Stahl Geglüht	200	Sorte 2234 und 4234						
		05.11	Vergütet	330	30	40	50	30	40	50	
	M	M1.0.Z.AQ M1.0.C.UT M1.1.Z.AQ	05.21	Austenitischer rostfreier Stahl Geglüht/vergütet	200	Sorte 2234 und 4234					
			15.21	Gegossen+unbehandelt	200	40	50	60	40	50	60
05.21			Zerspanbarkeit verbessert	200	50	60	70	50	60	70	
M2.0.Z.AQ M2.0.C.AQ		05.23	Superaustenitischer (Ni≥20%) rostfreier Stahl Geglüht/vergütet	200	60	75	90	60	75	90	
		15.23	Gegossen+geglüht/vergütet	200	20	40	60	20	40	60	
M3.1.Z.AQ M3.2.Z.AQ		05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle >60% Ferrit (N<0.10%)	230	40	55	70	40	55	70	
	05.52	<60% Ferrit (N≥0.10%)	260	20	40	60	20	40	60		
K	K1.1.C.NS K1.1.C.NS	07.1	Temperguss Ferritisch (kurzspanend)	130	Sorte 3234 und 4234						
		07.2	Perlitisch (langspanend)	200	100	145	190	100	145	190	
	K2.1.C.UT K2.2.C.UT	08.1	Grauguss Niedrige Festigkeit	180	90	125	160	90	125	160	
		08.2	Hohe Festigkeit	245	100	150	200	100	150	200	
K3.1.C.UT K3.3.C.UT	09.1	Kugelgraphitguß Ferritisch	155	90	130	170	90	130	170		
	09.2	Perlitisch	265	100	145	190	100	145	190		

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< 6 x DC

Metrische Werte

Vorschub, mm/ U entsprechend dem Bohrerdurchmesser																	
10.00-11.99 mm			12.00-13.99 mm			14.00-15.99 mm			16.00-20.99 mm			21.00-25.99 mm			26.00-33.00 mm		
Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.
Geometrie -PM und -GP																	
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.10	0.16	0.24	0.12	0.19	0.33	0.14	0.22	0.38	0.18	0.25	0.40	0.18	0.30	0.45	0.18	0.30	0.45
0.10	0.16	0.24	0.12	0.19	0.33	0.14	0.22	0.38	0.18	0.25	0.40	0.18	0.30	0.45	0.18	0.30	0.45
Geometrie -PM, -MM and -GP																	
0.12	0.14	0.19	0.14	0.16	0.22	0.14	0.18	0.24	0.18	0.24	0.30	0.22	0.28	0.34	0.22	0.28	0.34
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.18	0.22	0.16	0.22	0.26	0.16	0.22	0.26
Geometrie -MM und -GP																	
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.14	0.18	0.22	0.14	0.18	0.22
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.14	0.18	0.22	0.14	0.18	0.22
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.16	0.22	0.14	0.18	0.24	0.14	0.18	0.24
0.10	0.12	0.14	0.10	0.12	0.16	0.10	0.12	0.16	0.10	0.14	0.16	0.12	0.14	0.18	0.12	0.14	0.18
0.10	0.12	0.14	0.10	0.12	0.16	0.10	0.12	0.16	0.10	0.14	0.16	0.12	0.14	0.18	0.12	0.14	0.18
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.16	0.22	0.14	0.16	0.22	0.14	0.16	0.22
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.12	0.16	0.2	0.12	0.16	0.2
Geometrie -KM und -GP																	
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60

