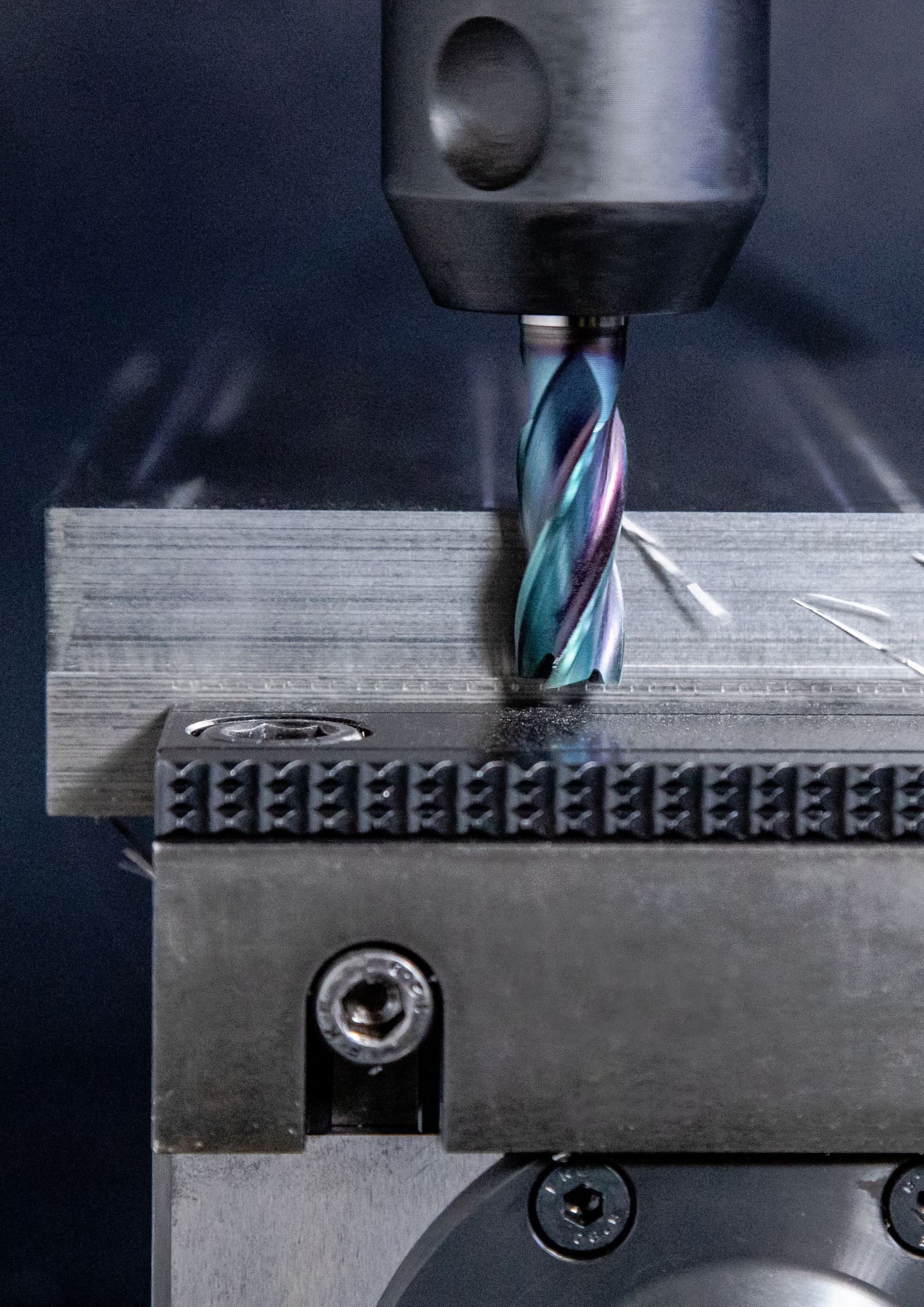
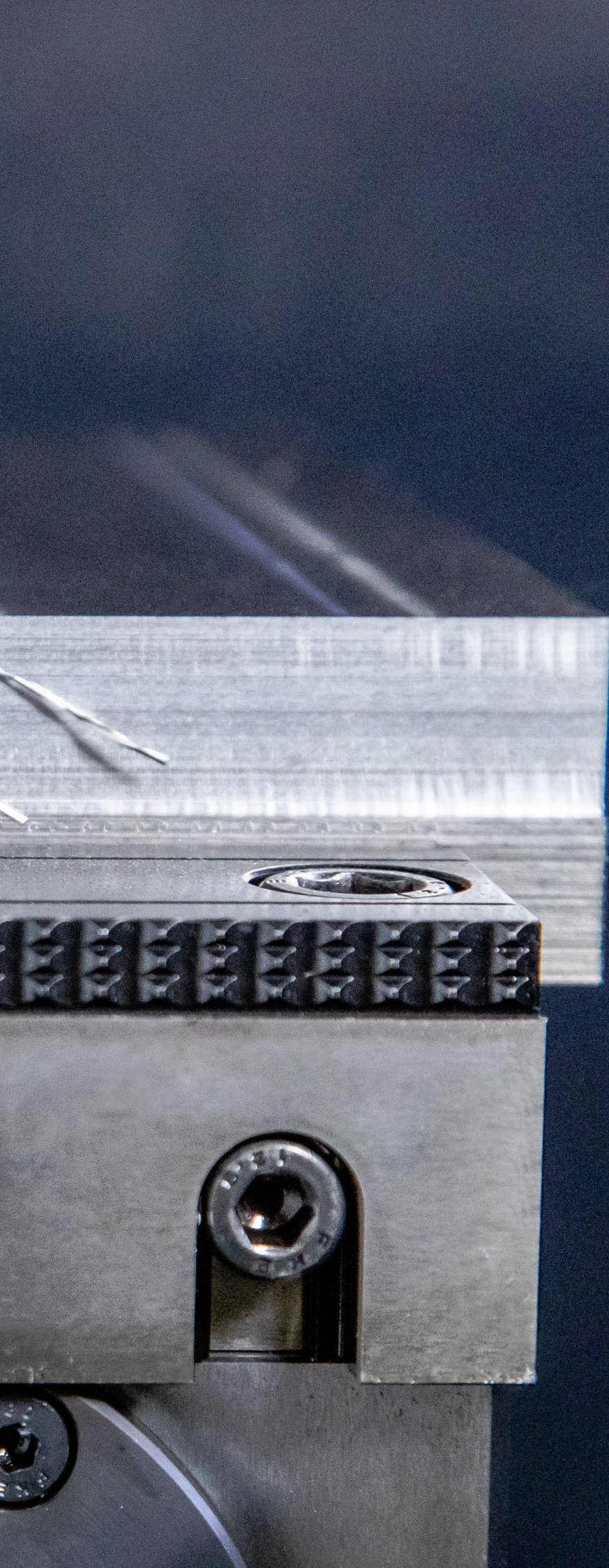






Obrada provrta

- | | |
|---|-----------------------------|
| 1 | HSS svrdla |
| 2 | VHM svrdla |
| 3 | Svrdla s okretnim pločicama |
| 4 | Razvrtači i upuštači |
| 5 | Alati za razvrtanje |

Obrada navoja

- | | |
|---|--|
| 6 | Navojna svrdla i alati za oblikovanje navoja |
| 7 | Cirkularna glodala i glodala za navoje |
| 8 | Alati za tokarenje navoja |

Obrada tokarenjem

- | | |
|----|-------------------------------------|
| 9 | Tokarski alati s okretnim pločicama |
| 10 | EcoCut |
| 11 | Ubodni alati |
| 12 | Minijaturni tokarski alati |

Obrada glodanjem

- | | |
|----|--|
| 13 | HSS glodala |
| 14 | VHM glodala |
| 15 | Alati za glodanje s okretnim pločicama |

Naprezanje alata

- | | |
|----|----------------|
| 16 | Prihvati alata |
| 17 | Pribor |

- | | |
|----|---|
| 18 | Primjeri materijala i popis narudžbenih brojeva |
|----|---|

Sadržaj

Objašnjenje simbola	2
Toolfinder	3
Pregled sadržaja	4+5
Proizvodni program	6-38
Tehničke informacije	
Podaci o rezanju	39-46
Formule za izračun podataka o rezanju	47
Prevlaka	47

WNT \ Performance

Alati vrhunske kvalitete za vrhunske radne učinke.

Alati vrhunske kvalitete iz linije proizvoda **WNT Performance** koncipirani su za specijalne primjene i odlikuju se izvanrednim radnim karakteristikama. Ako u svojoj proizvodnji postavite najviše zahtjeve u smislu radnog učinka te očekujete najbolje moguće rezultate, preporučujemo vrhunske alate iz ove linije proizvoda.

Objašnjenje simbola

Držak



Izvedba držaka



Duljina za ugradnju: vrlo kratka/kratka/srednja/
dugačka/vrlo dugačka



Prijelom ruba



Oštro



Skošenje (CHW = širina skošenja u mm)



Puni radijus



Primjena



Primjer obrade



Crvene strelice prikazuju moguće smjerove posmaka



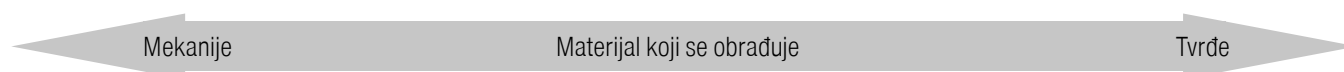
Broj zubaca



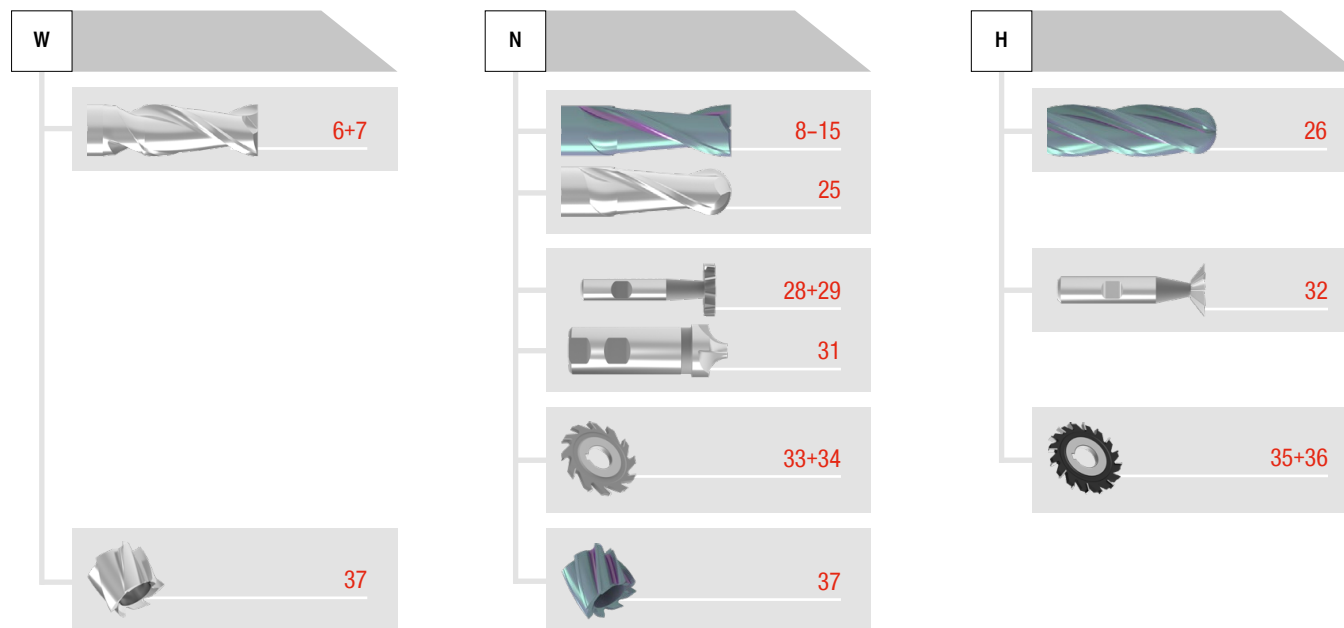
Geometrija oštrice
 $\lambda_s = 30^\circ$ = kut zakretanja
 $\gamma_s = 12^\circ$ = kut odvođenja strugotina

- = Glavna primjena
- = Sporedna primjena

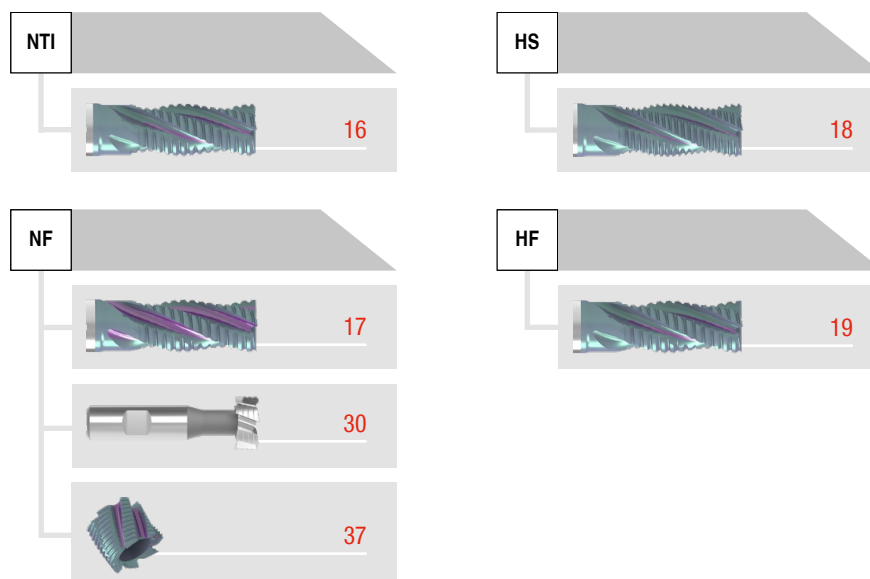
Toolfinder



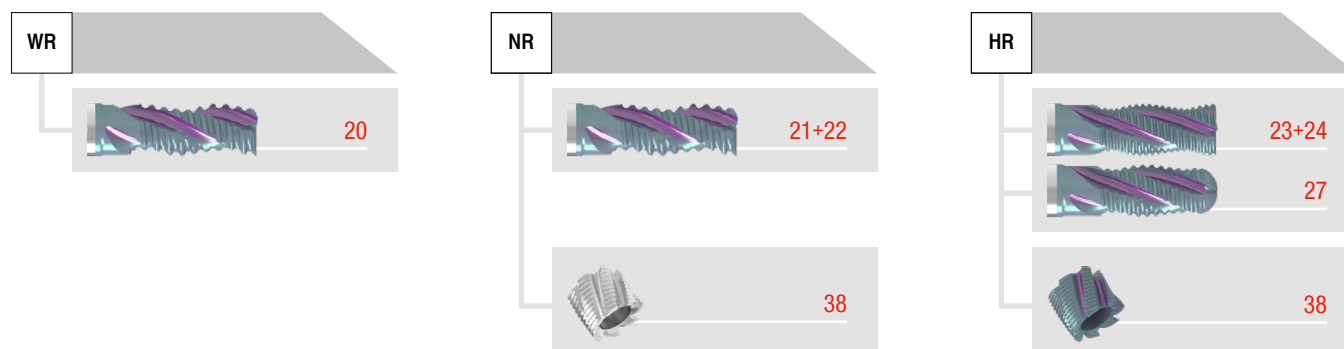
Fina obrada



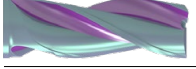
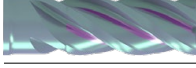
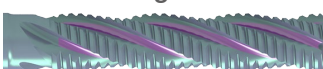
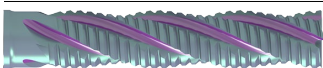
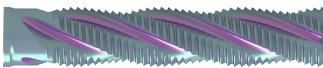
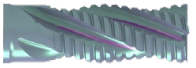
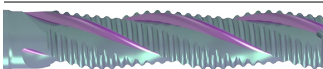
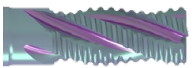
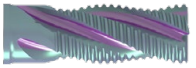
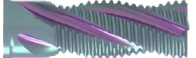
Gruba i fina obrada



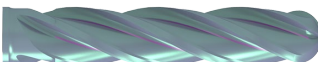
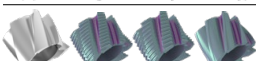
Gruba obrada



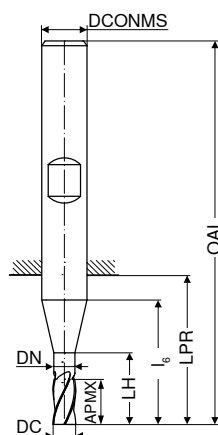
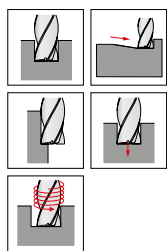
Pregled HSS glodala

Vrsta alata	Broj zubaca ZEFP	Ø DC	Promjer u mm	Materijal					Oštro	Skošenje	Radijus	Puni radijus	Ugradna duljina	Materijal, npr. PM = praškasti čelik	S prevlakom		WNT / Performance
				Čelik	Nehrđajući čelik	Lijevano željezo	Neželjezni metali	Visokootporan na toplinu							Kaljeni čelik	Bez prevlake	
Glodala za finu obradu																	
	W	2	2-22											HSS-E			6
	W	3-4	2-40											HSS-E			7
	N	2	1-26											HSS-E			8+9
	N	3	1-10											HSS-E			10
	N	3	1,8-24,7											HSS-E			11+12
	N	4-5	4-25											HSS-E			13
	N	4-8	2-50											HSS-E			14+15
Glodala za grubu i finu obradu																	
	NTI	4-6	6-40											PM			16
	NF	4-5	6-28											HSS-E			17
	HS	4-6	6-40											PM			18
	HF	4	6-25											PM			19
Glodala za grubu obradu																	
	WR	3	6-32											HSS-E			20
	NR	3	6-25											HSS-E			21
	NR	4-6	6-40											HSS-E			22
	HR	4-6	6-32											PM			23
	HR	3-6	4-32											HSS-E			24

Pregled HSS glodala

Vrsta alata	Broj zubaca 	Promjer u mm Ø DC										Ugradna duljina	Materijal, npr. PM = praškasti čelik	 S prevlakom  Bez prevlake	WNT / Performance	
			Čelik	Nehrđajući čelik	Lijevano željezo	Neželjezni metali	Visokootporan na toplinu									Kaljeni čelik
Radijusno glodala																
	N	2	2-30									HSS-E			25	
	H	4-5	6-25									HSS-E			26	
	HR	4	6-20									HSS-E			27	
Profilirana/pločasta/valjkasta čeona glodala																
	N	6-10	11-60									HSS-E			28	
	N	6-12	10,5-45,5									HSS-E			29	
	NF	6-8	21-45									HSS-E			30	
	N	4-6	1-16									HSS-E			31	
	H	10	16-25									HSS-E			32	
	N	14-28										HSS			33	
		12-52										HSS-E			34-36	
		6-12										HSS-E			37+38	

Glodalo za uzdužne utore HSS-E Co 8



DIN 844



U6

Artikl br.

50 144 ...

