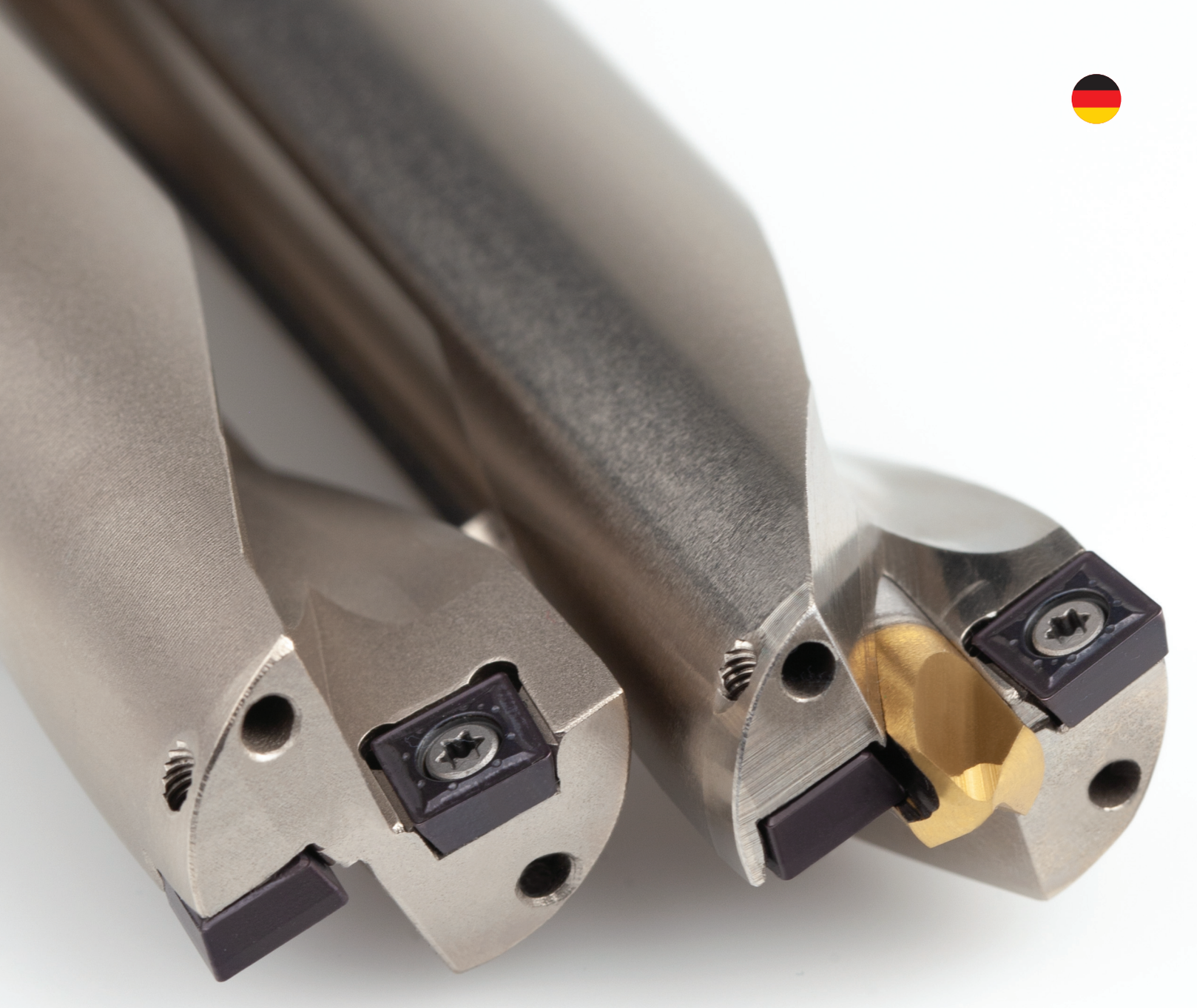

DRS SYSTEM

Breite Produktpalette an Bohrmöglichkeiten

2XD - 3XD
4XD - 5XD
6XD - 9XD

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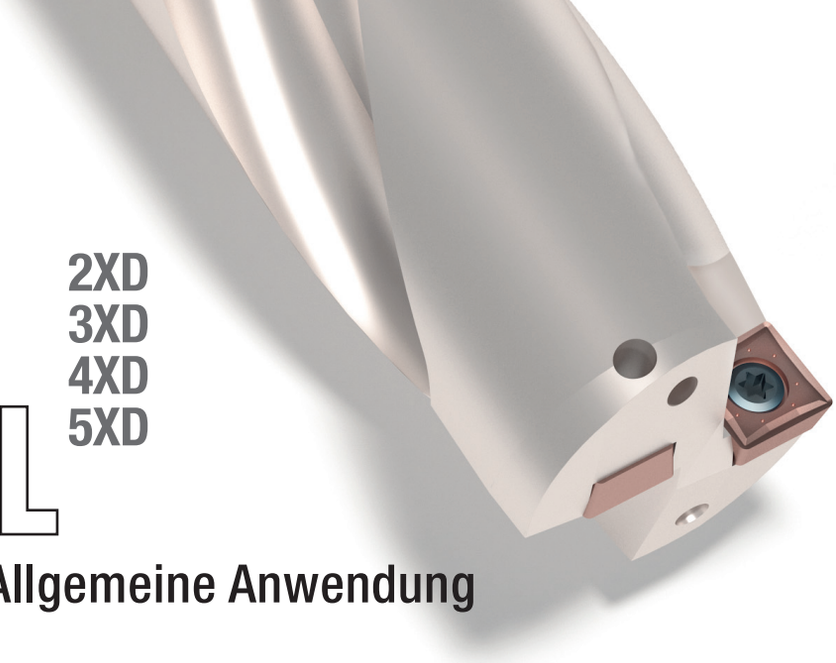
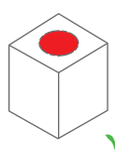
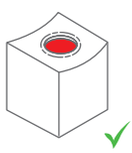
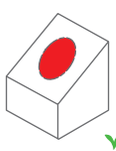
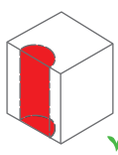
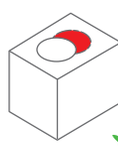
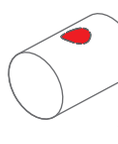
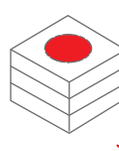


DRSDRILL