Schnittdaten für CoroDrill® 870

≥ 6 x DC

Metrische Werte

ISO	MC-Nr.	CMC- Nr.	Werkstoff	Brinell Härte (HB)	Schnittgeschwindigkeit (V _C) m/min entsprechend Bohrerdurchmesser						
					10.00-20.99mm			21.00-33.00mm			
					Min.	Emp- fehl.	Max.	Min.	Emp- fehl.	Max.	
P	P1.1.Z.AN	01.1	Unlegierter Stahl		Sorte 4234						
	P1.2.Z.AN	01.2	C=0.10-0.25%	125	80	120	160	80	120	160	
	P1.3.Z.AN	01.3	C=0.25-0.55%	190	80	120	160	80	120	160	
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	70	100	130	70	100	130	
	P1.5.C.UT	06.1	Gegossen - unbehandelt	150	80	110	140	80	110	140	
	D	P2.1.Z.AN	02.1	Niedriglegierter Stahl							
		P2.2.Z.AN	02.1	Geglüht	175	80	110	140	80	110	140
		P2.4.Z.AN	02.1	Geglüht	240	80	110	140	80	110	140
		P2.4.Z.AN	02.1	Geglüht	225	80	110	140	80	110	140
		P2.5.Z.HT	02.2	Vergütet	330	70	100	130	50	75	100
		P2.6.C.UT	06.2	Gegossen - unbehandelt	200	70	100	130	70	100	130
	E	P3.0.Z.AN	03.11	Hochlegierter Stahl							
		P3.0.Z.HT	03.21	Geglüht	200	60	80	100	60	80	100
		P3.0.Z.HT	03.21	Vergütet	380	40	60	80	40	60	80
	E	P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl		Sorte 2234 und 4234					
P5.0.Z.HT		05.11	Geglüht	200	30	40	50	30	40	50	
E	P5.0.Z.HT	05.11	Vergütet	330	70	90	110	60	75	90	
	M	M1.0.Z.AQ	05.21	Austenitischer rostfreier Stahl		Sorte 2234 und 4234					
M1.0.C.UT		15.21	Geglüht/vergütet	200	40	50	60	40	50	60	
M1.0.C.UT		15.21	Gegossen+unbehandelt	200	50	60	70	50	60	70	
M1.1.Z.AQ		05.21	Zerspanbarkeit verbessert	200	60	75	90	60	75	90	
M2.0.Z.AQ		05.23	Superaustenitischer (Ni≥20%) rostfreier Stahl								
M2.0.C.AQ		15.23	Geglüht/vergütet	200	20	40	60	20	40	60	
F	M2.0.C.AQ	15.23	Gegossen+geglüht/vergütet	200	20	40	60	20	40	60	
	F	M3.1.Z.AQ	05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle							
M3.2.Z.AQ		05.52	>60% Ferrit (N<0.10%)	230	40	55	70	40	55	70	
F	M3.2.Z.AQ	05.52	<60% Ferrit (N≥0.10%)	260	20	40	60	20	40	60	
	K	K1.1.C.NS	07.1	Temperguss		Sorte 3234 und 4234					
K1.1.C.NS		07.2	Ferritisch (kurzspanend)	130	100	130	170	100	130	170	
K1.1.C.NS		07.2	Perlitisch (langspanend)	200	90	115	145	90	115	145	
K	K2.1.C.UT	08.1	Grauguss								
	K2.2.C.UT	08.2	Niedrige Festigkeit	180	100	135	180	100	135	180	
K	K2.2.C.UT	08.2	Hohe Festigkeit	245	90	120	155	90	120	155	
	G	K3.1.C.UT	09.1	Kugelgraphitguß							
K3.3.C.UT		09.2	Ferritisch	155	100	130	170	100	130	170	
G	K3.3.C.UT	09.2	Perlitisch	265	90	115	145	90	115	145	

Schnittdaten für CoroDrill® 870

≥ 6 x DC

Metrische Werte

Vorschub _f , mm/ U entsprechend dem Bohrerdurchmesser																	
10.00-11.99 mm			12.00-13.99 mm			14.00-15.99 mm			16.00-20.99 mm			21.00-25.99 mm			26.00-33.00 mm		
Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.
Geometrie -PM und -GP																	
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
Geometrie -PM, -MM and -GP																	
0.12	0.13	0.15	0.14	0.15	0.18	0.14	0.15	0.19	0.18	0.19	0.24	0.22	0.23	0.27	0.22	0.23	0.27
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.14	0.15	0.16	0.16	0.17	0.18	0.16	0.17	0.18
Geometrie -MM und -GP																	
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.12	0.13	0.16	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.12	0.13	0.16	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.14	0.15	0.18	0.14	0.15	0.19	0.14	0.15	0.19
Geometrie -KM und -GP																	
0.10	0.11	0.12	0.10	0.11	0.13	0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.14
0.10	0.11	0.12	0.10	0.11	0.13	0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.14
0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.14	0.15	0.18	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.12	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.16	0.12	0.13	0.16	0.12	0.13	0.16
Geometrie -KM und -GP																	
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48