EUR

DC _{ø8}	APMX	DN	LH	I ₆	LPR	OAL	DCONMS _{n6}	ZEFP	
mm	mm	mm	mm	mm	mm	mm	mm		
2,0	7		7	13	15	51	6	2	21,30 020
2,5	8		8	14	16	52	6	2	21,30 025
3,0	8		8	14	16	52	6	2	21,30 030
3,5	10		10	16	18	54	6	2	21,30 035
4,0	11		11	17	19	55	6	2	21,30 040
4,5	11		11	17	19	55	6	2	21,30 045
5,0	13		13	19	21	57	6	2	21,30 050
5,5	13		13	19	21	57	6	2	21,30 055
6,0	13		13	19	21	57	6	2	21,30 060
6,5	16	6,0	22	24	26	66	10	2	28,71 065
7,0	16	6,5	22	24	26	66	10	2	28,71 070
8,0	19	7,5	25	27	29	69	10	2	28,71 080
9,0	19	8,5	26	27	29	69	10	2	28,71 090
10,0	22	9,5	30	30	32	72	10	2	28,71 100
12,0	26	11,5	36	36	38	83	12	2	37,94 120
14,0	26	11,5	36	36	38	83	12	2	42,18 140
16,0	32	15,0	42	42	44	92	16	2	50,97 160
18,0	32	15,0	42	42	44	92	16	2	62,73 180
20,0	38	19,0	52	52	54	104	20	2	75,67 200
22,0	38	19,0	52	52	54	104	20	2	120,90 220

Čelik

Nehrđajući čelik

Lijevano željezo

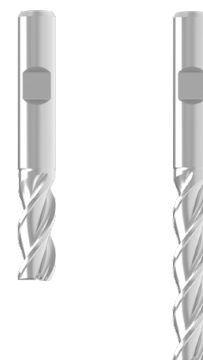
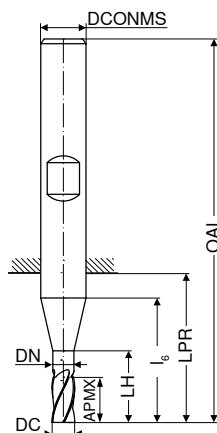
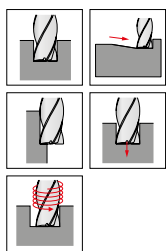
Neželjezni metali

Visokootporan na toplinu

Kaljeni čelik

→ v_c/f_z Stranica 40-42

Vretenasto glodalo HSS-E Co 8



DIN 69844



DIN 844



DC _{k10}	APMX	DN	LH	l_6	LPR	OAL	DCONMS _{n6}	ZEFP
mm	mm	mm	mm	mm	mm	mm	mm	
2	7		7	13	15	51	6	3
3	8		8	14	16	52	6	3
3	12		12	18	20	56	6	3
4	11		11	17	19	55	6	3
4	19		19	25	27	63	6	3
5	13		13	19	21	57	6	3
5	24		24	30	32	68	6	3
6	13	5,5	19	19	21	57	6	3
6	24	5,5	30	30	32	68	6	3
7	16	6,5	22	24	26	66	10	3
7	30	6,5	36	38	40	80	10	3
8	19	7,5	25	27	29	69	10	3
8	38	7,5	44	46	48	88	10	3
9	19	8,5	26	27	29	69	10	3
9	38	8,5	45	46	48	88	10	3
10	22	9,5	30	30	32	72	10	3
10	45	9,5	53	53	55	95	10	3
12	26	11,5	36	36	38	83	12	3
12	53	11,5	63	63	65	110	12	3
14	26	11,5	36	36	38	83	12	3
14	53	11,5	63	63	65	110	12	3
16	32	15,0	42	42	44	92	16	3
16	63	15,0	73	73	75	123	16	3
18	32	15,0	42	42	44	92	16	3
18	63	15,0	73	73	75	123	16	3
20	38	19,0	52	52	54	104	20	3
20	75	19,0	89	89	91	141	20	3
22	38	19,0	52	52	54	104	20	3
22	75	19,0	89	89	91	141	20	3
24	90	23,0	106	108	110	166	25	3
25	45	24,0	63	45	65	121	25	4
25	90	24,0	108	108	110	166	25	4
28	90	24,0	108	108	110	166	25	4
30	90	24,0	108	108	110	166	25	4
32	106	31,0	123	123	126	186	32	4
36	106	31,0	123	123	126	186	32	4
40	125	38,0	142	142	147	217	40	4

U8	U8
Artikl br. 50 120 ...	Artikl br. 50 121 ...
EUR	EUR
36,88	
35,39	
	40,37
29,89	
	41,43
29,89	
	41,43
31,69	
	39,31
41,86	
	59,03
37,41	
	47,27
48,54	
	65,92
42,82	
	53,31
50,34	
	59,03
63,69	
	68,89
59,77	
	72,81
98,98	
	121,90
97,07	
	116,60
140,90	
	174,80
	223,60
154,80	
	212,00
	239,50
	302,00
	311,60
	431,30
	550,10

Čelik

Nehrđajući čelik

Lijevano željezo

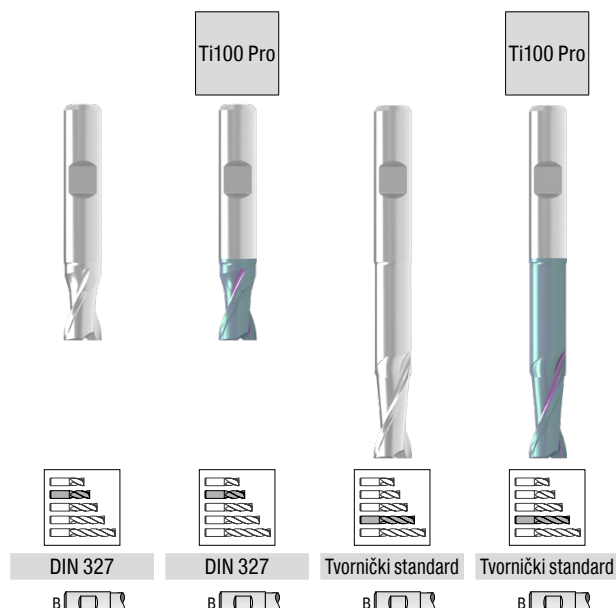
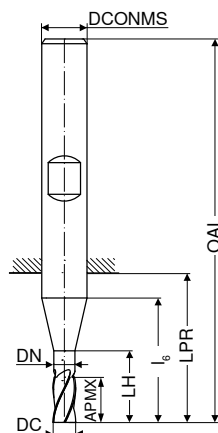
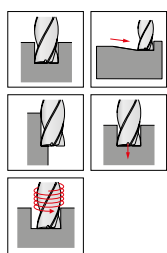
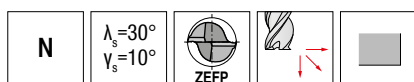
Neželjezni metali

Visokootporan na toplinu

Kaljeni čelik

→ v_c/f_z Stranica 40-42

Glodalo za uzdužne uture HSS-E Co 8



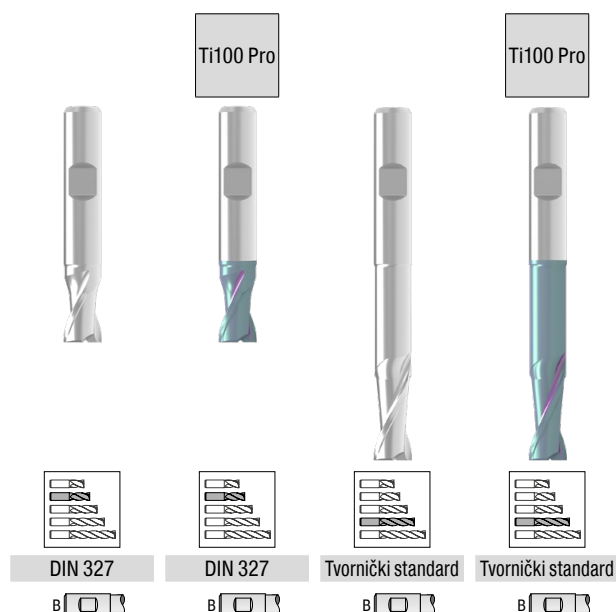
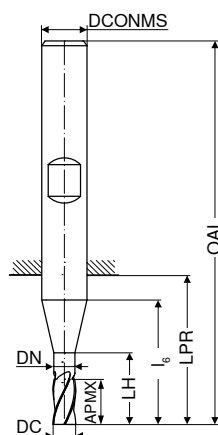
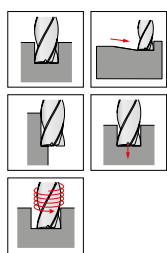
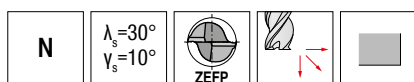
DC	Tol.	APMX	DN	LH	I ₆	LPR	OAL	DCONMS _{h6}	ZEFP	U8 Artikl br. 50 100 ... EUR	U8 Artikl br. 54 025 ... EUR	U8 Artikl br. 50 122 ... EUR	U8 Artikl br. 54 020 ... EUR
1,00	h10	2,5		2,5	9	11	47	6	2	31,16 010 ¹⁾	35,61 010 ¹⁾		
1,50	h10	3,0		3,0	9	11	47	6	2	29,14 015 ¹⁾	35,61 015 ¹⁾		
1,80	h10	4,0		4,0	10	12	48	6	2	14,31 018	36,35 018		
2,00	e8	4,0		4,0	10	12	48	6	2	17,07 020	29,99 020		
2,50	e8	5,0		5,0	11	13	49	6	2	17,07 025	29,99 025		
2,80	h10	5,0		5,0	11	13	49	6	2	17,07 028	31,37 028		
3,00	e8	5,0		5,0	11	13	49	6	2	15,58 030	29,99 030		
3,00	e8	8,0		8,0	18	20	56	6	2			25,01 030	44,19 030
3,50	h10	6,0		6,0	12	14	50	6	2	16,95 035	31,37 035		
3,50	h10	10,0		10,0	21	23	59	6	2			31,05 035	48,43 035
3,80	h10	7,0		7,0	13	15	51	6	2	17,70 038	34,98 038		
4,00	e8	7,0		7,0	13	15	51	6	2	15,58 040	26,38 040		
4,00	e8	11,0		11,0	25	27	63	6	2			26,81 040	44,19 040
4,50	h10	7,0		7,0	13	15	51	6	2	19,40 045	31,37 045		
4,50	h10	11,0		11,0	25	27	63	6	2			34,02 045	48,43 045
4,80	h10	8,0		8,0	14	16	52	6	2	19,40 048	34,98 048		
5,00	e8	8,0		8,0	14	16	52	6	2	15,58 050	29,99 050		
5,00	e8	13,0		13,0	30	32	68	6	2			25,97 050	44,19 050
5,50	h10	8,0		8,0	14	16	52	6	2	19,40 055	31,37 055		
5,50	h10	13,0		13,0	30	32	68	6	2			34,02 055	48,43 055
5,75	h10	8,0		8,0	14	16	52	6	2	19,50 057	34,98 057		
6,00	e8	8,0	5,50	14,0	14	16	52	6	2	15,58 060	29,99 060		
6,00	e8	13,0	5,50	30,0	30	32	68	6	2			28,40 060	42,82 060
6,50	h10	10,0	6,00	16,0	18	20	60	10	2	21,40 065	36,98 065		
6,50	h10	16,0	6,35	36,0	38	40	80	10	2			40,70 065	59,77 065
6,75	h10	10,0	6,50	16,0	18	20	60	10	2	23,95 067	39,31 067		
7,00	e8	10,0	6,50	16,0	18	20	60	10	2	22,79 070	35,61 070		
7,00	e8	16,0	6,35	36,0	38	40	80	10	2			35,71 070	55,54 070
7,50	h10	10,0	7,00	16,0	18	20	60	10	2	24,27 075	36,98 075		
7,50	h10	16,0	7,35	36,0	38	40	80	10	2			41,76 075	59,77 075
7,75	h10	11,0	7,50	17,0	19	21	61	10	2	23,95 077	39,31 077		
8,00	e8	11,0	7,50	17,0	19	21	61	10	2	20,66 080	35,61 080		
8,00	e8	19,0	7,35	44,0	46	48	88	10	2			31,05 080	54,89 080
8,50	h10	11,0	8,00	18,0	19	21	61	10	2	24,27 085	46,31 085		
8,50	h10	19,0	8,35	45,0	46	48	88	10	2			44,82 085	63,38 085
8,70	h10	11,0	8,50	18,0	19	21	61	10	2	29,78 087	49,91 087		
9,00	h10	11,0	8,50	18,0	19	21	61	10	2	23,74 090	45,68 090		
9,00	h10	19,0	8,35	45,0	46	48	88	10	2			40,70 090	64,12 090
9,50	h10	11,0	9,00	18,0	19	21	61	10	2	29,78 095	46,31 095		
9,50	h10	19,0	9,35	45,0	46	48	88	10	2			46,10 095	66,98 095
9,70	h10	13,0	9,50	21,0	21	23	63	10	2	29,04 097	49,91 097		
10,00	e8	13,0	9,50	21,0	21	23	63	10	2	22,68 100	39,96 100		
10,00	e8	22,0	9,35	53,0	53	55	95	10	2			33,70 100	57,01 100
10,50	h10	13,0	10,00	21,0	23	25	70	12	2	42,60 105	54,15 105		
10,70	h10	13,0	10,50	21,0	23	25	70	12	2	39,53 107	59,13 107		
11,00	h10	13,0	10,50	21,0	23	25	70	12	2	36,88 110	49,28 110		
11,00	h10	22,0	10,50	53,0	55	57	102	12	2			47,05 110	68,36 110
11,50	h10	13,0	11,00	21,0	23	25	70	12	2	42,39 115	54,89 115		

Čelik	●	●	●	●
Nehrdajući čelik	○	●	○	●
Lijevano željezo	●	●	●	●
Neželjezni metali	○	○	○	○
Visokootporan na toplinu	○	○	○	○
Kaljeni čelik				

1) Tvornički standard

→ v_c/f_z Stranica 40-42

Glodalo za uzdužne uture HSS-E Co 8



DC	Tol.	APMX	DN	LH	l_6	LPR	OAL	DCONMS _{h6}	ZEFP	U8 Artikl br. 50 100 ... EUR	U8 Artikl br. 54 025 ... EUR	U8 Artikl br. 50 122 ... EUR	U8 Artikl br. 54 020 ... EUR
11,70	h10	16,0	11,50	26,0	26	28	73	12	2	42,39	58,40		
12,00	e8	16,0	11,50	26,0	26	28	73	12	2	30,94	49,28		
12,00	e8	26,0	11,50	63,0	63	65	110	12	2			38,79	64,96
12,70	h10	16,0	11,50	26,0	26	28	73	12	2	47,58	81,18		
13,00	h10	16,0	11,50	26,0	26	28	73	12	2	42,39	72,70		
13,00	h10	26,0	11,50	63,0	63	65	110	12	2			63,91	94,01
13,70	h10	16,0	11,50	26,0	26	28	73	12	2	58,93	76,94		
14,00	e8	16,0	11,50	26,0	26	28	73	12	2	40,37	66,98		
14,00	e8	26,0	11,50	63,0	63	65	110	12	2			49,17	89,76
14,70	h10	16,0	11,50	26,0	26	28	73	12	2	65,07			
15,00	h10	16,0	11,50	26,0	26	28	73	12	2	49,17	72,70		
15,00	h10	26,0	11,50	63,0	63	65	110	12	2			60,51	101,30
15,70	h10	19,0	15,00	29,0	29	31	79	16	2	64,32	84,15		
16,00	e8	19,0	15,00	29,0	29	31	79	16	2	45,04	72,70		
16,00	e8	32,0	15,00	73,0	73	75	123	16	2			58,71	98,46
16,70	h10	19,0	15,00	29,0	29	31	79	16	2	74,71			
17,00	h10	19,0	15,00	29,0	29	31	79	16	2	57,97	104,10		
17,00	h10	32,0	15,00	73,0	73	75	123	16	2			76,51	147,30
17,70	h10	19,0	15,00	29,0	29	31	79	16	2	78,31	104,10		
18,00	e8	19,0	15,00	29,0	29	31	79	16	2	61,68	92,73		
18,00	e8	32,0	15,00	73,0	73	75	123	16	2			77,04	132,50
19,00	h10	19,0	15,00	29,0	29	31	79	16	2	74,82	115,50		
19,00	h10	32,0	15,00	73,0	73	75	123	16	2			83,72	153,70
19,70	h10	22,0	19,00	36,0	36	38	88	20	2	89,44	115,50		
20,00	e8	22,0	19,00	36,0	36	38	88	20	2	69,84	99,73		
20,00	e8	38,0	19,00	89,0	89	91	141	20	2			77,37	135,60
21,70	h10	22,0	19,00	36,0	36	38	88	20	2	124,00	166,40		
22,00	e8	22,0	19,00	36,0	36	38	88	20	2	85,42	142,10		
22,00	e8	38,0	19,00	89,0	89	91	141	20	2			133,50	177,00
23,70	h10	26,0	23,00	42,0	44	46	102	25	2	131,50	191,80		
24,00	e8	26,0	23,00	42,0	44	46	102	25	2	111,30	172,70		
24,00	e8	45,0	23,00	106,0	108	110	166	25	2			165,40	246,90
24,70	h10	26,0	24,00	44,0	44	46	102	25	2	130,30	197,10		
25,00	e8	26,0	24,00	44,0	44	46	102	25	2	105,50	171,70		
25,00	e8	45,0	24,00	108,0	108	110	166	25	2			165,40	204,60
26,00	h10	26,0	24,00	44,0	44	46	102	25	2	128,20	222,60		

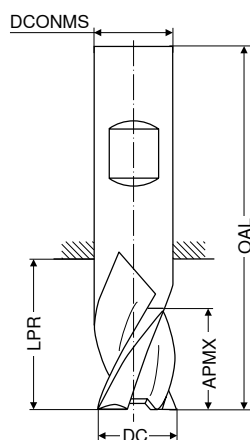
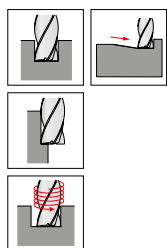
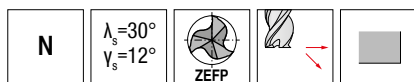
Čelik	●	●	●	●
Nehrdajući čelik	○	●	○	●
Lijevano željezo	●	●	●	●
Neželjezni metali	○	○	○	○
Visokootporan na toplinu	○	○	○	○
Kaljeni čelik				

1) Tvornički standard

→ v_d/f_t Stranica 40-42

Jednokratno glodalo HSS-E Co 8

▲ Držak kao DIN 1835 B



Tvornički standard

Tvornički standard

Tvornički standard

Tvornički standard



DC _{es}	APMX	LPR	OAL	DCONMS _{n6}	ZEFP	U6 Artikl br. 50 092 ... EUR		U8 Artikl br. 54 014 ... EUR		U6 Artikl br. 50 093 ... EUR		U8 Artikl br. 54 042 ... EUR	
1,00	2	8	34	6	3	11,34	010	22,46	010				
1,50	3	8	34	6	3	11,34	015	22,46	015				
1,50	4	10	35	6	3					13,25	015 ¹⁾	25,12	015 ¹⁾
1,80	3	8	34	6	3	11,34	018	22,46	018				
2,00	4	9	35	6	3	11,34	020	22,46	020	13,25	020 ¹⁾	25,12	020
2,30	4	9	35	6	3	11,34	023	22,46	023				
2,50	5	10	36	6	3	11,34	025	22,46	025	13,25	025 ¹⁾	25,12	025
2,50	8	13	39	6	3					13,25	025 ¹⁾	25,12	025
2,80	5	10	36	6	3	11,34	028	22,46	028				
3,00	5	10	36	6	3	11,34	030	22,46	030	13,25	030 ¹⁾	25,12	030
3,00	8	13	39	6	3					13,25	030 ¹⁾	25,12	030
3,30	6	11	37	6	3	11,34	033	22,46	033				
3,50	6	11	37	6	3	11,34	035	22,46	035	13,25	035 ¹⁾	25,12	035
3,50	10	15	41	6	3					13,25	035 ¹⁾	25,12	035
3,80	7	12	38	6	3	11,34	038	22,46	038				
4,00	7	12	38	6	3	11,34	040	22,46	040	13,25	040 ¹⁾	25,12	040
4,00	11	16	42	6	3					13,25	040 ¹⁾	25,12	040
4,30	7	12	38	6	3	11,34	043	22,46	043				
4,50	7	12	38	6	3	11,34	045	22,46	045	13,25	045 ¹⁾	25,12	045
4,50	11	16	42	6	3					13,25	045 ¹⁾	25,12	045
4,80	8	13	39	6	3	11,34	048	22,46	048				
5,00	8	13	39	6	3	11,34	050	22,46	050	13,25	050 ¹⁾	25,12	050
5,00	13	18	44	6	3					13,25	050 ¹⁾	25,12	050
5,30	8	13	39	6	3	11,34	053	22,46	053				
5,50	8	13	39	6	3	11,34	055	22,46	055	13,25	055 ¹⁾	25,12	055
5,50	13	18	44	6	3					13,25	055 ¹⁾	25,12	055
5,75	8	13	39	6	3	11,34	057	22,46	057				
6,00	8	13	39	6	3	11,34	060	22,46	060	13,25	060 ¹⁾	25,12	060
6,00	13	18	44	6	3					13,25	060 ¹⁾	25,12	060
6,50	10	14	42	8	3	13,15	065	30,63	065	15,68	065 ¹⁾	33,49	065
6,50	16	20	48	8	3					15,68	065 ¹⁾	33,49	065
7,00	10	14	42	8	3	13,15	070	30,63	070	15,68	070 ¹⁾	33,49	070
7,00	16	20	48	8	3					15,68	070 ¹⁾	33,49	070
7,50	10	14	42	8	3	13,15	075	30,63	075	15,68	075 ¹⁾	33,49	075
7,50	16	20	48	8	3					15,68	075 ¹⁾	33,49	075
8,00	11	15	43	8	3	13,15	080	30,63	080	15,68	080 ¹⁾	33,49	080
8,00	19	23	51	8	3					15,68	080 ¹⁾	33,49	080
8,50	11	16	48	10	3	17,07	085	34,98	085	19,60	085 ¹⁾	37,51	085
8,50	19	24	56	10	3					19,60	085 ¹⁾	37,51	085
9,00	11	16	48	10	3	17,07	090	34,98	090	19,60	090 ¹⁾	37,51	090
9,00	19	24	56	10	3					19,60	090 ¹⁾	37,51	090
9,50	11	16	48	10	3	17,07	095	34,98	095	19,60	095 ¹⁾	37,51	095
9,50	19	24	56	10	3					19,60	095 ¹⁾	37,51	095
10,00	13	18	50	10	3	17,07	100	34,98	100	19,60	100 ¹⁾	37,51	100
10,00	22	27	59	10	3					19,60	100 ¹⁾	37,51	100