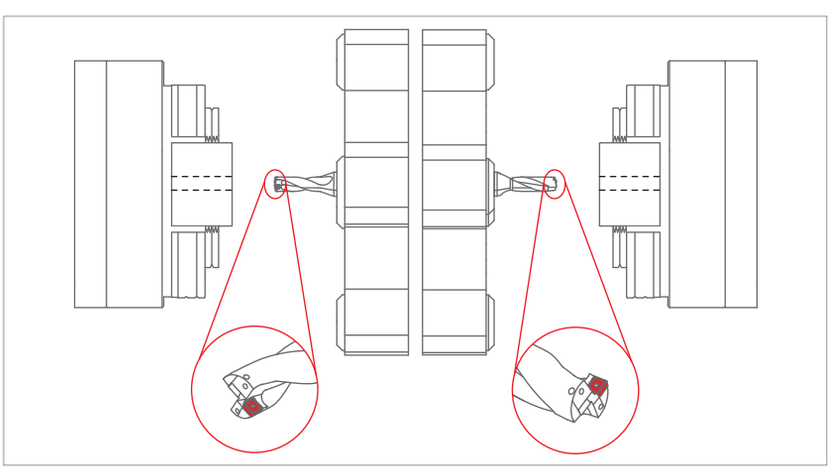
2XD
3XD
4XD
5XD

Hochleistungsbohrer für Allgemeine Anwendung

1. Wo kann man die DRS Bohrer einsetzen?

PLANE OBERFLÄCHE	KONKAVE OBERFLÄCHE	SCHRÄGE OBERFLÄCHE	HALBLOCH	BOHRUNGSVERSATZ	ROHRE	GESTAPELTE PLATTEN
						

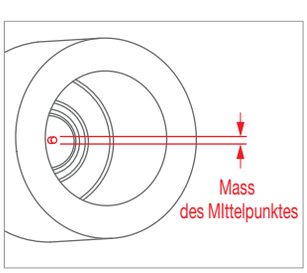
2. Setup des Werkzeugs auf einer Drehmaschine



Um die besten Leistungen zu erzielen ist es wichtig den Setup der Wendeplatte in Richtung des Maschinenbedieners zu machen, siehe Zeichnung, und dies auch für die eventuelle zweite Spindel.

