

ARDATZ

PERFOR

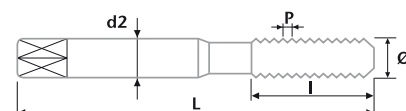
9 63302 1



8 05168 1



APPLICATIONS / ANWENDUNGEN



$\emptyset$	$\geq P$	$\emptyset$ mm	L	l	$\emptyset$	$\emptyset$	Tube	DiN 5156	$\emptyset$	$\geq P$	$\emptyset$ mm	L	l	$\emptyset$	$\emptyset$	Tube	DiN 5156
GAS 1/8	28	8,8	90	18	7	5,5	5-10	•	GAS 5/8	14	21	125	25	18	14,5	17-23	•
GAS 1/4	19	11,8	100	22	11	9	8-13	•	GAS 3/4	14	24,5	140	28	20	16	21-27	•
GAS 3/8	19	15,25	100	25	12	9	12-17	•	GAS 1"	11	30,75	160	36	25	20	26-34	•
GAS 1/2	14	19	125	25	16	12	15-21	•									

ARDATZ

PERFOR

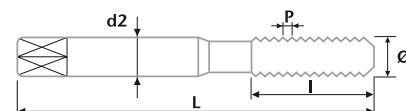
9 63303 1



8 05199 1



APPLICATIONS / ANWENDUNGEN



$\emptyset$	$\geq P$	$\emptyset$ mm	L	l	$\emptyset$	$\emptyset$	Tube	DiN 5156	$\emptyset$	$\geq P$	$\emptyset$ mm	L	l	$\emptyset$	$\emptyset$	Tube	DiN 5156
GAS 1/8	28	8,8	90	18	7	5,5	5-10	•	GAS 7/8	14	28,25	150	28	22	18	*	•
GAS 1/4	19	11,8	100	22	11	9	8-13	•	GAS 3/4	14	24,5	140	28	20	16	21-27	•
GAS 3/8	19	15,25	100	25	12	9	12-17	•	GAS 1"	11	30,75	160	36	25	20	26-34	•
GAS 1/2	14	19	125	25	16	12	15-21	•									

CONDITIONS DE COUPE

CUTTING CONDITIONS

SCHNITTBEDINGUNGEN

CONDICIONES DE CORTE

TiN, TiCN... = Vc + 20 → 50 %

Vc = 20 m/min	Vc = 8 m/min	Vc = 8 m/min	Vc = 20 m/min	Vc = 18/25 m/min	Vc = 20 m/min	Vc = 5 m/min	Vc = 4 m/min
Vc = 18 m/min	Vc = 7 m/min	Vc = 7 m/min	Vc = 18 m/min	Vc = 18/25 m/min	Vc = 18 m/min	Vc = 5 m/min	Vc = 4 m/min