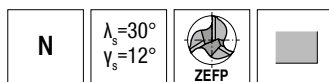
Čelik	●	●	●	●
Nehrđajući čelik	○	●	○	●
Lijevano željezo	○	●	●	●
Neželjezni metali	○	○	○	○
Visokootporan na toplinu	○	○	○	○
Kaljeni čelik				

1) Tolerancija držaka -0,025/-0,0323

→ v_c/f_z Stranica 40-42

Vretenasto glodalo HSS-E Co 8

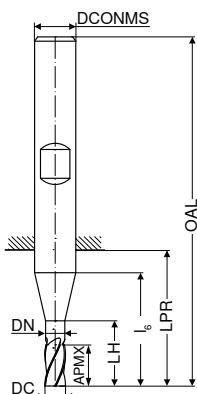
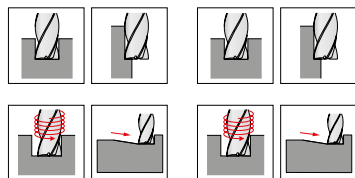
▲ Ø ≤ 6 mm, 3 oštrice do centra



≤ Ø DC 6,0 mm



> Ø DC 6,0 mm



DIN 327

DIN 327

DIN 844 K

DIN 844 K



DC	Tol.	APMX	DN	LH	l_6	LPR	OAL	DCONMS _{h6}	ZEFP	U8 Artikl. br. 50 105 ... EUR	U8 Artikl. br. 54 021 ... EUR	U8 Artikl. br. 50 106 ... EUR	U8 Artikl. br. 54 016 ... EUR
1,80	h10	4		4	10	12	48	6	3	25,97 018	36,98 018		
2,00	e8	4		4	10	12	48	6	3	21,20 020	30,63 020		
2,50	e8	5		5	11	13	49	6	3	23,10 025	30,63 025		
2,80	h10	5		5	11	13	49	6	3	25,97 028	36,98 028		
2,80	h10	8		8	18	20	56	6	3			32,12 028 ¹⁾	42,82 028 ¹⁾
3,00	e8	5		5	11	13	49	6	3	20,46 030	30,63 030		
3,00	e8	8		8	14	16	52	6	3			24,59 030	27,87 030
3,50	h10	6		6	12	14	50	6	3	25,44 035	33,49 035		
3,50	h10	10		10	16	18	54	6	3			26,60 035	27,87 035
3,80	h10	7		7	13	15	51	6	3	25,44 038	36,98 038		
3,80	h10	11		11	25	27	63	6	3			32,12 038 ¹⁾	42,82 038 ¹⁾
4,00	e8	7		7	13	15	51	6	3	20,46 040	30,63 040		
4,00	e8	11		11	17	19	55	6	3			23,95 040	27,87 040
4,50	h10	7		7	13	15	51	6	3	23,10 045	33,49 045		
4,50	h10	11		11	17	19	55	6	3			26,60 045	27,87 045
4,80	h10	8		8	14	16	52	6	3	23,10 048	36,98 048		
5,00	e8	8		8	14	16	52	6	3	20,87 050	30,63 050		
5,00	e8	13		13	19	21	57	6	3			24,59 050	27,87 050
5,50	h10	8		8	14	16	52	6	3	25,44 055	33,49 055		
5,50	h10	13		13	19	21	57	6	3			28,61 055	27,87 055
5,75	h10	8		8	14	16	52	6	3	25,44 057	36,98 057		
6,00	e8	8	5,5	14	14	16	52	6	3	20,87 060	30,63 060		
6,00	e8	13	5,5	19	19	21	57	6	3			23,95 060	27,87 060
6,50	h10	10	6,0	16	18	20	60	10	3	33,70 065	46,31 065		
6,50	h10	16	6,0	22	24	26	66	10	3			32,43 065	39,96 065
6,75	h10	10	6,5	16	18	20	60	10	3	33,70 067	54,15 067		
7,00	e8	10	6,5	16	18	20	60	10	3	33,06 070	45,68 070		
7,00	e8	16	6,5	22	24	26	66	10	3			32,65 070	39,96 070
7,50	h10	10	7,0	16	18	20	60	10	3	33,70 075	46,31 075		
7,50	h10	16	7,0	22	24	26	66	10	3			38,57 075	39,96 075
7,75	h10	11	7,5	17	19	21	61	10	3	33,70 077	48,43 077		
8,00	e8	11	7,5	17	19	21	61	10	3	29,46 080	42,82 080		
8,00	e8	19	7,5	25	27	29	69	10	3			34,12 080	39,96 080
8,50	h10	11	8,0	18	19	21	61	10	3	34,65 085	47,05 085		
8,50	h10	19	8,0	26	27	29	69	10	3			44,82 085	39,96 085
8,70	h10	11	8,5	18	19	21	61	10	3	34,65 087	54,15 087		
9,00	h10	11	8,5	18	19	21	61	10	3	36,88 090	45,68 090		
9,00	h10	19	8,5	26	27	29	69	10	3			37,62 090	39,96 090
9,50	h10	11	9,0	18	19	21	61	10	3	37,20 095	48,43 095		
9,50	h10	19	9,0	26	27	29	69	10	3			42,49 095	61,36 095
9,70	h10	13	9,5	21	21	23	63	10	3	37,20 097	51,40 097		
10,00	e8	13	9,5	21	21	23	63	10	3	28,19 100	44,94 100		
10,00	e8	22	9,5	30	30	32	72	10	3			33,81 100	39,96 100
10,50	h10	13	10,0	21	23	25	70	12	3	48,43 105	55,54 105		
10,70	h10	13	10,5	21	23	25	70	12	3	48,43 107	61,36 107		
11,00	h10	13	10,5	21	23	25	70	12	3	41,43 110	52,03 110		

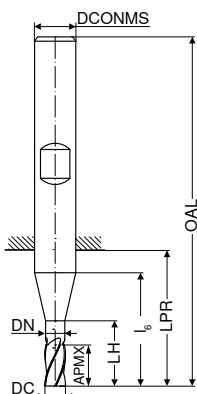
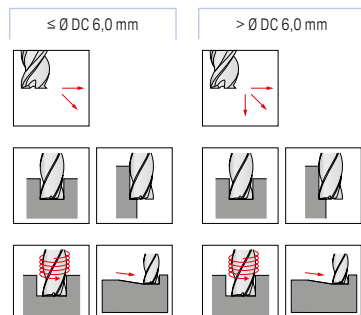
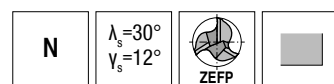
Čelik	●	●	●	●
Nehrđajući čelik	○	●	○	●
Lijevano željezo	●	●	●	●
Neželjezni metali	○	○	○	○
Visokootporan na toplinu	○	○	○	○
Kaljeni čelik				

1) Tvornički standard

→ v_c/f_z Stranica 40-42

Vretenasto glodalo HSS-E Co 8

▲ Ø ≤ 6 mm, 3 oštrice do centra



DIN 327

DIN 327

DIN 844 K

DIN 844 K



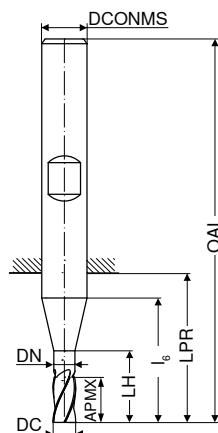
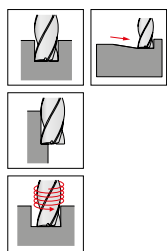
DC	Tol.	APMX	DN	LH	I ₆	LPR	OAL	DCONMS _{h6}	ZEFP	U8 Artikl br. 50 105 ... EUR	U8 Artikl br. 54 021 ... EUR	U8 Artikl br. 50 106 ... EUR	U8 Artikl br. 54 016 ... EUR
mm		mm	mm	mm	mm	mm	mm	mm					
11,00	h10	22	10,5	30	32	34	79	12	3				
11,50	h10	13	11,0	21	23	25	70	12	3	42,92	55,54	42,49	41,23
11,50	h10	22	11,0	30	32	34	79	12	3			54,48	70,58
11,70	h10	16	11,5	26	26	28	73	12	3	42,92	61,99		
12,00	e8	16	11,5	26	26	28	73	12	3	36,88	51,40		
12,00	e8	26	11,5	36	36	38	83	12	3			40,27	48,43
12,70	h10	16	11,5	26	26	28	73	12	3	53,94	86,90		
13,00	h10	16	11,5	26	26	28	73	12	3	53,94	75,56		
13,00	h10	26	11,5	36	36	38	83	12	3			58,60	59,77
13,70	h10	16	11,5	26	26	28	73	12	3	57,34	81,18		
14,00	e8	16	11,5	26	26	28	73	12	3	52,67	71,32		
14,00	e8	26	11,5	36	36	38	83	12	3			52,03	63,38
15,00	h10	16	11,5	26	26	28	73	12	3	55,85	75,56		
15,00	h10	26	11,5	36	36	38	83	12	3			72,91	95,38
15,50	h10	32	15,0	42	42	44	92	16	3			91,56	114,50
15,70	h10	19	15,0	29	29	31	79	16	3	58,71	91,14		
16,00	e8	19	15,0	29	29	31	79	16	3	50,44	78,43		
16,00	e8	32	15,0	42	42	44	92	16	3			60,40	63,38
17,00	h10	19	15,0	29	29	31	79	16	3	72,81	111,30		
17,00	h10	32	15,0	42	42	44	92	16	3			71,85	84,15
17,70	h10	19	15,0	29	29	31	79	16	3	84,04	115,50		
18,00	e8	19	15,0	29	29	31	79	16	3	70,69	101,30		
18,00	e8	32	15,0	42	42	44	92	16	3			66,98	92,73
19,00	h10	19	15,0	29	29	31	79	16	3	81,18	122,90		
19,00	h10	32	15,0	42	42	44	92	16	3			87,33	92,73
19,50	h10	38	19,0	52	52	54	104	20	3			106,00	153,70
19,70	h10	22	19,0	36	36	38	88	20	3	91,25	122,90		
20,00	e8	22	19,0	36	36	38	88	20	3	79,70	107,00		
20,00	e8	38	19,0	52	52	54	104	20	3			80,01	102,60
21,70	h10	22	19,0	36	36	38	88	20	3	138,80	173,80		
22,00	e8	22	19,0	36	36	38	88	20	3	124,00	153,70		
22,00	e8	38	19,0	52	52	54	104	20	3			98,03	116,60
23,70	h10	26	23,0	42	44	46	102	25	3	166,40	204,60		
24,00	e8	26	23,0	42	44	46	102	25	3	142,10	181,30		
24,70	h10	26	24,0	44	44	46	102	25	3	160,10	210,90		

Čelik	●	●	●	●
Nehrđajući čelik	○	●	○	●
Lijeveno željezo	●	●	●	●
Neželjezni metali	○	○	○	○
Visokootporan na toplinu	○	○	○	○
Kaljeni čelik				

1) Tvornički standard

→ v_c/f_z Stranica 40-42

Vretenasto glodalo HSS-E Co 8



Ti100 Pro



Ti100 Pro



Tvrnički standard



B



DIN 844



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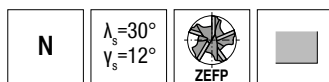
DC	Tol.	APMX	DN	LH	l ₆	LPR	OAL	DCONMS _{h6}	ZEFP	U8	U8	U8
mm		mm	mm	mm	mm	mm	mm	mm		Artikl br. 54 017 ... EUR	Artikl br. 50 124 ... EUR	Artikl br. 54 011 ... EUR
4	k10	11		11	17	19	55	6	4		36,45	040 51,93
5	k10	13		13	19	21	57	6	4		36,45	050 56,27
6	e8	8	5,5	14	14	16	52	6	4	28,51	060 36,45	060 56,27
6	k10	13	5,5	19	19	21	57	6	4			
8	e8	11	7,5	17	19	21	61	10	4	35,61	080 40,27	080 68,67
8	k10	19	7,5	25	27	29	69	10	4		50,97	090 74,92
9	k10	19	8,5	26	27	29	69	10	4			
10	e8	13	9,5	21	21	23	63	10	4	37,84	100 49,49	100 68,67
10	k10	22	9,5	30	30	32	72	10	4			
12	e8	16	11,5	26	26	28	73	12	4	45,68	120 55,11	120 86,37
12	k10	26	11,5	36	36	38	83	12	4			
14	e8	16	11,5	26	26	28	73	12	4	64,12	140 64,75	140 114,50
14	k10	26	11,5	36	36	38	83	12	4		83,72	150
15	k10	26	11,5	36	36	38	83	12	4			
16	e8	19	15,0	29	29	31	79	16	4	65,60	160 73,76	160 125,00
16	k10	32	15,0	42	42	44	92	16	4		104,10	170 174,80
17	k10	32	15,0	42	42	44	92	16	4			
18	e8	19	15,0	29	29	31	79	16	4	81,18	180 96,01	180 170,70
18	k10	32	15,0	42	42	44	92	16	4			
20	e8	22	19,0	36	36	38	88	20	4	92,73	200 108,10	200 179,10
20	k10	38	19,0	52	52	54	104	20	4		153,70	250 257,50
25	k10	45	24,0	63	63	65	121	25	5			

Čelik	○	○	○
Nehrđajući čelik	●	●	●
Lijeivano željezo	○	○	○
Neželjezni metali	●	●	●
Visokootporan na toplinu	●	●	●
Kaljeni čelik			

→ v_c/f_z Stranica 40-42

Vretenasto glodalo HSS-E Co 8

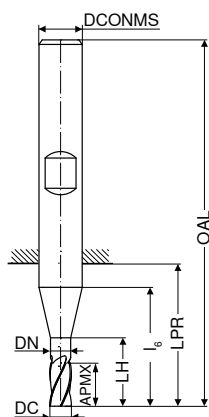
▲ > Ø 28,0 mm u centru slobodno



≤ Ø DC 28,0 mm



> Ø DC 28,0 mm



DIN 69844



DIN 69844



DIN 844



DIN 844



Tvornički standard



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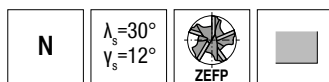
DC _{k10}	APMX	DN	LH	<i>l₆</i>	LPR	OAL	DCONMS _{h6}	ZEFP	U8 Artikl. br. 50 110 ... EUR	U8 Artikl. br. 54 018 ... EUR	U8 Artikl. br. 50 111 ... EUR	U8 Artikl. br. 54 019 ... EUR	U6 Artikl. br. 50 104 ... EUR
2,0	7		7	13	15	51	6	4	21,20	020	34,98	020	
2,5	8		8	14	16	52	6	4	22,36	025	33,49	025	
3,0	8		8	14	16	52	6	4	21,20	030	32,75	030	
3,0	12		12	18	20	56	6	4			29,57	030	42,07
3,5	10		10	16	18	54	6	4	21,20	035	34,98	035	
4,0	11		11	17	19	55	6	4	19,29	040	31,37	040	
4,0	19		19	25	27	63	6	4			29,04	040	42,07
4,5	11		11	17	19	55	6	4	21,20	045	34,23	045	
5,0	13		13	19	21	57	6	4	19,29	050	31,37	050	
5,0	24		24	30	32	68	6	4			29,04	050	42,07
5,5	13		13	19	21	57	6	4	21,20	055	34,98	055	
6,0	13	5,5	19	19	21	57	6	4	17,91	060	32,00	060	
6,0	24	5,5	30	30	32	68	6	4			26,28	060	41,23
6,0	56	5,5	62	62	64	100	6	4					45,78
6,5	16	6,0	22	24	26	66	10	4	25,12	065	44,19	065	
7,0	16	6,5	22	24	26	66	10	4	25,12	070	43,56	070	
7,0	30	6,5	36	38	40	80	10	4			43,56	070	52,78
7,5	16	7,0	22	24	26	66	10	4	25,12	075	44,19	075	
8,0	19	7,5	25	27	29	69	10	4	22,05	080	42,07	080	
8,0	38	7,5	44	46	48	88	10	4			37,30	080	48,43
8,0	70	7,5	73	73	75	115	10	4					51,72
8,5	19	8,0	26	27	29	69	10	4	26,81	085	44,19	085	
9,0	19	8,5	26	27	29	69	10	4	26,92	090	47,80	090	
9,0	38	8,5	45	46	48	88	10	4			45,35	090	57,01
9,5	19	9,0	26	27	29	69	10	4	26,81	095	54,89	095	
10,0	22	9,5	30	30	32	72	10	4	25,54	100	44,19	100	
10,0	45	9,5	53	53	55	95	10	4			39,31	100	52,03
10,0	75	9,5	79	79	81	121	10	4					62,32
10,5	22	10,0	30	32	34	79	12	4	42,71	105	60,73	105	
11,0	22	10,5	30	32	34	79	12	4	36,98	110	54,15	110	
11,0	45	10,5	53	55	57	102	12	4			51,62	110	69,20
11,5	22	11,0	30	32	34	79	12	4	41,12	115	55,54	115	
12,0	26	11,5	36	36	38	83	12	4	35,39	120	51,40	120	
12,0	53	11,5	63	63	65	110	12	4			42,49	120	61,36
12,0	85		85	85	85	130	12	4					67,30
13,0	26	11,5	36	36	38	83	12	4	53,41	130	75,56	130	
14,0	26	11,5	36	36	38	83	12	4	47,48	140	64,12	140	
14,0	53	11,5	63	63	65	110	12	4			54,48	140	81,18

Čelik	●	●	●	●	●
Nehrđajući čelik	○	●	○	●	○
Lijevano željezo	●	●	●	●	●
Neželjezni metali	○	○	○	○	○
Visokootporan na toplinu	○	○	○	○	○
Kaljeni čelik					

→ v_c/f_z Stranica 40-42

Vretenasto glodalo HSS-E Co 8

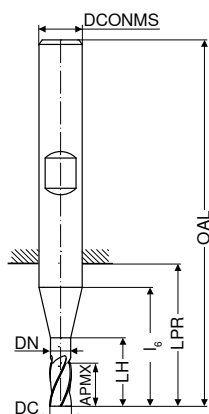
▲ > Ø 28,0 mm u centru slobodno



≤ Ø DC 28,0 mm



> Ø DC 28,0 mm



DIN 69844



DIN 69844



DIN 844



DIN 844



Tvornički standard



B



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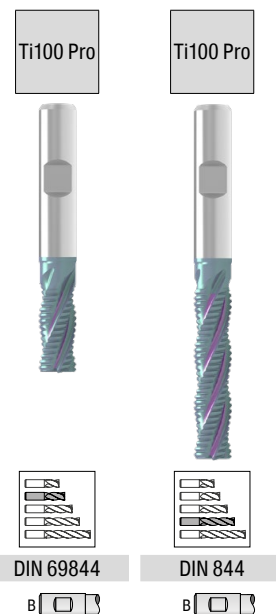
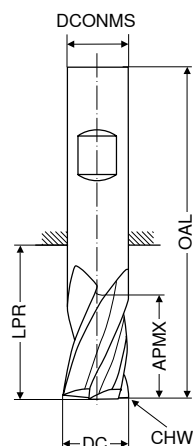
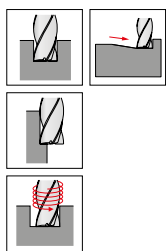
B

DC _{k10}	APMX	DN	LH	l_6	LPR	OAL	DCONMS _{h6}	ZEFP	U8 Artikl br. 50 110 ... EUR	U8 Artikl br. 54 018 ... EUR	U8 Artikl br. 50 111 ... EUR	U8 Artikl br. 54 019 ... EUR	U6 Artikl br. 50 104 ... EUR
mm	mm	mm	mm	mm	mm	mm	mm						
14,0	85		85	85	85	130	12	4					85,42
15,0	26	11,5	36	36	38	83	12	4	53,94	150	76,94	150	
15,0	53	11,5	63	63	65	110	12	4			70,69	150	94,01
16,0	32	15,0	42	42	44	92	16	4	49,17	160	75,56	160	
16,0	63	15,0	73	73	75	123	16	4			60,51	160	91,14
16,0	90	15,0	95	95	97	145	16	4					81,18
18,0	32	15,0	42	42	44	92	16	4	69,20	180	104,10	180	
18,0	63	15,0	73	73	75	123	16	4			74,92	180	129,30
18,0	100	15,0	110	110	112	160	16	5					149,50
20,0	38	19,0	52	52	54	104	20	4	72,59	200	109,20	200	
20,0	75	19,0	89	89	91	141	20	4			86,80	200	135,60
20,0	110	19,0	128	128	130	180	20	5					139,90
22,0	38	19,0	52	52	54	104	20	5	100,80	220	145,20	220	
22,0	75	19,0	89	89	91	141	20	5			121,90	220	219,30
22,0	110	19,0	128	128	130	180	20	5					197,10
24,0	45	23,0	61	63	65	121	25	5	116,60	240	167,40	240	
24,0	90	23,0	106	108	110	166	25	5			164,30	240	243,80
25,0	45	24,0	63	63	65	121	25	5	116,60	250	160,10	250	
25,0	90	24,0	108	108	110	166	25	5			165,40	250	233,20
25,0	125	24,0	142	142	144	200	25	6					197,10
28,0	45	24,0	63	63	65	121	25	5	133,50	280	197,10	280	
28,0	90	24,0	108	108	110	166	25	5			196,00	280	305,20
28,0	140	24,0	147	147	149	205	25	6					276,60
30,0	45	24,0	63	63	65	121	25	5	186,50	300	234,20	300	
30,0	90	24,0	108	108	110	166	25	5			216,20	300	363,50
32,0	53	31,0	70	70	73	133	32	6	181,30	320			
32,0	53	31,0	70	70	73	133	32	5			222,60	320	
32,0	106	31,0	123	123	126	186	32	6			205,60	320	354,00
32,0	160	31,0	167	167	170	230	32	6					338,10
36,0	53	31,0	70	70	73	133	32	6	205,60	360	321,20	360	
40,0	63	38,0	80	80	85	155	40	6	271,30	400	399,60	400	
40,0	125	38,0	142	142	147	217	40	6			389,00	400	524,60
40,0	180	31,0	197	197	200	260	32	8					562,70
45,0	125	38,0	142	142	147	217	40	8			652,80	450	722,80
50,0	150	48,0	172	172	172	252	50	8			753,50	500	839,40

