Novi proizvodi za strojarske tehničare

NEW DHFC

Dvostrani sustav glodanja s visokim posmakom.

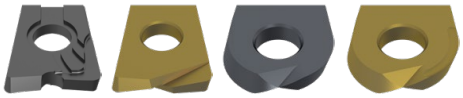
NEW HPC-04

Sustav glodanja PKD i CBN Ø 20–40 mm.

NEW CTCS245

Nova Dragonskin prevlaka visokog učinka za ISO S područje primjene.

NEW Ažuriranje vrsti za sustav K2000



Nove vrste visokog učinka za izradu kalupa.

NEW Dodatak MaxiMill 270-19

Nove veličine sustava s veličinom okretne pločice 19 mm za tešku strojnu obradu.

NEW Dodatak MaxiMill 273

Podesivo glodalo s podešavanjem Duljine.

NEW Dodatak MaxiMill 491

Proširenje okretne pločice u veličini SNHU 09.. RE 1,2 i RE 1,6 kao i druge vrste za područje primjene ISO M i S.

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

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CERATIZIT \ Performance

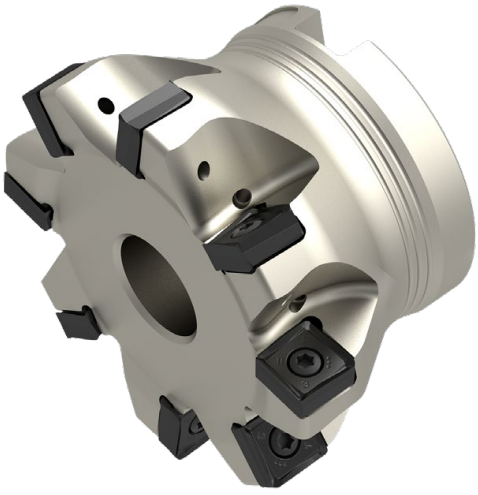
Alati vrhunske kvalitete za vrhunske radne učinke.

Alati vrhunske kvalitete iz linije proizvoda **CERATIZIT 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

Centralno unutarnje hlađenje

Bočno unutarnje hlađenje



ZNF = Broj zubaca

● = **Glavna primjena**

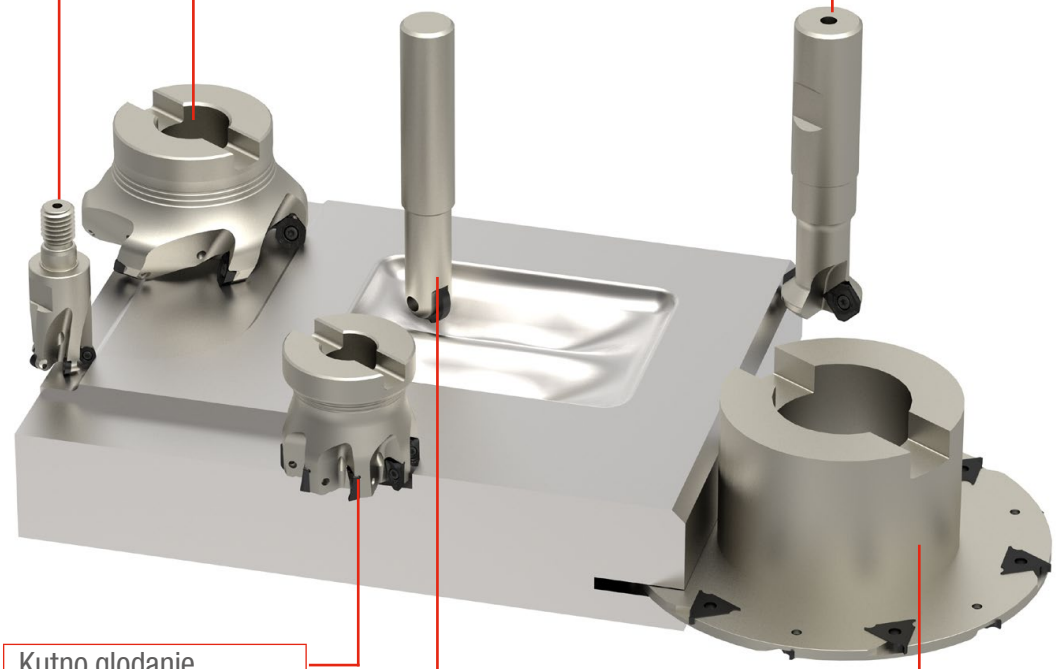
○ = Sporedna primjena

Toolfinder – Pomoć pri odabiru primjene

Profilirano glodanje
→ Odabir sustava:
8+9

Ravno glodanje
→ Odabir sustava:
4+5

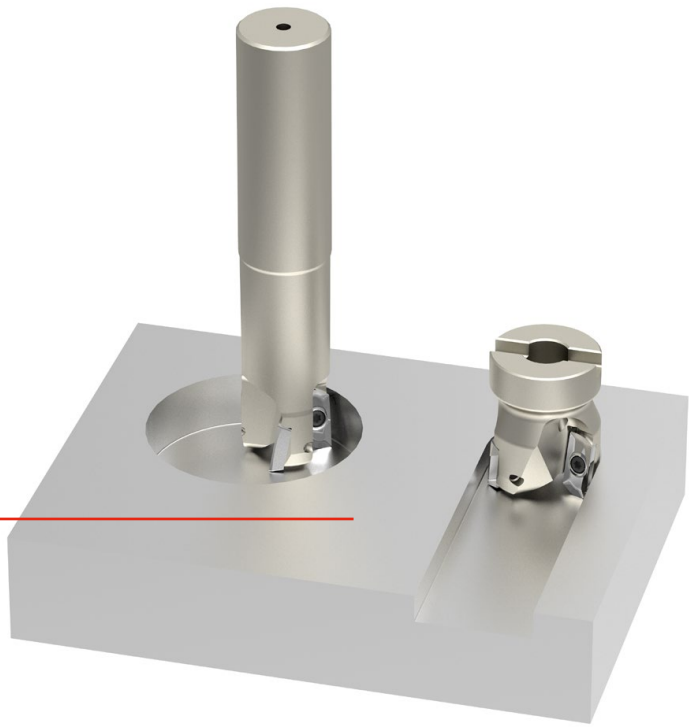
Glodanje skošenja/kutova
→ Odabir sustava:
10



Kutno glodanje
→ Odabir sustava:
6+7

Glodanje utora/višenamjensko glodanje
→ Odabir sustava:
10

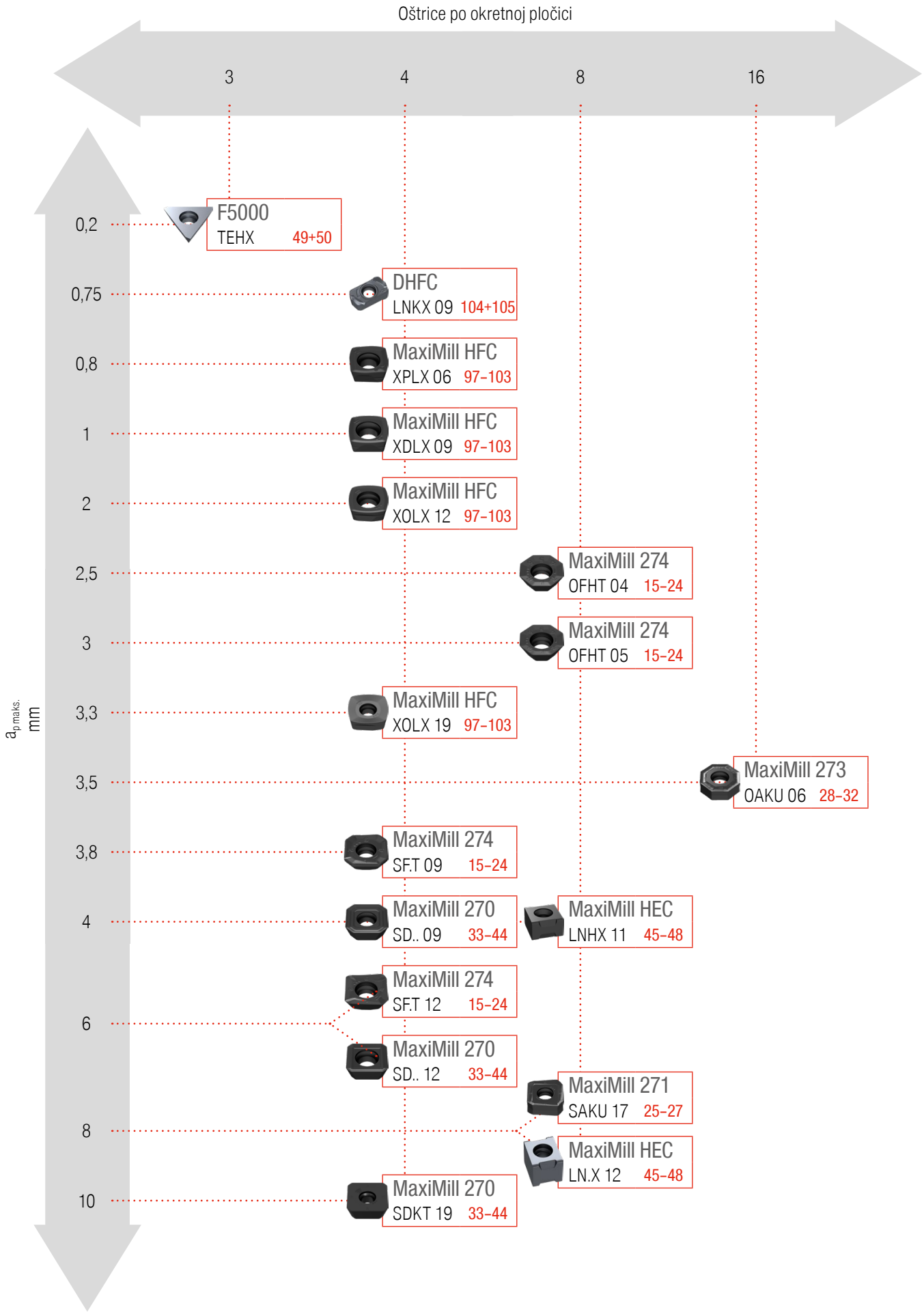
Profilirano glodanje
→ Odabir sustava:
8+9



HSC/HPC glodanje
→ Odabir sustava:
6+7

15

Toolfinder – Ravno glodanje



Pregled – Ravno glodanje

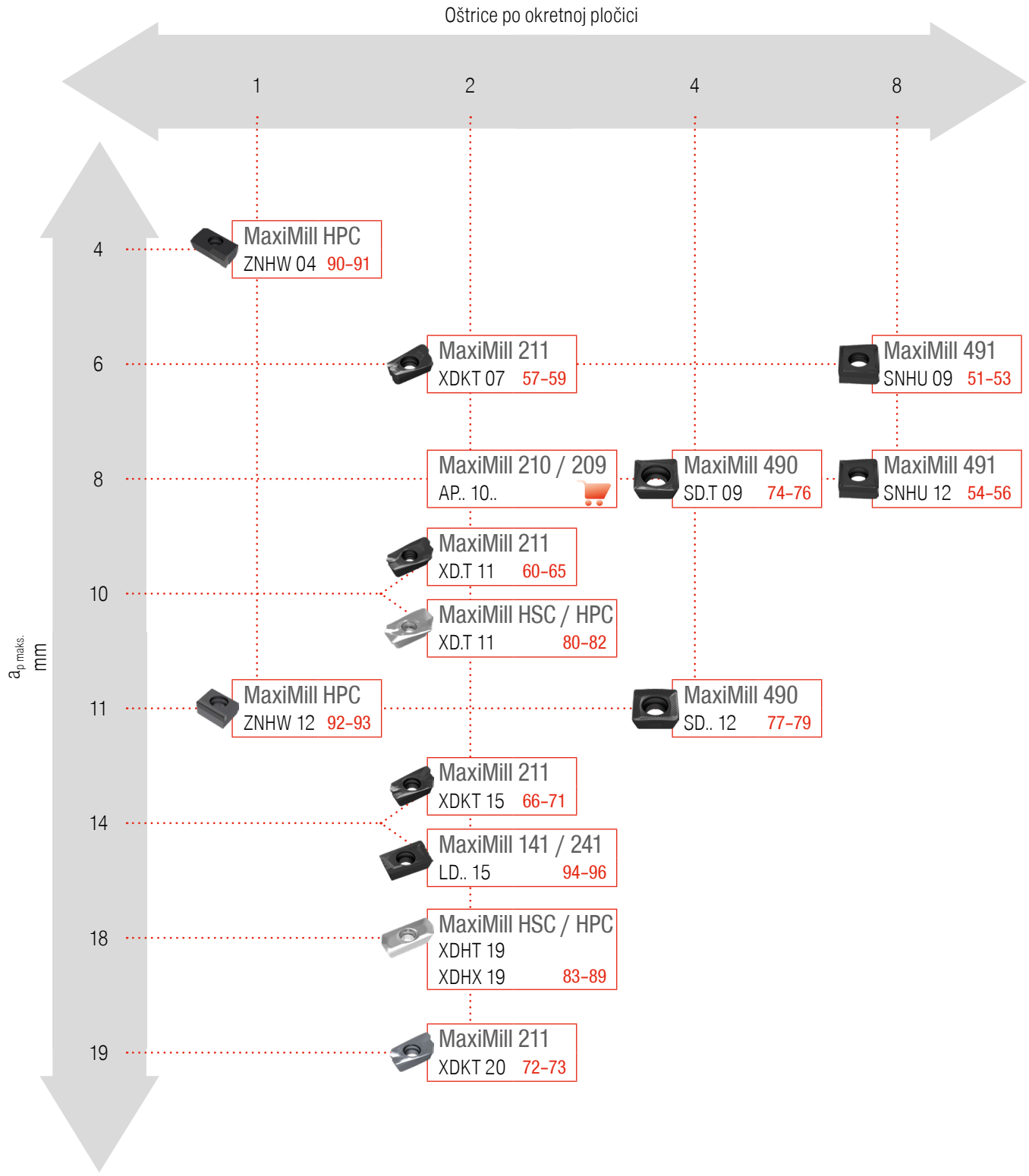
Sustav	Okretna pločica	Oštrice po okretnoj pločici	$a_{p\ maks.}$ mm	Raspon Ø mm			Čelik	Nehrđajući čelik	Lijevano željezo	Neželjezni metali	Visokootporan na toplinu	Kaljeni čelik	Stranica
MaxiMill 274	OFH. 04.. / 05.. | SF.T 09.. / 12..	8 / 4	2,5–6	Ø 20–32	Ø 20–32	Ø 32–160	●	●	●	●	●		15–24
MaxiMill 271	SAKU 1706..	8	8,4			Ø 50–250	●	●	●		●		25–27
MaxiMill 273	OAKU 0605..	16	3,5		Ø 32–40	Ø 40–250	●	●	●		●		28–32
MaxiMill 270	SD.. 0903.. / 1204.. / 19..	4	4–10	Ø 16–32	Ø 6–32	Ø 32–315	●	●	●	●	●		33–44
MaxiMill HEC	LNHX 1106.. | LN.X 1210..	8	4–8			Ø 50–160	●	○	●				45–48
F 5000	TEHX 16T3..	3	0,2			Ø 42–100	●	○	●	○		●	49–50
MaxiMill HFC	X..X 06.. / 09.. / 12.. / 19..	4	0,8–3,3	Ø 16–42	Ø 16–35	Ø 32–160	●	●	●		●		97–103
DHFC	LNKX 09..	4	0,75	Ø 16–42	Ø 16–20		●	●	●		●	●	104–105

Ostali promjeri dostupni su na upit

Okretne pločice za sustave koji više nisu na popisu možete pronaći u našem internetskom dućanu pod cuttingtools.ceratizit.com

15

Toolfinder – Kutno glodanje



Pregled – Kutno glodanje

Sustav	Okretna pločica	Oštrice po okretnoj pločici	$a_{p\ maks.}$ mm	Raspon Ø mm				Čelik	Nehrđajući čelik	Lijevano željezo	Neželjezni metali	Visokootporan na toplinu	Kaljeni čelik	Stranica
MaxiMill 491	SNHU 09T3.. / 1204..	8	6–8	Ø 25–32	Ø 25–32	Ø 40–160		●	●	●	●	●		51–56
MaxiMill 211	XD.T 0703.. / 11T3.. / 1505.. / 2007..	2	6–19	Ø 16–40	Ø 10–40	Ø 32–160		●	●	●	●	●	○	57–73
MaxiMill 211 K	XD.T 11T3.. / 1505.. / 2007..	2	27–75,5		Ø 25–50	Ø 40–50		●	●	●	●	●		57–73
MaxiMill 490	SD.. 09T3.. / 1205..	4	8–11	Ø 25–40	Ø 25–32	Ø 40–160		●	●	●	●	●		74–79
MaxiMill 490 K	SD.. 09T3..	4	41			Ø 40–63		●	●	●	●	●		74–79
MaxiMill HSC / HPC	XD.. 11T3.. / 1904..	2	10–18	Ø 16–40	Ø 16–32	Ø 40–125	Ø 25–50			○	●			80–89
MaxiMill HPC	ZNHW 04T3.. / 1205..	1	4–11	Ø 20–40	Ø 20–40	Ø 40–315	Ø 40–160			●	●		○	90–93
MaxiMill 141 / 241	LD.. 1504..	2	14	Ø 25–40	Ø 20–32	Ø 40–100		●	●	●	●			94–96
MaxiMill 210 / 209	AP.. 1003..	2	8	Ø 16,0–31,7	Ø 9,7–32	Ø 40–125		●	●	●	●	●	●	

Ostali promjeri dostupni su na upit

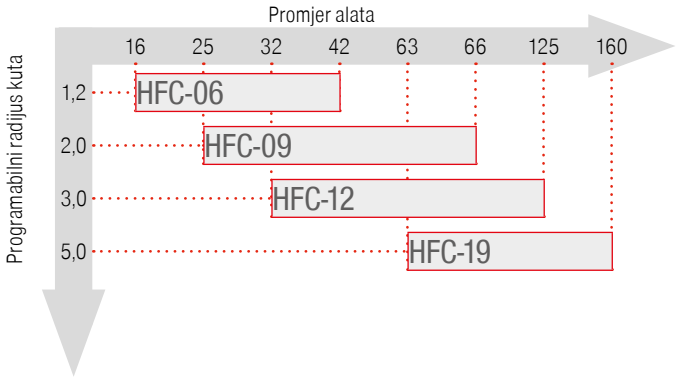
Okretne pločice za sustave koji više nisu na popisu možete pronaći u našem internetskom dućanu pod cuttingtools.ceratizit.com

Ovaj artikl možete pronaći u našem internetskom dućanu pod cuttingtools.ceratizit.com

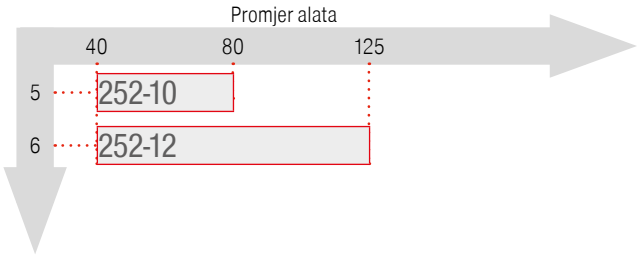
15

Toolfinder – Oblikovno glodanje

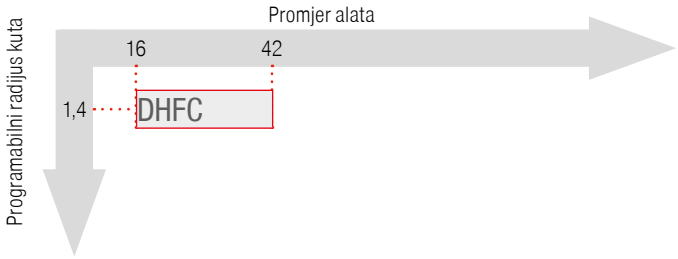
MaxiMill HFC 97–103



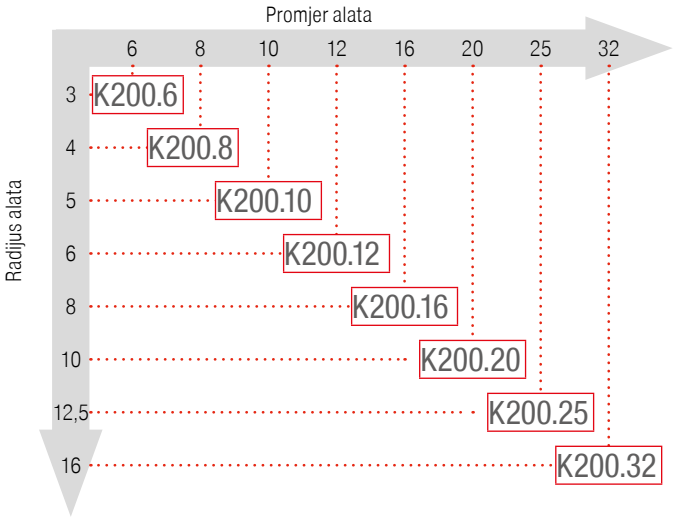
MaxiMill 252 119+120



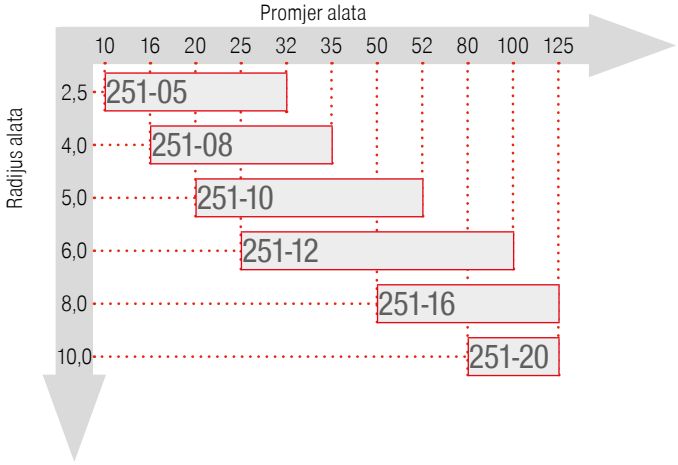
DHFC 104+105



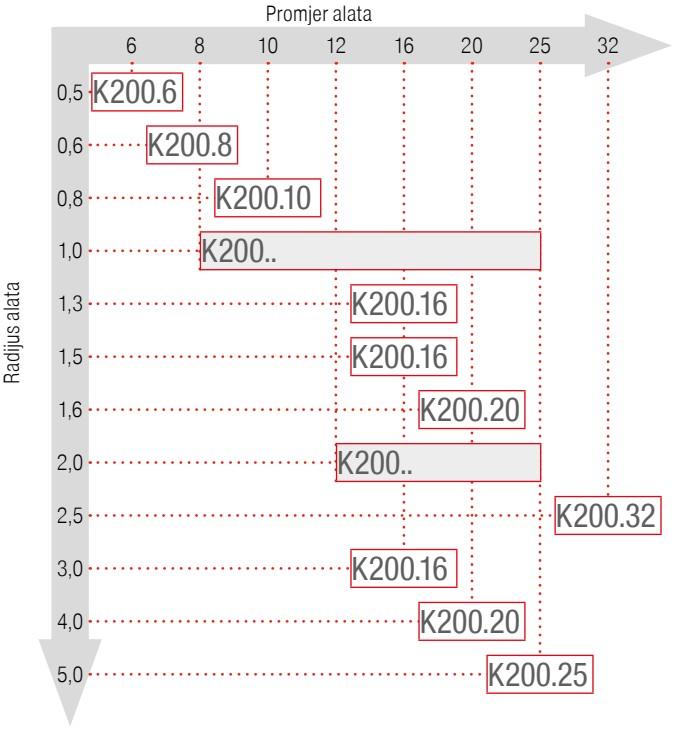
K200. Radijus 121–125



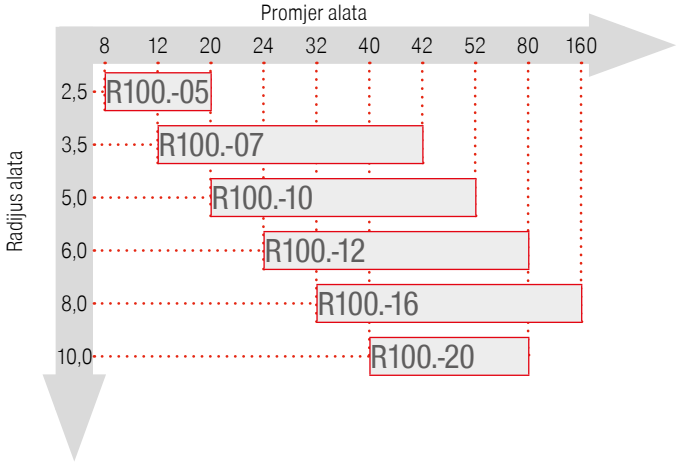
MaxiMill 251 106–113



K200. Torus 126–129



R100. 114–118



Područje primjene

Promjer alata

Pregled – Oblikovno glodanje

Sustav	Okretna pločica	Oštrice po okretnoj pločici	$a_{p\ maks.}$ mm	Raspon Ø mm			Čelik	Nehrđajući čelik	Lijevano željezo	Neželjezni metali	Visokootporan na toplinu	Kaljeni čelik	Stranica
MaxiMill HFC	X.LX 06.. / 09.. / 12.. / 19..	4	0,8–3,3	Ø 16–42	Ø 16–35	Ø 32–160	●	●	●		●		97–103
DHFC	LNKX 09..	4	0,75	Ø 16–42	Ø 16–20		●	●	●		○	○	104+105
MaxiMill 251	R..X 05.. / 08.. / 10.. / 12.. / 16.. / 20..	8	2,5–10	Ø 10–42	Ø 10–32	Ø 40–125	●	●	●	●	●		106–113
R100.	RD.X 05.. / 07.. / 10.. / 12.. / 16.. / 20..	8	5	Ø 12–42	Ø 8–20	Ø 42–160	●	●	●	●	○	●	114–118
MaxiMill 252	RNHU 10.. / 12..	8	3			Ø 40–125	●	●	○		●		119+120
K200. Radijus	RO.X .... / XOHX	1	0,4–8	Ø 8–32	Ø 6–32		●	●	●	●	●	●	121–125
K200. Torus	XO.X	1	0,5–8	Ø 8–32	Ø 8–32		●	●	●	●	●	●	126–129

Ostali promjeri dostupni su na upit

Okretne pločice za sustave koji više nisu na popisu možete pronaći u našem internetskom dućanu pod cuttingtools.ceratizit.com

15

Pregled – Glodanje skošenja/kuteva

Sustav	Okretna pločica	Oštrice po okretnoj pločici	$a_{p\,maks.}$ mm	Raspon Ø mm		Čelik	Nehrđajući čelik	Lijevano željezo	Neželjezni metali	Visokootporan na toplinu	Kaljeni čelik	Stranica
MaxiMill 272	SD.. 0903..	4	4		Ø 6–25	●	●	○	●	●		35+36
4500	SD.. 09T3..	4	4		Ø 16–25	●	●	●	●	●		75+76
4500	SD.. 1205..	4	4	Ø 20–32	Ø 20–32	●	●	●	●	●		78+79
MaxiMill 242	LD.. 1504..	2			Ø 50–92	○	●			●		95+96

Ostali promjeri dostupni su na upit.

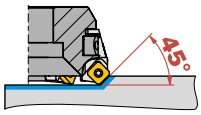
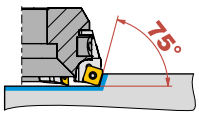
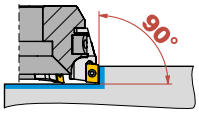
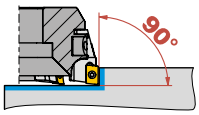
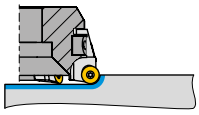
Pregled – Glodanje utora/višenamjensko glodanje

Sustav	Okretna pločica	Oštrice po okretnoj pločici	$a_{p\,maks.}$ mm	Raspon Ø mm		Čelik	Nehrđajući čelik	Lijevano željezo	Neželjezni metali	Visokootporan na toplinu	Kaljeni čelik	Stranica
FM	FM..	1	49		Ø 100–160	●	●	●	●			130+131
TX	TX.. R/L	3	64	Ø 80–160	Ø 100–200	●	●	●	●	●		132–134

Ostali promjeri dostupni su na upit.

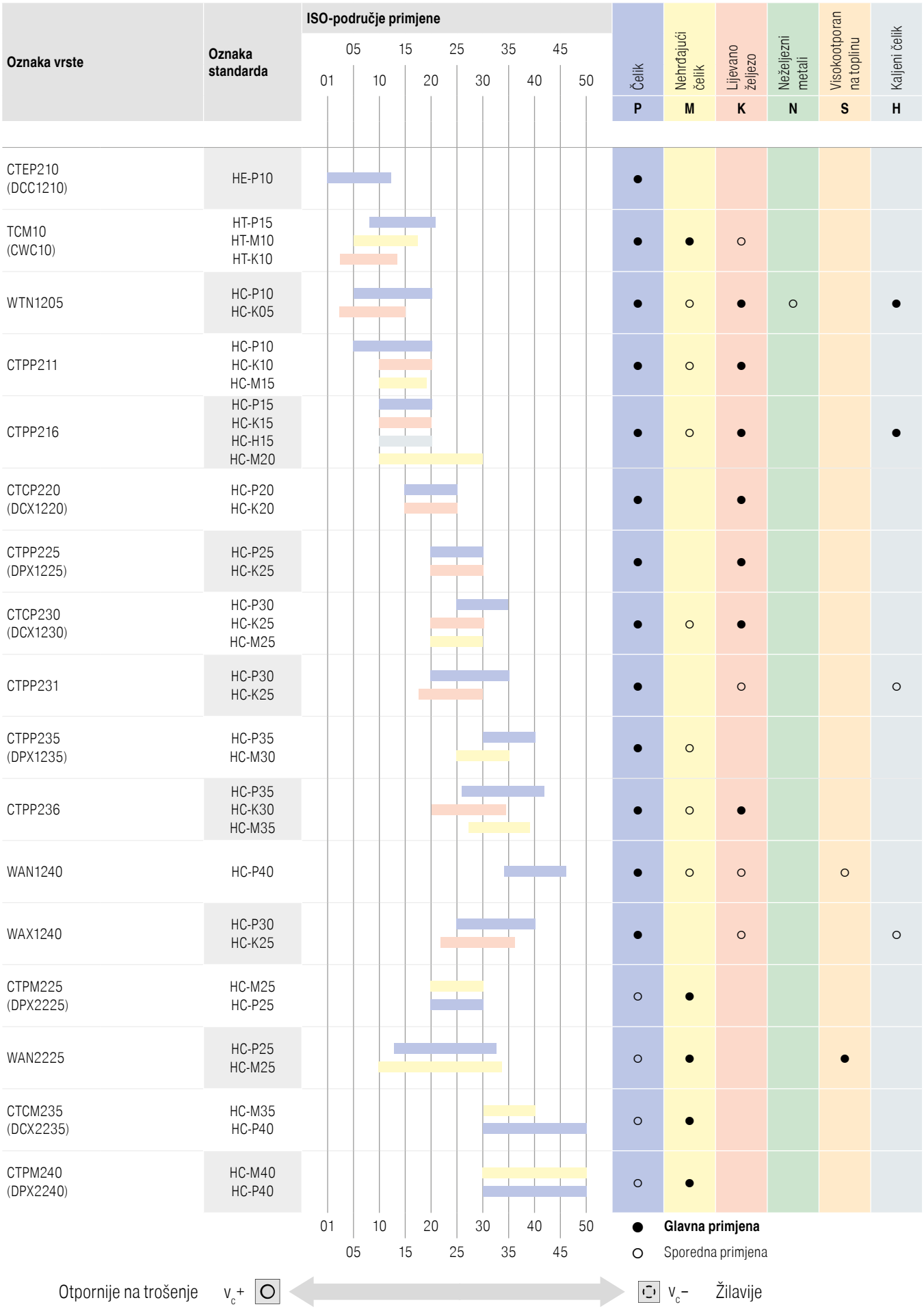
Pregled – Kombinirano glodanje

Sustav	Raspon Ø mm	Stranica
MaxiMill 260	80–400	135

													Stranica
	**Br. kazete**	**041**	**031**			**029**		**032**		**057**			136
				SD.. 0903..	SD.. 1204.. XD.. 1204..		SE.. 1204..		SD.. 1504..		OA.. 0605.. XA.. 0605..		
	**Br. kazete**	**018**											136
			SP.. 1204..										
	**Br. kazete**	**042**		**039**		**051**		**025**					136
			AP.. 1003..		SD.. 1205..		LD.. 1504..		TP.. 2204..				
	**Br. kazete**	**055**		**054**		**056**							136
			SD.. 09T3		XD.. 11T3		XD.. 1505						
	**Br. kazete**	**052**		**053**									136
			RP.X 1204..		RP.X 1604..								

15

Toolfinder – Odabir vrste



Toolfinder – Odabir vrste

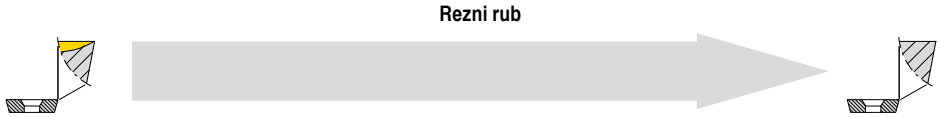
Oznaka vrste	Oznaka standarda	ISO-područje primjene	Čelik P	Nehrđajući čelik M	Lijevano željezo K	Neželjezni metali N	Visokootporan na toplinu S	Kaljeni čelik H
CTPM241	HC-M40 HC-P40		○	●			●	
CTPM245 (DPX2245)	HC-M45 HC-P50		○	●				
CTN3105 (CTS3105)	CN-K05				●			
CTL3215 (CWB3215)	BC-K10 BC-H10				●			
CTCK215 (DCX3215)	HC-K15				●			
CTPK220 (DPX3220)	HC-K20				●			
CTPK221	HC-K10 HC-M15			○	●		○	○
CTPK226	HC-K15 HC-H15 HC-P15		○		●			●
CTPK231	HC-P30 HC-K30		●		●			
CTD4205 (CWD4205)	DP-N05					●		
AMZ (AMZ)	HC-N10 HC-P10 HC-K10		○		○	●		
WUN4210	HT-N10 HT-M15			○		●		
CTCN211	HC-N10					●		
H216T	HW-N15 HW-K15 HW-S15				●	●	○	
CTC5240 (HCF5240)	HC-S35 HC-M35			●			●	
CTCS245	HC-S40						●	
CTP6215 (CCN6215)	HC-K15 HC-H15		○		●			●

ISO-područje primjene: 01 05 10 15 20 25 30 35 40 45 50

● **Glavna primjena**
○ Sporedna primjena

Otpornije na trošenje v_c+ ⟷ v_c– Žilavije

Toolfinder – Kanali za odvođenje strugotina



Povećavajući kut klina				Oštro ●		Srednja ● ●		Stabilno ● ● ●	
				10	20	30	40	50	60
	Fini	F	▮	**-F10**	**-F20**		**-F40**	**-F50**	**-33**
	Srednja	M	▮▮			**-M31** **-M30** **-M32**		**-M50** **-31**	**-29**
	Grubo	R	▮▮▮			**-R30**		**-R50**	**-R60**

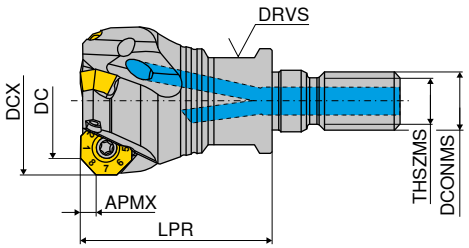
Detaljni pregled kanala za odvođenje strugotina možete pronaći na → **Stranica 196–208.**

Kôd kanala za odvođenje strugotina

Stupanj strojne obrade			Rezni rub: Oštro 10–20	Srednja 30–40	Stabilno 50–60
	Jednostavno	F	▮	●	● ●	● ● ●
	Univerzalno	M	▮▮	●	● ●	● ● ●
	Teško	R	▮▮▮	●	● ●	● ● ●

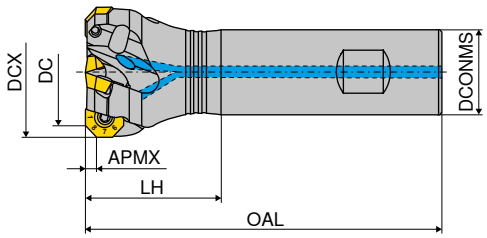
Primjer: Kanal za odvođenje strugotina -M50

MaxiMill – Uvrtno glodalo G 274-04/-09



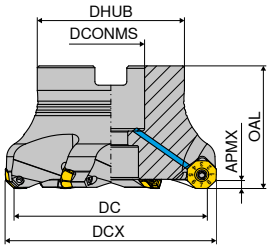
Oznaka	DC	DCX	ZNF	APMX	LPR	THSZMS	DCONMS	DRVS	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 742 ... EUR	
	mm	mm		mm	mm		mm	mm	Nm			
G274.20.R.03-09	20	25,5	3	3,8	35	M12	12,5	17	1,2	OF.. 0403 / SF.. 0903	268,10	**020**
G274.25.R.04-09	25	30,6	4	3,8	35	M12	12,5	17	1,2	OF.. 0403 / SF.. 0903	305,30	**025**
G274.32.R.05-09	32	37,6	5	3,8	35	M16	17,0	24	1,2	OF.. 0403 / SF.. 0903	342,70	**032**

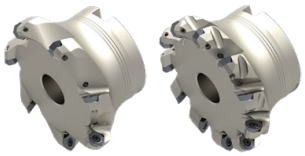
MaxiMill – Vretenasto glodalo C 274-04/-09



Oznaka	DC	DCX	ZNF	APMX	OAL	LH	DCONMS	Pritezni moment	Okretna pločica	A 2B/40 Artikl br. 50 743 ... EUR		B 2B/40 Artikl br. 50 743 ... EUR	
	mm	mm		mm	mm	mm	mm	Nm					
C274.20.R.03-09-A/B20-25	20	25,5	3	3,8	77	25	20	1,2	OF.. 0403 / SF.. 0903	268,10	**020**	268,10	**120**
C274.25.R.04-09-A/B20-32	25	30,6	4	3,8	84	32	20	1,2	OF.. 0403 / SF.. 0903	305,30	**025**	305,30	**125**
C274.32.R.05-09-A/B25-40	32	37,6	5	3,8	98	40	25	1,2	OF.. 0403 / SF.. 0903	342,70	**032**	342,70	**132**

MaxiMill – Utično glodalo A 274-04/-09

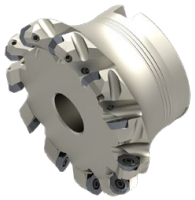




Oznaka	DC	DCX	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 744 ... EUR		2B/40 Artikl br. 50 744 ... EUR	
	mm	mm		mm	mm	mm	mm	Nm					
A274.32.R.05-09	32	37,7	5	3,8	40	38	16	1,2	OF.. 0403 / SF.. 0903			342,70	032
A274.40.R.04-09	40	45,7	4	3,8	40	38	16	1,2	OF.. 0403 / SF.. 0903	342,70	040		
A274.40.R.06-09	40	45,7	6	3,8	40	38	16	1,2	OF.. 0403 / SF.. 0903			379,90	140
A274.50.R.05-09	50	55,7	5	3,8	40	48	22	1,2	OF.. 0403 / SF.. 0903	398,60	050		
A274.50.R.07-09	50	55,7	7	3,8	40	48	22	1,2	OF.. 0403 / SF.. 0903			417,40	150
A274.63.R.06-09	63	68,7	6	3,8	40	48	22	1,2	OF.. 0403 / SF.. 0903	454,70	063		
A274.63.R.09-09	63	68,7	9	3,8	40	48	22	1,2	OF.. 0403 / SF.. 0903			510,70	163
A274.80.R.07-09	80	85,7	7	3,8	50	58	27	1,2	OF.. 0403 / SF.. 0903	510,70	080		
A274.80.R.11-09	80	85,7	11	3,8	50	58	27	1,2	OF.. 0403 / SF.. 0903			585,30	180
A274.100.R.09-09	100	105,7	9	3,8	50	78	32	1,2	OF.. 0403 / SF.. 0903	629,80	100		
A274.100.R.13-09	100	105,7	13	3,8	50	78	32	1,2	OF.. 0403 / SF.. 0903			704,50	200
A274.125.R.12-09	125	130,7	12	3,8	63	88	40	1,2	OF.. 0403 / SF.. 0903	767,40	125		

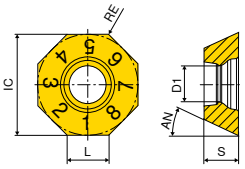
Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 T-stezni ključ Artikl br. 80 397 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Vodeći vijak Artikl br. 70 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
20 - 25	4,76	043			10,20	125			4,38	303	4,09	133	118,90	191
32 - 40	4,76	043	3,91	040	10,20	125	12,48	151	4,38	303	4,09	133	118,90	191
50 - 125	4,76	043			10,20	125			4,38	303	4,09	133	118,90	191

Dva tipa pločica – JEDNO glodalo

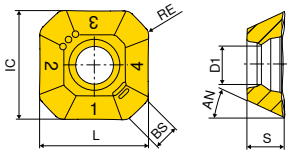


OFHT / OFHW / SFHT / SFKT

Oznaka	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
OFH. 0403..	9,52	3,35	3,94	-	3,18	25
SF.T 0903..	9,80	3,35	9,00	2,25	3,50	25



OF..

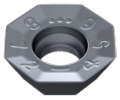
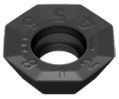
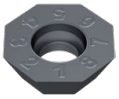


SF.T

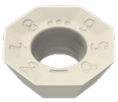
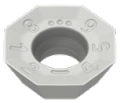
OFHT

	-F50 CTCP220	-F50 CTPP225	-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
	-F50 DCX1220	-F50 DPX1225	-F50 DCX1230	-M50 DCX1230	-F50 DPX1235	-M50 DPX1235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	OFHT	OFHT	OFHT	OFHT	OFHT	OFHT
	1B/61	1B/61	1B/61	1B/61	1B/61	1B/61
ISO / RE	Artikl br. 51 002 ...	Artikl br. 51 002 ...	Artikl br. 51 002 ...	Artikl br. 51 003 ...	Artikl br. 51 002 ...	Artikl br. 51 003 ...
mm	EUR	EUR	EUR	EUR	EUR	EUR
040305SN / 0,5	15,76 255	15,76 055	15,76 005	15,76 005	15,76 105	15,76 105
Čelik	●	●	●	●	●	●
Nehrđajući čelik			○	○	○	○
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

OFHT / OFHW

	-F50 CTPM225	-F50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F50 CTPM245	CTPM245
	-F50 DPX2225	-F50 DCX2235	-F50 DPX2240	-M50 DPX2240	-F50 DPX2245	DPX2245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	OFHT	OFHT	OFHT	OFHT	OFHT	OFHW
	1B/61	1B/61	1B/61	1B/61	1H/17	1H/17
ISO / RE	Artikl br. 51 002 ...	Artikl br. 51 002 ...	Artikl br. 51 002 ...	Artikl br. 51 003 ...	Artikl br. 51 002 ...	Artikl br. 51 105 ...
mm	EUR	EUR	EUR	EUR	EUR	EUR
040302EN / 0,2						17,37 452
040305SN / 0,5	15,76 205	15,76 305	15,76 405	15,76 405	17,37 455	
Čelik	○	○	○	○	●	●
Nehrđajući čelik	●	●	●	●	●	●
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

OFHT / OFHW

		-M50 CTCK215	-F10 CTWN215	-F50 CTC5240	CTC5240	-F50 CTCS245
		-M50 DCX3215	-F10 CWK4615		HCF5240	
		DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		OFHT	OFHT	OFHT	OFHW	OFHT
		1B/61	1B/61	NEW 1H/D4	1H/D4	NEW 1H/D4
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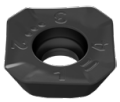
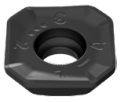
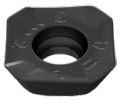
	mm	EUR	EUR	EUR	EUR	EUR
040302EN	0,2				17,37 504	
040305FN	0,5		16,71 505			
040305SN	0,5	15,76 505		17,37 15500		17,37 555
Čelik		○				
Nehrđajući čelik						
Lijevano željezo		●	○			
Neželjezni metali			●			
Visokootporan na toplinu				●	●	●
Kaljeni čelik						

SFHT / SFKT

		-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
		-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		SFHT	SFKT	SFHT	SFKT
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 012 ...	Artikl br. 51 013 ...	Artikl br. 51 012 ...	Artikl br. 51 013 ...
	mm	EUR	EUR	EUR	EUR
0903AFSR	1,0	15,76 270	11,61 270	15,76 070	11,61 070
Čelik		●	●	●	●
Nehrđajući čelik					
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

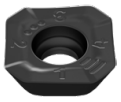
SFHT / SFKT

		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
		-F50 DCX1230	-M50 DCX1230	-F50 DPX1235	-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		SFHT	SFKT	SFHT	SFKT
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 012 ...	Artikl br. 51 013 ...	Artikl br. 51 012 ...	Artikl br. 51 013 ...
	mm	EUR	EUR	EUR	EUR
0903AFSR	1,0	15,76 020	11,61 020	15,76 120	11,61 120
Čelik		●	●	●	●
Nehrđajući čelik		○	○	○	○
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

SFHT / SFKT

		-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F50 CTPM245
		-F50 DPX2225	-M50 DPX2225	-F50 DCX2235	-F50 DPX2240		-F50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		SFHT	SFKT	SFHT	SFHT	SFKT	SFHT
		1B/61	1B/61	1B/61	1B/61	NEW 1B/61	1H/17
ISO	RE	Artikl br. 51 012 ...	Artikl br. 51 013 ...	Artikl br. 51 012 ...	Artikl br. 51 012 ...	Artikl br. 51 013 ...	Artikl br. 51 012 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
0903AFSR	1,0	15,76 220	11,61 220	15,76 320	15,76 420	11,61 42000	19,60 470
Čelik		○	○	○	○	○	●
Nehrđajući čelik		●	●	●	●	●	●
Lijevano željezo							
Neželjezni metali							
Visokootporan na toplinu							
Kaljeni čelik							

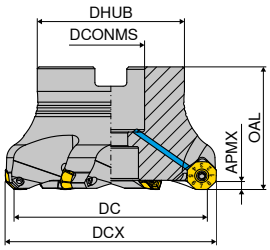
SFKT / SFHT

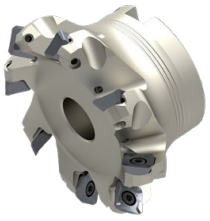
		-R50 CTCK215	-R50 CTPK220	-F10 CTWN215	-F40 CTC5240
		-R50 DCX3215	-R50 DPX3220	-F10 CWK4615	-F40 HCF5240
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN
					
		SFKT	SFKT	SFHT	SFHT
		1B/61	1B/61	1B/61	1H/D4
ISO	RE	Artikl br. 51 065 ...	Artikl br. 51 065 ...	Artikl br. 50 514 ...	Artikl br. 50 514 ...
	mm	EUR	EUR	EUR	EUR
0903AFFR	1,0			18,90 505	
0903AFSR	1,0	11,61 520	11,61 620		19,60 504
Čelik		○	○		
Nehrđajući čelik					
Lijevano željezo		●	●	○	
Neželjezni metali				●	
Visokootporan na toplinu					●
Kaljeni čelik					

Priručnik za glodanje

Strategija obrade	→ 140	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 140
Početni parametar	→ 141		

MaxiMill – Utično glodalo A 274-05/-12



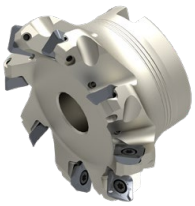


Oznaka	DC	DCX	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 772 ... EUR	
	mm	mm		mm	mm	mm	mm	Nm			
A274.40.R.03-12	40	48,0	3	6	40	38	16	3,2	OFHT 0504 / SFKT 1204	258,00	**24000**
A274.40.R.04-12	40	48,0	4	6	40	38	16	3,2	OFHT 0504 / SFKT 1204	338,50	**04000**
A274.50.R.05-12	50	58,0	5	6	40	43	22	3,2	OFHT 0504 / SFKT 1204	429,90	**050**
A274.50.R.04-12	50	58,1	4	6	40	43	22	3,2	OFHT 0504 / SFKT 1204	343,90	**25000**
A274.63.R.06-12	63	71,0	6	6	40	48	22	3,2	OFHT 0504 / SFKT 1204	515,90	**063**
A274.63.R.05-12	63	71,1	5	6	40	48	22	3,2	OFHT 0504 / SFKT 1204	440,40	**26300**
A274.80.R.06-12	80	88,0	6	6	50	58	27	3,2	OFHT 0504 / SFKT 1204	537,30	**28000**
A274.80.R.08-12	80	88,0	8	6	50	58	27	3,2	OFHT 0504 / SFKT 1204	687,90	**080**
A274.100.R.10-12	100	107,9	10	6	50	78	32	3,2	OFHT 0504 / SFKT 1204	849,00	**100**
A274.100.R.08-12	100	108,0	8	6	50	78	32	3,2	OFHT 0504 / SFKT 1204	709,40	**30000**
A274.125.R.12-12	125	132,9	12	6	63	88	40	3,2	OFHT 0504 / SFKT 1204	1.037,00	**125**
A274.125.R.09-12	125	133,0	9	6	63	88	40	3,2	OFHT 0504 / SFKT 1204	889,20	**32500**
A274.160.R.11-12	160	133,0	11	6	63	88	40	3,2	OFHT 0504 / SFKT 1204	1.081,00	**36000** [1]
A274.160.R.14-12	160	167,9	14	6	63	98	40	3,2	OFHT 0504 / SFKT 1204	1.376,00	**16000** [1]

1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

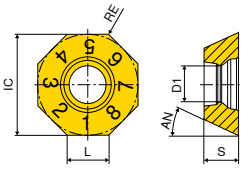
Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
40 - 160	5,26	**054**	11,89	**128**	4,38	**303**	4,61	**340**	131,90	**193**

Dva tipa pločica – JEDNO glodalo

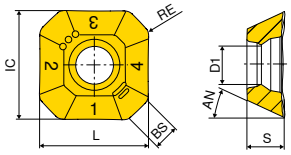


OFHT / SFHT / SFKT

Oznaka	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
OFHT 0504..	12,7	4,8	4,5	-	4,76	25
SF.T 1204..	12,7	4,8	12,7	1,42	4,76	25



OF..

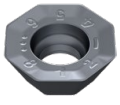
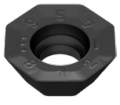
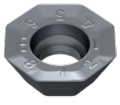
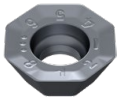


SF.T

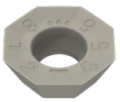
OFHT

		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
		-F50 DCX1230		-F50 DPX1235	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		OFHT	OFHT	OFHT	OFHT
		1B/61	NEW 1B/61	1B/61	NEW 1B/61
ISO	RE	**Artikl br. 51 002 ...**	**Artikl br. 51 003 ...**	**Artikl br. 51 002 ...**	**Artikl br. 51 003 ...**
	mm	EUR	EUR	EUR	EUR
050410SN	1,0	17,33 **010**	17,33 **01000**	17,33 **110**	17,33 **11000**
Čelik		●	●	●	●
Nehrđajući čelik		○	○	○	○
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

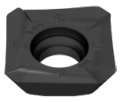
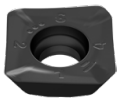
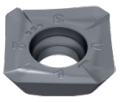
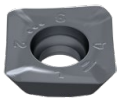
OFHT

		-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F50 CTPM245
		-F50 DPX2225	-M50 DPX2225	-F50 DCX2235	-F50 DPX2240		-F50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		OFHT	OFHT	OFHT	OFHT	OFHT	OFHT
		1B/61	1B/61	1B/61	1B/61	NEW 1B/61	1H/17
ISO	RE	**Artikl br. 51 002 ...**	**Artikl br. 51 003 ...**	**Artikl br. 51 002 ...**	**Artikl br. 51 002 ...**	**Artikl br. 51 003 ...**	**Artikl br. 51 002 ...**
	mm	EUR	EUR	EUR	EUR	EUR	EUR
050410SN	1,0	17,33 **210**	17,33 **210**	17,33 **310**	17,33 **410**	17,33 **41000**	19,10 **460**
Čelik		○	○	○	○	○	●
Nehrđajući čelik		●	●	●	●	●	●
Lijevano željezo							
Neželjezni metali							
Visokootporan na toplinu							
Kaljeni čelik							

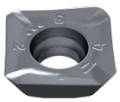
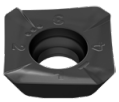
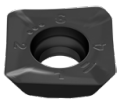
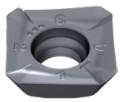
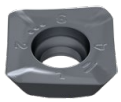
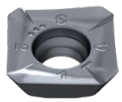
OFHT

		-F10 CTWN215	-F50 CTC5240
			DRAGONSKIN
			
		OFHT	OFHT
		NEW 1B/61	NEW 1H/D4
ISO	RE	Artikl br. 51 122 ...	Artikl br. 51 002 ...
	mm	EUR	EUR
050410FN	1,0	20,79 36000	
050410SN	1,0		19,10 16000
Čelik			
Nehrđajući čelik			
Lijevano željezo		○	
Neželjezni metali		●	
Visokootporan na toplinu			●
Kaljeni čelik			

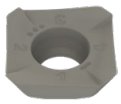
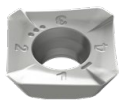
SFHT / SFKT

		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
			-M50 DCX1230		-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		SFHT	SFKT	SFHT	SFKT
		NEW 1B/61	1B/61	NEW 1B/61	1B/61
ISO	RE	Artikl br. 51 012 ...	Artikl br. 51 013 ...	Artikl br. 51 012 ...	Artikl br. 51 013 ...
	mm	EUR	EUR	EUR	EUR
1204AFSR	1,0	17,33 02500	12,77 025	17,33 12500	12,77 125
Čelik		●	●	●	●
Nehrđajući čelik		○	○	○	○
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

SFHT / SFKT

		-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-M50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F50 CTPM245
		-F50 DPX2225	-M50 DPX2225	-F50 DCX2235	-M50 DCX2235		-M50 DPX2240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		SFHT	SFKT	SFHT	SFKT	SFHT	SFKT	SFHT
		1B/61	1B/61	1B/61	1B/61	NEW 1B/61	1B/61	NEW 1H/17
ISO	RE	Artikl br. 51 012 ...	Artikl br. 51 013 ...	Artikl br. 51 012 ...	Artikl br. 51 013 ...	Artikl br. 51 012 ...	Artikl br. 51 013 ...	Artikl br. 51 012 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR	EUR
1204AFSR	1,0	17,33 225	12,77 225	17,33 325	12,77 325	17,33 42500	12,77 425	21,15 47500
Čelik		○	○	○	○	○	○	●
Nehrđajući čelik		●	●	●	●	●	●	●
Lijevano željezo								
Neželjezni metali								
Visokootporan na toplinu								
Kaljeni čelik								

SFHT

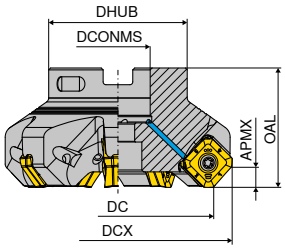
		-F10 CTWN215	-F40 CTC5240
			DRAGONSKIN
			
		SFHT	SFHT
		NEW 1B/61	NEW 1H/D4
ISO	RE	Artikl br. 51 123 ...	Artikl br. 50 514 ...
	mm	EUR	EUR
1204AFER	1,0		21,58 50900
1204AFFR	1,0	20,79 37000	
Čelik			
Nehrđajući čelik			
Lijevano željezo		○	
Neželjezni metali		●	
Visokootporan na toplinu			●
Kaljeni čelik			

Priručnik za glodanje

Strategija obrade	→ 142	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 142
Početni parametar	→ 143		

MaxiMill – Utično glodalo A 271

▲ 8 reznih bridova po okretnoj reznoj pločici



Oznaka	DC	DCX	ZNF	APMX	OAL	DCONMS	DHUB	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 767 ...	
	mm	mm		mm	mm	mm	mm	Nm		EUR	
A271.50.R.04-17	50	66,1	4	8,4	40	22	43	5	SAKU 1706	397,70	**050**
A271.63.R.06-17	63	79,1	6	8,4	40	22	48	5	SAKU 1706	558,90	**063**
A271.80.R.07-17	80	96,1	7	8,4	50	27	58	5	SAKU 1706	639,50	**080**
A271.100.R.08-17	100	116,1	8	8,4	50	32	78	5	SAKU 1706	736,30	**100**
A271.125.R.10-17	125	141,1	10	8,4	63	40	88	5	SAKU 1706	849,00	**125**
A271.160.R.12-17	160	176,1	12	8,4	63	40	104	5	SAKU 1706	999,60	**16000** [1]
A271.200.R.13-17	200	216,1	13	8,4	63	60	134	5	SAKU 1706	1.236,00	**20000** [2]
A271.250.R.15-17	250	266,1	15	8,4	63	60	134	5	SAKU 1706	1.494,00	**25000** [2]

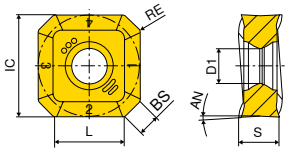
1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm
2) S 4 navojna provrta M16 na ravnini, Ø kruga rupe = 101,6 mm

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A/28 Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR	
50 - 250	4,76	**037**	9,95	**114**	4,38	**303**	4,09	**302**	131,90	**193**

15

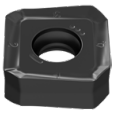
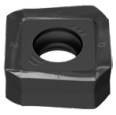
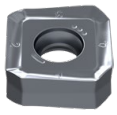
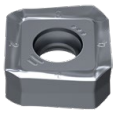
SAKU

Oznaka	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
SAKU 1706..	17	5,8	11,85	3,7	6,35	3

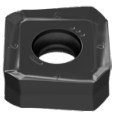
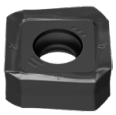
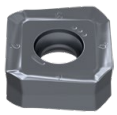
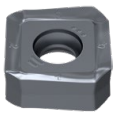


SAKU

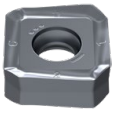
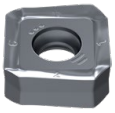
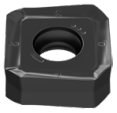
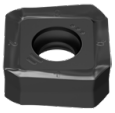
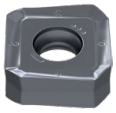
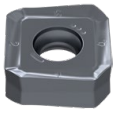
SAKU

	-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
	-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	SAKU	SAKU	SAKU	SAKU
	1B/61	1B/61	1B/61	1B/61
ISO RE mm	**Artikl br. 51 004 ...** EUR	**Artikl br. 51 005 ...** EUR	**Artikl br. 51 004 ...** EUR	**Artikl br. 51 005 ...** EUR
1706ABSR 0,8	29,13 **270**	29,13 **270**	29,13 **070**	29,13 **070**
Čelik	●	●	●	●
Nehrđajući čelik				
Lijevano željezo				
Neželjezni metali				
Visokootporan na toplinu				
Kaljeni čelik				

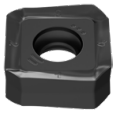
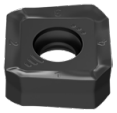
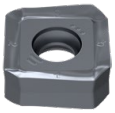
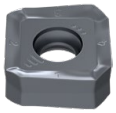
SAKU

	-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
	-F50 DCX1230	-M50 DCX1230	-F50 DPX1235	-M50 DPX1235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	SAKU	SAKU	SAKU	SAKU
	1B/61	1B/61	1B/61	1B/61
ISO RE mm	**Artikl br. 51 004 ...** EUR	**Artikl br. 51 005 ...** EUR	**Artikl br. 51 004 ...** EUR	**Artikl br. 51 005 ...** EUR
1706ABSR 0,8	29,13 **020**	29,13 **020**	29,13 **120**	29,13 **120**
Čelik	●	●	●	●
Nehrđajući čelik	○	○	○	○
Lijevano željezo				
Neželjezni metali				
Visokootporan na toplinu				
Kaljeni čelik				

SAKU

		-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-M50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F50 CTPM245
		-F50 DPX2225	-M50 DPX2225	-F50 DCX2235	-M50 DCX2235	-F50 DPX2240	-M50 DPX2240	-F50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		SAKU	SAKU	SAKU	SAKU	SAKU	SAKU	SAKU
		1B/61	1B/61	1B/61	1B/61	1B/61	1B/61	1H/17
ISO	RE	Artikl br. 51 004 ...	Artikl br. 51 005 ...	Artikl br. 51 004 ...	Artikl br. 51 005 ...	Artikl br. 51 004 ...	Artikl br. 51 005 ...	Artikl br. 51 004 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR	EUR
1706ABSR	0,8	29,13 220	29,13 220	29,13 320	29,13 320	29,13 420	29,13 420	35,84 470
Čelik		○	○	○	○	○	○	●
Nehrđajući čelik		●	●	●	●	●	●	●
Lijevano željezo								
Neželjezni metali								
Visokootporan na toplinu								
Kaljeni čelik								

SAKU

		-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-R50 CTPK220	-F50 CTC5240	-F50 CTCS245
		-M50 DCX3215	-R50 DCX3215	-M50 DPX3220	-R50 DPX3220	-F50 HCF5240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		SAKU	SAKU	SAKU	SAKU	SAKU	SAKU
		1B/61	1B/61	1B/61	1B/61	1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 005 ...	Artikl br. 51 058 ...	Artikl br. 51 005 ...	Artikl br. 51 058 ...	Artikl br. 50 306 ...	Artikl br. 51 004 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
1706ABSR	0,8	29,13 520	29,13 520	29,13 620	29,13 620	35,84 520	35,84 570
Čelik		○	○	○	○		
Nehrđajući čelik							
Lijevano željezo		●	●	●	●		
Neželjezni metali							
Visokootporan na toplinu						●	●
Kaljeni čelik							

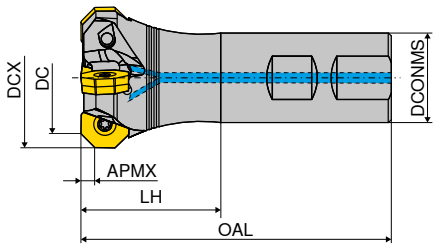
Priručnik za glodanje

Početni parametar	→ 144	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 144

15

MaxiMill – Vretenasto glodalo C 273

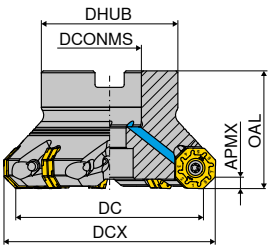
▲ 16 reznih bridova po okretnoj pločici

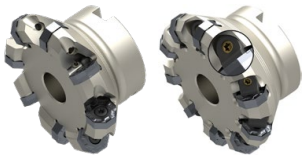


Oznaka	DC mm	DCX mm	ZNF	APMX mm	DCONMS h6 mm	LH mm	OAL mm	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 762 ... EUR	
C273.32.R.03-06-B-40	32	42,1	3	3,5	32	40	101	5	OAKU / XAHT 0605	387,10	032
C273.40.R.04-06-B32-50	40	50,1	4	3,5	32	50	111	5	OAKU / XAHT 0605	400,00	040

MaxiMill – Utično glodalo A 273

▲ 16 reznih bridova po okretnoj pločici





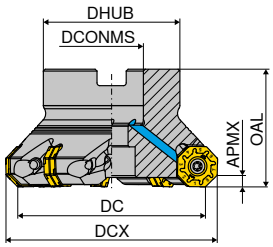
Oznaka	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DCONMS H6 mm	DHUB mm	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 741 ... EUR		2B/40 Artikl br. 50 741 ... EUR	
A273.40.R.04-06	40	50,2	3	3,5	40	16	38	5	OAKU / XAHT 0605	381,40	040		
A273.40.R.04-06	40	50,2	4	3,5	40	16	38	5	OAKU / XAHT 0605	400,00	140 [5]		
A273.50.R.05-06	50	60,2	5	3,5	40	22	43	5	OAKU / XAHT 0605	448,50	050		
A273.63.R.07-06	63	73,2	7	3,5	40	22	48	5	OAKU / XAHT 0605	538,40	063		
A273.80.R.08-06	80	90,2	8	3,5	50	27	58	5	OAKU / XAHT 0605	628,10	080		
A273.80.R.10-06	80	90,2	10	3,5	50	27	58	5	OAKU / XAHT 0605			957,10	180 [1]
A273.100.R.10-06	100	110,2	10	3,5	50	32	78	5	OAKU / XAHT 0605	740,30	100		
A273.100.R.14-06	100	110,2	14	3,5	50	32	78	5	OAKU / XAHT 0605			1.223,00	200 [1]
A273.125.R.12-06	125	135,2	12	3,5	63	40	88	5	OAKU / XAHT 0605	830,00	125		
A273.125.R.17-06	125	135,2	17	3,5	63	40	88	5	OAKU / XAHT 0605			1.419,00	225 [1]
A273.160.R.14-06	160	170,2	14	3,5	63	40	104	5	OAKU / XAHT 0605	983,90	160 [4]		
A273.160.R.20-06	160	170,2	20	3,5	63	40	104	5	OAKU / XAHT 0605			1.679,00	260 [2]
A273.200.R.25-06	200	210,2	25	3,5	63	60	153	5	OAKU / XAHT 0605			2.099,00	300 [3]
A273.250.R.31-06	250	260,2	31	3,5	63	60	153	5	OAKU / XAHT 0605			2.567,00	25031 [3]

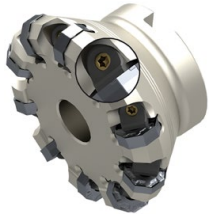
1) Izvedba sa steznim klinom, bez unutarnjeg dovoda rashladnog sredstva
2) Izvedba sa steznim klinom, bez unutarnjeg dovoda rashladnog sredstva / S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm
3) Izvedba sa steznim klinom, bez unutarnjeg dovoda rashladnog sredstva / S 4 navojna provrta M16 na ravnini, Ø kruga rupe = 101,6 mm
4) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm / Bez unutarnjeg dovoda rashladnog sredstva
5) Bez unutarnjeg dovoda rashladnog sredstva

	Y7		Y7		2A/28		2A/28		Y7		2A/28		2A/28		Y7	
	TORX®– Izmjenjiva oštrica		T-stezni ključ		Vijak steznog klina		Stezni klin		D-ključ		Vodeći vijak		Stezni vijak		Momentni odvijač	
Rezervni dijelovi IDNR	**Artikl br. 80 950 ...** EUR		**Artikl br. 80 397 ...** EUR		**Artikl br. 70 950 ...** EUR		**Artikl br. 70 950 ...** EUR		**Artikl br. 80 950 ...** EUR		**Artikl br. 70 950 ...** EUR		**Artikl br. 70 950 ...** EUR		**Artikl br. 80 950 ...** EUR	
50741040	4,76	037	3,91	040					9,95	114	12,48	151	4,09	302	131,90	193
50741050	4,76	037	4,24	050					9,95	114	17,14	154	4,09	302	131,90	193
50741063 - 50741125	4,76	037							9,95	114			4,09	302	131,90	193
50741140	4,76	037	3,91	040					9,95	114	12,48	151	4,09	302	131,90	193
50741160	4,76	037							9,95	114			4,09	302	131,90	193
50741180 - 50741300	4,76	036			5,90	844	23,55	845	9,28	113					131,90	193
50762032 - 50762040	4,76	037							9,95	114			4,09	302	131,90	193
5074125031	4,76	036			5,90	844	23,55	845	9,28	113					131,90	193

MaxiMill – Utično glodalo A 273

- 16 reznih bridova po okretnoj pločici
- Aksijalno podesivo





Oznaka	DC	DCX	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	Pritezni moment	Okretna pločica	NEW 2B/40 Artikl br. 50 777 ...	
	mm	mm		mm	mm	mm	mm	Nm		EUR	
A273.80.R.10A10-06	80	90,2	10	3,5	50	27	58	5	OAKU / XAHT 0605	1.258,00	**08010** [1]
A273.100.R.14A14-06	100	110,2	14	3,5	50	32	78	5	OAKU / XAHT 0605	1.713,00	**10014** [1]
A273.125.R.17A17-06	125	135,2	17	3,5	63	40	88	5	OAKU / XAHT 0605	2.014,00	**12517** [1]
A273.160.R.20A20-06	160	170,2	20	3,5	63	40	104	5	OAKU / XAHT 0605	2.378,00	**16020** [2]
A273.200.R.25A25-06	200	210,2	25	3,5	63	60	153	5	OAKU / XAHT 0605	2.974,00	**20025** [3]
A273.250.R.31A31-06	250	260,2	31	3,5	63	60	153	5	OAKU / XAHT 0605	3.652,00	**25031** [3]

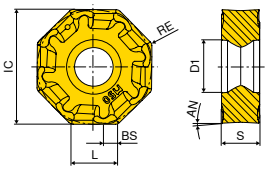
1) Izvedba sa steznim klinom, bez unutarnjeg dovoda rashladnog sredstva
2) Izvedba sa steznim klinom, bez unutarnjeg dovoda rashladnog sredstva / S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm
3) Izvedba sa steznim klinom, bez unutarnjeg dovoda rashladnog sredstva / S 4 navojna provrta M16 na ravnini, Ø kruga rupe = 101,6 mm

	Y7	2A/28	2A/28	Y7	2A/28	2A/28	Y7
	TORX®-Izmjenjiva oštrica	Vijak steznog klina	Stezni klin	D-ključ	Pasta Molykote	Klin	Momentni odvijač
Rezervni dijelovi	**Artikl br.**	**Artikl br.**	**Artikl br.**	**Artikl br.**	**Artikl br.**	**Artikl br.**	**Artikl br.**
DC	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
	EUR	EUR	EUR	EUR	EUR	EUR	EUR
80 - 250	4,76 **036**	5,90 **844**	23,55 **845**	9,28 **113**	4,38 **303**	36,80 **199**	131,90 **193**

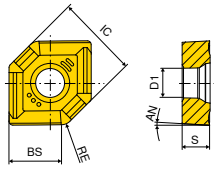
15

OAKU / XAHT

Oznaka	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
XAHT 0605..	17,08	6,0	-	11,95	5,56	3
OAKU 0605..	17,10	5,8	6	2,00	5,66	3

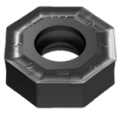
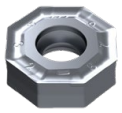


OAKU

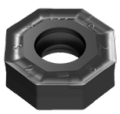
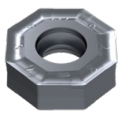


XAHT

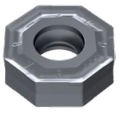
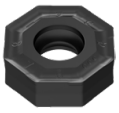
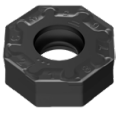
OAKU

		-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
		-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		OAKU	OAKU	OAKU	OAKU
		1B/61	1B/61	1B/61	1B/61
ISO	RE	**Artikl br. 51 000 ...**	**Artikl br. 51 001 ...**	**Artikl br. 51 000 ...**	**Artikl br. 51 001 ...**
	mm	EUR	EUR	EUR	EUR
060508SR	0,8	24,56 **258**	24,56 **258**	24,56 **058**	24,56 **058**
Čelik		●	●	●	●
Nehrđajući čelik					
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

OAKU

		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
		-F50 DCX1230	-M50 DCX1230	-F50 DPX1235	-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		OAKU	OAKU	OAKU	OAKU
		1B/61	1B/61	1B/61	1B/61
ISO	RE	**Artikl br. 51 000 ...**	**Artikl br. 51 001 ...**	**Artikl br. 51 000 ...**	**Artikl br. 51 001 ...**
	mm	EUR	EUR	EUR	EUR
060508SL	0,8				24,56 **10900**
060508SR	0,8	24,56 **008**	24,56 **008**	24,56 **108**	24,56 **108**
Čelik		●	●	●	●
Nehrđajući čelik		○	○	○	○
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

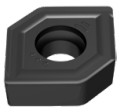
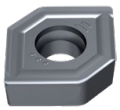
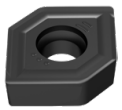
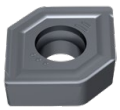
OAKU

		-F50 CTPM225		-M50 CTPM225		-F50 CTCM235		-M50 CTCM235		-F50 CTPM240		-M50 CTPM240		-F40 CTPM245	
		-F50 DPX2225		-M50 DPX2225		-F50 DCX2235		-M50 DCX2235		-F50 DPX2240		-M50 DPX2240		-F40 DPX2245	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		OAKU		OAKU		OAKU		OAKU		OAKU		OAKU		OAKU	
		1B/61		1B/61		1B/61		1B/61		1B/61		1B/61		1H/17	
ISO	RE	Artikl br. 51 000 ...		Artikl br. 51 001 ...		Artikl br. 51 000 ...		Artikl br. 51 001 ...		Artikl br. 51 000 ...		Artikl br. 51 001 ...		Artikl br. 51 104 ...	
	mm	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
060508ER	0,8													30,71	458
060508SR	0,8	24,56	208	24,56	208	24,56	308	24,56	308	24,56	408	24,56	408		
Čelik		○		○		○		○		○		○		●	
Nehrđajući čelik		●		●		●		●		●		●		●	
Lijevano željezo															
Neželjezni metali															
Visokootporan na toplinu															
Kaljeni čelik															

