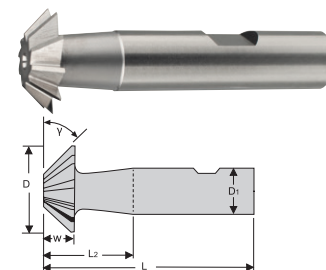


## D forma, 45°

| D<br>mm | γ<br>° | w<br>mm | L2<br>mm | L<br>mm | D1<br>mm | Z  | Előtolás fz<br>acél < 1000 N/mm²<br>mm/fog | Cikkszám    | €      |
|---------|--------|---------|----------|---------|----------|----|--------------------------------------------|-------------|--------|
| 16,0    | 45     | 4       | 15       | 60      | 12       | 10 | 0,01                                       | 291394 0160 | 51,90  |
| 20,0    | 45     | 5       | 18       | 63      | 12       | 10 | 0,014                                      | 291394 0200 | 65,60  |
| 25,0    | 45     | 6,3     | 22       | 67      | 12       | 10 | 0,016                                      | 291394 0250 | 80,30  |
| 32,0    | 45     | 8       | 23       | 71      | 16       | 12 | 0,019                                      | 291394 0320 | 109,50 |

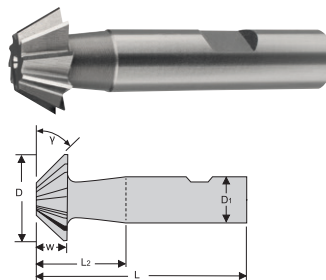
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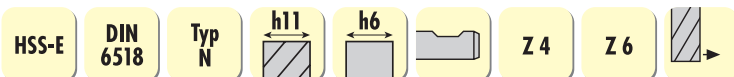
## D forma, 60°

| D<br>mm | γ<br>° | w<br>mm | L2<br>mm | L<br>mm | D1<br>mm | Z  | Előtolás fz<br>acél < 1000 N/mm²<br>mm/fog | Cikkszám    | €      |
|---------|--------|---------|----------|---------|----------|----|--------------------------------------------|-------------|--------|
| 16,0    | 60     | 6,3     | 15       | 60      | 12       | 10 | 0,01                                       | 291395 0160 | 51,90  |
| 20,0    | 60     | 8       | 18       | 63      | 12       | 10 | 0,014                                      | 291395 0200 | 65,60  |
| 25,0    | 60     | 10      | 22       | 67      | 12       | 10 | 0,016                                      | 291395 0250 | 80,30  |
| 32,0    | 60     | 12,5    | 23       | 71      | 16       | 12 | 0,019                                      | 291395 0320 | 109,50 |

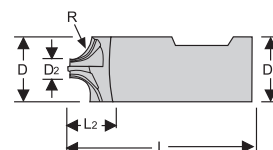
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## SARA® Negyedkör maró, konkáv



- radiális-axiális hátraköszörülés
- Vágószög (axiális) kb. 5°
- a DIN 1835 B szerinti hengeres szár, Ø16mm-es szárátmérőig menesztőfelülettel is



| Alkalmazás                   | ● kiválóan alkalmas<br>○ alkalmas                                                   |                                                                                     | Acél         |                  |             | Rozsdamentes |                                                                                     |                                                                                     | Öntvény |          | Titán-<br>ötvözetek | Szuper-ötv. Fe/NiCo-alapú                                                           |                                                                                       | Alumínium   |                | Réz      | Grafit   | Edzett acél |  |                                                                                           |  |  |  |  |  |  |  |  |  |
|------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|--------------|------------------|-------------|--------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|---------|----------|---------------------|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|-------------|----------------|----------|----------|-------------|--|-------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|
|                              | < 700 N/mm²                                                                         | < 1000 N/mm²                                                                        | < 1400 N/mm² | ferfit./martenz. | ausztenites | duplex       | GG/GTS                                                                              | GGG                                                                                 |         | < 30 HRc | ≥ 30 HRc            | < 8 % Si                                                                            | ≥ 8 % Si                                                                              | Réz ötvözet | GFK/CFK/Durup. | < 55 HRc | < 60 HRc | ≥ 60 HRc    |  |                                                                                           |  |  |  |  |  |  |  |  |  |
|                              |  |  |              |                  |             |              |  |  |         |          |                     |  |  |             |                |          |          |             |  |                                                                                           |  |  |  |  |  |  |  |  |  |
|                              | 30                                                                                  | 30                                                                                  |              |                  |             |              | 25                                                                                  | 25                                                                                  |         |          |                     | 80                                                                                  | 55                                                                                    |             |                |          |          |             |  |                                                                                           |  |  |  |  |  |  |  |  |  |
| Választás sebesség Vc m/min. |                                                                                     |                                                                                     |              |                  |             |              |                                                                                     |                                                                                     |         |          |                     |                                                                                     |                                                                                       |             |                |          |          |             |  | A megadott irányértékeket a munkadarab stabilitásához és a gép állapothoz kell igazítani! |  |  |  |  |  |  |  |  |  |

Vágási sebesség Vc m/min.