Čelik	●	●	●	●	●
Nehrdajući čelik	○	●	○	●	○
Lijevano željezo	●	●	●	●	●
Neželjezni metali	○	○	○	○	○
Visokootporan na toplinu	○	○	○	○	○
Kaljeni čelik					

→ v_c/f_z Stranica 40-42

Glodalo od praškastog čelika za grubu i finu obradu

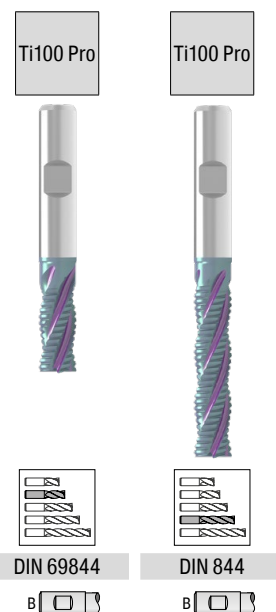
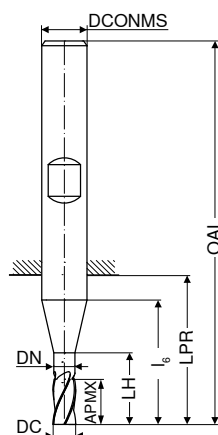
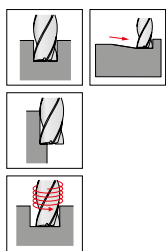


DC _{k12}	APMX	LPR	OAL	DCONMS _{n6}	CHW	ZEFP	U8 Artikl br. 54 007 ... EUR	U8 Artikl br. 54 008 ... EUR
6	13	21	57	6	0,3	4	101,50	060
6	24	32	68	6	0,3	4		145,20 060
7	16	26	66	10	0,3	4	143,10	070
8	19	29	69	10	0,3	4	133,50	080
8	38	48	88	10	0,3	4		171,70 080
9	19	29	69	10	0,5	4	153,70	090
10	22	32	72	10	0,5	4	143,10	100
10	45	55	95	10	0,5	4		180,10 100
12	26	38	83	12	0,7	4	147,30	120
12	53	65	110	12	0,7	4		201,30 120
14	26	38	83	12	0,8	4	186,50	140
14	53	65	110	12	0,8	4		239,50 140
16	32	44	92	16	0,8	4	210,90	160
16	63	75	123	16	0,8	4		272,40 160
18	32	44	92	16	0,8	4	265,00	180
18	63	75	123	16	0,8	4		346,50 180
20	38	54	104	20	0,8	4	280,80	200
20	75	91	141	20	0,8	4		375,10 200
25	45	65	121	25	1,0	5	416,50	250
25	90	110	166	25	1,0	4		609,30 250
30	90	110	166	25	1,3	5		957,00 300
32	53	73	133	32	1,3	6	557,40	320
32	106	126	186	32	1,3	5		886,00 320
40	63	85	155	40	1,3	6	957,00	400
40	125	147	217	40	1,3	6		1.378,00 400

Čelik	○	○
Nehrđajući čelik	●	●
Lijevano željezo	○	○
Neželjezni metali	○	○
Visokootporan na toplinu	●	●
Kaljeni čelik		

→ v_c/f_z Stranica 40-42

Glodalo za grubu i finu obradu HSS-E Co 5

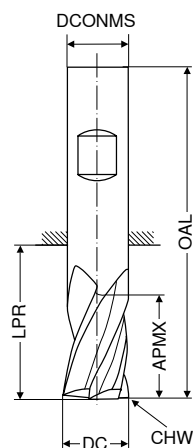
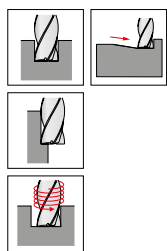


DC _{k12}	APMX	DN	LH	l ₆	LPR	OAL	DCONMS _{n6}	ZEFP
mm	mm	mm	mm	mm	mm	mm	mm	
6	13	5,5	19	19	21	57	6	4
6	24	5,5	30	30	32	68	6	4
7	16	6,5	22	24	26	66	10	4
8	19	7,5	25	27	29	69	10	4
8	38	7,5	44	46	48	88	10	4
9	19	8,5	26	27	29	69	10	4
10	22	9,5	30	30	32	72	10	4
10	45	9,5	53	53	55	95	10	4
11	22	10,5	30	32	32	79	12	4
11	45	10,5	53	55	57	102	12	4
12	26	11,5	36	36	38	83	12	4
12	53	11,5	63	63	65	110	12	4
13	26	11,5	36	36	38	83	12	4
14	26	11,5	36	36	38	83	12	4
15	26	11,5	36	36	38	83	12	4
15	53	11,5	63	63	65	110	12	4
16	32	15,0	42	42	44	92	16	4
16	63	15,0	73	73	75	123	16	4
18	32	15,0	42	42	44	92	16	4
20	38	19,0	52	52	54	104	20	4
20	75	19,0	89	89	91	141	20	4
22	75	19,0	89	89	91	141	20	4
22	38	19,0	52	52	54	104	20	4
25	90	24,0	108	108	110	166	25	4
25	45	24,0	63	63	65	121	25	4
28	90	24,0	108	108	110	166	25	5

Čelik	•	•
Nehrđajući čelik	○	○
Lijevano željezo	•	•
Neželjezni metali	○	○
Visokootporan na toplinu	○	○
Kaljeni čelik	○	○

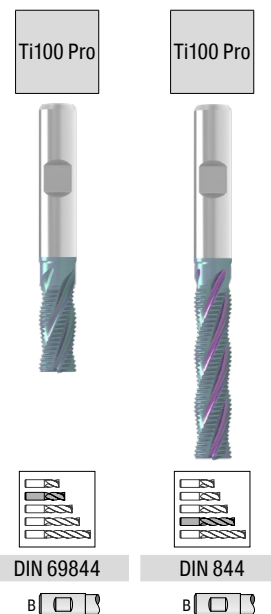
→ v_c/f_t Stranica 40-42

Glodalo od praškastog čelika za grubu i finu obradu



DC _{k12}	APMX	LPR	OAL	DCONMS _{n6}	CHW	ZEFP
mm	mm	mm	mm	mm	mm	
6	13	21	57	6	0,45	4
6	24	32	68	6	0,45	4
8	19	29	69	10	0,45	4
8	38	48	88	10	0,45	4
10	22	32	72	10	0,45	4
10	45	55	95	10	0,45	4
12	26	38	83	12	0,45	4
12	53	65	110	12	0,45	4
14	26	38	83	12	0,45	4
14	53	65	110	12	0,45	4
16	32	44	92	16	0,60	4
16	63	75	123	16	0,60	4
18	32	44	92	16	0,60	4
18	63	75	123	16	0,60	4
20	38	54	104	20	0,60	4
20	75	91	141	20	0,60	4
22	38	54	104	20	0,60	5
25	45	65	121	25	0,75	5
25	90	110	166	25	0,75	5
28	45	65	121	25	0,75	5
28	90	110	166	25	0,75	5
30	45	65	121	25	0,75	5
30	90	110	166	25	0,75	5
32	53	73	133	32	0,75	6
32	106	126	186	32	0,75	5
40	63	85	155	40	0,90	6

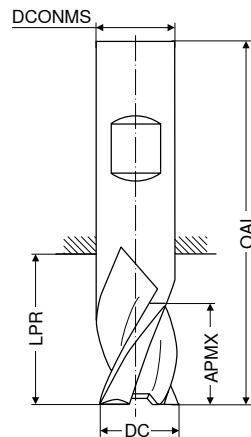
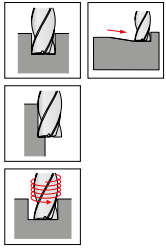
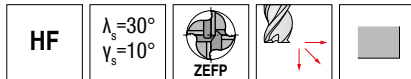
Čelik	○	○
Nehrđajući čelik		
Lijeвано željezo	●	●
Neželjezni metali		
Visokootporan na toplinu	●	●
Kaljeni čelik		



U8	U8
Artikl br.	Artikl br.
54 009 ...	54 012 ...
EUR	EUR
101,50	060
133,50	080
143,10	100
147,30	120
186,50	140
210,90	160
265,00	180
280,80	200
368,80	220
416,50	250
522,50	280
605,20	300
557,40	320
957,00	400

→ v_c/f_z Stranica 40-42

Glodalo od praškastog čelika za grubu i finu obradu



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DIN 844

B

U8

Artikl br.

54 034 ...

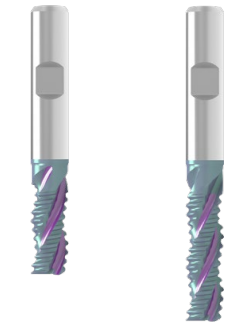
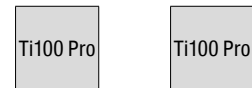
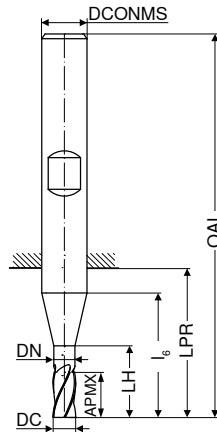
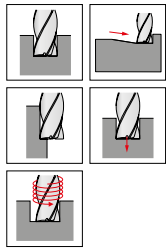
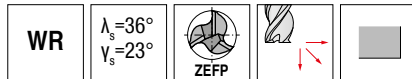
EUR

DC _{k12}	APMX	LPR	OAL	DCONMS _{h6}	ZEFP		
mm	mm	mm	mm	mm			
6	13	21	57	6	4	55,54	060
8	19	29	69	10	4	75,56	080
10	22	32	72	10	4	81,18	100
12	26	38	83	12	4	88,28	120
14	26	38	83	12	4	99,73	140
16	32	44	92	16	4	131,50	160
18	32	44	92	16	4	138,80	180
20	38	54	104	20	4	168,50	200
25	45	65	121	25	4	258,50	250

Čelik	●
Nehrđajući čelik	○
Lijevano željezo	●
Neželjezni metali	○
Visokootporan na toplinu	○
Kaljeni čelik	○

→ v_c/f_t Stranica 40-42

Glodalo za grubu obradu HSS-E Co 8



DIN 844



Tvornički standard



DC _{k12}	APMX	DN	LH	l_6	LPR	OAL	DCONMS _{h6}	ZEFP
mm	mm	mm	mm	mm	mm	mm	mm	
6	13	5,5	19	19	21	57	6	3
6	19	5,5	25	25	27	63	6	3
8	19	7,5	25	27	29	69	10	3
8	28	7,5	34	36	38	78	10	3
10	22	9,5	30	30	32	72	10	3
10	34	9,5	42	42	44	84	10	3
12	26	11,5	36	36	38	83	12	3
12	40	11,5	50	50	52	97	12	3
16	32	15,0	42	42	44	92	16	3
16	48	15,0	58	58	60	108	16	3
20	38	19,0	52	52	54	104	20	3
20	56	19,0	70	70	72	122	20	3
25	45	24,0	63	63	65	121	25	3
25	68	24,0	86	86	88	144	25	3
32	80	31,0	97	97	100	160	32	3

Čelik

Nehrđajući čelik

Lijevano željezo

Neželjezni metali

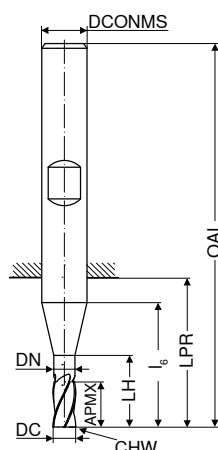
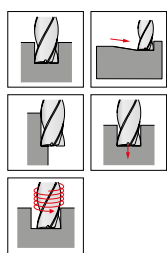
Visokootporan na toplinu

Kaljeni čelik

U8	U8
Artikl br.	Artikl br.
54 013 ...	54 010 ...
EUR	EUR
79,27	060
105,80	080
115,50	100
124,00	120
172,70	160
232,10	200
333,80	250
	320

→ v_c/f_z Stranica 40-42

Glodalo za grubu obradu HSS-E Co 8



DIN 69844

DIN 69844

DIN 844

DIN 844



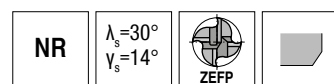
DC _{k12}	APMX	DN	LH	l_6	LPR	OAL	DCONMS _{h6}	CHW	ZEFP	U8 Artikl br. 50 153 ... EUR	060	U8 Artikl br. 54 026 ... EUR	060	U8 Artikl br. 50 157 ... EUR	060	U8 Artikl br. 54 027 ... EUR	060
6	13	5,5	19	19	21	57	6	0,5	3	41,96		48,43		49,91		69,20	
6	24	5,5	30	30	32	68	6	0,5	3								
7	16	6,5	22	24	26	66	10	0,5	3	55,11	070	66,98	070				
8	19	7,5	25	27	29	69	10	0,7	3	50,34	080	62,63	080				
8	38	7,5	44	46	48	88	10	0,7	3					55,74	080	81,18	080
9	19	8,5	26	27	29	69	10	0,7	3	60,62	090	71,32	090				
9	38	8,5	45	46	48	88	10	0,7	3					82,66	090	94,01	090
10	22	9,5	30	30	32	72	10	0,7	3	53,62	100	65,60	100				
10	45	9,5	53	53	55	95	10	0,7	3					71,00	100	86,90	100
11	22	10,5	30	32	34	79	12	0,7	3	67,93	110	81,18	110				
11	45	10,5	53	55	55	102	12	0,7	3					92,73	110	115,50	110
12	26	11,5	36	36	38	83	12	0,7	3	57,65	120	72,70	120				
12	53	11,5	63	63	65	110	12	0,7	3					76,73	120	96,97	120
14	26	11,5	36	36	38	83	12	0,9	3	66,98	140	91,14	140				
14	53	11,5	63	63	65	110	12	0,9	3					92,52	140	116,60	140
15	26	11,5	36	36	38	83	12	0,9	3	79,06	150	102,60	150				
15	53	11,5	63	63	65	110	12	0,9	3					110,20	150	136,80	150
16	32	15,0	42	42	44	92	16	0,9	3	76,30	160	99,73	160				
16	63	15,0	73	73	75	123	16	0,9	3					95,38	160	131,50	160
18	32	15,0	42	42	44	92	16	0,9	3	96,34	180	135,60	180				
18	63	15,0	73	73	75	123	16	0,9	3					145,20	180	176,00	180
20	38	19,0	52	52	54	104	20	0,9	3	105,70	200	138,80	200				
20	75	19,0	89	89	91	141	20	0,9	3					139,90	200	186,50	200
25	45	24,0	63	63	65	121	25	0,9	3	164,30	250	198,20	250				
25	90	24,0	108	108	110	166	25	0,9	3					205,60	250	305,20	250

Čelik	●	●	●	●
Nehrđajući čelik	○	○	○	○
Lijeвано željezo	●	●	●	●
Neželjezni metali	○	○	○	○
Visokootporan na toplinu	○	○	○	○
Kaljeni čelik				

→ v_d/f_z Stranica 40-42

Glodalo za grubu obradu HSS-E Co 5

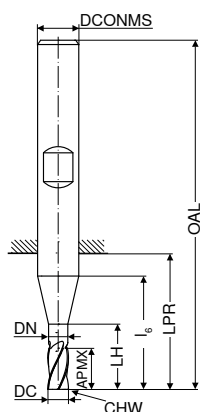
▲ > Ø 25,0 mm u centru slobodno



≤ Ø DC 25,0 mm



≥ Ø DC 30,0 mm



Ti100 Pro



DIN 69844

DIN 69844

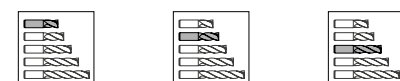
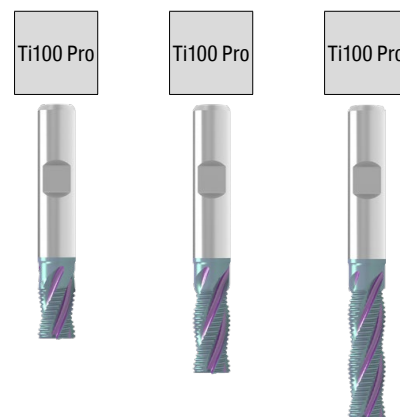
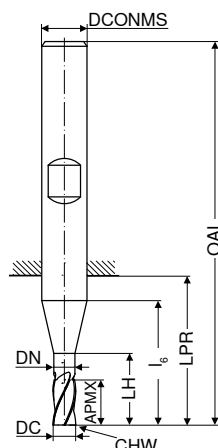
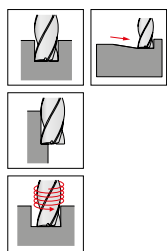


DC _{k12}	APMX	DN	LH	I ₆	LPR	OAL	DCNMS _{h6}	CHW	ZEFP
mm	mm	mm	mm	mm	mm	mm	mm	mm	
6	13	5,5	19	19	21	57	6	0,5	4
7	16	6,5	22	24	26	66	10	0,5	4
8	19	7,5	25	27	29	69	10	0,7	4
9	19	8,5	26	27	29	69	10	0,7	4
10	22	9,5	30	30	32	72	10	0,7	4
11	22	10,5	30	32	32	79	12	0,7	4
12	26	11,5	36	36	38	83	12	0,7	4
13	26	11,5	36	36	38	83	12	0,7	4
14	26	11,5	36	36	38	83	12	0,9	4
15	26	11,5	36	36	38	83	12	0,9	4
16	32	15,0	42	42	44	92	16	0,9	4
18	32	15,0	42	42	44	92	16	0,9	4
20	38	19,0	52	52	54	104	20	0,9	4
22	38	19,0	52	52	54	104	20	0,9	4
24	45	23,0	61	63	65	121	25	0,9	4
25	45	24,0	63	63	65	121	25	0,9	4
30	45	24,0	63	63	65	121	25	1,1	5
32	53	31,0	70	70	73	133	32	1,1	6
40	63	38,0	80	80	85	155	40	1,1	6

Čelik	●	●
Nehrđajući čelik	○	○
Lijevano željezo	●	●
Neželjezni metali	○	○
Visokootporan na toplinu	○	○
Kaljeni čelik	○	○

→ v_c/f_t Stranica 40-42

Glodalo od praškastog čelika za fino-grubu obradu



Tvornički standard B DIN 844 B Tvornički standard B

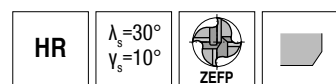
DC _{k12}	APMX	DN	LH	I ₆	LPR	OAL	DCONMS _{n6}	CHW	ZEFP	U8	U8	U8
mm	mm	mm	mm	mm	mm	mm	mm	mm		Artikl br. 54 031 ...	Artikl br. 54 032 ...	Artikl br. 54 033 ...
6	8	5,5	14	14	16	52	6	0,35	4	63,38	060	
6	13	5,5	19	19	21	57	6	0,35	4			
8	11	7,5	17	19	21	61	10	0,45	4	71,32	080	
8	19	7,5	25	27	29	69	10	0,45	4			
8	28	7,5	34	36	38	78	10	0,45	4			93,26
10	13	9,5	21	21	23	63	10	0,45	4	71,32	100	
10	22	9,5	30	30	32	72	10	0,45	4			
10	34	9,5	42	42	44	84	10	0,45	4			100,00
12	16	11,5	26	26	28	73	12	0,60	4	84,15	120	
12	26	11,5	36	36	38	83	12	0,60	4			
12	40	11,5	50	50	52	97	12	0,60	4			116,60
14	16	11,5	26	26	28	73	12	0,60	4	108,10	140	
14	26	11,5	36	36	38	83	12	0,60	4			
14	40	11,5	50	50	52	97	12	0,60	4			152,60
16	19	15,0	29	29	31	79	16	0,70	4	118,70	160	
16	32	15,0	42	42	44	92	16	0,70	4			
16	48	15,0	58	58	60	108	16	0,70	4			174,80
18	19	15,0	29	29	31	79	16	0,70	4	142,10	180	
18	32	15,0	42	42	44	92	16	0,70	4			
18	48	15,0	58	58	60	108	16	0,70	4			216,20
20	22	19,0	36	36	38	88	20	0,70	4	160,10	200	
20	38	19,0	52	52	54	104	20	0,70	4			
20	56	19,0	70	70	72	122	20	0,70	4			219,30
22	22	19,0	36	36	38	88	20	0,70	4	214,00	220	
22	38	19,0	52	52	54	104	20	0,70	4			
22	56	19,0	70	70	72	122	20	0,70	4			305,20
25	26	24,0	44	44	46	102	25	0,70	4	252,20	250	
25	45	24,0	63	63	65	121	25	0,70	4			
25	68	24,0	86	86	88	144	25	0,70	4			342,30
28	26	24,0	44	44	46	102	25	0,90	5	316,90	280	
30	45	24,0	63	63	65	121	25	0,90	5			
32	32	31,0	49	49	52	112	32	0,90	6	337,00	320	
32	53	31,0	70	70	73	133	32	0,90	6			

