

Straight Reduced Shank Drill-bit HSS DIN 338 N MR
Broca con mango cilíndrico reducido HSS DIN 338 N MR
Foret HSS DIN 338 N Queue Réduite

Ref.

1104

1104 HSS DIN 338 N MR
Aceros 400 - 800 N/mm²
Aciers / Steel

Aplicaciones / Applications


TECHNICAL PARAMETERS / CARACTERÍSTICAS TÉCNICAS / CARACTÉRISTIQUES TECHNIQUES

Diameters Diámetros Diamètres	\varnothing mm	Ø10mm – Ø30mm	
Total length Longitud total Longuer total	L mm	DIN 338 N (Catalogue)	
Length of cut Longitud de corte Longuer coupe	l mm	DIN 338 N (Catalogue)	
Tip angle Ángulo de punta Angle de pointe		118°	
Flute angle Ángulo de hélice Angle d'hélice		30°	
Tip Punta Affûtage de la pointe		Conventionnel Convencional	
Material Matériel	Quality Calidad Qualité	HSS – M2	
	Hardness Dureza HRc Dureté	63 - 65	
Shank Mango Queue		Reduced Straight Cilíndrico rebajado Cylindrique Queue Réduite	
Surface Superficie Finition		-	
Main application Aplicación Applications	800 N/mm ²	Aceros 400 - 800 N/mm² Aciers / Steel	
Packing Envasado Conditionnement		Caja 1 uds. Box / Boîte	

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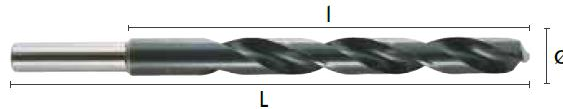
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CUTTING CONDITIONS / CONDICIONES DE CORTE / CONDITION DE COUPE

Material	N/mm ²	Cutting speed V _c m/min.	Avance mm/rpm				
			Ø2	Ø5	Ø10	Ø15	Ø20
1.1 Soft magnetic steel 1.1 Acero magnético blando 1.1 Magnetiques mous	<400	25-35	0.04-0.06	0.08-0.012	0.20-0.30	0.30-0.40	0.35-0.46
1.2 Construction and cement steel 1.2 Acero de construcción y cementación 1.2 Bâtiment et cémentation	<700	20-30	0.04-0.06	0.08-0.012	0.20-0.30	0.30-0.40	0.35-0.46
1.3 Non-alloy carbon Steel 1.3 Acero al carbono no aleado 1.3 Au carbon non allié	<750	15-25	0.02-0.03	0.05-0.07	0.12-0.18	0.18-0.24	0.22-0.28
3.1 Grey cast iron 3.1 Fundición gris 3.1 Fonte gris	<500	25-30	0.04-0.06	0.08-0.012	0.20-0.30	0.30-0.40	0.35-0.46
3.3 Grey with spheroidal cast iron 3.3 Fundición gris con grafito esférico 3.3 Fonte Gris à Graphite Sphéroïdal	<700	12-16	0.04-0.06	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
6.3 Long chipping brass 6.3 Latón de viruta larga 6.3 Laiton copeau long	<700	40-60	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
6.5 Long chipping bronze 6.5 Bronce de viruta larga 6.5 Bronze copeau long	<700	30-50	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
7.2 Alloy aluminium Si<10% 7.2 Aleación de aluminio con Si<10% 7.2 Alliages avec Si<10%	<600	50-60	0.02-0.04	0.05-0.09	0.18-0.21	0.20-0.28	0.25-0.33
8.1 Thermoplastics 8.1 Termoplásticos 8.1 Thermoplastiques	<50	20-25	0.03-0.04	0.06-0.07	0.12-0.13	0.16-0.17	0.25-0.26

Optima / Optimun Alternativo / Alternative