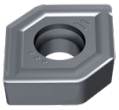
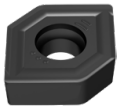
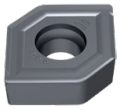
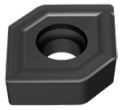
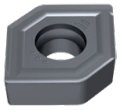
OAKU

		-M50 CTCK215		-R50 CTCK215		-M50 CTPK220		-R50 CTPK220		-F40 CTC5240	
		-M50 DCX3215		-R50 DCX3215		-M50 DPX3220		-R50 DPX3220		-F40 HCF5240	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		OAKU		OAKU		OAKU		OAKU		OAKU	
		1B/61		1B/61		1B/61		1B/61		1H/D4	
ISO	RE	Artikl br. 51 001 ...		Artikl br. 51 027 ...		Artikl br. 51 001 ...		Artikl br. 51 027 ...		Artikl br. 50 446 ...	
	mm	EUR		EUR		EUR		EUR		EUR	
060508ER	0,8									30,71	550
060508SL	0,8	24,56	50900			24,56	60900				
060508SR	0,8	24,56	508	24,56	508	24,56	608	24,56	608		
Čelik			○		○		○		○		
Nehrđajući čelik											
Lijevano željezo			●		●		●		●		
Neželjezni metali											
Visokootporan na toplinu											●
Kaljeni čelik											

XAHT

		-M50 CTCP220	-M50 CTPP225	-M50 CTCP230	-M50 CTPP235
		-M50 DCX1220	-M50 DPX1225	-M50 DCX1230	-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		XAHT	XAHT	XAHT	XAHT
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 014 ...	Artikl br. 51 014 ...	Artikl br. 51 014 ...	Artikl br. 51 014 ...
	mm	EUR	EUR	EUR	EUR
060525SR	2,5	30,41 **275**	30,41 **075**	30,41 **025**	30,41 **125**
Čelik		●	●	●	●
Nehrđajući čelik				○	○
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

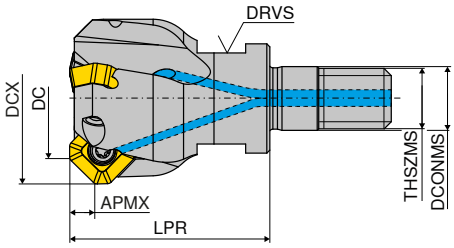
XAHT

		-M50 CTPM225	-M50 CTCM235	-M50 CTPM240	-M50 CTCK215	-M50 CTPK220
		-M50 DPX2225	-M50 DCX2235	-M50 DPX2240	-M50 DCX3215	-M50 DPX3220
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		XAHT	XAHT	XAHT	XAHT	XAHT
		1B/61	1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 014 ...	Artikl br. 51 014 ...	Artikl br. 51 014 ...	Artikl br. 51 014 ...	Artikl br. 51 014 ...
	mm	EUR	EUR	EUR	EUR	EUR
060525SL	2,5				30,41 **52600**	
060525SR	2,5	30,41 **225**	30,41 **325**	30,41 **425**	30,41 **525**	30,41 **625**
Čelik		○	○	○	○	○
Nehrđajući čelik		●	●	●		
Lijevano željezo					●	●
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

Priručnik za glodanje

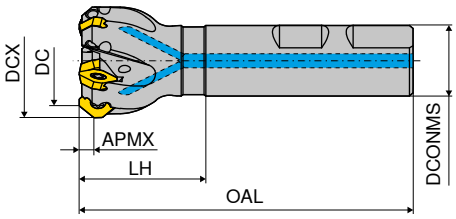
Početni parametar	→ 145	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 145

MaxiMill – Uvrtno glodalo 45° G 270-09



Oznaka	DC	DCX	ZNF	APMX	LPR	THSZMS	DCONMS	DRVS	Pritezni moment	Okretna pločica	2B Artikl br. 55 202 ... EUR	
	mm	mm		mm	mm		mm	mm	Nm			
G270.ESF.16.R.02-09	16	24,4	2	4	27	M8	8,5	10	1,8	SD.. 0903..	157,30	016
G270.ESF.20.R.03-09	20	28,4	3	4	33	M10	10,5	15	1,8	SD.. 0903..	184,50	020
G270.ESF.25.R.04-09	25	33,4	4	4	35	M12	12,5	17	1,8	SD.. 0903..	207,70	025
G270.ESF.32.R.05-09	32	40,4	5	4	35	M16	17,0	17	1,8	SD.. 0903..	228,50	032

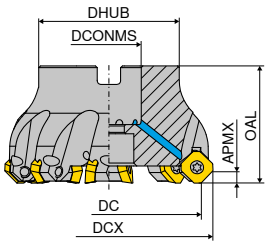
MaxiMill – Vretenasto glodalo 45° C 270-09



B

Oznaka	DC	DCX	ZNF	APMX	OAL	LH	DCONMS	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 666 ... EUR	
	mm	mm		mm	mm	mm	mm	Nm			
C270.06.R.01-09	6	14,4	1	4	80	32	16	1,2	SD.. 0903..	135,80	006
C270.12.R.01-09	12	20,4	1	4	80	32	16	1,2	SD.. 0903..	150,00	012
C270.16.R.02-09	16	24,4	2	4	90	40	20	1,8	SD.. 0903..	170,80	016
C270.20.R.03-09	20	28,4	3	4	90	40	20	1,8	SD.. 0903..	217,30	020
C270.25.R.04-09	25	33,4	4	4	100	44	25	1,8	SD.. 0903..	307,90	025
C270.32.R.05-09	32	40,4	5	4	95	36	25	1,8	SD.. 0903..	362,20	032

MaxiMill – Utično glodalo 45° A 270-09



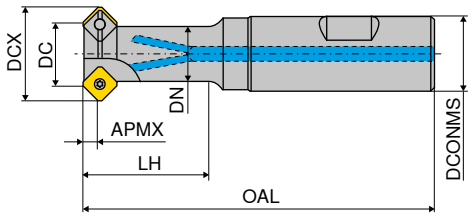
									Desno		Desno		Desno		Lijevo	
									2B/40		2B/40		2B/40		2B	
Oznaka	DC	DCX	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	Pritezni moment	**Artikl br. 50 704 ...**		**Artikl br. 50 705 ...**		**Artikl br. 50 706 ...**		**Artikl br. 50 707 ...**	
	mm	mm		mm	mm	mm	mm	Nm	EUR		EUR		EUR		EUR	
A270.32.R.05-09	32	40,4	5	4	40	34	16	1,8					346,60	**532**		
A270.40.R.04-09	40	48,4	4	4	40	38	16	1,8			355,70	**540**				
A270.40.R.06-09	40	48,4	6	4	40	38	16	1,8					401,10	**540**		
A270.42.R.06-09	42	50,4	6	4	40	38	16	1,8					415,20	**542**		
A270.50.R.06-09	50	58,4	6	4	40	43	22	1,8			412,70	**550**				
A270.50.R.08-09	50	58,4	8	4	40	43	22	1,8					494,20	**550**		
A270.50.L.08-09	50	58,4	8	4	40	43	22	1,8							511,70	**550**
A270.52.R.08-09	52	60,4	8	4	40	43	22	1,8					511,70	**552**		
A270.63.R.05-09	63	71,4	5	4	40	48	22	1,8	401,10	**563**						
A270.63.R.08-09	63	71,4	8	4	40	48	22	1,8			500,60	**563**				
A270.63.R.10-09	63	71,4	10	4	40	48	22	1,8					623,50	**563**		
A270.63.L.10-09	63	71,4	10	4	40	48	22	1,8							644,90	**563**
A270.66.R.10-09	66	74,4	10	4	40	48	22	1,8					644,90	**566**		
A270.80.R.06-09	80	88,4	6	4	50	58	27	1,8	454,00	**580**						
A270.80.R.10-09	80	88,4	10	4	50	58	27	1,8			632,50	**580**				
A270.80.R.12-09	80	88,4	12	4	50	58	27	1,8					750,10	**580**		
A270.80.L.12-09	80	88,4	12	4	50	58	27	1,8							776,00	**580**
A270.100.R.07-09	100	108,4	7	4	50	78	32	1,8	586,10	**600**						
A270.100.R.12-09	100	108,4	12	4	50	78	32	1,8			763,20	**600**				
A270.100.R.14-09	100	108,4	14	4	50	78	32	1,8					886,20	**600**		
A270.125.R.12-09	125	133,4	12	4	63	88	40	1,8			892,60	**625**				
A270.160.R.12-09	160	168,4	12	4	63	93	40	1,8	1.148,00	**660** [1)]						

1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

- ▲ 50 704 ... široka podjela za primjenu na legurama aluminija, obojenim metalima i plastici.
- ▲ 50 705 ... normalna podjela za široki spektar primjene legura aluminija, obojenih metala do mekih čeličnih materijala.
- ▲ 50 706 ... uska podjela za najviši kapacitet strojne obrade, primjena prvenstveno kod čelika i lijevanog željeza.
- ▲ 50 707 ... kao 50 706 ..., međutim u izvedbi **s lijevo narezanim navojima.**

MaxiMill – Glodalo za skošenja C 272-09

▲ Primjenjivo prema naprijed i prema natrag



B

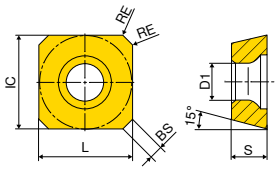
Oznaka	DC mm	DCX mm	ZNF	APMX mm	DN mm	OAL mm	LH mm	DCONMS mm	Pritezni moment Nm	Okretna pločica	2B Artikl br. 50 669 ... EUR	
C272.06.R.01-09	6	14,4	1	4	10	91	24,0	16	1,2	SD.. 0903..	161,50	**006**
C272.08.R.01-09	8	16,4	1	4	10	91	25,5	16	1,2	SD.. 0903..	180,00	**008**
C272.12.R.01-09	12	20,4	1	4	12	91	26,0	16	1,2	SD.. 0903..	185,00	**012**
C272.16.R.02-09	16	24,4	2	4	15	97	30,0	20	1,8	SD.. 0903..	227,70	**016**
C272.18.R.02-09	18	26,4	2	4	16	97	30,0	20	1,8	SD.. 0903..	227,70	**018**
C272.25.R.03-09	25	33,4	3	4	21	109	35,0	25	1,8	SD.. 0903..	266,40	**025**

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
6 - 12	4,76	**033**	7,80	**110**	4,38	**303**	3,14	**365**	118,90	**191**
16 - 160	4,76	**033**	7,80	**110**	4,38	**303**	2,57	**115**	118,90	**191**

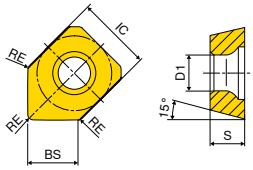
15

SDHW / SDNT / SDHT / XDHW

Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDHW 0903..	9,52	3,4	-	5,50	3,18
SD.. 0903..	9,52	3,4	9,52	1,68	3,18

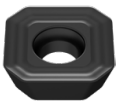
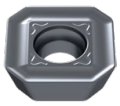
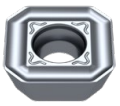


SD..

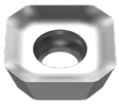
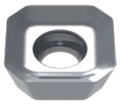


XDHW

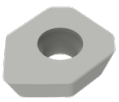
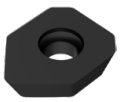
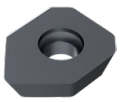
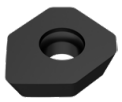
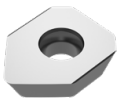
SDHW / SDNT / SDHT

		TCM10	-29 CTCP230	-29 CTPP235	-33 CTPM240	-33P CTPM240	-F50 CTPM245
		CWC10	-29 DCX1230	-29 DPX1235	-33 DPX2240	-33P DPX2240	-F50 DPX2245
			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		CERMET					
		SDHW	SDNT	SDNT	SDHT	SDHT	SDHT
		1B/79	1B/61	1B/61	1B/61	1B/61	1H/17
ISO	RE	Artikl br. 50 428 ...	Artikl br. 51 011 ...	Artikl br. 51 011 ...	Artikl br. 51 028 ...	Artikl br. 51 086 ...	Artikl br. 51 109 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
0903AESN	1,0	15,97 898	13,79 020	13,79 120	15,76 420	16,59 420	19,60 470
Čelik		●	●	●	○	○	●
Nehrđajući čelik		●	○	○	●	●	●
Lijevano željezo		○					
Neželjezni metali							
Visokootporan na toplinu							
Kaljeni čelik							

SDNT / SDHT

		-31 CTCK215	-27P H216T	-27P AMZ	-M31 CTC5240	-F50 CTCS245
		-31 DCX3215	-ALP CWK26	-ALP AMZ	-M31 HCF5240	
		DRAGONSKIN			DRAGONSKIN	DRAGONSKIN
						
		SDNT	SDHT	SDHT	SDHT	SDHT
		1B/61	1A/90	1A/90	1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 029 ...	Artikl br. 50 426 ...	Artikl br. 50 426 ...	Artikl br. 50 421 ...	Artikl br. 51 109 ...
	mm	EUR	EUR	EUR	EUR	EUR
0903AEFN	1,0		15,76 548	18,90 848		
0903AESN	1,0	13,20 520			19,60 509	19,60 57100
Čelik		○				
Nehrđajući čelik						
Lijevano željezo		●	○	○		
Neželjezni metali			●	●		
Visokootporan na toplinu					●	●
Kaljeni čelik						

XDHW

		TCM10	CTCP230	CTPP235	CTCK215	H216T
		CWC10	DCX1230	DPX1235	DCX3215	CWK26
			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
						
		CERMET				
		XDHW	XDHW	XDHW	XDHW	XDHW
		1B/79	1B/61	1B/61	1B/18	1B/61
ISO	RE	Artikl br. 50 449 ...	Artikl br. 51 015 ...	Artikl br. 51 015 ...	Artikl br. 51 015 ...	Artikl br. 50 449 ...
	mm	EUR	EUR	EUR	EUR	EUR
0903AEEN	1				18,75 520	
0903AEFN	1					16,59 548
0903AESN	1	17,31 898	19,39 020	19,39 120		
Čelik		●	●	●	○	
Nehrđajući čelik		●	○	○		
Lijevano željezo		○			●	○
Neželjezni metali						●
Visokootporan na toplinu						
Kaljeni čelik						

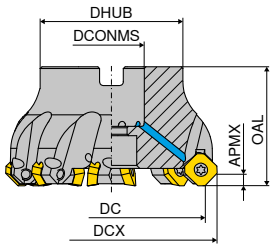
Priručnik za glodanje

Strategija obrade	→ 146	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 146

15

MaxiMill – Utično glodalo 45° A 270-12

- ▲ 50 705 ... normalna podjela za široki spektar primjene legura aluminija, obojenih metala do mekih čeličnih materijala.
- ▲ 50 706 ... uska podjela za najviši kapacitet strojne obrade, primjena prvenstveno kod čelika i lijevanog željeza.



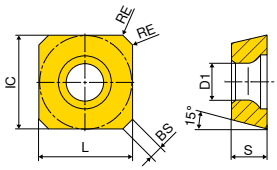
Oznaka	DC	DCX	ZNF	APMX	DCONMS $_{H6}$	OAL	DHUB	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 705 ...		2B/40 Artikl br. 50 706 ...	
	mm	mm		mm	mm	mm	mm	Nm		EUR		EUR	
A270.32.R.03-12	32	46	3	6	16	40	32	5	SD../XD.. 1204..	397,10	**032**		
A270.40.R.03-12	40	54	3	6	16	40	38	5	SD../XD.. 1204..	406,20	**040**		
A270.40.R.04-12	40	54	4	6	16	40	38	5	SD../XD.. 1204..			406,20	**040**
A270.50.R.04-12	50	64	4	6	22	40	43	5	SD../XD.. 1204..	459,20	**050**		
A270.50.R.05-12	50	64	5	6	22	40	43	5	SD../XD.. 1204..			459,20	**050**
A270.63.R.04-12	63	77	4	6	22	40	48	5	SD../XD.. 1204..	525,20	**063**		
A270.63.R.06-12	63	77	6	6	22	40	48	5	SD../XD.. 1204..			601,50	**063**
A270.80.R.05-12	80	94	5	6	27	50	58	5	SD../XD.. 1204..	609,30	**080**		
A270.80.R.08-12	80	94	8	6	27	50	58	5	SD../XD.. 1204..			750,10	**080**
A270.100.R.06-12	100	114	6	6	32	50	78	5	SD../XD.. 1204..	717,80	**100**		
A270.100.R.10-12	100	114	10	6	32	50	78	5	SD../XD.. 1204..			878,30	**100**
A270.125.R.07-12	125	139	7	6	40	63	88	5	SD../XD.. 1204..	877,00	**125**		
A270.125.R.12-12	125	139	12	6	40	63	88	5	SD../XD.. 1204..			1.186,00	**125**
A270.160.R.08-12	160	174	8	6	40	63	94	5	SD../XD.. 1204..	1.120,00	**160** [1)]		

1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

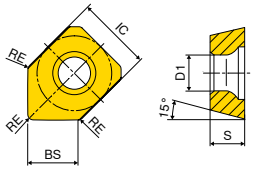
Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 T-stezni ključ Artikl br. 80 397 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Vodeći vijak Artikl br. 70 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
32 - 40	4,76	**037**	3,91	**040**	9,95	**114**	12,48	**151**	4,38	**303**	2,52	**280**	131,90	**193**
50 - 160	4,76	**037**			9,95	**114**			4,38	**303**	2,52	**280**	131,90	**193**

SDHT / SDHW / SDMT / XDHW

Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDHW 1204..	12,7	5,5	-	7,50	4,76
SD.. 1204..	12,7	5,5	12,7	1,74	4,76



SD..

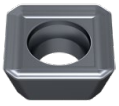
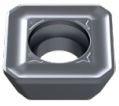


XDHW

SDHT / SDHW / SDMT

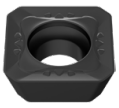
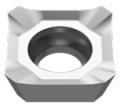
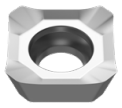
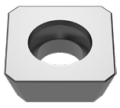
		TCM10	-R TCM10	-29R CTCP230	-R CTCP230	CTCP230
		CWC10	-R CWC10	-29R DCX1230	-R DCX1230	DCX1230
				DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		CERMET	**CERMET**			
		SDHT	SDHW	SDMT	SDHT	SDHW
		1B/79	1B/79	1B/61	1B/61	1B/61
ISO	RE	**Artikl br.** **50 426 ...**	**Artikl br.** **50 428 ...**	**Artikl br.** **51 010 ...**	**Artikl br.** **51 006 ...**	**Artikl br.** **51 008 ...**
	mm	EUR	EUR	EUR	EUR	EUR
1204AESN	0,2	17,19 **900**				
1204AESN	1,0		17,91 **899**	14,65 **020**	16,71 **020**	17,19 **020**
Čelik		●	●	●	●	●
Nehrđajući čelik		●	●	○	○	○
Lijevano željezo		○	○			
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

SDMT / SDHT / SDHW

		-29 CTPP235	-R CTPP235	-R CTPP235	-F50 CTPM245	-33 CTPM240
		-29 DPX1235	-R DPX1235	-R DPX1235	-F50 DPX2245	-33 DPX2240
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		SDMT	SDHT	SDHW	SDHT	SDHT
		1B/61	1B/61	1B/61	1H/17	1B/61
ISO	RE	**Artikl br.** **51 010 ...**	**Artikl br.** **51 006 ...**	**Artikl br.** **51 008 ...**	**Artikl br.** **51 109 ...**	**Artikl br.** **51 028 ...**
	mm	EUR	EUR	EUR	EUR	EUR
1204AESN	1,0	14,65 **120**	16,71 **120**	17,19 **120**	22,57 **475**	17,19 **425**
Čelik		●	●	●	●	○
Nehrđajući čelik		○	○	○	●	●
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

15

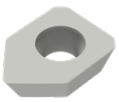
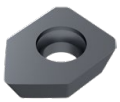
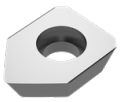
SDMT / SDHW / SDHT

		-31 CTCK215	-R CTCK215	-27 H216T	-27P H216T	H216T
		-31 DCX3215	-R DCX3215	-AL CWK26	-ALP CWK26	CWK26
		DRAGONSKIN	DRAGONSKIN			
						
		SDMT	SDHW	SDHT	SDHT	SDHW
		1B/61	1B/61	1A/90	1A/90	1B/61
ISO	RE	Artikl br. 51 059 ...	Artikl br. 51 008 ...	Artikl br. 50 426 ...	Artikl br. 50 426 ...	Artikl br. 50 428 ...
	mm	EUR	EUR	EUR	EUR	EUR
1204AEEN	1,0	14,28 520	17,19 520			
1204AEFN	0,2			17,19 504		
1204AEFN	1,0				17,19 554	
1204AESN	0,2					14,28 600
Čelik		○	○			
Nehrđajući čelik						
Lijevano željezo		●	●	○	○	○
Neželjezni metali				●	●	●
Visokootporan na toplinu						
Kaljeni čelik						

SDHT

		-M31 CTC5240	-F50 CTCS245
		-M31 HCF5240	
		DRAGONSKIN	DRAGONSKIN
		SDHT	SDHT
		1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 50 421 ...	Artikl br. 51 109 ...
	mm	EUR	EUR
1204AESN	1,0	22,57 512	22,57 57600
Čelik			
Nehrđajući čelik			
Lijevano željezo			
Neželjezni metali			
Visokootporan na toplinu		●	●
Kaljeni čelik			

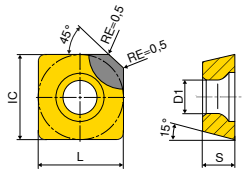
XDHW

		TCM10	CTCP230	CTPP235	CTCK215	H216T
		CWC10	DCX1230	DPX1235	DCX3215	CWK26
			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
						
		CERMET				
		XDHW	XDHW	XDHW	XDHW	XDHW
		1B/79	1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 50 449 ...	Artikl br. 51 015 ...	Artikl br. 51 015 ...	Artikl br. 51 015 ...	Artikl br. 50 449 ...
	mm	EUR	EUR	EUR	EUR	EUR
1204AEEN	1				22,64 525	
1204AEFN	1					21,42 600
1204AESN	1	22,64 900	23,74 025	23,74 125		
Čelik		●	●	●	○	
Nehrđajući čelik		●	○	○		
Lijevano željezo		○			●	○
Neželjezni metali						●
Visokootporan na toplinu						
Kaljeni čelik						

15

SDHW

Oznaka	IC	D1	L	S
	mm	mm	mm	mm
SDHW 1204..	12,7	5,5	12,7	4,76

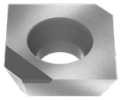


SDHW

SDHW

CTBS10U

PBC10



CBN
SDHW
V9

ISO	Artikl br. 51 900 ...	EUR	
1204AETN-2	300 [1]	54,15	

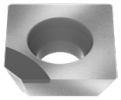
Čelik	
Nehrđajući čelik	
Lijevano željezo	●
Neželjezni metali	
Visokootporan na toplinu	●
Kaljeni čelik	

1) $a_{p\,maks.}$ = 2,0 mm

SDHW

CTDPS30

PDC



DIAMOND
SDHW
V9

ISO	Artikl br. 51 900 ...	EUR	
1204AEFN-2	100 [1]	59,03	
1204AEFN-3	102 [2]	59,03	

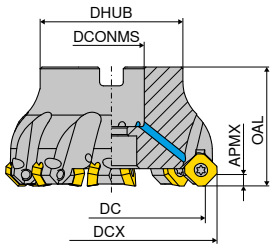
Čelik	
Nehrđajući čelik	
Lijevano željezo	
Neželjezni metali	●
Visokootporan na toplinu	
Kaljeni čelik	

1) $a_{p\,maks.}$ = 2,0 mm
2) $a_{p\,maks.}$ = 3,5 mm

Priručnik za glodanje

Strategija obrade	→ 147	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 147

MaxiMill – Utično glodalo 45° A 270-19



Oznaka	DC	DCX	ZNF	APMX	DCONMS $_{H6}$	OAL	DHUB	Pritezni moment	Okretna pločica	Lijevo NEW 2B/40 Artikl br. 50 698 ... EUR		Desno NEW 2B/40 Artikl br. 50 698 ... EUR	
	mm	mm		mm	mm	mm	mm	Nm					
A270.125.R.07-19	125	146,4	7	10	40	63	88	5	SD.. 1907..			786,50	**12507**
A270.160.R.09-19	160	181,4	9	10	40	63	104	5	SD.. 1907..			996,20	**16009**[1)]
A270.200.R.11-19	200	221,1	11	10	60	63	134	5	SD.. 1907..			1.206,00	**20011**[2)]
A270.250.L.14-19	250	271,4	14	10	60	63	134	5	SD.. 1907..	2.254,00	**75014**[2)]		
A270.250.R.14-19	250	271,4	14	10	60	63	134	5	SD.. 1907..			2.254,00	**25014**[2)]
A270.315.L.17-19	315	336,4	17	10	60	63	226	5	SD.. 1907..	2.670,00	**81517**[3)]		
A270.315.R.17-19	315	336,4	17	10	60	63	226	5	SD.. 1907..			2.670,00	**31517**[3)]

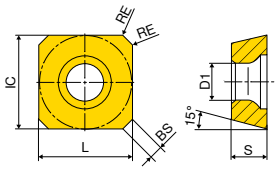
1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm
2) S 4 navojna provrta M16 na ravnini, Ø kruga rupe = 101,6 mm
3) S 4 navojna provrta M16 na ravnini, Ø kruga rupe = 101,6 mm in s 4 navojna provrta M20 na ravnini, Ø kruga rupe = 177,8 mm

Rezervni dijelovi DC	Y7 TORX®-Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
125 - 315	4,76	**037**	9,95	**114**	4,38	**303**	4,09	**302**	131,90	**193**

15

SDKT

Oznaka	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
SDKT 1907..	19,15	6	19,15	1,5	7,35	15
SDKT 1907..	19,15	6	19,15	1,5	7,16	15



SD..

SDKT

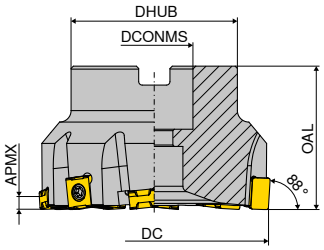
	-R50 CTCP230	-M50 CTPP235	-R50 CTPP235	-R50 CTPM225	-R50 CTCK215
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	SDKT	SDKT	SDKT	SDKT	SDKT
	NEW 1B/61	NEW 1B/61	NEW 1B/61	NEW 1B/61	NEW 1B/61
ISO RE	**Artikl br.** **51 132 ...**	**Artikl br.** **51 131 ...**	**Artikl br.** **51 132 ...**	**Artikl br.** **51 132 ...**	**Artikl br.** **51 132 ...**
mm	EUR	EUR	EUR	EUR	EUR
1907AESN 1,6	31,03 **02100**	31,03 **12000**	31,03 **12300**	31,03 **22200**	31,03 **52000**
Čelik	●	●	●	○	○
Nehrđajući čelik	○	○	○	●	
Lijevano željezo					●
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

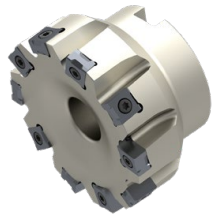
Priručnik za glodanje

Opis vrsta	→ 209	Sustav označavanja	→ 194+195
Referentne vrijednosti podataka o rezanju	→ 148		

MaxiMill – Utično glodalo HEC 11

▲ Nije namjestivo



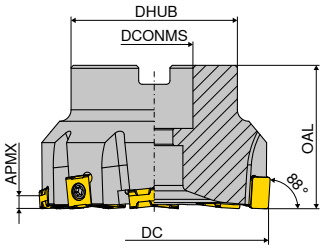


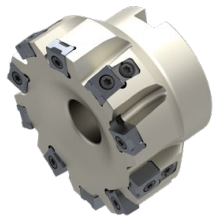
Oznaka	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 725 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm			
AHEC.50.R.06-11	50	6	6	40	48	22	12700	3,2	LNHX 1106	542,80	**050**
AHEC.63.R.08-11	63	8	6	40	48	22	10100	3,2	LNHX 1106	651,60	**063**
AHEC.80.R.10-11	80	10	6	50	58	27	8000	3,2	LNHX 1106	796,60	**080**
AHEC.100.R.12-11	100	12	6	50	78	32	6400	3,2	LNHX 1106	929,60	**100**
AHEC.125.R.12-11	125	12	6	63	88	40	5100	3,2	LNHX 1106	1.062,00	**125**
AHEC.125.R.16-11	125	16	6	63	88	40	5100	3,2	LNHX 1106	1.070,00	**12516**
AHEC.160.R.20-11	160	20	6	63	100	40	4000	3,2	LNHX 1106	1.559,00	**160** [1]

1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

MaxiMill – Utično glodalo HEC 11

▲ Aksijalno namjestivo s ravnomjernom podjelom zuba



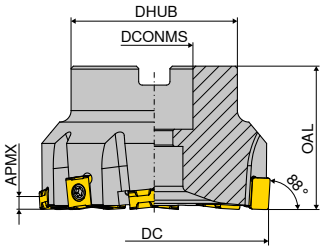


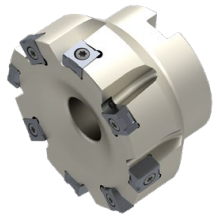
Oznaka	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 733 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm			
AHEC.50.R.06A03-11	50	6	6	40	48	22	12700	3,2	LNHX 1106	822,50	**050**
AHEC.63.R.08A04-11	63	8	6	40	48	22	10100	3,2	LNHX 1106	1.024,00	**063**
AHEC.80.R.10A05-11	80	10	6	50	58	27	8000	3,2	LNHX 1106	1.263,00	**080**
AHEC.100.R.12A06-11	100	12	6	50	78	32	6400	3,2	LNHX 1106	1.490,00	**100**
AHEC.125.R.16A08-11	125	16	6	63	88	40	5100	3,2	LNHX 1106	2.016,00	**125**
AHEC.160.R.20A10-11	160	20	6	63	100	40	4000	3,2	LNHX 1106	2.491,00	**160** [1]

1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

MaxiMill – Utično glodalo HEC 11

▲ S nejednakom podjelom zuba, nije namjestivo





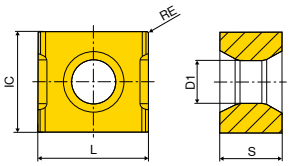
Oznaka	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 733 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
AHEC.50.R.04B-11	50	4	6	40	48	22	12700	3,2	LNHX 1106	423,40	**550**
AHEC.63.R.06B-11	63	6	6	40	48	22	10100	3,2	LNHX 1106	526,20	**563**
AHEC.80.R.08B-11	80	8	6	50	58	27	8000	3,2	LNHX 1106	674,40	**580**
AHEC.100.R.10B-11	100	10	6	50	78	32	6400	3,2	LNHX 1106	866,80	**600**
AHEC.125.R.12B-11	125	12	6	63	88	40	5100	3,2	LNHX 1106	1.060,00	**625**
AHEC.160.R.14B-11	160	14	6	63	100	40	4000	3,2	LNHX 1106	1.316,00	**660** [1]

1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

Rezervni dijelovi DC	Y7 TORX®-Izmjenjiva oštrica Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Disk rashladnog sredstva Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		2A/28 Klin Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
50 - 63	4,76	**036**	4,38	**303**	25,18	**852**	3,14	**113**	36,80	**199**	131,90	**193**
80	4,76	**036**	4,38	**303**	25,73	**853**	3,14	**113**	36,80	**199**	131,90	**193**
100	4,76	**036**	4,38	**303**	28,32	**854**	3,14	**113**	36,80	**199**	131,90	**193**
125	4,76	**036**	4,38	**303**	37,33	**855**	3,14	**113**	36,80	**199**	131,90	**193**
160	4,76	**036**	4,38	**303**			3,14	**113**	36,80	**199**	131,90	**193**

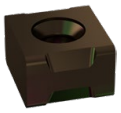
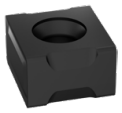
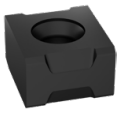
LNHX

Oznaka	IC	D1	L	S
	mm	mm	mm	mm
LNHX 1106..	10	4,27	11	6,35



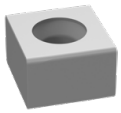
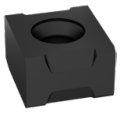
LNHX

LNHX

		CTEP210	CTCK215	-R50 CTCK215	-Q CTCK215
		DCC1210	DCX3215	-R50 DCX3215	-Q DCX3215
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		CERMET			
		LNHX	LNHX	LNHX	LNHX
		1B/79	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 046 ...	Artikl br. 51 046 ...	Artikl br. 51 024 ...	Artikl br. 51 045 ...
	mm	EUR	EUR	EUR	EUR
1106PNEN	0,5		25,91 51600		
1106PNER	0,5		25,91 520	25,91 520	
1106PNER	0,8	30,04 820			
1106ZZER	0,5				25,91 520 1)
Čelik		●	○	○	○
Nehrđajući čelik					
Lijevano željezo		●	●	●	●
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

1) -Q = pločica za široko završno glodanje

LNHX

		CTPK220	-R50 CTPK220	CTN3105	CTL3215	-Q CTL3215
		DPX3220	-R50 DPX3220	CTS3105	CWB3215	
		DRAGONSKIN	DRAGONSKIN			
						
				CERAMIC	CBN	CBN
		LNHX	LNHX	LNHX	LNHX	LNHX
		1B/61	1B/61	1G/55	1G/21	1G/21
ISO	RE	Artikl br. 51 046 ...	Artikl br. 51 024 ...	Artikl br. 50 500 ...	Artikl br. 51 046 ...	Artikl br. 51 045 ...
	mm	EUR	EUR	EUR	EUR	EUR
110608EN	0,8		25,91 608			
1106PNER	0,5	25,91 620	25,91 620			
1106PNSR	0,5			24,42 904		
1106PNSR					142,70 87200	
1106ZZER						142,70 87000 1)
Čelik		○	○			
Nehrđajući čelik						
Lijevano željezo		●	●	●	●	●
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik					○	○

1) -Q = pločica za široko završno glodanje

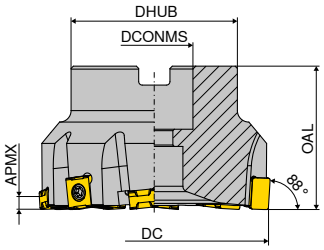
15

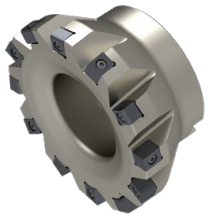
Priručnik za glodanje

Opis vrsta	→ 209+210	Sustav označavanja	→ 194+195
Referentne vrijednosti podataka o rezanju	→ 148		

MaxiMill – Utično glodalo HEC 12

▲ Nije namjestivo





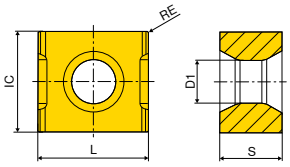
Oznaka	DC	ZNF	APMX	OAL	DHUB	DCONMS H6	RPMX	Pritezni moment	Okretna pločica	NEW 2B/40 Artikl br. 50 725 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
AHEC.125.R.12-1210	125	12	8	63	88	40	5000	3,2	LN.. 1210..	1.062,00	**32512**
AHEC.160.R.16-1210	160	16	8	63	88	40	3900	3,2	LN.. 1210..	1.247,00	**36016** 1)

1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

Rezervni dijelovi DC	Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Disk rashladnog sredstva Artikl br. 70 950 ... EUR	
125 - 160	7,05	**105**	37,33	**855**

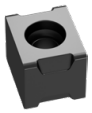
LNHX / LNEX

Oznaka	IC	D1	L	S
	mm	mm	mm	mm
LN.X 1210..	10	4,4	12,7	10,00



LNHX

LNHX / LNEX

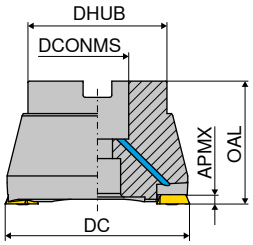
		CTCK215	CTPK220	-R50 CTPK220
		LNHX	 LNEX	LNHX
		NEW 1B/61 Artikl br. 51 135 ... EUR	NEW 1B/61 Artikl br. 51 133 ... EUR	NEW 1B/61 Artikl br. 51 134 ... EUR
ISO	RE mm			
121008EN	0,8			32,38 **60800**
121008SN	0,8	32,38 **50900**		
121020EN			29,79 **62000**	
121020SN	2,0	32,38 **52100**		
Čelik		○	○	○
Nehrđajući čelik				
Lijevano željezo		●	●	●
Neželjezni metali				
Visokootporan na toplinu				
Kaljeni čelik				

Priručnik za glodanje

Opis vrsta → 209+210
Sustav označavanja → 194+195
Referentne vrijednosti podataka o rezanju → 148

Čeono glodalo za finu obradu F 5000 A

- S okretnim pločicama namjestivima u području µm
- Vijak za namještanje aksijalnog hoda (56 950 017) namjestite ključem Torx20 (80 950 114)



Oznaka	DC	ZNF	APMX	OAL	DCONMS	DHUB	Pritezni moment	Okretna pločica	WA Artikl br. 56 511 ...	
	mm		mm	mm	mm	mm	Nm		EUR	
F5000A.42.2.43.IK	42	2	0,2	43	16	35	3,2	TEHX 16T3..	321,90	**421**
F5000A.52.2.43.IK	52	2	0,2	43	22	48	3,2	TEHX 16T3..	389,10	**521**
F5000A.66.2.53.IK	66	2	0,2	53	27	60	3,2	TEHX 16T3..	454,00	**661**
F5000A.80.2.53.IK	80	2	0,2	53	27	60	3,2	TEHX 16T3..	520,10	**801**
F5000A.100.2.53	100	2	0,2	53	32	70	3,2	TEHX 16T3..	585,10	**910** 1)

1) Bez unutarnjeg dovoda rashladnog sredstva

Rezervni dijelovi DC	Y7 TORX®- Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 T-ključ Artikl br. 80 950 ...		Y7 D-ključ Artikl br. 80 950 ...		WA Vijak za namještanje aksijalnog hoda Artikl br. 56 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		WA Stezni vijak Artikl br. 56 950 ...		WA Navojni zatik Artikl br. 56 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR		EUR	
42	4,76	**036**	4,46	**088**	9,95	**114**	3,84	**017**	4,38	**303**	3,54	**028**	24,12	**121**	131,90	**193**
52	4,76	**036**	4,46	**088**	9,28	**113**	3,84	**017**	4,38	**303**	3,54	**028**			131,90	**193**
66	4,76	**036**	4,46	**088**	9,28	**113**	3,84	**017**	4,38	**303**	3,54	**028**			131,90	**193**
80	4,76	**036**	4,46	**088**	9,28	**113**	3,84	**017**	4,38	**303**	3,54	**028**			131,90	**193**
100	4,76	**036**	4,46	**088**	9,28	**113**	3,84	**017**	4,38	**303**	3,54	**028**	24,12	**121**	131,90	**193**

Opis artikla

- Pritezni moment steznog vijka okretne pločice 56 950 028 iznosi 3,2 Nm.
- S ovim se alatom postiže apsolutno glatka površina Rz ≤ 2,5 µm i visoka preciznost ravnanja.
- S pomoću dvaju aksijalno djelujućih vijaka za fino namještanje alati se mogu namještati u području µm.
- Može se izostaviti dodatni hod brusilice, čime se skraćuje vrijeme obrade i snižavaju se troškovi.
- Ovaj alat je vrlo prikladan i za nestabilne komponente i strojeve s manjom snagom.

Vijci za namještanje aksijalnog hoda, učvršćeni u svakom glodalu, moraju se tijekom rada obavezno pritezati prednapinjanjem. U suprotnom postoji opasnost da se vijci tijekom obrade otpuste. To može imati za posljedicu da se, s jedne strane, ošteti izradak odn. alat, a s druge strane postoji i opasnost za rukovatelja stroja. Ako vijci nisu potrebni za fino namještanje, preporučujemo da vijke odstranite iz alata.

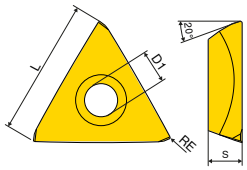
Materijal	v_c m/min	f_z mm	a_p mm
Čelik	150–250*)	0,5–2	0,05–0,2
Lijevano željezo	150–250*)	0,5–2	0,05–0,2
Kaljeni materijal ≤ 56 HRC	35–200*)	0,2–1	0,05–0,1

*) Ovisno o vrsti obrade i mikrostrukturi materijala koji se obrađuje.

15

TEHX

Oznaka	L	S	D1
	mm	mm	mm
TEHX 16T3..	14,32	4,00	3,9



TEHX

WTN1205

TEHX
WB

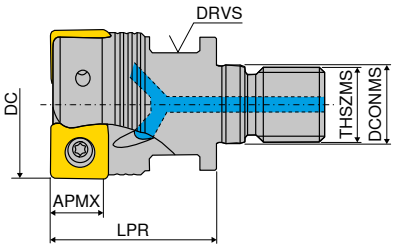
ISO	RE	Artikl br. 56 327 ...
	mm	EUR
16T3ZF	0,2	21,18 **151**

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

Priručnik za glodanje

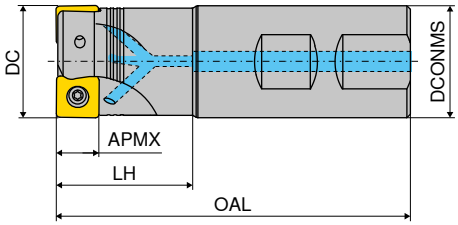
Opis vrsta	→ 209+210	Sustav označavanja	→ 194+195
Referentne vrijednosti podataka o rezanju	→ 49		

MaxiMill – Uvrtno glodalo G 491



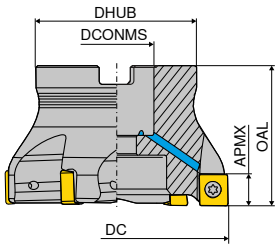
Oznaka	DC mm	ZNF	APMX mm	LPR mm	THSZMS	DCONMS mm	DRVS mm	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 773 ... EUR	
G491.25.R.03-09	25	3	6	35	M12	12,5	17	2	SNHU 09T3	351,30	**125**
G491.32.R.03-09	32	3	6	35	M16	17,0	24	2	SNHU 09T3	356,60	**132**
G491.32.R.04-09	32	4	6	35	M16	17,0	24	2	SNHU 09T3	398,40	**232**

MaxiMill – Vretenasto glodalo C 491



Oznaka	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS h6 mm	RPMX 1/min.	Pritezni moment Nm	Okretna pločica	A 2B/40 Artikl br. 50 774 ... EUR		B 2B/40 Artikl br. 50 774 ... EUR	
C491.25.R.03-09-B-32	25	3	6	59	32	25	23500	2	SNHU 09T3			356,60	**425**
C491.25.R.03-09-A-50-225	25	3	6	225	50	25	23500	2	SNHU 09T3	356,60	**325**		
C491.32.R.03-09-B-40	32	3	6	101	40	32	19600	2	SNHU 09T3			367,00	**632**
C491.32.R.04-09-B-40	32	4	6	101	40	32	19600	2	SNHU 09T3			398,40	**432**
C491.32.R.03-09-A-63-250	32	3	6	250	63	32	19600	2	SNHU 09T3	367,00	**532**		
C491.32.R.04-09-A-63-250	32	4	6	250	63	32	19600	2	SNHU 09T3	398,40	**332**		

MaxiMill – Utično glodalo A 4910

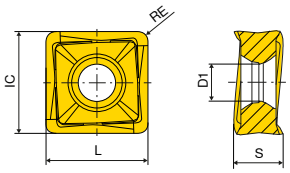


Oznaka	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 776 ... EUR		2B/40 Artikl br. 50 775 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm					
A491.40.R.03-09	40	3	6	40	38	16	16800	2	SNHU 09T3			387,90	**240**
A491.40.R.05-09	40	5	6	40	38	16	16800	2	SNHU 09T3	450,90	**240**		
A491.50.R.04-09	50	4	6	40	43	22	14600	2	SNHU 09T3			429,90	**250**
A491.50.R.06-09	50	6	6	40	43	22	14600	2	SNHU 09T3	492,80	**250**		
A491.63.R.05-09	63	5	6	40	48	22	12700	2	SNHU 09T3			513,80	**263**
A491.63.R.08-09	63	8	6	40	48	22	12700	2	SNHU 09T3	608,10	**263**		
A491.80.R.06-09	80	6	6	50	58	27	11100	2	SNHU 09T3			545,30	**280**
A491.80.R.10-09	80	10	6	50	58	27	11100	2	SNHU 09T3	671,10	**280**		
A491.100.R.07-09	100	7	6	50	78	32	9800	2	SNHU 09T3			692,00	**300**
A491.100.R.12-09	100	12	6	50	78	32	9800	2	SNHU 09T3	849,30	**300**		
A491.125.R.08-09	125	8	6	63	88	40	8700	2	SNHU 09T3			838,80	**325**
A491.125.R.15-09	125	15	6	63	88	40	8700	2	SNHU 09T3	1.028,00	**325**		

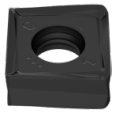
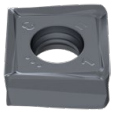
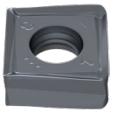
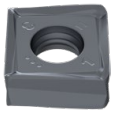
Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 T-stezni ključ Artikl br. 80 397 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Vodeći vijak Artikl br. 70 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
25 - 32	5,26	**053**			8,91	**119**			4,38	**303**	3,09	**710**	131,90	**193**
40	5,26	**053**	3,91	**040**	8,91	**119**	12,48	**151**	4,38	**303**	3,09	**710**	131,90	**193**
50 - 125	5,26	**053**			8,91	**119**			4,38	**303**	3,09	**710**	131,90	**193**

SNHU

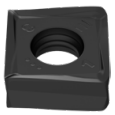
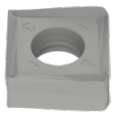
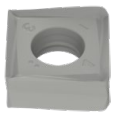
Oznaka	IC	L	S	D1
	mm	mm	mm	mm
SNHU 09T3..	9,15	9,15	3,70	3,85



SNHU

		-M50 CTCP230	-M50 CTPP235	-F50 CTPM240	-M50 CTPM240	-F40 CTPM245
		-M50 DCX1230	-M50 DPX1235	-F50 DPX2240	-M50 DPX2240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		SNHU	SNHU	SNHU	SNHU	SNHU
		1B/61	1B/61	1B/61	1B/61	NEW 1H/17
ISO	RE	Artikl br. 51 120 ...	Artikl br. 51 120 ...	Artikl br. 51 119 ...	Artikl br. 51 120 ...	Artikl br. 51 126 ...
	mm	EUR	EUR	EUR	EUR	EUR
09T308ER	0,8					27,46 45800
09T308SR	0,8	21,95 008	21,95 108	21,95 408	21,95 408	
09T312SR	1,2	21,95 01200	21,95 11200	21,95 41200	21,95 41200	
09T316SR	1,6	21,95 01600	21,95 11600	21,95 41600	21,95 41600	
Čelik		●	●	○	○	●
Nehrđajući čelik		○	○	●	●	●
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

SNHU

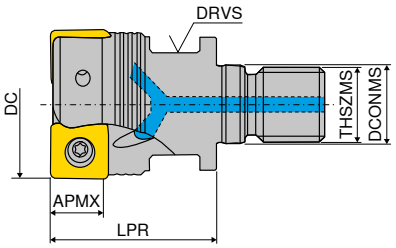
		-R50 CTCK215	-F10 CTWN215	-F40 CTC5240	-F40 CTCS245
		-R50 DCX3215	-F10 CWK4615		
		DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
					
		SNHU	SNHU	SNHU	SNHU
		1B/61	1B/61	NEW 1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 121 ...	Artikl br. 51 118 ...	Artikl br. 51 126 ...	Artikl br. 51 126 ...
	mm	EUR	EUR	EUR	EUR
09T308ER	0,8			27,46 15800	27,46 55800
09T308FR	0,8		21,95 358		
09T308SR	0,8	21,95 508			
09T312FR	1,2		21,95 36200		
09T312SR	1,2	21,95 51200			
09T316FR	1,6		21,95 36600		
09T316SR	1,6	21,95 51600			
Čelik		○			
Nehrđajući čelik					
Lijevano željezo		●	○		
Neželjezni metali			●		
Visokootporan na toplinu				●	●
Kaljeni čelik					

15

Priručnik za glodanje

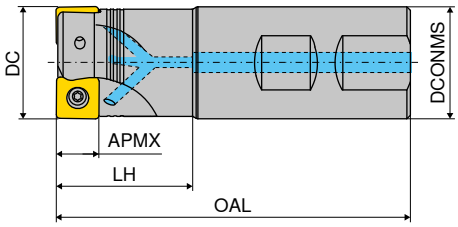
Početni parametar	→ 150	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 150

MaxiMill – Uvrtno glodalo G 491



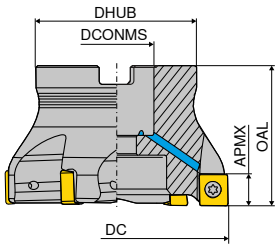
Oznaka	DC mm	ZNF	APMX mm	LPR mm	THSZMS	DCONMS mm	DRVS mm	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 773 ... EUR	
G491.32.R.02-12	32	2	8	35	M16	17	24	3,2	SNHU 1204	335,60	**032**

MaxiMill – Vretenasto glodalo C 491



Oznaka	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS $_{h6}$ mm	RPMX 1/min.	Pritezni moment Nm	Okretna pločica	A 2B/40 Artikl br. 50 774 ... EUR		B 2B/40 Artikl br. 50 774 ... EUR	
C491.32.R.02-12-B-40	32	2	8	102	40	32	13600	3,2	SNHU 1204			335,60	**032**
C491.32.R.02-12-A-63-250	32	2	8	250	63	32	10200	3,2	SNHU 1204	335,60	**232**		

MaxiMill – Utično glodalo A 491



Oznaka	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 776 ...		2B/40 Artikl br. 50 775 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
A491.40.R.03-12	40	3	8	40	38	16	11500	3,2	SNHU 1204			387,90	**040**
A491.40.R.04-12	40	4	8	40	38	16	11500	3,2	SNHU 1204	419,40	**040**		
A491.50.R.04-12	50	4	8	40	43	22	9800	3,2	SNHU 1204			429,90	**050**
A491.50.R.05-12	50	5	8	40	43	22	9800	3,2	SNHU 1204	461,40	**050**		
A491.63.R.05-12	63	5	8	40	48	22	8500	3,2	SNHU 1204			513,80	**063**
A491.63.R.06-12	63	6	8	40	48	22	8500	3,2	SNHU 1204	545,30	**063**		
A491.80.R.06-12	80	6	8	50	58	27	7400	3,2	SNHU 1204			545,30	**080**
A491.80.R.08-12	80	8	8	50	58	27	7400	3,2	SNHU 1204	629,10	**080**		
A491.100.R.07-12	100	7	8	50	78	32	6500	3,2	SNHU 1204			692,00	**100**
A491.100.R.10-12	100	10	8	50	78	32	6500	3,2	SNHU 1204	786,50	**100**		
A491.125.R.08-12	125	8	8	63	88	40	5700	3,2	SNHU 1204			838,80	**125**
A491.125.R.12-12	125	12	8	63	88	40	5700	3,2	SNHU 1204	964,70	**125**		
A491.160.R.09-12	160	9	8	63	98	40	5000	3,2	SNHU 1204			975,20	**160** [1]
A491.160.R.14-12	160	14	8	63	98	40	5000	3,2	SNHU 1204	1.133,00	**160** [1]		

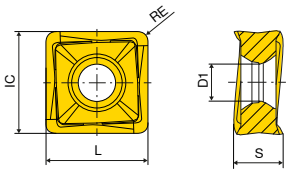
1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 T-stezni ključ Artikl br. 80 397 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Vodeći vijak Artikl br. 70 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A/28 Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
32	5,26	**054**			11,89	**128**			4,38	**303**	3,14	**859**	131,90	**193**
40	5,26	**054**	3,91	**040**	11,89	**128**	12,48	**151**	4,38	**303**	3,14	**859**	131,90	**193**
50 - 160	5,26	**054**			11,89	**128**			4,38	**303**	3,14	**859**	131,90	**193**

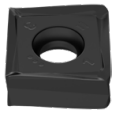
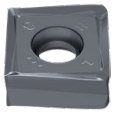
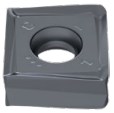
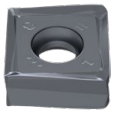
15

SNHU

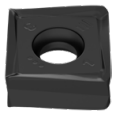
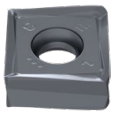
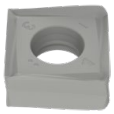
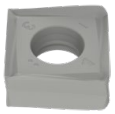
Oznaka	IC	L	S	D1
	mm	mm	mm	mm
SNHU 1204..	12,2	12,2	5,00	4,4



SNHU

		-M50 CTCP230	-M50 CTPP235	-F50 CTPM240	-M50 CTPM240	-F40 CTPM245
		-M50 DCX1230	-M50 DPX1235	-F50 DPX2240	-M50 DPX2240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		SNHU	SNHU	SNHU	SNHU	SNHU
		1B/61	1B/61	1B/61	1B/61	NEW 1H/17
ISO	RE	Artikl br. 51 100 ...	Artikl br. 51 100 ...	Artikl br. 51 102 ...	Artikl br. 51 100 ...	Artikl br. 51 128 ...
	mm	EUR	EUR	EUR	EUR	EUR
120408ER	0,8					32,97 45800
120408SR	0,8	26,81 008	26,81 108	26,81 408	26,81 408	
120412SR	1,2		26,81 112	26,81 412		
120416SR	1,6		26,81 116	26,81 416		
120420SR	2,0		26,81 120	26,81 420		
Čelik		●	●	○	○	●
Nehrđajući čelik		○	○	●	●	●
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

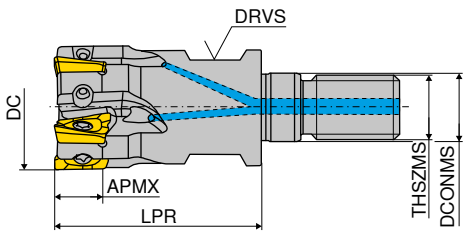
SNHU

		-R50 CTCK215	-R50 CTPK220	-F10 CTWN215	-F40 CTC5240	-F40 CTCS245
		-R50 DCX3215	-R50 DPX3220	-F10 CWK4615		
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
						
		SNHU	SNHU	SNHU	SNHU	SNHU
		1B/61	1B/61	1B/61	NEW 1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 103 ...	Artikl br. 51 103 ...	Artikl br. 51 101 ...	Artikl br. 51 128 ...	Artikl br. 51 128 ...
	mm	EUR	EUR	EUR	EUR	EUR
120408ER	0,8				32,97 15800	32,97 55800
120408FR	0,8			26,81 358		
120408SR	0,8	26,81 508	26,81 608			
120412FR	1,2			26,81 362		
120412SR	1,2	26,81 512				
120416FR	1,6			26,81 366		
120416SR	1,6	26,81 516				
120420FR	2,0			26,81 370		
120420SR	2,0	26,81 520				
Čelik		○	○			
Nehrđajući čelik						
Lijevano željezo		●	●	○		
Neželjezni metali				●		
Visokootporan na toplinu					●	●
Kaljeni čelik						

Priručnik za glodanje

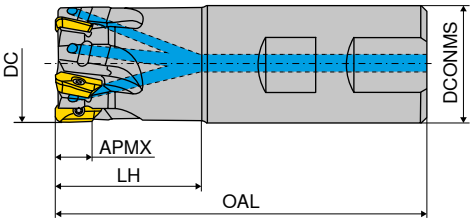
Početni parametar	→ 151	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 151

MaxiMill – Uvrtno glodalo G 211-07



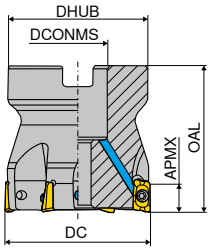
Oznaka	DC	ZNF	APMX	LPR	DCONMS	THSZMS	DRVS	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 751 ... EUR	
	mm		mm	mm	mm		mm	1/min.	Nm			
G211.16.R.04-07	16	4	6	27	8,5	M8	10	50400	1	XD.T 0703	268,00	016
G211.20.R.05-07	20	5	6	33	10,5	M10	15	44280	1	XD.T 0703	299,00	020
G211.25.R.06-07	25	6	6	35	12,5	M12	17	39480	1	XD.T 0703	348,80	025
G211.32.R.08-07	32	8	6	35	17,0	M16	24	36240	1	XD.T 0703	379,80	032

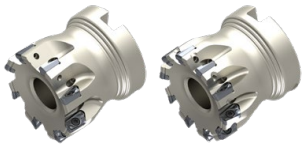
MaxiMill – Vretenasto glodalo C 211-07



Oznaka	DC	ZNF	APMX	OAL	LH	DCONMS	RPMX	Pritezni moment	Okretna pločica	A 2B/40 Artikl br. 50 752 ... EUR		B 2B/40 Artikl br. 50 752 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm					
C211.10.R.01-07-A-20	10	1	6	61,0	20	10	72000	1	XD.T 0703	212,00	010		
C211.12.R.02-07-A-20	12	2	6	66,5	20	12	66600	1	XD.T 0703	243,00	012		
C211.16.R.04-07-A/B-25	16	4	6	74,5	25	16	50400	1	XD.T 0703	268,00	016	268,00	216
C211.16.R.03-07-A-32-165	16	3	6	165,0	32	16	17760	1	XD.T 0703	249,20	116		
C211.20.R.05-07-A/B-25	20	5	6	77,0	25	20	44280	1	XD.T 0703	299,00	020	299,00	220
C211.20.R.04-07-A-40-200	20	4	6	200,0	40	20	12600	1	XD.T 0703	280,30	120		
C211.25.R.06-07-A/B20-32	25	6	6	84,0	32	20	39840	1	XD.T 0703	348,80	025	348,80	225
C211.25.R.05-07-A20-50-225	25	5	6	225,0	50	20	11280	1	XD.T 0703	311,50	125		
C211.32.R.08-07-A/B25-40	32	8	6	98,0	40	25	36240	1	XD.T 0703	379,80	032	379,80	232

MaxiMill – Utično glodalo A 211-07



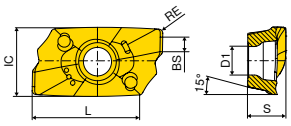


Oznaka	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 753 ...		2B/40 Artikl br. 50 754 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
A211.32.R.06-07	32	6	6	40	16	38	36240	1	XD.T 0703	317,90	**032**		
A211.32.R.08-07	32	8	6	40	16	38	36240	1	XD.T 0703			355,10	**032**
A211.40.R.08-07	40	8	6	40	16	38	33240	1	XD.T 0703	392,50	**040**		
A211.40.R.10-07	40	10	6	40	16	38	33240	1	XD.T 0703			429,90	**040**
A211.50.R.10-07	50	10	6	40	22	43	30480	1	XD.T 0703	467,20	**050**		
A211.50.R.12-07	50	12	6	40	22	43	30480	1	XD.T 0703			504,50	**050**

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 T-stezni ključ Artikl br. 80 397 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Vodeći vijak Artikl br. 70 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A/28 Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
10 - 32	5,26	**051**			10,22	**124**			4,38	**303**	3,18	**137**	118,90	**191**
32	5,26	**051**	3,91	**040**	10,22	**124**	12,48	**151**	4,38	**303**	3,18	**137**	118,90	**191**
40 - 50	5,26	**051**			10,22	**124**			4,38	**303**	3,18	**137**	118,90	**191**

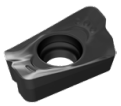
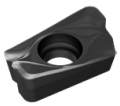
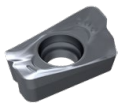
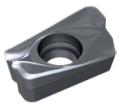
XDKT

Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDKT 0703..	4,9	2,5	7,8	1,2	3,18

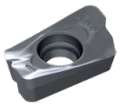
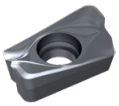
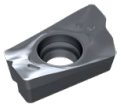


XDKT

XDKT

		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
		-F50 DCX1230	-M50 DCX1230	-F50 DPX1235	-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 033 ...	Artikl br. 51 036 ...	Artikl br. 51 033 ...	Artikl br. 51 036 ...
	mm	EUR	EUR	EUR	EUR
070304SR	0,4	11,56 004	11,56 004	11,56 104	11,56 104
070308SR	0,8	11,56 008	11,56 008	11,56 108	11,56 108
Čelik		●	●	●	●
Nehrđajući čelik		○	○	○	○
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

XDKT

		-F50 CTPM240	-M50 CTPM240	-F40 CTPM245	-F20 CTWN215	-F40 CTC5240	-F40 CTCS245
		-F50 DPX2240	-M50 DPX2240	-F40 DPX2245	-F20 CWK4615	-F40 HCF5240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
							
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1H/17	1A/90	1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 033 ...	Artikl br. 51 036 ...	Artikl br. 51 112 ...	Artikl br. 50 507 ...	Artikl br. 50 498 ...	Artikl br. 51 112 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
070304ER	0,4			13,81 454		13,81 544	
070304FR	0,4				13,31 504		
070304SR	0,4	11,56 404	11,56 404				
070308ER	0,8			13,81 458		13,81 548	13,81 558
070308FR	0,8				13,31 508		
070308SR	0,8	11,56 408	11,56 408				
Čelik		○	○	●			
Nehrđajući čelik		●	●	●			
Lijevano željezo					○		
Neželjezni metali					●		
Visokootporan na toplinu						●	●
Kaljeni čelik							

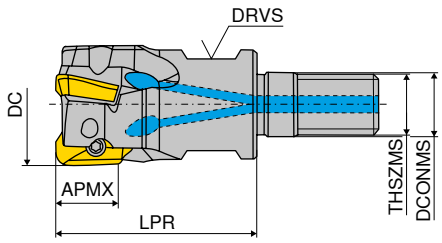
15

Priručnik za glodanje

Strategija obrade	→ 152	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 152
Početni parametar	→ 152	Korekcija posmaka zuba f_z	→ 157

MaxiMill – Uvrtno glodalo G 211-11

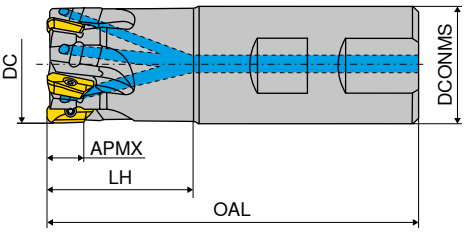
▲ Radijus okretnih pločica > 1,6 mm: Modificiranje osnovnog tijela



Oznaka	DC	ZNF	APMX	LPR	DCONMS	THSZMS	DRVS	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 736 ... EUR	
	mm		mm	mm	mm		mm	1/min.	Nm			
G211.16.R.02-11	16	2	10	27	8,5	M8	10	42000	1,2	XD.T 11T3	230,50	016
G211.20.R.03-11	20	3	10	33	10,5	M10	15	36900	1,2	XD.T 11T3	261,70	020
G211.25.R.03-11	25	3	10	35	12,5	M12	17	33200	1,2	XD.T 11T3	274,10	12500
G211.25.R.04-11	25	4	10	35	12,5	M12	17	33200	1,2	XD.T 11T3	292,90	025
G211.32.R.04-11	32	4	10	35	17,0	M16	24	30200	1,2	XD.T 11T3	305,30	13200
G211.32.R.05-11	32	5	10	35	17,0	M16	24	30200	1,2	XD.T 11T3	324,10	032
G211.40.R.06-11	40	6	10	35	17,0	M16	27	27700	1,8	XD.T 11T3	355,10	040

MaxiMill – Vretenasto glodalo C 211-11

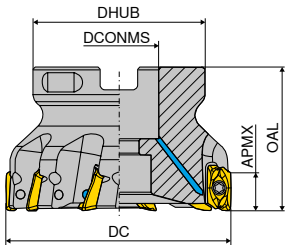
▲ Radijus okretnih pločica > 1,6 mm: Modificiranje osnovnog tijela

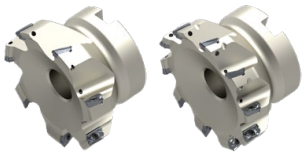


Oznaka	DC	ZNF	APMX	OAL	LH	DCONMS h6	RPMX	Pritezni moment	Okretna pločica	A 2B/40 Artikl br. 50 737 ... EUR		B 2B/40 Artikl br. 50 737 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm					
C211.12.R.01-11-B-20	12	1	10	75	20	16	55000	1,2	XD.T 11T3			205,60	012
C211.16.R.02-11-A/B-25	16	2	10	75	25	16	42000	1,2	XD.T 11T3	230,50	116	230,50	016
C211.16.R.02-11-A15-32-165	16	2	10	165	32	15	14800	1,2	XD.T 11T3	230,50	316		
C211.16.R.02-11-A-32-165	16	2	10	165	32	16	14800	1,2	XD.T 11T3	230,50	216		
C211.20.R.03-11-A-25	20	3	10	77	25	20	36900	1,2	XD.T 11T3	261,70	120		
C211.20.R.02-11-B-25	20	2	10	77	25	20	36900	1,2	XD.T 11T3			243,00	02002
C211.20.R.02-11-A-25	20	2	10	77	25	20	36900	1,2	XD.T 11T3	243,00	12002		
C211.20.R.03-11-B-25	20	3	10	77	25	20	36900	1,2	XD.T 11T3			261,70	020
C211.20.R.03-11-A-32-165	20	3	10	165	32	20	15800	1,2	XD.T 11T3	261,70	320		
C211.20.R.02-11-A-40-200	20	2	10	200	40	20	10500	1,2	XD.T 11T3	243,00	420		
C211.20.R.02-11-A19-40-200	20	2	10	200	40	19	10500	1,2	XD.T 11T3	243,00	620		
C211.25.R.03-11-A/B-32	25	3	10	90	32	25	33200	1,2	XD.T 11T3	274,20	625	274,20	725
C211.25.R.04-11-A/B-32	25	4	10	90	32	25	33200	1,2	XD.T 11T3	292,90	125	292,90	025
C211.25.R.04-11-A-40-165	25	4	10	165	40	25	19900	1,2	XD.T 11T3	292,90	325		
C211.25.R.03-11-A-50-225	25	3	10	225	50	25	9400	1,2	XD.T 11T3	274,20	425		
C211.25.R.02-11-A-50-225	25	2	10	225	50	25	9400	1,2	XD.T 11T3	255,60	02502		
C211.25.R.03-11-A24-50-225	25	3	10	225	50	24	9400	1,2	XD.T 11T3	274,20	825		
C211.32.R.04-11-A-40	32	4	10	102	40	32	30200	1,2	XD.T 11T3	305,30	13204		
C211.32.R.05-11-B5-40	32	5	10	102	40	25	30200	1,2	XD.T 11T3			324,10	73200
C211.32.R.04-11-B-25	32	4	10	102	40	32	30200	1,2	XD.T 11T3			305,30	83200
C211.32.R.04-11-A25-40	32	4	10	102	40	25	30200	1,2	XD.T 11T3	305,30	53204		
C211.32.R.05-11-A/B-40	32	5	10	102	40	32	30200	1,2	XD.T 11T3	324,10	132	324,10	032
C211.32.R.05-11-A-50-165	32	5	10	165	50	32	20900	1,2	XD.T 11T3	324,10	332		
C211.32.R.04-11-A-64-250	32	4	10	250	64	32	8500	1,2	XD.T 11T3	305,30	432		
C211.40.R.06-11-B32-50	40	6	10	110	50	32	27700	1,8	XD.T 11T3			355,10	04000
C211.40.R.06-11-B-50	40	6	10	122	50	40	27700	1,8	XD.T 11T3			355,10	14000

MaxiMill – Utično glodalo A 211-11

▲ Radijus okretnih pločica > 1,6 mm: Modificiranje osnovnog tijela





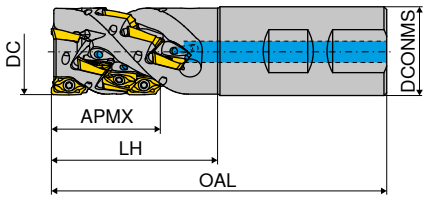
Oznaka	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 738 ...		2B/40 Artikl br. 50 739 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
A211.40.R.04-11	40	4	10	40	16	38	27700	1,8	XD.T 11T3	317,90	**040**		
A211.40.R.06-11	40	6	10	40	16	38	27700	1,8	XD.T 11T3			355,10	**040**
A211.50.R.05-11	50	5	10	40	22	43	25400	1,8	XD.T 11T3	373,80	**050**		
A211.50.R.08-11	50	8	10	40	22	43	25400	1,8	XD.T 11T3			430,00	**050**
A211.63.R.06-11	63	6	10	40	22	48	23300	1,8	XD.T 11T3	430,00	**063**		
A211.63.R.10-11	63	10	10	40	22	48	23300	1,8	XD.T 11T3			504,70	**063**
A211.80.R.07-11	80	7	10	50	27	58	21300	1,8	XD.T 11T3	486,10	**080**		
A211.80.R.10-11	80	10	10	50	27	58	21300	1,8	XD.T 11T3			542,10	**180**
A211.100.R.08-11	100	8	10	50	32	78	19600	1,8	XD.T 11T3	542,10	**10000**		
A211.125.R.10-11	125	10	10	63	40	88	17900	1,8	XD.T 11T3	591,90	**12500**		

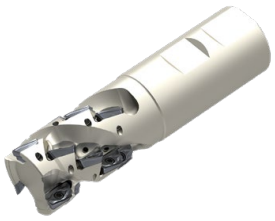
Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 T-stezni ključ Artikl br. 80 397 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Vodeći vijak Artikl br. 70 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A/28 Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
12	4,76	**043**			10,20	**125**			4,38	**303**	2,57	**116**	118,90	**191**
16 - 32	4,76	**043**			10,20	**125**			4,38	**303**	4,09	**128**	118,90	**191**
40	4,76	**043**	3,91	**040**	10,20	**125**	12,48	**151**	4,38	**303**	4,09	**131**	118,90	**191**
50	4,76	**043**	4,24	**050**	10,20	**125**	17,14	**154**	4,38	**303**	4,09	**131**	118,90	**191**
63 - 125	4,76	**043**			10,20	**125**			4,38	**303**	4,09	**131**	118,90	**191**

15

MaxiMill – Valjkasto čeono glodalo C 211-11K

▲ ZEFP = broj okretnih pločica
▲ ZNP = redovi zubiju





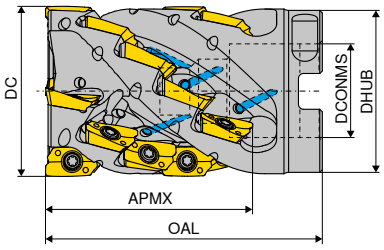
B

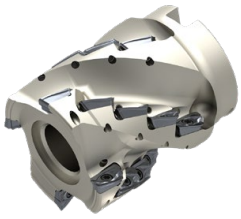
Oznaka	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	ZEFP	ZNP	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 758 ... EUR	
C211.25.R.02K3-11-B-40	25	2	27,0	97	40	25	6	3	1,2	XD.T 11T3	635,30	**025**
C211.25.R.02K4-11-B-50	25	2	37,0	107	50	25	8	4	1,2	XD.T 11T3	672,60	**125**
C211.25.R.02K5-11-B-60	25	2	45,5	117	60	25	10	5	1,2	XD.T 11T3	717,40	**225** 1)
C211.32.R.02K4-11-B-50	32	2	37,0	111	50	32	8	4	1,2	XD.T 11T3	696,80	**032**
C211.32.R.03K5-11-B-60	32	3	45,5	121	60	32	15	5	1,2	XD.T 11T3	840,70	**132**
C211.40.R.03K4-11-B32-50	40	3	37,0	110	50	32	12	4	1,8	XD.T 11T3	799,60	**040**
C211.40.R.04K5-11-B32-60	40	4	45,5	120	60	32	20	5	1,8	XD.T 11T3	964,00	**140**

