

# TECHNISCHE DATEN

## TECHNICAL DATA



| Typ / Type                                      |                              | MULTI DTM 2tg  |           | MULTI DTM 3tg  |           |
|---|------------------------------|--|-----------|--|-----------|
| ILIX Typ-siehe Seite / ILIX type - see page     |                              | 306  |           | 308  |           |
| Werkstoff / Material                            |                              | Wechselplatte VHM                                      |           | Wechselplatte VHM                                      |           |
| Anwendung / Application                         |                              | Sackloch / Blind Hole<br>Durchgangsloch / Through Hole |           | Sackloch / Blind Hole<br>Durchgangsloch / Through Hole |           |
| Anschnitt - Drallwinkel / Chamfer - Flute angle |                              | -  |           | -  |           |
| Gewindetiefe / Threading deep                   |                              | -  |           | -  |           |
| Beschichtung / Coating                          |                              | BL   | TF        | BL   | TF        |
| Innenliegende Kühlkanäle / Internal Coolant     |                              |  |           |  |           |
| M   | 4H                           | 6940/6942/6947   |           | 7071/7073//7075/7077                                   |           |
|   | 6H/6HX                       | 6940/6942/6947   |           | 7071/7073//7075/7077                                   |           |
|   | 6G/6GX                       | 6940/6942/6947   |           | 7071/7073//7075/7077                                   |           |
|   | 7G                           | 6940/6942/6947   |           | 7071/7073//7075/7077                                   |           |
|   | 6H+0,1                       | 6940/6942/6947   |           | 7071/7073//7075/7077                                   |           |
| MF  | 6H/6HX                       | 6944/6946/6943   |           | 7072/7074/7076/7078                                    |           |
|   | 6G/6GX                       | 6944/6946/6943   |           | 7072/7074/7076/7078                                    |           |
|   | 6H+0,1                       | 6944/6946/6943   |           | 7072/7074/7076/7078                                    |           |
| UNC   | 2B/2BX                       | 7068-7070  |           | -  |           |
|   | 3B/3BX                       | 7068-7070  |           | -  |           |
| UNF   | 2B/2BX                       | 7064-7066  |           | -  |           |
|   | 3B/3BX                       | 7064-7066  |           | -  |           |
| 8-UN  | 2B                           | -  |           | -  |           |
| BSP/G   | G                            | -  |           | -  |           |
| RP (BSPP)                                       | Rp                           | -  |           | -  |           |
| RC (BSPT)                                       | Rc                           | -  |           | -  |           |
| BSW-W   | BSW                          | -  |           | -  |           |
| NPT   | NPT                          | -  |           | -  |           |
| NPTF  | NPTF                         | -  |           | -  |           |
|   |                              | Vc   | Fz        | Vc   | Fz        |
| P   | < 800 N/mm <sup>2</sup>      | -  | -         | -  | -         |
|   | 700-1000 N/mm <sup>2</sup>   | -  | -         | -  | -         |
|   | 1000-1300 N/mm <sup>2</sup>  | -  | -         | -  | -         |
| M   | Austenitisch                 | -  | -         | -  | -         |
|   | Austenitisch / ferritisch    | -  | -         | -  | -         |
| K   | GG                           | 100  | 0,06-0,12 | 100  | 0,06-0,12 |
|   | GGG                          | -  | -         | -  | -         |
| N   | Aluminium                    | 250  | 0,07-0,15 | 250  | 0,07-0,15 |
|   | NE-Metalle                   | 200  | 0,07-0,15 | 200  | 0,07-0,15 |
| S   | Titan                        | -  | -         | -  | -         |
|   | Sonderlegierungen            | -  | -         | -  | -         |
| H   | Gehärteter Stahl 38 / 48 HRC | -  | -         | -  | -         |
|   | Gehärteter Stahl 48 / 58 HRC | -  | -         | -  | -         |
|   | Gehärteter Stahl 58 / 68 HRC | -  | -         | -  | -         |