Čelik	•	•	•
Nehrđajući čelik	•	•	•
Lijevano željezo	•	•	•
Neželjezni metali	○	○	○
Visokootporan na toplinu	○	○	○
Kaljeni čelik			

→ v₀/f_z Stranica 40-42

Glodalo za fino-grubu obradu HSS-E Co 8

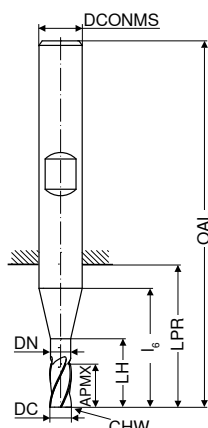
▲ > Ø 28,0 mm u centru slobodno



≤ Ø DC 28,0 mm



> Ø DC 28,0 mm



Tvornički standard



DIN 69844



DIN 69844



DIN 844



DIN 844



B



B



B



B



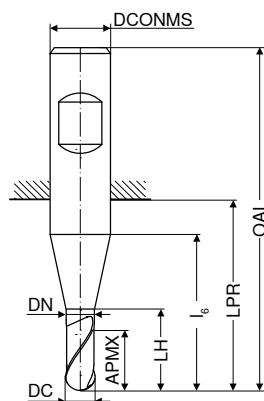
B

DC _{k12}	APMX	DN	LH	l ₆	LPR	OAL	DCONMS _{h6}	CHW	ZFP	U8	U8	U8	U8	U8
mm	mm	mm	mm	mm	mm	mm	mm	mm		Artikl br.	Artikl br.	Artikl br.	Artikl br.	Artikl br.
										54 022 ...	50 140 ...	54 023 ...	50 141 ...	54 024 ...
										EUR	EUR	EUR	EUR	EUR
4	11		11	17	19	55	6	0,35	3					
5	13		13	19	21	57	6	0,35	3					
6	8	5,5	14	14	16	52	6	0,35	4	50,55				
6	13	5,5	19	19	21	57	6	0,35	4					
6	24	5,5	30	30	32	68	6	0,35	4					
8	11	7,5	17	19	21	61	10	0,45	4	62,63				
8	19	7,5	25	27	29	69	10	0,45	4					
8	38	7,5	44	46	48	88	10	0,45	4					
10	13	9,5	21	21	23	63	10	0,45	4	55,54				
10	22	9,5	30	30	32	72	10	0,45	4					
10	45	9,5	53	53	55	95	10	0,45	4					
12	16	11,5	26	26	28	73	12	0,60	4	68,36				
12	26	11,5	36	36	38	83	12	0,60	4					
12	53	11,5	63	63	65	110	12	0,60	4					
14	16	11,5	26	26	28	73	12	0,60	4	86,90				
14	26	11,5	36	36	38	83	12	0,60	4					
14	53	11,5	63	63	65	110	12	0,60	4					
16	19	15,0	29	29	31	79	16	0,70	4	91,14				
16	32	15,0	42	42	44	92	16	0,70	4					
16	63	15,0	73	73	75	123	16	0,70	4					
18	19	15,0	29	29	31	79	16	0,70	4	118,70				
18	32	15,0	42	42	44	92	16	0,70	4					
18	63	15,0	73	73	75	123	16	0,70	4					
20	22	19,0	36	36	38	88	20	0,70	4	122,90				
20	38	19,0	52	52	54	104	20	0,70	4					
20	75	19,0	89	89	91	141	20	0,70	4					
22	38	19,0	52	52	54	114	20	0,70	4					
22	75	19,0	89	89	91	141	20	0,70	4					
25	45	24,0	63	63	65	121	25	0,70	4					
25	90	24,0	108	108	110	166	25	0,70	4					
28	45	24,0	63	63	65	121	25	0,90	5					
28	90	24,0	108	108	110	166	25	0,90	5					
30	45	24,0	63	63	65	121	25	0,90	5					
30	90	24,0	108	108	110	166	25	0,90	5					
32	53	31,0	70	70	73	133	32	0,90	6					
32	106	31,0	123	123	126	186	32	0,90	6					

Čelik	●	●	●	●	●
Nehrđajući čelik	●	○	●	○	●
Lijevano željezo	●	●	●	●	●
Neželjezni metali	○	○	○	○	○
Visokootporan na toplinu	○	○	○	○	○
Kaljeni čelik					

→ v_c/f_z Stranica 40-42

Radijusno vretenasto glodalo HSS-E Co 8



Tvornički standard

Tvornički standard

Tvornički standard

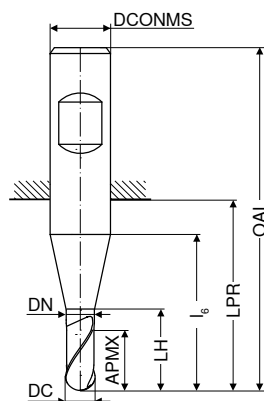


DC _{h10}	APMX	DN	LH	I ₆	LPR	OAL	DCONMS _{n6}	ZEFP	U6		U6		U6	
									Artikl br. 50 320 ...	EUR	Artikl br. 54 041 ...	EUR	Artikl br. 50 321 ...	EUR
2	4		4	10	12	48	6	2	35,18	020	45,68	020		
3	5		5	11	13	49	6	2	33,17	030	44,94	030		
3	8		8	18	20	56	6	2					49,28	030
4	7		7	13	15	51	6	2	33,17	040	44,94	040		
4	11		11	25	27	63	6	2					49,28	040
5	8		8	14	16	52	6	2	33,17	050	44,94	050		
5	13		13	30	32	68	6	2					49,28	050
6	8	5,50	14	14	16	52	6	2	33,17	060	44,94	060		
6	13	5,50	30	30	32	68	6	2					52,03	060
7	10	6,50	16	18	20	60	10	2	44,82	070	65,60	070		
7	16	6,35	36	38	40	80	10	2					58,50	070
8	11	7,50	17	19	21	61	10	2	36,35	080	61,36	080		
8	19	7,35	44	46	48	88	10	2					53,09	080
9	11	8,50	18	19	21	61	10	2	42,07	090	69,20	090		
9	19	8,35	45	46	48	88	10	2					62,10	090
10	13	9,50	21	21	23	63	10	2	41,86	100	64,12	100		
10	22	9,35	53	53	55	95	10	2					66,45	100
11	13	10,50	21	23	25	70	12	2	48,64	110				
11	22	10,50	53	55	57	102	12	2					71,75	110
12	16	11,50	26	26	28	73	12	2	46,95	120	72,70	120		
12	26	11,50	63	63	65	110	12	2					67,61	120
13	16	11,50	26	26	28	73	12	2	54,05	130	104,10	130		
14	16	11,50	26	26	28	73	12	2	54,89	140	95,38	140		
14	26	11,50	63	63	65	110	12	2					78,53	140
15	16	11,50	26	26	28	73	12	2	64,01	150	114,50	150		
15	26	11,50	63	63	65	110	12	2					102,00	150
16	19	15,50	29	29	31	79	16	2	66,55	160	114,50	160		
16	32	15,00	73	73	75	123	16	2					102,20	160
18	19	15,50	29	29	31	79	16	2	82,98	180	136,80	180		
18	32	15,00	73	73	75	123	16	2					129,30	180
20	22	19,00	36	36	38	88	20	2	88,28	201	135,60	201		
22	22	19,00	36	36	38	88	20	2	113,40	220				
24	26	23,00	42	44	46	102	25	2	115,50	240	215,20	240		
24	45	23,00	106	108	110	166	25	2					191,80	240
25	26	24,00	44	44	46	102	25	2	115,50	250				
25	45	24,00	108	108	110	166	25	2					180,10	250
26	26	24,00	44	44	46	102	25	2	168,50	260				
28	26	24,00	44	44	46	102	25	2	159,00	280				
30	26	24,00	44	44	46	102	25	2	183,40	300				
30	45	24,00	108	108	110	166	25	2					260,70	300

Čelik	●	●	●
Nehrđajući čelik	○	○	○
Lijevano željezo	●	●	●
Neželjezni metali	○	○	○
Visokootporan na toplinu	○	○	○
Kaljeni čelik			

→ v_c/f_z Stranica 40-42

Radijusno glodalo HSS-E Co 8



DC _{k12}	APMX	DN	LH	l_6	LPR	OAL	DCONMS _{h6}	ZEFP
mm	mm	mm	mm	mm	mm	mm	mm	
6	13	5,5	19	19	21	57	6	4
6	24	5,5	30	30	32	68	6	4
8	19	7,5	25	27	29	69	10	4
8	38	7,5	44	46	48	88	10	4
10	22	9,5	30	30	32	72	10	4
10	45	9,5	53	53	55	95	10	4
12	26	11,5	36	36	38	83	12	4
12	53	11,5	63	63	65	110	12	4
16	32	15,0	42	42	44	92	16	4
16	63	15,0	73	73	75	123	16	4
20	38	19,0	52	52	54	104	20	4
20	75	19,0	89	89	91	141	20	4
25	45	24,0	63	63	65	121	25	5

Čelik	•	•	•
Nehrdajući čelik	○	○	○
Lijevano željezo	•	•	•
Neželjezni metali	○	○	○
Visokootporan na toplinu	○	○	○
Kaljeni čelik	○	○	○

1) Tvornički standard

→ v_c/f_z Stranica 40-42DIN 1889 B
B

U8
Artikl br. 50 308 ...
EUR 74,92
060
82,35
080
84,46
100
95,59
120
126,20
160

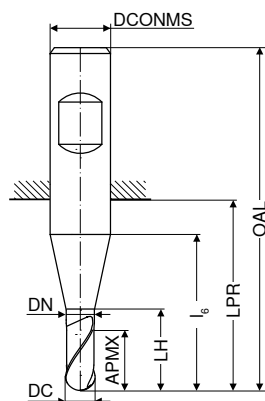
DIN 1889 B
B

U8
Artikl br. 54 038 ...
EUR 79,80
060
104,10
080
114,50
100
129,30
120
146,20
120
205,60
160
243,80
200
306,30
250

DIN 1889 B
B

U8
Artikl br. 54 039 ...
EUR 96,97
060 ¹⁾
116,60
080 ¹⁾
126,20
100
146,20
120
205,60
160
291,40
200

Radijusno glodalo za fino-grubu obradu HSS-E Co 8



Ti100 Pro



DIN 1889 B



U8

Artikl br.
54 040 ...

EUR

DC _{js14}	APMX	DN	LH	I ₆	LPR	OAL	DCONMS _{h6}	ZEFP		
mm	mm	mm	mm	mm	mm	mm	mm			
6	13	5,5	19	19	21	57	6	4	101,30	060
8	19	7,5	25	27	29	69	10	4	124,00	080
10	22	9,5	30	30	32	72	10	4	125,00	100
12	26	11,5	36	36	38	83	12	4	147,30	120
16	32	15,0	42	42	44	92	16	4	207,70	160
20	38	19,0	52	52	54	104	20	4	267,10	200

Čelik

Nehrđajući čelik

Lijevano željezo

Neželjezni metali

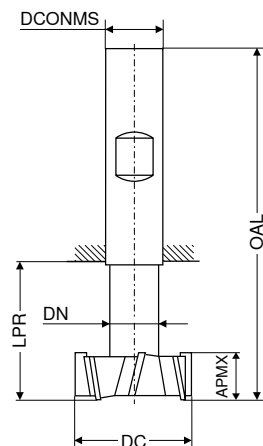
Visokootporan na toplinu

Kaljeni čelik

→ v_c/f_z Stranica 40-42

Glodalo za T-utore HSS-E Co 5, unakrsno ozubljeno

▲ Za utore prema DIN 650



DIN 851 A

B

U6

Artikl br.

50 240 ...

EUR

DC _{d11}	APMX _{d11}	DN _{h12}	LPR	OAL	DCONMS _{h6}	ZEFP		
mm	mm	mm	mm	mm	mm			
11,0	4	4	13,5	53,5	10	6	81,18	110
12,5	6	5	17,0	57,0	10	6	78,53	125
16,0	8	7	22,0	62,0	10	6	86,80	160
18,0	8	8	25,0	70,0	12	6	91,03	180
19,0	9	8	26,0	71,0	12	6	110,20	190 ¹⁾
21,0	9	10	29,0	74,0	12	6	113,40	210
22,0	10	10	30,0	75,0	12	6	116,60	220 ¹⁾
25,0	11	12	34,0	82,0	16	8	136,80	250
28,0	12	13	37,0	85,0	16	8	164,30	280 ¹⁾
32,0	14	15	42,0	90,0	16	8	185,40	320
36,0	16	17	47,0	103,0	25	8	278,70	360 ¹⁾
40,0	18	19	52,0	108,0	25	10	313,70	400
45,0	20	21	57,0	113,0	25	10	348,70	450 ¹⁾
50,0	22	25	64,0	124,0	32	10	383,70	500
60,0	28	30	79,0	139,0	32	10	512,90	600

Čelik

Nehrđajući čelik

Lijevano željezo

Neželjezni metali

Visokootporan na toplinu

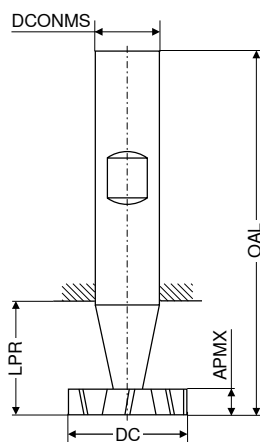
Kaljeni čelik

1) Tvornički standard

→ v_e/f_z Stranica 43

Glodalo za utore HSS-E Co 5, unakrsno ozubljeno

▲ Za utore prema DIN 6888

▲ $CDX = a_{p\max}$ 

DIN 850



U6

Artikl br.
50 234 ...

EUR

DC _{h12}	APMX _{e8}	LPR	OAL	DCONMS _{h6}	CDX	ZEFP	
mm	mm	mm	mm	mm	mm		
10,5	2,0	14	50	6	3,25	6	61,79 100
10,5	2,5	14	50	6	3,15	6	61,79 101
10,5	3,0	14	50	6	3,15	6	61,79 102
13,5	2,0	16	56	10	4,45	6	61,79 130 1)
13,5	3,0	16	56	10	4,45	6	61,79 132
13,5	4,0	16	56	10	4,45	6	61,79 133
16,5	3,0	16	56	10	5,95	6	67,30 161
16,5	4,0	16	56	10	5,95	6	67,30 162
16,5	5,0	16	56	10	5,75	6	67,30 163
19,5	3,0	23	63	10	6,95	8	74,18 190 1)
19,5	4,0	23	63	10	6,95	8	74,18 191
19,5	5,0	23	63	10	6,75	8	74,18 192
22,5	4,0	23	63	10	8,25	8	88,07 220 1)
22,5	5,0	23	63	10	8,25	8	88,07 221
22,5	6,0	23	63	10	8,00	8	88,07 222
25,5	5,0	23	63	10	9,00	10	88,07 250 1)
25,5	6,0	23	63	10	9,00	10	88,07 251
28,5	6,0	23	63	10	10,00	10	129,30 281
28,5	8,0	23	63	10	10,00	10	129,30 283
32,5	6,0	26	71	12	12,00	10	131,50 321 1)
32,5	8,0	26	71	12	12,00	10	131,50 322
38,5	8,0	26	71	12	13,35	10	195,00 381 1)
45,5	10,0	26	71	12	16,85	12	237,40 450

Čelik

Nehrđajući čelik

Lijevano željezo

Neželjezni metali

Visokootporan na toplinu

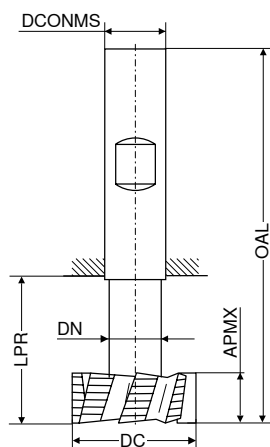
Kaljeni čelik

1) Tvornički standard

→ v_c/f_z Stranica 43

Glodalo za T-utore HSS-E Co 5

▲ Za utore prema DIN 650



DIN 851 A



U6

Artikl br.

50 241 ...

EUR

DC _{d11}	APMX	DN _{h12}	LPR	OAL	DCONMS _{h6}	ZEFP		
mm	mm	mm	mm	mm	mm			
21	9	10	29	74	12	6	131,50	210
22	10	10	30	75	12	6	145,20	220 ¹⁾
25	11	12	34	82	16	6	156,80	250
28	12	13	37	85	16	6	171,70	280 ¹⁾
32	14	15	42	90	16	6	216,20	320
36	16	17	47	103	25	6	263,90	360 ¹⁾
40	18	19	52	108	25	8	341,20	400
45	20	21	57	113	25	8	357,10	450 ¹⁾

Čelik

Nehrđajući čelik

Lijevano željezo

Neželjezni metali

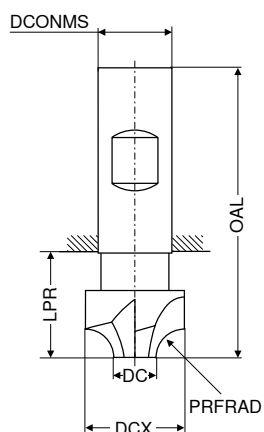
Visokootporan na toplinu

Kaljeni čelik

1) Tvornički standard

→ v_c/f_z Stranica 43

Profilno glodalo s četvrt kruga HSS-E Co 5, konkavno



DIN 6518



U6

Artikl br.

50 248 ...

