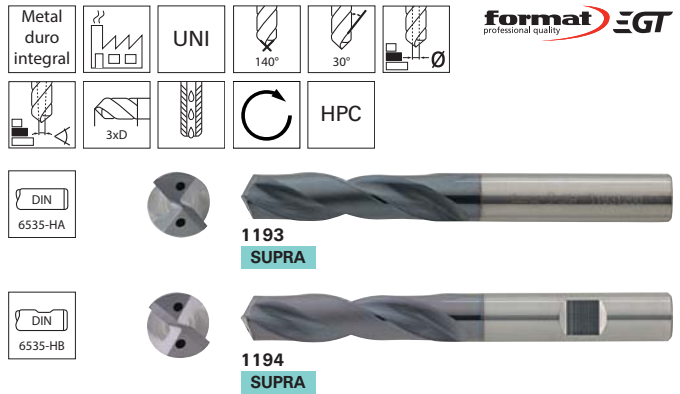


### Broca espiral HPC, 3 x D

Características: Broca espiral estable, multigeometría especial, con cámaras de virutas pulidas.



Aplicación	ACERO			INOX			FUNDICIÓN		ALEACIONES ESPECIALES	METALES NO FÉRRICOS				ACERO TEMPLADO			Ref.
	< 700 N/mm <sup>2</sup>	< 1000 N/mm <sup>2</sup>	< 1400 N/mm <sup>2</sup>	Ferrit./ martens.	Aus-tenítico	Duplex	GG/ GTS	GGG	Titanio > 850 N/mm <sup>2</sup>	Alumi- nio < 8% Si	Alumi- nio > 8% Si	Aleaciones de cobre y cinc	GFRP/CFRP/ Duropl.	< 55 HRC	< 60 HRC	> 60 HRC	
V <sub>c</sub> [m/min]	110	75	45	50	35	-	100	90	50	190	140	120	-	35	-	-	1193
	110	75	45	50	35	-	100	90	50	190	140	120	-	35	-	-	1194

Ø m7 mm	Longitud de la espiral mm	Longitud total mm	Ø de vástago mm	f mm/rev	format EGT		Ref.
					ACERO < 1400 N/mm <sup>2</sup>	1193 SUPRA	
3	20	62	6	0.12	50,26	50,26	...0300
3.1	20	62	6	0.12	50,26	50,26	...0310
3.2	20	62	6	0.12	50,26	50,26	...0320
3.25	20	62	6	0.12	50,26	50,26	...0325
3.3	20	62	6	0.12	50,26	50,26	...0330
3.4	20	62	6	0.12	50,26	50,26	...0340
3.5	20	62	6	0.12	50,26	50,26	...0350
3.6	20	62	6	0.12	50,26	50,26	...0360
3.7	20	62	6	0.12	50,26	50,26	...0370
3.8	24	66	6	0.12	50,26	50,26	...0380
3.9	24	66	6	0.12	50,26	50,26	...0390
4	24	66	6	0.12	50,26	50,26	...0400
4.1	24	66	6	0.12	50,26	50,26	...0410
4.2	24	66	6	0.12	50,26	50,26	...0420
4.3	24	66	6	0.12	50,26	50,26	...0430
4.4	24	66	6	0.12	50,26	50,26	...0440
4.5	24	66	6	0.12	50,26	50,26	...0450
4.6	24	66	6	0.12	50,26	50,26	...0460
4.65	24	66	6	0.12	50,26	50,26	...0465
4.7	24	66	6	0.12	50,26	50,26	...0470
4.8	28	66	6	0.12	50,26	50,26	...0480
4.9	28	66	6	0.12	50,26	50,26	...0490
5	28	66	6	0.12	50,26	50,26	...0500
5.1	28	66	6	0.16	50,26	50,26	...0510
5.2	28	66	6	0.16	50,26	50,26	...0520
5.3	28	66	6	0.16	50,26	50,26	...0530
5.4	28	66	6	0.16	50,26	50,26	...0540
5.5	28	66	6	0.16	50,26	50,26	...0550
5.55	28	66	6	0.16	50,26	50,26	...0555
5.6	28	66	6	0.16	50,26	50,26	...0560
5.7	28	66	6	0.16	50,26	50,26	...0570
5.8	28	66	6	0.16	50,26	50,26	...0580
5.9	28	66	6	0.16	50,26	50,26	...0590
6	28	66	6	0.16	50,26	50,26	...0600
6.1	34	79	8	0.16	66,06	66,06	...0610
6.2	34	79	8	0.16	66,06	66,06	...0620
6.3	34	79	8	0.16	66,06	66,06	...0630
6.4	34	79	8	0.16	66,06	66,06	...0640
6.5	34	79	8	0.16	66,06	66,06	...0650
6.6	34	79	8	0.16	66,06	66,06	...0660
6.7	34	79	8	0.16	66,06	66,06	...0670
6.8	34	79	8	0.16	66,06	66,06	...0680
6.9	34	79	8	0.16	66,06	66,06	...0690
7	34	79	8	0.16	66,06	66,06	...0700
7.1	41	79	8	0.16	66,06	66,06	...0710
7.2	41	79	8	0.16	66,06	66,06	...0720