1) Samo za glodanje kontura

MaxiMill – Valjkasto čeono glodalo A 211-11K

▲ ZEFP = broj okretnih pločica
▲ ZNP = redovi zubiju





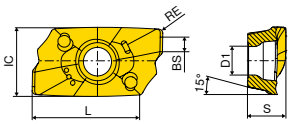
Oznaka	DC mm	ZNF	APMX mm	ZEFP	ZNP	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 757 ... EUR	
A211.40.R.03K4-11	40	3	37,0	12	4	56	16	38	1,8	XD.T 11T3	799,60	**040**
A211.40.R.04K4-11	40	4	37,0	16	4	55	16	38	1,8	XD.T 11T3	874,20	**140**
A211.40.R.04K5-11	40	4	45,5	20	5	65	16	38	1,8	XD.T 11T3	964,00	**240** 1)
A211.50.R.04K5-11	50	4	45,5	20	5	65	22	43	1,8	XD.T 11T3	1.054,00	**150**
A211.50.R.05K5-11	50	5	45,5	25	5	65	22	43	1,8	XD.T 11T3	1.148,00	**050**
A211.50.R.05K6-11	50	5	54,5	30	6	74	22	43	1,8	XD.T 11T3	1.258,00	**250** 1)

1) Samo za glodanje kontura

Rezervni dijelovi	2A/28 Vijak za zaključavanje Artikl br. 70 950 ... EUR		Y7 TORX®- Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		2A/28 Vijak s unutarnjim šesterokutom Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
25 (50758...)			4,76	**043**	10,20	**125**	4,38	**303**	4,09	**128**			118,90	**191**
32 - 40 (50758...)			4,76	**043**	10,20	**125**	4,38	**303**	4,09	**131**			118,90	**191**
40 (50757...)	9,36	**001**	4,76	**043**	10,20	**125**	4,38	**303**	4,09	**131**	3,14	**179**	118,90	**191**
50 (50757...)	11,50	**002**	4,76	**043**	10,20	**125**	4,38	**303**	4,09	**131**	5,44	**180**	118,90	**191**

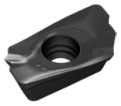
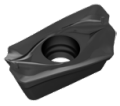
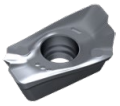
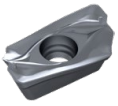
XDKT

Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDKT 11T302..	6,8	2,8	10,6	2	3,80
XDKT 11T304..	6,8	2,8	10,6	1,8	3,80
XDKT 11T308..	6,8	2,8	10,6	1,4	3,80
XDKT 11T312..	6,8	2,8	10,6	1,4	3,80
XDKT 11T316..	6,8	2,8	10,6	1,4	3,80
XDKT 11T320..	6,8	2,8	10,6	1,4	3,80
XDKT 11T325..	6,8	2,8	10,6	1,4	3,80
XDKT 11T332..	6,8	2,8	10,6	-	3,80
XDKT 11T332..	6,8	2,8	10,6	1,4	3,80
XDKT 11T332..	6,8	2,8	10,6	0,8	3,80
XDKT 11T340..	6,8	2,8	10,6	-	3,80

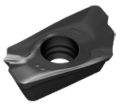
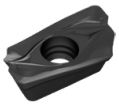
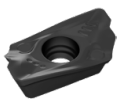
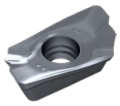
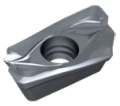
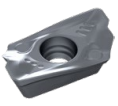


XDKT

XDKT

	-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
	-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	XDKT	XDKT	XDKT	XDKT
	1B/61	1B/61	1B/61	1B/61
ISO / RE mm	Artikl br. 51 034 ... EUR	Artikl br. 51 037 ... EUR	Artikl br. 51 034 ... EUR	Artikl br. 51 037 ... EUR
11T308SR 0,8	14,06 258	14,06 258	14,06 058	14,06 058
Čelik	●	●	●	●
Nehrđajući čelik				
Lijevano željezo				
Neželjezni metali				
Visokootporan na toplinu				
Kaljeni čelik				

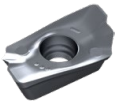
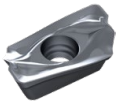
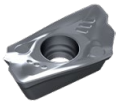
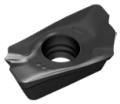
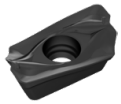
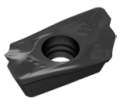
XDKT

	-F50 CTCP230	-M50 CTCP230	-R50 CTCP230	-F50 CTPP235	-M50 CTPP235	-R50 CTPP235
	-F50 DCX1230	-M50 DCX1230	-R50 DCX1230	-F50 DPX1235	-M50 DPX1235	-R50 DPX1235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
	1B/61	1B/61	1B/61	1B/61	1B/61	1B/61
ISO / RE mm	Artikl br. 51 034 ... EUR	Artikl br. 51 037 ... EUR	Artikl br. 51 039 ... EUR	Artikl br. 51 034 ... EUR	Artikl br. 51 037 ... EUR	Artikl br. 51 039 ... EUR
11T304SR 0,4	14,06 004	14,06 004	14,06 004	14,06 104	14,06 104	14,06 104
11T308SR 0,8	14,06 008	14,06 008	14,06 008	14,06 108	14,06 108	14,06 108
11T312SR 1,2		14,06 012			14,06 112	
11T320SR 2,0	14,06 020 1)	14,06 020 1)	14,06 020 1)	14,06 120 1)	14,06 120 1)	14,06 120 1)
11T325SR 2,5	14,06 025 1)	14,06 025 1)	14,06 025 1)	14,06 125 1)	14,06 125 1)	14,06 125 1)
11T332SR 3,2				14,06 13200		
11T340SR 4,0				14,06 14000		
Čelik	●	●	●	●	●	●
Nehrđajući čelik	○	○	○	○	○	○
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

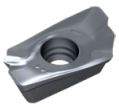
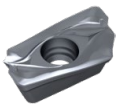
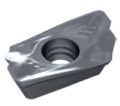
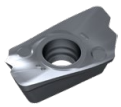
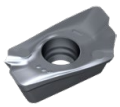
1) Radijus okretnih pločica > 1,6 mm: Modificiranje osnovnog tijela

15

XDKT

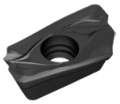
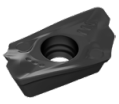
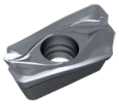
		-F50 CTPM225	-M50 CTPM225	-R50 CTPM225	-F50 CTCM235	-M50 CTCM235	-R50 CTCM235
		-F50 DPX2225	-M50 DPX2225	-R50 DPX2225	-F50 DCX2235	-M50 DCX2235	-R50 DCX2235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 034 ...	Artikl br. 51 037 ...	Artikl br. 51 039 ...	Artikl br. 51 034 ...	Artikl br. 51 037 ...	Artikl br. 51 039 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
11T308SR	0,8	14,06 208	14,06 208	14,06 208	14,06 308	14,06 308	14,06 308
Čelik		○	○	○	○	○	○
Nehrđajući čelik		●	●	●	●	●	●
Lijevano željezo							
Neželjezni metali							
Visokootporan na toplinu							
Kaljeni čelik							

XDKT

		-F50 CTPM240	-M50 CTPM240	-R50 CTPM240	-F40 CTPM245	-F50 CTPM245
		-F50 DPX2240	-M50 DPX2240	-R50 DPX2240	-F40 DPX2245	-F50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		XDKT	XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1H/17	1H/17
ISO	RE	Artikl br. 51 034 ...	Artikl br. 51 037 ...	Artikl br. 51 039 ...	Artikl br. 51 113 ...	Artikl br. 51 034 ...
	mm	EUR	EUR	EUR	EUR	EUR
11T304ER	0,4				18,09 454	
11T304SR	0,4		14,06 404			
11T308ER	0,8				18,09 458	
11T308SR	0,8	14,06 408	14,06 408	14,06 408		18,09 458
11T312ER	1,2				18,09 462	
11T312SR	1,2	14,06 412	14,06 412	14,06 412		
11T316ER	1,6				18,09 466	
11T320ER	2,0				18,09 470 [1]	
11T320SR	2,0	14,06 420 [1]	14,06 420 [1]	14,06 420 [1]		
11T325ER	2,5				18,09 475 [1]	
11T332ER	3,2				18,09 482 [1]	
11T332SR	3,2	14,06 432 [1]	14,06 432 [1]	14,06 432 [1]		
11T340ER	4,0				18,09 490 [1]	
Čelik		○	○	○	●	●
Nehrđajući čelik		●	●	●	●	●
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

1) Radijus okretnih pločica > 1,6 mm: Modificiranje osnovnog tijela

XDKT

		-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-F20 CTWN215	-F40 CTC5240	-F40 CTCS245	-R60 CTP6215
		-M50 DCX3215	-R50 DCX3215	-M50 DPX3220	-F20 CWK4615	-F40 HCF5240		-R60 CCN6215
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	
								
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1A/90	1H/D4	NEW 1H/D4	1B/61
ISO	RE	Artikl br. 51 037 ...	Artikl br. 51 039 ...	Artikl br. 51 037 ...	Artikl br. 50 478 ...	Artikl br. 50 463 ...	Artikl br. 51 113 ...	Artikl br. 50 464 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR	EUR
11T302FR	0,2				17,67 502			
11T304ER	0,4					18,09 504		
11T304FR	0,4				17,67 504			
11T304SR	0,4	14,06 504						
11T308ER	0,8					18,09 500	18,09 558	
11T308FR	0,8				17,67 508			
11T308SR	0,8	14,06 508	14,06 508	14,06 608				18,17 300
11T312ER	1,2					18,09 512	18,09 562	
11T316ER	1,6					18,09 516	18,09 566	
11T320ER	2,0					18,09 520 1)	18,09 570	
11T320FR	2,0				17,67 520 1)			
11T325ER	2,5					18,09 525 1)	18,09 57500 1)	
11T325FR	2,5				17,67 525 1)			
11T332ER	3,2					18,09 532 1)	18,09 582	
11T340ER	4,0					18,09 540 1)	18,09 59000 1)	

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

1) Radijus okretnih pločica > 1,6 mm: Modificiranje osnovnog tijela

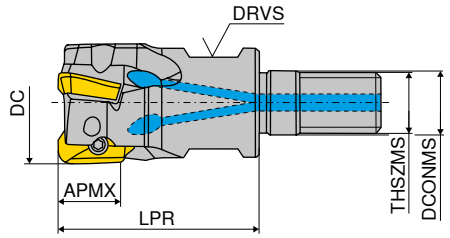
Priručnik za glodanje

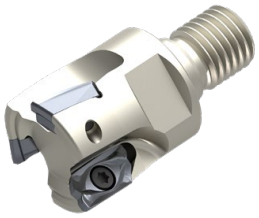
Strategija obrade	→ 153	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 153
Početni parametar	→ 155	Korekcija posmaka zuba f_z	→ 157

15

MaxiMill – Uvrtno glodalo G 211-15

▲ Radijus okretnih pločica > 2,5 mm: Modificiranje osnovnog tijela

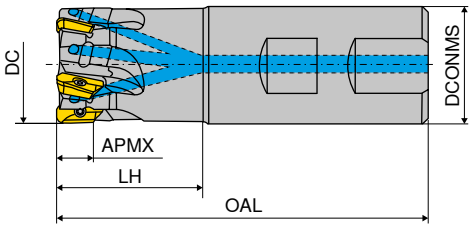




Oznaka	DC	ZNF	APMX	LPR	DCONMS	THSZMS	DRVS	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 746 ...	
	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
G211.25.R.02-15	25	2	14	35	12,5	M12	17	26560	3,2	XD.T 1505	264,70	025
G211.32.R.03-15	32	3	14	35	17,0	M16	24	30200	3,2	XD.T 1505	294,70	032
G211.40.R.04-15	40	4	14	40	17,0	M16	27	27700	3,2	XD.T 1505	325,00	040

MaxiMill – Vretenasto glodalo C 211-15

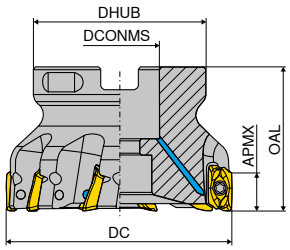
▲ Radijus okretnih pločica > 2,5 mm: Modificiranje osnovnog tijela

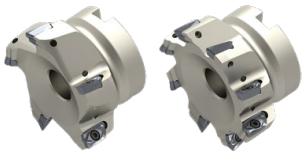


Oznaka	DC	ZNF	APMX	OAL	LH	DCONMS	RPMX	Pritezni moment	Okretna pločica	A 2B/40 Artikl br. 50 747 ...		B 2B/40 Artikl br. 50 747 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
C211.25.R.02-15-B20-32	25	2	14	83	32	20	26560	3,2	XD.T 1505			264,70	125
C211.25.R.02-15-B/A-32	25	2	14	90	32	25	26560	3,2	XD.T 1505	264,70	225	264,70	025
C211.25.R.02-15-A-50-225	25	2	14	225	50	25	7520	3,2	XD.T 1505	246,70	325		
C211.32.R.03-15-B25-40	32	3	14	96	40	25	22160	3,2	XD.T 1505			294,70	132
C211.32.R.03-15-A-40	32	3	14	103	40	32	24160	3,2	XD.T 1505	294,70	232		
C211.32.R.03-15-B-40	32	3	14	103	40	32	24160	3,2	XD.T 1505			294,70	032
C211.32.R.03-15-A-63-250	32	3	14	250	63	32	6800	3,2	XD.T 1505	276,80	332		
C211.40.R.04-15-A-50	40	4	14	110	50	32	22160	3,2	XD.T 1505	325,00	240		
C211.40.R.04-15-B32-50	40	4	14	110	50	32	22160	3,2	XD.T 1505			325,00	040
C211.40.R.03-15-A-50-275	40	3	14	275	50	32	6120	3,2	XD.T 1505	306,70	340		

MaxiMill – Utično glodalo A 211-15

▲ Radijus okretnih pločica > 2,5 mm: Modificiranje osnovnog tijela





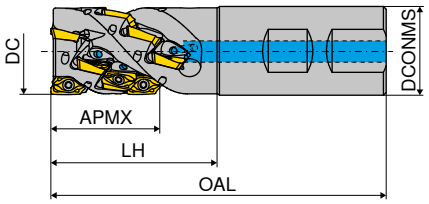
Oznaka	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 748 ...		2B/40 Artikl br. 50 749 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
A211.40.R.03-15	40	3	14	40	16	38	22160	3,2	XD.T 1505	288,80	**040**		
A211.40.R.04-15	40	4	14	40	16	38	22160	3,2	XD.T 1505			325,00	**040**
A211.50.R.03-15	50	3	14	40	22	43	20320	3,2	XD.T 1505	342,90	**050**		
A211.50.R.05-15	50	5	14	40	22	43	20320	3,2	XD.T 1505			379,00	**050**
A211.63.R.04-15	63	4	14	45	22	48	18640	3,2	XD.T 1505	415,00	**063**		
A211.63.R.06-15	63	6	14	45	22	48	18640	3,2	XD.T 1505			451,50	**063**
A211.80.R.05-15	80	5	14	50	27	58	17040	3,2	XD.T 1505	469,20	**080**		
A211.80.R.08-15	80	8	14	50	27	58	17040	3,2	XD.T 1505			505,20	**080**
A211.100.R.06-15	100	6	14	50	32	78	15680	3,2	XD.T 1505	523,50	**100**		
A211.100.R.10-15	100	10	14	50	32	78	15680	3,2	XD.T 1505			559,50	**100**
A211.125.R.07-15	125	7	14	63	40	88	14320	3,2	XD.T 1505	553,40	**125**		
A211.125.R.11-15	125	11	14	63	40	88	14320	3,2	XD.T 1505			589,50	**125**
A211.160.R.08-15	160	8	14	63	40	93	13200	3,2	XD.T 1505	775,30	**160**		
A211.160.R.12-15	160	12	14	63	40	93	13200	3,2	XD.T 1505			811,40	**160**

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 T-stezni ključ Artikl br. 80 397 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Vodeći vijak Artikl br. 70 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
25 - 32	5,26	**054**			11,89	**128**			4,38	**303**	3,18	**839**	131,90	**193**
40	5,26	**054**	3,91	**040**	11,89	**128**	12,48	**151**	4,38	**303**	3,18	**839**	131,90	**193**
50	5,26	**054**	4,24	**050**	11,89	**128**	17,14	**154**	4,38	**303**	3,18	**839**	131,90	**193**
63 - 160	5,26	**054**			11,89	**128**			4,38	**303**	3,18	**839**	131,90	**193**

15

MaxiMill – Valjkasto čeono glodalo C 211-15K

▲ ZEFP = broj okretnih pločica
▲ ZNP = redovi zubiju



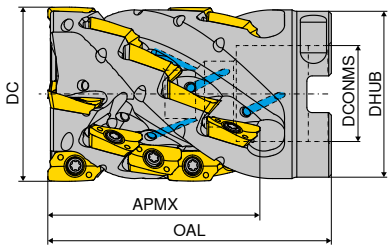
B

Oznaka	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	ZEFP	ZNP	Pritezni moment Nm	Okretna pločica	NEW 2B/40 Artikl br. 50 782 ... EUR	
C211.40.R.02K3-15-B32-60	40	2	38,0	120	60	32	6	3	3,2	XD.T 1505	773,60	**04002**
C211.50.R.03K4-15-B40-64	50	3	50,5	134	64	40	12	4	3,2	XD.T 1505	904,40	**05003**

Rezervni dijelovi DC	Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR	
40 - 50	9,15	**120**	3,18	**839**

MaxiMill – Valjkasto čeono glodalo A 211-15K

▲ ZEFP = broj okretnih pločica
▲ ZNP = redovi zubiju

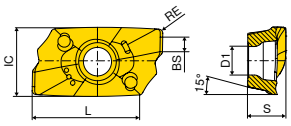


Oznaka	DC mm	ZNF	APMX mm	ZEFP	ZNP	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 759 ... EUR	
A211.50.R.03K4-15	50	3	50,5	12	4	74	22	43	3,2	XD.T 1505	904,40	**050**
A211.50.R.03K5-15	50	3	63,0	15	5	88	22	43	3,2	XD.T 1505	960,40	**150**
A211.63.R.03K4-15	63	3	50,5	12	4	74	27	58	3,2	XD.T 1505	986,00	**063**
A211.63.R.04K6-15	63	4	75,5	24	6	102	27	58	3,2	XD.T 1505	1.210,00	**163**
A211.80.R.04K5-15	80	4	63,0	20	5	88	32	78	3,2	XD.T 1505	1.216,00	**080**
A211.80.R.05K6-15	80	5	75,5	30	6	102	32	78	3,2	XD.T 1505	1.404,00	**180**

Rezervni dijelovi DC	2A/28 Vijak za zaključavanje Artikl br. 70 950 ... EUR		Y7 TORX®-Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		2A/28 Vijak s unutarnjim šesterokutom Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
50	11,50	**002**	5,26	**054**	11,89	**128**	4,38	**303**	3,18	**839**	5,44	**180**	131,90	**193**
63	15,95	**003**	5,26	**054**	11,89	**128**	4,38	**303**	3,18	**839**	8,45	**181**	131,90	**193**
80	25,73	**004**	5,26	**054**	11,89	**128**	4,38	**303**	3,18	**839**	11,50	**234**	131,90	**193**

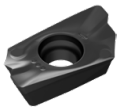
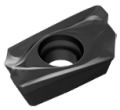
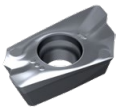
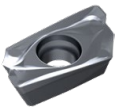
XDKT

Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDKT 150508..	9,3	4,4	14,8	1,6	5,56
XDKT 150512..	9,3	4,4	14,8	1,6	5,56
XDKT 150516..	9,3	4,4	14,8	1,6	5,56
XDKT 150520..	9,3	4,4	14,8	1,6	5,56
XDKT 150530..	9,3	4,4	14,8	1,6	5,56
XDKT 150532..	9,3	4,4	14,8	1,9	5,56
XDKT 150540..	9,3	4,4	14,8	1,2	5,56



XDKT

XDKT

		-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
		-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
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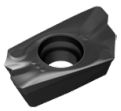
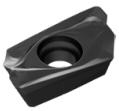
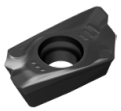
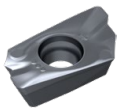
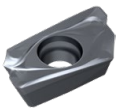
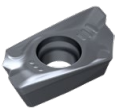
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 035 ...	Artikl br. 51 038 ...	Artikl br. 51 035 ...	Artikl br. 51 038 ...
	mm	EUR	EUR	EUR	EUR
150508SR	0,8	18,75 258	18,75 258	18,75 058	18,75 058
Čelik		●	●	●	●
Nehrđajući čelik					
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

XDKT

		-F50 CTCP230	-M50 CTCP230	-R50 CTCP230	-F50 CTPP235	-M50 CTPP235	-R50 CTPP235
		-F50 DCX1230	-M50 DCX1230	-R50 DCX1230	-F50 DPX1235	-M50 DPX1235	-R50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
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ISO	RE	Artikl br. 51 035 ...	Artikl br. 51 038 ...	Artikl br. 51 040 ...	Artikl br. 51 035 ...	Artikl br. 51 038 ...	Artikl br. 51 040 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
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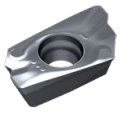
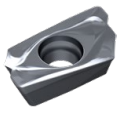
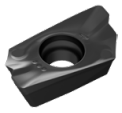
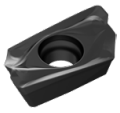
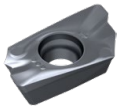
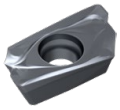
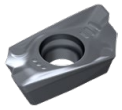
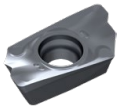
150512SR	1,2		18,75 012			18,75 112	
150516SR	1,6		18,75 016			18,75 116	
150520SR	2,0			18,75 020		18,75 120	18,75 120
150530SR	3,0		18,75 030			18,75 130	
150540SR	4,0		18,75 040			18,75 140	
Čelik		●	●	●	●	●	●
Nehrđajući čelik		○	○	○	○	○	○
Lijevano željezo							
Neželjezni metali							
Visokootporan na toplinu							
Kaljeni čelik							

15

XDKT

		-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-M50 CTCM235
		-F50 DPX2225	-M50 DPX2225	-F50 DCX2235	-M50 DCX2235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 035 ...	Artikl br. 51 038 ...	Artikl br. 51 035 ...	Artikl br. 51 038 ...
	mm	EUR	EUR	EUR	EUR
150508SR	0,8	18,75 208	18,75 208	18,75 308	18,75 308
Čelik		○	○	○	○
Nehrđajući čelik		●	●	●	●
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

XDKT

		-F50 CTPM240	-M50 CTPM240	-R50 CTPM240	-F40 CTPM245
		-F50 DPX2240	-M50 DPX2240	-R50 DPX2240	-F40 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
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		1B/61	1B/61	1B/61	1H/17
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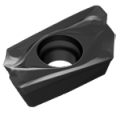
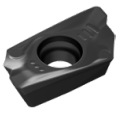
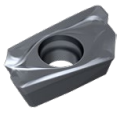
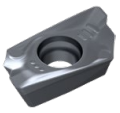
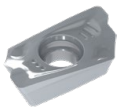
	mm	EUR	EUR	EUR	EUR
150508ER	0,8				22,57 458
150508SR	0,8	18,75 408	18,75 408	18,75 408	
150512SR	1,2		18,75 412		
150516SR	1,6		18,75 416		
150530SR	3,0		18,75 430		
150532ER	3,2				22,57 482 1)
150540ER	4,0				22,57 490 1)
150540SR	4,0		18,75 440		
Čelik		○	○	○	●
Nehrđajući čelik		●	●	●	●
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

1) Radijus okretnih pločica > 1,6 mm: Modificiranje osnovnog tijela

XDKT

	-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-R50 CTPK220	-F20 CTWN215
	-M50 DCX3215	-R50 DCX3215	-M50 DPX3220	-R50 DPX3220	-F20 CWK4615
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
					
	XDKT	XDKT	XDKT	XDKT	XDKT
	1B/61	1B/61	1B/61	1B/61	1A/90
ISO / RE mm	Artikl br. 51 038 ... EUR		Artikl br. 51 040 ... EUR		Artikl br. 51 038 ... EUR		Artikl br. 51 040 ... EUR		Artikl br. 50 479 ... EUR	
150508FR 0,8									22,16	508
150508SR 0,8	18,75	508	18,75	508	18,75	608	18,75	608		
Čelik	○		○		○		○			
Nehrđajući čelik										
Lijevano željezo	●		●		●		●		○	
Neželjezni metali									●	
Visokootporan na toplinu										
Kaljeni čelik										

XDKT

	-F40 CTC5240	-F40 CTCS245	-R60 CTP6215
	-F40 HCF5240		-R60 CCN6215
	DRAGONSKIN	DRAGONSKIN	
			
	XDKT	XDKT	XDKT
	1H/D4	NEW 1H/D4	1B/61
ISO / RE mm	Artikl br. 50 473 ... EUR		Artikl br. 51 114 ... EUR		Artikl br. 50 469 ... EUR	
150508ER 0,8	22,57	508	22,57	558		
150508SR 0,8					18,75	300
150532ER 3,2	22,57	532 [1)]				
150540ER 4,0	22,57	540 [1)]	22,57	59000 [1)]		
Čelik						
Nehrđajući čelik						
Lijevano željezo					●	
Neželjezni metali						
Visokootporan na toplinu	●		●			
Kaljeni čelik					●	

1) Radijus okretnih pločica > 2,5 mm: Modificiranje osnovnog tijela

Priručnik za glodanje

Strategija obrade	→ 154	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 154
Početni parametar	→ 155	Korekcija posmaka zuba f_z	→ 157

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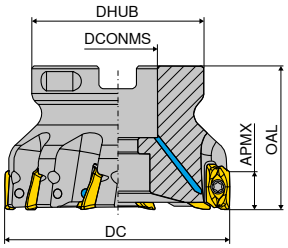
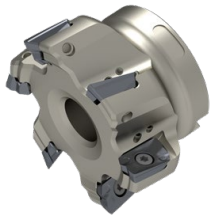
MaxiMill – Utično glodalo A 211-20

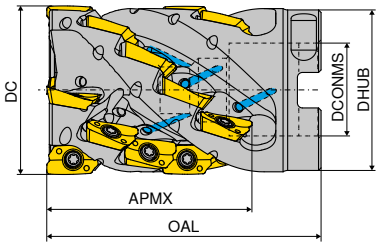




Oznaka	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	Pritezni moment	Okretna pločica	NEW 2B/40 Artikl br. 50 778 ...
	mm		mm	mm	mm	mm	1/min.	Nm		EUR
A211.63.R.05-20	63	5	19	45	22	48	14400	5	XD.. 2007..	434,10 **06305**
A211.80.R.06-20	80	6	19	50	27	58	12400	5	XD.. 2007..	464,30 **08006**
A211.100.R.07-20	100	7	19	50	32	78	10900	5	XD.. 2007..	498,20 **10007**

MaxiMill – Valjkasto čeono glodalo A 211-20K

- ZEFP = broj okretnih pločica
- ZNP = redovi zubiju

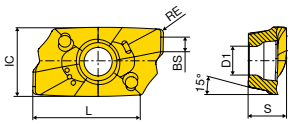


Oznaka	DC	ZNF	APMX	ZEFP	ZNP	OAL	DCONMS $_{H6}$	DHUB	Pritezni moment	Okretna pločica	NEW 2B/40 Artikl br. 50 780 ...
	mm		mm			mm	mm	mm	Nm		EUR
A211.63.R.04K4-20	63	4	68	16	4	92	27	58	3,2	XD.. 2007..	961,40 **06304**
A211.80.R.05K4-20	80	5	68	20	4	92	32	76	3,2	XD.. 2007..	1.078,00 **08005**

	2A/28		Y7		Y7		2A/28		2A		2A/28		Y7	
	Vijak za zaključavanje		TORX®-Izmjenjiva oštrica		D-ključ		Pasta Molykote		Stezni vijak		Vijak s unutarnjim šesterokutom		Momentni odvijač	
Rezervni dijelovi DC	**Artikl br. 70 950 ...**		**Artikl br. 80 950 ...**		**Artikl br. 80 950 ...**		**Artikl br. 70 950 ...**		**Artikl br. 70 950 ...**		**Artikl br. 70 950 ...**		**Artikl br. 80 950 ...**	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
63	15,95	**003**	4,76	**037**	7,52	**106**	4,38	**303**	2,52	**280**	8,45	**181**	131,90	**193**
80	25,73	**004**	4,76	**037**	7,52	**106**	4,38	**303**	2,52	**280**	11,50	**234**	131,90	**193**
100			4,76	**037**	7,52	**106**	4,38	**303**	2,52	**280**			131,90	**193**

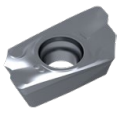
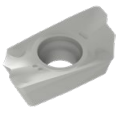
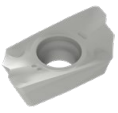
XDKT

Oznaka	IC	D1	L	S
	mm	mm	mm	mm
XDKT 200708..	12,5	5,5	18,8	6,93
XDKT 200732..	12,5	5,5	18,8	6,82



XDKT

XDKT

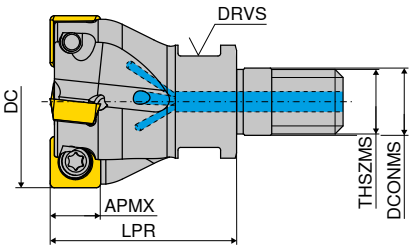
		-F40 CTPM245	-F40 CTC5240	-F40 CTCS245
			DRAGONSKIN	DRAGONSKIN
		 XDKT	 XDKT	 XDKT
		NEW 1H/17	NEW 1H/D4	NEW 1H/D4
ISO	RE	**Artikl br. 51 127 ...**	**Artikl br. 51 127 ...**	**Artikl br. 51 127 ...**
	mm	EUR	EUR	EUR
200708ER	0,8	26,69 **45800**	26,69 **15800**	26,69 **55800**
200732ER	3,2		26,69 **18200**	
Čelik		●		
Nehrđajući čelik		●		
Lijevano željezo				
Neželjezni metali				
Visokootporan na toplinu			●	●
Kaljeni čelik				

Priručnik za glodanje

Strategija obrade	→ 156	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 156
Početni parametar	→ 156	Korekcija posmaka zuba f_z	→ 157

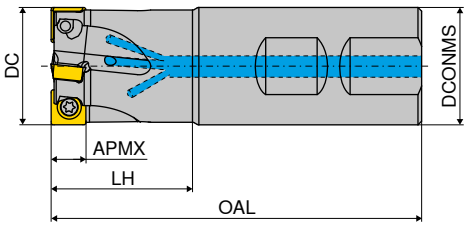
15

MaxiMill – Uvrtno glodalo G 490-09



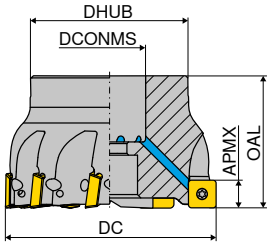
Oznaka	DC mm	ZNF	APMX mm	LPR mm	THSZMS	DCONMS mm	DRVS mm	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 726 ... EUR	
G490.25.R.03-09	25	3	8	35	M12	12,5	17	3,2	SD.. 09T3..	304,20	025
G490.32.R.04-09	32	4	8	35	M16	17,0	24	3,2	SD.. 09T3..	329,90	032

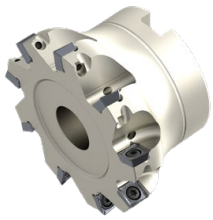
MaxiMill – Vretenasto glodalo C 490-09



Oznaka	DC mm	ZNF	APMX mm	DCONMS mm	OAL mm	LH mm	Pritezni moment Nm	Okretna pločica	A 2B/40 Artikl br. 50 727 ... EUR		B 2B/40 Artikl br. 50 727 ... EUR	
C490.25.R.03-09-B-32	25	3	8	25	88	32	3,2	SD.. 09T3..			304,20	025
C490.25.R.02-09-A-20	25	2	8	20	165	40	3,2	SD.. 09T3..	280,50	225		
C490.25.R.02-09-A-40-165	25	2	8	25	165	40	3,2	SD.. 09T3..	291,00	125		
C490.32.R.04-09-B-25	32	4	8	25	100	40	3,2	SD.. 09T3..			317,90	132
C490.32.R.04-09-B-40	32	4	8	32	100	40	3,2	SD.. 09T3..			329,90	032

MaxiMill – Utično glodalo A 490-09

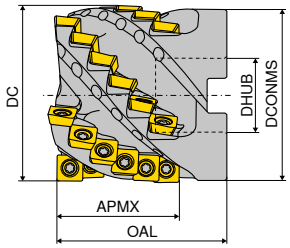


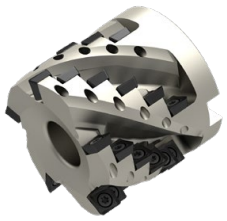


Oznaka	DC mm	ZNF	APMX mm	DHUB mm	DCONMS H6 mm	OAL mm	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 728 ... EUR	
A490.40.R.05-09	40	5	8	38	16	40	3,2	SD.. 09T3..	368,80	040
A490.42.R.06-09	42	6	8	38	16	40	3,2	SD.. 09T3..	394,50	042
A490.50.R.06-09	50	6	8	43	22	40	3,2	SD.. 09T3..	407,50	050
A490.52.R.07-09	52	7	8	43	22	40	3,2	SD.. 09T3..	433,30	052
A490.63.R.07-09	63	7	8	48	22	40	3,2	SD.. 09T3..	446,30	063
A490.66.R.08-09	66	8	8	48	22	40	3,2	SD.. 09T3..	472,10	066
A490.80.R.09-09	80	9	8	58	27	50	3,2	SD.. 09T3..	627,40	080
A490.100.R.10-09	100	10	8	78	32	50	3,2	SD.. 09T3..	685,60	100
A490.160.R.14-09	160	14	8	88	40	62	3,2	SD.. 09T3..	1.013,00	160

MaxiMill – Valjkasto čeono glodalo A 490-09K

▲ ZEFP = broj okretnih pločica
▲ ZNP = redovi zubiju

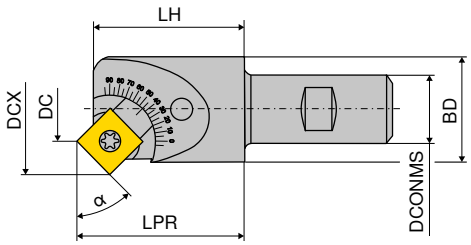




Oznaka	DC	ZNF	APMX	ZEFP	ZNP	OAL	DCONMS $_{H6}$	DHUB	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 761 ... EUR	
	mm		mm			mm	mm	mm	Nm			
A490.40.R.03K6-09	40	3	41	18	6	55	16	38	3,2	SD.. 09T3..	1.022,00	**040**
A490.50.R.04K6-09	50	4	41	24	6	55	22	48	3,2	SD.. 09T3..	1.237,00	**050**
A490.63.R.05K6-09	63	5	41	30	6	60	27	61	3,2	SD.. 09T3..	1.398,00	**063**

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 T-stezni ključ Artikl br. 80 397 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Vodeći vijak Artikl br. 70 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
25 - 32	4,76	**036**			9,28	**113**			4,38	**303**	3,14	**110**	128,60	**192**
40 - 42	4,76	**036**	3,91	**040**	9,28	**113**	12,48	**151**	4,38	**303**	3,14	**110**	128,60	**192**
50 - 160	4,76	**036**			9,28	**113**			4,38	**303**	3,14	**110**	128,60	**192**

Namjestivo kutno glodalo C 4500



B

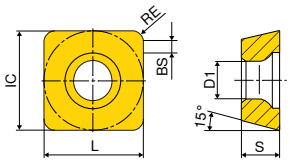
Oznaka	DC	DCX	ZNF	LPR	DCONMS	LH	BD	Pritezni moment	Okretna pločica	2B Artikl br. 50 668 ... EUR	
	mm	mm		mm	mm	mm	mm	Nm			
C4500.16.R.01	3,0 - 20,8	20,3 - 23,9	1	33,0 - 35,0	16	32	18,65	3,2	SD.. 09T3..	151,00	**116**

Rezervni dijelovi Okretna pločica	2A Vijak s cilindričnom glavom Artikl br. 70 950 ... EUR		2A Klin za namještanje Artikl br. 70 950 ... EUR		Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
SD.. 09T3..	3,38	**709**	15,10	**708**	4,76	**036**	9,28	**113**	4,38	**303**	3,14	**110**	128,60	**192**

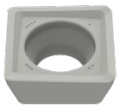
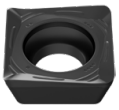
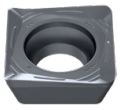
15

SDHT / SDNT

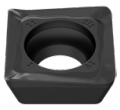
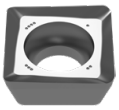
Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
SD.T 09T3..	9,52	4,4	9,52	2,5	3,97



SDHT / SDNT

	TCM10	-29 CTCP230	CTPP235	-29 CTPP235	-33 CTPM240	-F50 CTPM245
	CWC10	-29 DCX1230	DPX1235	-29 DPX1235	-33 DPX2240	-F50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	CERMET					
	SDHT	SDNT	SDNT	SDNT	SDNT	SDNT
	1B/79	1B/61	1B/61	1B/61	1B/61	1H/17
ISO RE mm	Artikl br. 50 424 ... EUR	Artikl br. 51 011 ... EUR	Artikl br. 51 082 ... EUR	Artikl br. 51 011 ... EUR	Artikl br. 51 030 ... EUR	Artikl br. 51 111 ... EUR
09T308ER 0,8			11,61 108			13,00 458
09T308SR 0,8	15,76 900	11,61 008		11,61 108	11,61 408	
Čelik	●	●	●	●	○	●
Nehrđajući čelik	●	○	○	○	●	●
Lijevano željezo	○					
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

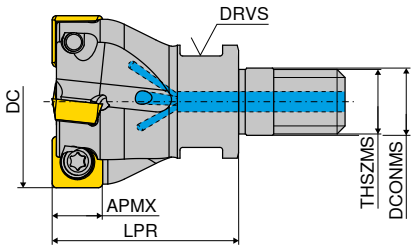
SDNT / SDHT

	-31 CTCK215	-27P H216T	-27P AMZ	-27 CTC5240	-M31 CTC5240	-F10 CTCS245
	-31 DCX3215	-27P CWK26	-27P AMZ	-AL HCF5240	-M31 HCF5240	
	DRAGONSKIN			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	SDNT	SDHT	SDHT	SDHT	SDNT	SDHT
	1B/61	1A/90	1A/90	1H/D4	1H/D4	NEW 1H/D4
ISO RE mm	Artikl br. 51 029 ... EUR	Artikl br. 50 424 ... EUR	Artikl br. 50 424 ... EUR	Artikl br. 50 496 ... EUR	Artikl br. 50 425 ... EUR	Artikl br. 51 125 ... EUR
09T308ER 0,8				21,73 508	13,00 508	21,73 55800
09T308FR 0,8		15,76 550	18,90 650			
09T308SR 0,8	11,61 508					
Čelik	○					
Nehrđajući čelik						
Lijevano željezo	●	○	○			
Neželjezni metali		●	●			
Visokootporan na toplinu				●	●	●
Kaljeni čelik						

Priručnik za glodanje

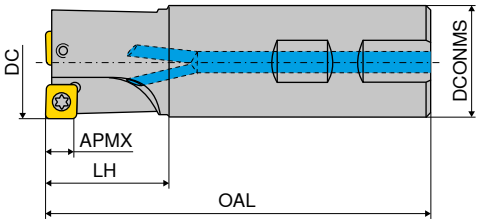
Strategija obrade	→ 157+186	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 157+186
Početni parametar	→ 157	Korekcija posmaka zuba f_z	→ 157

MaxiMill – Uvrtno glodalo G 490-12



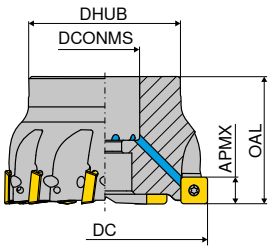
Oznaka	DC	ZNF	APMX	LPR	THSZMS	DCONMS	DRVS	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 726 ...	
	mm		mm	mm		mm	mm	Nm		EUR	
G490.32.R.03-12	32	3	10,7	35	M16	17	24	3,2	SD.. 1205..	317,80	13200
G490.40.R.04-12	40	4	10,7	40	M16	17	24	3,2	SD.. 1205..	351,10	14000

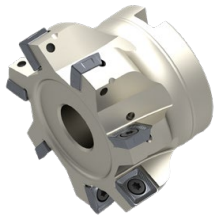
MaxiMill – Vretenasto glodalo C 490-12



Oznaka	DC	ZNF	APMX	DCONMS	OAL	LH	Pritezni moment	Okretna pločica	2B Artikl br. 50 703 ...	
	mm		mm	mm	mm	mm	Nm		EUR	
C490.32.R.02	32	2	11	32	110	40	5	SD.. 1205..	210,70	032
C490.32.R.03-12-B-40	32	3	11	32	101	40	5	SD.. 1205..	317,80	13200
C490.40.R.03	40	3	11	32	115	45	5	SD.. 1205..	248,50	040
C490.40.R.04-12-B32-50	40	4	11	32	112	50	5	SD.. 1205..	351,10	14000

MaxiMill – Utično glodalo A 490-12





Oznaka	DC	ZNF	APMX	DHUB	DCONMS	OAL	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 703 ...	
	mm		mm	mm	mm	mm	Nm		EUR	
A490.40.R.04-12	40	4	11	38	16	40	5	SD.. 1205..	351,10	54000
A490.50.R.05-12	50	5	11	43	22	40	5	SD.. 1205..	389,90	550
A490.63.R.06-12	63	6	11	48	22	40	5	SD.. 1205..	428,90	563
A490.80.R.07-12	80	7	11	58	27	50	5	SD.. 1205..	592,30	580
A490.100.R.08-12	100	8	11	75	32	50	5	SD.. 1205..	650,60	600
A490.125.R.10-12	125	10	11	88	40	63	5	SD.. 1205..	697,30	625

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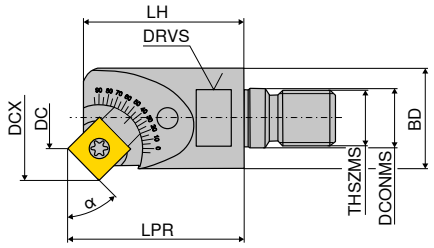
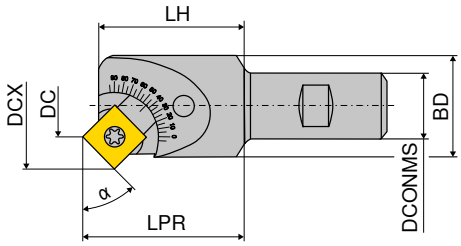
Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 T-stezni ključ Artikl br. 80 397 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Vodeći vijak Artikl br. 70 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
32 - 40	4,76	037			9,95	114			4,38	303	2,52	280	131,90	193
50 - 125	4,76	037	3,91	040	9,95	114	12,48	151	4,38	303	2,52	280	131,90	193

Namjestivo uvrtno kutno glodalo G 4500



Oznaka	DC	DCX	ZNF	LPR	THSZMS	DCONMS	LH	BD	DRVS	Pritezni moment	Okretna pločica	2B Artikl br. 55 210 ...	
	mm	mm		mm		mm	mm	mm	mm	Nm		EUR	
G4500.20.R.01	7,1 - 31,0	30,5 - 35,45	1	48 - 50	M16	17	46	28,5	24	5	SD.. 1205..	177,20	**020**

Namjestivo kutno glodalo C 4500

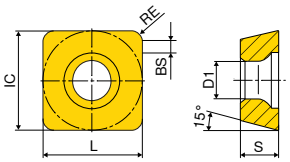


Oznaka	DC	DCX	ZNF	LPR	DCONMS	LH	BD	Pritezni moment	Okretna pločica	2B Artikl br. 50 668 ...	
	mm	mm		mm	mm	mm	mm	Nm		EUR	
C4500.20.R.01	3,7 - 27,8	27,3 - 32,2	1	35,9 - 40,5	20	37	25	5	SD.. 1205..	159,40	**020**

	2A		2A		Y7		Y7		2A/28		2A		Y7	
	Vijak s cilindričnom glavom		Klin za namještanje		TORX®– Izmjenjiva oštrica		D-ključ		Pasta Molykote		Stezni vijak		Momentni odvijač	
Rezervni dijelovi	**Artikl br. 70 950 ...**		**Artikl br. 70 950 ...**		**Artikl br. 80 950 ...**		**Artikl br. 80 950 ...**		**Artikl br. 70 950 ...**		**Artikl br. 70 950 ...**		**Artikl br. 80 950 ...**	
Okretna pločica	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
SD.. 1205..	4,29	**706**	13,94	**705**	4,76	**037**	9,95	**114**	4,38	**303**	2,52	**280**	131,90	**193**

SDHW / SDMT / SDHT

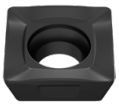
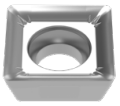
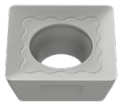
Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
SDH. 120508..	12,7	5,5	12,7	2,2	5,00
SDHT 120512..	12,7	5,5	12,7	1,8	5,00
SDHT 120520..	12,7	5,5	12,7	1,0	5,00
SDHT 120525..	12,7	5,5	12,7	1,5	5,00
SDMT 120508..	12,7	5,5	12,7	3,0	5,00
SDMT 1205ZZ..	12,7	5,5	12,7	0,9	5,00



SDHW / SDMT / SDHT

	TCM10	-29 CTCP230	-29 CTPP235	-29 CTPM240	-33 CTPM240	-F50 CTPM245
	CWC10	-29 DCX1230	-29 DPX1235	-29 DPX2240	-33 DPX2240	-F50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	CERMET SDHW	SDMT	SDMT	SDMT	SDHT	SDMT
	1B/79	1B/61	1B/61	1B/61	1B/61	1H/17
ISO / RE mm	Artikl br. 50 428 ... EUR	Artikl br. 51 081 ... EUR	Artikl br. 51 081 ... EUR	Artikl br. 51 081 ... EUR	Artikl br. 51 028 ... EUR	Artikl br. 51 110 ... EUR
120508ER 0,8						18,43 458
120508SR 0,8	18,75 901					
120512SR 1,2					18,27 412	
120520SR 2,0					18,27 421	
1205ZZSN 0,8		15,76 020	15,76 120	15,26 420		
Čelik	●	●	●	○	○	●
Nehrđajući čelik	●	○	○	●	●	●
Lijevano željezo	○					
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

SDMT / SDHT

	-31 CTCK215	-27P H216T	-27P AMZ	-M31 CTC5240	-F50 CTCS245
	-31 DCX3215	-ALP CWK26	-ALP AMZ	-M31 HCF5240	
	DRAGONSKIN			DRAGONSKIN	DRAGONSKIN
					
	SDMT	SDHT	SDHT	SDMT	SDMT
	1B/61	1A/90	1A/90	1H/D4	NEW 1H/D4
ISO / RE mm	Artikl br. 51 059 ... EUR	Artikl br. 50 426 ... EUR	Artikl br. 50 426 ... EUR	Artikl br. 50 580 ... EUR	Artikl br. 51 110 ... EUR
120508ER 0,8				18,43 508	18,43 55800
120508FR 0,8		18,27 555	22,64 655		
120525FR 2,5		18,27 559			
1205ZZSN 0,8	15,26 521				
Čelik	○				
Nehrđajući čelik					
Lijevano željezo	●	○	○		
Neželjezni metali		●	●		
Visokootporan na toplinu				●	●
Kaljeni čelik					

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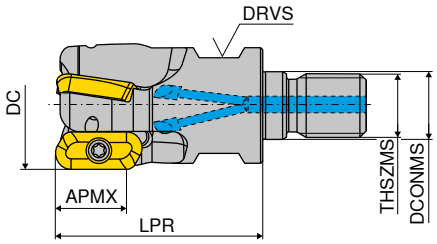
Priručnik za glodanje

Strategija obrade	→ 158+186	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 158+186
Početni parametar	→ 158		

MaxiMill – Uvrtno glodalo 90° G HSC-11

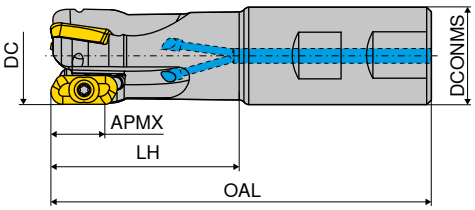
▲ Radijus okretnih pločica > 3,2 mm: Modificiranje osnovnog tijela



Oznaka	DC	ZNF	APMX	DCONMS	LPR	THSZMS	RPMX	DRVS	Pritezni moment	Okretna pločica	2B/40 Artikl br. 55 107 ... EUR	
	mm		mm	mm	mm		1/min.	mm	Nm			
GHSC.16.R.02-11	16	2	10	8,5	27	M8	56000	10	1,8	XDHT 11T3..	267,90	**016**
GHSC.18.R.02-11	18	2	10	8,5	27	M8	53100	10	1,8	XDHT 11T3..	274,30	**018**
GHSC.20.R.02-11	20	2	10	10,5	33	M10	50100	15	1,8	XDHT 11T3..	288,40	**020**
GHSC.25.R.03-11	25	3	10	12,5	35	M12	45000	17	1,8	XDHT 11T3..	324,90	**025**
GHSC.32.R.03-11	32	3	10	17,0	35	M16	39800	24	1,8	XDHT 11T3..	337,70	**032**
GHSC.40.R.03-11	40	3	10	17,0	35	M16	35500	24	1,8	XDHT 11T3..	354,50	**040**

MaxiMill – Vretenasto glodalo 90° C HSC-11

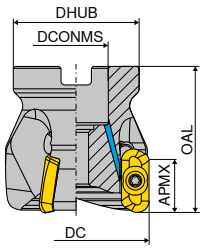
▲ Radijus okretnih pločica > 3,2 mm: Modificiranje osnovnog tijela



Oznaka	DC	ZNF	APMX	DCONMS $_{h6}$	OAL	LH	RPMX	Pritezni moment	Okretna pločica	A 2B/40 Artikl br. 50 675 ... EUR		B 2B/40 Artikl br. 50 675 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm					
CHSC.16.R.02-11-B/A-25	16	2	10	16	75	25	56200	1,8	XDHT 11T3..	267,90	**016**	267,90	**416**
CHSC.16.R.02-11-A-32	16	2	10	16	165	32	18800	1,8	XDHT 11T3..	267,90	**116**		
CHSC.18.R.02-11-A-25	18	2	10	20	78	25	56100	1,8	XDHT 11T3..	274,30	**018**		
CHSC.18.R.02-11-A-32	18	2	10	20	165	32	23900	1,8	XDHT 11T3..	274,30	**118**		
CHSC.19.R.02-11-A-25	19	2	10	20	78	25	51700	1,8	XDHT 11T3..	280,70	**019**		
CHSC.19.R.02-11-A-32	19	2	10	20	165	32	25400	1,8	XDHT 11T3..	280,70	**119**		
CHSC.20.R.02-11-A-32	20	2	10	20	84	32	50100	1,8	XDHT 11T3..	288,40	**020**		
CHSC.20.R.03-11-B-32	20	3	10	20	84	32	50100	1,8	XDHT 11T3..			327,20	**420**
CHSC.20.R.02-11-A-40	20	2	10	20	165	40	26700	1,8	XDHT 11T3..	288,40	**120**		
CHSC.22.R.02-11-A-32	22	2	10	25	91	32	47800	1,8	XDHT 11T3..	296,40	**022**		
CHSC.22.R.02-11-A-40	22	2	10	25	165	40	30200	1,8	XDHT 11T3..	296,40	**122**		
CHSC.25.R.02-11-A-40	25	2	10	25	98	40	45000	1,8	XDHT 11T3..	310,40	**025**		
CHSC.25.R.03-11-A-40	25	3	10	25	98	40	45000	1,8	XDHT 11T3..	324,90	**225**		
CHSC.25.R.04-11-B-40	25	4	10	25	98	40	45000	1,8	XDHT 11T3..			357,10	**425**
CHSC.25.R.02-11-A-50	25	2	10	25	165	50	31700	1,8	XDHT 11T3..	310,40	**125**		
CHSC.25.R.03-11-A-50	25	3	10	25	165	50	31700	1,8	XDHT 11T3..	324,90	**325**		
CHSC.32.R.03-11-A-50	32	3	10	32	112	50	39800	1,8	XDHT 11T3..	337,70	**032**		
CHSC.32.R.05-11-B-50	32	5	10	25	112	50	39800	1,8	XDHT 11T3..			426,90	**432**
CHSC.32.R.03-11-A-63	32	3	10	32	165	63	33400	1,8	XDHT 11T3..	337,70	**132**		

MaxiMill – Utično glodalo 90° A HSC-11

▲ Radijus okretnih pločica > 3,2 mm: Modificiranje osnovnog tijela

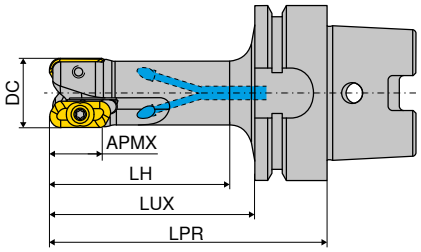


Oznaka	DC	ZNF	APMX	DCONMS $_{H6}$	DHUB	OAL	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 718 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
AHSC.40.R.04-11	40	4	10	16	38	50	35500	1,8	XDHT 11T3..	451,40	**040**
AHSC.50.R.04-11	50	4	10	22	43	50	31800	1,8	XDHT 11T3..	546,00	**050**
AHSC.63.R.05-11	63	5	10	22	43	50	28300	1,8	XDHT 11T3..	608,00	**063**
AHSC.80.R.05-11	80	5	10	27	58	50	25100	1,8	XDHT 11T3..	632,50	**080**
AHSC.100.R.05-11	100	5	10	32	78	50	22400	1,8	XDHT 11T3..	677,90	**100**

MaxiMill – Glodalo 90° M HSC-11 s HSK 63-A

▲ Izbalansirano G 6,3

▲ Radijus okretnih pločica > 3,2 mm: Modificiranje osnovnog tijela



Oznaka	DC	ZNF	APMX	LPR	LH	LUX	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 722 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
MHSC.25.R.03-11-H63A-50	25	3	10	90	50	64	45000	1,8	XDHT 11T3..	774,90	**025**
MHSC.25.R.03-11-H63A-63	25	3	10	100	63	74	42000	1,8	XDHT 11T3..	774,90	**125**
MHSC.32.R.03-11-H63A-63	32	3	10	100	63	74	39800	1,8	XDHT 11T3..	787,80	**032**
MHSC.32.R.03-11-H63A-80	32	3	10	120	80	94	37200	1,8	XDHT 11T3..	787,80	**132**
MHSC.40.R.04-11-H63A-63	40	4	10	100	63	74	35500	1,8	XDHT 11T3..	817,60	**040**
MHSC.40.R.04-11-H63A-80	40	4	10	120	80	94	35500	1,8	XDHT 11T3..	817,60	**140**
MHSC.50.R.04-11-H63A-63	50	4	10	100	63	74	31800	1,8	XDHT 11T3..	831,70	**050**
MHSC.50.R.04-11-H63A-100	50	4	10	140	100	114	31800	1,8	XDHT 11T3..	831,70	**150**

Rezervni dijelovi DC	Y7 TORX®-Izmjenjiva oštrica		Y7 T-stezni ključ		Y7 D-ključ		2A/28 Vodeći vijak		2A/28 Pasta Molykote		2A/28 Stezni vijak		Y7 Momentni odvijač	
	Artikl br. 80 950 ...		Artikl br. 80 397 ...		Artikl br. 80 950 ...		Artikl br. 70 950 ...		Artikl br. 70 950 ...		Artikl br. 70 950 ...		Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
16 - 25	4,76	**043**			10,20	**125**			4,38	**303**	4,09	**128**	128,60	**192**
32	4,76	**043**			10,20	**125**			4,38	**303**	4,09	**131**	128,60	**192**
40	4,76	**043**	3,91	**040**	10,20	**125**	12,48	**151**	4,38	**303**	4,09	**131**	128,60	**192**
50 - 63	4,76	**043**	4,24	**050**	10,20	**125**	17,14	**154**	4,38	**303**	4,09	**131**	128,60	**192**
80 - 100	4,76	**043**			10,20	**125**			4,38	**303**	4,09	**131**	128,60	**192**

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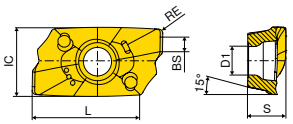
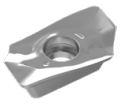
XDKT / XDHT

Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XD.T 11T302FR	6,8	2,8	10,6	2	3,80
XD.T 11T304FR	6,8	2,8	10,6	1,8	3,80
XD.T 11T308FR	6,8	2,8	10,6	1,4	3,80
XD.T 11T320FR	6,8	2,8	10,6	1,4	3,80
XD.T 11T325FR	6,8	2,8	10,6	1,4	3,80
XDHT 11T312FR	6,8	2,8	10,6	1,4	3,80
XDHT 11T316FR	6,8	2,8	10,6	1,4	3,80
XDHT 11T332FR	6,8	2,8	10,6	0,8	3,80
XDHT 11T340FR	6,8	2,8	10,6	-	3,80
XDHT 11T350FR	6,8	2,8	10,6	-	3,80



XDKT

XDKT / XDHT

		-F20 CTWN215		-27P H216T	
		-F20 CWK4615		-ALP CWK26	
					
		XDKT		XDHT	
		1A/90		1A/90	
ISO	RE	**Artikl br. 50 478 ...**		**Artikl br. 50 477 ...**	
	mm	EUR		EUR	
11T302FR	0,2	17,67	**502**	26,63	**502**
11T304FR	0,4	17,67	**504**	26,63	**504**
11T308FR	0,8	17,67	**508**	26,63	**508**
11T312FR	1,2			26,63	**512**
11T316FR	1,6			26,63	**516**
11T320FR	2,0	17,67	**520** 1)	26,63	**520** 1)
11T325FR	2,5	17,67	**525** 1)	26,63	**525** 1)
11T332FR	3,2			26,63	**532** 1)
11T340FR	4,0			26,63	**540** 1)
11T350FR	5,0			26,63	**550** 1)
Čelik					
Nehrđajući čelik					
Lijevano željezo			○		○
Neželjezni metali			●		●
Visokootporan na toplinu					
Kaljeni čelik					

1) Radijus okretnih pločica > 1,6 mm: Modificiranje osnovnog tijela

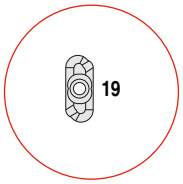
Priručnik za glodanje

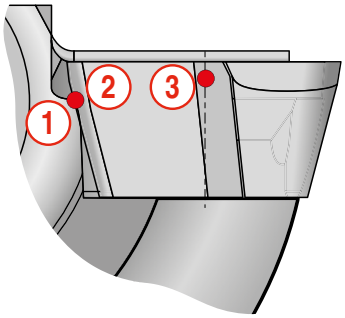
Strategija obrade	→ 161–165	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 160+163
Sigurnosne napomene	→ 159		

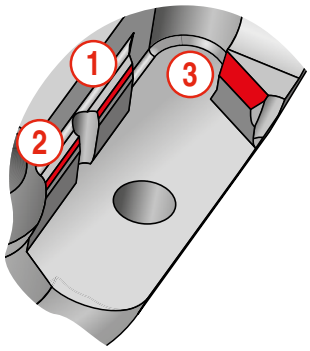
MaxiMill HSC-19

Za srednji do veći broj okretaja pri primjeni

$n_{maks.}$ = 34.400 min^{-1}
$a_{p\,max}$ = 18 mm







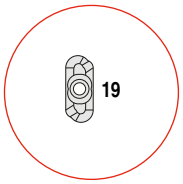
(1) (2) Radijalne kontaktne točke
- ▲ Jamče 90° kut ugla i točnu koncentričnost

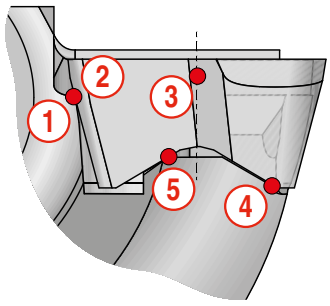
(3) Aksijalna kontaktna točka
- ▲ Jamči precizan aksijalni hod

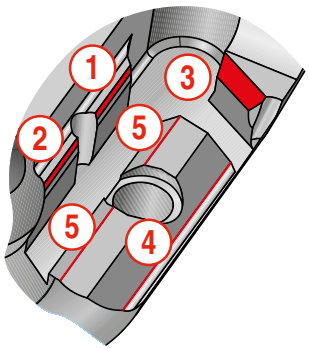
MaxiMill HPC-19

Za najveći broj okretaja pri primjeni

$n_{maks.}$ = 45.200 min^{-1}
$a_{p\,max}$ = 18 mm







Površina krova s kutom otvaranja od 140°
- ▲ Veća stabilnost, veća sigurnost
- ▲ Jamči pozitivno podudaranje između okretnih reznih pločica i alata

(1) (2) Radijalne kontaktne točke
- ▲ Jamče 90° kut ugla i točnu koncentričnost

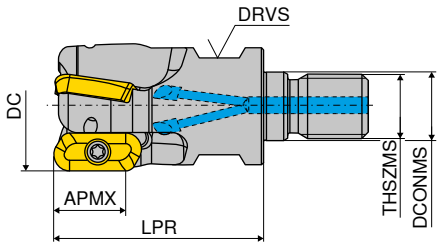
(3) Aksijalna kontaktna točka
- ▲ Jamči precizan aksijalni hod

(4) (5) Kontaktne točke
- ▲ Prihvat sile rezanja odn. centrifugalne sile

15

MaxiMill – Uvrtno glodalo 90° G HSC-19

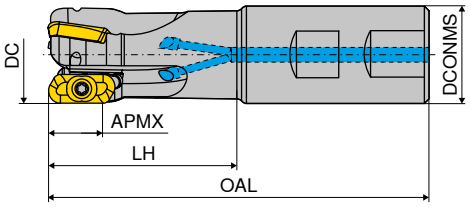
▲ Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela



Oznaka	DC	ZNF	APMX	DCONMS	LPR	THSZMS	DRVS	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 55 108 ...	
	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
GHSC.25.R.02-19	25	2	18	12,5	45	M12	17	34400	5	XDHT 1904..	315,60	**025**
GHSC.32.R.03-19	32	3	18	17,0	52	M16	24	29100	5	XDHT 1904..	408,80	**032**
GHSC.40.R.03-19	40	3	18	17,0	52	M16	24	24900	5	XDHT 1904..	434,70	**040**

MaxiMill – Vretenasto glodalo 90° C HSC-19

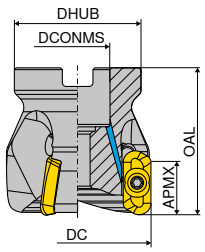
▲ Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela

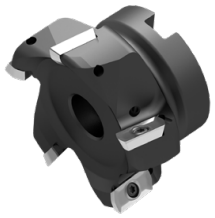


Oznaka	DC	ZNF	APMX	DCONMS $_{h5}$	OAL	LH	RPMX	Pritezni moment	Okretna pločica	A 2B/40 Artikl br. 50 679 ...		B 2B/40 Artikl br. 50 679 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
CHSC.25.R.02-19-A-50	25	2	18	25	121	50	32400	5	XDHT 1904..	315,60	**225**		
CHSC.25.R.02-19	25	2	18	25	121	65	32400	5	XDHT 1904..			324,90	**025**
CHSC.25.R.02-19-A-63	25	2	18	25	165	63	24700	5	XDHT 1904..	315,60	**325**		
CHSC.32.R.02-19-A-63	32	2	18	32	125	63	28900	5	XDHT 1904..	331,20	**232**		
CHSC.32.R.03-19-A-63	32	3	18	32	125	63	28900	5	XDHT 1904..	408,80	**432**		
CHSC.32.R.03-19	32	3	18	32	125	65	28900	5	XDHT 1904..			416,50	**033**
CHSC.32.R.02-19	32	2	18	32	125	65	28900	5	XDHT 1904..			338,90	**032**
CHSC.32.R.02-19-A-80	32	2	18	32	165	80	24400	5	XDHT 1904..	331,20	**332**		
CHSC.32.R.03-19-A-80	32	3	18	32	165	80	24400	5	XDHT 1904..	408,80	**532**		

MaxiMill – Utično glodalo 90° A HSC-19

▲ Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela



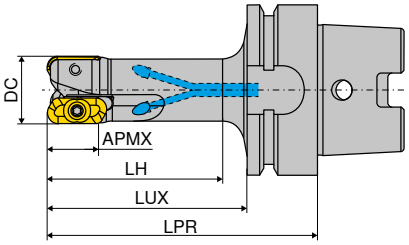


Oznaka	DC	ZNF	APMX	DCONMS $_{H6}$	DHUB	OAL	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 716 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
AHSC.40.R.03-19	40	3	18	16	38	50	24900	5	XDHT 1904..	423,00	**040**
AHSC.50.R.04-19	50	4	18	22	43	50	21600	5	XDHT 1904..	531,60	**050**
AHSC.63.R.04-19	63	4	18	22	48	50	18800	5	XDHT 1904..	595,10	**163**
AHSC.63.R.05-19	63	5	18	22	48	50	18800	5	XDHT 1904..	608,00	**063**
AHSC.80.R.04-19	80	4	18	27	58	50	16400	5	XDHT 1904..	618,30	**180**
AHSC.80.R.05-19	80	5	18	27	58	50	16400	5	XDHT 1904..	632,50	**080**
AHSC.100.R.04-19	100	4	18	32	78	50	14500	5	XDHT 1904..	663,70	**200**
AHSC.100.R.05-19	100	5	18	32	78	50	14500	5	XDHT 1904..	677,90	**100**
AHSC.125.R.05-19	125	5	18	40	88	63	12800	5	XDHT 1904..	783,80	**125**
AHSC.125.R.06-19	125	6	18	40	88	63	12800	5	XDHT 1904..	796,80	**225**

MaxiMill – Glodalo 90° M HSC-19 s HSK 63-A

▲ Izbalansirano G 6,3

▲ Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela



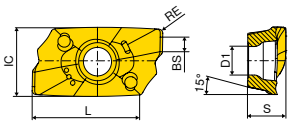
Oznaka	DC	ZNF	APMX	LPR	LH	LUX	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 720 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
MHSC.25.R.02-19-H63A-50	25	2	18	90	50	64	35000	5	XDHT 1904..	763,20	**525**
MHSC.25.R.02-19-H63A-63	25	2	18	100	63	74	32700	5	XDHT 1904..	763,20	**625**
MHSC.32.R.02-19-H63A-63	32	2	18	100	63	74	29100	5	XDHT 1904..	778,90	**532**
MHSC.32.R.02-19-H63A-80	32	2	18	120	80	94	27200	5	XDHT 1904..	778,90	**632**
MHSC.32.R.03-19-H63A-63	32	3	18	100	63	74	29100	5	XDHT 1904..	791,80	**732**
MHSC.32.R.03-19-H63A-80	32	3	18	120	80	94	27200	5	XDHT 1904..	791,80	**832**
MHSC.40.R.03-19-H63A-63	40	3	18	100	63	74	24900	5	XDHT 1904..	807,30	**540**
MHSC.40.R.03-19-H63A-80	40	3	18	120	80	94	24900	5	XDHT 1904..	807,30	**640**
MHSC.50.R.03-19-H63A-100	50	3	18	140	100	114	21600	5	XDHT 1904..	807,30	**550**

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 T-stezni ključ Artikl br. 80 397 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Vodeći vijak Artikl br. 70 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A/28 Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
25	4,76	**036**			9,28	**113**			4,38	**303**	2,86	**172**	131,90	**193**
32	4,76	**036**			9,28	**113**			4,38	**303**	3,40	**173**	131,90	**193**
40	4,76	**036**	3,91	**040**	9,28	**113**	12,48	**151**	4,38	**303**	3,40	**173**	131,90	**193**
50 - 63	4,76	**036**	4,24	**050**	9,28	**113**	17,14	**154**	4,38	**303**	3,40	**174**	131,90	**193**
80 - 125	4,76	**036**			9,28	**113**			4,38	**303**	3,40	**174**	131,90	**193**

15

XDHT

Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDHT 190402..	9,52	4,65	19	2	4,76
XDHT 190404..	9,52	4,65	19	2	4,76
XDHT 190408..	9,52	4,65	19	2	4,76
XDHT 190412..	9,52	4,65	19	2	4,76
XDHT 190416..	9,52	4,65	19	2	4,76
XDHT 190420..	9,52	4,65	19	2	4,76
XDHT 190425..	9,52	4,65	19	1,4	4,76
XDHT 190432..	9,52	4,65	19	1	4,76
XDHT 190440..	9,52	4,65	19	1	4,76
XDHT 190450..	9,52	4,65	19	-	4,76

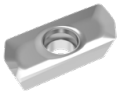


XDKT

XDHT

-27P
H216T

-ALP
CWK26


XDHT

ISO	RE	1A/90 Artikl br. 50 487 ... EUR	
	mm		
190402FR	0,2	27,36	**552**
190404FR	0,4	27,36	**554**
190408FR	0,8	27,36	**556**
190412FR	1,2	27,36	**557**
190416FR	1,6	27,36	**558**
190420FR	2,0	27,36	**560**
190425FR	2,5	27,36	**562**
190432FR	3,2	27,36	**564**
190440FR	4,0	27,36	**566**
190450FR	5,0	27,36	**568** 1)

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

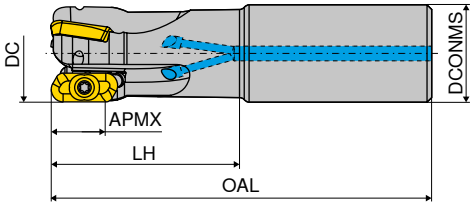
1) Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela

Priručnik za glodanje

Strategija obrade	→ 161–165	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 160+163
Sigurnosne napomene	→ 159		

MaxiMill – Vretenasto glodalo 90° C HPC-19

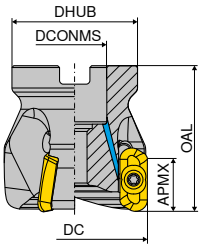
▲ Izvedba drška DIN 1835-A
▲ Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela



Oznaka	DC mm	ZNF	APMX mm	DCONMS $_{h5}$ mm	OAL mm	LH mm	RPMX 1/min.	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 680 ... EUR	
CHPC.22.R.02-19-A-40	22	2	18	22	165	40	31900	5	XDHX 1904..	380,20	**122**
CHPC.25.R.02-19-A-50	25	2	18	25	121	50	41800	5	XDHX 1904..	393,30	**125**
CHPC.25.R.02-19-A-63	25	2	18	25	165	63	31900	5	XDHX 1904..	393,30	**225**
CHPC.32.R.02-19-A-63	32	2	18	32	125	63	39800	5	XDHX 1904..	408,80	**132**
CHPC.32.R.02-19-A-80	32	2	18	32	165	80	33500	5	XDHX 1904..	408,80	**232**
CHPC.32.R.03-19-A-63	32	3	18	32	125	63	39800	5	XDHX 1904..	485,10	**332**
CHPC.32.R.03-19-A-80	32	3	18	32	165	80	33500	5	XDHX 1904..	485,10	**432**

MaxiMill – Utično glodalo 90° A HPC-19

▲ Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela



Oznaka	DC mm	ZNF	APMX mm	DCONMS $_{H6}$ mm	DHUB mm	OAL mm	RPMX 1/min.	Pritezni moment Nm	Okretna pločica	2B/40 Artikl br. 50 717 ... EUR	
AHPC.40.R.03-19	40	3	18	16	38	50	35700	5	XDHX 1904..	494,20	**040**
AHPC.50.R.03-19	50	3	18	22	43	50	31900	5	XDHX 1904..	514,80	**050**
AHPC.63.R.03-19	63	3	18	22	48	50	28500	5	XDHX 1904..	539,50	**063**
AHPC.63.R.04-19	63	4	18	22	48	50	28500	5	XDHX 1904..	553,70	**163**

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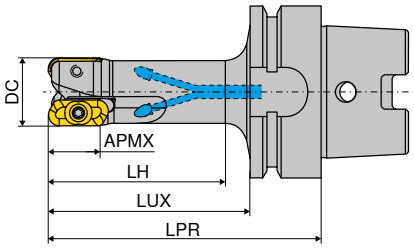
MaxiMill – Glodalo 90° M HPC-19 s HSK 63-A

