










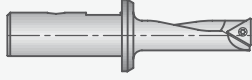
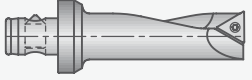
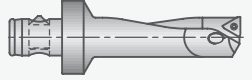
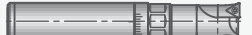

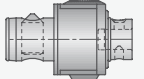
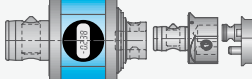
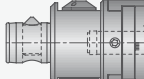
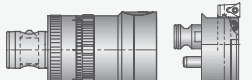
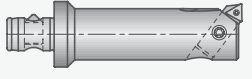
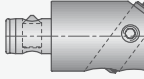
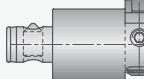
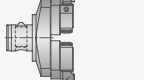



Entscheidungshilfe bei der Werkzeugauswahl

Ø (mm)	L / D	Bearbeitung							
		Durchgangsbohrung	Grundloch	schräg an-/ ausbohren, Schnittunterbrechung	Querbohrung	Rückwärtsbearbeitung	HRC > 54 Durchgangsbohrung	HRC > 54 Grundloch	schwingungsoptimiert
									
0,5 – 9	> 3,5 × D	●	●	◐	◐				●
3 – 8	> 3,5 × D	●	●	◐	◐				●
4 – 8	3 × D	●	●	◐	◐		●	●	●
5,6 – 24	3,5 × D	●	●	◐	◐		●	●	
7,9 – 44	3,5 × D	●	●	◐	◐		●	●	
11,9 – 30	3,5 × D	●	●	◐	◐		●	●	
15,9 – 26	3 × D	●	●	◐	◐		●	●	
5,6 – 26	> 3,5 × D	●	●	◐	◐		○	○	●
0,5 – 103	3 – 6 × D	●	●	◐	◐		●	●	
0,5 – 103	3 – 6 × D	●	●	◐	◐	●	◐	◐	
6 – 125	3,5 × D	●	●	◐	◐		◐	◐	
24,8 – 206	> 3,5 × D	●	●	◐	◐	●	●	●	●
28 – 44	3,5 × D	●	●	◐	◐		●	●	●
20 – 175	> 3,5 × D	●	●	◐	◐		●	●	●
29,5 – 199	> 3,5 × D	●	●	◐	◐		●	●	●
196 – 401	3,5 × D	●	●	◐	◐		●	●	
> 206	> 3,5 × D	●	●	◐	◐				

Kühlmittel		MMS		IT-Bereich	Werkzeug	Anbindung		
Emulsion						rechts		
innen	außen	innen	außen			ABS	Zylinder- schaft	
	●			abhängig von Einbau in Feinverstellkopf		Bohrstange		3.61
●	●			abhängig von Einbau in Feinverstellkopf		UniTurn®		3.63
	●	●	○	abhängig von Einbau in Feinverstellkopf		UniTurn®		3.65
●	●	●	○	abhängig von Einbau in Feinverstellkopf		Bohrstange		3.66
●	●	●	○	abhängig von Einbau in Feinverstellkopf		Bohrstange	3.68	
●	●	●	○	abhängig von Einbau in Feinverstellkopf		Bohrstange	3.70	
●	●	●	○	IT7		MicroKom® M10		3.74
●	●	●	○	abhängig von Einbau in Feinverstellkopf		Bohrstange schwingungsoptimiert		3.72
●	●	●	●	< IT7		MicroKom® M02	3.55 3.57	3.54 3.56
●	●	●	●	< IT7		MicroKom® M040 Wechselbrücke	3.25	3.24
●	●			> IT7		MicroKom® <i>hi.flex</i>		3.12
●	●	●	●	< IT7		MicroKom® M03Speed Wechselbrücke		3.34
●	●	●	●	> IT7		Feinverstellkopf		3.82
●	●	●	●	> IT7		Feinverstellkopf (FZ)		3.76
●	●	●	●	> IT7		Feinverstellkopf (FF)		3.83
●	●	●	●	< IT7		TwinKom® G01		3.86
●	●	●	●	< IT7		TwinKom® Doppelschneider in Leichtbauweise		3.89