Schnittdaten für CoroDrill® 870

< 6 x DC

Zoll-Werte

ISO	MC-Nr.	CMC- Nr.	Werkstoff	Brinell Härte (HB)	Schnittgeschwindigkeit (V _c) ft/min entsprechend Bohrerdurchmesser						
					.3937-.8264"			.8268-1.2992"			
					Min.	Emp- fehl.	Max.	Min.	Emp- fehl.	Max.	
P	P1.1.Z.AN P1.2.Z.AN P1.3.Z.AN P1.5.C.UT	01.1	Unlegierter Stahl C=0.10-0.25%	125	Sorte 4234						
		01.2	C=0.25-0.55%	190	260	395	525	260	395	525	
		01.3	C=0.55-0.80%	190	230	330	425	230	330	425	
		06.1	Gegossen - unbehandelt	150	260	360	460	260	360	460	
	P2.1.Z.AN P2.2.Z.AN P2.4.Z.AN P2.5.Z.HT P2.6.C.UT	02.1	Niedriglegierter Stahl Geglüht	175	260	360	460	260	360	460	
		02.1	Geglüht	240	260	360	460	260	360	460	
		02.1	Geglüht	225	260	360	460	260	360	460	
		02.2	Vergütet	330	230	330	425	165	245	330	
		06.2	Gegossen - unbehandelt	200	230	330	425	230	330	425	
		P3.0.Z.AN P3.0.Z.HT	03.11	Hochlegierter Stahl Geglüht	200	195	260	330	195	260	330
	03.21		Vergütet	380	130	195	260	130	195	260	
	P5.0.Z.AN P5.0.Z.HT	05.11	Ferritisch/martensitischer rostfreier Stahl Geglüht	200	Sorte 2234 und 4234						
		05.11	Vergütet	330	100	130	165	100	130	165	
	M	M1.0.Z.AQ M1.0.C.UT M1.1.Z.AQ	05.21	Austenitischer rostfreier Stahl Geglüht/vergütet	200	Sorte 2234 und 4234					
			15.21	Gegossen+unbehandelt	200	130	165	195	130	165	195
05.21			Zerspanbarkeit verbessert	200	165	195	230	165	195	230	
M2.0.Z.AQ M2.0.C.AQ		05.23	Superaustenitischer (Ni≥20%) rostfreier Stahl Geglüht/vergütet	200	195	245	295	195	245	295	
		15.23	Gegossen+geglüht/vergütet	200	65	130	195	65	130	195	
M3.1.Z.AQ M3.2.Z.AQ		05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle >60% Ferrit (N<0.10%)	230	130	180	230	130	180	230	
	05.52	<60% Ferrit (N≥0.10%)	260	65	130	195	65	130	195		
K	K1.1.C.NS K1.1.C.NS	07.1	Temperguss Ferritisch (kurzspanend)	130	Sorte 3234 und 4234						
		07.2	Perlitisch (langspanend)	200	330	475	620	330	475	620	
	K2.1.C.UT K2.2.C.UT	08.1	Grauguss Niedrige Festigkeit	180	295	410	525	295	410	525	
		08.2	Hohe Festigkeit	245	330	490	655	330	490	655	
K3.1.C.UT K3.3.C.UT	09.1	Kugelgraphitguß Ferritisch	155	295	425	560	295	425	560		
	09.2	Perlitisch	265	330	475	620	330	475	620		

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< 6 x DC

Zoll-Werte

Vorschub (f _s) Zoll/U, entsprechend dem Bohrerdurchmesser																	
.3937-.4720"			.4724-.5508"			.5512-.6295"			.6299-.8264"			.8268-1.0232"			1.0237-1.2992"		
Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.
Geometrie -PM und -GP																	
.0047	.0071	.0110	.0055	.0079	.0138	.0063	.0098	.0161	.0079	.0126	.0177	.0079	.0134	.0177	.0079	.0134	.0177
.0047	.0071	.0110	.0055	.0079	.0138	.0063	.0098	.0161	.0079	.0126	.0177	.0079	.0134	.0177	.0079	.0134	.0177
.0047	.0071	.0110	.0055	.0079	.0138	.0063	.0098	.0161	.0079	.0126	.0177	.0079	.0134	.0177	.0079	.0134	.0177
.0047	.0074	.0110	.0055	.0079	.0138	.0063	.0098	.0161	.0079	.0126	.0177	.0079	.0134	.0177	.0079	.0134	.0177
.0047	.0071	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0157	.0205
.0047	.0071	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0157	.0205
.0047	.0071	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0157	.0205
.0047	.0074	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0142	.0197
.0039	.0063	.0094	.0047	.0075	.0130	.0055	.0087	.0150	.0071	.0098	.0157	.0071	.0118	.0177	.0071	.0118	.0177
.0039	.0063	.0094	.0047	.0075	.0130	.0055	.0087	.0150	.0071	.0098	.0157	.0071	.0118	.0177	.0071	.0118	.0177
Geometrie -PM, -MM and -GP																	
.0047	.0055	.0075	.0055	.0063	.0087	.0055	.0071	.0094	.0071	.0094	.0118	.0087	.0110	.0134	.0087	.0110	.0134
.0039	.0047	.0063	.0039	.0047	.0063	.0047	.0055	.0071	.0055	.0071	.0087	.0063	.0087	.0102	.0063	.0087	.0102
Geometrie -MM und -GP																	
.0039	.0047	.0055	.0039	.0047	.0055	.0047	.0055	.0063	.0047	.0063	.0079	.0055	.0071	.0087	.0055	.0071	.0087
.0039	.0047	.0055	.0039	.0047	.0055	.0047	.0055	.0063	.0047	.0063	.0079	.0055	.0071	.0087	.0055	.0071	.0087
.0039	.0047	.0063	.0039	.0047	.0063	.0047	.0055	.0071	.0055	.0063	.0087	.0055	.0071	.0094	.0055	.0071	.0094
.0039	.0047	.0055	.0039	.0047	.0063	.0039	.0047	.0063	.0039	.0055	.0063	.0047	.0055	.0071	.0047	.0055	.0071
.0039	.0047	.0055	.0039	.0047	.0063	.0039	.0047	.0063	.0039	.0055	.0063	.0047	.0055	.0071	.0047	.0055	.0071
.0039	.0047	.0063	.0039	.0047	.0063	.0039	.0055	.0071	.0055	.0063	.0087	.0055	.0063	.0087	.0055	.0063	.0087
.0039	.0047	.0055	.0039	.0047	.0055	.0047	.0055	.0063	.0047	.0063	.0079	.0047	.0063	.0079	.0047	.0063	.0079
Geometrie -KM und -GP																	
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236