- Izbalansirano G 6,3
- Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela

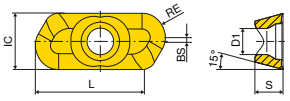


Oznaka	DC	ZNF	APMX	LPR	LH	LUX	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 721 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
MHPC.25.R.02-19-H63A-50	25	2	18	90	50	64	45200	5	XDHX 1904..	984,40	**025**
MHPC.25.R.02-19-H63A-63	25	2	18	100	63	74	42300	5	XDHX 1904..	984,40	**125**
MHPC.25.R.02-19-H63A-80	25	2	18	120	80	94	38400	5	XDHX 1904..	984,40	**225**
MHPC.25.R.02-19-H63A-100	25	2	18	140	100	114	33900	5	XDHX 1904..	984,40	**325**
MHPC.32.R.02-19-H63A-63	32	2	18	100	63	74	40000	5	XDHX 1904..	1.001,00	**032**
MHPC.32.R.03-19-H63A-63	32	3	18	100	63	74	40000	5	XDHX 1904..	1.105,00	**532**
MHPC.32.R.02-19-H63A-80	32	2	18	120	80	94	37500	5	XDHX 1904..	1.001,00	**132**
MHPC.32.R.03-19-H63A-80	32	3	18	120	80	94	37500	5	XDHX 1904..	1.105,00	**632**
MHPC.32.R.02-19-H63A-100	32	2	18	140	100	114	34300	5	XDHX 1904..	1.001,00	**232**
MHPC.40.R.03-19-H63A-63	40	3	18	100	63	74	35700	5	XDHX 1904..	1.136,00	**040**
MHPC.40.R.03-19-H63A-80	40	3	18	120	80	94	35700	5	XDHX 1904..	1.136,00	**140**
MHPC.40.R.03-19-H63A-100	40	3	18	140	100	114	33500	5	XDHX 1904..	1.136,00	**240**
MHPC.50.R.03-19-H63A-63	50	3	18	100	63	74	31900	5	XDHX 1904..	1.155,00	**050**
MHPC.50.R.03-19-H63A-80	50	3	18	120	80	94	31900	5	XDHX 1904..	1.155,00	**150**
MHPC.50.R.03-19-H63A-100	50	3	18	140	100	114	31900	5	XDHX 1904..	1.155,00	**250**

Rezervni dijelovi DC	Y7 TORX®-Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 T-stezni ključ Artikl br. 80 397 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Vodeći vijak Artikl br. 70 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A/28 Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
22 - 25	4,76	**036**			9,28	**113**			4,38	**303**	2,86	**172**	131,90	**193**
32	4,76	**036**			9,28	**113**			4,38	**303**	3,40	**173**	131,90	**193**
40	4,76	**036**	3,91	**040**	9,28	**113**	12,48	**151**	4,38	**303**	3,40	**173**	131,90	**193**
50 - 63	4,76	**036**	4,24	**050**	9,28	**113**	17,14	**154**	4,38	**303**	3,40	**174**	131,90	**193**

XDHX

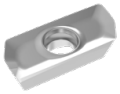
Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDHX 190402..	9,52	4,65	19	2	4,76
XDHX 190404..	9,52	4,65	19	2	4,76
XDHX 190408..	9,52	4,65	19	2	4,76
XDHX 190412..	9,52	4,65	19	2	4,76
XDHX 190416..	9,52	4,65	19	2	4,76
XDHX 190420..	9,52	4,65	19	2	4,76
XDHX 190425..	9,52	4,65	19	1,4	4,76
XDHX 190432..	9,52	4,65	19	1	4,76
XDHX 190440..	9,52	4,65	19	1	4,76
XDHX 190450..	9,52	4,65	19	-	4,76



XDHX

-27P
H216T

-ALP
CWK26



XDHX
1H/D4

ISO	RE	Artikl br. 50 488 ...	
	mm	EUR	
190402FR	0,2	35,72	**552**
190404FR	0,4	35,72	**554**
190408FR	0,8	35,72	**556**
190412FR	1,2	35,72	**557**
190416FR	1,6	35,72	**558**
190420FR	2,0	35,72	**560**
190425FR	2,5	35,72	**562**
190432FR	3,2	35,72	**564**
190440FR	4,0	35,72	**566**
190450FR	5,0	35,72	**568** 1)

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

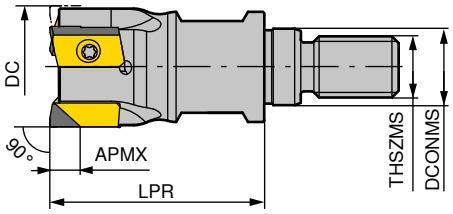
1) Radijus okretnih pločica > 4,0 mm: Modificiranje osnovnog tijela

Priručnik za glodanje

Strategija obrade	→ 163–165	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 163
Sigurnosne napomene	→ 159		

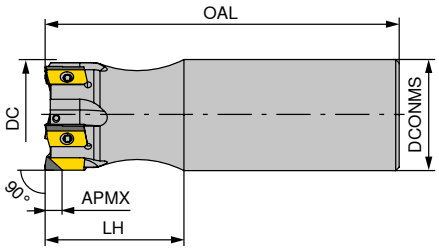
15

MaxiMill – Uvrtno glodalo G HPC 04



Oznaka	DC	ZNF	APMX	THSZMS	DCONMS	LPR	RPMX	Pritezni moment	Okretna pločica	NEW 2B/40 Artikl br. 50 785 ... EUR	
	mm		mm		mm	mm	1/min.	Nm			
GHPC.20.R.03-04	20	3	4	M10	10,5	35	52000	5	ZNHW 04T3..	261,70	**20003**
GHPC.25.R.04-04	25	4	4	M12	12,5	35	45000	5	ZNHW 04T3..	292,90	**25004**
GHPC.32.R.05-04	32	5	4	M16	17,0	35	38000	5	ZNHW 04T3..	324,10	**32005**
GHPC.40.R.06-04	40	6	4	M16	17,0	35	34000	5	ZNHW 04T3..	355,10	**40006**

MaxiMill – Vretenasto glodalo C HPC 04



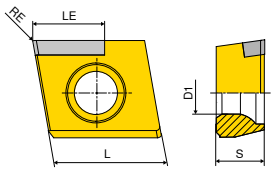
A

Oznaka	DC	ZNF	APMX	DCONMS	OAL	LH	RPMX	Pritezni moment	Okretna pločica	NEW 2B/40 Artikl br. 50 680 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm			
CHPC.20.R.03-04-A-25	20	3	4	20	77	25	52000	5	ZNHW 04T3..	261,70	**02003**
CHPC.25.R.04-04-A-32	25	4	4	25	90	32	45000	5	ZNHW 04T3..	292,90	**02504**
CHPC.32.R.05-04-A-40	32	5	4	32	102	40	38000	5	ZNHW 04T3..	324,10	**03205**
CHPC.40.R.06-04-A-50	40	6	4	32	112	50	34000	5	ZNHW 04T3..	355,10	**04006**

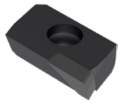
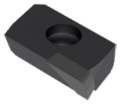
	Y7	Y7	2A/28	2A/28	Y7
	TORX®– Izmjenjiva oštrica	D-ključ	Pasta Molykote	Stezni vijak	Momentni odvijač
Rezervni dijelovi DC	Artikl br. 80 950 ... EUR	Artikl br. 80 950 ... EUR	Artikl br. 70 950 ... EUR	Artikl br. 70 950 ... EUR	Artikl br. 80 950 ... EUR
20 - 40	4,76 **043**	10,20 **125**	4,38 **303**	4,09 **131**	118,90 **191**

ZNHW

Oznaka	LE	D1	L	S
	mm	mm	mm	mm
ZNHW 04T3..	4	2,8	11	3,97
ZNHW 04T3..	4	2,8	11	3,97
ZNHW 04T3..	4	2,8	11	3,97
ZNHW 04T3..	4	2,8	11	3,97



ZNHW

ISO	RE	CTD4205 DIAMOND ZNHW NEW 1G/22 Artikl br. 51 137 ...		CTL3215 CWB3215 CBN ZNHW NEW 1G/21 Artikl br. 51 137 ...	
	mm	EUR		EUR	
04T304ER	0,4	105,00	75400		
04T305ER	0,5			126,80	85500
04T308ER	0,8	105,00	75800		
04T3POER		105,00	77000		
Čelik					
Nehrđajući čelik					
Lijevano željezo					●
Neželjezni metali			●		
Visokootporan na toplinu					
Kaljeni čelik					○

Priručnik za glodanje

Strategija obrade	→ 166	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 166

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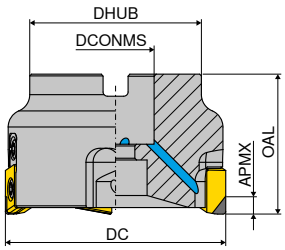
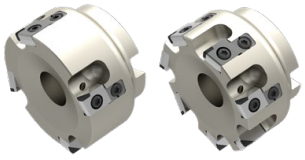
MaxiMill – Utično glodalo HPC 12

▲ 50 723 ... normalna podjela zubiju
▲ 50 724 ... uska podjela zubiju

Opseg isporuke:

Alat, klin za podešavanje i ključ za podešavanje uklj. drvenu kutiju





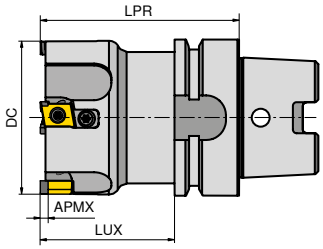
Oznaka	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 723 ...		2B/40 Artikl br. 50 724 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
AHPC.40.R.04-12	40	4	11	40	34	16	32000	5	ZNHW 1205..	652,90	**040**		
AHPC.50.R.04-12	50	4	11	40	49	22	32000	5	ZNHW 1205..	667,90	**050**		
AHPC.50.R.05-12	50	5	11	40	49	22	32000	5	ZNHW 1205..			747,90	**050**
AHPC.63.R.04-12	63	4	11	40	49	22	29000	5	ZNHW 1205..	688,00	**063**		
AHPC.63.R.07-12	63	7	11	40	49	22	29000	5	ZNHW 1205..			927,20	**063**
AHPC.80.R.09-12	80	9	11	50	60	27	26000	5	ZNHW 1205..			1.290,00	**080**
AHPC.80.R.05-12	80	5	11	50	60	27	26000	5	ZNHW 1205..	972,20	**080**		
AHPC.100.R.06-12	100	6	11	50	70	32	24000	5	ZNHW 1205..	1.097,00	**100**		
AHPC.100.R.12-12	100	12	11	50	70	32	24000	5	ZNHW 1205..			1.574,00	**100**
AHPC.125.R.08-12	125	8	11	63	72	40	22000	5	ZNHW 1205..	1.301,00	**125**		
AHPC.125.R.14-12	125	14	11	63	72	40	22000	5	ZNHW 1205..			1.779,00	**12514**
AHPC.160.R.10-12	160	10	11	63	118	40	18000	5	ZNHW 1205..	1.620,00	**16010**		
AHPC.160.R.16-12	160	16	11	63	118	40	18000	5	ZNHW 1205..			4.665,00	**16016**
AHPC.200.R.12-12	200	12	11	63	153	60	16000	5	ZNHW 1205..	4.832,00	**20000**		
AHPC.250.R.14-12	250	14	11	63	200	60	14000	5	ZNHW 1205..	5.457,00	**25014**		
AHPC.315.R.18-12	315	18	11	80	265	60	12000	5	ZNHW 1205..	6.874,00	**31518**		

MaxiMill – Monoblok HPC 12

▲ Izbalansirano G 6,3

Opseg isporuke:

Alat, klin za podešavanje i ključ za podešavanje uklj. drvenu kutiju

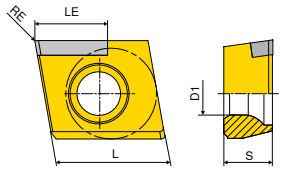


Oznaka	DC	ZNF	APMX	LPR	LUX	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 721 ...		2B/40 Artikl br. 50 721 ...	
	mm		mm	mm	mm	1/min.	Nm		EUR		EUR	
MHPC.40.R.04-12-H63A-70	40	4	11	70	44	32000	5	ZNHW 1205..			972,20	**04004**
MHPC.50.R.04-12-H63A-80	50	4	11	80	54	32000	5	ZNHW 1205..			972,20	**05004**
MHPC.50.R.05-12-H63A-80	50	5	11	80	54	32000	5	ZNHW 1205..	1.052,00	**05005**		
MHPC.63.R.04-12-H63A-80	63	4	11	80	54	29000	5	ZNHW 1205..			972,20	**06304**
MHPC.63.R.07-12-H63A-80	63	7	11	80	54	29000	5	ZNHW 1205..	1.211,00	**06307**		
MHPC.80.R.05-12-H63A-90	80	5	11	90	64	26000	5	ZNHW 1205..			1.192,00	**08005**
MHPC.80.R.09-12-H63A-90	80	9	11	90	64	26000	5	ZNHW 1205..	1.512,00	**08009**		
MHPC.100.R.06-12-H63A-90	100	6	11	90	64	24000	5	ZNHW 1205..			1.420,00	**10006**
MHPC.100.R.12-12-H63A-90	100	12	11	90	64	24000	5	ZNHW 1205..	1.900,00	**10012**		
MHPC.125.R.08-12-H63A-123	125	8	11	123	97	22000	5	ZNHW 1205..			3.355,00	**12508**
MHPC.160.R.10-12-H63A-123	160	10	11	123	97	18000	5	ZNHW 1205..			4.537,00	**16010**

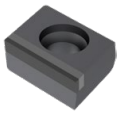
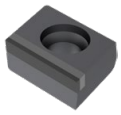
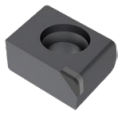
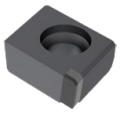
Rezervni dijelovi DC	Y7 TORX®-Izmjenjiva oštrica Artikl br. 80 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A/28 Stezni vijak Artikl br. 70 950 ...		2A/28 Klin Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR	
40 - 315	4,76	**036**	4,38	**303**	3,40	**174**	36,80	**199**	131,90	**193**

ZNHW

Oznaka	LE	D1	L	S
	mm	mm	mm	mm
ZNHW 120504ER-1503	3	4,85	12,7	5,40
ZNHW 120504FR-0007	7	4,85	12,7	5,40
ZNHW 120508ER-1503	3	4,85	12,7	5,40
ZNHW 120508SR-0003	3	4,85	12,7	5,40
ZNHW 1205EOER-1002	2	4,85	12,7	5,40
ZNHW 1205POER-1511	11	4,85	12,7	5,40
ZNHW 1205POSR-1003	3	4,85	12,7	5,40
ZNHW 1205POSR-1503	3	4,85	12,7	5,40
ZNHW 1205POSR-1506	6	4,85	12,7	5,40
ZNHW 1205POSR-3003	3	4,85	12,7	5,40
ZNHW 1205ZZSR-5003	3	4,85	12,7	5,40

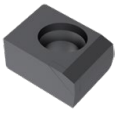


ZNHW

	CTD4205	-R CTD4205	CTD4205	-Q CTD4205
	CWD4205	CWD4205	CWD4205	-Q CWD4205
				
	DIAMOND ZNHW	DIAMOND ZNHW	DIAMOND ZNHW	DIAMOND ZNHW
	1G/22	NEW 1G/22	1G/22	1G/22
ISO	Artikl br. 50 467 ...	Artikl br. 50 517 ...	Artikl br. 50 468 ...	Artikl br. 50 466 ...
RE mm	EUR	EUR	EUR	EUR
120504ER-1503 0,4			116,10 906	
120504FR-0007 0,4			141,40 904	
120508ER-1503 0,8			116,10 910	
120508SR-0003 0,8			115,50 908	
1205POER-1511	167,30 902			
1205POSR-1003	116,10 90600			
1205POSR-1503	105,00 900			
1205POSR-1506	136,20 90800	136,20 90800		
1205POSR-3003	115,50 904			
1205ZZSR-5003				147,80 900 1)
Čelik				
Nehrđajući čelik				
Lijevano željezo				
Neželjezni metali	●	●	●	●
Visokootporan na toplinu				
Kaljeni čelik				

1) -Q = pločica za široko završno glodanje

ZNHW

	CTL3215
	CWB3215
	
	CBN ZNHW
	1G/21
ISO	Artikl br. 50 515 ...
	EUR
1205EOER-1002	133,90 952
Čelik	
Nehrđajući čelik	
Lijevano željezo	●
Neželjezni metali	
Visokootporan na toplinu	
Kaljeni čelik	○

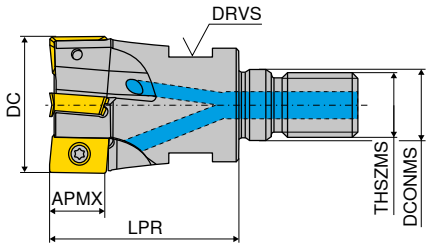
Priručnik za glodanje

Strategija obrade	→ 166+167
Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210
Referentne vrijednosti podataka o rezanju	→ 166

15

MaxiMill – Uvrtno glodalo G 141

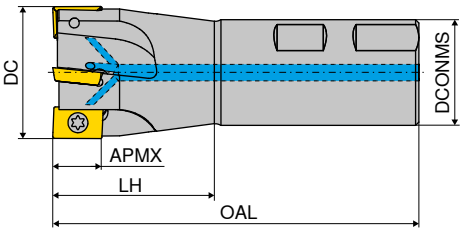
▲ Radijus okretnih pločica > 3,2 mm: Modificiranje osnovnog tijela



Oznaka	DC	ZNF	APMX	LPR	THSZMS	DCONMS	DRVS	Pritezni moment	Okretna pločica	2B Artikl br. 50 770 ...	
	mm		mm	mm		mm	mm	Nm		EUR	
G141.25.R.02.IK	25	2	14	35	M12	12,5	17	3,2	LD.. 1504..	166,70	**025**
G141.32.R.03.IK	32	3	14	40	M16	17,0	24	3,2	LD.. 1504..	200,20	**032**
G141.40.R.04.IK	40	4	14	40	M16	17,0	24	3,2	LD.. 1504..	230,70	**040**

MaxiMill – Vretenasto glodalo C 141

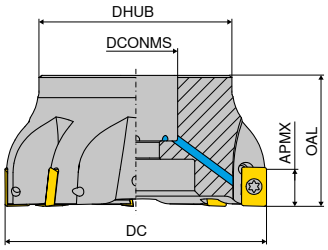
▲ Radijus okretnih pločica > 3,2 mm: Modificiranje osnovnog tijela

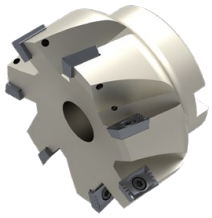


Oznaka	DC	ZNF	APMX	DCONMS	OAL	LH	Pritezni moment	Okretna pločica	2B Artikl br. 50 771 ...	
	mm		mm	mm	mm	mm	Nm		EUR	
C141.20.R.01	20	1	14	25	95	39	3,2	LD.. 1504..	170,90	**020**
C141.25.R.02	25	2	14	25	100	44	3,2	LD.. 1504..	227,50	**025**
C141.32.R.03	32	3	14	32	108	48	3,2	LD.. 1504..	264,30	**032**

MaxiMill – Utično glodalo A 241

▲ Radijus okretnih pločica > 3,2 mm: Modificiranje osnovnog tijela



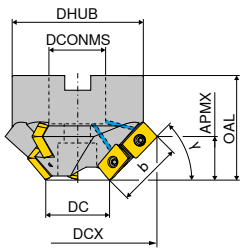


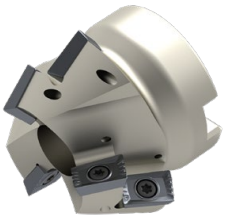
Oznaka	DC	ZNF	APMX	DHUB	DCONMS	OAL	Pritezni moment	Okretna pločica	2B Artikl br. 50 769 ... EUR	
	mm		mm	mm	mm	mm	Nm			
A241.40.R.04	40	4	14	33	16	40	3,2	LD.. 1504..	274,70	**040**
A241.50.R.05	50	5	14	43	22	40	3,2	LD.. 1504..	336,60	**050**
A241.52.R.05	52	5	14	43	22	40	3,2	LD.. 1504..	329,30	**052**
A241.63.R.06	63	6	14	48	22	40	3,2	LD.. 1504..	405,80	**063**
A241.66.R.06	66	6	14	58	27	50	3,2	LD.. 1504..	398,40	**066**
A241.80.R.07	80	7	14	58	27	50	3,2	LD.. 1504..	477,20	**080**
A241.100.R.08	100	8	14	75	32	50	3,2	LD.. 1504..	554,70	**100**

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
20 - 40	4,76	**036**	9,28	**113**	4,38	**303**	3,14	**110**	128,60	**192**
50 - 100	4,76	**036**	9,28	**113**	4,38	**303**	3,14	**304**	128,60	**192**

MaxiMill – Glodalo za skošenja A 242

▲ Pozor: Koristite samo okretne pločice s radijusom kuta manjim od 1,6 mm
▲ ZEFP = broj okretnih pločica
▲ ZNP = redovi zubiju





KAPR	DC	DCX ±0,3	ZNF	APMX ±0,3	ZEFP	b ±0,3	OAL	DCONMS	DHUB	ZNP	Pritezni moment	Okretna pločica	2B Artikl br. 50 768 ... EUR	
°	mm	mm		mm		mm	mm	mm	mm		Nm			
15	35	92,2	3	7,6	6	29,6	50	27	62,5	2	3,2	LD.. 1504..	376,40	**015**
30	35	86,3	3	14,8	6	29,6	50	27	62,5	2	3,2	LD.. 1504..	376,40	**030**
45	35	76,9	3	20,9	6	29,6	50	27	62,5	2	3,2	LD.. 1504..	376,40	**045**
60	35	64,6	3	25,6	6	29,6	50	22	62,5	2	3,2	LD.. 1504..	376,40	**060** 1)
75	35	50,3	3	28,5	6	29,6	60	22	49,0	2	3,2	LD.. 1504..	376,40	**075** 1)

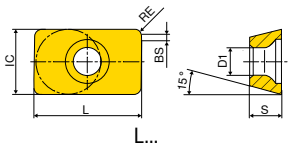
1) Izvedba s vodećim vijkom

Rezervni dijelovi KAPR	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 T-stezni ključ Artikl br. 80 397 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Vodeći vijak Artikl br. 70 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR		Y8 Pritezni vijak Artikl br. 83 950 ... EUR	
15 - 45	4,76	**036**			9,28	**113**			4,38	**303**	3,14	**304**	128,60	**192**	3,67	**125**
60 - 75	4,76	**036**	4,24	**050**	9,28	**113**	17,14	**154**	4,38	**303**	3,14	**304**	128,60	**192**		

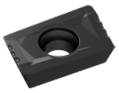
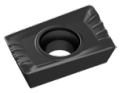
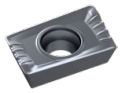
15

LDFW / LDFT / LDMT

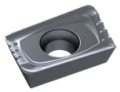
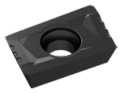
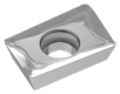
Oznaka	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
LD.. 1504PD..	9,52	4,4	15	1,2	4,76
LDFT 150408..	9,52	4,4	15	1,2	4,76
LDFT 1504PD..	9,52	4,4	15	0,8	4,76



LDFW / LDFT / LDMT

	CTCP230	-29 CTCP230	-29 CTCP230	-29 CTPP235	-29 CTPP235
	DCX1230	-29 DCX1230	-29 DCX1230	-29 DPX1235	-29 DPX1235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
	LDFW	LDFT	LDMT	LDFT	LDMT
	1B/61	1B/61	1B/61	1B/61	1B/61
ISO RE mm	Artikl br. 51 043 ... EUR	Artikl br. 51 079 ... EUR	Artikl br. 51 080 ... EUR	Artikl br. 51 079 ... EUR	Artikl br. 51 080 ... EUR
1504PDSR 0,8	15,97 020	19,13 020	9,77 020	19,13 120	9,77 120
Čelik	●	●	●	●	●
Nehrđajući čelik	○	○	○	○	○
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

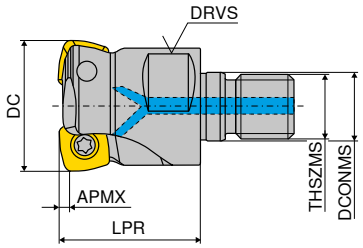
LDFT / LDFW

	-33 CTPM240	CTCK215	-27P H216T
	-33 DPX2240	DCX3215	-ALP CWK26
	DRAGONSKIN	DRAGONSKIN	
			
	LDFT	LDFW	LDFT
	1B/61	1B/61	1A/90
ISO RE mm	Artikl br. 51 042 ... EUR	Artikl br. 51 043 ... EUR	Artikl br. 50 409 ... EUR
150408FR 0,8			19,85 550
1504PDSR 0,8		15,97 520	
1504PDSR 1,2	18,27 420		
Čelik	○	○	
Nehrđajući čelik	●		
Lijevano željezo		●	○
Neželjezni metali			●
Visokootporan na toplinu			
Kaljeni čelik			

Priručnik za glodanje

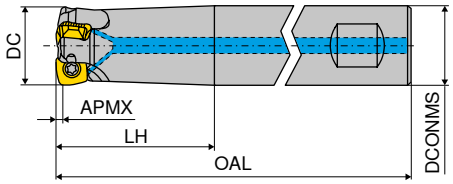
Strategija obrade	→ 168	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 168

MaxiMill – Uvrtno glodalo G HFC



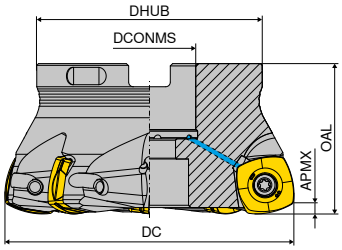
Oznaka	DC	ZNF	APMX	LPR	DCONMS	THSZMS	DRVS	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 682 ...	
	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
GHFC.16.R.02-06	16	2	0,8	27	8,5	M8	10	20800	1,2	XPLX 0603..	230,50	616
GHFC.20.R.03-06	20	3	0,8	33	10,5	M10	15	19800	1,2	XPLX 0603..	261,70	620
GHFC.25.R.04-06	25	4	0,8	35	12,5	M12	17	18700	1,2	XPLX 0603..	292,90	625
GHFC.32.R.05-06	32	5	0,8	35	17,0	M16	24	22000	1,2	XPLX 0603..	324,10	632
GHFC.42.R.07-06	42	7	0,8	35	17,0	M16	24	15000	1,2	XPLX 0603..	356,60	04207
GHFC.25.R.02-09	25	2	1,0	35	12,5	M12	17	30000	3,2	XDLX 09T3..	276,00	025
GHFC.25.R.03-09	25	3	1,0	35	12,5	M12	17	30000	3,2	XDLX 09T3..	296,30	125
GHFC.32.R.03-09	32	3	1,0	35	17,0	M16	24	27000	3,2	XDLX 09T3..	309,50	032
GHFC.42.R.05-19	42	5	1,0	35	17,0	M16	24	26100	3,2	XDLX 09T3..	346,70	04205
GHFC.32.R.02-12	32	2	2,0	35	17,0	M16	24	21600	5	XOLX 1204..	289,50	132
GHFC.35.R.03-12	35	3	2,0	35	17,0	M16	24	21360	5	XOLX 1204..	309,50	035
GHFC.42.R.04-12	42	4	2,0	35	17,0	M16	24	20800	5	XOLX 1204..	334,30	04204

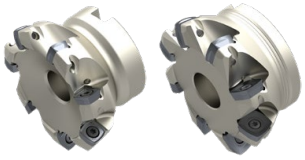
MaxiMill – Vretenasto glodalo C HFC



Oznaka	DC	ZNF	APMX	OAL	LH	DCONMS h6	RPMX	Pritezni moment	Okretna pločica	A 2B/40 Artikl br. 50 681 ...		B 2B/40 Artikl br. 50 681 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
CHFC.16.R.02-06-A-40-200	16	2	0,8	200	40	16	4600	1,2	XPLX 0603..	230,50	716		
CHFC.16.R.02-06-B-40	16	2	0,8	89	40	16	17300	1,2	XPLX 0603..			230,50	616
CHFC.20.R.03-06-B-50	20	3	0,8	101	50	20	14500	1,2	XPLX 0603..			261,70	620
CHFC.20.R.03-06-A-50-225	20	3	0,8	225	50	20	4200	1,2	XPLX 0603..	261,70	720		
CHFC.25.R.04-06-B-50	25	4	0,8	107	50	25	15600	1,2	XPLX 0603..			292,90	625
CHFC.25.R.04-06-A-50-225	25	4	0,8	225	50	25	4600	1,2	XPLX 0603..	292,90	725		
CHFC.32.R.05-06-B-25-60	32	5	0,8	117	60	25	11000	1,2	XPLX 0603..			324,10	632
CHFC.32.R.05-06-A-25-60-225	32	5	0,8	225	60	25	3900	1,2	XPLX 0603..	324,10	732		
CHFC.25.R.02-09-A-50-225	25	2	1,0	225	50	25	9000	3,2	XDLX 09T3..	276,00	025		
CHFC.25.R.03-09-A-50-225	25	3	1,0	225	50	25	9000	3,2	XDLX 09T3..	296,30	125		
CHFC.32.R.03-09-A-63-250	32	3	1,0	250	63	32	8100	3,2	XDLX 09T3..	309,50	032		
CHFC.32.R.02-12-A-63-250	32	2	2,0	250	63	32	6480	5	XOLX 1204..	289,50	132		
CHFC.35.R.03-12-A-63-250	35	3	2,0	250	63	32	6480	5	XOLX 1204..	309,50	035		

MaxiMill – Utično glodalo A HFC





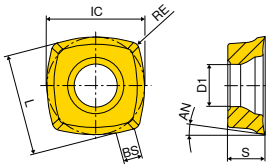
Oznaka	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 683 ...		2B/40 Artikl br. 50 683 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
AHFC.32.R.03-09	32	3	1,0	40	16	38	27700	3,2	XDLX 09T3..	309,50	**032**		
AHFC.35.R.04-09	35	4	1,0	40	16	38	26700	3,2	XDLX 09T3..	329,70	**035**		
AHFC.40.R.04-09	40	4	1,0	40	16	38	26400	3,2	XDLX 09T3..	343,20	**140**		
AHFC.42.R.05-09	42	5	1,0	40	16	38	26100	3,2	XDLX 09T3..	363,30	**142**		
AHFC.50.R.05-09	50	5	1,0	40	22	43	23500	3,2	XDLX 09T3..	403,80	**150**		
AHFC.52.R.06-09	52	6	1,0	40	22	43	23000	3,2	XDLX 09T3..	424,00	**152**		
AHFC.63.R.06-09	63	6	1,0	40	22	48	20500	3,2	XDLX 09T3..	464,30	**163**		
AHFC.66.R.07-09	66	7	1,0	40	22	48	20000	3,2	XDLX 09T3..	484,50	**16600**		
AHFC.40.R.03-12	40	3	2,0	40	16	38	21120	5	XOLX 1204..	323,10	**040**		
AHFC.42.R.04-12	42	4	2,0	40	16	38	20880	5	XOLX 1204..	343,20	**042**		
AHFC.50.R.04-12	50	4	2,0	40	22	43	18800	5	XOLX 1204..	383,50	**050**		
AHFC.52.R.05-12	52	5	2,0	40	22	43	18400	5	XOLX 1204..	403,80	**052**		
AHFC.63.R.05-12	63	5	2,0	40	22	48	16400	5	XOLX 1204..	444,00	**063**		
AHFC.66.R.06-12	66	6	2,0	40	22	48	16000	5	XOLX 1204..	464,30	**066**		
AHFC.80.R.07-12	80	7	2,0	50	27	58	14000	5	XOLX 1204..	524,90	**080**		
AHFC.100.R.08-12	100	8	2,0	50	32	78	12000	5	XOLX 1204..	585,60	**100**		
AHFC.63.R.05-19	63	5	3,3	40	22	48	5500	5	XOLX 1906..			464,90	**263**
AHFC.80.R.06-19	80	6	3,3	50	27	58	4700	5	XOLX 1906..			564,90	**280**
AHFC.100.R.08-19	100	8	3,3	52	32	78	4100	5	XOLX 1906..			672,40	**300**
AHFC.125.R.10-19	125	10	3,3	63	40	88	3600	5	XOLX 1906..			844,60	**325**
AHFC.160.R.11-19	160	11	3,3	63	40	98	3100	5	XOLX 1906..			1.021,00	**360** [1]

1) S 4 navojna provrta M12 na ravnini, Ø kruga rupe = 66,7 mm

Rezervni dijelovi	Y7 TORX®– Izmjenjiva oštrica		Y7 T-stezni ključ		Y7 D-ključ		2A/28 Vodeći vijak		2A/28 Pasta Molykote		2A/28 Stezni vijak		Y7 Momentni odvijač	
	Artikl br. 80 950 ...		Artikl br. 80 397 ...		Artikl br. 80 950 ...		Artikl br. 70 950 ...		Artikl br. 70 950 ...		Artikl br. 70 950 ...		Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
XDLX 09T3..	4,76	**036**			9,28	**113**			4,38	**303**	3,14	**110**	128,60	**192**
XDLX 09T3.. (Ø32 – Ø42)	4,76	**036**	3,91	**040**	9,28	**113**	12,48	**151**	4,38	**303**	3,14	**110**	128,60	**192**
XOLX 1204..	4,76	**037**			9,95	**114**			4,38	**303**	2,52	**280**	131,90	**193**
XOLX 1204.. (Ø40 – Ø42)	4,76	**037**	3,91	**040**	9,95	**114**	12,48	**151**	4,38	**303**	2,52	**280**	131,90	**193**
XOLX 1906..	4,76	**037**			9,95	**114**			4,38	**303**	4,09	**302**	131,90	**193**
XPLX 0603..	4,76	**033**			7,80	**110**			4,38	**303**	2,57	**116**	128,60	**192**

XPLX / XDLX / XOLX

Oznaka	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
XPLX 0603..	6,35	2,8	6	1	2,75	11
XDLX 09T3..	9,52	4,4	9	1,9	3,97	15
XOLX 1204..	12,70	5,5	12	1,3	4,76	-
XOLX 1906..	19,14	6,0	19	-	6,35	10



XPLX

		-M50 CTCP220	-M50 CTPP225	-M50 CTPP235	-M50 CTPM225	-M50 CTPM240	-F40 CTPM245
		-M50 DCX1220	-M50 DPX1225	-M50 DPX1235	-M50 DPX2225	-M50 DPX2240	-F40 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XPLX	XPLX	XPLX	XPLX	XPLX	XPLX
		1B/61	1B/61	1B/61	1B/61	1B/61	1H/17
ISO	RE	**Artikl br. 51 019 ...**	**Artikl br. 51 019 ...**	**Artikl br. 51 019 ...**	**Artikl br. 51 019 ...**	**Artikl br. 51 019 ...**	**Artikl br. 51 116 ...**
	mm	EUR	EUR	EUR	EUR	EUR	EUR
060305ER	0,5						15,06 **455**
060305SR	0,5	12,34 **255**	12,34 **055**	12,34 **105**	12,34 **205**	12,34 **405**	
Čelik		●	●	●	○	○	●
Nehrđajući čelik				○	●	●	●
Lijevano željezo							
Neželjezni metali							
Visokootporan na toplinu							
Kaljeni čelik							

15

XPLX

		-M50 CTCK215	-F40 CTC5240	-F40 CTCS245
		-M50 DCX3215	-F40 HCF5240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XPLX	XPLX	XPLX
		1B/61	1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 019 ...	Artikl br. 50 518 ...	Artikl br. 51 116 ...
	mm	EUR	EUR	EUR
060305ER	0,5		15,06 558	15,06 55500
060305SR	0,5	12,34 505		
Čelik		○		
Nehrđajući čelik				
Lijevano željezo		●		
Neželjezni metali				
Visokootporan na toplinu			●	●
Kaljeni čelik				

XDLX

		-M50 CTCP220	-M50 CTPP225	-M50 CTCP230	-M50 CTPP235
		-M50 DCX1220	-M50 DPX1225	-M50 DCX1230	-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XDLX	XDLX	XDLX	XDLX
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 016 ...	Artikl br. 51 016 ...	Artikl br. 51 016 ...	Artikl br. 51 016 ...
	mm	EUR	EUR	EUR	EUR
09T308SR	0,8	12,72 258	12,72 058	12,72 008	12,72 108
Čelik		●	●	●	●
Nehrđajući čelik				○	○
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

XDLX

		-M50 CTPM225	-M50 CTCM235	-M50 CTPM240	-F40 CTPM245	-M50 CTPM245
		-M50 DPX2225	-M50 DCX2235	-M50 DPX2240	-F40 DPX2245	-M50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XDLX	XDLX	XDLX	XDLX	XDLX
		1B/61	1B/61	1B/61	1H/17	1H/17
ISO	RE	Artikl br. 51 016 ...	Artikl br. 51 016 ...	Artikl br. 51 016 ...	Artikl br. 51 115 ...	Artikl br. 51 016 ...
	mm	EUR	EUR	EUR	EUR	EUR
09T308ER	0,8				15,36 458	
09T308SR	0,8	12,72 208	12,72 308	12,72 408		15,36 458
Čelik		○	○	○	●	●
Nehrđajući čelik		●	●	●	●	●
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

XDLX

		-M50 CTCK215	-F40 CTC5240	-F40 CTCS245
		-M50 DCX3215	-F40 HCF5240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XDLX	XDLX	XDLX
		1B/61	1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 016 ...	Artikl br. 50 503 ...	Artikl br. 51 115 ...
	mm	EUR	EUR	EUR
09T308ER	0,8		15,36 558	15,36 558
09T308SR	0,8	12,72 508		
Čelik		○		
Nehrđajući čelik				
Lijevano željezo		●		
Neželjezni metali				
Visokootporan na toplinu			●	●
Kaljeni čelik				

15

XOLX

		-M50 CTCP220	-M50 CTPP225	-M50 CTCP230	-M50 CTPP235	-R50 CTPP235
		-M50 DCX1220	-M50 DPX1225	-M50 DCX1230	-M50 DPX1235	-R50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XOLX	XOLX	XOLX	XOLX	XOLX
		1B/61	1B/61	1B/61	1B/61	1B/61
ISO	RE	Artikl br. 51 017 ...	Artikl br. 51 017 ...	Artikl br. 51 017 ...	Artikl br. 51 017 ...	Artikl br. 51 018 ...
	mm	EUR	EUR	EUR	EUR	EUR
120410SR	1,0	15,26 260	15,26 060	15,26 010	15,26 110	15,26 110
Čelik		●	●	●	●	●
Nehrđajući čelik				○	○	○
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

XOLX

		-M50 CTPM225	-M50 CTCM235	-M50 CTPM240	-F40 CTPM245	-M50 CTPM245
		-M50 DPX2225	-M50 DCX2235	-M50 DPX2240	-F40 DPX2245	-M50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XOLX	XOLX	XOLX	XOLX	XOLX
		1B/61	1B/61	1B/61	1H/17	1H/17
ISO	RE	Artikl br. 51 017 ...	Artikl br. 51 017 ...	Artikl br. 51 017 ...	Artikl br. 51 022 ...	Artikl br. 51 017 ...
	mm	EUR	EUR	EUR	EUR	EUR
120410ER	1,0				17,96 460	
120410SR	1,0	15,26 210	15,26 310	15,26 410		17,96 460
Čelik		○	○	○	●	●
Nehrđajući čelik		●	●	●	●	●
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu						
Kaljeni čelik						

XOLX / XOHX

		-M50 CTCK215	-F40 CTC5240	-F50 CTC5240	-F40 CTCS245	-F50 CTCS245
		-M50 DCX3215	-F40 HCF5240			
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XOLX	XOLX	XOHX	XOLX	XOLX
		1B/61	1H/D4	NEW 1H/D4	NEW 1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 017 ...	Artikl br. 50 504 ...	Artikl br. 51 124 ...	Artikl br. 51 022 ...	Artikl br. 51 124 ...
	mm	EUR	EUR	EUR	EUR	EUR
120410ER	1,0		17,96 558		17,96 560	
120410SR	1,0	15,26 510		23,35 16000		23,35 56000
Čelik		○				
Nehrđajući čelik						
Lijevano željezo		●				
Neželjezni metali						
Visokootporan na toplinu			●	●	●	●
Kaljeni čelik						

XOLX

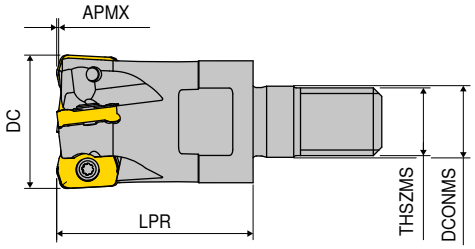
		-M50 CTCP230	-M50 CTPP235	-M50 CTPM240	-F40 CTPM245	-M50 CTCK215	-F40 CTC5240	-F40 CTCS245
		-M50 DCX1230	-M50 DPX1235	-M50 DPX2240	-F40 DPX2245	-M50 DCX3215	-F40 HCF5240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		XOLX	XOLX	XOLX	XOLX	XOLX	XOLX	XOLX
		1B/61	1B/61	1B/61	1H/17	1B/61	1H/D4	NEW 1H/D4
ISO	RE	Artikl br. 51 017 ...	Artikl br. 51 017 ...	Artikl br. 51 017 ...	Artikl br. 51 022 ...	Artikl br. 51 017 ...	Artikl br. 50 504 ...	Artikl br. 51 022 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR	EUR
190615ER	1,5				27,26 465		27,26 515	27,26 56500
190615SR	1,5	22,17 015	22,17 115	22,17 415		22,17 515		
Čelik		●	●	○	●	○		
Nehrđajući čelik		○	○	●	●			
Lijevano željezo						●		
Neželjezni metali								
Visokootporan na toplinu							●	●
Kaljeni čelik								

Priručnik za glodanje

Strategija obrade	→ 170–173	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 170–173
Početni parametar	→ 170–173		

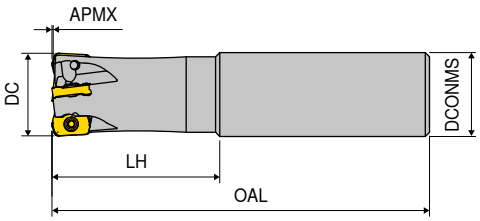
15

MaxiMill – Uvrtno glodalo G DHFC



Oznaka	DC	ZNF	APMX	LPR	DCONMS	THSZMS	Pritezni moment	Okretna pločica	NEW WA Artikl br. 56 411 ... EUR	
	mm		mm	mm	mm		Nm			
GDHFC.16.R.02-09	16	2	0,75	29	8,5	M8	0,65	LNKX 0925..	213,00	01602
GDHFC.16.R.03-09	16	3	0,75	29	8,5	M8	0,65	LNKX 0925..	232,30	01603
GDHFC.20.R.04-09	20	4	0,75	29	10,5	M10	0,65	LNKX 0925..	266,50	02004
GDHFC.25.R.05-09	25	5	0,75	33	12,5	M12	0,65	LNKX 0925..	309,30	02505
GDHFC.32.R.05-09	32	5	0,75	42	17,0	M16	0,65	LNKX 0925..	330,70	03205
GDHFC.35.R.06-09	35	6	0,75	42	17,0	M16	0,65	LNKX 0925..	350,00	03506
GDHFC.42.R.06-09	42	6	0,75	42	17,0	M16	0,65	LNKX 0925..	365,00	04206

MaxiMill – Vretenasto glodalo C DHFC



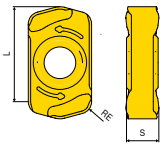
A

Oznaka	DC	ZNF	APMX	OAL	LH	DCONMS h6	Pritezni moment	Okretna pločica	NEW WA Artikl br. 56 417 ... EUR	
	mm		mm	mm	mm	mm	Nm			
CDHFC.16.R.05-09-A-32	16	3	0,75	80	32	16	0,65	LNKX 0925..	232,30	01603
CDHFC.20.R.04-09-A-40	20	4	0,75	90	40	20	0,65	LNKX 0925..	266,50	02004

Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica		Y7 D-ključ		2A/28 Pasta Molykote		WA Stezni vijak		Y7 Momentni odvijač	
	Artikl br. 80 950 ... EUR		Artikl br. 80 950 ... EUR		Artikl br. 70 950 ... EUR		Artikl br. 56 950 ... EUR		Artikl br. 80 950 ... EUR	
16 - 42	5,26	051	7,95	117	4,38	303	3,32	15000	118,90	191

LNKX

Oznaka	L	S
	mm	mm
LNKX 0925..	9	2,50



LNKX

		-R50 CTPP231	-M50 CTPP236	-R50 CTPP236	-M50 CTPM241	-R50 CTPK221
		LNKX	LNKX	LNKX	LNKX	LNKX
		NEW WB	NEW WB	NEW WB	NEW WB	NEW WB
ISO	RE	Artikl br. 56 353 ...	Artikl br. 56 355 ...	Artikl br. 56 353 ...	Artikl br. 56 355 ...	Artikl br. 56 353 ...
	mm	EUR	EUR	EUR	EUR	EUR
0925ZSR	1	17,68 12000	17,68 02500	17,68 02000	17,68 42500	17,68 27000
Čelik		●	●	●	●	●
Nehrđajući čelik					●	
Lijevano željezo		●	●	●		●
Neželjezni metali						
Visokootporan na toplinu					●	
Kaljeni čelik		●	●	●		●

Priručnik za glodanje

Strategija obrade	→ 174	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 174

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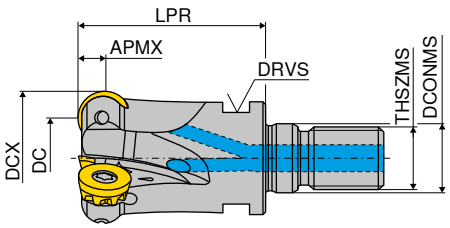
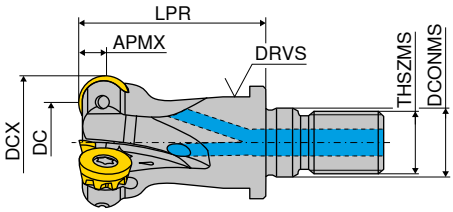
MaxiMill – Uvrtno glodalo G 251 RS



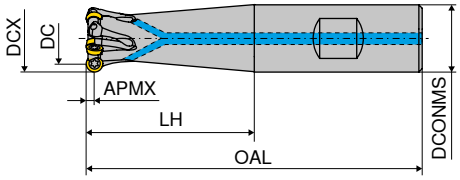
Oznaka	DC	DCX	ZNF	APMX	DCONMS	LPR	THSZMS	DRVS	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 684 ...	
	mm	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
G251.20.R.05-05-RS	15	20	5	2,5	10,5	33	M10	15	31800	0,7	RDHX 0501..	278,80	220
G251.25.R.06-05-RS	20	25	6	2,5	12,5	35	M12	17	24450	0,7	RDHX 0501..	321,00	225
G251.32.R.07-05-RS	27	32	7	2,5	17,0	35	M16	24	19850	0,7	RDHX 0501..	385,10	232
G251.20.R.03-08-RS	12	20	3	4,0	10,5	33	M10	15	25000	1,2	RDHX 0802..	261,70	120
G251.25.R.04-08-RS	17	25	4	4,0	12,5	35	M12	17	19000	1,2	RDHX 0802..	292,90	125
G251.32.R.05-08-35-RS	24	32	5	4,0	17,0	35	M16	24	19000	1,2	RDHX 0802..	356,10	132
G251.20.R.02-10-RS	10	20	2	5,0	10,5	33	M10	15	30000	2	RP.X 10T3..	211,70	020
G251.25.R.03-10-RS	15	25	3	5,0	12,5	35	M12	17	30000	2	RP.X 10T3..	284,60	025
G251.32.R.04-10-RS	22	32	4	5,0	17,0	35	M16	24	25000	2	RP.X 10T3..	331,20	032
G251.25.R.02-12-35-RS	13	25	2	6,0	12,5	35	M12	17	25000	3,2	RP.X 1204..	205,30	525
G251.32.R.03-12-35-RS	20	32	3	6,0	17,0	35	M16	24	19850	3,2	RP.X 1204..	250,50	532
G251.35.R.03-12-35-RS	23	35	3	6,0	17,0	35	M16	24	15900	3,2	RP.X 1204..	250,50	535
G251.42.R.04-12-42-RS	30	42	4	6,0	17,0	42	M16	24	15000	3,2	RP.X 1204..	297,70	542

MaxiMill – Uvrtno glodalo G 251



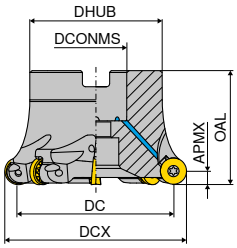
Oznaka	DC	DCX	ZNF	APMX	THSZMS	LPR	DCONMS	DRVS	Pritezni moment	Okretna pločica	2B Artikl br. 55 112 ...	
	mm	mm		mm		mm	mm	mm	Nm		EUR	
G251.10.R.02-05	5	10	2	2,5	M8	20	8,5	10	0,7	RDHX 0501..	151,00	110
G251.12.R.03-05	7	12	3	2,5	M8	20	8,5	10	0,7	RDHX 0501..	203,40	112
G251.15.R.04-05	10	15	4	2,5	M8	20	8,5	10	0,7	RDHX 0501..	238,00	115
G251.16.R.04-05	11	16	4	2,5	M8	20	8,5	10	0,7	RDHX 0501..	238,00	216
G251.20.R.05-05	15	20	5	2,5	M10	25	10,5	15	0,7	RDHX 0501..	281,00	320
G251.20.R.03-08	12	20	3	4,0	M10	28	10,5	15	1,2	RDHX 0802..	203,40	420
G251.25.R.04-08	17	25	4	4,0	M12	28	12,5	17	1,2	RDHX 0802..	254,80	425
G251.32.R.06-08	24	32	6	4,0	M16	28	17,0	24	1,2	RDHX 0802..	336,60	432
G251.35.R.06-08	27	35	6	4,0	M16	28	17,0	24	1,2	RDHX 0802..	336,60	435
G251.20.R.02-10	10	20	2	5,0	M10	33	10,5	15	2	RP.X 10T3..	216,00	220
G251.32.R.04-10	22	32	4	5,0	M16	35	17,0	24	2	RP.X 10T3..	315,60	232
G251.35.R.05-10	25	35	5	5,0	M16	35	17,0	24	2	RP.X 10T3..	353,40	235
G251.25.R.02-12.IK	13	25	2	6,0	M12	35	12,5	17	3,2	RP.X 1204..	212,90	525
G251.32.R.03-12.IK	20	32	3	6,0	M16	35	17,0	24	3,2	RP.X 1204..	259,00	532
G251.35.R.03-12.IK	23	35	3	6,0	M16	35	17,0	24	3,2	RP.X 1204..	259,00	535
G251.42.R.04-12.IK	30	42	4	6,0	M16	42	17,0	24	3,2	RP.X 1204..	308,30	542

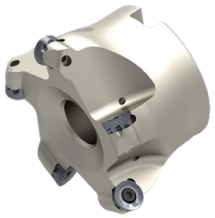
MaxiMill – Vretenasto glodalo C 251 RS



Oznaka	DC	DCX	ZNF	APMX	OAL	LH	DCONMS	RPMX	Okretna pločica	A 2B/40 Artikl br. 50 685 ...		B 2B/40 Artikl br. 50 685 ...	
	mm	mm		mm	mm	mm	mm	1/min.		EUR		EUR	
C251.10.R-02-05-B-12-20-RS	5	10	2	2,5	67	21,5	12	40000	RDHX 0501..			192,80	010
C251.10.R-02-05-A-25-165-RS	5	10	2	2,5	165	25,0	10	12000	RDHX 0501..	186,20	110		
C251.12.R-03-05-B-16-25-RS	7	12	3	2,5	75	25,0	16	40000	RDHX 0501..			243,20	012
C251.12.R-03-05-A-32-165-RS	7	12	3	2,5	165	32,0	12	16000	RDHX 0501..	234,20	112		
C251.16.R-04-05-B-32-RS	11	16	4	2,5	81	32,0	16	40000	RDHX 0501..			284,60	316
C251.16.R-04-05-A-40-165-RS	11	16	4	2,5	165	40,0	16	18000	RDHX 0501..	278,10	016		
C251.20.R-05-05-B-40-RS	15	20	5	2,5	91	40,0	20	31800	RDHX 0501..			331,20	620
C251.20.R-05-05-A-50-165-RS	15	20	5	2,5	165	50,0	20	18000	RDHX 0501..	324,90	120		
C251.16.R-02-08-B-32-RS	8	16	2	4,0	81	32,0	16	40000	RDHX 0802..			200,60	116
C251.16.R-02-08-A-40-165-RS	8	16	2	4,0	165	40,0	16	18000	RDHX 0802..	192,80	216		
C251.20.R-03-08-B-40-RS	12	20	3	4,0	91	40,0	20	31800	RDHX 0802..			254,90	220
C251.20.R-03-08-A-60-RS	12	20	3	4,0	110	50,0	20	30000	RDHX 0802..	261,70	020		
C251.20.R-03-08-A-50-200-RS	12	20	3	4,0	200	50,0	20	25000	RDHX 0802..	247,10	320		
C251.25.R-04-08-B-50-RS	17	25	4	4,0	107	50,0	25	25500	RDHX 0802..			301,40	625
C251.25.R-04-08-A-60-RS	17	25	4	4,0	116	60,0	25	19000	RDHX 0802..	292,90	125		
C251.25.R-04-08-A-60-225-RS	17	25	4	4,0	225	60,0	25	18000	RDHX 0802..	293,60	225		
C251.20.R-02-10-A-50-RS	10	20	2	5,0	102	50,0	20	25000	RP.X 10T3..	213,50	420		
C251.20.R-02-10-A-50-200-RS	10	20	2	5,0	200	50,0	20	25000	RP.X 10T3..	213,50	520		
C251.25.R.03-10-A-60-RS	15	25	3	5,0	116	60,0	25	25000	RP.X 10T3..	288,50	025		
C251.25.R-03-10-B-60-RS	15	25	3	5,0	116	60,0	25	20000	RP.X 10T3..			288,50	325
C251.25.R-03-10-A-60-225-RS	15	25	3	5,0	225	60,0	25	18000	RP.X 10T3..	288,50	425		
C251.32.R.04-10-A-70-RS	22	32	4	5,0	127	70,0	32	25000	RP.X 10T3..	324,90	032		
C251.25.R-02-12-B-30-RS	13	25	2	6,0	86	30,0	25	25000	RP.X 1204..			263,10	525
C251.32.R-03-12-A-RS	20	32	3	6,0	100	40,0	32	19000	RP.X 1204..	304,30	232		
C251.32.R-03-12-B-40-RS	20	32	3	6,0	100	40,0	32	19000	RP.X 1204..			304,30	132

MaxiMill – Utično glodalo A 251 RS



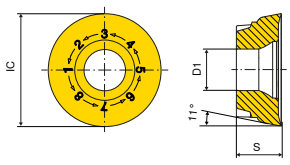


Oznaka	DC	DCX	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 686 ... EUR	
	mm	mm		mm	mm	mm	mm	1/min.	Nm			
A251.40.R.03-10-RS	30	40	3	5	40	38	16	15900	2	RP.X 10T3..	315,60	**240**
A251.40.R.05-10-RS	30	40	5	5	40	38	16	16000	2	RP.X 10T3..	355,70	**140**
A251.42.R.06-10-RS	32	42	6	5	40	38	16	16000	2	RP.X 10T3..	408,80	**142**
A251.50.R.04-10-RS	40	50	4	5	40	43	22	12700	2	RP.X 10T3..	346,60	**350**
A251.50.R.06-10-RS	40	50	6	5	40	43	22	12500	2	RP.X 10T3..	423,00	**150**
A251.52.R.06-10-RS	42	52	6	5	40	43	22	12500	2	RP.X 10T3..	423,00	**152**
A251.40.R.04-12-RS	28	40	4	6	40	38	16	15900	3,2	RP.X 1204..	327,20	**340**
A251.50.R.04-12-RS	38	50	4	6	40	43	22	12700	3,2	RP.X 1204..	337,70	**250**
A251.50.R.05-12-RS	38	50	5	6	40	43	22	12500	3,2	RP.X 1204..	397,10	**050**
A251.52.R.05-12-RS	40	52	5	6	40	43	22	12500	3,2	RP.X 1204..	416,50	**052**
A251.63.R.06-12-RS	51	63	6	6	40	48	22	10000	3,2	RP.X 1204..	490,30	**063**
A251.66.R.07-12-RS	54	66	7	6	40	48	22	9000	3,2	RP.X 1204..	516,90	**166**
A251.80.R.05-12-RS	68	80	5	6	50	58	27	7950	3,2	RP.X 1204..	447,50	**180**
A251.80.R.07-12-RS	68	80	7	6	50	58	27	8000	3,2	RP.X 1204..	553,10	**080**
A251.100.R.06-12-RS	88	100	6	6	50	78	32	6350	3,2	RP.X 1204..	499,40	**100**
A251.100.R.10-12-RS	88	100	10	6	50	78	32	6350	3,2	RP.X 1204..	729,60	**200**
A251.50.R.04-16-RS	34	50	4	8	40	48	22	12700	5	RP.X 1605..	397,10	**450**
A251.52.R.04-16-RS	36	52	4	8	40	48	22	10100	5	RP.X 1605..	397,10	**452**
A251.63.R.05-16-RS	47	63	5	8	40	48	22	10100	5	RP.X 1605..	500,60	**163**
A251.66.R.05-16-RS	50	66	5	8	40	48	22	7950	5	RP.X 1605..	504,30	**466**
A251.80.R.06-16-RS	64	80	6	8	50	58	27	7950	5	RP.X 1605..	608,00	**280**
A251.100.R.07-16-RS	84	100	7	8	50	78	32	6350	5	RP.X 1605..	710,30	**300**
A251.125.R.08-16-RS	109	125	8	8	63	88	40	5050	5	RP.X 1605..	751,80	**225**
A251.80.R.05-20-RS	60	80	5	10	50	58	27	7950	5	RP.X 2006..	514,80	**380**
A251.100.R.06-20-RS	80	100	6	10	50	78	32	6350	5	RP.X 2006..	615,80	**400**
A251.125.R.06-20-RS	105	125	6	10	63	88	40	5050	5	RP.X 2006..	623,50	**125**

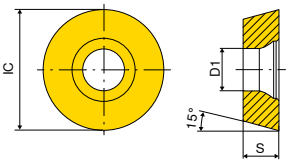
Rezervni dijelovi	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 T-stezni ključ Artikl br. 80 397 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Vodeći vijak Artikl br. 70 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
Okretna pločica														
RDHX 0501..	4,76	**031**			8,44	**108**			4,38	**303**	2,57	**149**	118,90	**191**
RDHX 0802..	4,76	**033**			7,80	**110**			4,38	**303**	2,57	**116**	118,90	**191**
RP.X 10T3..	4,76	**035**	3,91	**040**	9,14	**112**	12,48	**151**	4,38	**303**	2,57	**840**	128,60	**192**
RP.X 1204..	4,76	**036**	3,91	**040**	9,28	**113**	12,48	**151**	4,38	**303**	3,14	**304**	128,60	**192**
RP.X 1605..	4,76	**037**	4,24	**050**	9,95	**114**	17,14	**154**	4,38	**303**	2,52	**280**	131,90	**193**
RP.X 2006..	4,76	**037**			9,95	**114**			4,38	**303**	4,09	**302**	131,90	**193**

RDHX / RPHX / RPNX

Oznaka	IC	D1	S
	mm	mm	mm
RDHX 0501..	5	2,5	1,59
RDHX 0802..	8	2,8	2,38
RP.X 10T3..	10	3,4	3,97
RP.X 1204..	12	4,4	4,76
RP.X 1605..	16	5,5	5,56
RP.X 2006..	20	6,0	6,35



RP.X 10T3.. / RP.X 1204.. / RP.X 1605.. / RPNX 2006..

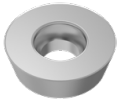


RDHX 0501.. / RDHX 0802..

RDHX

	-SN CTCP230	-SN CTPP235	-F50 CTPM240	-F50 CTPM245
	-SN DCX1230	-SN DPX1235	-F50 DPX2240	-F50 DPX2245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	RDHX	RDHX	RDHX	RDHX
	1B/61	1B/61	NEW 1B/61	1H/17
ISO	Artikl br. 51 048 ...	Artikl br. 51 048 ...	Artikl br. 51 083 ...	Artikl br. 51 083 ...
	EUR	EUR	EUR	EUR
0501MOSN	12,11 020	12,11 120		11,12 465
0802M4SN				14,64 471
0802MOSN	12,36 025	12,36 125	12,36 420	14,64 470
Čelik	●	●	○	●
Nehrđajući čelik	○	○	●	●
Lijevano željezo				
Neželjezni metali				
Visokootporan na toplinu				
Kaljeni čelik				

RDHX

	-EN CTCK215	-FN H216T	-M31 CTC5240	-F50 CTCS245
	-EN DCX3215	-FN CWK26	-M31 HCF5240	
	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
				
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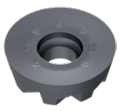
	1B/61	1B/61	1H/D4	NEW 1H/D4
ISO	Artikl br. 51 048 ...	Artikl br. 50 481 ...	Artikl br. 50 481 ...	Artikl br. 51 083 ...
	EUR	EUR	EUR	EUR
0501MOFN		9,61 600		
0802M4EN			14,64 50100	
0802MOEN	12,36 520		14,64 500	14,64 570
0802MOFN		9,91 602		
Čelik	○			
Nehrđajući čelik				
Lijevano željezo	●	○		
Neželjezni metali		●		
Visokootporan na toplinu			●	●
Kaljeni čelik				

15

RPHX / RPNX

ISO	-SN TCM10		-F50 CTCP230		-M50 CTCP230		-SN CTCP230		-SN CTCP230	
	-SN CWC10		-F50 DCX1230		-M50 DCX1230		-SN DCX1230		-SN DCX1230	
	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
	CERMET RPHX		RPNX		RPNX		RPHX		RPNX	
	1B/79		1B/18		1B/61		1B/61		1B/61	
	Artikl br. 50 483 ...		Artikl br. 51 055 ...		Artikl br. 51 054 ...		Artikl br. 51 052 ...		Artikl br. 51 057 ...	
	EUR		EUR		EUR		EUR		EUR	
10T3MOEN			12,83	020						
10T3MOSN	12,83	900			9,77	020	12,83	020		
1204MOEN			11,22	025						
1204MOSN	14,06	902			11,22	025	14,06	025	11,22	025
1605MOSN					15,26	030	19,13	030	15,26	030
2006MOSN									19,85	035
Čelik	●		●		●		●		●	
Nehrđajući čelik	●		○		○		○		○	
Lijevano željezo	○									
Neželjezni metali										
Visokootporan na toplinu										
Kaljeni čelik										

RPHX / RPNX

ISO	-F50 CTPP235		-F50 CTPP235		-M30 CTPP235		-M30 CTPP235	
	-F50 DPX1235		-F50 DPX1235		-M30 DPX1235		-M30 DPX1235	
	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
								
	RPHX		RPNX		RPHX		RPNX	
	1B/61		1B/61		1B/61		1B/61	
	Artikl br. 51 051 ...		Artikl br. 51 055 ...		Artikl br. 51 049 ...		Artikl br. 51 053 ...	
	EUR		EUR		EUR		EUR	
10T3MOEN					12,83	120		
10T3MOSN	12,83	12000	9,77	120				
1204MOEN			11,22	125				
1204MOSN	14,06	125						
1605MOSN			15,26	130				
2006MOEN							19,85	120
Čelik	●		●		●		●	
Nehrđajući čelik	○		○		○		○	
Lijevano željezo								
Neželjezni metali								
Visokootporan na toplinu								
Kaljeni čelik								

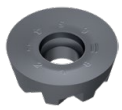
RPNX / RPHX

	-M50 CTPP235	-M50 CTPP235	-SN CTPP235	-SN CTPP235
	-M50 DPX1235	-M50 DPX1235	-SN DPX1235	-SN DPX1235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	RPNX	RPHX	RPHX	RPNX
	1B/61	NEW 1B/61	1B/61	1B/18
ISO	**Artikl br. 51 054 ...**	**Artikl br. 51 050 ...**	**Artikl br. 51 052 ...**	**Artikl br. 51 057 ...**
	EUR	EUR	EUR	EUR
10T3MOSN	9,77 **12000**	12,83 **12000**	12,83 **120**	
1204MOSN	11,22 **125**		14,06 **125**	11,22 **125**
1605MOSN	15,26 **130**		19,13 **130**	15,26 **130**
2006MOSN				19,85 **135**
Čelik	●	●	●	●
Nehrđajući čelik	○	○	○	○
Lijevano željezo				
Neželjezni metali				
Visokootporan na toplinu				
Kaljeni čelik				

RPHX

	-F50 CTPM225	-M30 CTPM225	-SN CTPM225	-F50 CTCM235	-M30 CTCM235
	-F50 DPX2225	-M30 DPX2225	-SN DPX2225	-F50 DCX2235	-M30 DCX2235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	RPHX	RPHX	RPHX	RPHX	RPHX
	1B/61	1B/61	1B/61	1B/61	1B/61
ISO	**Artikl br. 51 051 ...**	**Artikl br. 51 049 ...**	**Artikl br. 51 052 ...**	**Artikl br. 51 051 ...**	**Artikl br. 51 049 ...**
	EUR	EUR	EUR	EUR	EUR
1204MOEN		14,06 **225**		14,06 **325**	
1204MOSN	14,06 **225**		14,06 **225**		14,06 **325**
Čelik	○	○	○	○	○
Nehrđajući čelik	●	●	●	●	●
Lijevano željezo					
Neželjezni metali					
Visokootporan na toplinu					
Kaljeni čelik					

RPHX / RPNX

ISO	-F50 CTPM240		-F50 CTPM240		-M30 CTPM240		-M30 CTPM240		-M50 CTPM240	
	-F50 DPX2240		-F50 DPX2240		-M30 DPX2240		-M30 DPX2240		-M50 DPX2240	
	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
										
	RPHX		RPNX		RPHX		RPNX		RPHX	
	1B/61		1B/61		1B/61		1B/61		1B/61	
	Artikl br. 51 051 ...		Artikl br. 51 055 ...		Artikl br. 51 049 ...		Artikl br. 51 053 ...		Artikl br. 51 050 ...	
	EUR		EUR		EUR		EUR		EUR	
10T3MOEN					12,83	420			12,83	420
10T3MOSN	12,83	420								
1204MOEN					14,06	425			14,06	425
1204MOSN	14,06	425								
1605MOEN					19,13	430				
1605MOSN	19,13	430								
2006MOEN							19,85	420		
2006MOSN			19,85	435						
Čelik	○		○		○		○		○	
Nehrđajući čelik	●		●		●		●		●	
Lijevano željezo										
Neželjezni metali										
Visokootporan na toplinu										
Kaljeni čelik										

RPHX / RPNX

ISO	CTPM245		-F50 CTPM245		-F50 CTPM245		-M32 CTPM245		-M50 CTPM245	
	DPX2245		-F50 DPX2245		-F50 DPX2245		-M32 DPX2245		-M50 DPX2245	
	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
	RPHX		RPHX		RPNX		RPHX		RPHX	
	1H/17		1H/17		1H/17		1H/17		1H/17	
	Artikl br. 51 052 ...		Artikl br. 51 051 ...		Artikl br. 51 055 ...		Artikl br. 51 108 ...		Artikl br. 51 050 ...	
	EUR		EUR		EUR		EUR		EUR	
10T3M4SN			16,19	470 [1]	13,46	470 [1]			16,19	470 [1]
10T3M8SN			16,19	471	13,46	471			16,19	471
1204M4EN	17,84	475 [1]					17,84	475 [1]		
1204M4SN			17,84	475 [1]	15,84	475 [1]			17,84	475 [1]
1204M6SN			17,84	476					17,84	476
1204M8SN			17,84	477	15,84	476			17,84	477
1605M8SN			24,34	480						
2006M4SN			30,83	485 [1]						
2006M8SN					24,34	485				
Čelik	●		●		●		●		●	
Nehrđajući čelik	●		●		●		●		●	
Lijevano željezo										
Neželjezni metali										
Visokootporan na toplinu										
Kaljeni čelik										

1) Okretne pločice s 4-strukim indeksiranjem

RPNX / RPHX

ISO	-R30 CTCK215	-SN CTCK215	-SN CTCK215	-SN CTPK220	-27P H216T
	-R30 DCX3215	-SN DCX3215	-SN DCX3215	-SN DPX3220	-ALP CWK26
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
	RPNX	RPHX	RPNX	RPNX	RPHX
	1B/18	1B/61	1B/18	1B/61	1A/90
	Artikl br. 51 056 ...	Artikl br. 51 052 ...	Artikl br. 51 057 ...	Artikl br. 51 057 ...	Artikl br. 50 483 ...
	EUR	EUR	EUR	EUR	EUR
10T3MOEN	9,77 520				
10T3MOFN					14,65 600
10T3MOSN		12,83 520		9,77 620	
1204MOEN	11,22 525				
1204MOFN					16,24 602
1204MOSN		14,06 525	11,22 525	11,22 625	
1605MOFN					22,16 604
1605MOSN		19,13 530	15,26 530	15,26 630	
2006MOSN			19,85 535	19,85 635	
Čelik	○	○	○	○	
Nehrđajući čelik					
Lijevano željezo	●	●	●	●	○
Neželjezni metali					●
Visokootporan na toplinu					
Kaljeni čelik					

RPHX / RPNX

ISO	-M31 CTC5240	-F50 CTCS245	-F50 CTCS245	-R60 CTP6215
	-M31 HCF5240			-R60 CCN6215
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
	RPHX	RPHX	RPNX	RPNX
	1H/D4	NEW 1H/D4	NEW 1H/D4	1B/61
	Artikl br. 50 493 ...	Artikl br. 51 051 ...	Artikl br. 51 055 ...	Artikl br. 50 508 ...
	EUR	EUR	EUR	EUR
10T3M4EN	16,19 550 [1]			
10T3M4SN		16,19 570 [1]		
10T3M8EN	16,19 551			
10T3M8SN		16,19 571		
1204M4EN	17,84 552 [1]			
1204M4SN		17,84 575		
1204M6EN	17,84 56200	17,84 57800		
1204M8EN	17,84 582			12,11 300
1204M8SN		17,84 577		
1605M8EN	24,34 555	24,34 58100		
2006M8SN			24,34 585	
Čelik				
Nehrđajući čelik				
Lijevano željezo				●
Neželjezni metali				
Visokootporan na toplinu	●	●	●	
Kaljeni čelik				●

1) Okretne pločice s 4-strukim indeksiranjem

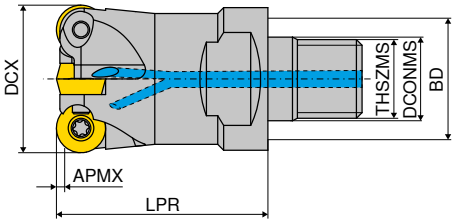
15

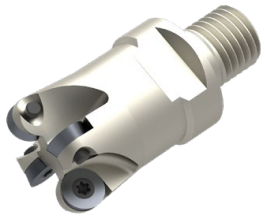
Priručnik za glodanje

Strategija obrade	→ 176	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 175

Glodalo s kružnom pločom R 1000 G

▲ Kut pločice 0°

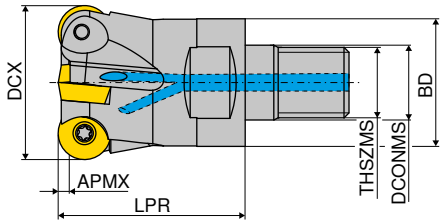




Oznaka	DCX	ZNF	APMX	THSZMS	LPR	DCONMS	BD	Pritezni moment	Okretna pločica	WA Artikl br. 56 403 ... EUR	
	mm		mm		mm	mm	mm	Nm			
R1000G.15.4.M8-05.IK	15	4	1,3	M8	20,5	8,5	13,8	0,43	RDHX 0501..	166,70	**151**
R1000G.20.5.M10-05.IK	20	5	1,3	M10	25,5	10,5	18,0	0,43	RDHX 0501..	197,20	**201**
R1000G.12.2.M8-07.IK	12	2	1,5	M8	28,5	8,5	11,8	0,75	RD.X 07T1..	108,10	**123**
R1000G.15.3.M8-07.IK	15	3	1,5	M8	28,5	8,5	13,8	0,75	RD.X 07T1..	130,10	**152**
R1000G.20.4.M10-07.IK	20	4	1,5	M10	28,5	10,5	18,0	0,75	RD.X 07T1..	167,70	**202**
R1000G.25.5.M12-07.IK	25	5	1,5	M12	28,5	10,5	21,0	0,75	RD.X 07T1..	191,90	**251**
R1000G.15.2.M8-07.IK	15	2	1,5	M8	28,5	8,5	13,8	0,9	RD.X 0702..	110,10	**153**
R1000G.16.3.M8-07.IK	16	3	1,5	M8	28,5	8,5	13,8	0,9	RD.X 0702..	133,20	**161**
R1000G.20.4.M10-07.IK	20	4	1,5	M10	28,5	10,5	18,0	0,9	RD.X 0702..	167,70	**203**
R1000G.25.5.M12-07.IK	25	5	1,5	M12	28,5	12,5	21,0	0,9	RD.X 0702..	191,90	**252**
R1000G.30.5.M16-07.IK	30	5	1,5	M16	28,5	17,0	29,0	0,9	RD.X 0702..	195,00	**301**
R1000G.35.6.M16-07.IK	35	6	1,5	M16	28,5	17,0	29,0	0,9	RD.X 0702..	219,20	**351**
R1000G.42.7.M16-07.IK	42	7	1,5	M16	42,5	17,0	29,0	0,9	RD.X 0702..	260,00	**421**
R1000G.20.2.M10-10.IK	20	2	2,8	M10	29,0	10,5	18,0	2,4	RD.X 1003..	117,40	**204**
R1000G.25.2.M12-10.IK	25	2	2,8	M12	33,0	12,5	21,0	2,4	RD.X 1003..	117,40	**253**
R1000G.25.3.M12-10.IK	25	3	2,8	M12	33,0	12,5	21,0	2,4	RD.X 1003..	122,70	**254**
R1000G.30.4.M12-10.IK	30	4	2,3	M12	33,0	12,5	21,0	2,4	RD.X 1003..	168,90	**302**
R1000G.30.4.M16-10.IK	30	4	2,8	M16	43,0	17,0	23,0	2,4	RD.X 1003..	168,90	**303**
R1000G.35.5.M16-10.IK	35	5	2,8	M16	43,0	17,0	29,0	2,4	RD.X 1003..	207,70	**352**
R1000G.42.5.M16-10.IK	42	5	2,8	M16	43,0	17,0	29,0	2,4	RD.X 1003..	219,20	**422**
R1000G.42.6.M16-10.IK	42	6	2,8	M16	43,0	17,0	29,0	2,4	RD.X 1003..	231,70	**423**
R1000G.24.2.M12-12.IK	24	2	3,0	M12	33,0	12,5	21,0	2,4	RD.X 12T3..	121,60	**241**
R1000G.35.3.M16-12.IK	35	3	3,0	M16	43,0	17,0	29,0	2,4	RD.X 12T3..	136,30	**353**
R1000G.35.4.M16-12.IK	35	4	3,0	M16	43,0	17,0	29,0	2,4	RD.X 12T3..	176,20	**354**
R1000G.42.4.M16-12.IK	42	4	3,0	M16	43,0	17,0	29,0	2,4	RD.X 12T3..	192,90	**424**
R1000G.42.5.M16-12.IK	42	5	3,0	M16	43,0	17,0	29,0	2,4	RD.X 12T3..	213,90	**425**
R1000G.32.2.M16-16.IK	32	2	4,0	M16	43,5	17,0	29,0	4,3	RD.X 1604..	141,60	**321**
R1000G.35.3.M16-16.IK	35	3	4,0	M16	43,5	17,0	29,0	4,3	RD.X 1604..	174,10	**355**
R1000G.40.2.M16-20.IK	40	2	7,0	M16	53,5	17,0	29,0	4,3	RD.X 2006..	197,20	**401**