EUR

PRFRAD _{H11}	DCX	DC	LPR	OAL	DCONMS _{H6}	ZEFP		
mm	mm	mm	mm	mm	mm			
1,0	8	6	20	60	10	4	47,58	010
1,5	9	6	20	60	10	4	58,18	015
2,0	10	6	20	60	10	4	53,94	020
2,5	11	6	20	60	10	4	60,73	025
3,0	12	6	15	60	12	4	55,21	030
4,0	14	6	15	60	12	4	71,43	040
5,0	16	6	15	60	12	4	74,18	050
6,0	20	8	19	67	16	4	96,75	060
8,0	24	8	23	71	16	4	129,30	080
9,0	26	8	29	85	25	4	136,80	090
10,0	28	8	29	85	25	4	157,90	100
12,0	34	10	34	90	25	4	240,60	120
15,0	46	16	44	100	25	6	330,60	150
16,0	48	16	44	100	25	6	389,00	160

Čelik

Nehrđajući čelik

Lijevano željezo

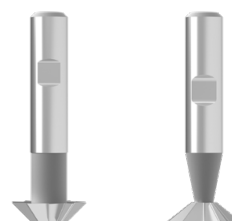
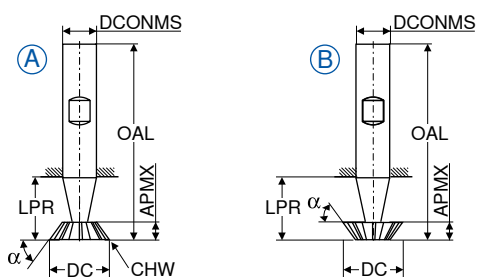
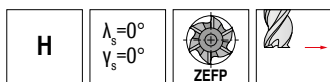
Neželjezni metali

Visokootporan na toplinu

Kaljeni čelik

→ v_c/f_z Stranica 43

Kutno glodalo HSS-E Co 5



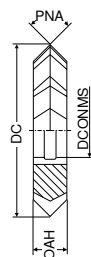
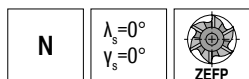
α°									DIN 1833		DIN 1833	
	DC	APMX	LPR	OAL	DCONMS _{h6}	CHW	ZEFP	Sl.	B		B	
	mm	mm	mm	mm	mm	mm			U6		U6	
									Artikl br. 50 246 ...		Artikl br. 50 245 ...	
									EUR		EUR	
45	16	4,0	15	60	12	0,3	10	A			71,43	016
	16	4,0	15	60	12		10	B	81,18	016		
	20	5,0	18	63	12	0,3	10	A			103,70	020
	20	5,0	18	63	12		10	B	109,20	020		
	25	6,3	22	67	12	0,3	10	A			126,20	025
	25	6,3	22	67	12		10	B	126,20	025		
60	16	6,3	15	60	12	0,3	10	A			81,18	116
	16	6,3	15	60	12		10	B	81,18	116		
	20	8,0	18	63	12	0,3	10	A			103,70	120
	20	8,0	18	63	12		10	B	103,70	120		
	25	10,0	22	67	12	0,3	10	A			112,30	125
	25	10,0	22	67	12		10	B	126,20	125		
70	16	7,0	15	60	12	0,3	10	A			81,18	216 ¹⁾
	20	9,0	18	63	12	0,3	10	A			103,70	220 ¹⁾
	25	11,0	19	67	16	0,3	10	A			126,20	225 ¹⁾
Čelik									●		●	
Nehrdajući čelik									○		○	
Lijevano željezo									●		●	
Neželjezni metali									○		○	
Visokootporan na toplinu									○		○	
Kaljeni čelik												

1) Tvornički standard

→ v_c/f_z Stranica 44

Prizmično glodalo HSS

▲ S utorom za prihvat prema DIN 138



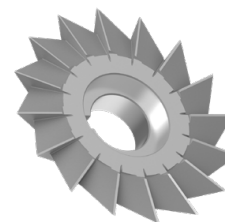
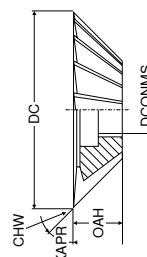
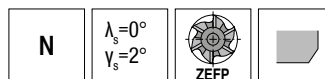
DIN 847					
U6					
PNA	DC	OAH	DCONMS	ZEFP	Artikl br. 50 360 ... EUR
°	mm	mm	mm		
45	50	8	16	22	131,50 045
	63	10	22	24	164,30 145
	80	12	27	26	260,70 245
	100	18	32	28	389,00 345
60	50	10	16	18	131,50 060
	63	14	22	20	164,30 160
	80	18	27	22	302,00 260
	100	25	32	24	484,30 360
90	50	14	16	16	153,70 090
	63	20	22	18	196,00 190
	80	22	27	20	321,20 290
	100	32	32	24	535,20 390
120	50	14	16	16	174,80 120 1)
	63	20	22	16	254,40 121 1)
Čelik ●					
Nehrđajući čelik ○					
Lijevano željezo ●					
Neželjezni metali ○					
Visokootporan na toplinu ○					
Kaljeni čelik ○					

1) Tvornički standard

→ v_c/f_z Stranica 44

Utično čeno kutno glodalo HSS

▲ S utorom za prihvat prema DIN 138

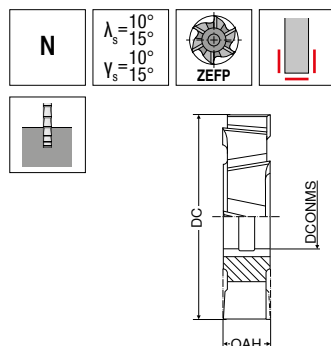


DIN 842 A						
U6						
KAPR	DC	OAH	DCONMS	CHW	ZEFP	Artikl br. 50 362 ... EUR
°	mm	mm	mm	mm		
45	40	10	10	0,3	14	151,50 045
	50	13	13	0,3	16	207,70 145
	63	18	16	0,3	18	261,80 245
	80	22	22	0,3	20	369,80 345
	100	28	27	0,3	22	561,70 445
50	50	16	13	0,3	16	207,70 150
60	40	13	10	0,3	14	133,50 060
	50	16	13	0,3	16	164,30 160
	63	20	16	0,3	18	225,80 260
	80	25	22	0,3	20	369,80 360
	100	32	27	0,3	22	561,70 460
	125	40	32	0,3	28	925,20 560
Čelik ●						
Nehrđajući čelik ○						
Lijevano željezo ●						
Neželjezni metali ○						
Visokootporan na toplinu ○						
Kaljeni čelik ○						

→ v_c/f_z Stranica 44

Pločasto glodalo HSS-E Co 5

- ▲ Grubo unakrsno nazubljeno
▲ S utorom za prihvati prema DIN 138



DIN 885 A

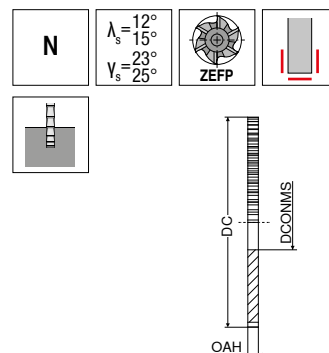
U6					
DC _{js16}	OAH _{k11}	DCONMS _{H7}	ZEFP	Artikl br. 50 348 ...	
mm	mm	mm		EUR	
50	4	16	12	102,30	100
50	5	16	12	104,10	102
50	6	16	12	105,80	104
50	8	16	12	118,70	106
50	10	16	12	128,20	108
63	4	22	12	111,30	200
63	5	22	12	118,70	202
63	6	22	12	117,60	204
63	8	22	12	130,30	206
63	10	22	12	143,10	208
63	12	22	12	164,30	210
63	14	22	12	184,40	212
80	5	27	14	150,50	300
80	6	27	14	152,60	302
80	8	27	14	164,30	304
80	10	27	14	168,50	306
80	12	27	14	186,50	308
80	14	27	14	216,20	310
80	16	27	14	233,20	312
80	18	27	14	269,20	314
80	20	27	14	291,40	316
100	6	32	14	219,30	400
100	8	32	14	218,30	402
100	10	32	14	231,00	404
100	12	32	14	251,20	406
100	14	32	14	281,90	408
100	16	32	14	294,60	410
100	18	32	14	348,70	412
100	20	32	14	341,20	414
100	25	32	14	442,90	418
125	8	32	16	288,30	500
125	10	32	16	308,40	502
125	12	32	16	333,80	504
125	14	32	16	376,30	506
125	16	32	16	397,40	508
125	18	32	16	431,30	510
125	20	32	16	461,00	512
125	25	32	16	554,20	516
160	10	40	18	456,80	600
160	12	40	18	507,60	602
160	14	40	18	537,30	604
160	16	40	18	577,60	606
160	18	40	18	644,40	608
160	20	40	18	652,80	610
160	25	40	18	799,00	614
160	32	40	18	1.015,00	618

Čelik	○
Nehrđajući čelik	●
Lijevano željezo	●
Neželjezni metali	●
Visokootporan na toplinu	○
Kaljani čelik	

→ v_c/f_z Stranica 45

Usko pločasto glodalo HSS-E Co 5

- ▲ Grubo unakrsno nazubljeno
▲ S utorom za prihvati prema DIN 138



Tvornički standard

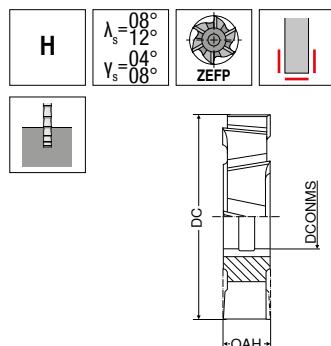
U6					
DC _{js16}	OAH _{k11}	DCONMS _{H7}	ZEFP	Artikl br. 50 342 ...	
mm	mm	mm		EUR	
63	1,6	22	16	109,20	200
63	2,0	22	16	96,44	202
63	2,5	22	16	98,24	204
63	3,0	22	16	101,10	206
80	1,6	27	20	116,60	300
80	2,0	27	20	113,40	302
80	2,5	27	20	115,50	304
80	3,0	27	20	118,70	306
80	4,0	27	20	128,20	310
100	1,6	32	24	149,50	400
100	2,0	32	24	147,30	402
100	2,5	32	24	147,30	404
100	3,0	32	24	150,50	406
100	4,0	32	24	161,10	410
100	5,0	32	24	172,70	414
125	1,6	32	26	186,50	500
125	2,0	32	26	179,10	502
125	2,5	32	26	184,40	504
125	3,0	32	26	187,60	506
125	4,0	32	26	204,60	510
125	5,0	32	26	218,30	514
125	6,0	32	26	234,20	516
160	2,0	40	30	291,40	600
160	2,5	40	30	281,90	602
160	3,0	40	30	286,10	604
160	4,0	40	30	301,00	606
160	5,0	40	30	320,00	608
160	6,0	40	30	341,20	610
160	8,0	40	22	392,10	612

Čelik	
Nehrđajući čelik	●
Lijevano željezo	
Neželjezni metali	●
Visokootporan na toplinu	○
Kaljani čelik	

→ v_c/f_z Stranica 45

Pločasto glodalo HSS-E Co 5

- ▲ Fino unakrsno nazubljeno
▲ S utorom za prihvata prema DIN 138



DIN 885 A

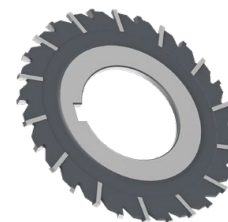
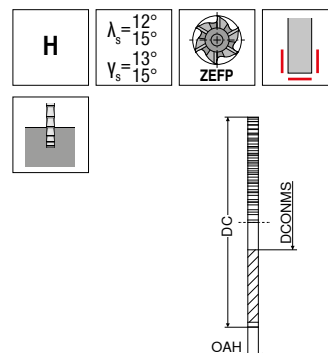
DIN 885 A				
U6				
DC _{js16}	OAH _{k11}	DCONMS _{H7}	ZEFP	Artikl br. 50 349 ...
mm	mm	mm		EUR
50	4	16	16	120,90 100
50	5	16	16	120,90 102
50	6	16	16	129,30 104
50	8	16	16	136,80 106
50	10	16	16	150,50 108
63	4	22	18	132,50 200
63	5	22	18	140,90 202
63	6	22	18	135,60 204
63	8	22	18	152,60 206
63	10	22	18	170,70 208
63	12	22	18	192,90 210
63	14	22	18	217,30 212
80	5	27	20	178,10 300
80	6	27	20	183,40 302
80	8	27	20	191,80 304
80	10	27	18	195,00 306
80	12	27	18	220,50 308
80	14	27	18	255,40 310
80	16	27	18	276,60 312
80	18	27	18	320,00 314
80	20	27	18	320,00 316
100	6	32	22	257,50 400
100	8	32	22	255,40 402
100	10	32	20	275,50 404
100	12	32	20	296,70 406
100	14	32	20	330,60 408
100	16	32	20	350,80 410
100	18	32	20	409,00 412
100	20	32	20	412,30 414
100	25	32	20	510,90 418
125	8	32	24	340,20 500
125	10	32	22	364,50 502
125	12	32	22	394,30 504
125	14	32	22	442,90 506
125	16	32	22	460,00 508
125	18	32	22	530,90 510
125	20	32	22	539,50 512
125	25	32	22	646,50 516
160	10	40	26	542,60 600
160	12	40	26	591,30 602
160	14	40	26	635,90 604
160	16	40	26	684,60 606
160	18	40	26	752,40 608
160	20	40	26	753,50 610
160	25	40	26	937,90 614
160	32	40	26	1.179,00 618

Čelik	●
Nehrđajući čelik	○
Lijevano željezo	●
Neželjezni metali	●
Visokootporan na toplinu	○
Kaljeni čelik	

→ v_c/f_z Stranica 45

Usko pločasto glodalo HSS-E Co 5

- ▲ Fino unakrsno nazubljeno
▲ S utorom za prihvata prema DIN 138



DIN 1834 A

DIN 1834 A				
U6				
DC _{js16}	OAH _{k11}	DCONMS _{H7}	ZEFP	Artikl br. 50 340 ...
mm	mm	mm		EUR
63	1,6	22	28	104,30 200
63	2,0	22	28	89,87 202
63	2,5	22	28	91,78 204
63	3,0	22	28	94,11 206
80	1,6	27	32	108,10 300
80	2,0	27	32	105,50 302
80	2,5	27	32	107,00 304
80	3,0	27	32	110,20 306
80	4,0	27	32	118,70 310
100	1,6	32	36	131,50 400
100	2,0	32	36	130,30 402
100	2,5	32	36	130,30 404
100	3,0	32	36	132,50 406
100	4,0	32	36	140,90 410
100	5,0	32	36	154,80 414
125	1,6	32	40	170,70 500
125	2,0	32	40	164,30 502
125	2,5	32	40	169,50 504
125	3,0	32	40	172,70 506
125	4,0	32	40	183,40 510
125	5,0	32	40	196,00 514
125	6,0	32	40	217,30 516
160	2,0	40	48	271,30 600
160	2,5	40	48	261,80 602
160	3,0	40	48	266,00 604
160	4,0	40	48	284,00 606
160	5,0	40	48	298,90 608
160	6,0	40	48	323,20 610
160	8,0	40	36	366,70 612

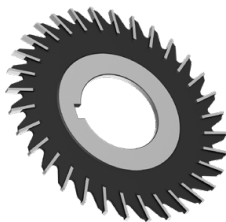
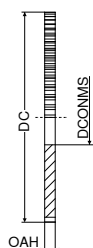
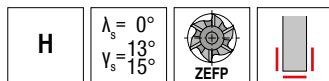
Čelik	●
Nehrđajući čelik	
Lijevano željezo	●
Neželjezni metali	●
Visokootporan na toplinu	●
Kaljeni čelik	

→ v_c/f_z Stranica 45

Usko pločasto glodalo HSS-E Co 5

▲ Ravno nazubljeno

▲ S utorom za prihvatač prema DIN 138



DIN 1834 B

U6

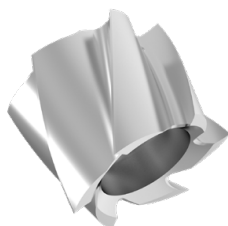
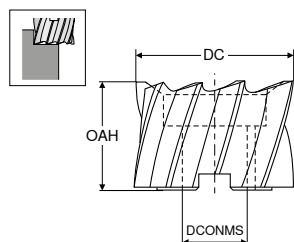
DC _{js16}	OAH _{k11}	DCONMS _{H7}	ZEFP	Artikl br. 50 341 ...	
mm	mm	mm		EUR	
63	1,6	22	32	119,80	200
63	2,0	22	32	106,00	202
63	2,5	22	32	108,10	204
63	3,0	22	32	111,30	206
80	1,6	27	36	129,30	300
80	2,0	27	36	125,00	302
80	2,5	27	36	126,20	304
80	3,0	27	36	131,50	306
80	4,0	27	36	138,80	310
100	1,6	32	40	152,60	400
100	2,0	32	40	152,60	402
100	2,5	32	40	152,60	404
100	3,0	32	40	154,80	406
100	4,0	32	40	168,50	410
100	5,0	32	40	177,00	414
125	1,6	32	44	206,70	500
125	2,0	32	44	197,10	502
125	2,5	32	44	204,60	504
125	3,0	32	44	208,70	506
125	4,0	32	44	222,60	510
125	5,0	32	44	239,50	514
125	6,0	32	44	262,80	516
160	2,0	40	52	320,00	600
160	2,5	40	52	307,30	602
160	3,0	40	52	313,70	604
160	4,0	40	52	330,60	606
160	5,0	40	52	351,80	608
160	6,0	40	52	375,10	610
160	8,0	40	40	430,30	612

Čelik	●
Nehrdajući čelik	○
Lijeвано željezo	●
Neželjezni metali	●
Visokootporan na toplinu	○
Kaljeni čelik	

→ v_c/f_z Stranica 45

Valjkasto čelono glodalo HSS-E Co 5

▲ S utorom za prihvat prema DIN 138



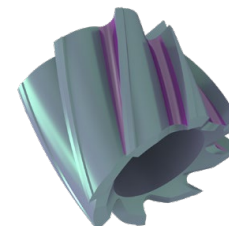
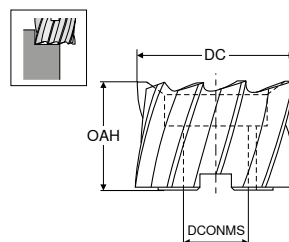
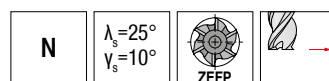
DIN 1880			
U8			
Artikl br. 50 255 ...			
EUR			
DC _{k10}	OAH	DCONMS	ZEFP
mm	mm	mm	
40	32	16	6
50	36	22	6
63	40	27	6
80	45	27	6
100	50	32	6

Čelik	•
Nehrđajući čelik	•
Lijevano željezo	•
Neželjezni metali	•
Visokootporan na toplinu	○
Kaljeni čelik	•

→ v_c/f_z Stranica 46+47

Valjkasto čelono glodalo HSS-E Co 5

▲ S utorom za prihvat prema DIN 138



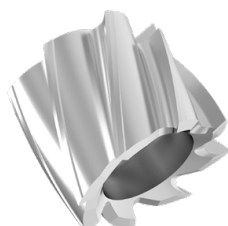
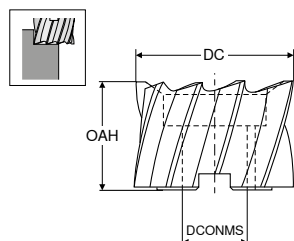
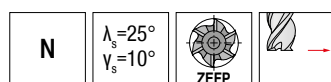
DIN 1880			
U8			
Artikl br. 54 035 ...			
EUR			
DC _{k10}	OAH	DCONMS	ZEFP
mm	mm	mm	
40	32	16	8
50	36	22	8
63	40	27	8
80	45	27	10
100	50	32	12

Čelik	•
Nehrđajući čelik	•
Lijevano željezo	•
Neželjezni metali	•
Visokootporan na toplinu	○
Kaljeni čelik	•

→ v_c/f_z Stranica 46+47

Valjkasto čelono glodalo HSS-E Co 5

▲ S utorom za prihvat prema DIN 138



DIN 1880			
U8			
Artikl br. 50 250 ...			
EUR			
DC _{k10}	OAH	DCONMS	ZEFP
mm	mm	mm	
40	32	16	8
50	36	22	8
63	40	27	8
80	45	27	10
100	50	32	12

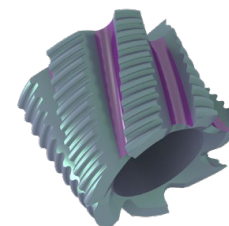
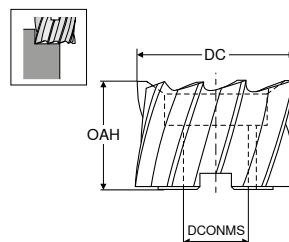
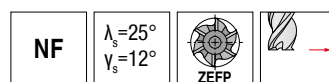
Čelik	•
Nehrđajući čelik	•
Lijevano željezo	•
Neželjezni metali	•
Visokootporan na toplinu	○
Kaljeni čelik	•

→ v_c/f_z Stranica 46+47

Valjkasto čelono glodalo za grubu i finu obradu HSS-E Co 5

▲ S utorom za prihvat prema DIN 138

▲ Proizvodna tolerancija je u pozitivnom području tolerancije js14



DIN 1880			
U8			
Artikl br. 54 036 ...			
EUR			
DC _{js14}	OAH	DCONMS	ZEFP
mm	mm	mm	
40	32	16	7
50	36	22	8
63	40	27	8
80	45	27	10
100	50	32	12

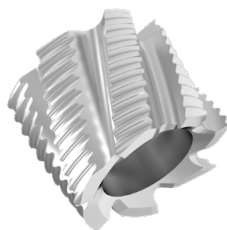
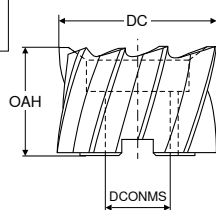
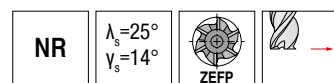
Čelik	•
Nehrđajući čelik	•
Lijevano željezo	•
Neželjezni metali	•
Visokootporan na toplinu	○
Kaljeni čelik	•

→ v_c/f_z Stranica 46+47

Valjkasto čeono glodalo za grubu obradu HSS-E Co 5

▲ S utorom za prihvat prema DIN 138

▲ Proizvodna tolerancija je u pozitivnom području tolerancije js14



DIN 1880			
U8			
Artikl br. 50 260 ...			
DC js14	OAH	DCONMS	ZEFP
mm	mm	mm	
40	32	16	7
50	36	22	8
63	40	27	8
80	45	27	10
100	50	32	12

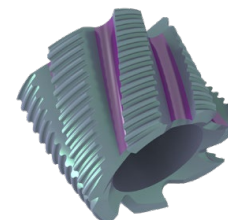
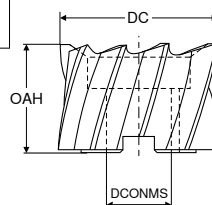
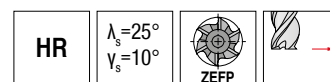
Čelik	●
Nehrđajući čelik	●
Lijevano željezo	●
Neželjezni metali	●
Visokootporan na toplinu	○
Kaljeni čelik	○