A megadott irányértékeket a munkadarab stabilitásához és a gép állapotához kell igazítani!



| R<br>mm | D<br>mm | Furat Ø<br>mm | L2<br>mm | L<br>mm | D1<br>mm | Z | Előtolás fz<br>acél < 1000 N/mm²<br>mm/fog | Cikkszám    | €     |
|---------|---------|---------------|----------|---------|----------|---|--------------------------------------------|-------------|-------|
| 1,0     | 8,0     | 6             | 20       | 60      | 10,0     | 4 | 0,002                                      | 291304 0010 | 52,50 |
| 1,5     | 9,0     | 6             | 20       | 60      | 10,0     | 4 | 0,002                                      | 291304 0015 | 52,50 |
| 1,6     | 9,2     | 6             | 20       | 60      | 10,0     | 4 | 0,002                                      | 291304 0016 | 52,50 |
| 2,0     | 10,0    | 6             | 20       | 60      | 10,0     | 4 | 0,003                                      | 291304 0020 | 52,50 |
| 2,5     | 11,0    | 6             | 20       | 60      | 10,0     | 4 | 0,003                                      | 291304 0025 | 52,50 |
| 3,0     | 12,0    | 6             | 15       | 60      | 12,0     | 4 | 0,003                                      | 291304 0030 | 52,50 |
| 3,5     | 13,0    | 6             | 15       | 60      | 12,0     | 4 | 0,003                                      | 291304 0035 | 56,10 |
| 4,0     | 14,0    | 6             | 15       | 60      | 12,0     | 4 | 0,004                                      | 291304 0040 | 56,10 |
| 4,5     | 15,0    | 6             | 15       | 60      | 12,0     | 4 | 0,004                                      | 291304 0045 | 66,30 |
| 5,0     | 16,0    | 6             | 15       | 60      | 12,0     | 4 | 0,004                                      | 291304 0050 | 66,30 |
| 6,0     | 20,0    | 8             | 19       | 67      | 16,0     | 4 | 0,006                                      | 291304 0060 | 77,60 |
| 6,5     | 21,0    | 8             | 23       | 71      | 16,0     | 4 | 0,006                                      | 291304 0065 | 88,50 |
| 7,0     | 22,0    | 8             | 23       | 71      | 16,0     | 4 | 0,006                                      | 291304 0070 | 88,50 |
| 7,5     | 23,0    | 8             | 23       | 71      | 16,0     | 4 | 0,009                                      | 291304 0075 | 88,50 |

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| R<br>mm | D<br>mm | Furat Ø<br>mm | L2<br>mm | L<br>mm | D1<br>mm | Z | Előtolás fz<br>acél < 1000 N/mm²<br>mm/fog | Cikkszám    | €     |
|---------|---------|---------------|----------|---------|----------|---|--------------------------------------------|-------------|-------|
| 8,0     | 24,0    | 8             | 23       | 71      | 16,0     | 4 | 0,009                                      | 291304 0080 | 88,50 |
| 8,5     | 25,0    | 8             | 29       | 85      | 25,0     | 4 | 0,009                                      | 291304 0085 | 116,- |
| 9,0     | 26,0    | 8             | 29       | 85      | 25,0     | 4 | 0,009                                      | 291304 0090 | 116,- |
| 10,0    | 28,0    | 8             | 29       | 85      | 25,0     | 4 | 0,014                                      | 291304 0100 | 116,- |
| 10,5    | 31,0    | 10            | 34       | 90      | 25,0     | 4 | 0,014                                      | 291304 0105 | 147,- |
| 11,0    | 32,0    | 10            | 34       | 90      | 25,0     | 4 | 0,018                                      | 291304 0110 | 147,- |
| 12,0    | 34,0    | 10            | 34       | 90      | 25,0     | 4 | 0,021                                      | 291304 0120 | 147,- |
| 12,5    | 41,0    | 16            | 40       | 100     | 25,0     | 6 | 0,021                                      | 291304 0125 | 207,- |
| 13,0    | 42,0    | 16            | 40       | 100     | 25,0     | 6 | 0,021                                      | 291304 0130 | 207,- |
| 14,0    | 44,0    | 16            | 40       | 100     | 25,0     | 6 | 0,023                                      | 291304 0140 | 207,- |
| 15,0    | 46,0    | 16            | 44       | 100     | 25,0     | 6 | 0,023                                      | 291304 0150 | 245,- |
| 16,0    | 48,0    | 16            | 44       | 100     | 25,0     | 6 | 0,025                                      | 291304 0160 | 237,- |
| 18,0    | 52,0    | 16            | 52       | 112     | 32,0     | 6 | 0,028                                      | 291304 0180 | 245,- |
| 20,0    | 56,0    | 16            | 52       | 112     | 32,0     | 6 | 0,03                                       | 291304 0200 | 296,- |

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