Glodalo s kružnom pločom R 1007 G

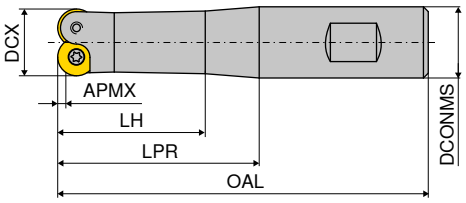
- Kut pločice 7°
- Za čelik < 10 % Cr



Oznaka	DCX mm	ZNF	APMX mm	THSZMS	LPR mm	DCONMS mm	BD mm	Pritezni moment Nm	Okretna pločica	WA Artikl br. 56 405 ... EUR	
R1007G.25.3.M12-10.IK	25	3	2,5	M12	32,5	12,5	21	2,4	RD.X 1003..	122,70	**251**
R1007G.42.6.M16-10.IK	42	6	2,5	M16	42,5	17,0	29	2,4	RD.X 1003..	231,70	**421**
R1007G.35.3.M16-12.IK	35	3	3,0	M16	42,5	17,0	29	2,4	RD.X 12T3..	154,10	**351**
R1007G.35.4.M16-12.IK	35	4	3,0	M16	42,5	17,0	29	2,4	RD.X 12T3..	176,20	**352**

Glodalo s kružnom pločom R 1000 C

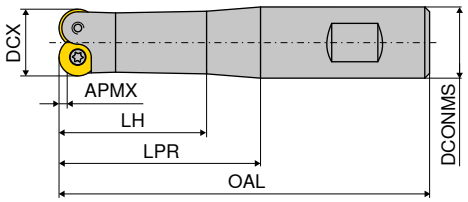
- Kut pločice 0°



Oznaka	DCX mm	ZNF	APMX mm	OAL mm	LPR mm	LH mm	DCONMS mm	Pritezni moment Nm	Okretna pločica	WA Artikl br. 56 441 ... EUR	
R1000C.8.1.30-05	8	1	1,3	75	30	18	10	0,43	RDHX 0501..	120,60	**081**
R1000C.10.2.30-05	10	2	1,3	75	30	23	10	0,43	RDHX 0501..	133,20	**101**
R1000C.12.3.30-05	12	3	1,3	81	30	23	12	0,43	RDHX 0501..	148,90	**121**
R1000C.12.2.30-07	12	2	1,5	76	30	23	12	0,75	RD.X 07T1..	95,32	**122**

Glodalo s kružnom pločom R 1002 C

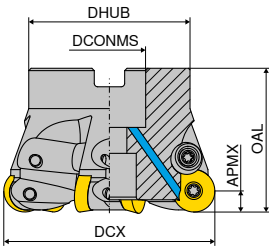
▲ Kut pločice 0°

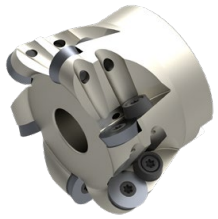


Oznaka	DCX	ZNF	APMX	OAL	LPR	LH	DCONMS	Okretna pločica	WA Artikl br. 56 443 ... EUR	
	mm		mm	mm	mm	mm	mm			
R1002C.12.2.40-07	12	2	1,5	89	40	19,5	16	RD.X 07T1..	97,30	**121**
R1002C.12.2.60-07	12	2	1,5	110	60	19,5	16	RD.X 07T1..	104,30	**122**
R1002C.12.2.80-07	12	2	1,5	129	80	19,5	16	RD.X 07T1..	111,10	**123**
R1002C.15.2.40-07	15	2	2,6	89	40	23,0	16	RD.X 0702..	97,30	**151**
R1002C.15.2.60-07	15	2	2,6	109	60	23,0	16	RD.X 0702..	103,50	**152**
R1002C.15.2.80-07	15	2	2,6	131	80	22,0	20	RD.X 0702..	111,10	**153**
R1002C.15.2.100-07	15	2	2,6	151	100	22,0	20	RD.X 0702..	119,60	**154**
R1002C.20.2.40-10	20	2	4,0	91	40	23,0	20	RD.X 1003..	110,10	**201**
R1002C.20.2.60-10	20	2	4,0	111	60	23,0	20	RD.X 1003..	113,30	**202**
R1002C.20.2.80-10	20	2	4,0	137	80	23,0	25	RD.X 1003..	118,50	**203**
R1002C.20.2.100-10	20	2	4,0	157	100	23,0	25	RD.X 1003..	124,80	**204**
R1002C.20.2.120-10	20	2	4,0	177	125	23,0	25	RD.X 1003..	131,10	**205**

Glodalo s kružnom pločom R 1000 A

▲ Kut pločice 0°

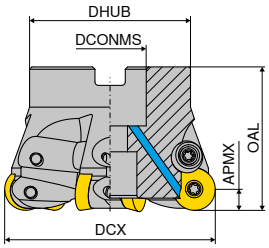


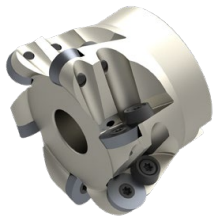


Oznaka	DCX	ZNF	APMX	OAL	DCONMS	DHUB	Pritezni moment	Okretna pločica	WA Artikl br. 56 407 ... EUR	
	mm		mm	mm	mm	mm	Nm			
R1000A.42.6.43-10.IK	42	6	2,8	43,0	16	35	2,4	RD.X 1003..	231,70	**420**
R1000A.42.4.43-12.IK	42	4	3,0	43,0	16	35	2,4	RD.X 12T3..	186,70	**421**
R1000A.42.5.43-12.IK	42	5	3,0	43,0	16	35	2,4	RD.X 12T3..	213,90	**422**
R1000A.52.5.53-12.IK	52	5	3,5	53,0	22	40	2,4	RD.X 12T3..	231,70	**521**
R1000A.52.4.53,5-16.IK	52	4	4,7	53,5	22	40	4,3	RD.X 1604..	227,50	**522**
R1000A.66.5.53,5-16.IK	66	5	5,1	53,5	27	48	4,3	RD.X 1604..	269,50	**661**
R1000A.80.6.53,5-16.IK	80	6	5,8	53,5	27	60	4,3	RD.X 1604..	345,00	**801**

Glodalo s kružnom pločom R 1007 A

- Kut pločice 7°
- Za čelik < 10 % Cr + glodalice s malom pogonskom snagom





Oznaka	DCX	ZNF	APMX	OAL	DCONMS	DHUB	Pritezni moment	Okretna pločica	WA Artikl br. 56 409 ...	
	mm		mm	mm	mm	mm	Nm		EUR	
R1007A.42.6.42,5-10.IK	42	6	3,5	42,5	16	35	2,4	RD.X 1003..	231,70	**421**
R1007A.52.7.52,5-10.IK	52	7	3,5	52,5	22	40	2,4	RD.X 1003..	338,60	**521**
R1007A.52.5.52,5-12.IK	52	5	3,5	52,5	22	40	2,4	RD.X 12T3..	231,70	**522**
R1007A.66.6.52,5-12.IK	66	6	3,5	52,5	27	48	2,4	RD.X 12T3..	274,70	**661**
R1007A.80.7.54,5-12.IK	80	7	3,5	54,5	27	60	2,4	RD.X 12T3..	345,00	**801**
R1007A.52.5.53-16.IK	52	5	4,1	53,0	22	40	4,3	RD.X 1604..	254,80	**523**
R1007A.66.5.53-16.IK	66	5	4,6	53,0	27	48	4,3	RD.X 1604..	269,50	**662**
R1007A.66.6.53-16.IK	66	6	5,1	53,0	27	48	4,3	RD.X 1604..	308,30	**663**
R1007A.80.6.53-16.IK	80	6	5,1	53,0	27	60	4,3	RD.X 1604..	345,00	**802**
R1007A.100.7.53-16	100	7	5,1	53,0	32	70	4,3	RD.X 1604..	426,70	**910** 1)
R1007A.125.8.53-16	125	8	5,2	53,0	40	90	4,3	RD.X 1604..	483,40	**925** 1)
R1007A.160.9.53-16	160	9	5,1	53,0	40	120	4,3	RD.X 1604..	661,70	**960** 1)
R1007A.66.5.53-20.IK	66	5	7,0	53,0	27	48	4,3	RD.X 2006..	323,00	**664**
R1007A.80.5.53-20.IK	80	5	7,4	53,0	27	60	4,3	RD.X 2006..	399,50	**803**

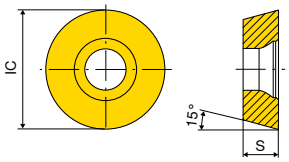
1) Bez unutarnjeg dovoda rashladnog sredstva

	Y7		WA		WA		Y7		2A/28		WA		Y7	
	TORX®-Izmjenjiva oštrica		Stezni vijak		Stezni disk		D-ključ		Pasta Molykote		Stezni vijak		Momentni odvijač	
Rezervni dijelovi	**Artikl br. 80 950 ...**		**Artikl br. 56 950 ...**		**Artikl br. 56 950 ...**		**Artikl br. 80 950 ...**		**Artikl br. 70 950 ...**		**Artikl br. 56 950 ...**		**Artikl br. 80 950 ...**	
Okretna pločica	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
RD.X 0702..	4,76	**032**					7,80	**109**	4,38	**303**	2,64	**006**	118,90	**191**
RD.X 07T1..	4,76	**032**					7,80	**109**	4,38	**303**	2,64	**004**	118,90	**191**
RD.X 1003..	4,76	**036**					9,28	**113**	4,38	**303**	3,40	**010**	128,60	**192**
RD.X 12T3..	4,76	**036**	2,07	**022**			9,28	**113**	4,38	**303**	3,40	**010**	128,60	**192**
RD.X 1604..	4,76	**037**			1,45	**210**	9,95	**114**	4,38	**303**	3,84	**012**	128,60	**192**
RD.X 2006..	4,76	**037**			1,45	**210**	9,95	**114**	4,38	**303**	3,84	**012**	128,60	**192**
RDHX 0501..							8,44	**108**	4,38	**303**	2,56	**002**	118,90	**191**

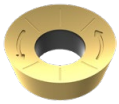
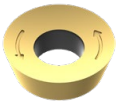
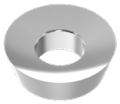
15

RDHX / RDMX / RDEX / RDPX

Oznaka	IC	S
	mm	mm
RDHX 0501..	5	1,50
RD.X 07T1..	7	1,99
RD.X 0702..	7	2,38
RD.X 1003..	10	3,18
RD.X 12T3..	12	3,97
RD.X 1604..	16	4,76
RDHX 2006..	20	6,00



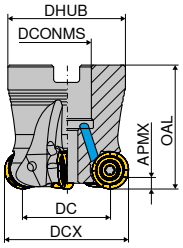
RDHX / RDMX / RDEX / RDPX

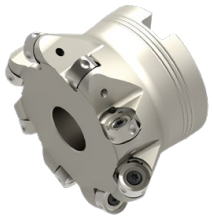
	WTN1205	WAN1240	WAX1240	-HP WAN2225	-F30P WUN4210
					
	RDHX	RDMX	RDEX	RDPX	RDHX
	WB	WB	WB	WB	WB
ISO	Artikl br. 56 302 ...	Artikl br. 56 309 ...	Artikl br. 56 314 ...	Artikl br. 56 348 ...	Artikl br. 56 304 ...
	EUR	EUR	EUR	EUR	EUR
0501MOT	12,00 100				
0702MOE					11,56 611
0702MOT	12,32 111		8,58 611		
07T1MOE					11,56 621
07T1MOT	12,32 121		8,44 621		
1003MOS				12,43 231	
1003MOT	12,43 131	9,17 731	9,03 631		12,97 631
12T3MOS				13,08 241	
12T3MOT	13,08 141	10,62 741	10,29 641		15,89 641
1604MOS				16,43 251	
1604MOT	13,08 151	11,68 751	11,46 651		19,24 651
2006MOT	17,95 161				21,08 661
Čelik	●	●	●		
Nehrđajući čelik	○	○		●	
Lijevano željezo	●	○	○		
Neželjezni metali	○				●
Visokootporan na toplinu		○		○	
Kaljeni čelik	●		○		

Priručnik za glodanje

Strategija obrade	→ 180+181	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 177–179

MaxiMill – Utično glodalo A 252





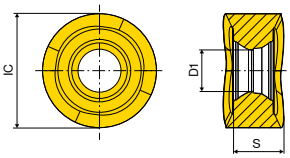
Oznaka	DC	DCX	ZNF	APMX	OAL	DHUB	DCONMS	Pritezni moment	Okretna pločica	2B/40 Artikl br. 50 689 ...	
	mm	mm		mm	mm	mm	mm	Nm		EUR	
A252.40.R.05-10	30	40	5	2,5	40	38	16	2	RNHU 1004..	409,50	**140**
A252.42.R.05-10	32	42	5	2,5	40	38	16	2	RNHU 1004..	469,60	**142**
A252.50.R.06-10	40	50	6	2,5	40	43	22	2	RNHU 1004..	486,90	**150**
A252.52.R.07-10	42	52	7	2,5	40	43	22	2	RNHU 1004..	528,80	**152**
A252.63.R.08-10	53	63	8	2,5	40	48	22	2	RNHU 1004..	599,30	**16300**
A252.80.R.10-10	70	80	10	2,5	50	58	27	2	RNHU 1004..	681,70	**18000**
A252.40.R.04-12	28	40	4	3,0	40	38	16	3,2	RNHU 1205..	376,20	**240**
A252.50.R.05-12	38	50	5	3,0	40	43	22	3,2	RNHU 1205..	456,80	**250**
A252.52.R.05-12	40	52	5	3,0	40	43	22	3,2	RNHU 1205..	457,90	**252**
A252.63.R.06-12	51	63	6	3,0	40	48	22	3,2	RNHU 1205..	564,30	**263**
A252.66.R.07-12	54	66	7	3,0	40	48	22	3,2	RNHU 1205..	594,40	**266**
A252.80.R.08-12	68	80	8	3,0	50	58	27	3,2	RNHU 1205..	649,20	**280**
A252.100.R.10-12	88	100	10	3,0	50	78	32	3,2	RNHU 1205..	772,60	**30000**
A252.125.R.12-12	113	125	12	3,0	63	88	40	3,2	RNHU 1205..	934,70	**32500**

Rezervni dijelovi	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 T-stezni ključ Artikl br. 80 397 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Vodeći vijak Artikl br. 70 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A/28 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
RNHU 1004.. (Ø40 – Ø80)	5,26	**053**			11,56	**127**			4,38	**303**	3,09	**710**	128,60	**192**
RNHU 1205.. (Ø40)	5,26	**054**	3,91	**040**	11,89	**128**	12,48	**151**	4,38	**303**	3,18	**839**	128,60	**192**
RNHU 1205.. (Ø50 – Ø125)	5,26	**054**			11,89	**128**			4,38	**303**	3,18	**839**	128,60	**192**

15

RNHU

Oznaka	IC	D1	S
	mm	mm	mm
RNHU 1004..	10	3,4	4,60
RNHU 1205..	12	4,4	5,30



RNHU

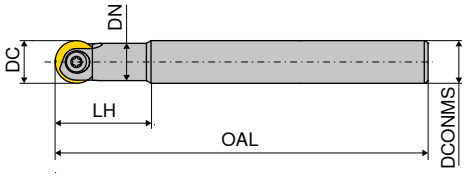
	-M50 CTPP235	-F50 CTPM240	-M31 CTPM245	-M32 CTPM245	-M31 CTC5240	-M31 CTC5240
			-M31 DPX2245	-M32 DPX2245	-M31 HCF5240	-M31 HCF5240
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	RNHU	RNHU	RNHU	RNHU	RNHU	RNHU
	NEW 1B/61	NEW 1B/61	1H/17	1H/17	1H/D4	1H/D4
ISO	Artikl br. 51 130 ...	Artikl br. 51 129 ...	Artikl br. 51 106 ...	Artikl br. 51 107 ...	Artikl br. 50 520 ...	Artikl br. 50 521 ...
	EUR	EUR	EUR	EUR	EUR	EUR
1004M4ER	18,34 12000	18,34 42000	24,81 470	24,81 470	24,81 550	
1205M4ER		19,86 42500	27,16 475	27,16 475		27,16 552
1205M4SR	19,86 12500					
Čelik	●	○	●	●		
Nehrđajući čelik	○	●	●	●		
Lijevano željezo						
Neželjezni metali						
Visokootporan na toplinu					●	●
Kaljeni čelik						

Priručnik za glodanje

Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 182
Sustav označavanja	→ 194+195		

Držač pločice kopirnog glodala K 2000C/K 2001C

▲ S drškom od tvrdog metala



Oznaka	DC	DN	LH	OAL	DCONMS $_{h6}$	Pritezni moment	WA Artikl br. 56 100 ...		WA Artikl br. 56 101 ...	
	mm	mm	mm	mm	mm	Nm	EUR		EUR	
K2000C.6.16.100	6	5,3	16	100	8	0,6	358,60	**060** [1]		
K2000C.6.20.100	6	5,8	20	100	6	0,6	358,60	**061** [1]		
K2000C.6.70.150	6	5,8	70	150	6	0,6	465,50	**062** [1]		
K2000C.6.100.200	6	5,8	100	200	6	0,6	564,10	**063** [1]		
K2000C.8.25.80	8	7,0	25	80	8	1	379,60	**081** [1]		
K2000C.8.25.100	8	7,0	25	100	8	1	379,60	**082** [1]		
K2000C.8.25.150	8	7,0	40	150	8	1	421,50	**083** [1]		
K2000C.10.35.80	10	8,8	35	80	10	5	458,20	**101** [1]		
K2000C.10.35.120	10	8,8	35	120	10	5	471,90	**102** [1]		
K2000C.10.50.150	10	8,8	50	150	10	5	523,30	**103** [1]		
K2000C/K2001C.12.35.80	12	10,5	35	80	12	5	476,00	**121** [1]	476,00	**121**
K2000C/K2001C.12.35.120	12	10,5	35	120	12	5	497,00	**122** [1]	497,00	**122**
K2000C/K2001C.12.50.160	12	10,5	50	160	12	5	531,60	**123** [1]	531,60	**123**
K2001C.16.40.100	16	14,0	40	100	16	5			655,40	**161**
K2001C.16.40.140	16	14,0	40	140	16	5			655,40	**162**
K2001C.16.55.175	16	14,0	55	175	16	5			714,00	**163**
K2001C.20.50.100	20	18,0	50	100	20	5			834,60	**201**
K2001C.20.50.140	20	18,0	50	140	20	5			834,60	**202**
K2001C.20.75.190	20	18,0	75	190	20	5			992,00	**203**
K2001C.25.60.160	25	22,4	60	160	25	5			1.182,00	**252**
K2001C.25.90.210	25	22,4	90	210	25	5			1.478,00	**253**

1) Bez unutarnjeg dovoda rashladnog sredstva

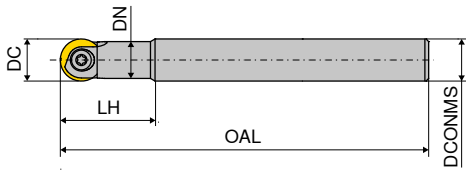
Upotrebljive pločice

	ROHX-FM3, ROHX-FM4, ROHX-FM6, ROHX-MR5, ROGX-MR4

	XOHX06.. -MR2, XOHX-FM1

Držač pločice kopirnog glodala K 2002C

▲ S cilindričnom izvedbom čeličnog drška



Oznaka	DC	DN	LH	OAL	DCONMS $_{h6}$	Pritezni moment	WA Artikl br. 56 102 ...	
	mm	mm	mm	mm	mm	Nm	EUR	
K2002C.12.32.90	12	10,5	32	90	12	5	93,53	**121**
K2002C.12.32.130	12	10,5	32	130	12	5	93,53	**122**
K2002C.12.46.150	12	10,5	46	150	12	5	97,83	**123**
K2002C.16.36.100	16	14,0	36	100	16	5	99,09	**161**
K2002C.16.36.140	16	14,0	36	140	16	5	99,09	**162**
K2002C.16.53.160	16	14,0	53	160	16	5	104,40	**163**
K2002C.20.45.160	20	18,0	45	160	20	5	103,40	**202**
K2002C.20.61.175	20	18,0	61	175	20	5	123,70	**203**
K2002C.25.45.160	25	22,4	45	160	25	5	145,70	**252**
K2002C.25.70.190	25	22,4	70	190	25	5	151,00	**253**
K2002C.32.56.175	32	28,6	56	175	32	5	185,60	**322**
K2002C.32.80.210	32	28,6	80	210	32	5	195,00	**323**

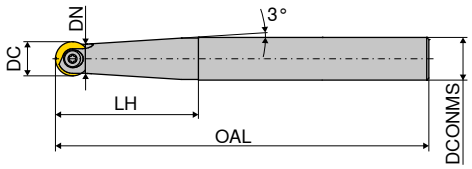
Upotrebljive pločice

	ROHX-FM3, ROHX-FM4, ROHX-FM6, ROHX-MR5, ROGX-MR4

	XOHX-FM1

Držač pločice kopirnog glodala K 2003C

▲ Konusna izvedba



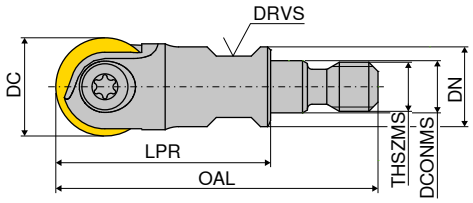
Oznaka	DC	DN	LH	OAL	DCONMS $_{h6}$	Pritezni moment	WA Artikl br. 56 104 ...	
	mm	mm	mm	mm	mm	Nm	EUR	
K2003C.6.16.90	6	5,3	16	90	10	0,6	104,90	**061**
K2003C.8.50.85	8	7,5	50	85	12	1	124,80	**081**
K2003C.8.50.140	8	7,5	50	140	12	1	124,80	**082**
K2003C.10.35.85	10	9,0	35	85	12	5	124,80	**101**
K2003C.10.35.150	10	9,0	35	150	12	5	124,80	**102**
K2003C.12.60.110	12	10,5	60	110	16	5	126,90	**121**
K2003C.12.60.160	12	10,5	60	160	16	5	126,90	**122**
K2003C.16.67.120	16	14,0	67	120	20	5	136,30	**161**
K2003C.16.67.175	16	14,0	67	175	20	5	136,30	**162**
K2003C.20.80.190	20	18,0	80	190	25	5	158,40	**201**
K2003C.25.100.210	25	22,4	100	210	32	5	197,20	**251**
K2003C.32.123.240	32	28,6	123	240	40	5	252,70	**321**

Upotrebljive pločice

	ROHX-FM3, ROHX-FM4, ROHX-FM6, ROHX-MR5, ROGX-MR4

	XOHX-FM1

Držač pločice kopirnog glodala K 2000G



Oznaka	DC	LPR	DN	OAL	DCONMS	THSZMS	DRVS	Pritezni moment	WA Artikl br. 56 120 ...	
	mm	mm	mm	mm	mm		mm	Nm	EUR	
K2000G.8.25.M6	8	25	10	39,5	6,5	M6	8	1	208,70	**081** 1)
K2000G.10.25.M6	10	25	10	39,5	6,5	M6	8	5	206,50	**101** 1)
K2000G.12.25.M6	12	25	10	39,5	6,5	M6	8	5	212,90	**121** 1)
K2000G.12.26.M8	12	26	13	43,5	8,5	M8	10	5	212,90	**122**
K2000G.16.26.M8	16	26	13	43,5	8,5	M8	10	5	221,20	**161**
K2000G.20.30.M10	20	30	18	49,5	10,5	M10	15	5	225,50	**201**
K2000G.25.40.M12	25	40	21	62,0	12,5	M12	17	5	233,80	**251**
K2000G.32.45.M16	32	45	30	69,0	17,0	M16	26	5	249,50	**321**

1) Bez unutarnjeg dovoda rashladnog sredstva

Upotrebljive pločice

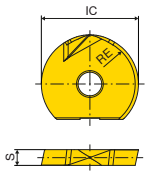
	ROHX-FM3, ROHX-FM4, ROHX-FM6, ROHX-MR5, ROGX-MR4

	XOHX-FM1

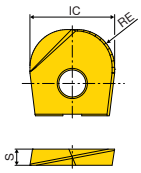
Rezervni dijelovi DC	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		WA Stezni vijak Artikl br. 56 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
6	4,76	**031**	8,44	**108**	4,38	**303**	6,10	**041**	118,90	**191**
8	4,76	**033**	7,80	**110**	4,38	**303**	6,10	**042**	118,90	**191**
10	4,76	**036**	9,28	**113**	4,38	**303**	6,10	**043**	131,90	**193**
12	4,76	**037**	9,95	**114**	4,38	**303**	8,33	**044**	131,90	**193**
16	4,76	**037**	9,95	**114**	4,38	**303**	8,33	**045**	131,90	**193**
20	4,76	**037**	9,95	**114**	4,38	**303**	8,33	**046**	131,90	**193**
25			12,10	**131**	4,38	**303**	8,33	**047**		
32			12,10	**131**	4,38	**303**	8,45	**048**		

ROHX / XOHX / ROGX

Oznaka	IC	S
	mm	mm
ROHX0616R..	6	1,60
ROHX0820R..	8	2,00
XOHX10254..	10	2,50
ROHX1025R..	10	2,50
XOHX12255..	12	2,50
RO.X1225R..	12	2,50
XOHX16307..	16	3,00
RO.X1630R..	16	3,00
XOHX20309..	20	3,00
RO.X2030R..	20	3,00
RO.X2540R..	25	4,00
RO.X3250R..	32	5,00



RO.X



XOHX

ROHX / XOHX / ROGX

ISO	RE	-MR5 CTPP211		-FM1 CTPP216		-FM3 CTPP216		-FM4 CTPP216		-FM4 CTPK226		-MR4 CTPK231		-FM6 CTCN211	
		ROHX		XOHX		ROHX		ROHX		ROHX		ROGX		ROHX	
		NEW WB		NEW WB		NEW WB		NEW WB		NEW WB		NEW WB		WB	
		Artikl br. 56 149 ...		Artikl br. 56 169 ...		Artikl br. 56 147 ...		Artikl br. 56 141 ...		Artikl br. 56 141 ...		Artikl br. 56 143 ...		Artikl br. 56 145 ...	
	mm	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
0616 R3	3,0					30,87	30200	25,73	90200					76,96	602 1)
0820 R4	4,0	31,38	71300			37,43	31300	24,72	71300	25,92	11300			100,20	613 1)
1025 R5	5,0	31,38	72400			37,43	32400	24,72	72400	25,92	12400			100,20	624 1)
102540	4,0			33,89	92400										
1225 R6	6,0					38,03	33500	25,73	73500	25,92	13500	25,22	53500	100,20	635 1)
122550	5,0			36,32	93500										
1630 R8	8,0					40,96	34600	29,56	74600	30,21	14600	29,56	54600	113,50	646 1)
163070	7,0			38,84	94700										
2030 R10	10,0					43,38	35700	33,89	75700	33,77	15700	33,89	55700		
203090	9,0			44,28	95900										
2540 R12,5	12,5					53,98	36800	50,54	76800	50,37	16800	49,94	56800		
3250 R16	16,0					72,33	37900	73,84	77900	74,69	17900	68,90	57900		

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

1) Specijalno za obradu grafita!

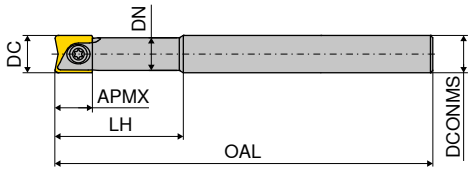
15

Priručnik za glodanje

Dubina postavljanja	→ 185	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 183+184

Držač pločice kopirnog glodala K 2005C/K 2006C

▲ S drškom od tvrdog metala



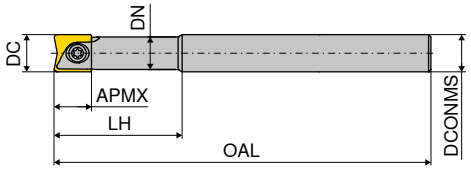
Oznaka	DC	APMX	DN	LH	OAL	DCONMS $_{h6}$	Pritezni moment	WA Artikl br. 56 110 ...		WA Artikl br. 56 111 ...	
	mm	mm	mm	mm	mm	mm	Nm	EUR		EUR	
K2005C.8.27.82	8	9,5	7,0	27	82	8	1	379,60	**081** [1]		
K2005C.8.27.102	8	9,5	7,0	27	102	8	1	379,60	**082** [1]		
K2005C.8.42.152	8	9,5	7,0	42	152	8	1	421,50	**083** [1]		
K2005C.10.37.82	10	11,5	8,8	37	82	10	5	458,20	**101** [1]		
K2005C.10.37.122	10	11,5	8,8	37	122	10	5	471,90	**102** [1]		
K2005C.10.52.152	10	11,5	8,8	52	152	10	5	523,30	**103** [1]		
K2005C/K2006C.12.37.82	12	14,0	10,5	37	82	12	5	476,00	**121** [1]	476,00	**121**
K2005C/K2006C.12.37.122	12	14,0	10,5	37	122	12	5	497,00	**122** [1]	497,00	**122**
K2005C/K2006C.12.52.162	12	14,0	10,5	52	162	12	5	531,60	**123** [1]	531,60	**123**
K2006C.16.42.102	16	16,0	14,0	42	102	16	5			655,40	**161**
K2006C.16.42.142	16	16,0	14,0	42	142	16	5			655,40	**162**
K2006C.16.57.177	16	16,0	14,0	57	177	16	5			714,00	**163**
K2006C.20.52.102	20	18,0	18,0	52	102	20	5			834,60	**201**
K2006C.20.52.142	20	18,0	18,0	52	142	20	5			834,60	**202**
K2006C.20.77.192	20	18,0	18,0	77	192	20	5			979,40	**203**
K2006C.25.62.162	25	23,5	22,4	62	162	25	5			1.182,00	**252**
K2006C.25.92.212	25	23,5	22,4	92	212	25	5			1.478,00	**253**

1) Bez unutarnjeg dovoda rashladnog sredstva

Upotrebljive pločice

	XOHX-FM2 / -FM5 / -MR2 / -MR3 / -MR6
	XOGX-MF4

Držač pločice kopirnog glodala K 2007C



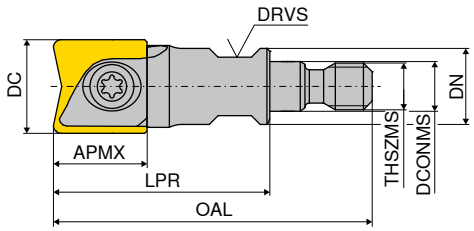
Oznaka	DC	APMX	DN	LH	OAL	DCONMS $_{h6}$	Pritezni moment	WA Artikl br. 56 112 ...	
	mm	mm	mm	mm	mm	mm	Nm	EUR	
K2007C.12.34.92	12	14,0	10,5	34	92	12	5	102,20	**121**
K2007C.12.34.132	12	14,0	10,5	34	132	12	5	93,53	**122**
K2007C.12.48.152	12	14,0	10,5	48	152	12	5	97,83	**123**
K2007C.16.38.102	16	16,0	14,0	38	102	16	5	99,09	**161**
K2007C.16.38.142	16	16,0	14,0	38	142	16	5	99,09	**162**
K2007C.16.55.162	16	16,0	14,0	55	162	16	5	104,40	**163**
K2007C.20.47.162	20	18,0	18,0	47	162	20	5	103,40	**202**
K2007C.20.63.177	20	18,0	18,0	63	177	20	5	123,70	**203**
K2007C.25.47.162	25	23,5	22,4	47	162	25	5	145,70	**252**
K2007C.25.72.192	25	23,5	22,4	72	192	25	5	151,00	**253**
K2007C.32.58.177	32	28,0	28,6	58	177	32	5	185,60	**322**
K2007C.32.82.212	32	28,0	28,6	82	212	32	5	195,00	**323**

Upotrebljive pločice

	XOHX-FM2 / -FM5 / -MR2 / -MR3 / -MR6
	XOGX-MF4

15

Držač pločice kopirnog glodala K 2005G



Oznaka	DC	APMX	DN	LPR	OAL	DCONMS	THSZMS	DRVS	Pritezni moment	WA Artikl br. 56 130 ...	
	mm	mm	mm	mm	mm	mm		mm	Nm	EUR	
K2005G.8.25.M6	8	9,5	10	25	39,5	6,5	M6	8	1	208,70	**081** 1)
K2005G.10.25.M6	10	11,5	10	25	39,5	6,5	M6	8	5	206,50	**101** 1)
K2005G.12.25.M6	12	14,0	10	25	39,5	6,5	M6	8	5	212,90	**121** 1)
K2005G.12.28.M8	12	14,0	13	28	45,5	8,5	M8	8	5	212,90	**122**
K2005G.16.28.M8	16	16,0	13	28	45,5	8,5	M8	10	5	221,20	**161**
K2005G.20.32.M10	20	18,0	18	32	51,5	10,5	M10	15	5	225,50	**201**
K2005G.25.42.M12	25	23,5	21	42	64,0	12,5	M12	17	5	233,80	**251**
K2005G.32.47.M16	32	28,0	30	47	71,0	17,0	M16	26	5	249,50	**321**

1) Bez unutarnjeg dovoda rashladnog sredstva

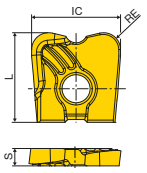
Upotrebljive pločice

	XOHX-FM2 / -FM5 / -MR2 / -MR3 / -MR6
	XOGX-MF4

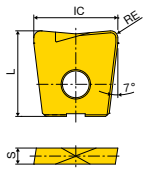
Rezervni dijelovi DC	Y7 TORX®-Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		WA Stezni vijak Artikl br. 56 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
8	4,76	**033**	7,80	**110**	4,38	**303**	6,10	**042**	118,90	**191**
10	4,76	**036**	9,28	**113**	4,38	**303**	6,10	**043**	131,90	**193**
12	4,76	**037**	9,95	**114**	4,38	**303**	8,33	**044**	131,90	**193**
16	4,76	**037**	9,95	**114**	4,38	**303**	8,33	**045**	131,90	**193**
20	4,76	**037**	9,95	**114**	4,38	**303**	8,33	**046**	131,90	**193**
25			12,10	**131**	4,38	**303**	8,33	**047**		
32			12,10	**131**	4,38	**303**	8,45	**048**		

XOHX / XOGX

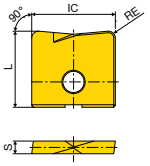
Oznaka	IC	S	L
	mm	mm	mm
XO.X10251..	10	2,50	11,5
XO.X12251..	12	2,50	14,0
XO.X12252..	12	2,50	14,0
XO.X16301..	16	3,00	16,0
XO.X16303..	16	3,00	16,0
XO.X20301..	20	3,00	18,0
XO.X20304..	20	3,00	18,0
XOHX06160..	6	1,60	8,0
XOHX08200..	8	2,00	9,5
XOHX08201..	8	2,00	9,5
XOHX10250..	10	2,50	11,5
XOHX12252..	12	3,00	14,0
XOHX20302..	20	3,00	18,0
XOHX25401..	25	4,00	23,5
XOHX25402..	25	4,00	23,5
XOHX25405..	25	4,00	23,5
XOHX32502..	32	5,00	28,0



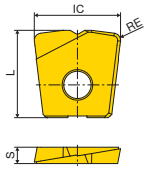
XOGX -MF4



XOHX -FM2, -MR2

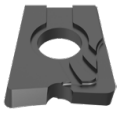
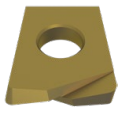
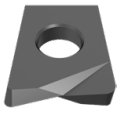


XOHX -FM5, -MR6



XOHX -MR3

XOHX / XOGX

	-MR2 CTPP211	-MR6 CTPP211	-FM2 CTPP216	-FM5 CTPP216	-MF4 CTPP216	-MR3 CTPK231	-MR2 CTCN211
							
	XOHX	XOHX	XOHX	XOHX	XOGX	XOHX	XOHX
	NEW WB	NEW WB	NEW WB	NEW WB	NEW WB	NEW WB	WB
ISO	RE	Artikl br. 56 167 ...	Artikl br. 56 163 ...	Artikl br. 56 165 ...	Artikl br. 56 159 ...	Artikl br. 56 161 ...	Artikl br. 56 171 ...	Artikl br. 56 168 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR	EUR
061605	0,5	32,08 71000						76,96 610 1)
082006	0,6		34,50 71000	30,37 71000	26,53 71000			
082010	1,0	35,11 71200		30,37 71200				92,10 612 1)
102508	0,8		34,50 72100	30,37 72100	26,23 72100		38,23 32100	
102510	1,0	35,11 72200		30,37 72200		30,67 92200		97,94 622 1)
122510	1,0	37,63 73200	37,63 73200	31,38 73200	29,56 73200	33,29 93200	38,23 53200	106,10 632 1)
122520	2,0	37,63 73500		31,38 73500		33,29 93500		
163010	1,0	40,65 74200		36,32 74200		37,63 94200		131,90 642 1)
163013	1,3		40,05 74300	36,32 74300	33,89 74300			
163015	1,5						40,65 54400	
163030	3,0	40,65 74700		36,32 74500		37,63 94700		
203010	1,0	46,81 75200		40,05 75200		42,47 95200		
203016	1,6		45,59 75400	40,05 75400	38,84 75400			
203020	2,0						48,02 55500	
203040	4,0	46,81 75800		40,05 75800		42,47 95800		
254010	1,0	59,72 76200		51,75 76200				
254020	2,0		62,74 76500	51,75 76500	54,17 76500			
254050	5,0	59,72 76900		51,75 76900				
325025	2,5		88,67 77600		75,16 77600			
Čelik		●	●	●	●	●	●	
Nehrđajući čelik		●	●	●	●	●	●	
Lijevano željezo		●	●	●	●	●	●	
Neželjezni metali		○	○					●
Visokootporan na toplinu		●	●	●	●	●	●	
Kaljeni čelik		○	○	●	●	●		

1) Specijalno za obradu grafita!

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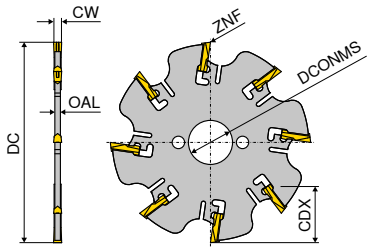
Priručnik za glodanje

Dubina postavljanja	→ 185	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 183+184

Pločasto glodalo, sustav FM

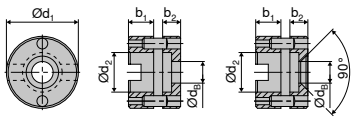
▲ Iz sigurnosnih razloga ne smije se prekoračiti brzina rezanja od 250 m/min!

Opseg isporuke:
Uklj. izbacivač



Oznaka	DC	CW	ZNF	CDX	OAL	DCONMS	RPMX	Okretna pločica	2B Artikl br. 50 756 ... EUR	
	mm	mm		mm	mm	mm	1/min.			
SF-1,8-Z 8-100	100	2,3	8	28	1,8	22	800	FM-2.3 ...	524,30	**100**
SF-2,4-Z 8-100	100	3,0	8	28	2,4	22	800	FM-3.0 ...	476,00	**102**
SF-2,8-Z 8-100	100	4,0	8	28	2,8	22	800	FM-4.0 ...	476,00	**104**
SF-3,7-Z 8-100	100	5,0	8	28	3,7	22	800	FM-5.0 ...	608,10	**106**
SF-4,7-Z 8-100	100	6,0	8	28	4,7	22	800	FM-6.0 ...	633,40	**108**
SF-1,8-Z 10-125	125	2,3	10	40	1,8	22	650	FM-2.3 ...	623,90	**110**
SF-2,4-Z 10-125	125	3,0	10	40	2,4	22	650	FM-3.0 ...	564,10	**112**
SF-2,8-Z 10-125	125	4,0	10	40	2,8	22	650	FM-4.0 ...	564,10	**114**
SF-3,7-Z 10-125	125	5,0	10	40	3,7	22	650	FM-5.0 ...	722,50	**116**
SF-4,7-Z 10-125	125	6,0	10	40	4,7	22	650	FM-6.0 ...	766,50	**118**
SF-2,4-Z 15-160	160	3,0	15	49	2,4	32	500	FM-3.0 ...	663,70	**120**
SF-2,8-Z 15-160	160	4,0	15	49	2,8	32	500	FM-4.0 ...	663,70	**122**
SF-3,7-Z 15-160	160	5,0	15	49	3,7	32	500	FM-5.0 ...	809,50	**124**
SF-4,7-Z 15-160	160	6,0	15	49	4,7	32	500	FM-6.0 ...	844,10	**126**

Zahvatni vijak



Tip	d_1 mm	d_2 mm	d_B mm	b_1 mm	b_2 mm	Ø mm	2A Artikl br. 70 950 ... EUR	
M22/2N	40	22	12	14,5	10	100/125	53,16	**800**
M32/2N	58	32	18	17,5	15	160	56,31	**801**
M22/2S	40	22	12	14,5	10	100/125	59,56	**802**
M32/2S	58	32	18	17,5	15	160	65,22	**803**

Izbacivač

2A Artikl br. 70 950 ... EUR	
3,72	**804**

FM

ISO	-N CWN35		-KXF CWN35		-N CWK12	
	FM V5		FM V5		FM V5	
	Artikl br. 50 491 ...		Artikl br. 50 492 ...		Artikl br. 50 491 ...	
	EUR		EUR		EUR	
FM-2.3-8	10,50	**023**	10,50	**023**	9,50	**123**
FM-3.0-8	10,50	**030**	10,50	**030**	9,50	**130**
FM-4.0-8	10,50	**040**	10,50	**040**	9,50	**140**
FM-5.0-8	13,29	**050**			12,97	**150**
FM-6.0-8	13,29	**060**			12,97	**160**
Čelik	●		●			
Nehrđajući čelik	●		●			
Lijevano željezo					●	
Neželjezni metali					●	
Visokootporan na toplinu						
Kaljeni čelik						

Priručnik za glodanje

Strategija obrade	→ 188	Sustav označavanja	→ 194+195
Opis vrsta	→ 209+210	Referentne vrijednosti podataka o rezanju	→ 187

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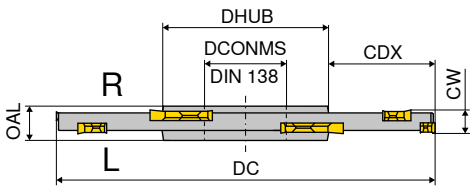
Glodalo za obrubljivanje s diskovima TX

- ▲ Pozor: Glodala za obrubljivanje s diskovima TX križno su ozubljena i opremljena okretnim pločicama u desnoj i lijevoj izvedbi
- ▲ ZEFP = broj okretnih pločica

Opseg isporuke:

Pločasto glodalo, 2 zamjenska stezna vijka i 1 Torx-ključ



Oznaka	DC	CW	ZNF	CDX	DCONMS	DHUB	OAL	ZEFP	Okretna pločica	Pritezni moment	V5 Artikl br. 50 730 ...	
	mm	mm		mm	mm	mm	mm			Nm	EUR	
TX.STF.80X27.03.Z4	80	3	4	18,0	27	40	8	8	TX. 161702	0,9	493,90	**083**
TX.STF.100X32.03.Z5	100	3	5	25,0	32	46	8	10	TX. 161702	0,9	621,80	**103**
TX.STF.125X40.03.Z6	125	3	6	32,0	40	54	10	12	TX. 161702	0,9	679,50	**123**
TX.STF.160X40.03.Z8	160	3	8	50,0	40	54	10	16	TX. 161702	0,9	793,80	**163**
TX.STF.80X27.04.Z4	80	4	4	18,0	27	40	8	8	TX. 162302	1,3	486,50	**084**
TX.STF.100X32.04.Z5	100	4	5	25,0	32	46	8	10	TX. 162302	1,3	613,40	**104**
TX.STF.125X40.04.Z6	125	4	6	32,0	40	54	10	12	TX. 162302	1,3	669,00	**124**
TX.STF.160X40.04.Z8	160	4	8	50,0	40	54	10	16	TX. 162302	1,3	783,30	**164**
TX.STF.80X27.06.Z4	80	6	4	21,0	27	36	10	8	TX. 223202	2	319,80	**086**
TX.STF.80X22.06.Z4	80	6	4	22,0	22	33	10	8	TX. 223202	2	319,80	**080**
TX.STF.100X32.06.Z5	100	6	5	25,5	32	47	10	10	TX. 223202	2	380,60	**106**
TX.STF.125X40.06.Z6	125	6	6	32,5	40	58	10	12	TX. 223202	2	513,80	**136**
TX.STF.160X40.06.Z8	160	6	8	50,0	40	58	10	16	TX. 223202	2	681,60	**166**
TX.STF.80X27.08.Z4	80	8	4	21,0	27	36	12	8	TX. 224302	2,8	319,80	**088**
TX.STF.100X32.08.Z5	100	8	5	25,5	32	47	12	10	TX. 224302	2,8	380,60	**108**
TX.STF.125X40.08.Z6	125	8	6	32,5	40	58	12	12	TX. 224302	2,8	513,80	**138**
TX.STF.160X40.08.Z8	160	8	8	50,0	40	58	12	16	TX. 224302	2,8	660,60	**168**
TX.STF.80X27.10.Z4	80	10	4	21,0	27	36	12	8	TX. 225402	3	319,80	**090**
TX.STF.100X32.10.Z5	100	10	5	25,5	32	47	12	10	TX. 225402	3	380,60	**110**
TX.STF.125X40.10.Z6	125	10	6	32,5	40	58	14	12	TX. 225402	3	513,80	**140**
TX.STF.160X40.10.Z8	160	10	8	50,0	40	58	14	16	TX. 225402	3	681,60	**170**

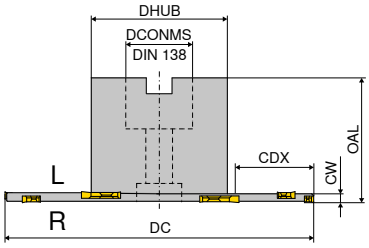
Rezervni dijelovi CW	Y7 TORX®-Izmjenjiva oštrica Artikl br. 80 950 ...		Y7 D-ključ Artikl br. 80 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		V5 Stezni vijak Artikl br. 70 950 ...		Y7 Momentni odvijač Artikl br. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR	
3	4,76	**032**	7,80	**109**	4,38	**303**	4,71	**858**	118,90	**191**
4	4,76	**033**	7,80	**110**	4,38	**303**	2,16	**218**	118,90	**191**
6	4,76	**036**	9,28	**113**	4,38	**303**	2,81	**101**	128,60	**192**
8	4,76	**037**	9,95	**114**	4,38	**303**	2,81	**135**	128,60	**192**
10	4,76	**037**	9,95	**114**	4,38	**303**	2,76	**146**	128,60	**192**

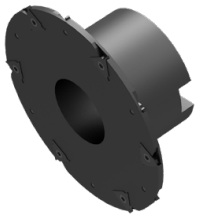
Utično pločasto glodalo TX

- ▲ Pozor: Glodala za obrubljivanje s diskovima TX križno su ozubljena i opremljena okretnim pločicama u desnoj i lijevoj izvedbi
- ▲ ZEFP = broj okretnih pločica

Opseg isporuke:

Pločasto glodalo, 2 zamjenska stezna vijka i 1 Torx-ključ





Oznaka	DC	CW	ZNF	CDX	DCONMS	DHUB	OAL	ZEFP	Pritezni moment	Okretna pločica	V5 Artikl br. 50 734 ...	
	mm	mm		mm	mm	mm	mm		Nm		EUR	
TX.ASF.100.R.03.Z5	100	3	5	25,0	27	48	50	10	0,9	TX. 161702	565,10	**300**
TX.ASF.125.R.03.Z6	125	3	6	37,5	27	48	50	12	0,9	TX. 161702	877,60	**225**
TX.ASF.160.R.03.Z8	160	3	8	44,0	40	70	50	16	0,9	TX. 161702	940,50	**260**
TX.ASF.100.R.04.Z5	100	4	5	25,0	27	48	50	10	3,2	TX. 162302	556,80	**100**
TX.ASF.125.R.04.Z6	125	4	6	37,5	27	48	50	12	3,2	TX. 162302	804,30	**025**
TX.ASF.125.R.04.Z6	125	4	6	26,5	40	70	50	12	3,2	TX. 162302	783,30	**125**
TX.ASF.160.R.04.Z8	160	4	8	55,0	27	48	50	16	3,2	TX. 162302	980,40	**060**
TX.ASF.160.R.04.Z8	160	4	8	44,0	40	70	50	16	3,2	TX. 162302	926,90	**160**
TX.ASF.180.R.04.Z9	180	4	9	54,0	40	70	50	18	3,2	TX. 162302	1.072,00	**180**
TX.ASF.200.R.04.Z10	200	4	10	64,0	40	70	50	20	3,2	TX. 162302	1.194,00	**200**

Rezervni dijelovi CW	DCONMS	V5 Podložna pločica Artikl br. 70 950 ... EUR		Y7 TORX®-Izmjenjiva oštrica Artikl br. 80 950 ... EUR		V5 Stezni vijak Artikl br. 70 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		V5 Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
3	40	1,63	**222**	4,76	**032**	7,03	**220**	7,80	**109**	4,38	**303**	4,71	**858**	118,90	**191**
3	27	1,08	**221**	4,76	**032**	1,63	**219**	7,80	**109**	4,38	**303**	4,71	**858**	118,90	**191**
4	27	1,08	**221**	4,76	**033**	1,63	**219**	7,80	**110**	4,38	**303**	2,16	**218**	128,60	**192**
4	40	1,63	**222**	4,76	**033**	7,03	**220**	7,80	**110**	4,38	**303**	2,16	**218**	128,60	**192**

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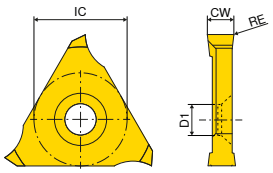
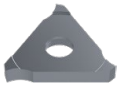
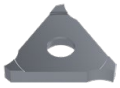
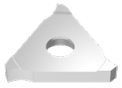
TX-L / TX-R

Oznaka	IC	D1	CW
	mm	mm	mm
TX . 1617..	10	3,95	1,7
TX . 1623..	10	3,95	2,3
TX . 2232..	13	5,50	3,2
TX . 2243..	13	5,50	4,3
TX . 2254..	13	5,50	5,4



TX-L / TX-R

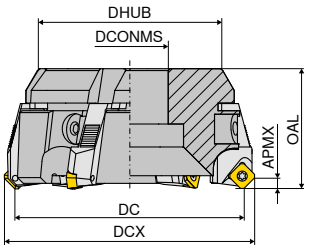
ISO	RE	CWX500		CWX500		CWK10		CWK10	
									
		TX-L		TX-R		TX-L		TX-R	
		V5		V5		V5		V5	
		Artikl br. 50 382 ...		Artikl br. 50 381 ...		Artikl br. 50 382 ...		Artikl br. 50 381 ...	
	mm	EUR		EUR		EUR		EUR	
TX 161702	0,2	19,78	217	19,78	217				
TX 162302	0,2	19,56	223	19,56	223				
TX 223202	0,2	29,52	232	29,52	232	26,16	532	26,16	532
TX 224302	0,2	29,83	243	29,83	243	26,70	543	26,70	543
TX 225402	0,2	22,16	254	22,16	254	19,02	554	19,02	554
Čelik		●		●					
Nehrđajući čelik		●		●					
Lijevano željezo		●		●					
Neželjezni metali						●		●	
Visokootporan na toplinu		●		●					
Kaljeni čelik									

Priručnik za glodanje

Opis vrsta → 209+210
Sustav označavanja → 194+195
Referentne vrijednosti podataka o rezanju → 187

MaxiMill – Osnovno tijelo kombiniranog glodala 260

▲ Osnovno tijelo sa steznim klinovima, bez kazeta



DC	ZNF	DCONMS	DHUB	OAL	WT	2B/40 Artikl br. 50 715 ...	
mm		mm	mm	mm	kg	EUR	
80	5	27	66	52	1	367,30	**080**
100	6	32	86	52	2	402,30	**100**
125	7	40	95	63	3	560,20	**125**
160	10	40	130	63	6	614,40	**160**
200	12	60	172	63	9	785,20	**200**
250	14	60	222	63	17	1.017,00	**250**
315	18	60	280	80	31	1.063,00	**315**
400	22	60	365	80	52	2.292,00	**400**

Za informacije o planiranom vremenu rada gledajte → **Stranica 189.**

Rezervni dijelovi DC	2A/28 Vijak steznog klina Artikl br. 70 950 ...		2A/28 Stezni klin Artikl br. 70 950 ...		2A/28 T-ključ Artikl br. 70 950 ...		2A/28 Pasta Molykote Artikl br. 70 950 ...		2A/28 Ekscentrični ključ Artikl br. 70 950 ...	
	EUR		EUR		EUR		EUR		EUR	
80 - 400	2,98	**297**	17,47	**296**	7,09	**317**	4,38	**303**	12,37	**298**

Promjer s umetnutim okretnim pločicama

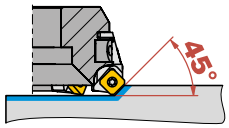
		Nazivni Ø u mm															
		80		100		120		160		200		250		315		400	
	Okretna pločica	DC mm	DCX mm	DC mm	DCX mm	DC mm	DCX mm	DC mm	DCX mm	DC mm	DCX mm	DC mm	DCX mm	DC mm	DCX mm	DC mm	DCX mm
	SD.. 0903..	80	88,4	100	108,4	123	131,4	158	166,4	198	206,4	248	256,4	313	321,4	398	406,4
	SD.. 1204..	80	94,5	100	114,5	123	137,5	158	172,5	198	212,5	248	262,5	313	327,5	398	412,5
	SE.. 1204..	80	93	100	113	123	136	158	171	198	211	248	261	313	326	398	411
	SD.. 1504..	75	94	95	114	118	137	153	172	193	212	243	262	308	327	393	412
	SP.. 1204..	82	88	102	108	125	131	160	166	200	206	250	256	315	321	400	406
	OA.. 0605..	80	85,6	100	105,6	123	128,6	158	163,6	198	203,6	248	253,6	313	318,6	398	403,6
	RP.X 1204..	80	92	100	112	123	135	158	170	198	210	248	260	313	325	398	410
	RP.X 16..	76	92	96	112	119	135	154	170	194	210	244	260	309	325	394	410
	SD.. 1205..	89		109		132		167		207		257		322		407	
	SD.. 09T3	89		109		132		167		207		257		322		407	
	LD..1504..	89		109		132		167		207		257		322		407	
	XD.T 11T3	89		109		132		167		207		257		322		407	
	XDKT 1505	89		109		132		167		207		257		322		407	
	AP.. 1003..	89		109		132		167		207		257		322		407	
	TPKW 2204..	89		109		132		167		207		257		322		407	

15

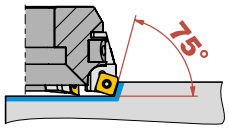
Sustav MaxiMill 260 / kombinirano glodalo

Kazete za okretne rezne pločice

Ravno glodanje

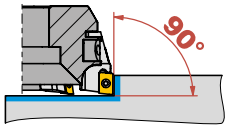


Br. kazete		SD.. 0903..	SD.. 1204..	SE.. 1204..	SD.. 1504..		OA.. 0605..
		041	**031**	**029**	**032**		**057**
Artikl br.	**70 950 ...**	**329**	**411**	**306**	**412**		**338**



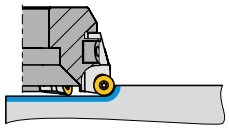
Br. kazete		SP.. 1204..	
		018	
Artikl br.	**70 950 ...**	**310**	

Kutno glodanje



Br. kazete		AP.. 1003..	LD.. 1504..	XD.T 11T3..	XDKT 1505..		SD.. 1205..	SD.. 09T3..		TPKW 2204..	
		042	**051**	**054**	**056**		**039**	**055**		**025**	
Artikl br.	**70 950 ...**	**307**	**300**	**336**	**339**		**311**	**337**		**313**	

Planarno/kopirno glodalo



Br. kazete		RP.X 1204..	RP.X 16....
		052	**053**
Artikl br.	**70 950 ...**	**333**	**707**

Okretna pločica	APMX	Kazete 2B/40 Artikl br. 70 950 ...	
	mm	EUR	
AP.. 1003..	8,0	84,26	**307**
LD.. 1504..	14,0	84,26	**300**
OA.. 0605..	3,5	84,26	**338**
RP.X 1204..	6,0	84,26	**333**
RP.X 16..	8,0	84,26	**707**
SD.. 0903..	4,0	84,26	**329**
SD.. 09T3..	8,0	84,26	**337**
SD.. 1204..	6,0	84,26	**411**
SD.. 1205..	6,0	84,26	**311**
SD.. 1504..	9,0	84,26	**412**
SE.. 1204..	6,0	84,26	**306**
SP.. 1204..	9,0	84,26	**310**
TPKW 2204..	18,0	84,26	**313**
XD.T 11T3	10,0	84,26	**336**
XDKT 1505..	14,0	84,26	**339**

Rezervni dijelovi	Y7 TORX®– Izmjenjiva oštrica Artikl br. 80 950 ... EUR		Y7 D-ključ Artikl br. 80 950 ... EUR		2A/28 Pasta Molykote Artikl br. 70 950 ... EUR		2A Stezni vijak Artikl br. 70 950 ... EUR		Y7 Momentni odvijač Artikl br. 80 950 ... EUR	
AP.. 1003..	4,76	**033**	7,80	**110**	4,38	**303**	2,36	**112**	118,90	**191**
OA.. 0605..	4,76	**037**	9,95	**114**	4,38	**303**	4,09	**302**	131,90	**193**
RP.X 1204.. / LD.. 1504..	4,76	**036**	9,28	**113**	4,38	**303**	3,14	**304**	128,60	**192**
SD.. 0903..	4,76	**033**	7,80	**110**	4,38	**303**	2,57	**115**	118,90	**191**
SD.. 09T3..	4,76	**036**	9,28	**113**	4,38	**303**	3,14	**110**	128,60	**192**
SD.. 1204.. / SE.. 1204.. / SP.. 1204.. / SD.. 1205.. / SD.. 1504.. / RP.X 16.. / TPKW 2204..	4,76	**037**	9,95	**114**	4,38	**303**	2,52	**280**	131,90	**193**
XD.T.. 11T3..	4,76	**043**	10,20	**125**	4,38	**303**	4,09	**131**	118,90	**191**
XDKT 1505..	5,26	**054**	11,89	**128**	4,38	**303**	3,18	**839**	128,60	**192**

Primjeri materijala za rezne tablice podataka

	Indeks	Materijal	Čvrstoća N/mm² / HB / HRC	Broj materijala	Oznaka materijala	Broj materijala	Oznaka materijala	Broj materijala	Oznaka materijala
P	1.1	Opći konstrukcijski čelik	< 800 N/mm²	1.0037	St 37-2	1.0570	St 52-3	1.0060	St 60-2
	1.2	Strojni čelik	< 800 N/mm²	1.0718	9 SMnPb 28	1.0727	45 S 20	1.0757	46 SPb 2
	1.3	Čelik za cementiranje nelegirani	< 800 N/mm²	1.0401	C 15	1.0481	17 Mn 4	1.1141	Ck 15
	1.4	Čelik za cementiranje legirani	< 1000 N/mm²	1.7131	16 MnCr 5	1.7015	13 Cr 3	1.5919	15 CrNi 6
	1.5	Kaljeni čelik nelegirani	< 850 N/mm²	1.0503	C 45	1.1191	Ck 45	1.0535	C 55
	1.6	Kaljeni čelik nelegirani	< 1000 N/mm²	1.0601	C 60	1.1221	Ck 60	1.0540	C 50
	1.7	Kaljeni čelik legirani	< 800 N/mm²	1.5131	50 MnSi 4	1.7030	28 Cr 4	1.7225	42 CrMo 4
	1.8	Kaljeni čelik legirani	< 1300 N/mm²	1.5755	31 NiCr 14	1.7033	34 Cr 4	1.3565	48 CrMo 4
	1.9	Lijevani čelik	< 850 N/mm²	0.9650	G-X 260 Cr 27	1.6750	GS-20 NiCrMo 3 7	1.6582	GS-34 CrNiMo 6
	1.10	Nitrirani čelik	< 1000 N/mm²	1.8504	34 CrAl 6	1.8507	34 AlMo 5	1.8509	41 CrAlMo 7
	1.11	Nitrirani čelik	< 1200 N/mm²	1.8515	31 CrMo 12	1.8523	39 CrMoV 19 3	1.8550	34 CrAlNi 7
	1.12	Čelik za valjkaste ležajeve	< 1200 N/mm²	1.3505	100 Cr6 (W3)	1.3543	X 192 CrMo 17	1.3520	100 CrMn 6
	1.13	Opružni čelik	< 1200 N/mm²	1.5026	55 Si 7	1.7176	55 Cr 3	1.7701	51 CrMoV 4
	1.14	Čelik za brzu obradu	< 1300 N/mm²	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/mm²	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/mm²	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 sulfurirani	< 850 N/mm²	1.3941	G-X 4 CrNi 18 13	1.4027	G-X 20 Cr 14	1.4107	G-X 8 CrNi 12
	2.2	Nehrđajući čelik, feritni	< 750 N/mm²	1.4510	X 3 CrTi 17	1.4528	X 105 CrCoMo 18 2	1.4016	X 6 Cr 17
	2.3	Nehrđajući čelik, martenzitni	< 900 N/mm²	1.4034	X 46 Cr 13	1.4116	X 50 CrMoV 15	1.4106	X 2 CrMoSiS 18 2 1
	2.4	Nehrđajući čelik, feritni/martenzitni	<1100 N/mm²	1.4313	X 3CrNi 13 4	1.4028	X 30 Cr 13	1.4104	X 14 CrMoS 17
	2.5	Nehrđajući čelik, austenitni/feritni	< 850 N/mm²	1.4460	X 8 CrNiMo 27 5	1.4821	X 20 CrNiSi 25 4	1.4462	X 2 CrNiMoN 22 5 3
	2.6	Nehrđajući čelik, austenitni	< 750 N/mm²	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/mm²	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/mm²	0.6010	GG-10	0.6025	GG-25		
	3.2	Sivo lijevano željezo s lamelnim grafitom	300–500 N/mm²	0.6030	GG-30	0.6045	GG-45		
	3.3	Sivi lijev sa sferoidalnim grafitom	300–500 N/mm²	0.7040	GGG-40	0.7050	GGG-50		
	3.4	Sivi lijev sa sferoidalnim grafitom	500–900 N/mm²	0.7060	GGG-60	0.7080	GGG-80		
	3.5	Temperirani lijev, bijeli	270–450 N/mm²	0.8035	GTW-35	0.8045	GTW-45		
	3.6	Temperirani lijev, bijeli	500–650 N/mm²	0.8055	GTW-55	0.8065	GTW-65		
	3.7	Temperirani lijev, crni	300–450 N/mm²	0.8135	GTS-35	0.8145	GTS-45		
	3.8	Temperirani lijev, crni	500–800 N/mm²	0.8155	GTS-55	0.8170	GTS-70		
N	4.1	Aluminij (nelegirani, nisko legirani)	< 350 N/mm²	3.0255	Al99,5	3.3308	Al99,9Mg0,5	3.0256	E-Al H
	4.2	Legure aluminija < 0,5 % Si	< 500 N/mm²	3.0515	AlMn1	3.1355	AlCuMg2	3.3315	AlMg1
	4.3	Legure aluminija 0,5–10 % Si	< 400 N/mm²	3.2315	AlMgSi1	3.2373	G-AlSi9Mg	3.2134	G-AlSi5Cu1Mg
	4.4	Legure aluminija 10-15 % Si	< 400 N/mm²	3.2581	G-AlSi12	3.2583	G-AlSi12(Cu)		
	4.5	Legure aluminija > 15 % Si	< 400 N/mm²		G-AlSi17Cu4		G-AlSi25CuNiMg		G-AlSi21CuNiMg
	4.6	Bakar (nelegirani, nisko legirani)	< 350 N/mm²	2.0060	E-Cu57	2.0090	SF-Cu	2.1522	CuSI2Mn
	4.7	Kovane legure bakra	< 700 N/mm²	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/mm²	2.0331	CuZn36Pb1,5	2.0380	CuZn39Pb2 (Ms58)	2.0410	CuZn44Pb2
	4.12	Mesing s dugim strugotinama	< 600 N/mm²	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/mm²	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/mm²	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/mm²	2.4886	SG-NiMo16Cr16W	2.4854	NiFe33Cr25Co	2.4816	NiCr15Fe
	5.6	Legure kobalta i kroma	< 1300 N/mm²	2.4711	CoCr20Ni15Mo	2.4964	CoCr20W15Ni	2.4989	CoCr20NiW
	5.7	Legure visokootporne na toplinu	< 1300 N/mm²	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/mm²	2.4806	SG-NiCr20Nb, Inconel 82	2.4851	NiCr23Fe, Inconel 601	2.4667	SG-NiCr19NbMoTi
	5.9	Čisti titanij	< 900 N/mm²	3.7025	Ti99,8	3.7034	Ti99,7	3.7064	Ti99,5
	5.10	Legure titanija	< 700 N/mm²	3.7114	TiAl5Sn2	3.7174	TiAl6V6Sn2	3.7124	TiCu2
	5.11	Legure titanija	< 1200 N/mm²	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 podataka o rezanju

Rezni materijal **tvrdi** (v_c↑) → **žilav** (v_c↓)

	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN				DRAGONSKIN				DRAGONSKIN		DRAGONSKIN		DRAGONSKIN					
	CERMET		CERMET																							
	CTEP210 (DCC1210)		TCM10 (CWC10)		CTCP220 (DCX1220)		CTPP225 (DPX1225)		CTCP230 (DCX1230)		CTPP231		CTPP235 (DPX1235)		CTPP236		CTPM225 (DPX2225)		CTCM235 (DCX2235)		CTPM240 (DPX2240)		CTPM241		CTPM245 (DPX2245)	
Indeks																										
1.1	**320**		**280**		**320**	170	**300**	160	**280**	170	**200**	**100**	**240**	140	**300**	**180**	270	160	240	140	220	130	**200**	**100**		
1.2	**400**		**350**		**280**	150	**250**	130	**230**	140	**170**	**90**	**190**	110	**250**	**150**	220	130	190	110	170	100	**170**	**90**		
1.3	**350**		**300**		**320**	170	**300**	160	**280**	170	**200**	**100**	**240**	140	**300**	**180**	270	160	240	140	220	130	**200**	**100**		
1.4	**330**		**300**		**300**	150	**280**	140	**250**	150	**170**	**90**	**220**	130	**270**	**160**	240	140	210	130	200	120	**170**	**90**	**250**	
1.5	**400**		**350**		**300**	150	**280**	140	**250**	150	**170**	**90**	**210**	130	**270**	**160**	230	140	210	130	190	110	**170**	**90**		
1.6	**350**		**300**		**300**	150	**280**	140	**250**	150	**170**	**90**	**210**	130	**270**	**160**	230	140	210	130	190	110	**170**	**90**		
1.7	**280**		**250**		**300**	150	**280**	140	**250**	150	**170**	**90**	**220**	130	**270**	**160**	240	140	210	130	200	120	**170**	**90**	**220**	
1.8	**320**		**280**		**250**	120	**220**	110	**190**	110	**150**	**80**	**160**	100	**210**	**120**	180	100	150	90	140	80	**150**	**80**	**180**	
1.9	**250**		**230**		**280**	140	**250**	130	**230**	140	**200**	**110**	**200**	120	**250**	**150**	220	130	200	120	180	100	**180**	**100**	**250**	
1.10	**280**		**250**		**300**	150	**280**	140	**250**	150	**170**	**90**	**220**	130	**270**	**160**	240	140	210	130	200	120	**170**	**100**	**220**	
1.11	**300**		**250**		**190**	100	**170**	90	**140**	90	**120**	**70**	**120**	70	**160**	**100**	140	80	100	60	100	60	**120**	**80**	**180**	
1.12	**300**		**250**		**300**	150	**280**	140	**250**	150	**170**	**90**	**220**	130	**270**	**160**	240	140	210	130	200	120	**170**	**100**	**250**	
1.13					**300**	150	**280**	140	**250**	150	**170**	**90**	**210**	130	**270**	**160**	230	140	210	130	190	110	**170**	**100**	**250**	
1.14					**150**	70	**130**	70	**100**	60	**120**	**70**	**90**	50	**150**	**100**	170	100	120	70	90	50	**120**	**80**	**120**	
1.15	**280**		**250**		**180**	90	**150**	90	**130**	80	**140**	**80**	**110**	70	**180**	**140**	180	110	150	90	120	70	**140**	**90**	**220**	
1.16	**280**		**250**		**180**	90	**150**	90	**130**	80	**140**	**80**	**110**	70	**180**	**140**	180	110	150	90	120	70	**180**	**100**	**160**	
2.1									90	60			80	50			170	**100**	110	**70**	80	**50**	**210**	**100**	**240**	
2.2			**280**						130	80			110	70			180	**110**	150	**90**	120	**70**	**210**	**100**	**240**	
2.3			**250**						90	60			80	50			170	**100**	110	**70**	80	**50**	**210**	**100**	**260**	
2.4									130	80			110	70			180	**110**	150	**90**	120	**70**	**210**	**100**	**280**	
2.5													190	110			280	**160**	250	**140**	190	**110**	**210**	**100**	**180**	160
2.6													190	110			280	**160**	260	**150**	210	**120**	**210**	**100**	**200**	180
2.7													190	110			280	**160**	260	**150**	210	**120**	**210**	**100**	**150**	130
3.1	**380**										**150**	**110**			**360**	**90**										
3.2	**300**		250								**150**	**110**			**360**	**90**										
3.3	**400**		350								**150**	**110**			**230**	**170**										
3.4	**350**		300								**150**	**110**			**160**	**110**										
3.5	**380**		330												**250**	**180**										
3.6	**250**														**250**	**180**										
3.7	**350**		300												**210**	**160**										
3.8	**280**														**210**	**160**										
4.1																										
4.2																										
4.3																										
4.4																										
4.5																										
4.6																										
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4.12																										
4.13																										
4.14																										
4.15																										
4.16																										
4.17																										
4.18																										
4.19																										
5.1																							**80**	**40**		
5.2																							**80**	**40**		
5.3																							**80**	**40**		
5.4																							**80**	**40**		
5.5																							**80**	**40**		
5.6																							**80**	**40**		
5.7																							**80**	**40**		
5.8																							**80**	**40**		
5.9																							**80**	**40**		
5.10																							**90**	**50**		
5.11																							**90**	**50**		
6.1											**120**	**50**			**130**	**60**										
6.2																										
6.3																										
6.4																										
6.5																										