→ v_c/f_z Stranica 46+47

Valjkasto čeono glodalo za fino-grubu obradu HSS-E Co 8

▲ S utorom za prihvat prema DIN 138

▲ Proizvodna tolerancija je u pozitivnom području tolerancije js14

Ti100
Pro

DIN 1880			
U8			
Artikl br. 54 037 ...			
DC js14	OAH	DCONMS	ZEFP
mm	mm	mm	
40	32	16	7
50	36	22	8
63	40	27	8
80	45	27	10
100	50	32	12

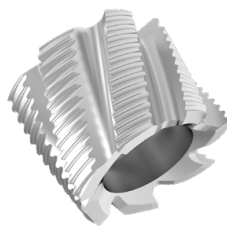
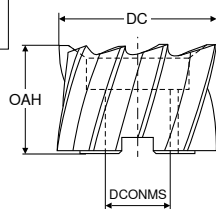
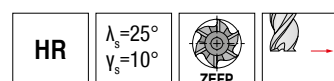
Čelik	●
Nehrđajući čelik	●
Lijevano željezo	●
Neželjezni metali	●
Visokootporan na toplinu	○
Kaljeni čelik	○

→ v_c/f_z Stranica 46+47

Valjkasto čeono glodalo za fino-grubu obradu HSS-E Co 8

▲ S utorom za prihvat prema DIN 138

▲ Proizvodna tolerancija je u pozitivnom području tolerancije js14



DIN 1880			
U8			
Artikl br. 50 297 ...			
DC js14	OAH	DCONMS	ZEFP
mm	mm	mm	
40	32	16	7
50	36	22	8
63	40	27	8
80	45	27	10
100	50	32	12

Čelik	●
Nehrđajući čelik	●
Lijevano željezo	●
Neželjezni metali	●
Visokootporan na toplinu	○
Kaljeni čelik	○

→ v_c/f_z Stranica 46+47

Primjeri materijala za rezne tablice podataka

	Indeks	Materijal	Čvrstoća N/mm ² / HB / HRC	Broj materijala	Oznaka materijala	Broj materijala	Oznaka materijala	Broj materijala	Oznaka materijala
P	1.1	Opći konstrukcijski čelik	< 800 N/mm ²	1.0037	St 37-2	1.0570	St 52-3	1.0060	St 60-2
	1.2	Strojni čelik	< 800 N/mm ²	1.0718	9 SMnPb 28	1.0727	45 S 20	1.0757	46 SPb 2
	1.3	Čelik za cementiranje nelegirani	< 800 N/mm ²	1.0401	C 15	1.0481	17 Mn 4	1.1141	Ck 15
	1.4	Čelik za cementiranje legirani	< 1000 N/mm ²	1.7131	16 MnCr 5	1.7015	13 Cr 3	1.5919	15 CrNi 6
	1.5	Kaljeni čelik nelegirani	< 850 N/mm ²	1.0503	C 45	1.1191	Ck 45	1.0535	C 55
	1.6	Kaljeni čelik nelegirani	< 1000 N/mm ²	1.0601	C 60	1.1221	Ck 60	1.0540	C 50
	1.7	Kaljeni čelik legirani	< 800 N/mm ²	1.5131	50 MnSi 4	1.7030	28 Cr 4	1.7225	42 CrMo 4
	1.8	Kaljeni čelik legirani	< 1300 N/mm ²	1.5755	31 NiCr 14	1.7033	34 Cr 4	1.3565	48 CrMo 4
	1.9	Lijevani čelik	< 850 N/mm ²	0.9650	G-X 260 Cr 27	1.6750	GS-20 NiCrMo 3 7	1.6582	GS-34 CrNiMo 6
	1.10	Nitirani čelik	< 1000 N/mm ²	1.8504	34 CrAl 6	1.8507	34 AlMo 5	1.8509	41 CrAlMo 7
	1.11	Nitirani čelik	< 1200 N/mm ²	1.8515	31 CrMo 12	1.8523	39 CrMoV 19 3	1.8550	34 CrAlNi 7
	1.12	Čelik za valjkaste ležajeve	< 1200 N/mm ²	1.3505	100 Cr6 (W3)	1.3543	X 192 CrMo 17	1.3520	100 CrMn 6
	1.13	Opružni čelik	< 1200 N/mm ²	1.5026	55 Si 7	1.7176	55 Cr 3	1.7701	51 CrMoV 4
	1.14	Čelik za brzu obradu	< 1300 N/mm ²	1.3344	S 6-5-3	1.3255	S 18-1-2-5	1.3294	PMHS6-5-3-8; ASP30
	1.15	Alatni čelik za hladnu obradu	< 1300 N/mm ²	1.2312	40 CrMnMoS 8 6	1.2379	X 155 CrVMo 12 1	1.2316	X36 CrMo 16
	1.16	Alatni čelik za vruću obradu	< 1300 N/mm ²	1.2343	X 38 CrMoV 5 1	1.2567	X 30 WCrV 5 3	1.2744	57 NiCrMov 7 7
M	2.1	Lijevani čelik nehrđajući sulfirirani	< 850 N/mm ²	1.3941	G-X 4 CrNi 18 13	1.4027	G-X 20 Cr 14	1.4107	G-X 8 CrNi 12
	2.2	Nehrdajući čelik, feritni	< 750 N/mm ²	1.4510	X 3 CrTi 17	1.4528	X 105 CrCoMo 18 2	1.4016	X 6 Cr 17
	2.3	Nehrdajući čelik, martenzitni	< 900 N/mm ²	1.4034	X 46 Cr 13	1.4116	X 50 CrMoV 15	1.4106	X 2 CrMoSiS 18 2 1
	2.4	Nehrdajući čelik, feritni/martenzitni	< 1100 N/mm ²	1.4313	X 3CrNi 13 4	1.4028	X 30 Cr 13	1.4104	X 14 CrMoS 17
	2.5	Nehrdajući čelik, austenitni/feritni	< 850 N/mm ²	1.4460	X 8 CrNiMo 27 5	1.4821	X 20 CrNiSi 25 4	1.4462	X 2 CrNiMoN 22 5 3
	2.6	Nehrdajući čelik, austenitni	< 750 N/mm ²	1.4301	X 5 CrNi 18 10	1.4571	X 6 CrNiMoTi 17 12 2	1.4449	X 3 CrNiMo 18 12 3
	2.7	Čelik otporan na toplinu	< 1100 N/mm ²	1.4747	X 80 CrNiSi 20	1.4876	X 10 NiCrAlTi 32 21	1.4841	X 10 NiCrAlTi 32 21
K	3.1	Sivo lijevano željezo s lamelnim grafitom	100-350 N/mm ²	0.6010	GG-10	0.6025	GG-25		
	3.2	Sivo lijevano željezo s lamelnim grafitom	300-500 N/mm ²	0.6030	GG-30	0.6045	GG-45		
	3.3	Sivi lijev sa sferoidalnim grafitom	300-500 N/mm ²	0.7040	GGG-40	0.7050	GGG-50		
	3.4	Sivi lijev sa sferoidalnim grafitom	500-900 N/mm ²	0.7060	GGG-60	0.7080	GGG-80		
	3.5	Temperirani lijev, bijeli	270-450 N/mm ²	0.8035	GTW-35	0.8045	GTW-45		
	3.6	Temperirani lijev, bijeli	500-650 N/mm ²	0.8055	GTW-55	0.8065	GTW-65		
	3.7	Temperirani lijev, crni	300-450 N/mm ²	0.8135	GTS-35	0.8145	GTS-45		
	3.8	Temperirani lijev, crni	500-800 N/mm ²	0.8155	GTS-55	0.8170	GTS-70		
N	4.1	Aluminij (nelegirani, nisko legirani)	< 350 N/mm ²	3.0255	Al99,5	3.3308	Al99,9Mg0,5	3.0256	E-AlH
	4.2	Legure aluminija < 0,5 % Si	< 500 N/mm ²	3.0515	AlMn1	3.1355	AlCuMg2	3.3315	AlMg1
	4.3	Legure aluminija 0,5-10 % Si	< 400 N/mm ²	3.2315	AlMgSi1	3.2373	G-AlSi9Mg	3.2134	G-AlSi5Cu1Mg
	4.4	Legure aluminija 10-15 % Si	< 400 N/mm ²	3.2581	G-AlSi12	3.2583	G-AlSi12(Cu)		
	4.5	Legure aluminija > 15 % Si	< 400 N/mm ²		G-AlSi17Cu4		G-AlSi25CuNiMg		G-AlSi21CuNiMg
	4.6	Bakar (nelegirani, nisko legirani)	< 350 N/mm ²	2.0060	E-Cu57	2.0090	SF-Cu	2.1522	CuSi2Mn
	4.7	Kovane legure bakra	< 700 N/mm ²	2.0205	CuZn0,5	2.1160	CuPb1P	2.1366	CuMn5
	4.8	Posebne legure bakra	< 200 HB	2.0916	CuAl5	2.1525	CuSi3Mn		Ampco 8-16
	4.9	Posebne legure bakra	< 300 HB	2.0978	CuAl11Ni6Fe5				Ampco18-26
	4.10	Posebne legure bakra	> 300 HB	2.1247	CuBe2F125				Ampco M-4
	4.11	Mesing s kratkim strugotinama, bronca, crveni lijev	< 600 N/mm ²	2.0331	CuZn36Pb1,5	2.0380	CuZn39Pb2 (Ms58)	2.0410	CuZn44Pb2
	4.12	Mesing s dugim strugotinama	< 600 N/mm ²	2.0335	CuZn36 (Ms63)	2.1293	CuCrZr	2.1080	CuSn6Zn6
	4.13	Termoplasti		PP	Hostalen	PVC	Makrolon, Novodur		
	4.14	Duromeri			Ferrozell, Bakelit		Pertinax		Resopal
	4.15	Plastika ojačana vlaknima			GFK*		CFK**		AFK***
	4.16	Magnezij i legure magnezija	< 850 N/mm ²	3.5200	MgMn2	3.5612	MgAl6Zn1	3.5812	MgAl8Zn1
	4.17	Grafit			R8500X		R8650		Technograph 15
	4.18	Volfram i legure volframa			W-NiFe (Densimet W)		W-Cu80/20		W93NiFe (DENAL)
	4.19	Molibden i legure molibdena			Mo, Mo-50Re		TZC, TZM		MHC, ODS
S	5.1	Čisti nikal		2.4060	Ni99,6	2.4066	Ni99,2	2.4068	LC-Ni99
	5.2	Legure nikla		1.3912	Ni36 (Invar)	1.3924	Ni54	1.3921	Ni49
	5.3	Legure nikla	< 850 N/mm ²	2.4360	NiCu30Fe	2.4375	NiCu30Al	2.4858	NiCr21Mo
	5.4	Legure nikla i molibdena		2.4600	NiMo29Cr	2.4617	NiMo28	2.4819	NiMo16Cr15W
	5.5	Legure nikla i kroma	< 1300 N/mm ²	2.4886	SG-NiMo16Cr16W	2.4854	NiFe33Cr25Co	2.4816	NiCr15Fe
	5.6	Legure kobalta i kroma	< 1300 N/mm ²	2.4711	CoCr20Ni15Mo	2.4964	CoCr20W15Ni	2.4989	CoCr20NiW
	5.7	Legure visokootporne na toplinu	< 1300 N/mm ²	1.4718	X 45 CrSi 9 3	1.4747	X 80 CrNiSi 20	1.4980	X5 NiCrTi 2615
	5.8	Legure nikla, kobalta i kroma	< 1400 N/mm ²	2.4806	SG-NiCr20Nb, Inconel 82	2.4851	NiCr23Fe, Inconel 601	2.4667	SG-NiCr19NbMoTi
	5.9	Čisti titanij	< 900 N/mm ²	3.7025	Ti99,8	3.7034	Ti99,7	3.7064	Ti99,5
	5.10	Legure titanija	< 700 N/mm ²	3.7114	TiAl5Sn2	3.7174	TiAl6V6Sn2	3.7124	TiCu2
	5.11	Legure titanija	< 1200 N/mm ²	3.7164	TiAl5V4	3.7144	TiAl6Sn2Zr4Mo2	3.7154	TiAl6Zr5
H	6.1		< 45 HRC						
	6.2		46-55 HRC						
	6.3	Kaljeni čelik	56-60 HRC						
	6.4		61-65 HRC						
	6.5		65-70 HRC						

*Pojačano staklenim
vlaknima**Pojačano ugljikovim
vlaknima***Pojačano aramidnim
vlaknima

Referentne vrijednosti brzine rezanja – glodala za uzdužne utore i vretenasta glodala

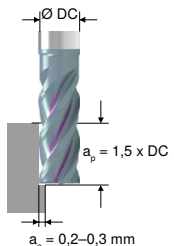
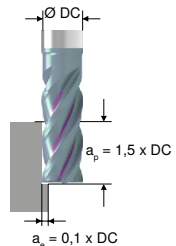
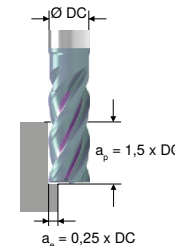
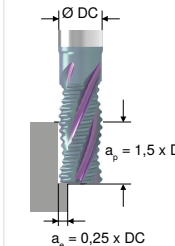
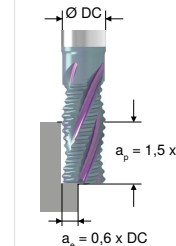
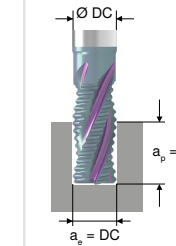
		Bez prevlake	Ti100 Pro	Praškasti čelik			
				Ti100 Pro	1. Odabir		Prikladan
Indeks	Kf _{fz}	v _c u m/min			Emulzija	Stlačen zrak	MMS
1.1	1,2	30-40	60-80	65-90			
1.2	1,2	25-35	50-65	55-75			
1.3	1,2	20-30	45-55	50-65			
1.4	1	15-25	40-55	45-65			
1.5	1,2	20-30	45-55	50-60			
1.6	1	15-20	30-35	35-45			
1.7	1,2	20-30	40-55	45-65			
1.8	0,8	15-20	30-35	35-45			
1.9	1,2	20-30	45-55	50-60			
1.10	1	15-20	30-35	35-45			
1.11	0,8	15-20	30-35	35-45			
1.12	0,8	15-20	30-35	35-45			
1.13							
1.14							
1.15	0,8	12-18	25-30	30-40			
1.16	0,8	10-15	20-25	25-35			
2.1	1	10-15	20-30	25-35			
2.2	1	10-15	20-30	25-35			
2.3	1	8-12	15-25	20-30			
2.4	0,9	7-10	15-20	20-30			
2.5	1	5-8	10-15	15-20			
2.6	1	10-15	20-30	25-35			
2.7							
3.1	1	18-25	35-45	40-55			
3.2	1	18-25	25-30	30-40			
3.3	1	15-20	30-35	35-45			
3.4	1	15-20	30-35	35-45			
3.5	1	15-25	35-40	40-50			
3.6	1	15-20	35-40	40-50			
3.7	1	15-20	30-35	35-45			
3.8	0,8	12-18	25-30	30-40			
4.1	1,9	150-180	240-280	260-300			
4.2	1,9	100-130	130-160	150-180			
4.3	1,8		100-140	140-160			
4.4	1,7		60-130	80-150			
4.5							
4.6	1,2	30-50	60-80	80-100			
4.7	1,1		110-150	130-170			
4.8	0,9	5-10	10-15	20-25			
4.9							
4.10							
4.11	1,1		100-140	130-170			
4.12	1,1	80-120	120-150	140-180			
4.13	2	20-30	25-45	40-60			
4.14	2	30-40	50-70	70-90			
4.15							
4.16	1,8	90-120	140-170	160-190			
4.17	1		30-40	40-50			
4.18	1,1		10-20	15-25			
4.19							
5.1	1,1	5-10	10-15	15-20			
5.2							
5.3							
5.4							
5.5							
5.6							
5.7							
5.8							
5.9	1	10-15	15-25	25-35			
5.10	1,1	10-15	15-20	25-35			
5.11							
6.1							
6.2							
6.3							
6.4							
6.5							

i Kod glodanja punog utora brzinu rezanja navedenu u ovoj tablici (v_c) smanjite za oko 15–20 %!

Kf f_z = faktor korekcije za posmak po zubu.

Posmak po zubu za HSS vretenasta glodala

Referentne vrijednosti (u mm) za posmak po zubu (f_z)

		Podrezivanje										Glodanje punog utora	
													
		f _z u mm		f _z u mm		f _z u mm		f _z u mm		f _z u mm			
Ø DC mm	Bez prevlake	S prevlakom	Bez prevlake	S prevlakom	Bez prevlake	S prevlakom	Bez prevlake	S prevlakom	Bez prevlake	S prevlakom	Bez prevlake	S prevlakom	
2	0,008	0,009	0,008	0,009	0,008	0,009							
3	0,011	0,012	0,010	0,012	0,009	0,010							
4	0,017	0,018	0,014	0,015	0,013	0,014	0,015	0,016	0,013	0,014	0,011	0,012	
5	0,024	0,026	0,018	0,020	0,014	0,015	0,019	0,021	0,016	0,018	0,014	0,016	
6	0,032	0,035	0,022	0,024	0,015	0,017	0,024	0,027	0,020	0,022	0,018	0,019	
8	0,047	0,051	0,029	0,032	0,020	0,022	0,032	0,036	0,027	0,030	0,024	0,026	
10	0,065	0,072	0,037	0,041	0,026	0,028	0,042	0,047	0,035	0,039	0,031	0,034	
12	0,084	0,091	0,044	0,049	0,031	0,034	0,051	0,057	0,043	0,047	0,037	0,041	
14	0,100	0,106	0,054	0,059	0,037	0,041	0,063	0,069	0,053	0,058	0,045	0,050	
16	0,111	0,121	0,061	0,067	0,042	0,046	0,072	0,079	0,060	0,066	0,052	0,057	
18	0,126	0,136	0,070	0,077	0,048	0,053	0,084	0,093	0,071	0,078	0,061	0,067	
20	0,141	0,151	0,076	0,083	0,052	0,057	0,092	0,101	0,077	0,084	0,066	0,073	
22	0,160	0,166	0,085	0,094	0,059	0,065	0,104	0,114	0,087	0,096	0,075	0,082	
25	0,170	0,188	0,095	0,104	0,065	0,072	0,117	0,129	0,098	0,108	0,084	0,093	
28	0,196	0,210	0,109	0,120	0,075	0,083	0,136	0,150	0,114	0,125	0,098	0,108	
32	0,212	0,240	0,124	0,137	0,086	0,094	0,157	0,173	0,131	0,145	0,113	0,125	
36	0,224	0,240	0,144	0,159	0,099	0,109	0,170	0,194	0,142	0,162	0,126	0,140	
40	0,240	0,240	0,157	0,173	0,108	0,119	0,184	0,202	0,154	0,169	0,132	0,146	
45	0,240	0,240	0,157	0,173	0,108	0,119	0,200	0,220	0,170	0,180	0,140	0,160	
50	0,240	0,240	0,157	0,173	0,108	0,119	0,200	0,220	0,170	0,180	0,140	0,160	

Napomena:

Kod glodala bez prevlake obično se daje prednost istosmjernom glodanju pred protusmjernim glodanjem. Kod glodala s prevlakom potrebno je istosmjerno glodanje kako bi se postigao optimalan radni učinak.

i Korekcija posmaka:

Pomnožite vrijednost f_z iz gornje tablice s odgovarajućim **korekcijskim faktorom** $K_f f_z$ iz tablice na → **Stranica 40.**

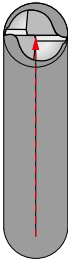
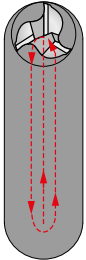
Općenito vrijedi:

$$f_z(\text{glodanje}) = f_z \times K_f f_z$$

$$f_7(\text{bušenje}) = f_7(\text{glodanje}) \div \text{broj zubaca}$$

Posmak po zubu kod glodanja utora dosjednih klinova HSS glodalima za uzdužne uture

Referentne vrijednosti (u mm) za posmak po zubu (f_z)

Glodanje punih dimenzija (u jednome rezu)			Glodanje izvan dimenzija (glodanje u okviru)				Bušenje glodanjem					
												
f _z u mm			f _z u mm				f _z u mm					
Ø DC mm	Bez prevlake		S prevlakom		Bez prevlake		S prevlakom		Bez prevlake		S prevlakom	
2	0,005		0,006		0,005	0,006	0,008	0,009	0,003	0,003	0,002	0,002
3	0,009		0,010		0,009	0,010	0,015	0,016	0,004	0,005	0,003	0,003
4	0,012		0,013		0,012	0,013	0,022	0,024	0,006	0,007	0,004	0,004
5	0,016		0,017		0,016	0,017	0,030	0,033	0,008	0,009	0,005	0,006
6	0,020		0,022		0,020	0,022	0,039	0,043	0,010	0,011	0,007	0,007
8	0,026		0,029		0,026	0,029	0,055	0,061	0,013	0,014	0,009	0,010
10	0,034		0,037		0,034	0,037	0,075	0,082	0,017	0,019	0,011	0,012
12	0,040		0,044		0,040	0,044	0,093	0,101	0,020	0,022	0,013	0,015
14	0,049		0,054		0,049	0,054	0,117	0,118	0,024	0,027	0,016	0,018
16	0,056		0,062		0,056	0,062	0,135	0,135	0,028	0,031	0,019	0,021
18	0,065		0,072		0,065	0,072	0,151	0,151	0,033	0,036	0,022	0,024
20	0,071		0,078		0,071	0,078	0,167	0,167	0,035	0,039	0,024	0,026
22	0,080		0,088		0,080	0,088	0,184	0,184	0,040	0,044	0,027	0,029
25	0,089		0,098		0,089	0,098	0,208	0,208	0,044	0,049	0,030	0,033
28	0,103		0,113		0,103	0,113	0,233	0,233	0,051	0,056	0,034	0,037
32	0,118		0,130		0,118	0,130	0,260	0,260	0,060	0,065	0,040	0,043
36	0,130		0,143		0,130	0,143	0,260	0,260	0,060	0,065	0,040	0,043
40	0,130		0,143		0,130	0,143	0,260	0,260	0,060	0,065	0,040	0,043
45	0,130		0,143		0,130	0,143	0,260	0,260	0,060	0,065	0,040	0,043
50	0,130		0,143		0,130	0,143	0,260	0,260	0,060	0,065	0,040	0,043

i Napomena:

Kod glodala bez prevlake obično se daje prednost istosmjernom glodanju pred protusmjernim glodanjem.
Kod glodala s prevlakom potrebno je istosmjerno glodanje kako bi se postigao optimalan radni učinak.

i Korekcija posmaka:

Pomnožite vrijednost f_z iz gornje tablice s odgovarajućim **korekcijskim faktorom $K_f f_z$** iz tablice na → **Stranica 40**.