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Broca espiral HPC, 3 x D

Continuado de la página anterior

Ø m7 mm	Longitud de la espiral mm	Longitud total mm	Ø de vástago mm	ACERO < 1400 N/mm <sup>2</sup> f mm/rev	sumitomo $\geq$ GT		Ref.
					1193 SUPRA €	1194 SUPRA €	
7.3	41	79	8	0.16	66,06	66,06	...0730
7.4	41	79	8	0.16	66,06	66,06	...0740
7.5	41	79	8	0.16	66,06	66,06	...0750
7.6	41	79	8	0.16	66,06	66,06	...0760
7.7	41	79	8	0.16	66,06	66,06	...0770
7.8	41	79	8	0.16	66,06	66,06	...0780
7.9	41	79	8	0.16	66,06	66,06	...0790
8	41	79	8	0.16	66,06	66,06	...0800
8.1	47	89	10	0.16	83,88	83,88	...0810
8.2	47	89	10	0.16	83,88	83,88	...0820
8.3	47	89	10	0.16	83,88	83,88	...0830
8.4	47	89	10	0.16	83,88	83,88	...0840
8.5	47	89	10	0.16	83,88	83,88	...0850
8.6	47	89	10	0.16	83,88	83,88	...0860
8.7	47	89	10	0.16	83,88	83,88	...0870
8.8	47	89	10	0.16	83,88	83,88	...0880
8.9	47	89	10	0.16	83,88	83,88	...0890
9	47	89	10	0.16	83,88	83,88	...0900
9.1	47	89	10	0.21	83,88	83,88	...0910
9.2	47	89	10	0.21	83,88	83,88	...0920
9.3	47	89	10	0.21	83,88	83,88	...0930
9.4	47	89	10	0.21	83,88	83,88	...0940
9.5	47	89	10	0.21	83,88	83,88	...0950
9.6	47	89	10	0.21	83,88	83,88	...0960
9.7	47	89	10	0.21	83,88	83,88	...0970
9.8	47	89	10	0.21	83,88	83,88	...0980
9.9	47	89	10	0.21	83,88	83,88	...0990
10	47	89	10	0.21	83,88	83,88	...1000
10.1	55	102	12	0.21	117,44	117,44	...1010
10.2	55	102	12	0.21	117,44	117,44	...1020
10.3	55	102	12	0.21	117,44	117,44	...1030
10.4	55	102	12	0.21	117,44	117,44	...1040
10.5	55	102	12	0.21	117,44	117,44	...1050
10.6	55	102	12	0.21	117,44	117,44	...1060
10.7	55	102	12	0.21	117,44	117,44	...1070
10.8	55	102	12	0.21	117,44	117,44	...1080
10.9	55	102	12	0.21	117,44	117,44	...1090
11	55	102	12	0.21	117,44	117,44	...1100
11.1	55	102	12	0.21	117,44	117,44	...1110
11.2	55	102	12	0.21	117,44	117,44	...1120
11.3	55	102	12	0.21	117,44	117,44	...1130
11.4	55	102	12	0.21	117,44	117,44	...1140
11.5	55	102	12	0.21	117,44	117,44	...1150
11.6	55	102	12	0.21	117,44	117,44	...1160
11.7	55	102	12	0.21	117,44	117,44	...1170
11.8	55	102	12	0.21	117,44	117,44	...1180
11.9	55	102	12	0.21	117,44	117,44	...1190
12	55	102	12	0.21	117,44	117,44	...1200
12.2	60	107	14	0.27	152,06	152,06	...1220
12.3	60	107	14	0.27	152,06	152,06	...1230
12.5	60	107	14	0.27	152,06	152,06	...1250
12.8	60	107	14	0.27	152,06	152,06	...1280
13	60	107	14	0.27	152,06	152,06	...1300
13.5	60	107	14	0.27	152,06	152,06	...1350
13.8	60	107	14	0.27	152,06	152,06	...1380
14	60	107	14	0.27	152,06	152,06	...1400
14.2	65	115	16	0.27	181,39	181,39	...1420
14.5	65	115	16	0.27	181,39	181,39	...1450
14.8	65	115	16	0.27	181,39	181,39	...1480
15	65	115	16	0.27	181,39	181,39	...1500
15.1	65	115	16	0.27	181,39	181,39	...1510
15.2	65	115	16	0.27	181,39	181,39	...1520
15.5	65	115	16	0.27	181,39	181,39	...1550
15.8	65	115	16	0.27	181,39	181,39	...1580
16	65	115	16	0.27	181,39	181,39	...1600
16.5	73	123	18	0.35	277,85	277,85	...1650
16.8	73	123	18	0.35	277,85	277,85	...1680
17	73	123	18	0.35	277,85	277,85	...1700
17.3	73	123	18	0.35	277,85	277,85	...1730