Referentne vrijednosti podataka o rezanju

	Rezni materijal **tvrdi** (v_c↑) → **žilav** (v_c↓)																					
							DRAGONSKIN		DRAGONSKIN								DRAGONSKIN					
	CERAMIC		CBN																			
	CTN3105 CTS3105		CTL3215 CWB3215		CTPK221		CTCK215 DCX3215		CTPK220 DPX3220		H216T CWK 26		AMZ AMZ		CTWN215 CWK 4615		CTC5240 HCF 5240		CTCS245		CTP6215 CCN6215	
Indeks																						
1.1					**190**	**120**	350	210	300	180												
1.2					**180**	**100**	300	180	250	150												
1.3					**190**	**120**	350	210	300	180												
1.4					**180**	**100**																
1.5					**180**	**100**	320	190	270	160												
1.6					**180**	**100**	320	190	270	160												
1.7					**180**	**100**																
1.8					**180**	**100**																
1.9					**200**	**120**	300	180	260	160												
1.10					**180**	**100**																
1.11					**120**	**70**																
1.12					**180**	**100**																
1.13					**180**	**100**	320	190	270	160												
1.14					**120**	**70**																
1.15					**210**	**120**																
1.16					**210**	**120**																
2.1																						
2.2																						
2.3																						
2.4																						
2.5																						
2.6																						
2.7																						
3.1	**400–1500**		**500–1000**		**270**	**200**	**360**	160	**320**	160	110	110	140		80	80					**280**	250
3.2	**300–800**		**500–1000**		**270**	**200**	**360**	160	**320**	160	110	110	140		80	80					**280**	250
3.3					**250**	**180**	**230**	140	**210**	130	130	130	150		80	80					**180**	150
3.4			**350–650**		**180**	**120**	**160**	100	**140**	80	130	130	150		80	80					**180**	150
3.5					**270**	**190**	**250**	150	**200**	120	130	130	150		80	80					**250**	220
3.6					**270**	**190**	**250**	150	**200**	120	130	130	150		80	80					**250**	220
3.7					**220**	**170**	**210**	130	**170**	100	130	130	150		80	80					**190**	160
3.8					**220**	**170**	**210**	130	**170**	100	130	130	150		80	80					**190**	160
4.1												**1500**		**1500**		**280**						
4.2												**1500**		**1500**		**250**						
4.3												**400**		**400**		**800**						
4.4												**350**		**350**		**800**						
4.5																**500**						
4.6												**500**		**500**		**200**						
4.7												**500**		**500**	80	**80**						
4.8												**500**		**500**	80	**80**						
4.9												**500**		**500**	80	**80**						
4.10												**300**		**300**	70	**70**						
4.11												**800**		**800**	80	**80**						
4.12												**800**		**800**	80	**80**						
4.13												**350**		**350**	80	**80**						
4.14												**350**		**350**	80	**80**						
4.15												**350**		**350**	80	**80**						
4.16												**150**		**150**	80	**110**						
4.17											**90**				80	**80**						
4.18												**90**		**90**		**90**						
4.19												**130**		**130**		**130**						
5.1																		**50**		**30–50**		
5.2																		**50**		**30–50**		
5.3																		**50**		**30–50**		
5.4																		**40**		**30–50**		
5.5																		**40**		**30–50**		
5.6																		**40**		**30–50**		
5.7																		**40**		**30–50**		
5.8																		**40**		**30–50**		
5.9																		**90**				
5.10																		**60**				
5.11																		**60**				
6.1					**180**	**120**															**50**	
6.2					**160**	**100**															**50**	
6.3			110–190																		**40**	
6.4																						
6.5																						

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Sustav MaxiMill 274-04/-09

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Sustav Maximill 274 OFHT-04

	F			M			R		
Materijal	m/min	f_z mm	a_p mm	m/min	f_z mm	a_p mm	m/min	f_z mm	a_p mm
Čelik	50–350	0,1–0,25	2,5	60–280	0,1–0,3	2,5	60–280	0,1–0,3	2,5
Nehrđajući čelik	60–270	0,1–0,25	2,5	60–270	0,1–0,3	2,5	60–270	0,1–0,3	2,5
Lijevano željezo				130–360	0,1–0,3	2,5	130–360	0,1–0,3	2,5
Neželjezni metali	160–1500	0,05–0,4	2,5	160–1500	0,05–0,4	2,5	160–1500	0,05–0,4	2,5
Visokootporan na toplinu	25–80	0,1–0,25	2,5	25–80	0,1–0,25	2,5			
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

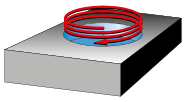
Sustav MaxiMill 274 SFKT-09

	F			M			R		
Materijal	m/min	f_z mm	a_p mm	m/min	f_z mm	a_p mm	m/min	f_z mm	a_p mm
Čelik	50–350	0,1–0,25	3,8	60–280	0,1–0,3	3,8	60–280	0,1–0,3	3,8
Nehrđajući čelik	60–270	0,1–0,25	3,8	60–270	0,1–0,3	3,8	60–270	0,1–0,3	3,8
Lijevano željezo	110–130	0,05–0,4		130–360	0,1–0,35	3,8	130–360	0,1–0,35	3,8
Neželjezni metali	160–1500	0,05–0,4	3,8	160–1500	0,05–0,4	3,8	160–1500	0,05–0,4	3,8
Visokootporan na toplinu	25–80	0,1–0,25	3,8	25–80	0,1–0,25	3,8	25–80	0,1–0,25	3,8
Kaljeni čelik									

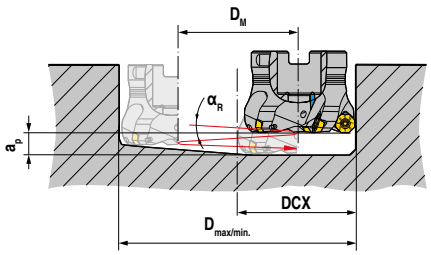
Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

Potopno glodanje cirkularno



$D_{maks.}$ u mm = Najveći promjer za ravne površine podloge
$D_{min.}$ u mm = Najmanji promjer provrta za ravne površine podloge
D_M = $D_{maks.}$ – DCX odn. $D_{min.}$ – DCX



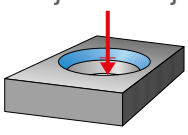
OF..04

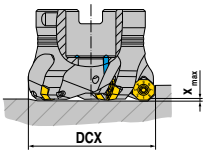
DCX mm	D_{max} mm	D_{min} mm	$\alpha_{R\,max}$ °
25,6	45	39	2,3
30,7	55	49	1,9
37,7	69	63	1,4
45,7	85	79	1,2
55,7	105	99	0,9
68,7	131	125	0,7
85,7	165	159	0,6
105,7	205	199	0,5
130,7	255	249	0,4

SF..09

DCX mm	D_{max} mm	D_{min} mm	$\alpha_{R\,max}$ °
27,4	45,00	42,0	1,9
32,5	55,00	52,0	1,5
39,2	69,00	66,0	1,1
47,6	85,00	82,0	0,9
57,6	105,00	102,0	0,7
70,5	131,00	128,0	0,5
87,5	165,00	162,0	0,4
107,5	205,00	202,0	0,3
132,5	255,00	252,0	0,3

Aksijalno uranjanje





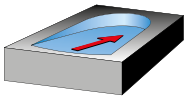
OF..04

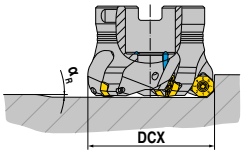
DCX mm	x_{max} mm
25,6	2,5
30,7	2,5
37,7	2,5
45,7	2,5
55,7	2,5
68,7	2,5
85,7	2,5
105,7	2,5
130,7	2,5

SF..09

DCX mm	x_{max} mm
27,4	3,7
32,5	3,5
39,2	3,2
47,6	3,1
57,6	3,1
70,5	3,0
87,5	2,9
107,5	2,7
132,5	2,7

Koso uranjanje





OF..04

DCX mm	$\alpha_{R\,max}$ °
25,6	14,2
30,7	9,5
37,7	6,5
45,7	4,7
55,7	3,5
68,7	2,7
85,7	2,0
105,7	1,6
130,7	1,2

SF..09

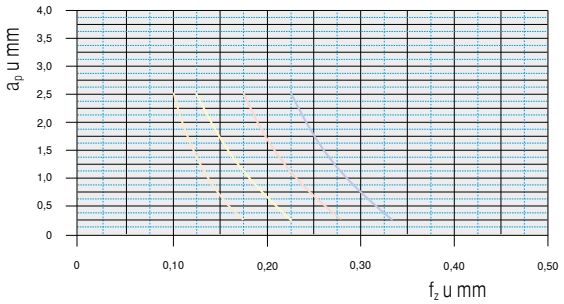
DCX mm	$\alpha_{R\,max}$ °
27,4	20,4
32,5	13,0
39,2	8,0
47,6	5,8
57,6	4,3
70,5	3,2
87,5	2,3
107,5	1,7
132,5	1,3

Sustav MaxiMill 274-04

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

OF.. 04



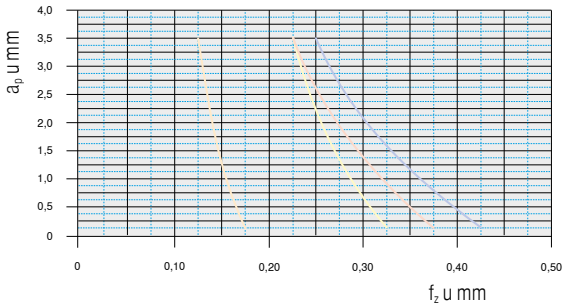
Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**OFHT040305SN-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**OFHT040305SN-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**OFHT040305SN-M50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**OFHT040305SN-F50**	**CTC5240** (HCF5240)	35	Emulzija

Sustav MaxiMill 274-09

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

SF.. 09



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**SFKT0903AFSR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**SFHT0903AFSR-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**SFKT0903AFSR-R50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**SFHT0903AFSR-F50**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 274-05/-12

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Sustav MaxiMill 274 OFHT-05

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	50–350	0,1–0,25	3	60–280	0,1–0,3	3	60–280	0,1–0,3	3
Nehrđajući čelik	60–270	0,1–0,25	3	60–270	0,1–0,3	3	60–270	0,1–0,3	3
Lijevano željezo				130–360	0,1–0,3	3	130–360	0,1–0,3	3
Neželjezni metali	160–1500	0,05–0,4	3	160–1500	0,05–0,4	3	160–1500	0,05–0,4	3
Visokootporan na toplinu	25–80	0,1–0,25	3	25–80	0,1–0,25	3			
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

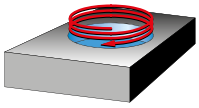
Sustav MaxiMill 274 SFKT-12

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	50–350	0,1–0,25	6	60–280	0,1–0,3	6	60–280	0,1–0,3	6
Nehrđajući čelik	60–270	0,1–0,25	6	60–270	0,1–0,3	6	60–270	0,1–0,3	6
Lijevano željezo	110–130	0,05–0,4		130–360	0,1–0,35	6	130–360	0,1–0,35	6
Neželjezni metali	160–1500	0,05–0,4	6	160–1500	0,05–0,4	6	160–1500	0,05–0,4	6
Visokootporan na toplinu	25–80	0,1–0,25	6	25–80	0,1–0,25	6	25–80	0,1–0,25	6
Kaljeni čelik									

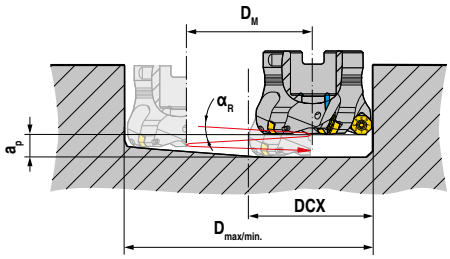
Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

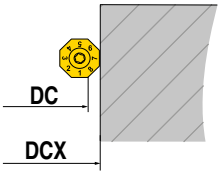
Strategija obrade

Potopno glodanje cirkularno



$D_{maks.}$ u mm = Najveći promjer za ravne površine podloge
$D_{min.}$ u mm = Najmanji promjer provrta za ravne površine podloge
D_M = $D_{maks.}$ – DCX odn. $D_{min.}$ – DCX





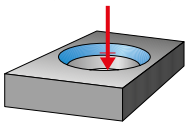
OF..05

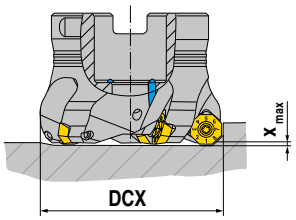
DC mm	DCX mm	D_{max} mm	D_{min} mm	$\alpha_{R\,max}$ °
50	**58**	107	99	1,1
63	**71**	133	125	0,9
80	**88**	167	159	0,7
100	**107,9**	207	199	0,5
125	**132,9**	257	249	0,4

SF..12

DC mm	DCX mm	D_{max} mm	D_{min} mm	$\alpha_{R\,max}$ °
47,0	**61,0**	107	105	0,5
59,9	**74,0**	133	131	0,4
76,9	**90,9**	167	165	0,3
96,9	**110,9**	207	205	0,25
121,9	**135,9**	257	255	0,2

Aksijalno uranjanje





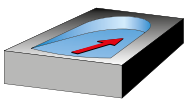
OF..05

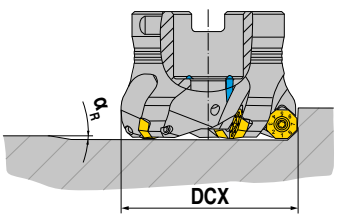
DC mm	DCX mm	X_{max} mm
50	**58**	2,2
63	**71**	1,9
80	**88**	1,8
100	**107,9**	1,1
125	**132,9**	1,4

SF..12

DC mm	DCX mm	X_{max} mm
47,0	**61,0**	3,4
59,9	**74,0**	3,2
76,9	**90,9**	3,0
96,9	**110,9**	2,5
121,9	**135,9**	2,6

Koso uranjanje





OF..05

DC mm	DCX mm	$\alpha_{R\,max}$ °
50	**58**	3,2
63	**71**	2,0
80	**88**	1,5
100	**107,9**	0,7
125	**132,9**	0,7

SF..12

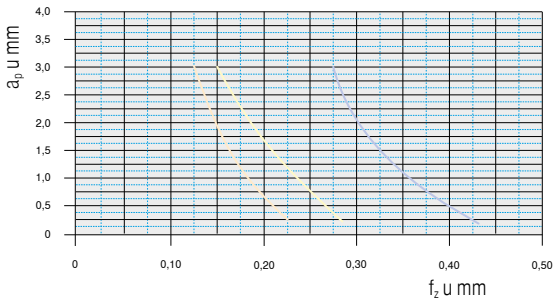
DC mm	DCX mm	$\alpha_{R\,max}$ °
47,0	**61,0**	4,9
59,9	**74,0**	3,4
76,9	**90,9**	2,4
96,9	**110,9**	1,6
121,9	**135,9**	1,3

Sustav MaxiMill 274-05

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

OF.. 05



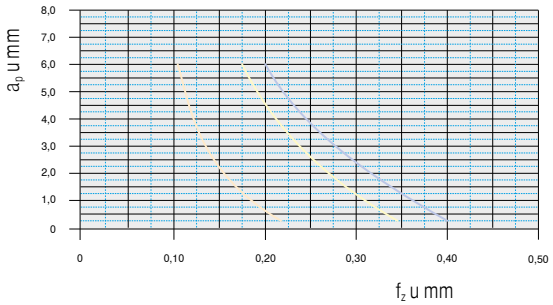
Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**OFHT050410SN-M50**	**CTCP230** (DCX1230)	200	Suho
Nehrđajući čelik	1.4571	**OFHT050410SN-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301				
Visokootporan na toplinu	2.4856	**OFHT050410SN-F50**	**CTC5240** (HCF5240)	35	Emulzija

Sustav MaxiMill 274-12

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

SF.. 12



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**SFKT1204AFSR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**SFKT1204AFSR-M50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301				
Visokootporan na toplinu	2.4856	**SFHT1204AFER-F40**	**CTC5240** (HCF5240	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 271

Referentne vrijednosti podataka o rezanju

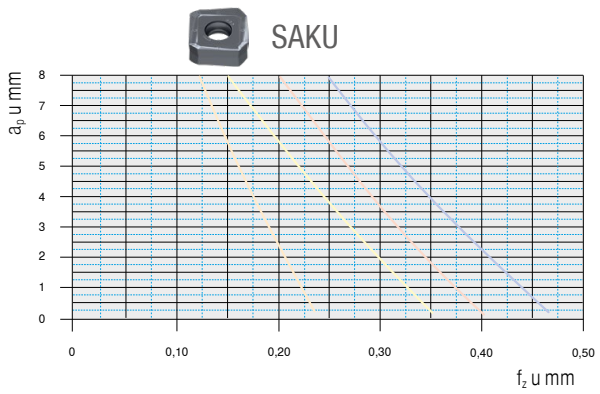
MaxiMill 271

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	50–340	0,2–0,3	8,4	50–340	0,2–0,5	8,4	50–340	0,2–0,5	8,4
Nehrđajući čelik	60–270	0,2–0,3	8,4	60–270	0,2–0,5	8,4	60–270	0,2–0,5	8,4
Lijevano željezo				130–360	0,2–0,5	8,4	130–360	0,2–0,5	8,4
Neželjezni metali									
Visokootporan na toplinu	25–80	0,2–0,3	8,4	25–80	0,2–0,3	8,4	25–80	0,2–0,3	8,4
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**SAKU 1706ABSR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**SAKU 1706ABSR-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**SAKU 1706ABSR-R50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**SAKU 1706ABSR-F50**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 273 / 273 XAHT

Referentne vrijednosti podataka o rezanju

MaxiMill 273

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	60–280	0,2–0,25	3,5	60–280	0,2–0,5	3,5	60–280	0,2–0,5	3,5
Nehrđajući čelik	130–240	0,2–0,5	3,5	60–270	0,2–0,5	3,5	60–270	0,2–0,5	3,5
Lijevano željezo				130–360	0,2–0,5	3,5	130–360	0,2–0,5	3,5
Neželjezni metali									
Visokootporan na toplinu	25–80	0,2–0,25	3,5	25–80	0,2–0,25	3,5	25–80	0,2–0,25	3,5
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

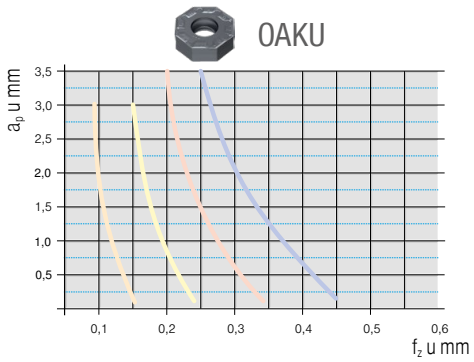
Sustav MaxiMill 273 široka pločica za finiširanje XAHT

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm						
Čelik	60–350	0,05–0,15	0,20–1,00						
Nehrđajući čelik	40–250	0,05–0,15	0,20–1,00						
Lijevano željezo	70–280	0,05–0,15	0,20–1,00						
Neželjezni metali									
Visokootporan na toplinu	10–100	0,05	0,20–1,00						
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8–6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**OAKU 060508SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**OAKU 060508SR-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**OAKU 060508SR-R50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**OAKU 060508ER-F40**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

15

Sustav MaxiMill 270-09

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

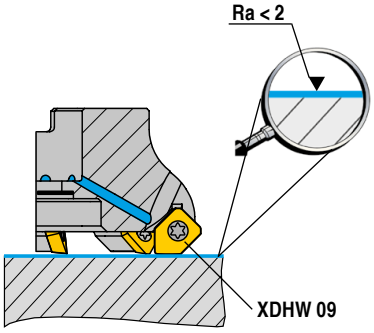
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	60–280	0,1–0,3	4	60–280	0,1–0,3	4	60–280	0,1–0,3	4
Nehrđajući čelik	60–270	0,1–0,25	4	60–270	0,1–0,25	4	60–270	0,1–0,25	4
Lijevano željezo	110–130	0,05–0,4		130–360	0,1–0,35	4	130–360	0,1–0,35	4
Neželjezni metali	160–1500	0,05–0,4	4	160–1500	0,05–0,4	4	160–1500	0,05–0,4	4
Visokootporan na toplinu	25–80	0,1–0,25	4	25–80	0,1–0,25	4	25–80	0,1–0,25	4
Kaljeni čelik									

Za pločice za široko završno glodanje

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	150–350	0,05–0,25	0,10–2,0						
Nehrđajući čelik	110–200	0,05–0,25	0,10–2,0						
Lijevano željezo	150–280	0,05–0,25	0,10–2,0						
Neželjezni metali	< 2000	0,05–0,25	0,10–2,0						
Visokootporan na toplinu									
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

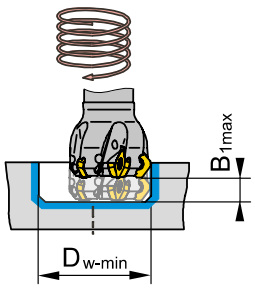


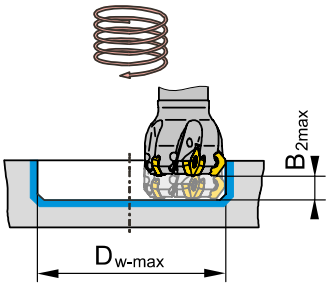
Završno glodanje s pločicama za široko završno glodanje

Na svakoj glavi noža montira se pločica za široko završno glodanje, od Ø 125 mm dvije.

Čelik	SDNT	0903AESN-29	DPX 1235	+	XDHW	0903AESN	DPX 1235
	SDNT	0903AESN-29	DCX 1230	+	XDHW	0903AESN	DCX 1230
	SDHT	0903AESN-33	DCX 1230	+	XDHW	0903AESN	DCX 1230
	SDHW	0903AESN	CWC 10	+	XDHW	0903AESN	CWC 10
Lijevano željezo	SDNT	0903AESN-31	DCX 3215	+	XDHW	0903AEEN	DCX 3215
Neželjezni metali	SDHT	0903AEFN-ALP	CWK 26	+	XDHW	0903AEFN	CWK 26

Potopno glodanje cirkularno (bez početnog bušenja)





C 270-09

DC mm	$D_{w\text{-}min}$ mm	$B_{1\,max}$ mm	$D_{w\text{-}max}$ mm	$B_{2\,max}$ mm
6	14,4	1,5	19,0	1,5
12	28,5	1,5	31,0	1,5
16	36,5	1,5	39,0	1,5
20	44,5	1,5	47,0	1,5
25	54,5	1,5	57,0	1,5
32	68,5	1,5	71,0	1,5

A 270-09

DC mm	$D_{w\text{-}min}$ mm	$B_{1\,max}$ mm	$D_{w\text{-}max}$ mm	$B_{2\,max}$ mm
32	68,5	1,5	71,0	1,5
40	84,5	1,5	87,0	1,5
50	104,5	1,5	107,0	1,5
63	130,5	1,5	133,0	1,5
80	164,5	1,5	167,0	1,5
100	204,5	1,5	207,0	1,5
125	254,5	1,5	257,0	1,5
160	324,5	1,5	327,0	1,5

Sustav MaxiMill 270-12

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	30–280	0,1–0,3	6	60–280	0,1–0,3	6	60–280	0,1–0,3	6
Nehrđajući čelik	60–270	0,1–0,25	6	60–270	0,1–0,25	6	60–270	0,1–0,25	6
Lijevano željezo	150–200	0,05–0,4	6	130–360	0,1–0,35	6	130–360	0,1–0,3	6
Neželjezni metali	160–3500	0,05–0,4	6	160–1500	0,05–0,4	6	160–1500	0,05–0,4	6
Visokootporan na toplinu	25–80	0,1–0,25	6	25–80	0,1–0,25	6	25–80	0,1–0,25	6
Kaljeni čelik									

Za pločice za široko završno glodanje

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	20–350	0,10–0,25	0,10–4,00						
Nehrđajući čelik	40–120	0,10–0,25	0,10–4,00						
Lijevano željezo	120–290	0,10– 0,25	0,10–4,00						
Neželjezni metali	< 2000	0,10–0,25	0,10–4,00						
Visokootporan na toplinu									
Kaljeni čelik									

Za CBN okretne pločice

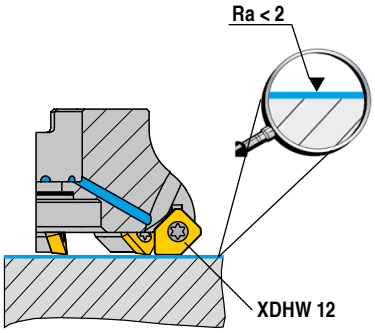
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik									
Nehrđajući čelik									
Lijevano željezo	600–1600	0,10–0,25	0,20–1,50						
Neželjezni metali									
Visokootporan na toplinu	350–700	0,08–0,15	0,20–1,00						
Kaljeni čelik	350–600	0,08–0,12	0,20–0,40						

Za PKD/MDC okretne pločice

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik									
Nehrđajući čelik									
Lijevano željezo									
Neželjezni metali	< 2000	0,05–0,25	0,10–2,00						
Visokootporan na toplinu									
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

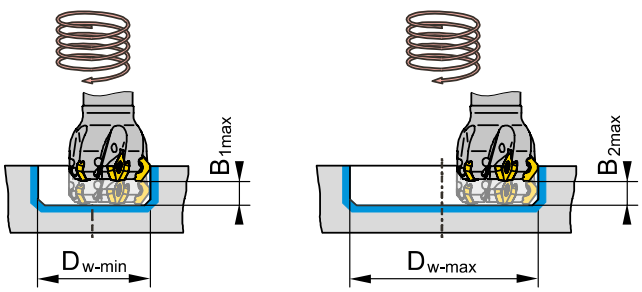


Završno glodanje s pločicama za široko završno glodanje

Na svakoj glavi noža montira se pločica za široko završno glodanje, od Ø 125 mm dvije.

Čelik	SDMT	1204AESN-29R	DPX 1235	+	XDHW	1204AESN DPX 1235
	SDMT	1204AESN-29R	DCX 1230	+	XDHW	1204AESN DCX 1230
	SDHW	1204AESN-R	CWC 10	+	XDHW	1204AESN CWC 10
Lijevano željezo	SDMT	1204AEEN-31	DCX 3215	+	XDHW	1204AEEN DCX 3215
	SDHW	1204AESN-R	DCX 3215	+	XDHW	1204AEEN DCX 3215
Neželjezni metali	SDHT	1204AEFN-ALP	CWK 26	+	XDHW	1204AEFN CWK 26

Potopno glodanje cirkularno (bez početnog bušenja)



DC mm	$D_{w\text{-}min}$ mm	$B_{1\,max}$ mm	$D_{w\text{-}max}$ mm	$B_{2\,max}$ mm
32	74,5	1,5	78,0	1,5
40	90,5	1,5	94,0	1,5
50	110,5	1,5	114,0	1,5
63	136,5	1,5	140,0	1,5
80	170,5	1,5	174,0	1,5
100	210,5	1,5	214,0	1,5
125	260,5	1,5	264,0	1,5
160	330,5	1,5	334,0	1,5

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 270-19

Referentne vrijednosti podataka o rezanju

Za standardne okretne pločice

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik				40–180	0,15–0,6	10	40–180	0,3–0,7	10
Nehrđajući čelik				40–120	0,15–0,5	10	40–120	0,3–0,6	10
Lijevano željezo							50–200	0,3–0,9	10
Neželjezni metali									
Visokootporan na toplinu				20–70	0,15–0,5	10			
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill HEC

Referentne vrijednosti podataka o rezanju

MaxiMill HEC 11

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik									
Nehrđajući čelik									
Lijevano željezo	100–800	0,08–0,3	6	100–360	0,08–0,3	6	100–360	0,1–0,45	6
Neželjezni metali									
Visokootporan na toplinu									
Kaljeni čelik									

MaxiMill HEC 12

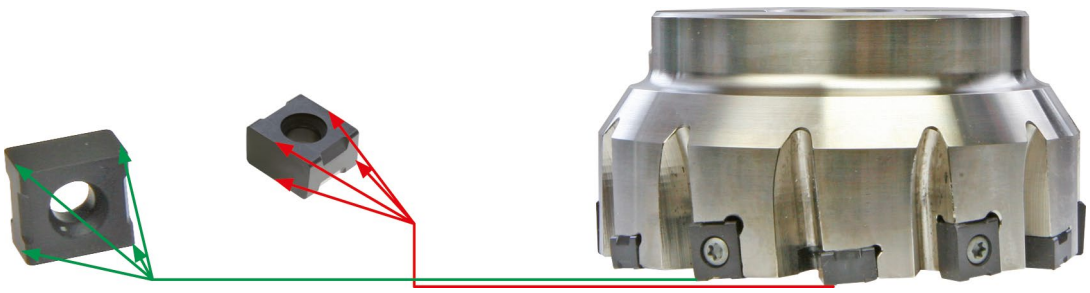
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik									
Nehrđajući čelik									
Lijevano željezo	100–360	0,08–0,3	8	100–360	0,08–0,3	8	100–360	0,1–0,45	8
Neželjezni metali									
Visokootporan na toplinu									
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

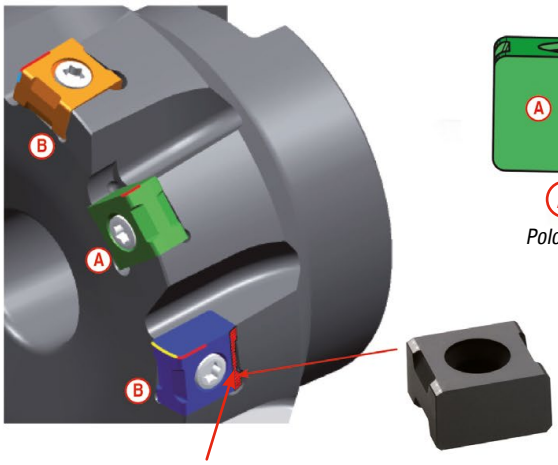
Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill HEC 11

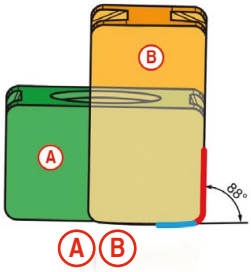
Četiri rezna brida po položaju ugradnje



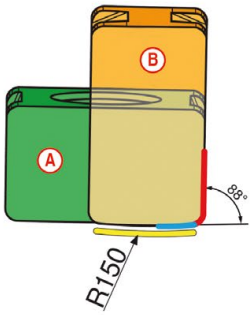
Ispravna montaža standardne i stružne okretne pločice



Označavanje za pravilnu montažu



Položaj ugradnje



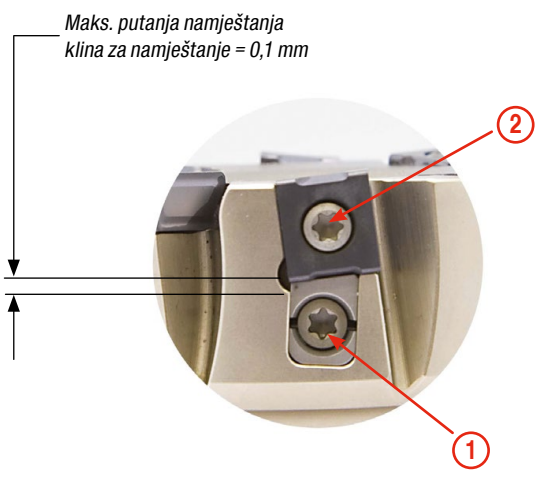
Standardna pločica za planarno rezanje B

Pločica glavnog reznog ruba A B

Pločica za široko završno glodanje B

Namještanje alata s aksijalnim namještanjem

- Klin za namještanje montirati u glodalo kako je prikazano te vijak pritegnuti tako čvrsto da se klin ne može širiti. (1)
- Okretne rezne pločice montirati kako je prikazano i zategnuti s 1,0 Nm. (2)
- Primjenom uređaja za namještanje označite najviši rezni rub. (1)
- Malim, postepenim okretajima vijka za namještanje rezne rubove namjestite na aksijalni hod od minimalno 0,005 mm ili bolji. (1)
- Okretnu reznu pločicu pritegnite s 3,2 Nm. (2)



15

Sustav MaxiMill 491-09

Referentne vrijednosti podataka o rezanju

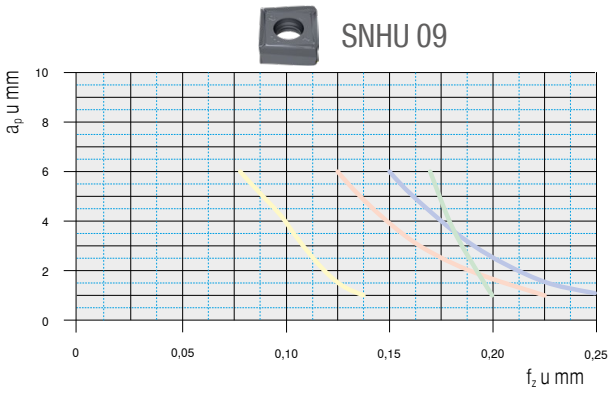
MaxiMill 491-09

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	60–280	0,1–0,2	6	60–280	0,1–0,2	6	60–280	0,1–0,2	6
Nehrđajući čelik	60–280	0,05–0,2	6	130–240	0,05–0,25	6	130–240	0,1–0,25	6
Lijevano željezo	110–130	0,05–0,25	6	100–360	0,1–0,25	6	100–360	0,1–0,25	6
Neželjezni metali	160–1500	0,05–0,25	6	160–1500	0,05–0,25	6	160–1500	0,05–0,25	6
Visokootporan na toplinu	25–75	0,08–0,15	6	25–75	0,08–0,15	6	25–75	0,08–0,15	6
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Neželjezni metali	450 N/mm²	4.3	3.2315	AlMgSi1



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**SNHU09T308SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**SNHU09T308SR-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**SNHU09T308SR-R50**	**CTCK215** (DCX3215)	250	Suho
Neželjezni metali	3.2315	**SNHU09T308FR-F10**	**CTWN215** (CWK4615)	500	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 491-12

Referentne vrijednosti podataka o rezanju

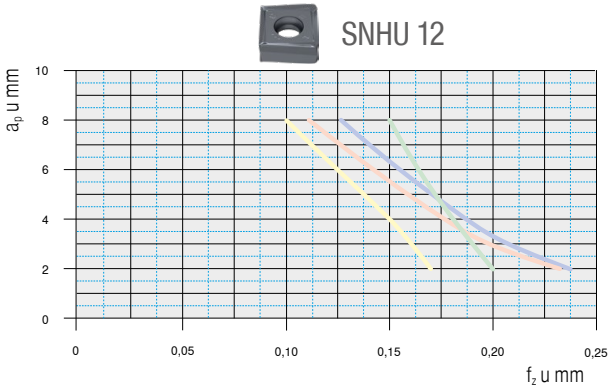
MaxiMill 491-12

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	60–280	0,1–0,2	8	60–280	0,1–0,2	8	60–280	0,1–0,2	8
Nehrđajući čelik	60–280	0,05–0,2	8	130–240	0,05–0,25	8	130–240	0,1–0,25	8
Lijevano željezo	110–130	0,05–0,25	8	100–360	0,1–0,25	8	100–360	0,1–0,25	8
Neželjezni metali	160–1500	0,05–0,25	8	160–1500	0,05–0,25	8	160–1500	0,05–0,25	8
Visokootporan na toplinu	25–75	0,08–0,15	8	25–75	0,08–0,15	8	25–75	0,08–0,15	8
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Neželjezni metali	450 N/mm²	4.3	3.2315	AlMgSi1



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**SNHU120408SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**SNHU120408SR-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**SNHU120408SR-R50**	**CTCK215** (DCX3215)	250	Suho
Neželjezni metali	3.2315	**SNHU120408FR-F10**	**CTWN215** (CWK4615)	500	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 211-07

Referentne vrijednosti podataka o rezanju / tehnološki podaci

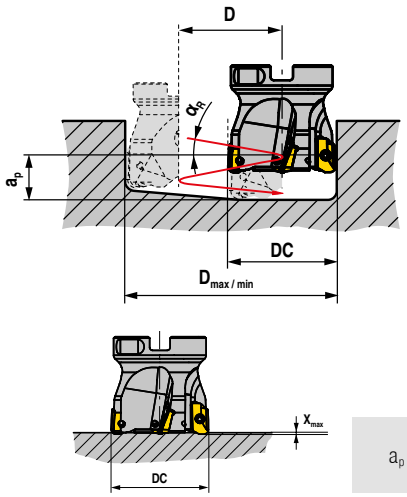
Za standardne okretne pločice

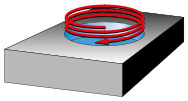
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	50–340	0,1–0,2	6	50–340	0,1–0,2	6	50–340	0,1–0,2	6
Nehrđajući čelik	60–280	0,05–0,2	6	60–280	0,05–0,3	6	60–280	0,1–0,3	6
Lijevano željezo				100–360	0,1–0,3	6	100–360	0,1–0,3	6
Neželjezni metali	160–1500	0,1–0,2	6	160–1500	0,1–0,2	6	160–1500	0,1–0,2	6
Visokootporan na toplinu	25–75	0,05–0,15	6	25–75	0,05–0,15	6	25–75	0,05–0,15	6
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

Potopno glodanje cirkularno



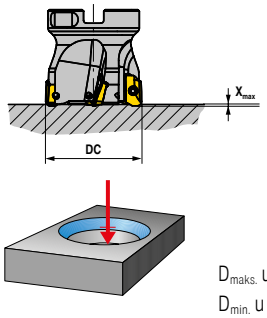


DC mm	D_{max} / RE 0,4 mm	D_{min} mm	$\alpha_{R\,max}$ °
10	19	13	5,5
12	23	17	6,0
16	31	25	3,0
20	39	33	2,0
25	49	43	1,5
32	63	57	1,2
40	79	73	0,8
50	99	93	0,7

DC mm	D mm	$\alpha_{R\,max\,360°}$ °
10	13	5,5
12	17	6,0
16	25	3,0
20	33	2,0
25	43	1,5
32	57	1,2
40	73	0,8
50	93	0,7

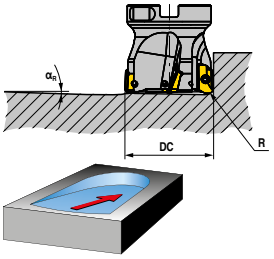
a_p u mm = $D * \pi * \tan \alpha_R$

Aksijalno uranjanje



DC mm	X_{max} mm
10	0,8
12	0,8
16	0,8
20	0,8
25	0,8
32	0,8
40	0,8
50	0,8

Koso uranjanje



DC mm	α °
10	11,0
12	7,9
16	4,3
20	3,0
25	2,5
32	1,6
40	1,2
50	1,0

$D_{maks.}$ u mm = Najveći promjer za ravne površine podloge

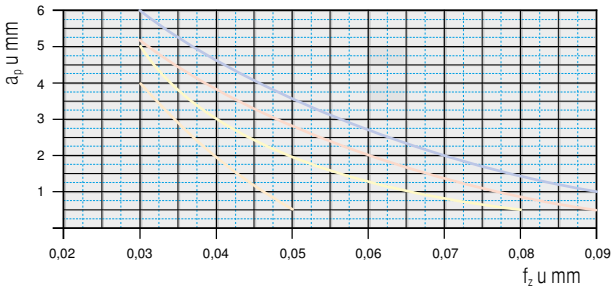
$D_{min.}$ u mm = Najmanji promjer provrta za ravne površine podloge

$D = D_{max} - DC / D_{min} - DC$

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

XDKT 07



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**XDKT070308SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**XDKT070308SR-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301		**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**XDKT070308ER-F40**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 211-11

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

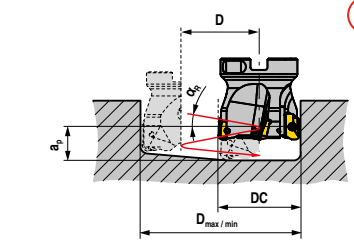
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	50–340	0,1–0,2	10	50–340	0,1–0,2	10	50–340	0,1–0,2	10
Nehrđajući čelik	60–280	0,05–0,2	10	60–280	0,05–0,25	10	60–280	0,1–0,25	10
Lijevano željezo				100–360	0,1–0,25	10	100–360	0,1–0,25	10
Neželjezni metali	160–1500	0,1–0,2	10	160–1500	0,1–0,2	10	160–1500	0,1–0,2	10
Visokootporan na toplinu	25–75	0,05–0,15	10	25–75	0,05–0,15	10	25–75	0,05–0,15	10
Kaljeni čelik				40–60	0,05–0,2	10			

Za valjkasto čeona glodala

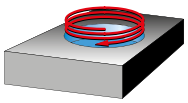
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	100–300	0,05–0,20	≤ APMX						
Nehrđajući čelik	80–200	0,05–0,20	≤ APMX						
Lijevano željezo	110–300	0,05–0,20	≤ APMX						
Neželjezni metali	300–2000	0,10–0,25	≤ APMX						
Visokootporan na toplinu	40–80	0,05–0,15	≤ APMX						
Kaljeni čelik	30–50	0,05–0,10	≤ APMX						

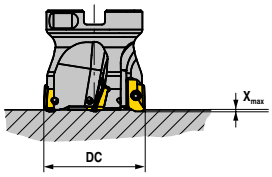
Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

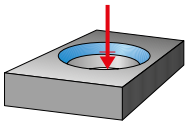


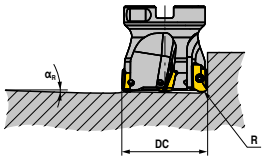
1 Potopno glodanje cirkularno



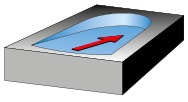


2 Aksijalno uranjanje





3 Koso uranjanje



DC mm	Potopno glodanje cirkularno RE = 0,8 mm	Aksijalno uranjanje X_{max}	Koso uranjanje α_R
12	α_R 16° D_{max} 21 mm D_{min} 14 mm	1,3 mm	18°
16	α_R 9,5° D_{max} 29 mm D_{min} 21 mm	1,5 mm	10,8°
20	α_R 7° D_{max} 37 mm D_{min} 30 mm	2,0 mm	9,8°
25	α_R 4,5° D_{max} 47 mm D_{min} 40 mm	2,0 mm	7,5°
32	α_R 3,2° D_{max} 61 mm D_{min} 53 mm	1,0 mm	4,8°
40	α_R 2,2° D_{max} 77 mm D_{min} 72 mm	1,6 mm	2,9°
50	α_R 1,7° D_{max} 98 mm D_{min} 93 mm	1,6 mm	2,2°
63	α_R 1,5° D_{max} 123 mm D_{min} 116 mm	1,6 mm	1,8°
80	α_R 1,0° D_{max} 157 mm D_{min} 153 mm	1,6 mm	1,4°
100	α_R 0,8° D_{max} 107 mm D_{min} 101 mm	1,6 mm	1,1°

DC mm	Maksimalna brzina s obzirom na duljinu prevjesa $n_{maks.}$ u min^{-1}				
	l_a = 1–2 x Ø mm	l_a = 2,5 x Ø mm	l_a = 3 x Ø mm	l_a = 4 x Ø mm	l_a = 5 x Ø mm
12	55000	51500	47000	42000	37000
16	42000	38500	34100	28900	24200
20	36900	33000	28500	23900	19500
25	33200	29000	24400	19900	15400
32	30200	26000	20900	16600	11900
40	27700	23000	18000	13500	9000
50	25400	20400	15400	10800	6100
63	23300	18300	12900	8300	3700
80	21300	16100	10600	5800	
100	19600	14100	8400		

$D_{maks.}$ u mm = Najveći promjer za ravne površine podloge
$D_{min.}$ u mm = Najmanji promjer za ravne površine podloge
a_p u mm = D x π x tan (α_R) = Nagib
l_a u mm = Duljina prevjesa

Sustav MaxiMill 211-15

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

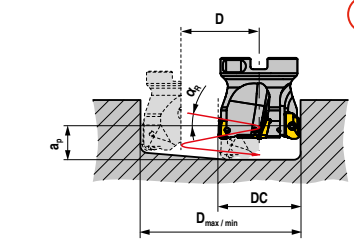
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	50–340	0,1–0,2	14	50–340	0,1–0,2	14	50–340	0,1–0,2	14
Nehrđajući čelik	60–280	0,05–0,2	14	60–280	0,05–0,25	14	60–280	0,1–0,25	14
Lijevano željezo				100–360	0,1–0,25	14	100–360	0,1–0,25	14
Neželjezni metali	160–1500	0,1–0,2	14	160–1500	0,1–0,2	14	160–1500	0,1–0,2	14
Visokootporan na toplinu	25–75	0,05–0,15	14	25–75	0,05–0,15	14	25–75	0,05–0,15	14
Kaljeni čelik				40–60	0,05–0,2	14			

Za valjkasto čeona glodala

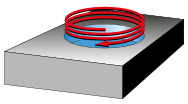
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	120–300	0,08–0,35	≤ APMX						
Nehrđajući čelik	150–200	0,08–0,35	≤ APMX						
Lijevano željezo	130–300	0,08–0,35	≤ APMX						
Neželjezni metali	400–2500	0,12–0,40	≤ APMX						
Visokootporan na toplinu	25–80	0,08–0,20	≤ APMX						
Kaljeni čelik									

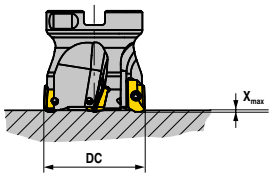
Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

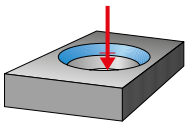


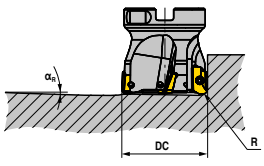
1 Potopno glodanje cirkularno



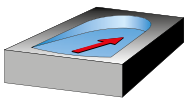


2 Aksijalno uranjanje





3 Koso uranjanje



DC mm	1 Potopno glodanje cirkularno	RE = 0,8 mm	2 Aksijalno uranjanje X_{max}	3 Koso uranjanje α_R
25	α_R	7,5°	2,7 mm	9,5°
	D_{max}	48 mm		
	D_{min}	37 mm		
32	α_R	5°	2,5 mm	6,8°
	D_{max}	62 mm		
	D_{min}	47 mm		
40	α_R	3,2°	2,5 mm	5,1°
	D_{max}	78 mm		
	D_{min}	63 mm		
50	α_R	2,5°	2,5 mm	2,5°
	D_{max}	98 mm		
	D_{min}	86 mm		
63	α_R	1,5°	2,5 mm	2,5°
	D_{max}	124 mm		
	D_{min}	111 mm		
80	α_R	1,3°	2,5 mm	2,0°
	D_{max}	158 mm		
	D_{min}	147 mm		
100	α_R	1,1°	2,5 mm	1,5°
	D_{max}	198 mm		
	D_{min}	190 mm		
125	α_R	0,9°	2,5 mm	0,9°
	D_{max}	248 mm		
	D_{min}	240 mm		
160	α_R	0,6°	2,5 mm	0,7°
	D_{max}	318 mm		
	D_{min}	310 mm		

Maksimalna brzina s obzirom na duljinu prevjesa $n_{maks.}$ u min^{-1}			
DC mm	l_a = 2 x Ø mm	l_a = 3 x Ø mm	l_a = 5 x Ø mm
25	26560	19520	13320
32	24160	16720	9520
40	22160	14400	7200
50	20320	12320	4880
63	18640	10320	2960
80	17040	8480	
100	15680	6720	
125	14320		
160	13200		

$D_{maks.}$ u mm = Najveći promjer za ravne površine podloge
$D_{min.}$ u mm = Najmanji promjer za ravne površine podloge

a_p u mm = D x π x tan (α_R) = Nagib

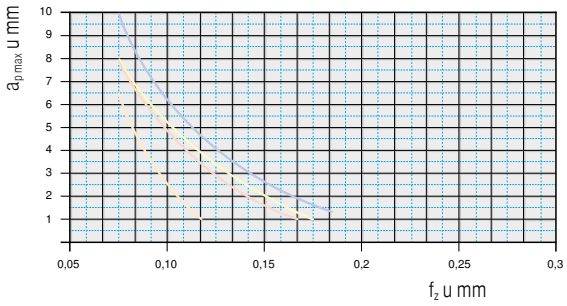
l_a u mm = Duljina prevjesa

Sustav MaxiMill 211-11

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

XDKT 11



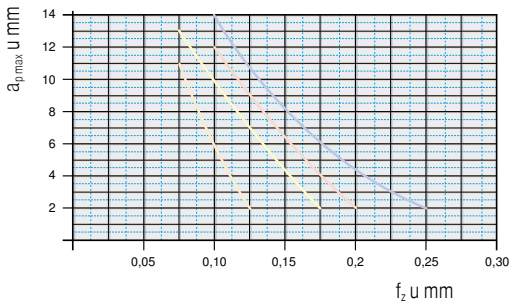
Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**XDKT11T308SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**XDKT11T308SR-F50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**XDKT11T308SR-R50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**XDKT11T308ER-F50**	**CTC5240** (HCF5240)	35	Emulzija

Sustav MaxiMill 211-15

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

XDKT 15



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**XDKT150508SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571		**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**XDKT150508SR-R50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**XDKT150508ER-F40**	**CTC5240** (HCF5240)	35	Emulzija

15

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 211-20

Referentne vrijednosti podataka o rezanju / tehnološki podaci

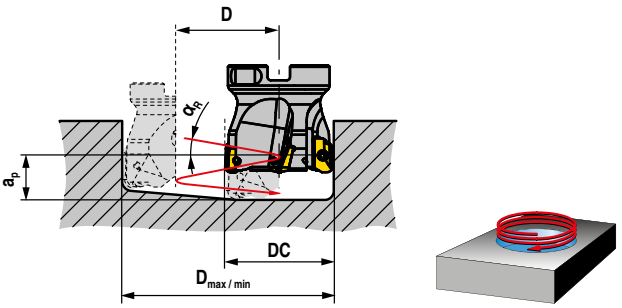
Za standardne okretne pločice

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik									
Nehrđajući čelik	130–280	0,08–0,2	19	130–280	0,08–0,3	19	180–280	0,1–0,25	19
Lijevano željezo									
Neželjezni metali									
Visokootporan na toplinu	25–80	0,08–0,2	19	25–80	0,08–0,3	19	25–80	0,1–0,15	19
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

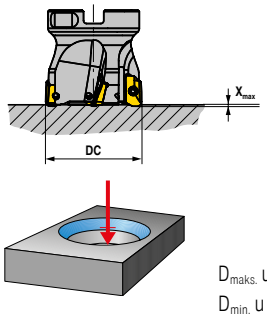
Potopno glodanje cirkularno



DC mm	D_{max} / RE 0,4 mm	D_{min} mm	$\alpha_{R\,max}$ °
63	124	107	2,2
80	158	143	1,7
100	198	183	1,3

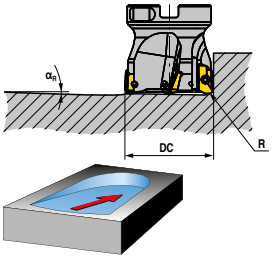
a_p u mm = D * π * tan α_R

Aksijalno uranjanje



DC mm	X_{max} mm
63	2,0
80	2,0
100	2,0

Koso uranjanje



DC mm	α °
63	2,2
80	1,7
100	1,3

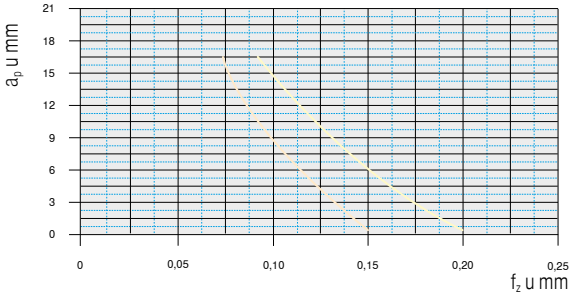
$D_{maks.}$ u mm = Najveći promjer za ravne površine podloge
$D_{min.}$ u mm = Najmanji promjer provrta za ravne površine podloge

$D = D_{max} - DC / D_{min} - DC$

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

XDKT 20



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312				
Nehrđajući čelik	1.4571	**XDKT200708ER-F40**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301				
Visokootporan na toplinu	2.4856	**XDKT200708ER-F40**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill 490-09

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	50–350	0,05–0,25	7,3	50–350	0,05–0,3	7,3	50–270	0,1–0,3	7,3
Nehrđajući čelik	130–280	0,1–0,2	7,3	60–280	0,1–0,2	7,3	60–280	0,1–0,2	7,3
Lijevano željezo	100–360	0,05–0,25	7,3	100–360	0,05–0,3	7,3	100–360	0,1–0,3	7,3
Neželjezni metali	160–1500	0,08–0,35	7,3	160–1500	0,08–0,35	7,3	160–1500	0,08–0,35	7,3
Visokootporan na toplinu	25–75	0,1–0,2	7,3	25–75	0,1–0,2	7,3	25–75	0,1–0,2	7,3
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

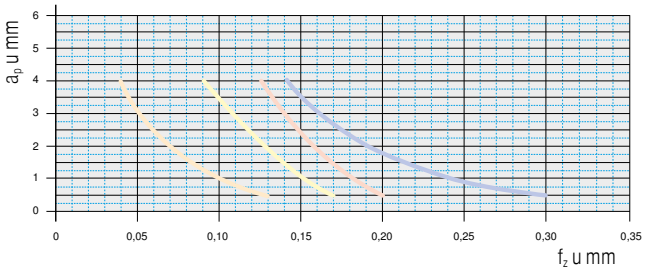
Strategija obrade

Sustav MaxiMill 490-09 nije prikladan za potopno glodanje!

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

SDNT 09

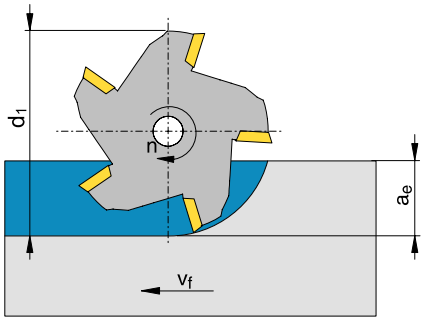


Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**SDNT09T308SR-29**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**SDNT09T308SR-33**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**SDNT09T308SR-31**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**SDNT09T308ER-M31**	**CTC5240** (HCF5240)	35	Emulzija

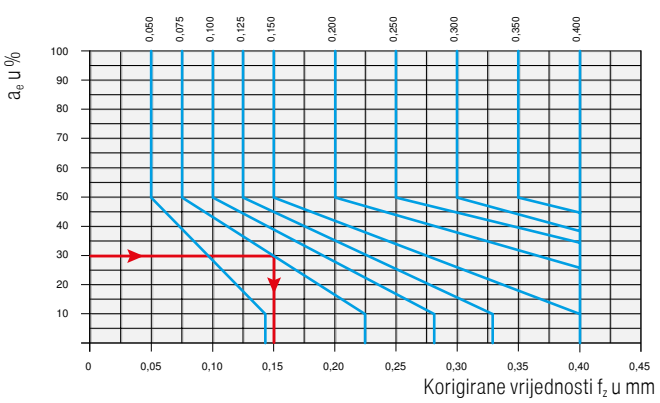
Korekcija posmaka zuba f_z

Za sustave 211-07/-11/-15/-20 i 490-09/-12

Ove vrijednosti vrijede za širinu djelovanja (a_e) ispod 50 %!



Početne vrijednosti f_z u mm iz dijagrama početnih parametara



Primjer:
Početne vrijednosti (f_z) = 0,075 mm
a_e = 30 %
Korigirana vrijednost (f_z) = 0,15 mm

Sustav MaxiMill 490-12

Referentne vrijednosti podataka o rezanju

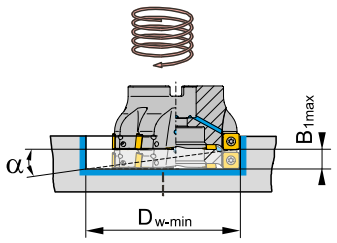
Za standardne okretne pločice

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	50–350	0,05–0,25	10,7	50–350	0,05–0,3	10,7	50–270	0,1–0,3	10,7
Nehrđajući čelik	130–280	0,1–0,2	10,7	60–280	0,1–0,2	10,7	60–280	0,1–0,2	10,7
Lijevano željezo	100–360	0,05–0,25	10,7	100–360	0,05–0,3	10,7	100–360	0,1–0,3	10,7
Neželjezni metali	160–1500	0,08–0,35	10,7	160–1500	0,08–0,35	10,7	160–1500	0,08–0,35	10,7
Visokootporan na toplinu	25–75	0,1–0,2	10,7	25–75	0,1–0,2	10,7	25–75	0,1–0,2	10,7
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

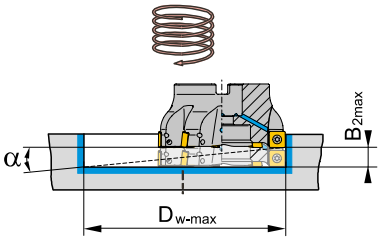
Strategija obrade

Potopno glodanje cirkularno (bez početnog bušenja)



$$B = (D_W - DC) \times \pi \times \tan \alpha$$

D_w = Promjer provrta koji treba napraviti
DC = Nazivni promjer alata za glodanje
B = Aksijalno pozicioniranje na cirkularnom kretanju 360°

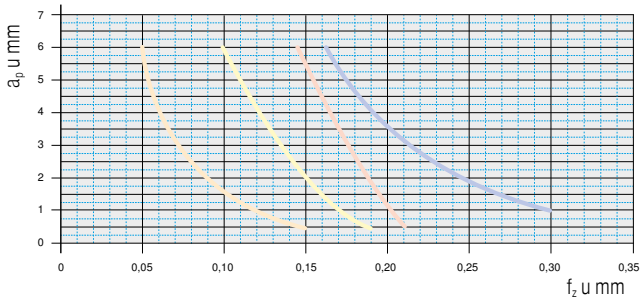


DC mm	$D_{w\text{-}min}$ mm	$B_{1\,max}$ mm	$D_{w\text{-}max}$ mm	$B_{2\,max}$ mm	α °
50	77	2,5	98	4,8	2,0
63	103	1,8	124	3,0	1,0
80	137	2,1	158	3,0	0,8
100	177	2,1	198	2,9	0,6
125	227	1,8	248	2,4	0,4

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

SDMT 12



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**SDMT1205ZZSN-29**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**SDMT120512SR-33**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**SDMT1205ZZSN-31**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**SDMT120508ER-M31**	**CTC5240** (HCF5240)	35	Emulzija

HSC/HPC obrada

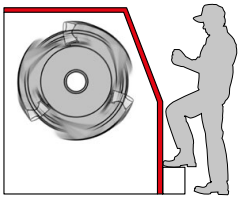
Sigurnosne napomene

Prikladnost alata za HSC obradu

HSC alati tvrtke CERATIZIT razvijeni su specijalno za ovu strategiju obrade i jamče maksimalnu sigurnost na radu.

Pridržavanje sigurnosnih propisa proizvođača stroja

Uvjerite se da se poštuju svi sigurnosni propisi proizvođača stroja (npr.: zatvoreni obradni moduli).

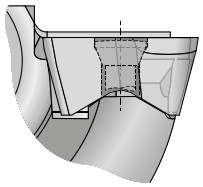


Prikladnost prihvata alata za HGF obradu

Odaberite optimalnu kombinaciju stezanja alata prema svojoj situaciji glodanja.
Kod primjene za glodanje s brzim okretanjem potrebno je da alat i prihvat alata budu međusobno dinamički izbalansirani (u skladu s Direktivom ISO 1940).

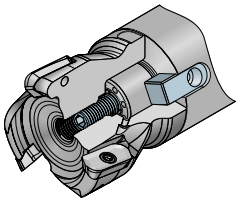
Pričvršćenje okretne rezne pločice sa zaštitom od centrifugalne sile

Stezaljka okretne pločice: EURO-Patent EP 1083017A1
Pazite da sjedište pločice bude čisto te da je navojni provrt za stezni vijak u besprijekornom stanju.
Provjerite aksijalni i radijalni priključak okretne pločice u sjedištu pločice.
Stezni vijci za prilagođeno pričvršćenje okretne pločice moraju biti pritegnuti priteznim momentom M (XDHT11 = 1,8 Nm; XDH.19 = 6,0 Nm).



Optimalno pričvršćenje HSC glodala (DC = Ø 40–63) na trnove glodala s pomoću vodećeg vijka.

Vodeći vijak jamči stabilno povezivanje alata i trna glodala i vrlo je jednostavan za rukovanje.



Vodeći vijak

Maksimalni dopušteni broj okretaja pri primjeni

Pazite na maksimalni dopušteni broj okretaja koji je naveden na alatu. On vrijedi isključivo za postojeći alat i mora se prilagoditi u skladu s izabranim prihvatom alata, ukupnom duljinom prevjesa i određenom situacijom obrade.

Optimalno područje primjene alata (a_e, a_p, f_z, n)

Da bi se osiguralo produktivno glodanje, pridržavajte se preporuka koje se odnose na parametre rezanja.

Nepridržavanje ovih sigurnosnih propisa tvrtku CERATIZIT automatski oslobađa odgovornosti.

Sustav MaxiMill HSC-11

Referentne vrijednosti podataka o rezanju

Za standardne okretne pločice

Materijal	F v_c m/min	F f_z mm	F a_p mm	M v_c m/min	M f_z mm	M a_p mm	R v_c m/min	R f_z mm	R a_p mm
Čelik									
Nehrđajući čelik									
Lijevano željezo	110–130	0,05–0,35	10						
Neželjezni metali	160–3000	0,05–0,35	10	160–3000	0,05–0,35	10	160–3000	0,05–0,35	10
Visokootporan na toplinu									
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

	Materijal izratka	Vrsta obrade/legiranje		VDI 3323 grupa	Tvrdoća HB	H216T (CWK26) v_c u m/min	H216T (CWK26) v_c u m/min
N	Aluminij kovane legure	Ne može se kaliti		21	60		200–3000
		Može se kaliti		22	100		200–2000
	Aluminij lijevane legure	Ne može se kaliti	< 12% Si	23	80		200–2000
		Može se kaliti	< 12% Si	24	90		200–1800
		Ne može se kaliti	> 12% Si	25	130		200–1000
	Bakar i legure bakra (bronca, mjed)		Legure za obradu na automatskim strojevima (1 % Pb)	26			200–600
			Mjed, crveni lijev	27	90	250–1000	250–1000
			Bronca	28	100		150–400
			Bezolovni bakar i elektrolitski bakar	29	100		300–800
	Nemetalni materijali		Duromeri	29		80–1000	80–1000
			Plastika ojačana vlaknima	29		70–500	70–500
			Tvrda guma	30		80–300	80–300

= Hlađenje punim mlazom

= Podmazivanje minimalnim količinama

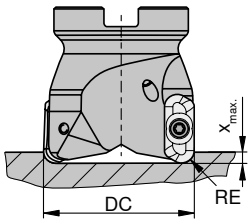
= Suha strojna obrada

Sustav MaxiMill HSC-11

Tehnološki podaci

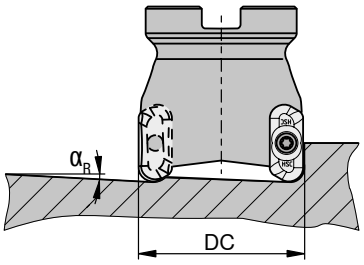
Strategija obrade

Aksijalno uranjanje



DC mm	11 RE 0,2-4,0 $x_{max.}$ mm
16	1,70
18	2,11
19	2,24
20	2,39
22	2,70
25	2,55
32	2,40
40	2,28
50	2,26
63	2,10
80	1,75
100	1,79

Linearno uranjanje



DC mm	α_R °
16	18,8
18	16,3
19	15,3
20	14,8
22	13,8
25	10,3
32	6,8
40	4,8
50	3,5
63	2,5
80	1,8
100	1,3

Strategija grube-fine obrade/glodanja

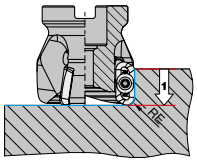
S maksimalnim intervalom uklanjanja

Okretna rezna pločica	RE mm	a_p mm	$a_{p\ max.}$ mm
XDHT 11T302FR-ALP	0,2	10	9,8
XDHT 11T304FR-ALP	0,4	10	9,6
XDHT 11T308FR-ALP	0,8	10	9,2
XDHT 11T312FR-ALP	1,2	10	8,8
XDHT 11T316FR-ALP	1,6	10	8,4
XDHT 11T320FR-ALP	2,0	10	8,0
XDHT 11T325FR-ALP	2,5	10	7,5
XDHT 11T332FR-ALP	3,2	10	6,8
XDHT 11T340FR-ALP	4,0	10	6,0
XDHT 11T350FR-ALP	5,0	10	5,0

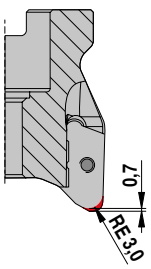
S maksimalnom kvalitetom bočne stijene

Okretna rezna pločica	RE mm	$a_{p\ max.}$ mm
XDHT 11T302FR-ALP	0,2	7,8
XDHT 11T304FR-ALP	0,4	7,6
XDHT 11T308FR-ALP	0,8	7,2
XDHT 11T312FR-ALP	1,2	6,5
XDHT 11T316FR-ALP	1,6	6,8
XDHT 11T320FR-ALP	2,0	6,4
XDHT 11T325FR-ALP	2,5	5,5
XDHT 11T332FR-ALP	3,2	4,8
XDHT 11T340FR-ALP	4,0	4,0
XDHT 11T350FR-ALP	5,0	3,0

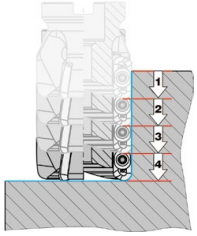
Kutno glodanje

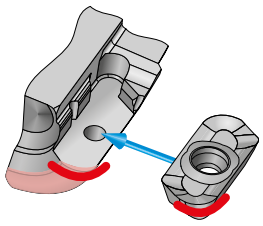


Dodatno pritezanje čeone konture

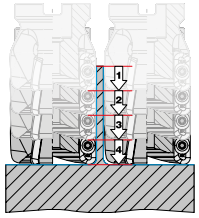


Glodanje džepova





Glodanje džepova s tankim mrežama



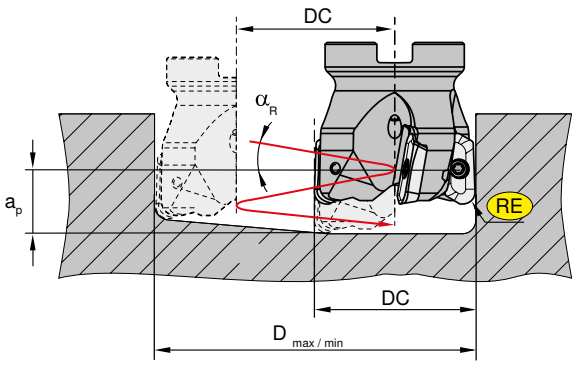
Kod okretnih pločica s kutnim radijusom većim od 3,2 mm potrebno je modificirati osnovno tijelo alata prema gornjoj skici.

Sustav MaxiMill HSC-11

Tehnološki podaci

Strategija obrade

Cirkularno uranjanje



RE = Radijus okretnih pločica
α_R u mm = Maksimalni kut uranjanja (u odnosu na sredinu alata)

a_p u mm = Nagib → D x π x tan (α_R)

D u mm = Nagib → $D_{maks.}$ – DC odn. $D_{min.}$ – DC

Za ravno dno provrta

$D_{maks.}$ u mm = Najveći promjer provrta
$D_{min.}$ u mm = Najmanji promjer provrta
$DN_{maks.}$ u mm = Najveći promjer provrta za neujednačeno dno provrta

DC u mm		XDHT-11 (HSC-11)								
(DN_{max})		RE = 0,2	RE = 0,4	RE = 0,8	RE = 1,2	RE = 1,6	RE = 2,0	RE = 2,5	RE = 3,2	RE = 4,0
16	α_R	9,7°	10,0°	9,9°	9,4°	8,9°	8,4°	7,9°	7,0°	6,1°
	D_{max}	30	30	29	28	27	27	26	24	23
(31)	D_{min}	18	18	18	18	18	18	18	18	18
18	α_R	9,4°	9,1°	8,7°	8,3°	7,9°	7,5°	6,9°	6,2°	5,3°
	D_{max}	34	34	33	32	31	31	30	28	27
(35)	D_{min}	22	22	22	22	22	22	22	22	22
19	α_R	8,8°	8,6°	8,3°	7,9°	7,5°	7,5°	6,5°	5,9°	5,1°
	D_{max}	36	36	35	34	33	33	32	30	29
(37)	D_{min}	24	24	24	24	24	24	24	24	24
20	α_R	8,4°	8,2°	7,8°	7,4°	7,7°	6,7°	6,2°	5,5°	4,8°
	D_{max}	38	38	37	36	35	35	34	32	31
(39)	D_{min}	26	26	26	26	26	26	26	26	26
22	α_R	7,6°	7,4°	7,8°	6,7°	6,4°	6,5°	5,6°	5,2°	4,3°
	D_{max}	42	42	41	40	39	39	38	36	35
(43)	D_{min}	30	30	30	30	30	30	30	30	30
25	α_R	6,7°	6,5°	6,2°	5,9°	5,6°	5,3°	4,9°	4,4°	3,8°
	D_{max}	48	48	47	46	45	45	44	42	41
(49)	D_{min}	36	36	36	36	36	36	36	36	36
32	α_R	4,7°	4,7°	4,8°	4,6°	4,3°	4,1°	3,8°	3,4°	2,9°
	D_{max}	62	62	61	60	59	59	58	56	55
(63)	D_{min}	50	50	50	50	50	50	50	50	50
40	α_R	3,3°	3,3°	3,4°	3,4°	3,5°	3,3°	3,0°	2,7°	2,3°
	D_{max}	78	78	77	76	75	75	74	72	71
(79)	D_{min}	66	66	66	66	66	66	66	66	66
50	α_R	2,4°	2,5°	2,5°	2,5°	2,6°	2,6°	2,4°	2,2°	1,9°
	D_{max}	98	98	97	96	95	95	94	92	91
(99)	D_{min}	86	86	86	86	86	86	86	86	86
63	α_R	1,7°	1,7°	1,7°	1,8°	1,8°	1,8°	1,8°	1,7°	1,5°
	D_{max}	124	124	123	122	121	121	120	118	117
(125)	D_{min}	112	112	112	112	112	112	112	112	112
80	α_R	1,1°	1,1°	1,1°	1,1°	1,1°	1,1°	1,1°	1,2°	1,2°
	D_{max}	158	158	157	156	155	155	154	152	151
(159)	D_{min}	146	146	146	146	146	146	146	146	146
100	α_R	0,8°	0,8°	0,9°	0,9°	0,9°	0,9°	0,9°	0,9°	0,9°
	D_{max}	198	198	197	196	195	195	194	192	191
(199)	D_{min}	186	186	186	186	186	186	186	186	186

Sustav MaxiMill HSC/HPC-19

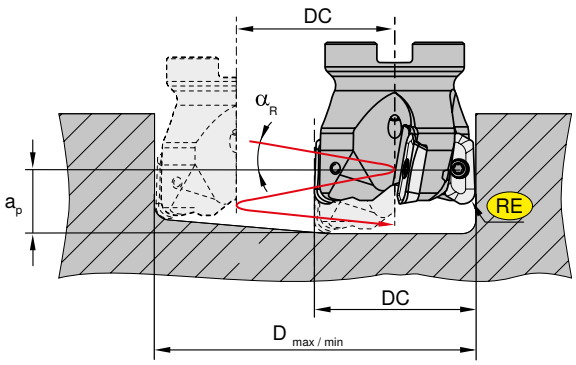
Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik									
Nehrđajući čelik									
Lijevano željezo	110–130	0,05–0,35	18						
Neželjezni metali	160–3000	0,05–0,35	18	160–3000	0,05–0,35	18	160–3000	0,05–0,35	18
Visokootporan na toplinu									
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Cirkularno uranjanje



RE = Radijus okretnih pločica
α_R u mm = Maksimalni kut uranjanja (u odnosu na sredinu alata)

a_p u mm = Nagib → D x π x tan (α_R)

D u mm = Nagib → $D_{maks.}$ – DC odn. $D_{min.}$ – DC

Za ravno dno provrta

$D_{maks.}$ u mm = Najveći promjer provrta
$D_{min.}$ u mm = Najmanji promjer provrta
$DN_{maks.}$ u mm = Najveći promjer provrta za neujednačeno dno provrta

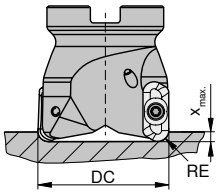
	DC mm	DN_{max} mm	α_R °	D_{max} mm	D_{min} mm
RE = 0,2 mm	**25**	49	7°02‘	48	32
	32	63	4°34‘	62	46
	40	79	3°47‘	78	62
	50	99	3°01‘	97	81
	63	125	2°17‘	124	107
	80	159		158	141
	100	199		198	181
RE = 0,4 mm	**25**	49	7°08‘	48	32
	32	63	4°37‘	62	46
	40	79	3°49‘	78	62
	50	99	3°02‘	98	81
	63	125	2°18‘	124	107
	80	159		158	141
	100	199		198	181
RE = 0,8 mm	**25**	49	7°21‘	47	32
	32	63	4°44‘	61	46
	40	79	3°53‘	77	62
	50	99	3°05‘	97	81
	63	125	2°20‘	123	107
	80	159		157	141
	100	199		197	181
RE = 2,0 mm	**25**	49	8°40‘	45	32
	32	63	5°04‘	59	46
	40	79	4°06‘	75	62
	50	99	3°13‘	95	81
	63	125	2°25‘	121	107
	80	159		155	141
	100	199		195	181
RE = 2,5 mm	**25**	49	8°24‘	44	32
	32	63	5°13‘	58	46
	40	79	4°12‘	74	62
	50	99	3°17‘	94	81
	63	125	2°27‘	120	107
	80	159		154	141
	100	199		194	181
RE = 3,2 mm	**25**	49	8°54‘	42	32
	32	63	5°26‘	56	46
	40	79	4°20‘	72	62
	50	99	3°21‘	92	81
	63	125	2°30‘	118	107
	80	159		152	141
	100	199		192	181
RE = 4,0 mm	**25**	49	9°32‘	41	32
	32	63	5°42‘	55	46
	40	79	4°30‘	71	62
	50	99	3°28‘	91	81
	63	125	2°33‘	117	107
	80	159		151	141
	100	199		191	181
RE = 5,0 mm	**25**	49	6°49‘	39	32
	32	63	3°59‘	53	46
	40	79	3°20‘	69	62
	50	99	2°13‘	89	81
	63	125	1°52‘	115	107
	80	159		149	141
	100	199		189	181

Sustav MaxiMill HSC/HPC-19

Tehnološki podaci

Strategija obrade

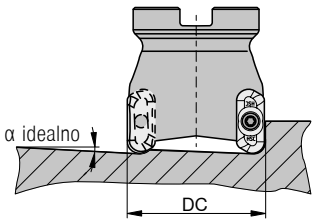
Aksijalno uranjanje



HSC 19	DC mm	19 RE 0,2–4,0 $x_{max.}$ mm	19 RE 5,0 $x_{max.}$ mm
CHSC 19 / GHSC 19 / MHSC 19	25	5,0	4,0
CHSC 19 / GHSC 19 / MHSC 19	32–40	4,0	3,0
AHSC 19	40–100	4,0	3,0

HPC 19	DC mm	19 RE 0,2–4,0 $x_{max.}$ mm	19 RE 5,0 $x_{max.}$ mm
CHPC 19 / MHPC 19	22–25	5,0	4,0
CHPC 19 / MHPC 19	32–50	6,0	5,0
AHPC 19	40–63	6,0	5,0

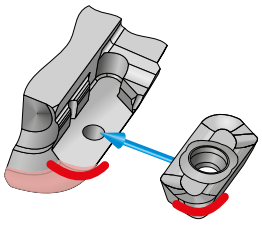
Linearno uranjanje

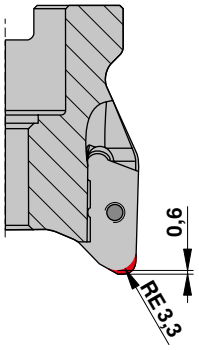


DC mm	α idealno HSC 19	α idealno HPC 19
25	11°	11°
32	7°	7°
40	5°	5°
50	4°	4°
63	3°	3°
80	2°	
100	2°	

Dorađeno osnovno tijelo alata

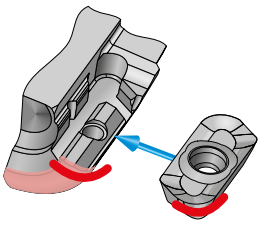
HSC 19





Dodatno pritezanje čeone konture

HPC 19



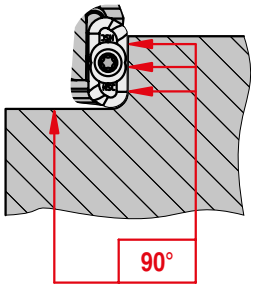
Kod okretnih pločica s kutnim radijusom većim od 4,0 mm potrebno je modificirati osnovno tijelo alata prema gornjoj skici.