Schnittdaten für CoroDrill® 870

≥ 6 x DC

Zoll-Werte

ISO	MC-Nr.	CMC- Nr.	Werkstoff	Brinell Härte (HB)	Schnittgeschwindigkeit (V _c) ft/min entsprechend Bohrerdurchmesser						
					.3937-.8264"			.8268-1.2992"			
					Min.	Emp- fehl.	Max.	Min.	Emp- fehl.	Max.	
P	P1.1.Z.AN P1.2.Z.AN P1.3.Z.AN P1.5.C.UT	01.1	Unlegierter Stahl C=0.10-0.25%	125	Sorte 4234						
		01.2	C=0.25-0.55%	190	260	395	525	260	395	525	
		01.3	C=0.55-0.80%	190	230	330	425	230	330	425	
		06.1	Gegossen - unbehandelt	150	260	360	460	260	360	460	
	P2.1.Z.AN P2.2.Z.AN P2.4.Z.AN P2.5.Z.HT P2.6.C.UT	02.1	Niedriglegierter Stahl Geglüht	175	260	360	460	260	360	460	
		02.1	Geglüht	240	260	360	460	260	360	460	
		02.1	Geglüht	225	260	360	460	260	360	460	
		02.2	Vergütet	330	230	330	425	165	245	330	
		06.2	Gegossen - unbehandelt	200	230	330	425	230	330	425	
		P3.0.Z.AN P3.0.Z.HT	03.11	Hochlegierter Stahl Geglüht	200	195	260	330	195	260	330
	03.21		Vergütet	380	130	195	260	130	195	260	
	P5.0.Z.AN P5.0.Z.HT	05.11	Ferritisch/martensitischer rostfreier Stahl Geglüht	200	Sorte 2234 und 4234						
		05.11	Vergütet	330	100	130	165	100	130	165	
	M	M1.0.Z.AQ M1.0.C.UT M1.1.Z.AQ	05.21	Austenitischer rostfreier Stahl Geglüht/vergütet	200	Sorte 2234 und 4234					
			15.21	Gegossen+unbehandelt	200	130	165	195	130	165	195
05.21			Zerspanbarkeit verbessert	200	165	195	230	165	195	230	
M2.0.Z.AQ M2.0.C.AQ		05.23	Superaustenitischer (Ni≥20%) rostfreier Stahl Geglüht/vergütet	200	195	245	295	195	245	295	
		15.23	Gegossen+geglüht/vergütet	200	65	130	195	65	130	195	
M3.1.Z.AQ M3.2.Z.AQ		05.51	Rostfreie (austenitische/ferritische) Duplex-Stähle >60% Ferrit (N<0.10%)	230	130	180	230	130	180	230	
	05.52	<60% Ferrit (N≥0.10%)	260	65	130	195	65	130	195		
K	K1.1.C.NS K1.1.C.NS	07.1	Temperguss Ferritisch (kurzspanend)	130	Sorte 3234 und 4234						
		07.2	Perlitisch (langspanend)	200	330	425	560	330	425	560	
	K2.1.C.UT K2.2.C.UT	08.1	Grauguss Niedrige Festigkeit	180	295	380	475	295	380	475	
		08.2	Hohe Festigkeit	245	330	440	590	330	440	590	
K3.1.C.UT K3.3.C.UT	09.1	Kugelgraphitguß Ferritisch	155	295	395	510	295	395	510		
	09.2	Perlitisch	265	330	425	560	330	425	560		