Općenito vrijedi:

$$f_z (\text{glodanje}) = f_z \times K_f f_z$$

$$f_z (\text{bušenje}) = f_z (\text{glodanje}) \div \text{broj zubaca}$$

Referentne vrijednosti podataka o rezanju – profilirana glodala

		50 241 ...			50 240 ...					50 234 ...					50 248 ...				● 1. Odabir		○ Prikladan		
		Ø DC 21–25 mm	Ø DC 28–36 mm	Ø DC 40–45 mm	Ø DC 11–16 mm	Ø DC 18–22 mm	Ø DC 25–32 mm	Ø DC 36–45 mm	Ø DC 50–60 mm			Ø DC 10–17 mm	Ø DC 19–26 mm	Ø DC 28–33 mm	Ø DC 33–46 mm	Ø DC 8–11 mm	Ø DC 12–24 mm	Ø DC 26–34 mm	Ø DC 46–48 mm				
Indeks	V _c m/min	f _z mm			f _z mm							f _z mm				f _z mm				Emulzija	Stlačen zrak	MMS	
1.1	28	0,07	0,1	0,12	0,015	0,03	0,03	0,03	0,04	28	0,02	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
1.2	28	0,07	0,1	0,12	0,015	0,03	0,03	0,03	0,04	28	0,02	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
1.3	28	0,07	0,1	0,12	0,015	0,03	0,03	0,03	0,04	28	0,02	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
1.4	28	0,07	0,1	0,12	0,015	0,03	0,03	0,03	0,04	28	0,02	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
1.5	28	0,07	0,1	0,12	0,015	0,03	0,03	0,03	0,04	28	0,02	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
1.6	22	0,06	0,08	0,1	0,015	0,03	0,03	0,03	0,04	22	0,02	0,03	0,035	0,045	0,025	0,055	0,08	0,1	●				
1.7	22	0,06	0,08	0,1	0,015	0,03	0,03	0,03	0,04	22	0,02	0,03	0,035	0,045	0,025	0,055	0,08	0,1	●				
1.8																							
1.9	20	0,06	0,08	0,1	0,015	0,03	0,03	0,03	0,04	20	0,02	0,03	0,035	0,045	0,025	0,055	0,08	0,1	●				
1.10																							
1.11																							
1.12																							
1.13																							
1.14																							
1.15																							
1.16																							
2.1	10	0,06	0,08	0,1	0,01	0,025	0,025	0,025	0,03	10	0,02	0,025	0,03	0,04	0,02	0,045	0,08	0,09	●				
2.2	10	0,06	0,08	0,1	0,01	0,025	0,025	0,025	0,03	10	0,02	0,025	0,03	0,04	0,02	0,045	0,08	0,09	●				
2.3	10	0,06	0,08	0,1	0,01	0,025	0,025	0,025	0,03	10	0,02	0,025	0,03	0,04	0,02	0,045	0,08	0,09	●				
2.4																							
2.5																							
2.6	10	0,06	0,08	0,1	0,01	0,025	0,025	0,025	0,03	10	0,02	0,025	0,03	0,04	0,02	0,045	0,08	0,09	●				
2.7																							
3.1	28	0,07	0,1	0,12	0,015	0,03	0,025	0,04	0,035	24	0,025	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
3.2																			●				
3.3	22	0,07	0,1	0,12	0,015	0,03	0,025	0,04	0,035	22	0,025	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
3.4	20	0,07	0,1	0,12	0,015	0,03	0,025	0,04	0,035	20	0,025	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
3.5	20	0,07	0,1	0,12	0,015	0,03	0,025	0,04	0,035	20	0,025	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
3.6	15	0,07	0,1	0,12	0,015	0,03	0,025	0,04	0,035	15	0,025	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
3.7	20	0,07	0,1	0,12	0,015	0,03	0,025	0,04	0,035	20	0,025	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
3.8	15	0,07	0,1	0,12	0,015	0,03	0,025	0,04	0,035	15	0,025	0,03	0,04	0,05	0,03	0,06	0,1	0,12	●				
4.1	100	0,1	0,12	0,15	0,02	0,045	0,045	0,045	0,055	90	0,03	0,04	0,06	0,07	0,035	0,07	0,14	0,15					
4.2	100	0,1	0,12	0,15	0,02	0,045	0,045	0,045	0,055	90	0,03	0,04	0,06	0,07	0,035	0,07	0,14	0,15	●				
4.3	80	0,09	0,11	0,13	0,015	0,04	0,035	0,04	0,045	80	0,03	0,035	0,045	0,055	0,03	0,06	0,12	0,12	●				
4.4	60	0,09	0,11	0,13	0,015	0,04	0,035	0,04	0,045	60	0,03	0,035	0,045	0,055	0,03	0,06	0,12	0,12	●				
4.5																							
4.6	25	0,08	0,1	0,12	0,015	0,04	0,035	0,03	0,035	25	0,02	0,035	0,045	0,055	0,03	0,06	0,12	0,12	●				
4.7	20	0,08	0,1	0,12	0,015	0,04	0,035	0,03	0,035	20	0,02	0,035	0,045	0,055	0,03	0,06	0,12	0,12	●				
4.8																							
4.9																							
4.10																							
4.11	50	0,09	0,11	0,13	0,015	0,03	0,03	0,03	0,04	45	0,02	0,035	0,045	0,055	0,03	0,06	0,12	0,12	●				
4.12	25	0,09	0,11	0,13	0,015	0,03	0,03	0,03	0,04	25	0,02	0,035	0,045	0,055	0,03	0,06	0,12	0,12	●				
4.13	80	0,12	0,15	0,18	0,025	0,06	0,055	0,055	0,07	80	0,04	0,05	0,07	0,09	0,045	0,1	0,18	0,18	●				
4.14	65	0,12	0,15	0,18	0,025	0,06	0,055	0,055	0,07	65	0,04	0,05	0,07	0,09	0,045	0,1	0,18	0,18	●				
4.15																							
4.16	70	0,1	0,12	0,15	0,018	0,04	0,03	0,035	0,045	70	0,03	0,035	0,05	0,06	0,025	0,06	0,1	0,12	●				
4.17																							
4.18																							
4.19																							
5.1																							
5.2																							
5.3																							
5.4																							
5.5																							
5.6																							
5.7																							
5.8																							
5.9	20	0,06	0,08	0,1	0,012	0,025	0,025	0,025	0,035	20	0,015	0,025	0,035	0,045	0,02	0,05	0,07	0,09					
5.10																							
5.11																							
6.1																							
6.2																							
6.3																							
6.4																							
6.5																							



Podaci o rezanju u velikoj mjeri ovise o vanjskim uvjetima, kao npr. stabilnosti naprezanja alata i radnog komada, materijalu i vrsti stroja!
Navedene vrijednosti predstavljaju moguće podatke o rezanju, koji se moraju korigirati prema uvjetima primjene prema gore ili prema dolje!

Referentne vrijednosti podataka o rezanju – profilirana glodala

		50 245 ... / 50 246 ...					50 360 ...				50 362 ...				● 1. Odabir		○ Prikladan	
		Ø DC 16 mm a _e = 3,2	Ø DC 20 mm a _e = 4	Ø DC 25 mm a _e = 5			Ø DC 50 mm a _e = 5	Ø DC 63 mm a _e = 6,3	Ø DC 80 mm a _e = 8	Ø DC 100 mm a _e = 10	Ø DC 40-50 mm	Ø DC 63 mm	Ø DC 80 mm	Ø DC 100 mm				
Indeks	v _c m/min	f _z mm					v _c m/min	f _z mm				f _z mm				Emulzija	Slačen zrak	MMS
1.1	28	0,01	0,015	0,018			22	0,01	0,01	0,015	0,02	0,005	0,008	0,01	0,012	●		
1.2	28	0,01	0,015	0,018			22	0,01	0,01	0,015	0,02	0,005	0,008	0,01	0,012	●		
1.3	28	0,01	0,015	0,018			22	0,01	0,01	0,015	0,02	0,005	0,008	0,01	0,012	●		
1.4	28	0,01	0,015	0,018			22	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
1.5	28	0,01	0,015	0,018			22	0,01	0,01	0,015	0,02	0,005	0,008	0,01	0,012	●		
1.6	22	0,01	0,015	0,018			20	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
1.7	22	0,01	0,015	0,018			20	0,01	0,01	0,015	0,02	0,005	0,008	0,01	0,012	●		
1.8																		
1.9	20	0,01	0,015	0,015			20	0,01	0,01	0,015	0,02	0,005	0,008	0,01	0,012	●		
1.10																		
1.11																		
1.12																		
1.13																		
1.14																		
1.15																		
1.16																		
2.1	10	0,007	0,01	0,012			10	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
2.2	10	0,007	0,01	0,012			10	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
2.3	10	0,007	0,01	0,012			10	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
2.4																		
2.5																		
2.6	10	0,007	0,01	0,015												●		
2.7																		
3.1	24	0,01	0,012	0,015			19	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
3.2							12	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
3.3	22	0,01	0,012	0,015			15	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
3.4	20	0,01	0,012	0,015			12	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
3.5	20	0,01	0,012	0,015			16	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
3.6	15	0,01	0,012	0,015														
3.7	20	0,01	0,012	0,015			13	0,008	0,01	0,012	0,018	0,005	0,008	0,01	0,012	●		
3.8	15	0,01	0,012	0,015														
4.1	90	0,01	0,015	0,02														
4.2	90	0,01	0,015	0,02			70	0,012	0,015	0,02	0,024	0,008	0,012	0,014	0,018	●		
4.3	80	0,01	0,015	0,02			60	0,012	0,015	0,02	0,024	0,008	0,012	0,014	0,018	●		
4.4	60	0,01	0,015	0,02			60	0,012	0,015	0,02	0,024	0,008	0,012	0,014	0,018	●		
4.5																		
4.6	25	0,01	0,015	0,02			18	0,01	0,012	0,015	0,018	0,005	0,008	0,01	0,012	●		
4.7	20	0,01	0,015	0,02			20	0,01	0,012	0,015	0,018	0,005	0,008	0,01	0,012	●		
4.8																		
4.9																		
4.10																		
4.11	45	0,01	0,015	0,02			40	0,01	0,012	0,015	0,018	0,005	0,008	0,01	0,012	●		
4.12	25	0,01	0,015	0,015			20	0,01	0,012	0,015	0,018	0,005	0,008	0,01	0,012	●		
4.13	80	0,018	0,02	0,025			65	0,015	0,02	0,025	0,03	0,008	0,012	0,018	0,022	●		
4.14	65	0,018	0,02	0,025			60	0,015	0,02	0,025	0,03	0,008	0,012	0,018	0,022	●		
4.15																		
4.16	70	0,01	0,015	0,0175			45	0,01	0,012	0,015	0,018	0,005	0,008	0,01	0,01	●		
4.17																		
4.18																		
4.19																		
5.1																		
5.2																		
5.3																		
5.4																		
5.5																		
5.6																		
5.7																		
5.8																		
5.9	20	0,008	0,01	0,015			20	0,008	0,01	0,012	0,016	0,005	0,007	0,009	0,012	●		
5.10																		
5.11																		
6.1																		
6.2																		
6.3																		
6.4																		
6.5																		



Podaci o rezanju u velikoj mjeri ovise o vanjskim uvjetima, kao npr. stabilnosti naprezanja alata i radnog komada, materijalu i vrsti stroja!
Navedene vrijednosti predstavljaju moguće podatke o rezanju, koji se moraju korigirati prema uvjetima primjene prema gore ili prema dolje!

Referentne vrijednosti podataka o rezanju – pločasta glodala

		Bez prevlake						● 1. Odabir		○ prikladan	
		Ø DC 50 mm	Ø DC 63 mm	Ø DC 80 mm	Ø DC 100 mm	Ø DC 125 mm	Ø DC 160 mm	Emulzija	Stlačen zrak	MMS	
Indeks	v _c u m/min	f _z mm									
1.1	30-40	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,095-0,11	0,1-0,12	●			
1.2	30-40	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,095-0,11	0,1-0,12	●			
1.3	30-40	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,095-0,11	0,1-0,12	●			
1.4	20-30	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
1.5	20-25	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,095-0,11	0,1-0,12	●			
1.6	15-30	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
1.7	20-25	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
1.8	10-15	0,03-0,04	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	●			
1.9	18-25	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
1.10	15-30	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
1.11	12-18	0,03-0,04	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	●			
1.12	15-20	0,03-0,04	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	●			
1.13											
1.14											
1.15	10-15	0,03-0,04	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	●			
1.16	10-15	0,03-0,04	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	●			
2.1	12-18	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
2.2	10-15	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
2.3	8-12	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
2.4	7-10	0,03-0,04	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	●			
2.5	5-8	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
2.6	10-15	0,03-0,04	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	●			
2.7											
3.1	20-30	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
3.2	18-25	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
3.3	18-25	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
3.4	15-20	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
3.5	25-35	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
3.6	18-25	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
3.7	25-35	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
3.8	18-25	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
4.1	150-180	0,06-0,075	0,075-0,09	0,009-0,1	0,01-0,12	0,12-0,135	0,135-0,15	●			
4.2	100-130	0,06-0,075	0,075-0,09	0,009-0,1	0,01-0,12	0,12-0,135	0,135-0,15	●			
4.3	80-100	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,095-0,11	0,1-0,12	●			
4.4	40-60	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,095-0,11	0,1-0,12	●			
4.5											
4.6	30-50	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,095-0,11	0,1-0,12	●			
4.7	90-110	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
4.8	5-10	0,03-0,04	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	●			
4.9											
4.10											
4.11	80-100	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
4.12	80-120	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
4.13	20-30	0,08-0,1	0,1-0,12	0,12-0,14	0,14-0,16	0,16-0,18	0,18-0,2	●			
4.14	30-40	0,08-0,1	0,1-0,12	0,12-0,14	0,14-0,16	0,16-0,18	0,18-0,2	●			
4.15											
4.16	90-120	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,095-0,11	0,1-0,12		●		
4.17											
4.18											
4.19											
5.1	5-10	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
5.2											
5.3											
5.4											
5.5											
5.6											
5.7											
5.8											
5.9	10-15	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
5.10	10-15	0,04-0,05	0,05-0,06	0,06-0,07	0,07-0,08	0,08-0,09	0,09-0,1	●			
5.11											
6.1											
6.2											
6.3											
6.4											
6.5											

i Korektivni faktor posmaka (Kf f_z) za pločasto glodalo dobiveno iz dubine intruzije (a_e).

a _e	Kf f _z
0,05 x DC	1,4
0,1 x DC	1,0
0,15 x DC	0,8
0,2 x DC	0,7
0,25 x DC	0,6

Referentne vrijednosti brzine rezanja – valjkasta čeona glodala

		Bez prevlake	Ti100 Pro	●		○
				1. Odabir		prikladan
Indeks	Kff _z	v _c u m/min		Emulzija	Stlačen izrak	IMMS
1.1	1,2	25–30	50–60	●		
1.2	1,2	25–30	45–55	●		
1.3	1,2	25–30	45–55	●		
1.4	1	20–25	40–50	●		
1.5	1,2	20–25	40–50	●		
1.6	1	15–30	30–40	●		
1.7	1,2	20–25	40–50	●		
1.8	0,8	10–15	20–30	●		
1.9	1,2	18–25	35–45	●		
1.10	1	15–30	30–40	●		
1.11	0,8	12–18	25–35	●		
1.12	0,8	15–20	30–40	●		
1.13						
1.14						
1.15	0,8	10–15	20–30	●		
1.16	0,8	10–15	20–30	●		
2.1	1	12–18	20–25	●		
2.2	1	10–15	15–20	●		
2.3	1	8–12	20–25	●		
2.4	0,9	7–10	15–20	●		
2.5	1	5–8	10–15	●		
2.6	1	10–15	15–20	●		
2.7						
3.1	1	20–30	30–40	●		
3.2	1	18–25	30–35	●		
3.3	1	18–25	30–35	●		
3.4	1	15–20	25–30	●		
3.5	1	25–35	35–40	●		
3.6	1	18–25	30–35	●		
3.7	1	25–35	35–40	●		
3.8	1	18–25	30–35	●		
4.1	1,5	150–180		●		
4.2	1,5	100–130		●		
4.3	1,3	80–100		●		
4.4	1,3	40–60		●		
4.5						
4.6	1,2	30–50	60–80	●		
4.7	1,1	90–110	120–150	●		
4.8	0,9	5–10	10–15	●		
4.9						
4.10						
4.11	1,1	80–100	110–140	●		
4.12	1,1	80–120	120–150	●		
4.13	2	20–30	25–45	●		
4.14	2	30–40	50–70	●		
4.15						
4.16	1,3	90–120	120–140		●	
4.17	1		30–40		●	
4.18	1,1		15–25	●		
4.19						
5.1	1,1	5–10	10–15	●		
5.2						
5.3						
5.4						
5.5						
5.6						
5.7						
5.8						
5.9	1	10–15	15–25	●		
5.10	1,1	10–15	15–20	●		
5.11	0,8		10–15	●		
6.1						
6.2						
6.3						
6.4						
6.5						

i Kf f_z = faktor korekcije za posmak po zubu.

Posmak po zubu za HSS valjkasta čeona glodala

Referentne vrijednosti (u mm) za posmak po zubu (f_z)

Ø DC mm	N		NF HR NR		W	
	f_z u mm		f_z u mm		f_z u mm	
	Bez prevlake	Ti100 Pro	Bez prevlake	Ti100 Pro	Bez prevlake	
40	0,049	0,054	0,064	0,070	0,060	
50	0,055	0,060	0,071	0,078	0,066	
63	0,061	0,067	0,079	0,087	0,074	
80	0,065	0,071	0,084	0,092	0,078	
100	0,059	0,065	0,076	0,084	0,071	

i Korekcija posmaka:Pomnožite vrijednost f_z iz gornje tablice s odgovarajućim **korekcijskim faktorom $K_f f_z$** iz tablice na → **Stranica 46**.

Općenito vrijedi:

$$f_z (\text{glodanje}) = f_z \times K_f f_z$$

$$f_z (\text{bušenje}) = f_z (\text{glodanje}) \div \text{broj zubaca}$$

Formule za izračun podataka o rezanju

Oznaka	Kratice	Jedinica	Formula
Broj okretaja	n	min ⁻¹	$n = \frac{v_c \times 1000}{DC \times \pi}$
Brzina rezanja	v_c	m/min	$v_c = \frac{DC \times \pi \times n}{1000}$
Posmak po zubu	f_z	mm	$f_z = \frac{v_f}{Z \times n} \quad f_z = h_m \times \sqrt{\frac{DC}{a_e}}$
Posmak po okretaju	f	mm	$f = f_z \times Z$
Brzina posmaka	v_f	mm/min	$v_f = f_z \times Z \times n$
Srednja debljina	h_m	mm	$h_m = f_z \times \sqrt{\frac{a_e}{DC}}$

Z = Broj zubaca

 a_e = Širina ulaska glodala (kod dubine intruzije pločastog glodala)

DC = Promjer oštrice

Prevlaka

Ti100
Pro

- ▲ Višeslojno prevlačenje Ti
- ▲ HV0,05 = 3500
- ▲ Koeficijent trenja (prema čeliku) = 0,7
- ▲ Maksimalna temperatura primjene: 900 °C