Wenn man diesen Tipp folgt, dann wird normalerweise der Setup der inneren Wendeplatte unter der mitte erfolgen. Die ist die optimale Bedingung für beste Ergebnisse.

3. Schnelle Kontrolle der Positionierung der Mittelachse



Um zu überprüfen ob die Positionierung der Spindel korrekt ist, soll eine Testbohrung gemacht werden. Danach muss der erhaltene Kern kontrolliert werden.

Die Positionierung der Spindel soll verbessert werden falls entweder kein Kern entsteht oder dieser grösser als 1mm ist.

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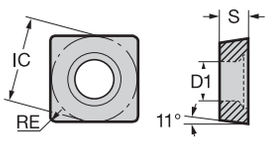
SP□X

DRS
Wendeplatten mit 4 Schneiden



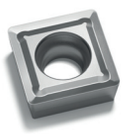
4 edges

Grösse	IC	S	D1	RE
05	5.00	2.38	2.50	0.40
06	6.00	2.38	2.80	0.40
07	7.94	3.97	2.80	0.80
09	9.80	4.30	4.10	0.80
11	11.50	4.76	4.40	0.80
14	14.30	5.20	5.50	1.20

ISO513	HC-PVD JP5625	HC-PVD JP5530	HC-PVD JP9635	HW JU6520
P	80 300	80 300		
M			50 220	
K	120 250	120 250		
N				200 400
S				
H				

ANWENDUNGSFELD DER SORTEN	Hohe Stabilität
Haupteinsatz	Mittlere Stabilität
Einsetzbar	Unstabile Bearbeitung

Härte: – +
Zähigkeit: + –

ALLGEMEIN	GP P M K S	SPMX 050204-GP	2xD	f_n ▸	0.04	**0.08**	0.12	●	●	●	
			3xD	f_n ▸	0.04	**0.07**	0.10				
			4xD	f_n ▸	0.04	**0.06**	0.08				
			5xD	f_n ▸	0.04	**0.05**	0.06				
		SPMX 060204-GP	2xD	f_n ▸	0.06	**0.10**	0.14	●	●	●	
			3xD	f_n ▸	0.06	**0.09**	0.12				
			4xD	f_n ▸	0.05	**0.07**	0.10				
			5xD	f_n ▸	0.04	**0.06**	0.08				
		SPMX 07T308-GP	2xD	f_n ▸	0.06	**0.11**	0.16	●	●	●	
			3xD	f_n ▸	0.06	**0.10**	0.14				
			4xD	f_n ▸	0.06	**0.09**	0.12				
			5xD	f_n ▸	0.05	**0.07**	0.09				
		SPMX 090408-GP	2xD	f_n ▸	0.08	**0.14**	0.20	●	●	●	
			3xD	f_n ▸	0.08	**0.13**	0.18				
			4xD	f_n ▸	0.06	**0.11**	0.16				
			5xD	f_n ▸	0.06	**0.09**	0.12				
		SPMX 110408-GP	2xD	f_n ▸	0.08	**0.15**	0.22	●	●	●	
			3xD	f_n ▸	0.08	**0.14**	0.20				
			4xD	f_n ▸	0.07	**0.12**	0.18				
			5xD	f_n ▸	0.06	**0.12**	0.16				
		SPMX 140512-GP	2xD	f_n ▸	0.10	**0.17**	0.24	●	●	●	
			3xD	f_n ▸	0.10	**0.16**	0.22				
			4xD	f_n ▸	0.08	**0.14**	0.20				
			5xD	f_n ▸	0.07	**0.12**	0.18				
ALUMINIUM	AL N	SPGX 050204-AL	2xD	f_n ▸	0.06	**0.09**	0.12				●
			3xD	f_n ▸	0.06	**0.09**	0.12				
			4xD	f_n ▸	0.04	**0.07**	0.10				
			5xD	f_n ▸	0.04	**0.06**	0.08				
		SPGX 060204-AL	2xD	f_n ▸	0.08	**0.12**	0.16				●
			3xD	f_n ▸	0.08	**0.12**	0.16				
			4xD	f_n ▸	0.06	**0.09**	0.12				
			5xD	f_n ▸	0.06	**0.08**	0.10				
		SPGX 07T308-AL	2xD	f_n ▸	0.10	**0.14**	0.18				●
			3xD	f_n ▸	0.10	**0.14**	0.18				
			4xD	f_n ▸	0.08	**0.11**	0.14				
			5xD	f_n ▸	0.08	**0.10**	0.12				
		SPGX 090408-AL	2xD	f_n ▸	0.10	**0.15**	0.20				●
			3xD	f_n ▸	0.10	**0.15**	0.20				
			4xD	f_n ▸	0.09	**0.12**	0.15				
			5xD	f_n ▸	0.09	**0.11**	0.13				
		SPGX 110408-AL	2xD	f_n ▸	0.11	**0.16**	0.21				●
			3xD	f_n ▸	0.11	**0.16**	0.21				
			4xD	f_n ▸	0.10	**0.14**	0.18				
			5xD	f_n ▸	0.10	**0.13**	0.16				
		SPGX 140512-AL	2xD	f_n ▸	0.12	**0.17**	0.22				●
			3xD	f_n ▸	0.12	**0.17**	0.22				
			4xD	f_n ▸	0.10	**0.15**	0.20				
	polierte Oberfläche		5xD	f_n ▸	0.10	**0.14**	0.18				