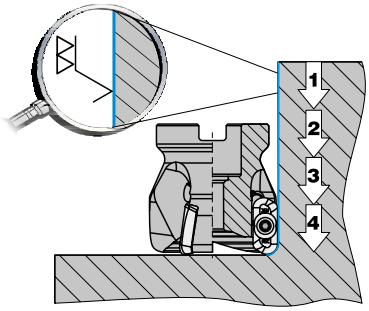
Sustav MaxiMill HSC/HPC-19

Tehnološki podaci

Strategija obrade

▽ + ▽▽ Izvrsna kvaliteta bočne stijenke nakon postupka grube obrade.
Dodatni postupci fine obrade mogu se izostaviti.





Strategija grube-fine obrade/glodanja

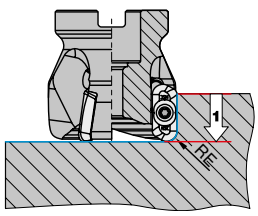
S maksimalnim intervalom uklanjanja

Okretna rezna pločica	RE mm	a_p mm	$a_{p\ max.}$ mm
XDH. 190402FR-ALP	0,2	18,0	17,8
XDH. 190404FR-ALP	0,4	18,0	17,6
XDH. 190408FR-ALP	0,8	18,0	17,2
XDH. 190420FR-ALP	2,0	18,0	16,0
XDH. 190425FR-ALP	2,5	18,0	15,0
XDH. 190432FR-ALP	3,2	18,0	14,8
XDH. 190440FR-ALP	4,0	18,0	14,0
XDH. 190450FR-ALP	5,0	17,0	13,0

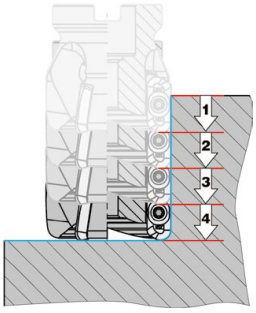
S maksimalnom kvalitetom bočne stijene

Kutno glodanje	RE mm	$a_{p\ max.}$ mm
XDH. 190402FR-ALP	0,2	11,8
XDH. 190404FR-ALP	0,4	11,6
XDH. 190408FR-ALP	0,8	11,2
XDH. 190420FR-ALP	2,0	10,0
XDH. 190425FR-ALP	2,5	9,5
XDH. 190432FR-ALP	3,2	8,8
XDH. 190440FR-ALP	4,0	8,0
XDH. 190450FR-ALP	5,0	7,0

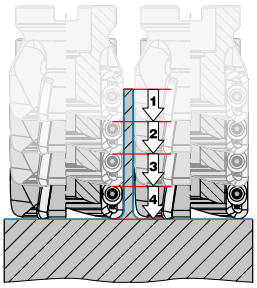
Kutno glodanje



Glodanje džepova



Glodanje džepova s tankim mrežama



Ovi podaci vrijede za okretne pločice u izvedbi XDHT 19 i XDHX 19.

Sustav MaxiMill HPC-04/12

Referentne vrijednosti podataka o rezanju / tehnološki podaci

MaxiMill HPC-04

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik									
Nehrđajući čelik									
Lijevano željezo	450–800	0,05–0,2	4						
Neželjezni metali	350–3500	0,05–0,2	4	350–3500	0,05–0,2	4			
Visokootporan na toplinu									
Kaljeni čelik									

MaxiMill HPC-12

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik									
Nehrđajući čelik									
Lijevano željezo	450–800	0,05–0,2	2						
Neželjezni metali	350–3500	0,1–0,35	11	350–3500	0,1–0,35	11	350–3500	0,1–0,4	11
Visokootporan na toplinu									
Kaljeni čelik									

Strategija obrade

Na što obratiti pozornost?

- Stabilnost stroja.
- Stabilno stezanje izratka i prihvat alata.
- Primjena rashladnog sredstva općenito nije potrebna, međutim tako se olakšava odvođenje strugotina – dodatno se poboljšava kvaliteta površine.
- Pazite na utjecaj izmjena topline i kritičnu temperaturu od 600 °C; ovisno o materijalu radite s hlađenjem.
- Izbjegavanje vibracija.
- Održavanje ravnoteže.
- Pazite na kemijske reakcije dijamanta s elementima koji stvaraju karbid (Fe, Ti, Ta, Co, Ni).

Kada je uporaba posebno korisna?

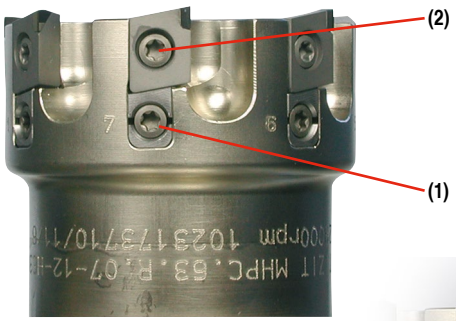
- Komponente izrađene iz lakih i teških metala, plastike, vlaknastih materijala, grafita ...
- Kada mogućnost jednostavnog namještanja može uštedjeti troškove za prednamještanje alata.
- Proizvodnja u velikim serijama.
- Visoki zahtjevi za kvalitetu površine izratka.
- Nužnost dugog vijeka trajanja za smanjenje složenih zamjena alata i skupih zastoja stroja.
- Već postojeći servis alata na licu mjesta (prednamještanje itd.).

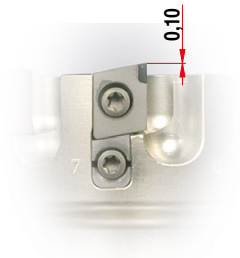
Kontrola ravnoteže

Kvaliteta izbalansiranosti se nakon sastavljanja mora kontrolirati stezanjem okretnih pločica i namještanjem aksijalnog hoda. Posebno je pri primjeni utičnog glodala nakon sastavljanja s prihvatom potrebno balansiranje.

Postupak namještanja s podložnim pločicama

Pritom se, analogno gore opisanom postupku namještanja, standardne pločice namještaju koncentrično na = 0,02 mm. Okretne pločice sa stružnom oštricom tada se namještaju za 0,02–0,03 mm preko najviše oštrice.





Postupak namještanja

1 Montirajte klin za namještanje na alat (odgovara stanju isporuke). Pritegnite vijak za namještanje (1) pazeći da se klinovi ne izobliče.

2 Montirajte PKD pločice i pritegnite stezne vijke (2) s 1,0 Nm.

3 Označite „najvišu oštricu“ s pomoću uređaja za prednamještanje.

4 Namjestite ovu PKD okretnu pločicu za 0,02 mm okretanjem vijka za namještanje (1) u smjeru kazaljke sata.

Potrebno je postići prednapetost. Pritom koristite priloženi TORX kutni odvijač!

5 Namjestite ostale oštrice na tu razinu s odstupanjem od maksimalno 0,005 mm. Maksimalna putanja namještanja = 0,10 mm.

6 Pritezanje svih steznih vijaka (2) okretne rezne pločice s 5,0 Nm.

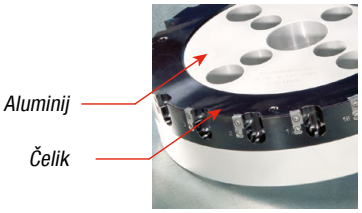
7 Kontrola aksijalnog hoda svih okretnih pločica: Zadana vrijednost = 0,005 mm.

Savršena preciznost – MaxiMill HPC-12

Namjestivi visokoučinkoviti alat za završnu obradu aluminijskih komponenti

Tijelo alata od čelika

- Za najveću stabilnost
- Maksimalna otpornost na trošenje
- Izvedba u bimetalu od promjera 160 mm; lakše rukovanje i zaštićeno vreteno kod velikih alata



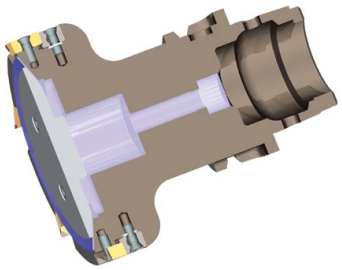
Slika prikazuje bimetalnu izvedbu

Izvedba kao utična ili monoblok varijanta

- Izravno povezivanje HSK63 kao monoblok varijanta
- Monoblok alati izbalansirani G2,5 pri n = 20.000 min^{-1} (ISO1940)

Unutarnji dovod rashladnog sredstva specijalno razvijen za HSC primjenu

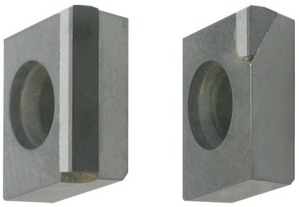
- Poboljšano odvođenje strugotina
- Visoka kvaliteta površine
- Optimalni uvjeti primjene
- Prikladnost za podmazivanje u minimalnoj količini



Vrijeme je novac – sustav MaxiMill HPC-12 postavlja se jednostavno i prije svega brzo!

Visokopozitivni kut odvođenja strugotine s +25°

- Smanjena snaga rezanja
- Povećana ujednačenost površine
- Minimalne deformacije komponenti



Tangencijalni princip rezanja

- Stabilna struktura za PKD segment i najviša procesna sigurnost

Prilagođena PKD oštrica

- Visoka udarna čvrstoća pri postupku glodanja!
- Maksimalna stabilnost rubova
- Smanjeno stvaranje nabora na izratku
- Obrada Al-Si legura s udjelom silicija od preko 12 % moguća je bez problema

Odabir okretne pločice

- Standardne okretne pločice
- Okretne pločice s radijusom kuta
- Okretne pločice sa stružnom oštricom

Sustav MaxiMill 141 / 241

Referentne vrijednosti podataka o rezanju / tehnološki podaci

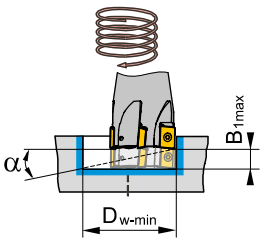
Za standardne okretne pločice

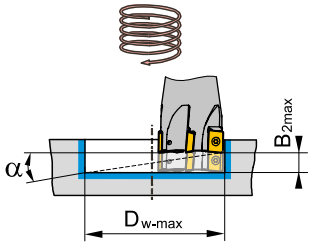
	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	60–280	0,1–0,2	14	60–280	0,1–0,2	14	60–280	0,1–0,2	14
Nehrđajući čelik	130–240	0,05–0,2	14	130–240	0,05–0,25	14	130–240	0,1–0,25	14
Lijevano željezo				100–360	0,1–0,25	14			
Neželjezni metali	160–1500	0,1–0,2	14	160–1500	0,1–0,2	14	160–1500	0,1–0,2	14
Visokootporan na toplinu									
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

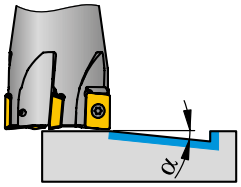
Strategija obrade

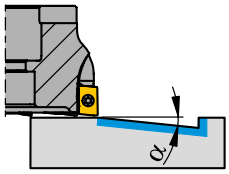
Potopno glodanje cirkularno (bez početnog bušenja)





Koso uranjanje





D_w = Promjer provrta koji treba napraviti
DC = Nazivni promjer alata za glodanje
B = Aksijalno pozicioniranje na cirkularnom kretanju 360°

$$B = (D_w - DC) \times \pi \times \tan \alpha$$

C 141

DC mm	$D_{w\text{-}min}$ mm	$B_{1\,max}$ mm	$D_{w\text{-}max}$ mm	$B_{2\,max}$ mm	α °
16	20,0	0,4	30,0	1,5	2,0
20	24,0	0,4	38,0	1,9	2,0
25	34,0	0,9	48,0	2,5	2,0
32	48,0	1,7	62,0	3,2	2,0
40	64,0	1,9	78,0	3,1	1,5

A 241

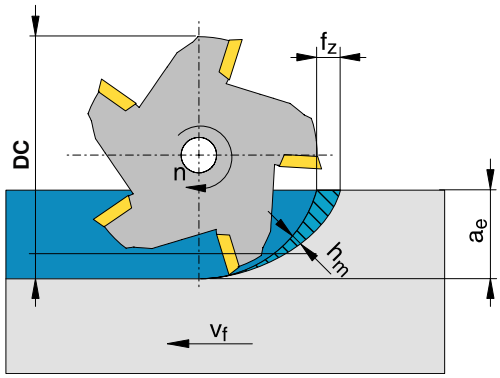
DC mm	$D_{w\text{-}min}$ mm	$B_{1\,max}$ mm	$D_{w\text{-}max}$ mm	$B_{2\,max}$ mm	α °
40	64,0	1,9	78,0	3,1	1,5
50	84,0	1,8	98,0	2,6	1,0
63	110,0	1,2	124,0	1,6	0,5
80	144,0	1,4	158,0	1,7	0,4
100	184,0	1,3	198,0	1,6	0,3
125	234,0	1,2	248,0	1,3	0,2

Srednja debljina strugotine [h_m] – postupak

Kutno glodanje

1 Odgovarajuću srednju debljinu strugotine [h_m] za odgovarajući čelik izaberite iz tablice.

Materijal	Vlačna čvrstoća N/mm²	h_m mm
za čelik	...–800	0,16
za čelik	800–1000	0,14
za čelik	1000–1200	0,12
za čelik	1200–...	0,10
za VA	...–750	0,15
za VA	750–900	0,13
za VA	900–1150	0,11
za VA	1150–...	0,09 *



2 Uzeti srednju debljinu strugotine [h_m] i s odgovarajućom širinom djelovanja [a_e] uzeti korigiranu vrijednost posmaka iz tablice.

h_m mm	Korigirana vrijednost posmaka f_z za h_m				
0,16	0,36	0,29	0,25	0,18	0,16
0,14	0,31	0,26	0,22	0,16	0,14
0,12	0,27	0,22	0,19	0,14	0,12
0,10	0,22	0,18	0,16	0,12	0,10
0,15	0,34	0,27	0,24	0,17	0,15
0,13	0,29	0,24	0,21	0,15	0,13
0,11	0,25	0,20	0,17	0,13	0,11
0,09 *	0,20	0,16	0,14	0,10	0,09 *
a_e =	**0,2 x DC**	**0,3 x DC**	**0,4 x DC**	**0,75 x DC**	**1 x DC**

Ravno glodanje

Materijal	Vlačna čvrstoća N/mm²	h_m mm
za čelik	...–800	0,2
za čelik	800–1000	0,18
za čelik	1000–1200	0,16
za čelik	1200–...	0,14
za VA	... –750	0,21
za VA	750–900	0,19
za VA	900–1150	0,17
za VA	1150– ...	0,15

Postupak kao kod kutnog glodanja.

h_m mm	Korigirana vrijednost posmaka f_z za h_m			
0,20	0,40 **	0,40 **	0,33	0,28
0,18	0,40 **	0,40 **	0,29	0,25
0,16	0,40 **	0,36	0,26	0,23
0,14	0,36	0,31	0,23	0,20
0,21	0,40 **	0,40 **	0,34	0,30
0,19	0,40 **	0,40 **	0,31	0,27
0,17	0,40 **	0,38	0,28	0,24
0,15	0,39	0,34	0,24	0,21
a_e =	**0,3 x DC**	**0,4 x DC**	**0,75 x DC**	**1 x DC**

* f_z < 0,08 mm: Opasnost, jer alat više nije učinkovit za rezanje
** f_z > 0,4 mm: Opasnost kontakta otvorenog prostora

Sustav MaxiMill HFC-06

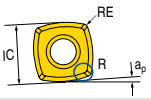
Referentne vrijednosti podataka o rezanju / tehnološki podaci

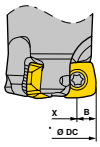
	F			M			R		
Materijal	v_c u m/min	f_z u mm	a_p u mm	v_c u m/min	f_z u mm	a_p u mm	v_c u m/min	f_z u mm	a_p u mm
Čelik				60–280	0,2–1,25	0,8	60–280	0,2–1,25	0,8
Nehrđajući čelik				60–270	0,2–1,25	0,8	60–270	0,2–1,25	0,8
Lijevano željezo				130–360	0,2–1,25	0,8	130–360	0,2–1,25	0,8
Neželjezni metali									
Visokootporan na toplinu				25–75	0,2–1,25	0,8	25–75	0,2–1,25	0,8
Kaljeni čelik									

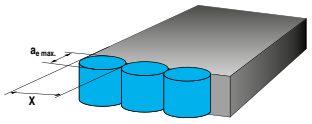
Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

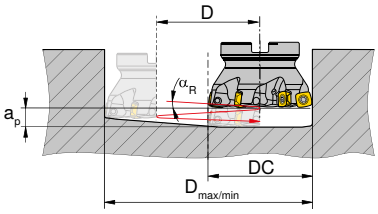
Programirani radijus R = 1,2 mm

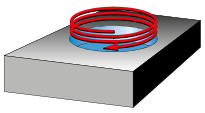


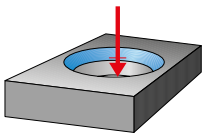


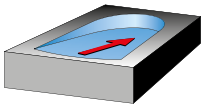


Dubina rezanja i ostatak materijala			Širina rezanja za ravne površine			Djelovanje kod potopnog glodanja				
IC in mm	RE u mm	$a_{p\,maks.}$ u mm	DC u mm	X u mm	B u mm	$a_{e\,max.}$ u mm	f_z u mm			X
							Inicijalno	Min.	Maks.	
6,35	0,5	0,8	16–32	DC–(2 x B)	4,3	5,3	0,10	0,08	0,15	<0,7 x DC







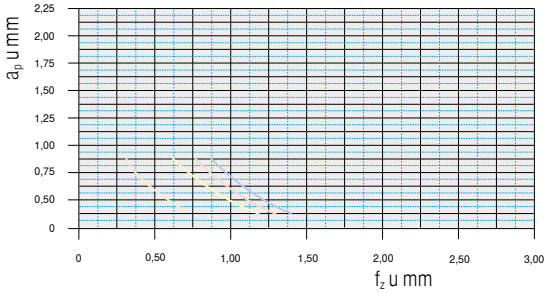


	Cirkularno			Aksijalni	Koso
	Bušenje glodanjem (cirkularno uranjanje u kruti materijal)			Uranjanje	
DC mm	$D_{max.}$ mm	$D_{min.}$ mm	$\alpha_{R\,max.}$ °	$X_{max.}$ mm	$\alpha_{R\,max.}$ °
16	31	22	4,5°	0,5	5,9°
20	39	30	2,3°		3,2°
25	49	40	1,3°		2°
32	63	54	0,9°		1,3°

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

XPLX 06



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**XPLX 060305SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**XPLX 060305ER-M40**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**XPLX 060305ER-M50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**XPLX 060305SR-F40**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill HFC-09

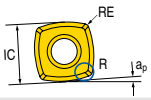
Referentne vrijednosti podataka o rezanju / tehnološki podaci

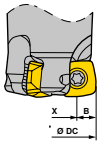
	F			M			R		
Materijal	v_c u m/min	f_z u mm	a_p u mm	v_c u m/min	f_z u mm	a_p u mm	v_c u m/min	f_z u mm	a_p u mm
Čelik				60–280	0,2–2,5	1	60–280	0,2–2,5	1
Nehrđajući čelik				60–270	0,2–2,5	1	60–270	0,2–2,5	1
Lijevano željezo				130–360	0,2–2,5	1	130–360	0,2–2,5	1
Neželjezni metali									
Visokootporan na toplinu				25–75	0,2–2,5	1	25–75	0,2–2,5	1
Kaljeni čelik									

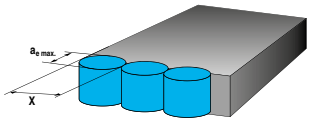
Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

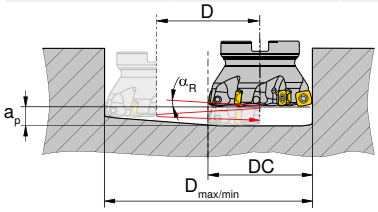
Programirani radijus R = 2 mm

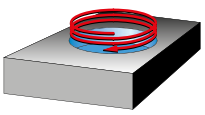


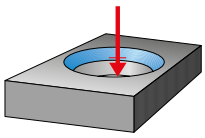


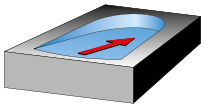


Dubina rezanja i ostatak materijala			Širina rezanja za ravne površine			Djelovanje kod potopnog glodanja				
IC in mm	RE u mm	$a_{p\,maks.}$ u mm	DC u mm	X u mm	B u mm	$a_{e\,max.}$ u mm	f_z u mm			X
							Inicijalno	Min.	Maks.	
9	0,8	1	25–66	DC–(2 x B)	5,9	7,5	0,10	0,08	0,15	<0,7 x DC







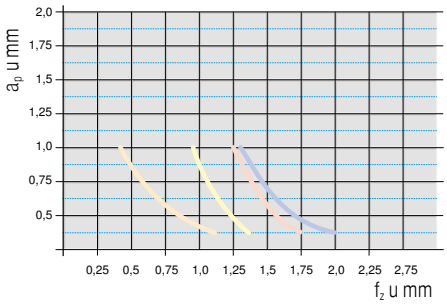


	Cirkularno				Aksijalni	Koso
	Bušenje glodanjem (cirkularno uranjanje u kruti materijal)				Uranjanje	
DC mm	$D_{max.}$ mm	$D_{min.}$ mm	$\alpha_{R\,max.}$ °	**DC** mm	$X_{max.}$ mm	$\alpha_{R\,max.}$ °
25	48	35	3,1°	**25**		3,6°
32	62	49	1,7°	**32**		2,0°
35	68	55	1,4°	**35**		1,6°
40	78	65	1,0°	**40**		1,2°
42	82	69	0,9°	**42**	0,75	1,1°
50	98	85	0,8°	**50**		0,9°
52	102	89	0,7°	**52**		0,8°
63	124	111	0,7°	**63**		0,8°
66	130	117	0,6°	**66**		0,7°

Početni parametar

	Primjer materijala			
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

XDLX 09



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**XDLX09T308SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**XDLX09T308SR-M50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**XDLX09T308SR-M50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**XDLX09T308ER-F40**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill HFC-12

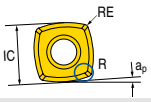
Referentne vrijednosti podataka o rezanju / tehnološki podaci

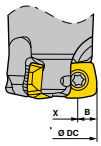
	F			M			R		
Materijal	v_c u m/min	f_z u mm	a_p u mm	v_c u m/min	f_z u mm	a_p u mm	v_c u m/min	f_z u mm	a_p u mm
Čelik				60–280	0,2–3,0	2	60–280	0,2–3,0	2
Nehrđajući čelik				60–270	0,2–3,0	2	60–270	0,2–3,0	2
Lijevano željezo				130–360	0,2–3,0	2	130–360	0,2–3,0	2
Neželjezni metali									
Visokootporan na toplinu				25–75	0,2–3,0	2	25–75	0,2–3,0	2
Kaljeni čelik									

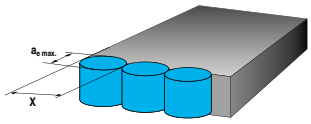
Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

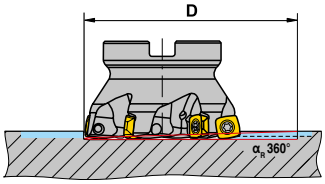
Programirani radijus R = 3 mm

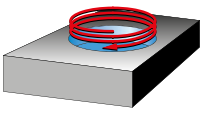


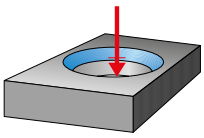


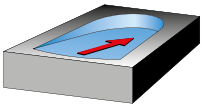


Dubina rezanja i ostatak materijala			Širina rezanja za ravne površine			Djelovanje kod potopnog glodanja				
IC in mm	RE u mm	$a_{p\,maks.}$ u mm	DC u mm	X u mm	B u mm	$a_{e\,max.}$ u mm	f_z u mm			X
							Inicijalno	Min.	Maks.	
12	1,0	2	32–100	DC–(2 x B)	8,3	10	0,15	0,10	0,20	<0,7 x DC







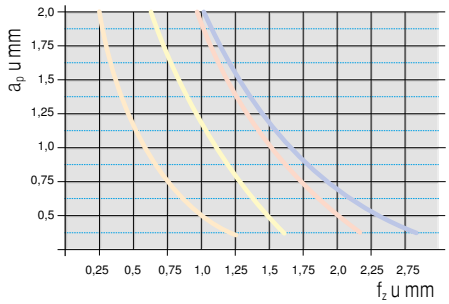


	Cirkularno			Aksijalni	Koso
	Bušenje glodanjem (cirkularno uranjanje u kruti materijal)			Uranjanje	
DC mm	$D_{max.}$ mm	$D_{min.}$ mm	$\alpha_{R\,max.}$ °	$X_{max.}$ mm	$\alpha_{R\,max.}$ °
32	62	44	6,1°	1,15	7,2°
35	68	50	3,7°		4,4°
40	78	60	2,5°		2,9°
42	82	64	2,3°		2,7°
50	98	80	1,3°		1,5°
52	102	84	1,3°		1,1°
63	124	106	0,9°		1,3°
66	130	112	0,9°		0,7°
80	158	140	1,1°		
100	198	180	0,6°		

Početni parametar

	Primjer materijala			
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

XOLX 12



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**XOLX120410SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**XOLX120410ER-M50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**XOLX120410ER-M50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**XOLX120410ER-F40**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav MaxiMill HFC-19

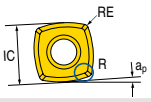
Referentne vrijednosti podataka o rezanju / tehnološki podaci

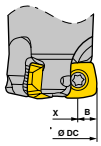
	F			M			R		
Materijal	v_c u m/min	f_z u mm	a_p u mm	v_c u m/min	f_z u mm	a_p u mm	v_c u m/min	f_z u mm	a_p u mm
Čelik				60–280	0,2–3,0	3,3	60–280	0,2–3,0	3,3
Nehrđajući čelik				60–270	0,2–3,0	3,3	60–270	0,2–3,0	3,3
Lijevano željezo				130–360	0,2–3,0	3,3	130–360	0,2–3,0	3,3
Neželjezni metali									
Visokootporan na toplinu				25–75	0,2–3,0	3,3	25–75	0,2–3,0	3,3
Kaljeni čelik									

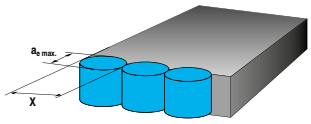
Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Strategija obrade

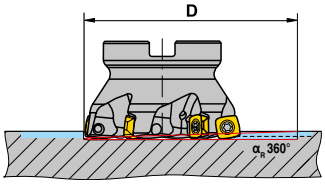
Programirani radijus R = 5 mm

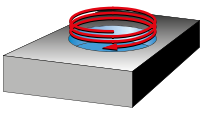


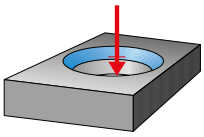


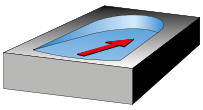


Dubina rezanja i ostatak materijala			Širina rezanja za ravne površine			Djelovanje kod potopnog glodanja				
IC in mm	RE u mm	$a_{p\,maks.}$ u mm	DC u mm	X u mm	B u mm	$a_{e\,max.}$ u mm	f_z u mm			X
							Inicijalno	Min.	Maks.	
19,14	1,5	3,3	63–160	DC–(2 x B)	13,1	12	0,2	0,10	0,25	<0,65 x DC









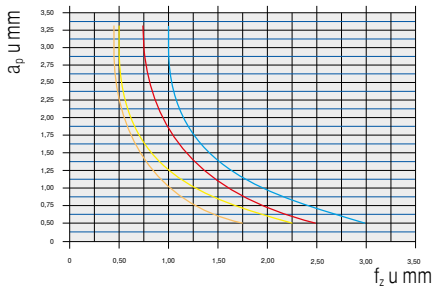
	Cirkularno		
	Bušenje glodanjem (cirkularno uranjanje u kruti materijal)		
DC mm	$D_{max.}$ mm	$D_{min.}$ mm	$\alpha_{R\,max.}$ °
63	97	123	2,5
80	131	157	1,4
100	171	197	1,0
125	221	247	0,7
160	291	317	0,5

	Aksijalni	Koso	
	Uranjanje		
DC mm	$X_{max.}$ mm	$\alpha_{R\,max.}$ °	$a_{p\,max}$ mm
63		2,9	
80		1,8	
100	1,7	1,3	3,3
125		1,0	
160		0,7	

Početni parametar

Primjer materijala				
Čelik	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Nehrđajući čelik	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Lijevano željezo	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Visokootporan na toplinu	1450 N/mm²	5.8	Inconel 625	Inconel 718

XOLX 19



Materijal		Okretna pločica		v_c u m/min	Hlađenje
Čelik	1.2312	**XOLX190615SR-M50**	**CTPP235** (DPX1235)	200	Suho
Nehrđajući čelik	1.4571	**XOLX190615SR-M50**	**CTPM240** (DPX2240)	180	Suho
Lijevano željezo	5.1301	**XOLX190615SR-M50**	**CTCK215** (DCX3215)	250	Suho
Visokootporan na toplinu	2.4856	**XOLX190615ER-F40**	**CTC5240** (HCF5240)	35	Emulzija

Od v_c > 400 m/min alat mora biti izbalansiran!

Sustav DHFC

Referentne vrijednosti podataka o rezanju / tehnološki podaci

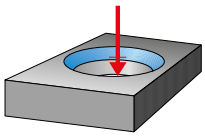
Za standardne okretne pločice

	F			M			R		
Materijal	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Čelik	130–300	0,25–1,0	0,7	130–300	0,25–1,0	0,7	130–300	0,25–1,0	0,7
Nehrđajući čelik				80–210	0,25–1,0	0,6			
Lijevano željezo				120–250	0,2–1,1	0,7	120–270	0,2–1,2	0,75
Neželjezni metali									
Visokootporan na toplinu				30–90	0,15–0,75	0,6			
Kaljeni čelik									

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

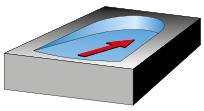
Strategija obrade

Aksijalno uranjanje u kruti materijal



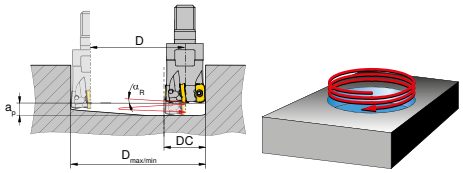
DC mm	X_{max} mm
16	0,35
20	0,40
25	0,45
32–35	0,50
40	0,55

Koso uranjanje



DC mm	α°	y mm
16	<2,5	7
20	<1,9	11
25	<1,5	16
32	<1,2	23
35	<1,0	26
42	<0,9	33

Cirkularno glodanje



DC mm	D_{min} mm	D_{max} mm
16	23	31
20	31	39
25	41	49
32	55	63
35	61	69
42	75	83

Sustav MaxiMill 251

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

	F				
		05		08	
Materijal	v_c m/min	f_z mm	a_p mm	f_z mm	a_p mm
Čelik	50–350	0,08–0,35	2,5	0,08–0,35	4
Nehrđajući čelik	130–280	0,08–0,35	2,5	0,08–0,35	4
Lijevano željezo	100–360			0,1–0,4	4
Neželjezni metali	160–1500	0,05–0,4	2,5	0,05–0,4	4
Visokootporan na toplinu	25–75			0,08–0,35	4
Kaljeni čelik					

	M						
		10		12		16	
Materijal	v_c m/min	f_z mm	a_p mm	f_z mm	a_p mm	f_z mm	a_p mm
Čelik	50–350	0,08–0,4	5	0,08–0,4	6	0,08–0,4	8
Nehrđajući čelik	60–280	0,08–0,35	5	0,08–0,35	6	0,08–0,35	8
Lijevano željezo	100–360	0,1–0,4	5	0,1–0,4	6	0,1–0,4	8
Neželjezni metali	160–1500	0,05–0,4	5	0,05–0,4	6	0,05–0,4	8
Visokootporan na toplinu	25–75	0,08–0,38	5	0,08–0,38	6	0,08–0,38	8
Kaljeni čelik	40–60			0,05–0,35	6		

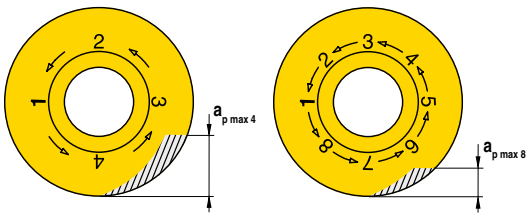
	R						
		20					
Materijal	v_c m/min	f_z mm	a_p mm	f_z mm	a_p mm	f_z mm	a_p mm
Čelik	50–350	0,1–0,4	10				
Nehrđajući čelik	60–280	0,08–0,35	10				
Lijevano željezo	100–360	0,1–0,4	10				
Neželjezni metali	160–1500	0,05–0,4	10				
Visokootporan na toplinu	25–75	0,08–0,38	10				
Kaljeni čelik							

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Preporučene dubine rezanja

Ø mm	4-struko $a_{p\,max.}$ mm	4-struko $a_{p\,maks}$ teoretski mm	8-struko $a_{p\,max.}$ mm
5	1,0	2,0	0,7
8	1,5	3,5	1,1
10	2,5	4,5	1,4
12	3,0	5,5	1,7
16	4,0	7,5	2,3
20	4,0	9,5	2,9

Dubina rezanja za 4-/8-struku uporabu okretne rezne pločice

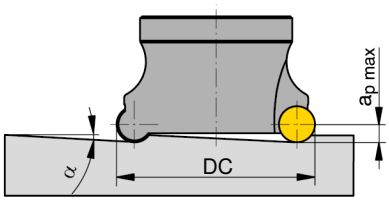


15

Sustav MaxiMill 251

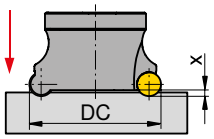
Tehnološki podaci

Linearno uranjanje



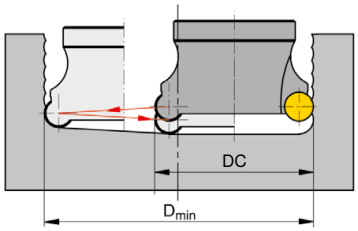
	05	08	10	12	16	20
Ø DC mm	α °	α °	α °	α °	α °	α °
10	3,4					
12	16,0					
16	8,0	5,0				
20	5,5	20,0	1,3			
25	4,0	13,0	2,0	6,0		
32	3,0	8,0	3,0	4,0		
40			3,3	2,8		
42			3,1			
50			2,4	2,6	4,0	
52			2,2	2,3		
63				1,9	2,8	
66				1,6		
80				1,3	2,0	3,2
100				1,0	1,5	2,3
125						1,7

Aksijalno uranjanje

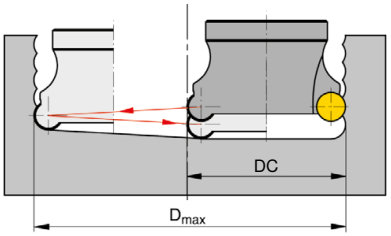


	05	08	10	12	16	20
Ø DC mm	X max. mm	X max. mm	X max. mm	X max. mm	X max. mm	X max. mm
10	0,5					
12	1,3					
16	1,3	0,5				
20	1,3	2,7	0,2			
25	1,3	2,7	0,4	1,0		
32	1,3	2,7	0,8	1,1		
40			1,5	1,2		
42			1,5	1,5		
50			1,5	1,5	2,0	
52			1,5	1,5	2,0	
63				1,5	2,0	
66				1,5	2,0	
80				1,5	2,0	3,0
100				1,5	2,0	3,0
125						3,0

Cirkularno glodanje u krutom materijalu



$D_{min.}$ = Najmanji promjer provrta ovisno o promjeru alata



$D_{maks.}$ = Najveći promjer provrta ovisno o promjeru alata

Maksimalni mogući promjer provrta = 2 x DC – 1 mm.

	05			08			10			12			16			20		
Ø DC mm	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °
10	12	15	2,5															
12	16	19	2,1															
16	24	27	1,5	21	24	2,4												
20	32	35	1,2	27	32	1,9	26	30	1,3									
25	42	45	1,0	37	42	1,5	37	40	1,8	31	38	2,2						
32	56	59	0,7	51	56	1,2	50	54	1,5	46	52	1,7						
40							64	70	1,1	62	68	1,4						
42							68	74	1,1									
50							84	90	0,9	81	88	1,1	75	84	1,5			
52							88	94	0,9	86	92	1,0						
63										107	114	0,9	101	110	1,1			
66										113	120	0,8						
80										142	148	0,7	135	144	0,9	128	140	1,1
100										181	188	0,5	175	184	0,7	168	180	0,9
125																218	230	0,7

Sustav R100.

Referentne vrijednosti podataka o rezanju

	v_c m/min	WTN 1205	WAN 2225	WAN 1240	WAX 1240	WUN 4210
Čelik						
Nelegirani čelik	**R**	150–250		100–250	100–300	
	F	200–400			150–350	
Legirani alatni čelik Lijevani čelik	**R**	150–250		100–200	100–250	
	F	200–350			150–300	
Visokolegirani alatni čelik	**R**	120–200		100–150	150–180	
	F	150–300			150–250	
Nehrđajući čelik						
	R		80–200			
	F	100–200	80–230			
Lijevano željezo						
Sivo lijevano željezo GG	**R**	150–200			160–220	
	F	200–350			160–220	
Nodularno lijevano željezo GGG	**R**	150–200			160–220	
	F	200–350			160–220	
Obogaćeno lijevano željezo	**R**	100–180			160–220	
	F	200–350			160–220	
Neželjezni metali						
Aluminij	**R**					100–800
	F					100–800
Bakar	**R**					100–400
	F					100–400
Grafit	**R**	200–800				200–800
	F	200–800				200–800
Plastika	**R**	200–800				200–800
	F	200–800				200–800
Visokootporan na toplinu						
Legure visokootporne na toplinu	**R**					
	F					
Legure titanija	**R**		40–50			
	F		40–60			
Kaljeni čelik						
Do 48 HRC	**R**	150–250			80–150	
	F	150–250				
Do 55 HRC	**R**	100–180				
	F	100–180				
Do 65 HRC	**R**	35–150				
	F	35–150				

R (gruba obrada)
F (fina obrada)

Sustav R 1000, 1002, 1007

Referentne vrijednosti podataka o rezanju

		f_z, a_p mm	WTN1205	WUN 4210	WAN2225	WAX1240	WAN1240
Čelik							
	0501	f_z	0,1–0,3				
		a_p	0,1–0,3				
	07T1	f_z	0,1–0,3	0,1–0,2		0,1–0,3	
		a_p	0,1–0,5	0,1–0,2		0,1–0,7	
	0702	f_z	0,1–0,3			0,2–0,5	
		a_p	0,1–0,7			0,1–0,75	
	1003	f_z	0,1–0,3	0,15–0,3		0,2–0,7	0,2–0,9
		a_p	0,1–1,0	0,1–0,3		0,2–1,5	0,2–1,5
	12T3	f_z	0,1–0,3	0,15–0,3		0,2–0,8	0,25–1,0
		a_p	0,1–1,5	0,1–0,3		0,2–2,0	0,2–2,0
	1604	f_z	0,2–0,3			0,25–1,0	0,3–1,2
		a_p	0,2–1,5			0,2–3,0	0,25–3,0
	2006	f_z	0,25–0,4				
		a_p	0,2–2,0				
Nehrđajući čelik							
	0501	f_z	0,1–0,15				
		a_p	0,1–0,15				
	07T1	f_z	0,1–0,2	0,1–0,2			
		a_p	0,1–0,2	0,1–0,2			
	0702	f_z	0,1–0,2	0,1–0,2			
		a_p	0,1–0,2	0,1–0,2			
	1003	f_z	0,15–0,3	0,15–0,3	0,15–0,6		
		a_p	0,1–0,3	0,1–0,3	0,4–1,0		
	12T3	f_z	0,15–0,3	0,15–0,3	0,2–0,8		
		a_p	0,1–0,3	0,1–0,3	0,5–2,0		
	1604	f_z	0,15–0,3	0,15–0,3	0,3–1,0		
		a_p	0,1–0,3	0,1–0,3	0,6–3,0		
	2006	f_z		0,15–0,3			
		a_p		0,1–0,4			
Lijevano željezo							
	0501	f_z	0,1–0,2				
		a_p	0,1–03				
	07T1	f_z	0,1–0,3	0,1–0,3		0,1–0,3	
		a_p	0,1–0,5	0,1–0,5		0,1–0,5	
	0702	f_z	0,1–0,3	0,1–0,3		0,1–0,3	
		a_p	0,1–0,7	0,1–1,0		0,1–0,7	
	1003	f_z	0,15–0,3	0,15–0,3		0,1–0,3	0,1–0,3
		a_p	0,1–1,0	0,1–1,5		0,1–1,0	0,1–1,0
	12T3	f_z	0,15–0,4	0,15–0,4		0,1–0,4	0,1–0,4
		a_p	0,1–1,5	0,1–2,0		0,1–1,5	0,1–1,5
	1604	f_z	0,2–0,5	0,2–0,5		0,2–0,5	0,2–0,5
		a_p	0,2–3,0	0,2–3,0		0,2–3,0	0,2–2,0
	2006	f_z	0,25–0,6	0,25–0,6			
		a_p	0,2–4,0	0,2–4,0			

Sustav R 1000, 1002, 1007

Referentne vrijednosti podataka o rezanju

		f_z, a_p mm	WTN1205	WUN4210	WAN2225	WAX1240	WAN1240
Neželjezni metali							
	0501	f_z	0,1–0,2				
		a_p	0,1–0,3				
	07T1	f_z	0,1–0,3				
		a_p	0,1–0,7				
	0702	f_z	0,1–0,3				
		a_p	0,1–1,0				
	1003	f_z	0,1–0,3				
		a_p	0,1–1,5				
	12T3	f_z	0,1–0,4				
		a_p	0,1–2,0				
	1604	f_z	0,2–0,5				
		a_p	0,2–4,0				
	2006	f_z	0,25–0,6				
		a_p	0,2–5,0				
Visokootporan na toplinu							
	0501	f_z					
		a_p					
	07T1	f_z					
		a_p					
	0702	f_z					
		a_p					
	1003	f_z			0,1–0,4		
		a_p			0,2–1,0		
	12T3	f_z			0,15–0,5		
		a_p			0,3–1,5		
	1604	f_z			0,15–0,5		
		a_p			0,3–2,0		
	2006	f_z					
		a_p					
Kaljeni čelik							
	0501	f_z	0,1–0,15				
		a_p	0,1–0,2				
	07T1	f_z	0,1–0,15			0,1–0,2	
		a_p	0,1–0,2			0,1–0,3	
	0702	f_z	0,1–0,2			0,1–0,2	
		a_p	0,1–0,3			0,1–0,3	
	1003	f_z	0,1–0,2			0,1–0,2	
		a_p	0,1–0,5			0,1–0,5	
	12T3	f_z	0,1–0,25			0,1–0,25	
		a_p	0,1–0,7			0,1–0,7	
	1604	f_z	0,15–0,3			0,15–0,3	
		a_p	0,2–1,0			0,2–1,0	
	2006	f_z	0,2–0,4				
		a_p	0,2–1,0				

WTN 1205

Do 48 HRC: a_p– Područje kako je navedeno u tablici
Do 55 HRC: Maksimalna vrijednost a_p x 0,7
Do 65 HRC: Maksimalna vrijednost a_p x 0,5

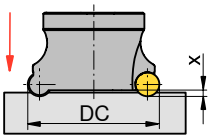
15

Sustav R 1000, 1002, 1007

Tehnološki podaci

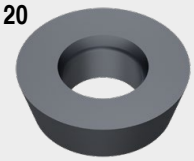
Strategija obrade

Aksijalno uranjanje

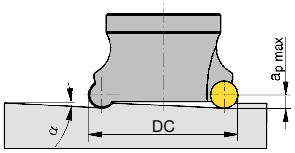


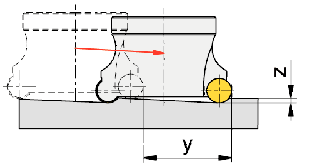
f_z u skladu s tablicom primjene smanjiti na 30 %.

→ v_c Stranica 178+179

	05	07	10	12	16	20
						
Ø DC mm	$X_{max.}$ mm	$X_{max.}$ mm	$X_{max.}$ mm	$X_{max.}$ mm	$X_{max.}$ mm	$X_{max.}$ mm
8–160	1,0	1,2	2,5	3,0	4,0	5,0

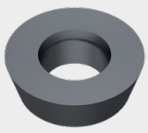
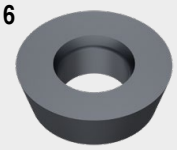
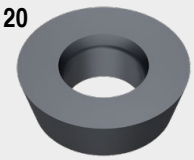
Linearno uranjanje





y = minimalna putanja
z = maksimalna dopuštena dubina uranjanja
a_p / f_z u skladu s tablicom primjene

→ v_c Stranica 178+179

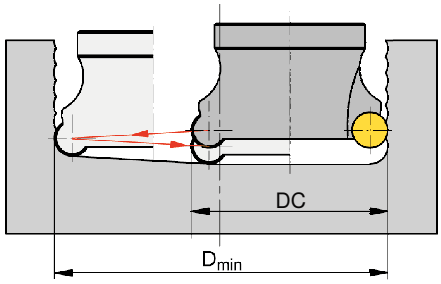
	05			07			10			12			16			20		
																		
Ø DC mm	α°	y mm	z mm	α°	y mm	z mm	α°	y mm	z mm	α°	y mm	z mm	α°	y mm	z mm	α°	y mm	z mm
8	26,5	2	< 1,0															
10																		
12	14,0	4	< 1,0															
14	9,5	6	< 1,0															
15	8,1	7	< 1,0	26,5	2	< 1,2												
16	7,1	8	< 1,0	14,0	4	< 1,2												
18	5,7	10	< 1,0	11,3	6	< 1,2												
20	4,7	12	< 1,0	8,5	8	< 1,2												
22																		
24																		
25				5,3	13	< 1,2	19,7	7	< 2,5									
30				3,8	18	< 1,2	11,7	12	< 2,5									
32																		
35				3,0	23	< 1,2	8,4	17	< 2,5	13,0	13	< 3,0	38,7	5	< 4,0			
40																		
42				2,3	30	< 1,2	5,9	24	< 2,5	8,5	20	< 3,0						
50																22,6	12	< 5,0
52							4,2	34	< 2,5	5,7	30	< 3,0	10,3	22	< 4,0			
66										3,9	44	< 3,0	6,4	36	< 4,0	10,1	28	< 5,0
80										3,0	58	< 3,0	4,6	50	< 4,0	6,8	42	< 5,0
100													3,3	70	< 4,0	4,6	62	< 5,0
125													2,4	95	< 4,0	3,3	87	< 5,0
160													1,8	130	< 4,0	2,3	122	< 5,0

Sustav R 1000, 1002, 1007

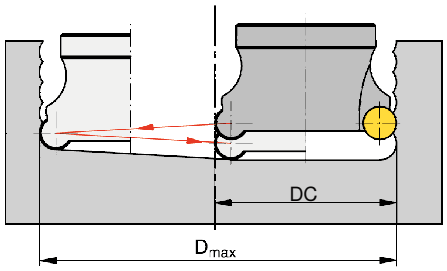
Tehnološki podaci

Strategija obrade

Cirkularno uranjanje



$D_{min.}$ = Minimalni promjer provrta ovisno o promjeru alata



$D_{maks.}$ = Maksimalni promjer provrta ovisno o promjeru alata

a_p / f_z u skladu s tablicom primjene.

→ v_c Stranica 178+179

	05		07		10		12		16		20	
Ø DC	D_{min}	D_{max}	D_{min}	D_{max}	D_{min}	D_{max}	D_{min}	D_{max}	D_{min}	D_{max}	D_{min}	D_{max}
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
8	10	16										
10	12	20										
12	16	24	14	24								
14	20	28	16	28								
15	22	30	17	30								
16	24	30	20	32								
18	28	36	24	36	20	36						
20	32	40	28	40	22	40						
22							24	44				
24							26	48				
25			38	50	32	50						
30			48	60	42	60						
32									34	64		
35			58	80	72	70	48	70	40	70		
40											42	80
42			72	84	66	84	62	84				
50											62	100
52					86	104	82	104	74	104		
66							110	132	102	132	94	132
80							138	160	130	160	122	160
100									170	200	162	200
125									220	250	212	250
160									290	320	282	320

Sustav MaxiMill 252

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

	M						
		10		12			
Materijal	v_c m/min	f_z mm	a_p mm	f_z mm	a_p mm	f_z mm	a_p mm
Čelik	60–240	0,08–0,35	2,5	0,08–0,35	3		
Nehrđajući čelik	60–280	0,05–0,35	2,5	0,05–0,35	3		
Lijevano željezo							
Neželjezni metali							
Visokootporan na toplinu	25–75	0,08–0,35	2,5	0,08–0,35	3		
Kaljeni čelik							

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

MaxiMill 252 – preporučena dubina rezanja

	4-struko	
Ø mm	$a_{p\,max}$ mm	$a_{p\,maks}$ teoretski mm
10	2,5	4,5
12	3,0	5,5

Referentne vrijednosti podataka o rezanju za kopirno glodalo K200.

● 1. Odabir ○ Prikladan

	R	F	R	F	R	F	R	F	Odgovarajuća rashladna sredstva		
	CTPK226		CTPP211		CTPK231		CTCN211		Emulzija	Stlačeni zrak	MMS
Indeks	v_c m/min	v_c m/min	v_c m/min	v_c m/min	v_c m/min	v_c m/min	v_c m/min	v_c m/min			
1.1		280–300	180–220	220–300	160–200				○	●	●
1.2		280–300	180–220	220–300	160–200				○		●
1.3		280–300	180–220	220–300	160–200				○		●
1.4		280–300	180–220	220–300	160–200				○		●
1.5		220–240	180–220	220–240	160–200				○	●	●
1.6		220–240	180–220	220–240	160–200				○		●
1.7		220–240	180–220	220–240	160–200				○	●	●
1.8		220–240	180–220	220–240	160–200				○		●
1.9		220–240	180–220	220–240	160–200				○		●
1.10		280–300	140–220	200–300	140–180				○	●	●
1.11		280–300	140–220	200–300	140–180				○		●
1.12		280–300	140–220	200–300	140–180				○		●
1.13		280–300	140–220	200–300	140–180				○		●
1.14		280–300	140–220	200–300	140–180				○		●
1.15		280–320	180–220	240–320	160–200				○	●	●
1.16		280–320	180–220	240–320	160–200				○	●	●
2.1		220–220	140–180	200–240	120–180				●		
2.2		220–220	140–180	200–240	120–180				●		
2.3		220–220	140–180	200–240	120–180				●		
2.4		220–220	140–180	200–240	120–180				●	○	
2.5		220–220	140–180	200–240	120–160				●		
2.6		180–200	140–160	180–200	120–160				●	○	
2.7		180–200	140–160	180–200	120–160				●		
3.1		280–300	160–200	200–300	120–200					●	○
3.2		280–300	160–200	200–300	120–200					●	○
3.3		280–300	160–200	200–300	120–200					●	○
3.4		300–350	180–220	240–350	180–200					●	○
3.5		300–350	180–220	240–350	180–200					●	○
3.6		300–350	180–220	240–350	180–200					●	○
3.7		300–350	180–220	240–350	180–200					●	○
3.8		240–260	160–200	220–260	160–200					●	○
4.1			240–280	300–600	300–600				●		
4.2			240–280	300–600	300–600				●		
4.3			240–280	300–600	300–600				●		
4.4			240–280	300–600	300–600				●		
4.5									●		
4.6			240–280	300–600	240–280				●		
4.7			240–280	300–600	240–280				●		
4.8			240–280	300–600	240–280				●		
4.9			240–280	300–600	240–280				●		
4.10			240–280	280–320	240–280				●		
4.11			240–280	280–320	240–280				●		
4.12			240–280	280–320	240–280				●		
4.13			500–600	500–600			400–600	600–800		●	
4.14			300–400	300–400						●	
4.15			300–400	300–400				250–300		●	
4.16			300–400	300–400				300–400	●		
4.17							400–600	600–800		●	
4.18							100–140	160–180	●		
4.19							100–140	100–140	●		
5.1					80–120				●		
5.2				80–120	80–120				●		
5.3				80–120	80–120				●		
5.4				80–120	80–120				●		
5.5				80–120	80–120				●		
5.6				80–120	80–120				●		
5.7				80–120	80–120				●		
5.8				80–120	80–120				●		
5.9				80–120	80–120				●		
5.10				60–80	60–80				●	○	
5.11				60–80	80–100				●	○	
6.1		240–260		60–80	140–160						
6.2		240–260	140–200	220–300	140–160					●	○
6.3		200–220	120–160	180–300	80–100					●	○
6.4		120–140	100–120	120–200						●	○
6.5											

Referentne vrijednosti podataka o rezanju za kopirno glodalo K200.

● 1. Odabir ○ Prikladan

	R	F	Gruba obrada (R)		Fina obrada (F)		Samo za -MR3 grubu obradu (R)		Odgovarajuća rashladna sredstva		
	CTPP216		Ø 6–16	Ø 20–32	Ø 6–16	Ø 20–32	Ø 6–16	Ø 20–32	Emulzija	Stlačeni zrak	MMS
Indeks	v_c m/min	v_c m/min	f_z mm	f_z mm	f_z mm	f_z mm	f_z mm	f_z mm			
1.1	220-300	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,2-1,5	○	●	●
1.2	220-300	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,2-1,5	○		●
1.3	220-300	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,2-1,5	○		●
1.4	220-300	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,2-1,5	○		●
1.5	220-300	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,2-1,5	○	●	●
1.6	220-300	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	○		●
1.7	260-340	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	○	●	●
1.8	260-340	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	○		●
1.9	260-340	280-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	○		●
1.10	240-340	240-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,20	○	●	●
1.11	240-340	240-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5	○		●
1.12	240-340	240-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5	○		●
1.13	240-340	240-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5	○		●
1.14	240-340	240-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5	○		●
1.15	250-360	240-320	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5	○	●	●
1.16	250-360	240-320	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5	○	●	●
2.1	220-300	220-240	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	●		
2.2	220-300	220-240	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	●		
2.3	220-300	220-240	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	●		
2.4	220-300	220-240	0,08-0,4	0,25-0,45	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	●	○	
2.5	220-300	220-240	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25	●		
2.6	220-250	220-240	0,08-0,4	0,25-0,45	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,5	●	○	
2.7	220-250	220-240	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,5	●		
3.1	240-350	240-260	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5		●	○
3.2	240-350	240-260	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5		●	○
3.3	240-350	240-260	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,8	1,0-1,5		●	○
3.4	340-400	240-360	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25		●	○
3.5	340-400	240-360	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25		●	○
3.6	340-400	240-360	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25		●	○
3.7	340-400	240-360	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25		●	○
3.8	280-340	220-300	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,3-0,6	0,8-1,25		●	○
4.1		400-450	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.2		400-450	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.3		400-450	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.4		400-450	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.5		300-400	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.6		300-400	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.7		300-400	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.8		300-400	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.9		300-400	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.10		300-400	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.11		300-400	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.12		300-400	0,08-0,35	0,25,0,45	0,06-0,25	0,025-0,45			●		
4.13		600-800	0,25-0,35	0,4-0,5	0,08-0,3	0,25-0,4				●	
4.14		300-350	0,25-0,35	0,4-0,5	0,08-0,3	0,25-0,4				●	
4.15			0,25-0,35	0,4-0,5	0,08-0,3	0,25-0,4				●	
4.16			0,25-0,35	0,4-0,5	0,08-0,3	0,25-0,4			●		
4.17			0,25-0,35	0,4-0,5	0,08-0,3	0,25-0,4				●	
4.18							0,20-0,4	0,4-0,8	●		
4.19							0,20-0,4	0,4-0,8	●		
5.1		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,20-0,4	0,4-0,8	●		
5.2		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,20-0,4	0,4-0,8	●		
5.3		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,20-0,4	0,4-0,8	●		
5.4		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,20-0,4	0,4-0,8	●		
5.5		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,20-0,4	0,4-0,8	●		
5.6		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,20-0,4	0,4-0,8	●		
5.7		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,25-0,5	0,6-1,0	●		
5.8		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,25-0,5	0,6-1,0	●		
5.9		60-80	0,08-0,3	0,15-0,4	0,05-0,2	0,15-0,25	0,25-0,5	0,6-1,0	●		
5.10		60-80	0,08-0,35	0,4-0,5	0,08-0,3	0,25-0,4	0,25-0,5	0,6-1,0	●	○	
5.11		60-80	0,08-0,35	0,4-0,5	0,08-0,3	0,25-0,4	0,25-0,5	0,6-1,0	●	○	
6.1	240-260	240-260	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,25-0,5	0,6-1,0			
6.2	240-260	240-260	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5	0,25-0,5	0,6-1,0		●	○
6.3	220-240	160-240	0,08-0,4	0,25-0,5	0,08-0,3	0,2-0,5				●	○
6.4	120-140	100-140	0,25-0,35	0,4-0,5	0,08-0,2	0,18-0,35				●	○
6.5											

Maksimalne aksijalne dubine dopremanja a_p za kopirno glodalo K200.

Pločice s kuglicama									
Okretne pločice Ø u mm		6	8	10	12	16	20	25	32
		$a_{p\ max.}$	$a_{p\ max.}$	$a_{p\ max.}$	$a_{p\ max.}$	$a_{pmax.}$	$a_{p\ max.}$	$a_{p\ max.}$	$a_{p\ max.}$
ROHX-FM3	**R**	0,8	1,0	1,5	2,0	3,0	4,0	5,0	6,0
	F	0,4	0,8	1,0	1,2	1,5	1,5	2,0	2,0
ROHX-FM4	**R**	0,8	1,0	2,0	3,0	4,0	5,0	6,0	8,0
	F	0,4	0,8	1,0	1,2	1,5	1,5	2,0	2,0
ROHX-FM6	**R**	0,8	1,0	1,5	2,0	3,0	4,0	5,0	6,0
	F	0,4	0,8	1,0	1,2	1,5	1,5	2,0	2,0
ROGX-MR4	**R***				4,0	6,0	8,0	12,0	16,0
	F				2,0	3,0	4,0	5,0	6,0
ROHX-MR5	**R**		1,5	2,0					
	F		0,8	1,0					

*a_p kod punog djelovanja iznosi maksimalno 25 % od Ø DC!

Torusne pločice									
Okretne pločice Ø u mm		6	8	10	12	16	20	25	32
		$a_{p\ max.}$	$a_{p\ max.}$	$a_{p\ max.}$	$a_{p\ max.}$	$a_{pmax.}$	$a_{p\ max.}$	$a_{p\ max.}$	$a_{p\ max.}$
XOHX-FM5	**R**		2,0	3,0	3,0	4,0	5,0	6,0	8,0
	F		0,6	2,0	2,4	3,2	4,0	5,0	6,4
XOHX-MR6	**R**		2,0	3,0	3,0	4,0	5,0	6,0	8,0
	F		0,6	2,0	2,4	3,2	4,0	5,0	6,4
XOHX-FM1	**R**			1,5	2,0	3,0	4,0		
	F			0,8	0,8	1,0	1,0		
XOHX-FM2	**R**		1,0	1,5	2,0	3,0	4,0	5,0	
	F		0,5	0,7	0,8	1,0	1,0	1,5	
XOHX-MR2	**R**	0,8	1,0	1,5	2,0	3,0	4,0	5,0	
	F	0,5	0,5	0,7	0,8	1,0	1,0	1,5	
XOGX-MF4	**R**			1,5	2,0	3,0	4,0		
	F			0,7	0,8	1,0	1,0		
XOHX-MR3	**R**			0,5	0,6	0,8	1,0		
	F								

Područje primjene geometrije

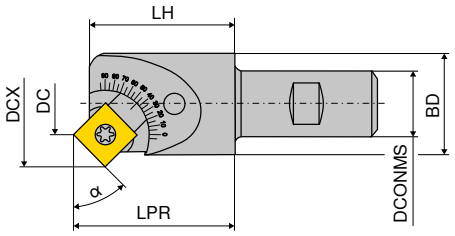
Okretna pločica	F	M	R	Glavna primjena
XOHX-FM1	●	●		Čelik, lijevani čelik, čelici s visokom otpornošću na toplinu, kaljeni čelici do 63 HRC
XOHX-FM2	●	●		Čelik, lijevani čelik, čelici s visokom otpornošću na toplinu, kaljeni čelici do 60 HRC
ROHX-FM3	●	●		Čelik, lijevani čelik, čelici s visokom otpornošću na toplinu
ROHX-FM4	●	●		Čelik, lijevani čelik, čelici s visokom otpornošću na toplinu, kaljeni čelici do 60 HRC
XOHX-FM5	●	●		Čelik, lijevani čelik, čelici s visokom otpornošću na toplinu, kaljeni čelici do 60 HRC
ROHX-FM6	●	●	●	Neželjezni metali, plastika, grafit
XOHX-MR2		●	●	željezni materijali s dugim strugotinama
XOHX-MR3		●	●	Čelik, lijevani čelik, čelici s visokom otpornošću na toplinu
ROGX-MR4		●	●	Čelik, lijevani čelik, čelici s visokom otpornošću na toplinu
XOGX-MF4	●	●		Čelik, lijevani čelik, čelici s visokom otpornošću na toplinu
ROHX-MR5		●	●	željezni materijali s dugim strugotinama
XOHX-MR6		●	●	željezni materijali s dugim strugotinama

Sustav 4500-09

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

Materijal	09 m/min	f_z mm
Čelik	120–250	0,05–0,30
Nehrđajući čelik	110–220	0,08–0,30
Lijevano željezo	120–240	0,10–0,35
Neželjezni metali	200–280	0,10–0,35
Visokootporan na toplinu		
Kaljeni čelik		



Strategija obrade

Postavljeni kut α	$D_{min.}$ mm	$D_{maks.}$ mm
0°	3,0	20,30
5°	3,8	20,90
10°	4,9	21,60
15°	5,8	22,10
20°	6,8	22,60
25°	7,9	23,00
30°	8,9	23,50
35°	10,0	23,60
40°	11,0	23,85
45°	12,3	23,90
50°	13,3	23,85
55°	14,3	23,80
60°	15,5	23,60
65°	16,4	23,40
70°	17,4	23,10
75°	18,4	22,60
80°	19,3	22,20
85°	20,0	21,50
90°	20,8	20,80

Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Sustav 4500-12

Referentne vrijednosti podataka o rezanju / tehnološki podaci

Za standardne okretne pločice

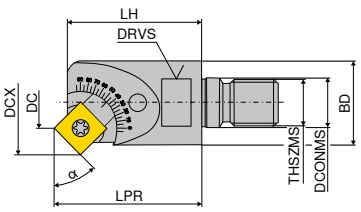
Materijal	12 m/min	f_z mm
Čelik	120–250	0,05–0,25
Nehrđajući čelik	110–220	0,08–0,20
Lijevano željezo	120–240	0,10–0,25
Neželjezni metali	200–280	0,10–0,25
Visokootporan na toplinu		
Kaljeni čelik		

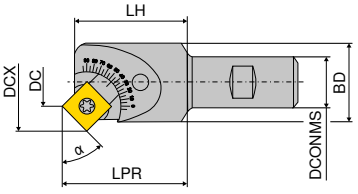
Strategija obrade

Postavljeni kut α	$D_{min.}$ mm	$D_{maks.}$ mm
0°	7,1	30,50
5°	7,8	31,40
10°	9,4	32,40
15°	10,7	33,20
20°	12,0	33,80
25°	13,4	34,40
30°	14,9	34,80
35°	16,5	35,20
40°	17,9	35,40
45°	19,3	35,45
50°	20,8	35,40
55°	22,3	35,20
60°	23,6	34,90
65°	25,0	34,60
70°	26,5	34,00
75°	27,7	33,40
80°	28,8	32,70
85°	29,9	31,90
90°	31,0	31,00

Strategija obrade

Postavljeni kut α	$D_{min.}$ mm	$D_{maks.}$ mm
0°	3,7	27,30
5°	4,7	28,20
10°	6,0	29,00
15°	7,3	29,80
20°	8,8	30,50
25°	10,0	31,00
30°	11,5	31,50
35°	13,1	31,90
40°	14,7	32,15
45°	16,0	32,20
50°	17,5	32,15
55°	19,0	32,00
60°	20,4	31,80
65°	21,8	31,30
70°	23,0	30,90
75°	24,4	30,20
80°	25,7	29,50
85°	26,7	28,70
90°	27,8	27,80





Detaljne informacije brzinam rezanja o pojedinačnim reznim materijalima možete pronaći na → Stranica 138+139

Referentne vrijednosti podataka o rezanju za glodala za obrubljivanje s diskom FM

Materijal	v_c m/min		f_z mm/z	
	CWN 35 **ISO (P35)**	CWK 12 **ISO (K10)**	FM-N	FM-KXF
St 37 / C 15	90–180		0,05–0,08	0,07–0,2
St 50 / C 50	80–150		0,04–0,08	0,07–0,2
St 60–70 / C 60	70–140		0,04–0,08	0,07–0,18
16 Mn Cr 5	50–120		0,04–0,09	0,07–0,2
42 Cr Mo4 / 50 Cr V 4	40–120		0,04–0,09	0,08–0,25
Alatni i HSS čelici	40–90		0,04–0,08	0,07–0,18
X-CrNi čelici otporni na hrđu	30–80		0,04–0,08	0,07–0,15
Feritni, austenitni čelici	10–40		0,03–0,09	0,07–0,15
GG-10		60–180	0,04–0,1	
GG-30		60–150	0,04–0,1	
Temperirani lijev GT		40–100	0,04–0,11	
Aluminij		200–250	0,04–0,12	
G Al Si		200–250	0,06–0,1	
Mjed		50–250	0,05–0,08	
Bakar Cu-E		120–250	0,04–0,08	
Crveni lijev		120–250	0,05–0,09	
Bronca		100–250	0,05–0,1	
Tvrda guma		200–250	0,03–0,15	
Novotex, Pertinax		50–250	0,03–0,1	
Bakelit		50–250	0,03–0,1	

Referentne vrijednosti podataka o rezanju za glodala za obrubljivanje TX

	Materijal			HB	v_c m/min	h_m mm
P	Nelegirani čelik	1.0711 9 S 20 1.0037 ST 37 1.0050 ST 50		125–300	160–240	0,1
	Niskolegirani čelik	1.0070 ST 70 1.7131 16 MnCr 5 1.7218 25 CrMo 4		180–350	70–150	0,08
	Visokolegirani čelik	1.2842 90 MnCr V 8 1.7225 42 CrMo4 V 1.2344 X 40 CrMoV		200–350	50–70	0,05
	Nehrđajući čelik	1.4002 X 6 CrA 13 1.4510 X 6 CrTi 17 1.4104 X 12 CrMoS 17		200–325	80–120	0,08
M	Nehrđajući čelik	1.4057 20 CrNi 17 2 1.4301 X 5 CrNi 18 10 1.4571 X 6 CrNiMoTi 17 12 2		180–330	120–130	0,08
K	Sivi lijev	0.6020 GG 20 0.6040 GG 40		180–260	90–100	0,1
	Sivi lijev sa sferoidalnim grafitom	0.7040 GGG 40 0.7070 GGG 70		160–250	60–100	0,08
N	Kovane aluminijske legure	Ne može se kaliti	Al Mn Al Mg Al Mg Mn	60	500–700	0,12
		Može se kaliti	Al Mg Si Al Cu Mg Al Cu Si Mn	100	200–500	0,12
	Lijevane aluminijske legure	ne može se kaliti < 12 % Si može se kaliti < 12 % Si ne može se kaliti > 12 % Si		80–130	80–220	0,1
	Bakar i legure bakra	Ne može se kaliti	Cu Ag Cu As	90–100	200–500	0,12
S	Legure otporne na toplinu	1.4962 X 12 CrNiWTi 16 13 1.4923 X 22 CrMoV 12 1		200–320	80–140	0,05
	Legure titanija	3.7024 Ti 99,5 3.7154 TiAl6Zr5		120–310	80–120	0,06

Srednja debljina strugotine

h_m u mm

$$h_m = f_z \sqrt{\frac{a_e}{DC}}$$

Posmak po zubu

f_z u mm

$$f_z = h_m \sqrt{\frac{DC}{a_e}}$$

Brzina posmaka

v_f u mm/min

$$v_f = f_z \times z \times n$$

DC = Ø pločastog glodala

ZNF = Broj zubiju glodala

15

Sustav FM

Tehnološki podaci

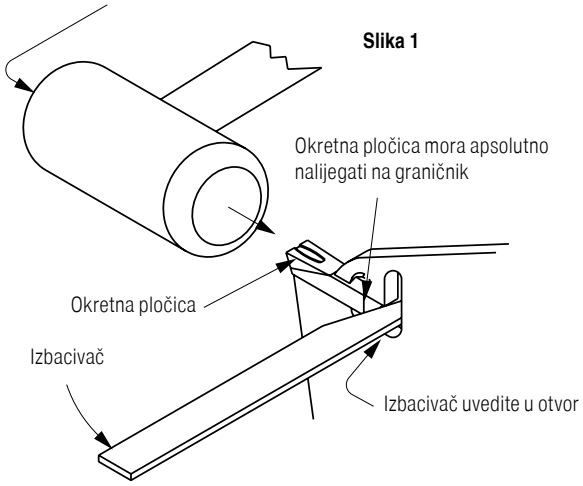
Strategija obrade

Prednosti:

- Samostezni alat s dvostrukom prizmom i apsolutna fiksna točka.
- Tlak stezanja pojačava se povećanjem tlaka rezanja (princip poluge).
- Bez dodatnih steznih elemenata kao što su kandže, vijci ili stezni klinovi u glodaćem tijelu.
- Posebni oblik kanala za odvođenje strugotina u okretnoj pločici deformira strugotinu, ona je manja od izglodanog utora, omogućen je kontinuirani protok strugotina.
- Svaki rezni umetak reže cijelu širinu rezanja, tako da se u odnosu na križno ozubljenje ili naizmjenično ozubljenje (predrezač/završni rezač) posmak udvostručuje po okretaju alata.
- Zamjena okretne pločice po oštrici traje manje od 15 sekundi i može se izvršiti u stroju bez demontaže pločastog glodala. Okretna pločica se odvodi iz prizme s pomoću priloženog izbacivača (slika 1).
- Pločasta glodala, sustav FM, mogu se koristiti kod protusmjernog, ali i kod istosmjernog glodanja.