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### Broca espiral HPC, 3 x D

Continuado de la página anterior

Ø m7 mm	Longitud de la espiral mm	Longitud total mm	Ø de vástago mm	ACERO < 1400 N/mm <sup>2</sup> f mm/rev	format EGT	format EGT	Ref.
					1193 SUPRA	1194 SUPRA	
17.5	73	123	18	0.35	277,85	277,85	...1750
17.7	73	123	18	0.35	277,85	277,85	...1770
17.8	73	123	18	0.35	277,85	277,85	...1780
18	73	123	18	0.35	277,85	277,85	...1800
18.5	79	131	20	0.35	314,55	314,55	...1850
19	79	131	20	0.35	314,55	314,55	...1900
19.3	79	131	20	0.35	314,55	314,55	...1930
19.5	79	131	20	0.35	314,55	314,55	...1950
19.8	79	131	20	0.35	314,55	314,55	...1980
20	79	131	20	0.35	314,55	314,55	...2000

(W111) (W111)

### Broca espiral HPC, 5 x D

Características: Broca espiral estable, multigeometría especial, con cámaras de virutas pulidas.

Metal duro integral


UNI

140°


30°

5xD


HPC



DIN 6535-HA  
**1195**  
SUPRA



DIN 6535-HB  
**1197**  
SUPRA



Aplicación	ACERO			INOX			FUNDICIÓN		ALEACIONES ESPECIALES	METALES NO FÉRRICOS				ACERO TEMPLADO			Ref.
	< 700 N/mm <sup>2</sup>	< 1000 N/mm <sup>2</sup>	< 1400 N/mm <sup>2</sup>	Ferrit./martens.	Austenítico	Duplex	GG/GTS	GGG	Titanio > 850 N/mm <sup>2</sup>	Aluminio < 8% Si	Aluminio > 8% Si	Aleaciones de cobre y cinc	GFRP/CFRP/Duropl.	< 55 HRC	< 60 HRC	> 60 HRC	
V <sub>c</sub> [m/min]	105	70	40	45	30	-	95	85	45	185	135	120	-	30	-	-	1195
	105	70	40	45	30	-	95	85	45	185	135	120	-	30	-	-	1197

Ø m7 mm	Longitud de la espiral mm	Longitud total mm	Ø de vástago mm	ACERO < 1400 N/mm <sup>2</sup> f mm/rev	format EGT	format EGT	Ref.
					1195 SUPRA	1197 SUPRA	
1	10	55	3	0.06	62,90	-	...0100
1.1	12	55	3	0.06	62,90	-	...0110
1.2	12	55	3	0.06	62,90	-	...0120
1.3	12	55	3	0.06	62,90	-	...0130
1.4	12	55	3	0.06	62,90	-	...0140
1.5	12	55	3	0.06	62,90	-	...0150
1.6	16	55	3	0.06	62,90	-	...0160
1.7	16	55	3	0.06	62,90	-	...0170
1.8	16	55	3	0.06	62,90	-	...0180
1.9	16	55	3	0.06	62,90	-	...0190
2	16	57	3	0.06	62,90	-	...0200
2.1	21	57	3	0.08	62,90	-	...0210
2.2	21	57	3	0.08	62,90	-	...0220
2.3	21	57	3	0.08	62,90	-	...0230
2.4	21	57	3	0.08	62,90	-	...0240
2.5	21	57	3	0.08	62,90	-	...0250
2.6	21	57	3	0.08	62,90	-	...0260
2.7	21	57	3	0.08	62,90	-	...0270

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