● Lagerware

MATERIAL

P M K N S H p. 14-15

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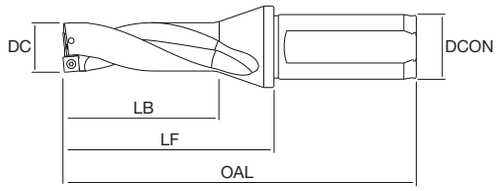

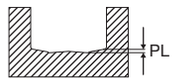

TOLLERANZ DER BOHRUNG 0/+0.20mm

	DRS 2XD			DC	DCON	OAL	LF	LB	ADJLX Max. radialer offset	PL Form des Lochbodens	MIID
05	NT-DRS-2D	D13.00-S20-05	●	13	20	94	44	26	0.50	0.40	SPMX05 SPGX05
		D14.00-S20-05	●	14	20	96	46	28	0.50	0.40	
		D15.00-S20-05	●	15	20	99	49	30	0.50	0.40	
06	NT-DRS-2D	D16.00-S25-06	●	16	25	108	52	32	0.50	0.50	SPMX06 SPGX06
		D17.00-S25-06	●	17	25	110	54	34	0.50	0.50	
		D18.00-S25-06	●	18	25	113	57	36	0.50	0.50	
		D19.00-S25-06	●	19	25	115	59	38	0.50	0.50	
		D20.00-S25-06	●	20	25	119	63	40	0.50	0.50	
		D21.00-S25-06	●	21	25	121	65	42	0.25	0.50	
07	NT-DRS-2D	D22.00-S25-07	●	22	25	123	67	44	0.50	0.50	SPMX07 SPGX07
		D23.00-S32-07	●	23	32	131	71	46	0.50	0.50	
		D24.00-S32-07	●	24	32	134	74	48	0.50	0.50	
		D25.00-S32-07	●	25	32	137	77	50	0.50	0.50	
		D26.00-S32-07	●	26	32	139	79	52	0.25	0.60	
		D27.00-S32-07	●	27	32	141	81	54	0.25	0.60	
09	NT-DRS-2D	D28.00-S32-09	●	28	32	144	84	56	0.50	0.80	SPMX09 SPGX09
		D29.00-S32-09	●	29	32	146	86	58	0.50	0.80	
		D30.00-S32-09	●	30	32	151	91	60	0.50	0.80	
		D31.00-S32-09	●	31	32	154	94	62	0.25	0.80	
		D32.00-S32-09	●	32	32	156	96	64	0.25	0.80	
		D33.00-S32-09	●	33	32	159	99	66	0.25	0.80	
11	NT-DRS-2D	D34.00-S40-11	●	34	40	171	101	68	0.50	0.90	SPMX11 SPGX11
		D35.00-S40-11	●	35	40	174	104	70	0.50	0.90	
		D36.00-S40-11	●	36	40	177	107	72	0.50	0.90	
		D37.00-S40-11	●	37	40	180	110	74	0.50	0.90	
		D38.00-S40-11	●	38	40	183	113	76	0.50	0.90	
		D39.00-S40-11	●	39	40	185	115	78	0.50	0.90	
		D40.00-S40-11	●	40	40	188	118	80	0.25	0.90	
		D41.00-S40-11	●	41	40	191	121	82	0.25	0.90	
14	NT-DRS-2D	D42.00-S40-14	●	42	40	193	123	84	0.50	1.00	SPMX14 SPGX14
		D43.00-S40-14	●	43	40	196	126	86	0.50	1.00	
		D44.00-S40-14	●	44	40	198	128	88	0.50	1.00	
		D45.00-S40-14	●	45	40	202	132	90	0.50	1.00	
		D46.00-S40-14	●	46	40	205	135	92	0.50	1.00	
		D47.00-S40-14	●	47	40	207	137	94	0.50	1.00	
		D48.00-S40-14	●	48	40	210	140	96	0.25	1.00	
		D49.00-S40-14	●	49	40	212	142	98	0.25	1.00	
		D50.00-S40-14	●	50	40	215	145	100	0.25	1.00	