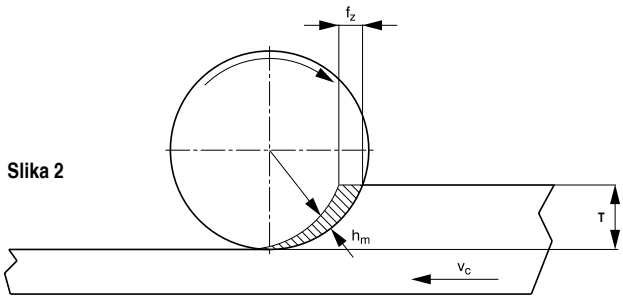
Okretnu pločicu s pomoću plastičnog čekića dovedite do graničnika

Slika 1

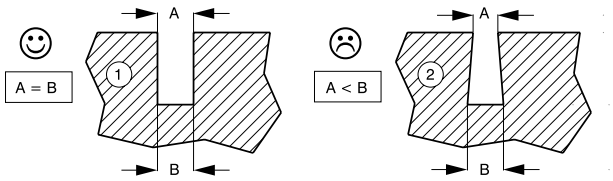


Otkvačite okretnu pločicu pokretom poluge

Slika 2



Slika 3



Napomene za uporabu:

Djelovanjem pločastog glodala na izratku nastaju strugotine u obliku zareza. Pri namještanju posmaka širina djelovanja „a_e“ od odlučujućeg je značaja. Mjera za efektivnu debljinu je srednja debljina strugotine „h_m“, koja je specijalno kod glodanja utora uvijek manja nego posmak/zub „f_z“ (pogledajte sliku 2).

Potrebno je paziti da ne nastanu pretanke strugotine jer će se oštrica prerano istrošiti.

Referentne vrijednosti za namještanje posmaka „f_z“:

1) Vrijednost posmaka „f_z" u tablici podataka o rezanju vrijede za 50–100 % maksimalne veličine djelovanja „a_e“.
2) Kod „a_e“ < 50 % i > 30 % posmak se mora povećati za oko 30–40 %.
3) Kod „a_e“ < 30 % posmak se mora povećati za oko 50 %.

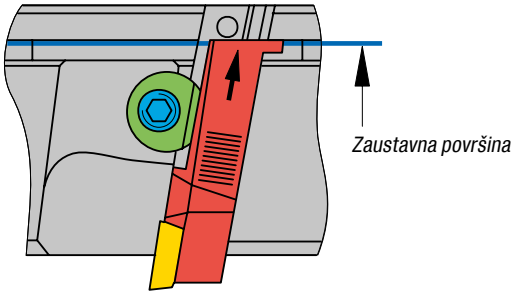
Poželjno je da se pločasta glodala koriste za istosmjerno glodanje (pogledajte sliku 2). Kod istosmjernog glodanja oštrica prodire u najveći poprečni presjek strugotine, stoga je manje trošenje trenjem nego kod protusmjernog glodanja (oštrica klizi u izradak prije djelovanja).
Druga prednost kod istosmjernog glodanja jest to što se izradak pritišće na podlogu – nije moguće podizanje izratka.

Specijalno kod glodanja utora obavezno se treba paziti da se glodani utor ni u kojem slučaju ne zakači, jer bi se okretne pločice izvukle iz sjedišta i alat bi se oštetio (pogledajte sliku 3).

Iz sigurnosnih razloga ne smije se prekoračiti maksimalna brzina rezanja od 250 m/min!

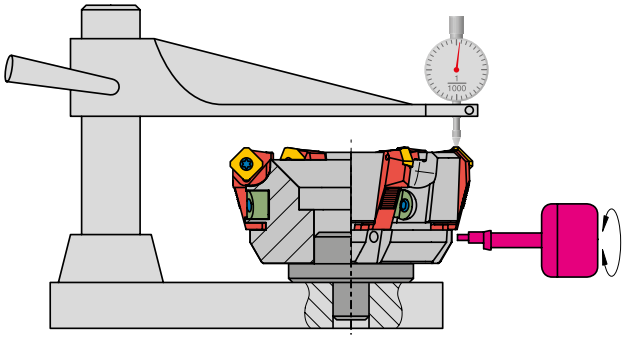
Sustav MaxiMill 260

Namještanje aksijalnog hoda za grubu obradu



Kazete jednostavno pri ugradnji pritisnuti na obrađenu zaustavnu površinu. Aksijalni hod iznosi 0,03 mm izmjereno na glavnoj pločici.

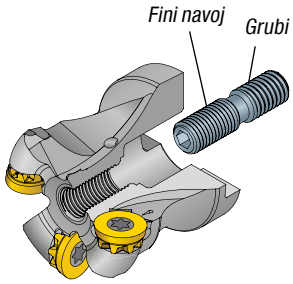
Namještanje aksijalnog hoda s pomoću ekscentričnog ključa i mjernog sata odn. na optičkom uređaju za namještanje



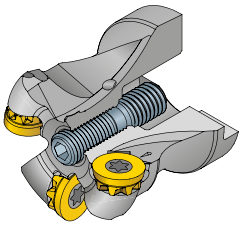
Točne postavke aksijalnog hoda do 0,002 mm

- Čišćenje alata za glodanje.
- Stezanje glodaćeg tijela na za to prikladnom uređaju za namještanje.
- Otpustite stezne klinove, blokade kazete na zaustavnoj površini te lagano pritegnite stezni klin.
- Ekscentrični ključ utaknite u provrt te uvrtanjem kazetu dovedite u željeni položaj.
- Ekscentrični ključ neka bude konstantno u kontaktu s kazetom, tako da zadržava pravi položaj te zategnite stezni klin (pritezni moment 10 Nm).
- Alat je sada spreman za upotrebu.

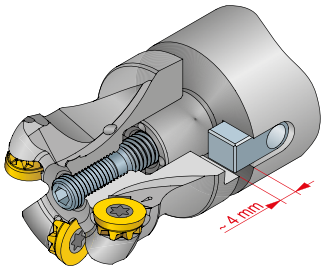
Jednostavno i sigurno stegnuto – s pomoću CERATIZIT vodećeg vijka



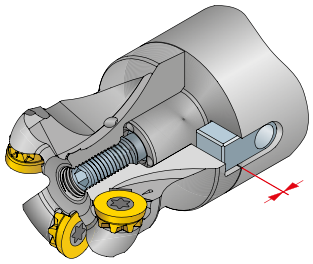
Dio s finim navojem steznog vijka uvrće se u glodalo.



Stezni vijak se blagim pritiskom uvrće do graničnika (opcija pri isporuci).



Kako bi se osigurao optimalni vijčani spoj, prije stezanja je potrebno predvidjeti razmak od oko 4 mm.
U kombinaciji s normiranim standardnim prihvatima to je automatski osigurano.
Po potrebi se može dodatno namjestiti s pomoću steznog vijka okretajem od 0,5 mm.



Stezni vijak uvrtite i pritegnite.

Pritezni momenti za stezne vijke za pričvršćenje glodala na utični trn

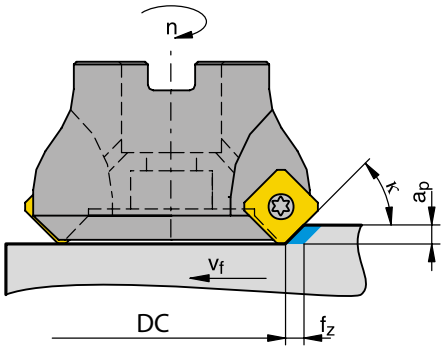
	10				12				16			
Ø glodala mm	ISK vijak DIN 912	M_d Nm	Pritezni vijak Artikl br.	M_d Nm	ISK vijak DIN 912	M_d Nm	Pritezni vijak Artikl br.	M_d Nm	ISK vijak DIN 912	M_d Nm	Pritezni vijak Artikl br.	M_d Nm
40			70 950 151	10			70 950 151	10				
42			70 950 151	10			70 950 151	10				
50	M10x25	80			M10x25	80					70 950 154	15
52					M10x25	80					70 950 154	15
63					M10x25	80			M10x25	80		
66					M10x25	80			M10x25	80		

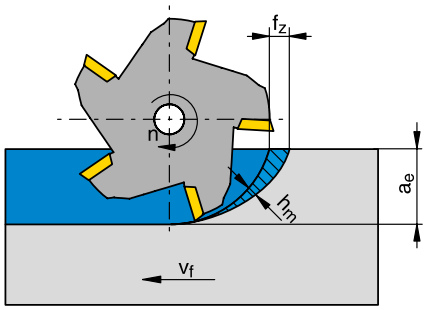
	12				16				20			
Ø glodala mm	ISK vijak DIN 912	M_d Nm	Pritezni vijak Artikl br.	M_d Nm	ISK vijak DIN 912	M_d Nm	Pritezni vijak Artikl br.	M_d Nm	ISK vijak DIN 912	M_d Nm	Pritezni vijak Artikl br.	M_d Nm
80	M12x30	140			M12x30	140			M12x30	140		
100	M16x35	180			M16x35	180			M16x35	180		
125					M16x35	180			M16x35	180		

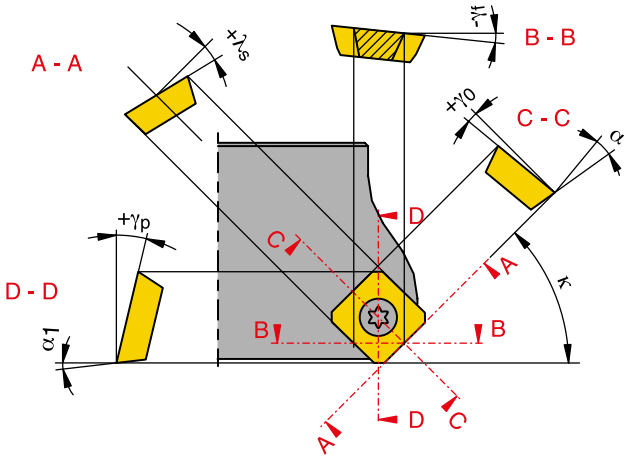
Kratice i dimenzije

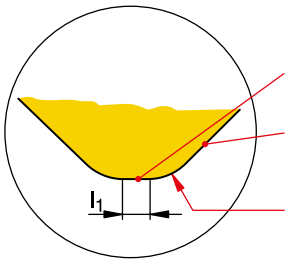
a_e	Širina djelovanja	mm
a_p	Dubina rezanja	mm
DC	Promjer glodala	mm
D_w	Promjer izratka	mm
f_z	Posmak po zubu	mm
h_m	Srednja debljina strugotine	mm
ZNP	Broj redova zubiju	
k_c	Specifična snaga rezanja	N/mm²
$k_{c1.1}$	Specifična snaga rezanja za poprečni presjek strugotine 1 mm²	N/mm²
BS	Duljina planarnog zarubljivanja	mm
m_c	Snaga rezanja specifična za vrijednost rasta	
n	Broj okretaja vretena	1/min
Q	Interval uklanjanja	cm³/min
v_c	Brzina rezanja	m/min
v_f	Brzina posmaka	mm/min
ZNF	Efektivni broj zuba	

γ_0	Ortogonalni kut odvođenja strugotine (efektivni kut odvođenja strugotine)	Stupanj
γ_f	Bočni kut odvođenja strugotine (radijalni kut odvođenja strugotine)	Stupanj
γ_p	Stražnji kut odvođenja strugotine (aksijalni kut odvođenja strugotine)	Stupanj
κ	Kut namještanja (prilagodiv kut)	Stupanj
λ_s	Kut nagiba	Stupanj
α	Stražnji kut	Stupanj
α_1	Slobodni kut planarnog zarubljivanja	Stupanj









Planarno zarubljivanje

Glavna oštrica

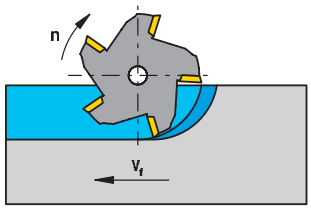
Radijus kuta ili zarubljivanje kuta

15

Situacije djelovanja

Povoljno

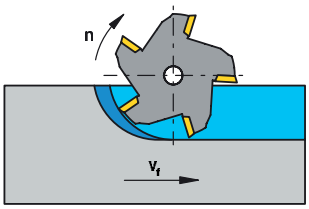
Istosmjerno glodanje



Smjer posmaka izratka podudara se sa smjerom okretanja glodala u zoni rezanja. Debljina strugotine najveća je pri ulasku reza i smanjuje se prema kraju reza do nule.

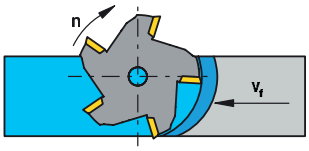
Nepovoljno

Protusmjerno glodanje

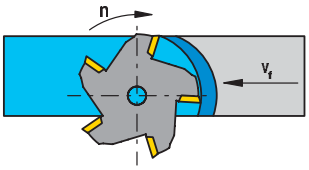


Smjer posmaka izratka suprotan je smjeru okretanja glodala u zoni rezanja. Debljina strugotine počinje na nuli pri ulasku reza i pojačava se do maksimuma na kraju reza.

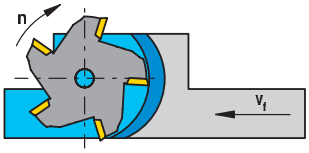
Postavljanje glodala



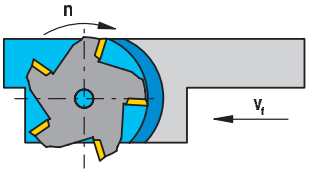
Alat za glodanje mora po mogućnosti tangencijalno izlaziti iz izratka.



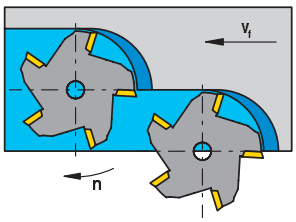
Položaj izratka



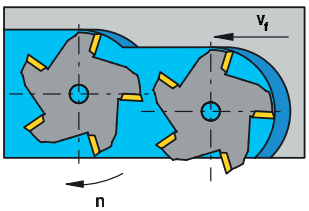
Po mogućnosti se izradak treba stegnuti tako da alat za glodanje može tangencijalno izaći preko cijele duljine obrade.



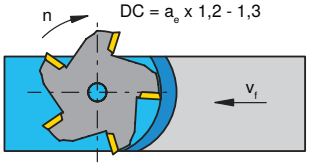
Pokrivenost



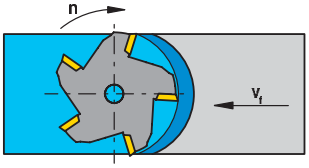
Bilo kod istosmjernog glodanja ili kao što je prikazano u lijevom primjeru, pazite na tangencijalni izlaz alata za glodanje.



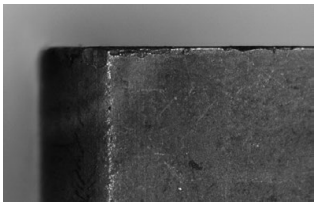
Veličina glodala

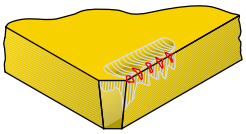


Kod planarnog glodanja promjer alata za glodanje mora biti 20–30 % veći od izratka.



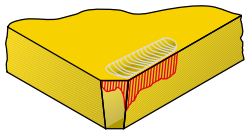
Naprezanje rezanja pri glodanju





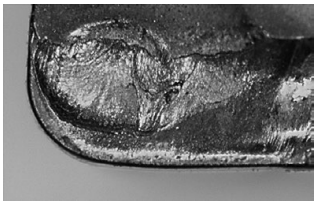
Ljuštenje reznih rubova

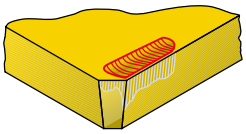
Brzina rezanja ↑
Posmak po zubu ↓
Žilavost reznog materijala ↑
Zarubljivanje reznih rubova ↑



Trošenje na bočnoj strani

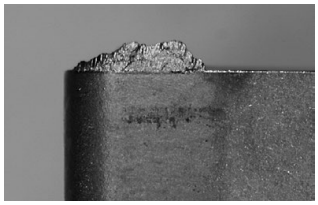
Brzina rezanja ↓
Posmak po zubu ↑
Otpornost reznog materijala na trošenje ↑

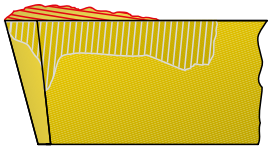




Trošenje u obliku kratera

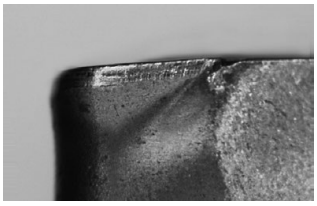
Brzina rezanja ↓
Posmak po zubu ↓
Otpornost reznog materijala na trošenje ↑

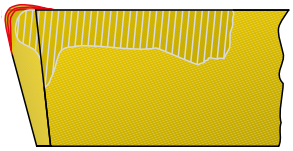




Stvaranje naslaga na oštrici

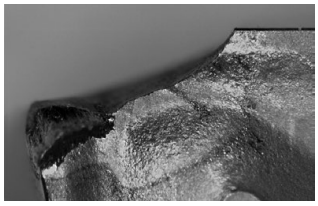
Brzina rezanja ↑
Posmak po zubu ↑
Otpornost na trošenje ↑

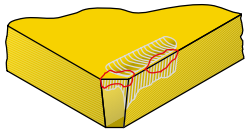




Formiranje reznih rubova

Brzina rezanja ↓
Posmak po zubu ↓
Otpornost reznog materijala na trošenje ↑





Probijanje reznih rubova

Brzina rezanja ↓
Žilavost reznog materijala ↑

15

ISO sustav označavanja za okretne rezne pločice za glodanje

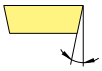
X	D	K	T	11	T3	08	S	R	-	F50
1	2	3	4	5	6	7	8	9		10

Z	N	H	W	12	05	PO	S	R	-	15	06	-	R
1	2	3	4	5	6	7	8	9		11	12		13

1 Pločasti oblik

A	85°	
B	82°	
K	55°	
H	120°	
L	90°	
O	135°	
P	108°	
C	80°	
D	55°	
E	75°	
M	86°	
V	35°	
R		
S	90°	
T	60°	
W	80°	
X Z	Posebna izvedba	

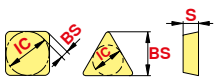
2 Stražnji kut



	α
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Posebna izvedba

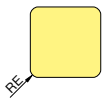
3 Tolerancije

	IC ±mm	BS ±mm	S ±mm	IC = 6,35 / 9,52	IC = 12,7	IC = 15,8 / 19,05
A	0,025	0,005	0,025	●	●	●
C	0,025	0,013	0,025	●	●	●
E	0,025	0,025	0,025	●	●	●
F	0,013	0,005	0,025	●	●	●
G	0,025	0,025	0,13	●	●	●
H	0,013	0,013	0,025	●	●	●
J	0,05	0,005	0,025	●		
	0,08	0,005	0,025		●	
	0,10	0,005	0,025			●
K	0,05	0,013	0,025	●		
	0,08	0,013	0,02		●	
	0,10	0,013	0,02			●



	IC ±mm	BS ±mm	S ±mm	IC = 6,35 / 9,52	IC = 12,7	IC = 15,8 / 19,05
M	0,05	0,08	0,13	●		
	0,08	0,13	0,13		●	
	0,10	0,15	0,13			●
N	0,05	0,08	0,025	●		
	0,08	0,13	0,025		●	
	0,10	0,15	0,025			●
U	0,08	0,13	0,13	●		
	0,13	0,20	0,13		●	
	0,18	0,27	0,13			●

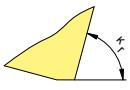
7 Ravno rubljenje / Radijus kuta



Radijus

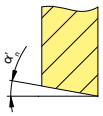
	RE u mm
M0*	
02	0,2
04	0,4
08	0,8
12	1,2

* Samo kod pločice oblika "R"



1. znakovi

	K_r
A	45°
D	60°
E	75°
F	85°
P	90°
Z	Ostalo

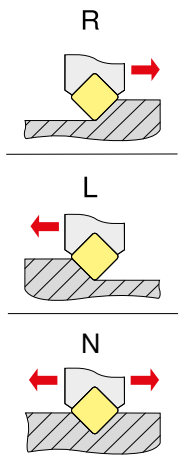


2. znakovi

	α'_n
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
Z O	Ostalo

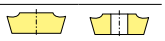
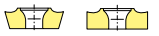
8 Rezni rub

9 Smjer rezanja



4

Karakteristike

A	
F	
G	
M	
N	
Q	
R	
T	
U	
W	
X	Posebna izvedba

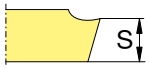
5

Duljina oštrica

IC mm	A	T	C/S	H	L	R	V	W	O	X	Z
4,90										07	
5,00						05					
5,56			05		08			03			
6,00											
6,35		11	06		10			04		06	
6,65	10										
6,80										11	
7,00											04
7,94			07								
8,00						08					
9,00					12						
9,30										15	
9,52	16	16	09		15			06	04		
9,57	15										
9,60										09	
10,00			10		11	10					12
12,00						12					
12,50										20	
12,70		12/22	12		20		22	08		12	
15,81			15		22			10			
16,00						16					
16,20				09							
16,74			16								
17,00			17								
17,18									06		
18,18									07		
19,05			19					13			
20,00						20					

6

Debljina pločice



	S mm
01	1,59
T1	1,98
02	2,38
03	3,18
T3	3,97
04	4,76
05	5,56
06	6,35
07	7,94
09	9,52

10

Kanal za odvođenje strugotina

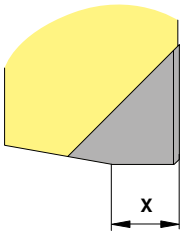
Oznaka stupnjeva
F.. = Fino
M.. = Srednje
R.. = Gruba obrada

Dodatne značajke:
R = Radijus prijelaza glavnog/sporednog reza
Q = Masterfinish

11

Podaci proizvođača

Duljina fine oštrice

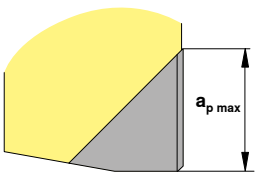


00 = 0,0 mm
10 = 1,0 mm
12 = 1,2 mm
15 = 1,5 mm
30 = 3,0 mm
50 = 5,0 mm

12

Podaci proizvođača

$a_{p\,max}$



02 = 2,0 mm
03 = 3,0 mm
04 = 4,0 mm
06 = 6,0 mm
07 = 7,0 mm
11 = 11,0 mm

13

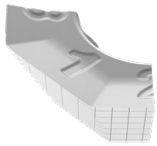
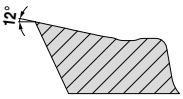
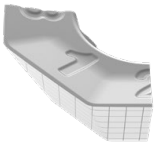
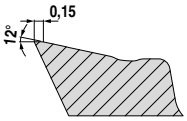
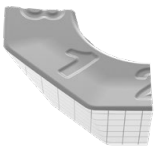
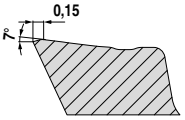
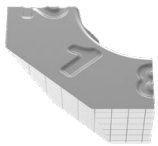
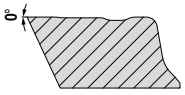
Podaci proizvođača

F = Fino
M = Srednje
R = Grubo

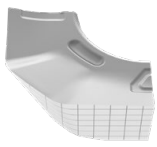
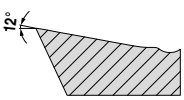
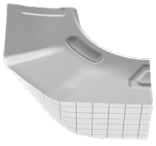
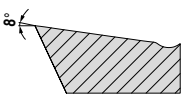
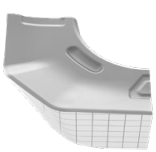
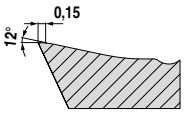
15

Pregled kanala za odvođenje strugotina

MaxiMill 274 (OF..)

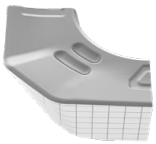
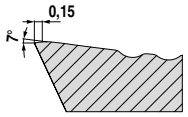
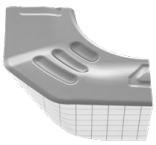
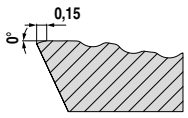
Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-F10 ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Prvi izbor za neželjezne metale		**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**		0,05–0,40
-F50 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Prvi izbor za nehrđajuće čelike		**CTCP220**/CTPP225 **(DCX1220**/DPX1225) CTPM225/**CTCM235** (DPX2225 /**DCX2235)** **CTC5240/CTCS245 (HCF5240)**	CTCP230/**CTPP235** (DCX1230/**DPX1235)** CTPM225/**CTCM235 CTPM240**/CTPM245 (DPX2225/**DCX2235 DPX2240**/ DPX2245) **CTC5240/CTCS245 (HCF5240)**	CTPM240/**CTPM245** (DPX2240/**DPX2245)**		0,10–0,25
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale			**CTCP230**/CTPP235 **(DCX1230**/DPX1235) **CTPM240/CTPM225 (DPX2240/DPX2225)** **CTCK215 (DCX3215)**	CTCP230/**CTPP235** (DCX1230/**DPX1235)** **CTPM240 (DPX2240)** **CTCK215 (DCX3215)**		0,10–0,30
EN ▲ Univerzalna geometrija ▲ Manja sila rezanja ▲ Prvi izbor za dobru ravninu		**CTPM245 (DPX2245)** **CTC5240 (HCF5240)**	**CTPM245 (DPX2245)** **CTC5240 (HCF5240)**			0,10–0,25

MaxiMill 274 (SF..)

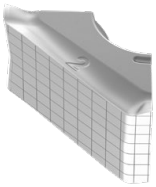
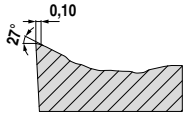
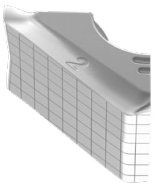
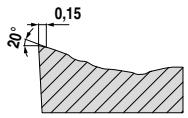
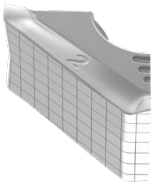
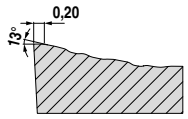
-F10 ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Prvi izbor za neželjezne metale		**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**		0,05–0,40
-F40 ▲ Pozitivna geometrija ▲ Fina i gruba obrada ▲ Za nestabilna stezanja ▲ Za materijale visokootporne na toplinu, titanij i superlegure		**CTC5240 (HCF5240)**	**CTC5240 (HCF5240)**			0,10–0,25
-F50 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Prvi izbor za nehrđajuće čelike		**CTCP220**/CTPP225 **(DCX1220**/DPX1225) CTPM225/**CTCM235** (DPX2225 /**DCX2235)**	CTCP230/**CTPP235** (DCX1230/**DPX1235)** CTPM225/**CTCM235 CTPM240**/CTPM245 (DPX2225/**DCX2235 DPX2240**/ DPX2245)	CTPM240/**CTPM245** (DPX2240/**DPX2245)**		0,10–0,25

Pregled kanala za odvođenje strugotina

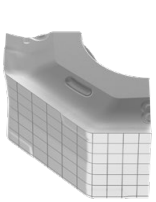
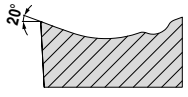
MaxiMill 274 (SF..)

	Model	Obrada			Rez	f_z u mm
		Fini	Srednja	Grubo		
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		**CTCP220**/CTPP225 **(DCX1220**/DPX1225) CTPM225 (DPX2225)	**CTCP230**/CTPP235 **(DCX1230**/DPX1235) **CTPM225/CTPM240** **(DPX2225/DPX2240)**	CTCP230/**CTPP235** (DCX1230/**DPX1235)** CTPM240 (DPX2240)		0,10–0,30
-R50 ▲ Stabilna geometrija ▲ Srednje gruba obrada ▲ Za isprekidane rezove ▲ Prvi izbor za materijale na bazi lijevanog željeza			**CTCK215/CTPK220** **(DCX3215/DPX3220)**	**CTCK215/CTPK220** **(DCX3215/DPX3220)**		0,10–0,35

MaxiMill 271

	Model	Obrada			Rez	f_z u mm
		Fini	Srednja	Grubo		
-F50 ▲ Pozitivna geometrija ▲ Srednje gruba obrada ▲ Za nestabilna stezanja kod obrade čelika ▲ Prvi izbor za nehrđajuće čelike		**CTCP220**/CTPP225 **(DCX1220**/DPX1225) **CTCM235**/CTPM225 **(DCX2235/**DPX2225) **CTCS245/CTC5240** **(HCF5240)**	**CTCP230**/CTPP235 **(DCX1230**/DPX1235) CTPM225/**CTPM240**/CTPM245 (DPX2225/**DPX2240**/ DPX2245) **CTCS245/CTC5240** **(HCF5240)**	**CTPP235** **(DPX1235)** **CTPM245** **(DPX2245)** **CTCS245/CTC5240** **(HCF5240)**		0,20–0,30
-M50 ▲ Univerzalna geometrija ▲ Srednja do jača gruba obrada ▲ Prvi izbor za opće čelične materijale		**CTCP220**/CTPP225 **(DCX1220**/DPX1225)	CTPP225/**CTCP230**/CTPP235 (DPX1225/**DCX1230**/DPX1235) CTPM225/**CTCM235**/**CTPM240** (DPX2225/**DCX2235**/**DPX2240**) **CTCK215**/CTPK220 **(DCX3215**/DPX3220)	CTCP230/**CTPP235** (DCX1230/**DPX1235)** CTCM235/**CTPM240** (DCX2235/**DPX2240)** CTCK215/**CTPK220** (DCX3215/**DPX3220)**		0,20–0,50
-R50 ▲ Stabilna geometrija ▲ Jako gruba obrada ▲ Za jake isprekidane rezove ▲ Prvi izbor za materijale na bazi lijevanog željeza			**CTCK215**/CTPK220 **(DCX3215**/DPX3220)	CTCK215/**CTPK220** (DCX3215/**DPX3220)**		0,20–0,50

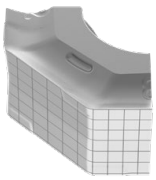
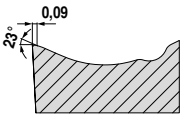
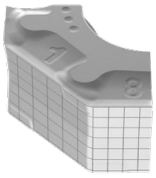
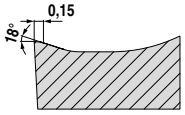
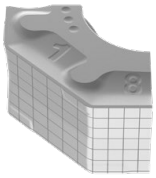
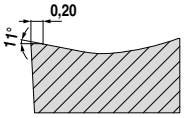
MaxiMill 273

	Model	Obrada			Rez	f_z u mm
		Fini	Srednja	Grubo		
-F40 ▲ Pozitivna geometrija ▲ Fina i gruba obrada ▲ Za nestabilna stezanja ▲ Za materijale visokootporne na toplinu, titanij i superlegure		CTPM245 (DPX2245) **CTC5240** **(HCF5240)**	CTPM245 (DPX2245) **CTC5240** **(HCF5240)**	CTC5240 (HCF5240)		0,20–0,25

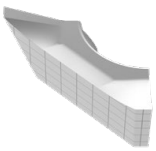
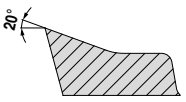
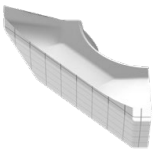
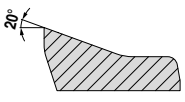
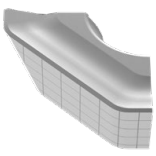
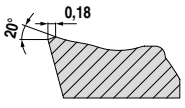
15

Pregled kanala za odvođenje strugotina

MaxiMill 273

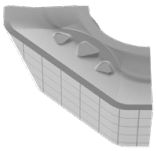
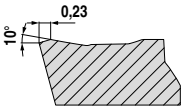
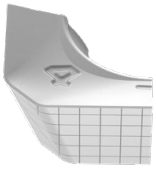
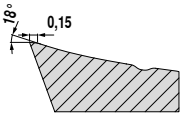
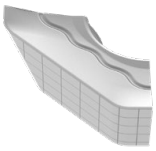
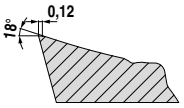
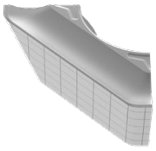
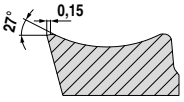
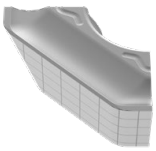
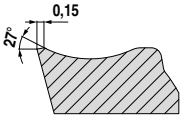
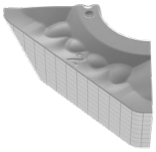
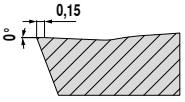
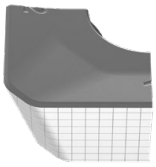
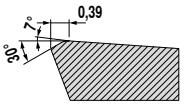
Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-F50 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Prvi izbor za nehrđajuće čelike		**CTCP220/**CTPP225 **(DCX1220/**DPX1225) CTPM225/CTCM235 (DPX2225/DCX2235)	CTPP225/**CTCP230**/CTPP235 (DPX1225/**DCX1230**/DPX1235) CTPP225/**CTPM240** (DPX1225/**DPX2240)**	CTPM240 (DPX2240)		0,20–0,25
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		**CTCP220/**CTPP225 **(DCX1220/**DPX1225) CTPM225/CTCM235 (DPX2225/ DCX2235)	CTPP225/**CTCP230**/CTPP235 (DPX1225/**DCX1230**/DPX1235) CTPP225/**CTPM240** (DPX1225/**DPX2240)** **CTCK215**/CTPK220 **(DCX3215/**DPX3220)	CTCP230/**CTPP235** (DCX1230/**DPX1235)** CTCM235/**CTPM240** (DCX2235/**DPX2240)** CTCK215/**CTPK220** (DCX3215/**DPX3220)**		0,20–0,50
-R50 ▲ Stabilna geometrija ▲ Jako gruba obrada ▲ Za jake isprekidane rezove ▲ Prvi izbor za materijale na bazi lijevanog željeza			CTCK215/CTPK220 (DCX3215/DPX3220) **CTCK215**/CTPK220 **(DCX3215/**DPX3220)	CTCK215/CTPK220 (DCX3215/DPX3220) CTCK215/**CTPK220** (DCX3215/**DPX3220)**		0,20–0,50

MaxiMill 270

-27 ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Prvi izbor za neželjezne metale		**H216T** **(CWK26)**	**H216T** **(CWK26)**	**H216T** **(CWK26)**		0,05–0,40
-27P ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Manja sklonost prianjanju ▲ Prvi izbor za neželjezne metale		**H216T**/AMZ **(CWK26**/AMZ)	**H216T**/AMZ **(CWK26**/AMZ)	**H216T**/AMZ **(CWK26**/AMZ)		0,05–0,40
-29 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		**CTCP230**/CTPP235 **(DCX1230**/DPX1235)	CTCP230/**CTPP235** (DCX1230/**DPX1235)**	CTCP230/**CTPP235** (DCX1230/**DPX1235)**		0,10–0,30

Pregled kanala za odvođenje strugotina

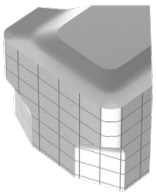
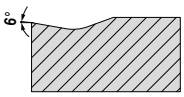
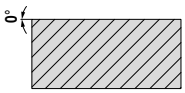
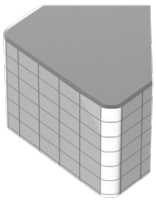
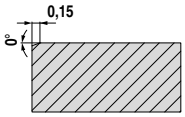
MaxiMill 270

Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-31 ▲ Stabilna geometrija ▲ Jako gruba obrada ▲ Za jake isprekidane rezove ▲ Prvi izbor za materijale na bazi lijevanog željeza			**CTCK215 (DCX3215)**	**CTCK215 (DCX3215)**		0,10–0,35
-F50 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Prvi izbor za nehrđajuće čelike		**CTPM245 (DPX2245)** CTCS245	**CTPM245 (DPX2245)** **CTCS245**	CTPM245 (DPX2245) CTCS245		0,10–0,20
-M31 ▲ Pozitivna geometrija ▲ Visoka mirnoća rada ▲ Univerzalna primjena ▲ Za materijale visokootporne na toplinu, titanij i superlegure		CTC5240 (HCF5240)	CTC5240 (HCF5240)	CTC5240 (HCF5240)		0,10–0,25
-33 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Prvi izbor za nehrđajuće čelike		**CTPM240 (DPX2240)**	**CTPM240 (DPX2240)**	**CTPM240 (DPX2240)**		0,10–0,25
-33P ▲ Pozitivna geometrija ▲ Manja sklonost prianjanju ▲ Prvi izbor za nehrđajuće čelike			**CTPM240 (DPX2240)**	**CTPM240 (DPX2240)**		0,10–0,25
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		CTPP235 (DPX1235)	**CTPP235 (DPX1235)**	**CTPP235 (DPX1235)**		0,20–0,60
-R50 ▲ Stabilna geometrija ▲ Srednje gruba obrada ▲ Za isprekidane rezove ▲ Prvi izbor za materijale na bazi lijevanog željeza		**CTCP230**/CTPP235 (**DCX1230**/DPX1235) **CTPM225** **CTCK215**	CTCP230/**CTPP235** (DCX1230/**DPX1235**) **CTPM225** **CTCK215**	**CTCP230/CTPP235 (DCX1230/DPX1235)** **CTPM225** **CTCK215**		0,30–0,80

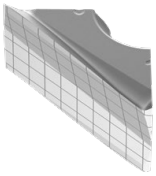
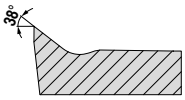
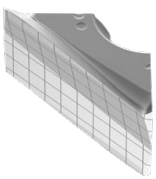
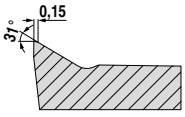
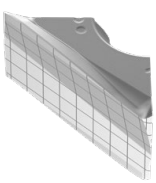
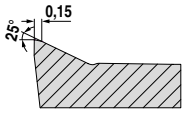
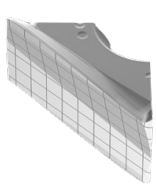
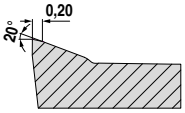
15

Pregled kanala za odvođenje strugotina

MaxiMill HEC

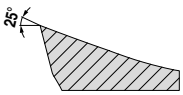
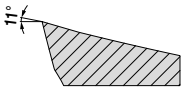
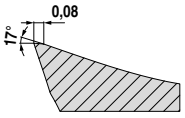
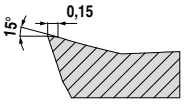
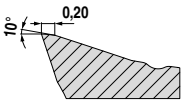
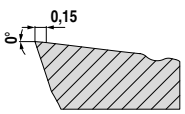
Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-R50 ▲ Pozitivna geometrija ▲ Kod komponenti s tankom stijenkom ▲ Kod ograničene snage stroja ▲ Za materijale na bazi lijevanog željeza		**CTCK215 (DCX3215)**	**CTPK220 (DPX3220)**			0,08–0,25
-ER ▲ Stabilni rezni rub ▲ Univerzalna primjena ▲ Visoka kvaliteta površine zbog ravnog rubljenja ▲ Prvi izbor za materijale na bazi lijevanog željeza		**CTEP210 (DCC1210)** **CTCK215**/CTEP210 **(DCX3215**/DCC1210)	**CTPK220 (DPX3220)**			0,08–0,30
-SR ▲ Stabilni rezni rubovi ▲ Prilagođeno za keramiku i CBN kao rezni materijal ▲ Stabilno stezanje komponente i stroj ▲ Za materijale na bazi lijevanog željeza		**CTN3105**/CTL3215 **(CTS3105)**				0,10–0,25

MaxiMill 491

-F10 ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Manja sklonost prianjanju ▲ Prvi izbor za neželjezne metale		CTWN215 (CWK4615) **CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**		0,05–0,25
-F50 ▲ Pozitivna geometrija ▲ Fina obrada i lagana gruba obrada ▲ Prvi izbor za nehrđajuće čelike		**CTPM240 (DPX2240)**	**CTPM240 (DPX2240)**			0,10–0,20
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale			**CTCP230**/CTPP235 **(DCX1230**/DPX1235) **CTPM240 (DPX2240)**	**CTPP235/**CTCP230 **(DPX1235**/DCX1230) **CTPM240 (DPX2240)**		0,10–0,25
-R50 ▲ Stabilna geometrija ▲ Jako gruba obrada ▲ Za jake isprekidane rezove ▲ Prvi izbor za materijale na bazi lijevanog željeza			**CTCK215**/CTPK220 **(DCX3215**/DPX3220)	**CTPK220**/CTCK215 **(DPX3220**/DCX3215)		0,10–0,30

Pregled kanala za odvođenje strugotina

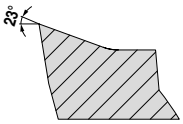
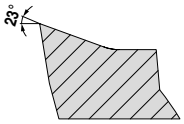
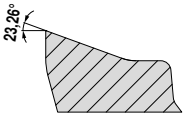
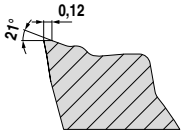
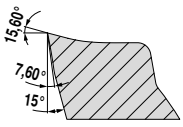
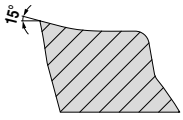
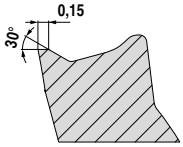
MaxiMill 211

Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-F20 ▲ Visokopozitivna geometrija ▲ Prvi izbor za neželjezne metale	**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**		0,10–0,20
-F40 ▲ Pozitivna geometrija ▲ Fina i gruba obrada ▲ Za nestabilna stezanja ▲ Za materijale visokootporne na toplinu, titanij i superlegure	**CTC5240/CTCS245**	CTPM245 **CTC5240/CTCS245**	**CTPM245** **CTC5240/CTCS245**		0,05–0,15
-F50 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Prvi izbor za nehrđajuće čelike	**CTCP220**/CTPP225 (**DCX1220**/DPX1225) **CTCM235**/CTPM225 (**DCX2235**/DPX2225)	**CTCP230**/CTPP235 (**DCX1230**/DPX1235) CTPM225/**CTPM240/CTPM245** (DPX2225/**DPX2240/ DPX2245**)	CTCP230/**CTPP235** (DCX1230/**DPX1235**) CTPM240/**CTPM245** (DPX2240/**DPX2245**)		0,10–0,20
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale	**CTCM235**/CTPM225 (**DCX2235**/DPX2225)	**CTCP230**/CTPP235 (**DCX1230**/DPX1235) CTPM225/**CTPM240** (DPX2225/**DPX2240**) **CTCK215**/CTPK220 (**DCX3215**/DPX3220)	CTCP230/CTPP235 (DCX1230/DPX1235) CTPM225/CTPM240 (DPX2225/DPX2240) CTCK215/**CTPK220** (DCX3215/**DPX3220**)		0,10–0,25
-R50 ▲ Stabilna geometrija ▲ Jako gruba obrada ▲ Za jake isprekidane rezove ▲ Prvi izbor za materijale na bazi lijevanog željeza	**CTCK215 (DCX3215)**	CTPM225/**CTPM240/CTCM235** (DPX2225/**DPX2240/DCX2235**) **CTCK215 (DCX3215)**	CTCP230/CTPP235 (DCX1230/DPX1235) CTPM225/**CTPM240/CTCM235** (DPX2225/**DPX2240/DCX2235**) **CTCK215 (DCX3215)**		0,10–0,30
-R60 ▲ Visokostabilna geometrija ▲ Za stabilna stezanja ▲ Prvi izbor za tešku obradu	**CTP6215 (CCN6215)**	**CTP6215 (CCN6215)**	**CTP6215 (CCN6215)**		0,05–0,20

15

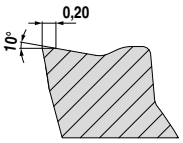
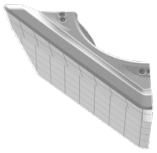
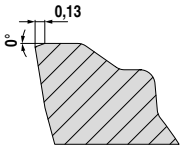
Pregled kanala za odvođenje strugotina

MaxiMill 490

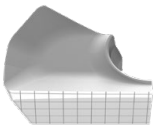
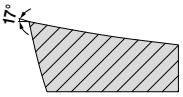
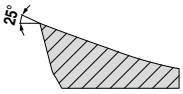
Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-27 ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Za finu obradu legura titanija		**CTC5240 (HCF5240)**	**CTC5240 (HCF5240)**		0,10–0,20
-27P ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Manja sklonost prianjanju ▲ Prvi izbor za neželjezne metale	**AMZ**/H216T **(AMZ**/CWK26) AMZ/**H216T** (AMZ/**CWK26)**	AMZ/H216T **(AMZ/CWK26)**	AMZ/H216T **(AMZ**/CWK26)		0,08–0,35
-F10 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Za materijale visokootporne na toplinu		**CTCS245**	**CTCS245**		0,05–0,20
-29 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		CTCP230/**CTPP235** (DCX1230/**DPX1235)** CTPM240 (DPX2240)	CTCP230/**CTPP235** (DCX1230/**DPX1235)**		0,10–0,25
-F50 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Prvi izbor za nehrđajuće čelike	CTPM245 (DPX2245)	**CTPM245 (DPX2245)** **CTCS245**	**CTCS245**		0,10–0,20
-M31 ▲ Pozitivna geometrija ▲ Univerzalna primjena ▲ Visoka mirnoća rada ▲ Za materijale visokootporne na toplinu, titanij i superlegure		**CTC5240 (HCF5240)**	**CTC5240 (HCF5240)**		0,10–0,20
-33 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Prvi izbor za nehrđajuće čelike		CTPM240 (DPX2240)	**CTPM240 (DPX2240)**		0,10–0,20

Pregled kanala za odvođenje strugotina

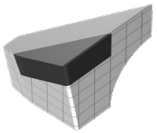
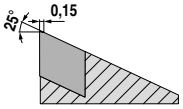
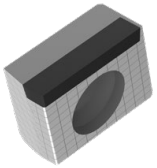
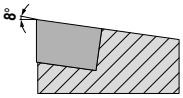
MaxiMill 490

Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-31 ▲ Stabilna geometrija ▲ Jako gruba obrada ▲ Za jake isprekidane rezove ▲ Prvi izbor za materijale na bazi lijevanog željeza			**CTCK215 (DCX3215)**	**CTCK215 (DCX3215)**		0,10–0,30
-SR ▲ Stabilna geometrija ▲ Lagana do srednja fina obrada ▲ Prilagođeno za keramal kao rezni materijal ▲ Za čelične materijale		**TCM10 (CWC10)** TCM10 (CWC10) TCM10 (CWC10)	**TCM10/CTPP235 (CWC10/DPX1235)**	**CTPP235 (DPX1235)**		0,05–0,25

MaxiMill HSC/HPC

-27P ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Manja sklonost prianjanju ▲ Prvi izbor za neželjezne metale		H216T (CWK26) **H216T (CWK26)**	**H216T (CWK26)**	**H216T (CWK26)**		0,05–0,35
-F20 ▲ Visokopozitivna geometrija ▲ Prvi izbor za neželjezne metale		**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**	**CTWN215 (CWK4615)**		0,10–0,20

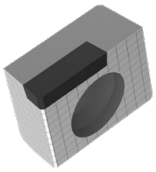
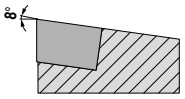
MaxiMill HPC

-SR ▲ Visokopozitivna geometrija ▲ Univerzalna primjena ▲ Smanjena snaga rezanja ▲ Minimalno stvaranje nabora ▲ Visoka kvaliteta površine		**CTD4205 (CWD4205)**	**CTD4205 (CWD4205)**	**CTD4205 (CWD4205)**		0,10–0,30
-ER ▲ Pozitivna geometrija ▲ Srednja do jača gruba obrada ▲ Smanjeno stvaranje nabora ▲ Fina obrada lijevanog željeza i kaljenog čelika		**CTL3215 (CWB3215)** **CTD4205 (CWD4205)** **CTL3215 (CWB3215)**	**CTL3215 (CWB3215)** **CTD4205 (CWD4205)**	**CTD4205 (CWD4205)**		0,10–0,35

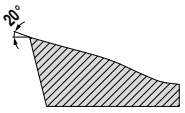
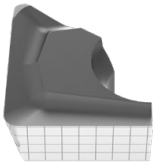
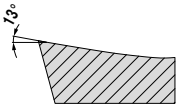
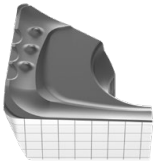
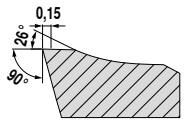
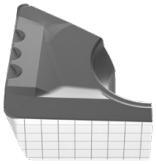
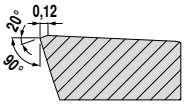
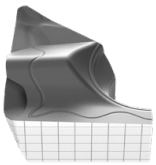
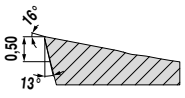
15

Pregled kanala za odvođenje strugotina

MaxiMill HPC

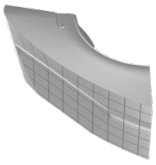
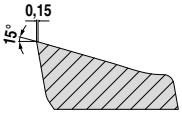
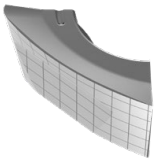
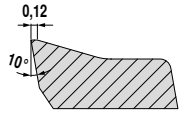
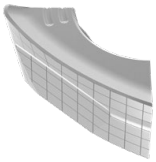
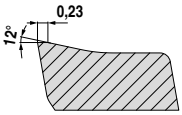
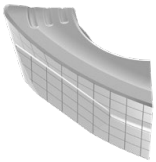
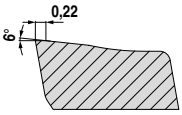
Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-FR ▲ Pozitivna geometrija ▲ Za srednju do jaku grubu obradu ▲ Smanjeno stvaranje nabora		**CTD4205 (CWD4205)**	**CTD4205 (CWD4205)**	**CTD4205 (CWD4205)**		0,10–0,35

MaxiMill 141/241/242

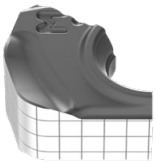
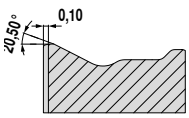
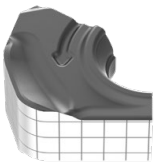
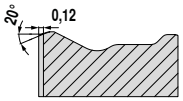
-27P ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Manja sklonost prianjanju ▲ Prvi izbor za neželjezne metale		**H216T (CWK26)**	**H216T (CWK26)**	**H216T (CWK26)**		0,05–0,25
-29 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale			**CTCP230**/CTPP235 **(DCX1230**/DPX1235)	CTCP230/**CTPP235** (DCX1230/**DPX1235**)		0,10–0,30
-33 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Prvi izbor za nehrđajuće čelike			**CTPM240 (DPX2240)**	**CTPM240 (DPX2240)**		0,10–0,30
-SR ▲ Stabilna geometrija ▲ Lagana do srednja fina obrada ▲ Prilagođeno za keramal kao rezni materijal ▲ Za čelične materijale			**CTCP230 (DCX1230)**	**CTCP230 (DCX1230)**		0,15–0,35
-ER ▲ Pozitivna geometrija ▲ Fina i gruba obrada ▲ Za nestabilna stezanja ▲ Za materijale visokootporne na toplinu, titanij i superlegure		CTC5240 (HCF5240)	**CTC5240 (HCF5240)**	**CTC5240 (HCF5240)**		0,10–0,25

Pregled kanala za odvođenje strugotina

MaxiMill HFC

Model	Obrada			Rez	f_z u mm
	Fini	Srednja	Grubo		
-F40 ▲ Pozitivna geometrija ▲ Fina i gruba obrada ▲ Za nestabilna stezanja ▲ Za materijale visokootporne na toplinu, titanij i superlegure		CTPM245 (DPX2245) **CTC5240/CTCS245 (HCF5240)**	CTPM245 (DPX2245) **CTC5240/CTCS245 (HCF5240)**		0,20–1,25
-F50 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Za materijale visokootporne na toplinu		**CTC5240/CTCS245 (HCF5240)**	**CTC5240/CTCS245 (HCF5240)**		0,20–1,50
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		CTCP220/**CTPP225/CTCP230** (DCX1220/**DPX1225/DCX1230**) **CTPM225 (DPX2225)**	CTPP225/**CTCP230/CTPP235** (DPX1225/**DCX1230/DPX1235**) **CTCM235/CTPM240**/CTPM245 (**DCX2235/DPX2240**/DPX2245) **CTCK215 (DCX3215)**	CTCP230/**CTPP235** (DCX1230/**DPX1235**) **CTPM240/CTPM245 (DPX2240/DPX2245)** **CTCK215 (DCX3215)**		0,50–3,00
-R50 ▲ Stabilna geometrija ▲ Za stabilne uvjete obrade ▲ Prvi izbor za jake isprekidane rezove ▲ Za opće čelične materijale			**CTPP235 (DPX1235)**	**CTPP235 (DPX1235)**		0,50–3,00

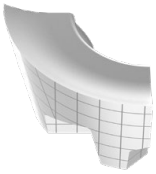
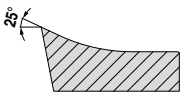
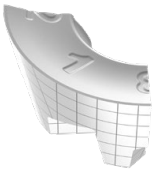
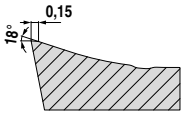
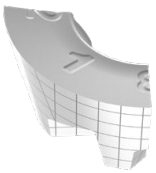
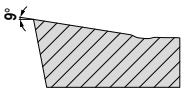
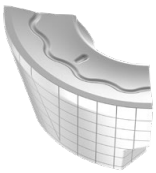
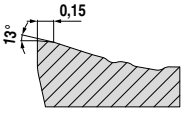
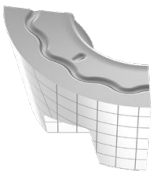
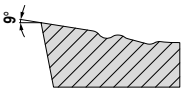
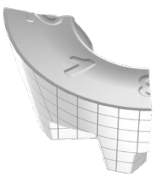
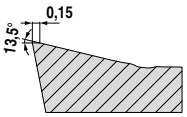
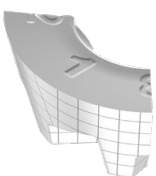
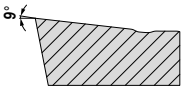
DHFC

-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		CTPP236 CTPM241	**CTPP236** **CTPM241**	CTPP236 CTPM241		0,25–1,20
-R50 ▲ Stabilna geometrija ▲ Za stabilne uvjete obrade ▲ Prvi izbor za jake isprekidane rezove ▲ Za opće čelične materijale			**CTPP231**/CTPP236 **CTPK221**	CTPP231/**CTPP236** **CTPK221**		0,30–1,20

15

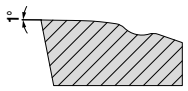
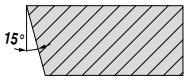
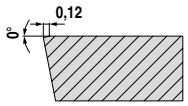
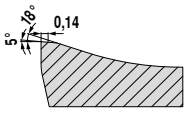
Pregled kanala za odvođenje strugotina

MaxiMill 251

	Model	Obrada			Rez	f_z u mm
		Fini	srednja	Grubo		
-27P ▲ Visokopozitivna geometrija ▲ Oštri rezni rubovi ▲ Manja sklonost prianjanju ▲ Prvi izbor za neželjezne metale		H216T (CWK26) **H216T (CWK26)**	**H216T (CWK26)**	**H216T (CWK26)**		0,05–0,40
-F50 ▲ Pozitivna geometrija ▲ Smanjena snaga rezanja ▲ Za nestabilna stezanja ▲ Prvi izbor za austenitne nehrđajuće čelike		CTCP230/**CTPP235** (DCX1230/**DPX1235**) CTPP225/**CTCM235**/CTPM240 (DPX1225/**DCX2235**/DPX2240) **CTCS245**	CTCP230/**CTPP235** (DCX1230/**DPX1235**) CTPP225/**CTCM235/CTPM240** (DPX1225/**DCX2235/DPX2240**) **CTCS245**	CTCM235/**CTPM240** (DCX2235/**DPX2240**) **CTCS245**		0,08–0,35
-M30 ▲ Srednje gruba obrada ▲ Ukupno manja sila rezanja i stabilnost ▲ Prvi izbor za martenzitne nehrđajuće čelične materijale		CTPP225/**CTCM235**/CTPM240 (DPX1225/**DCX2235**/DPX2240)	**CTPP235 (DPX1235)** CTPP225/**CTCM235/CTPM240** (DPX1225/**DCX2235/DPX2240**)	**CTPP235 (DPX1235)** CTPP225/CTCM235/**CTPM240** (DPX1225/DCX2235/**DPX2240**)		0,08–0,35
-M31 ▲ Pozitivna geometrija ▲ Univerzalna primjena ▲ Visoka mirnoća rada ▲ Za materijale visokootporne na toplinu, titanij i superlegure		**CTC5240 (HCF5240)**	**CTC5240 (HCF5240)**	**CTC5240 (HCF5240)**		0,08–0,35
-M32 ▲ Srednje gruba obrada ▲ Manja sila rezanja i dobra stabilnost ▲ Prvi izbor za martenzitne nehrđajuće čelične materijale		CTPM245 (DPX2245)	**CTPM245 (DPX2245)**	**CTPM245 (DPX2245)**		0,08–0,35
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		**CTCP230**/CTPP235 (**DCX1230**/DPX1235)	**CTCP230/CTPP235 (DCX1230/DPX1235)**	CTCP230/**CTPP235** (DCX1230/**DPX1235**)		0,10–0,40
-R30 ▲ Stabilna geometrija ▲ Jako gruba obrada ▲ Jaki isprekidani rezovi ▲ Prvi izbor za materijale na bazi lijevanog željeza			**CTCK215 (DCX3215)**	**CTCK215 (DCX3215)**		0,10–0,40

Pregled kanala za odvođenje strugotina

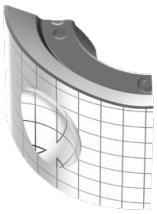
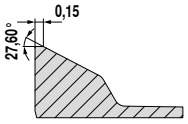
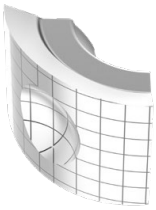
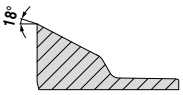
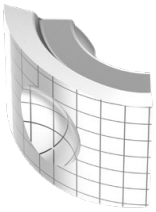
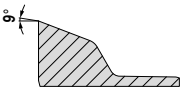
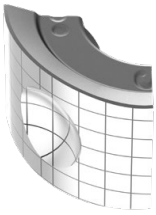
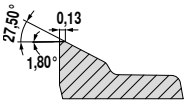
MaxiMill 251

Model	Obrada			Rez	f_z u mm
	Fini	srednja	Grubo		
-R60 ▲ Visokostabilna geometrija ▲ Za stabilna stezanja ▲ Prvi izbor za tešku obradu	**CTP6215 (CCN6215)**	**CTP6215 (CCN6215)**	**CTP6215 (CCN6215)**		0,05–0,35
-FN ▲ Visokopozitivna geometrija ▲ Prvi izbor za neželjezne metale	**H216T (CWK26)**	**H216T (CWK26)**	**H216T (CWK26)**		0,10–0,40
-SN ▲ Robusne okretne rezne pločice ▲ Za loše uvjete obrade ▲ Prvi izbor za lijevane materijale na bazi željeza/čelika	**TCM10**/CTCP230 **(CWC10**/DCX1230) TCM10/CTPM225 (CWC10/ DPX2225) TCM10/CTCK215 (CWC10/DCX3215)	TCM10/**CTCP230/CTPP235** (CWC10/**DCX1230/DPX1235**) **CTPM225 (DPX2225)** **CTCK215 (DCX3215)**	CTCP230/**CTPP235** (DCX1230/**DPX1235**) CTPM225 (DPX2225) **CTCK215 (DCX3215)**		0,10–0,40
-EN ▲ Univerzalna geometrija ▲ Manja sila rezanja ▲ Prvi izbor za dobru ravninu	**CTCK215 (DCX3215)**	**CTCK215 (DCX3215)**	**CTCK215 (DCX3215)**		0,15–0,50

15

Pregled kanala za odvođenje strugotina

MaxiMill 252

Model	Obrada			Rez	f_z u mm
	Fini	srednja	Grubo		
-F50 ▲ Pozitivna geometrija ▲ Lagana gruba obrada ▲ Za nestabilna stezanja ▲ Prvi izbor za nehrđajuće čelike			**CTPM240 (DPX2240)**	CTPM240 (DPX2240)		0,08–0,35
-M31 ▲ Pozitivna geometrija ▲ Univerzalna primjena ▲ Visoka mirnoća rada ▲ Za materijale visokootporne na toplinu, titanij i superlegure		CTPM245 (DPX2245) CTC5240 (HCF5240)	**CTPM245 (DPX2245)** **CTC5240 (HCF5240)**	**CTPM245 (DPX2245)** **CTC5240 (HCF5240)**		0,08–0,35
-M32 ▲ Srednje gruba obrada ▲ Manja sila rezanja i dobra stabilnost ▲ Prvi izbor za martenzitne nehrđajuće čelične materijale		CTPM245 (DPX2245)	**CTPM245 (DPX2245)**	**CTPM245 (DPX2245)**		0,05–0,35
-M50 ▲ Univerzalna geometrija ▲ Lagana do srednje gruba obrada ▲ Prvi izbor za opće čelične materijale		CTPP235 (DPX1235)	**CTPP235 (DPX1235)**	**CTPP235 (DPX1235)**		0,10–0,40

Opis vrsta

CTCP220
DCX1220
- Tvrdi metal, TiCN-Al_2O_3s prevlakom
- ISO | **P20**
- Vrsta otporna na trošenje za suhu obradu čelika

CTCP225
DPX1225
- Tvrdi metal, prevučen legurom TiAlTaN
- ISO | **P25** | **K25**
- Vrsta otporna na trošenje za mokru obradu čelika

CTCP230
DCX1230
- Tvrdi metal, TiCN-Al_2O_3s prevlakom
- ISO | **P30** | **K25** | M25
- Prvi odabir za suhu obradu čelika kod visokih vrijednosti brzine rezanja

CTPP235
DPX1235
- Tvrdi metal, prevučen legurom TiAlTaN
- ISO | **P25** | **K25**
- Vrsta otporna na trošenje za mokru obradu čelika

CTPM225
DPX2225
- Tvrdi metal, prevučen legurom TiAlTaN
- ISO | P25 | **M25**
- Odabir otporan na trošenje za obradu austenitnih čelika

CTCM235
DCX2235
- Tvrdi metal, TiCN-Al_2O_3s prevlakom
- ISO | P40 | **M35**
- Žilava alternativa u općoj obradi čelika
- Vrlo prikladno za martenzitne čelične materijale

CTPM240
DPX2240
- Tvrdi metal, prevučen legurom TiAlTaN
- ISO | P40 | **M40**
- Prvi izbor za obradu austenitnih čelika

CTCK215
DCX3215
- Tvrdi metal, TiCN-Al_2O_3s prevlakom
- ISO | **K15**
- Prvi izbor za obradu lijevanih materijala uz visoke brzine rezanja

CTPK220
DPX3220
- Tvrdi metal, prevučen legurom TiAlTaN
- ISO | **K20**
- Optimalno za obradu lijevanih materijala visoke tvrdoće u grubljim područjima primjene

CTEP210
DCC1210
- Kermet, TiCN-Al_2O_3s prevlakom
- ISO | **P10** | **K05**
- Prevučena vrsta kermeta s rezervom žilavosti za finu obradu kod visokih brzina rezanja

CTWN215
CWK4615
- Tvrdi metal, bez prevlake
- ISO | K15 | **N15**
- Vrsta tvrdog metala bez prevlake za obradu neželjeznih metala

AMZ
- Tvrdi metal, prevučen legurom TiAlN
- ISO | P10 | K10 | **N10** | S10
- Prevučeni tvrdi materijal za strojnu obradu aluminija

CTC5240
HCF5240
- Tvrdi metal, TiN-TiB_2s prevlakom
- ISO | **S40**
- Specijalna vrsta za strojnu obradu titanija i legura titanija

CTD4205
CWD4205
- Tvrdi metal, bez prevlake
- ISO | **N05**
- Vrsta polikristalog dijamanta za obradu neželjeznih metala i nemetalnih materijala

H216T
CWK26
- Tvrdi metal, bez prevlake
- ISO | **K15** | **N15**
- Neprevučeni tvrdi metal za obradu aluminija i drugih neželjeznih metala
- Također vrlo prikladan za HSC obradu

TCM10
CWC10
- Kermet, bez prevlake
- ISO | **P15** | **M10** | K10
- Vrsta kermeta bez prevlake za finu strojnu obradu nehrđajućeg i kaljenog čelika
- Posebno otporan na habanje zbog visoke otpornosti na toplinu

CTP6215
CCN6215
- Tvrdi metal, prevučen legurom TiAlN
- ISO | **K15** | **H15**
- Obloženi tvrdi materijal za tvrdu obradu

15

Opis vrsta

WAN1240
- Tvrdi metal, s prevlakom
- ISO | **P40** | M40 | K40
- Prevučena, žilava specijalna vrsta za obradu čelika pri srednjim do višim brzinama rezanja
- Prikladno za pomoćne primjene i za obradu lijevanog željeza

WAX1240
- Tvrdi metal, s prevlakom
- ISO | **P40** | K40
- Vrlo žilava specijalna vrsta za srednju i grubu strojnu obradu čelika pri srednjoj brzini rezanja i iznimno visokim posmacima zuba

WAN2225
- Tvrdi metal, s prevlakom
- ISO | **M25** | S25
- Finozrnata vrsta visoke žilavosti i otpornosti na visoke temperature
- Za grubu i finu obradu čelika otpornih na hrđu i kiseline u mokrom i suhom rezanju

WUN4210
- Tvrdi metal, bez prevlake
- ISO | **N10**
- Neprevučena standardna vrsta za srednju strojnu obradu neželjeznih metala i grafita

WTN1205
- Tvrdi metal, s prevlakom
- ISO | **P05** | **K05** | N05 | S05 | **H05**
- Specijalna vrsta s prevlakom za obradu čelika, kaljenog čelika, lijevanog željeza i grafita te plastike

CTPK211
- Tvrdi metal, s TiAlN prevlakom
- ISO | M15 | **K10** | **N10** | S10 | H10
- Standardna vrsta s prevlakom za finu strojnu obradu lijevanih i obojenih metala pri srednjim brzinama rezanja

CTPP236
- Tvrdi metal, s TiAlN-TiN prevlakom
- ISO | **P35** | M35 | **K30**
- Specijalna žilava vrsta za srednju i grubu strojnu obradu čelika u području visoke brzine rezanja
- Ova vrsta nalazi primjenu i u strojnoj obradi lijevanog i nehrđajućeg materijala

CTPP231
- Tvrdi metal, s prevlakom
- ISO | **P30** | K25
- Vrlo tvrda specijalna vrsta za srednju i grubu strojnu obradu čelika u području srednje brzine rezanja kod ekstremno visokih posmaka zuba

CTPM241
- Tvrdi metal, s AlTiN prevlakom
- ISO | P40 | **M40** | **S40**
- Žilava vrsta tvrdog metala za strojnu obradu nehrđajućih čelika i čelika s visokom otpornošću na toplinu

CTPP216
- Tvrdi metal, s TiAlN prevlakom
- ISO | **P10** | M10 | **K10** | H10
- Vrsta tvrdog metala s visokom otpornošću na habanje, visoke stabilnosti reznih oštrica za finu obradu materijala visoke čvrstoće, nelegiranih alatnih čelika, lijevanog željeza i kaljenog čelika do 54 HRC

CTPP211
- Tvrdi metal, s prevlakom
- ISO | **P10** | **M10** | K10
- Vrsta tvrdog metala otporna na habanje za srednju i grubu strojnu obradu čelika i nehrđajućih materijala
- Prikladno za suhu strojnu obradu

CTPK231
- Tvrdi metal, s prevlakom
- ISO | **P30** | **K30**
- Žilava vrsta tvrdog metala za srednju i grubu strojnu obradu čelika i lijevanih materijala
- Prikladno za suhu strojnu obradu

CTPK226
- Tvrdi metal, s prevlakom
- ISO | P30 | **K30** | **H30**
- Vrsta tvrdog metala ultrafinog zrna, visoke otpornosti na habanje, za strojnu obradu lijevanog materijala i kaljenih čelika do 62 HRC

CTCN211
- Tvrdi metal, s prevlakom
- ISO | **N10**
- Vrsta tvrdog metala prevučenom dijamantom specijalno za strojnu obradu grafita i obojenih metala

Opis vrsta

C	T	C	P	2	2	0
D	C	X	1	2	2	0

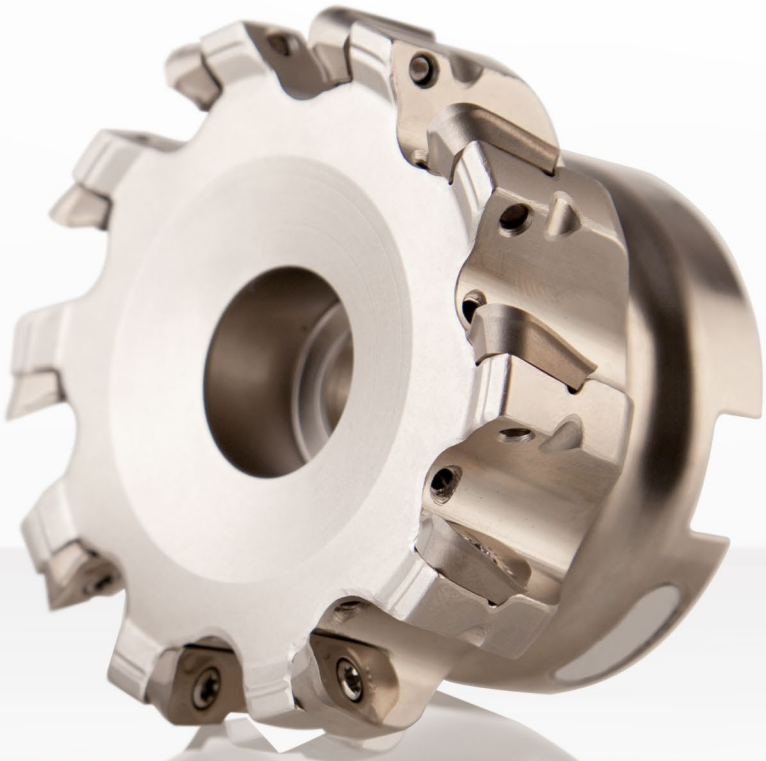
(Primjer)

Glavna primjena – materijal

1|P	Čelik
2|M	Nehrđajući čelik
3|K	Lijevano željezo
4|N	Lagani i neželjezni metali/NE-metali
5|S	Superlegure/titanij
6|H	Tvrdi materijal
7|X	Univerzalna primjena

Postupci

1	Tokarenje
2	Glodanje
3	Urezivanje
4	Bušenje
5	Tokarenje navoja
6	Ostalo
7	Više postupaka

Stupanj tvrdoće

05	ISO 05
10	ISO 10
15	ISO 15
...