Schnittdaten für CoroDrill® 870

≥ 6 x DC

Zoll-Werte

Vorschub (f _n) Zoll/U, entsprechend dem Bohrerdurchmesser																	
.3937-.4720"			.4724-.5508"			.5512-.6295"			.6299-.8264"			.8268-1.0232"			1.0237-1.2992"		
Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.	Min.	Empfehl.	Max.
Geometrie -PM und -GP																	
.0047	.0057	.0088	.0055	.0063	.0110	.0063	.0079	.0129	.0079	.0101	.0142	.0079	.0107	.0142	.0079	.0107	.0142
.0047	.0057	.0088	.0055	.0063	.0110	.0063	.0079	.0129	.0079	.0101	.0142	.0079	.0107	.0142	.0079	.0107	.0142
.0047	.0057	.0088	.0055	.0063	.0110	.0063	.0079	.0129	.0079	.0101	.0142	.0079	.0107	.0142	.0079	.0107	.0142
.0047	.0057	.0088	.0055	.0063	.0110	.0063	.0079	.0129	.0079	.0101	.0142	.0079	.0107	.0142	.0079	.0107	.0142
.0047	.0057	.0094	.0055	.0063	.0117	.0063	.0079	.0142	.0079	.0101	.0151	.0079	.0113	.0157	.0079	.0126	.0164
.0047	.0057	.0094	.0055	.0063	.0117	.0063	.0079	.0142	.0079	.0101	.0151	.0079	.0113	.0157	.0079	.0126	.0164
.0047	.0057	.0094	.0055	.0063	.0117	.0063	.0079	.0142	.0079	.0101	.0151	.0079	.0113	.0157	.0079	.0126	.0164
.0047	.0050	.0083	.0055	.0059	.0102	.0063	.0069	.0124	.0079	.0088	.0132	.0079	.0099	.0138	.0079	.0110	.0143
.0047	.0057	.0094	.0055	.0063	.0117	.0063	.0079	.0142	.0079	.0101	.0151	.0079	.0113	.0157	.0079	.0126	.0164
.0039	.0050	.0076	.0047	.0060	.0104	.0055	.0069	.0120	.0071	.0079	.0126	.0071	.0094	.0142	.0071	.0094	.0142
.0039	.0044	.0066	.0047	.0052	.0091	.0055	.0061	.0105	.0071	.0075	.0110	.0071	.0083	.0124	.0071	.0083	.0124
Geometrie -PM, -MM and -GP																	
.0047	.0051	.0060	.0055	.0059	.0069	.0055	.0059	.0076	.0071	.0076	.0094	.0087	.0091	.0107	.0087	.0091	.0107
.0039	.0043	.0047	.0039	.0043	.0047	.0047	.0051	.0055	.0055	.0059	.0063	.0063	.0067	.0072	.0063	.0067	.0072
Geometrie -MM und -GP																	
.0039	.0043	.0047	.0039	.0043	.0047	.0047	.0051	.0055	.0047	.0050	.0063	.0055	.0059	.0069	.0055	.0059	.0069
.0039	.0043	.0047	.0039	.0043	.0047	.0047	.0051	.0055	.0047	.0050	.0063	.0055	.0059	.0069	.0055	.0059	.0069
.0039	.0043	.0050	.0039	.0043	.0050	.0047	.0051	.0057	.0055	.0059	.0069	.0055	.0059	.0076	.0055	.0059	.0076
.0039	.0043	.0047	.0039	.0043	.0050	.0039	.0043	.0050	.0039	.0044	.0050	.0047	.0051	.0057	.0047	.0051	.0057
.0039	.0043	.0047	.0039	.0043	.0050	.0039	.0043	.0050	.0039	.0044	.0050	.0047	.0051	.0057	.0047	.0051	.0057
.0039	.0043	.0050	.0039	.0043	.0050	.0047	.0051	.0057	.0055	.0059	.0069	.0055	.0059	.0069	.0055	.0059	.0069
.0039	.0043	.0047	.0039	.0043	.0050	.0047	.0051	.0055	.0047	.0050	.0063	.0047	.0050	.0063	.0047	.0050	.0063
Geometrie -KM und -GP																	
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189