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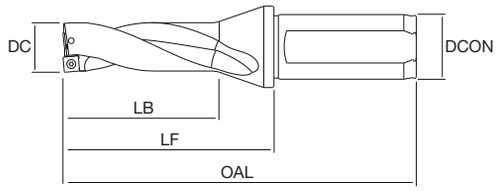
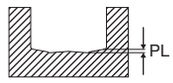
Ersatzteile	SCHRAUBE	SCHLÜSSEL
NT-DRS-2D D□□.□□-S□□-05	NT-ST059	NT-FTB06
NT-DRS-2D D□□.□□-S□□-06	NT-ST061	NT-FTB06
NT-DRS-2D D□□.□□-S□□-07	NT-ST062	NT-FTB07
NT-DRS-2D D□□.□□-S□□-09	NT-ST063	NT-FTB15
NT-DRS-2D D□□.□□-S□□-11	NT-ST064	NT-FTB15
NT-DRS-2D D□□.□□-S□□-14	NT-ST066	NT-FTB20





TOLLERANZ DER BOHRUNG 0/+0.25mm

	DRS 3XD			DC	DCON	OAL	LF	LB	ADJLX Max. radialer offset	PL Form des Lochbodens	MIID
05	NT-DRS-3D	D12.50-S20-05	●	12.5	20	107	57	39	0.50	0.40	SPMX05 SPGX05
		D13.00-S20-05	●	13	20	107	57	39	0.50	0.40	
		D13.50-S20-05	●	13.5	20	110	60	42	0.50	0.40	
		D14.00-S20-05	●	14	20	110	60	42	0.50	0.40	
		D14.50-S20-05	●	14.5	20	114	64	45	0.50	0.40	
		D15.00-S20-05	●	15	20	114	64	45	0.50	0.40	
06	NT-DRS-3D	D15.50-S25-06	●	15.5	25	124	68	48	0.50	0.50	SPMX06 SPGX06
		D16.00-S25-06	●	16	25	124	68	48	0.50	0.50	
		D16.50-S25-06	●	16.5	25	127	71	51	0.50	0.50	
		D17.00-S25-06	●	17	25	127	71	51	0.50	0.50	
		D17.50-S25-06	●	17.5	25	131	75	54	0.50	0.50	
		D18.00-S25-06	●	18	25	131	75	54	0.50	0.50	
		D18.50-S25-06	●	18.5	25	134	78	57	0.50	0.50	
		D19.00-S25-06	●	19	25	134	78	57	0.50	0.50	
		D19.50-S25-06	●	19.5	25	139	83	60	0.50	0.50	
		D20.00-S25-06	●	20	25	139	83	60	0.50	0.50	
		D20.50-S25-06	●	20.5	25	142	86	63	0.25	0.50	
		D21.00-S25-06	●	21	25	142	86	63	0.25	0.50	
		D21.50-S25-06	●	21.5	25	145	89	66	0.25	0.50	
07	NT-DRS-3D	D22.00-S25-07	●	22	25	145	89	66	0.50	0.50	SPMX07 SPGX07
		D22.50-S32-07	●	22.5	32	154	94	69	0.50	0.50	
		D23.00-S32-07	●	23	32	154	94	69	0.50	0.50	
		D23.50-S32-07	●	23.5	32	158	98	72	0.50	0.50	
		D24.00-S32-07	●	24	32	158	98	72	0.50	0.50	
		D24.50-S32-07	●	24.5	32	162	102	75	0.50	0.50	
