

# Entscheidungshilfe bei der Werkzeugauswahl

Ø (mm)	L / D	Bearbeitung										
		Vollbohren	Grundloch	Schmiede-/Gusshaut, Nahtstelle	schräg an-/ausbohren, Schnittunterbrechung	ballig	Querbohrung	Zentrierbohrung, Sicke	Auskesselung	Paketbohren	Aufbohren	einstellbar
14,0 - 65,0 ±0,2	2 × D	●	●	●	●	●	●	●	●	●	●	●
14,0 - 65,0 ±0,2	3 × D	●	●	●	●	●	●	●	●	●	●	●
15,5 - 44,0 ±0,2	4 × D	●	○	○	○	●						
12,0 - 44,0 ±0,1	2 × D	●	●	●	●	●	●	●	●		●	●
12,0 - 54,0 ±0,1	3 × D	●	●	●	●	●	●	●	●		○	●
14,0 - 44,0 ±0,1	4 × D	●	●	●	○	○	○	○	○			●
38,5 - 82,0 <sup>+1,0</sup> / <sub>-0,5</sub>	3 × D	●	●	○	○	○	○	○	○		○	●
45,0 - 82,0 ±0,2	2 × D	●	●	●	●	●	●	●	●		●	●
45,0 - 82,0 ±0,2	3 × D	●	●	●	●	●	●	●	●			●
17,3 - 44,2 ±0,1	5 × D	●	●	●	○	●	●	○	●	●	○	
20,0 - 81,0 ±0,1	9 × D	●	●	●	○	○	○	○	○			
65,0 - 155,0	bis 9 × D	●	●	●	○	○	○	○	○			●
80,0 - 155,0	6 × D	●	●	●	○	○	○	○	○			●
83,0 - 128,0 ±0,4	4 × D	●	●	●	○	○	○	○	○			
83,0 - 198,0 ±0,5	3 × D	●		●	●	●	●	●	●			
37,0 - 642,0 ±0,5	3 × D		●								●	●
14,0 - 82,0	2 × D	●	●	●	○	●	●	●	●	●	○	○
14,0 - 82,0	3 × D	●	●	●	○	●	●	●	●	●	○	○
14,0 - 44,0	1,5-4×D	●	●	●	●	●	●	●	●			●

Kühlmittel				Werkzeug	Werkstückstoff	Anbindung					
Emulsion		MMS				rechts			links		
innen	außen	innen	außen			ABS	Zylinder- schaft	VDI kompatibel	ABS	VDI kompatibel	
●	◐	●	◐			1.10	1.16				
●	◐	●	◐								
●	◐	●	◐				1.14	1.20			
●	◐	●	◐								
●	◐	●	○				1.26	1.32	1.40	1.50	1.54
●	○	●	○								
●	○	◐	○				1.62				
●	◐	◐	◐								
●	○	◐	○				1.66				
●	○	●	○			1.72	1.72				
●		○				1.92					
●		○				1.102					
●		○				1.106					
●	○	◐	○			1.111					
●	○	◐	○			1.114					
●	◐	◐	○			1.112					
●	◐	◐	○			1.115					
●	○	◐	○								
●	◐	◐	○			Kapitel 4					