		D25.00-S32-07	●	25	32	162	102	75	0.50	0.50	
		D25.50-S32-07	●	25.5	32	165	105	78	0.50	0.60	
		D26.00-S32-07	●	26	32	165	105	78	0.25	0.60	
		D26.50-S32-07	●	26.5	32	168	108	81	0.25	0.60	
		D27.00-S32-07	●	27	32	168	108	81	0.25	0.60	
		D27.50-S32-07	●	27.5	32	172	112	84	0.25	0.60	
09	NT-DRS-3D	D28.00-S32-09	●	28	32	172	112	84	0.50	0.80	SPMX09 SPGX09
		D28.50-S32-09	●	28.5	32	175	115	87	0.50	0.80	
		D29.00-S32-09	●	29	32	175	115	87	0.50	0.80	
		D29.50-S32-09	●	29.5	32	181	121	90	0.50	0.80	
		D30.00-S32-09	●	30	32	181	121	90	0.50	0.80	
		D31.00-S32-09	●	31	32	185	125	93	0.25	0.80	
		D32.00-S32-09	●	32	32	188	128	96	0.25	0.80	
		D33.00-S32-09	●	33	32	192	132	99	0.25	0.80	

● Lagerware

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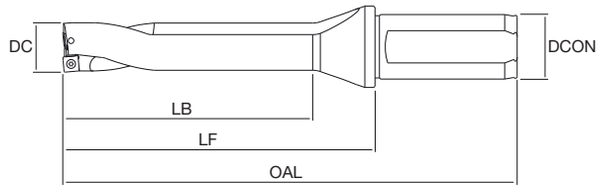
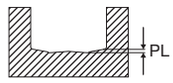
	DRS 3XD			DC	DCON	OAL	LF	LB	ADJLX Max. radialer offset	PL Form des Lochbodens	MIID
11	NT-DRS-3D	D34.00-S40-11	●	34	40	205	135	102	0.50	0.90	SPMX11 SPGX11
		D35.00-S40-11	●	35	40	209	139	105	0.50	0.90	
		D36.00-S40-11	●	36	40	213	143	108	0.50	0.90	
		D37.00-S40-11	●	37	40	217	147	111	0.50	0.90	
		D38.00-S40-11	●	38	40	221	151	114	0.50	0.90	
		D39.00-S40-11	●	39	40	224	154	117	0.50	0.90	
		D40.00-S40-11	●	40	40	228	158	120	0.25	0.90	
		D41.00-S40-11	●	41	40	232	162	123	0.25	0.90	
14	NT-DRS-3D	D42.00-S40-14	●	42	40	235	165	126	0.50	1.00	SPMX14 SPGX14
		D43.00-S40-14	●	43	40	239	169	129	0.50	1.00	
		D44.00-S40-14	●	44	40	242	172	132	0.50	1.00	
		D45.00-S40-14	●	45	40	247	177	135	0.50	1.00	
		D46.00-S40-14	●	46	40	251	181	138	0.50	1.00	
		D47.00-S40-14	●	47	40	254	184	141	0.50	1.00	
		D48.00-S40-14	●	48	40	258	188	144	0.25	1.00	
		D49.00-S40-14	●	49	40	261	191	147	0.25	1.00	
		D50.00-S40-14	●	50	40	265	195	150	0.25	1.00	

● Lagerware

Ersatzteile	SCHRAUBE 	SCHLÜSSEL 
NT-DRS-3D D□□.□□-S□□-05	NT-ST059	NT-FTB06
NT-DRS-3D D□□.□□-S□□-06	NT-ST061	NT-FTB06
NT-DRS-3D D□□.□□-S□□-07	NT-ST062	NT-FTB07
NT-DRS-3D D□□.□□-S□□-09	NT-ST063	NT-FTB15
NT-DRS-3D D□□.□□-S□□-11	NT-ST064	NT-FTB15
NT-DRS-3D D□□.□□-S□□-14	NT-ST066	NT-FTB20





TOLLERANZ DER BOHRUNG 0/+0.30mm

	DRS 4XD			DC	DCON	OAL	LF	LB	ADJLX Max. radialer offset	PL Form des Lochbodens	MIID
05	NT-DRS-4D	D12.50-S20-05	●	12.5	20	120	70	52	0.50	0.40	SPMX05 SPGX05
		D13.00-S20-05	●	13	20	120	70	52	0.50	0.40	
		D13.50-S20-05	●	13.5	20	124	74	56	0.50	0.40	
		D14.00-S20-05	●	14	20	124	74	56	0.50	0.40	
		D14.50-S20-05	●	14.5	20	129	79	60	0.50	0.40	
		D15.00-S20-05	●	15	20	129	79	60	0.50	0.40	
06	NT-DRS-4D	D15.50-S25-06	●	15.5	25	140	84	64	0.50	0.50	SPMX06 SPGX06
		D16.00-S25-06	●	16	25	140	84	64	0.50	0.50	
		D16.50-S25-06	●	16.5	25	144	88	68	0.50	0.50	
		D17.00-S25-06	●	17	25	144	88	68	0.50	0.50	
		D17.50-S25-06	●	17.5	25	149	93	72	0.50	0.50	
		D18.00-S25-06	●	18	25	149	93	72	0.50	0.50	
		D18.50-S25-06	●	18.5	25	153	97	76	0.50	0.50	
		D19.00-S25-06	●	19	25	153	97	76	0.50	0.50	
		D19.50-S25-06	●	19.5	25	159	103	80	0.50	0.50	
		D20.00-S25-06	●	20	25	159	103	80	0.50	0.50	
		D20.50-S25-06	●	20.5	25	163	107	84	0.25	0.50	
		D21.00-S25-06	●	21	25	163	107	84	0.25	0.50	
		D21.50-S25-06	●	21.5	25	167	111	88	0.25	0.50	
07	NT-DRS-4D	D22.00-S25-07	●	22	25	167	111	88	0.50	0.50	SPMX07 SPGX07
		D22.50-S32-07	●	22.5	32	177	117	92	0.50	0.50	
		D23.00-S32-07	●	23	32	177	117	92	0.50	0.50	
		D23.50-S32-07	●	23.5	32	182	122	96	0.50	0.50	
		D24.00-S32-07	●	24	32	182	122	96	0.50	0.50	
		D24.50-S32-07	●	24.5	32	187	127	100	0.50	0.50	
		D25.00-S32-07	●	25	32	187	127	100	0.50	0.50	
		D25.50-S32-07	●	25.5	32	191	131	104	0.50	0.60	
		D26.00-S32-07	●	26	32	191	131	104	0.25	0.60	
		D26.50-S32-07	●	26.5	32	195	135	108	0.25	0.60	
		D27.00-S32-07	●	27	32	195	135	108	0.25	0.60	
		D27.50-S32-07	●	27.5	32	200	140	112	0.25	0.60	
09	NT-DRS-4D	D28.00-S32-09	●	28	32	200	140	112	0.50	0.80	SPMX09 SPGX09
		D28.50-S32-09	●	28.5	32	204	144	116	0.50	0.80	
		D29.00-S32-09	●	29	32	204	144	116	0.50	0.80	
		D29.50-S32-09	●	29.5	32	211	151	120	0.50	0.80	
		D30.00-S32-09	●	30	32	211	151	120	0.50	0.80	
		D31.00-S32-09	●	31	32	216	156	124	0.25	0.80	
		D32.00-S32-09	●	32	32	220	160	128	0.25	0.80	
		D33.00-S32-09	●	33	32	225	165	132	0.25	0.80	

● Lagerware

nikkoTOOLS

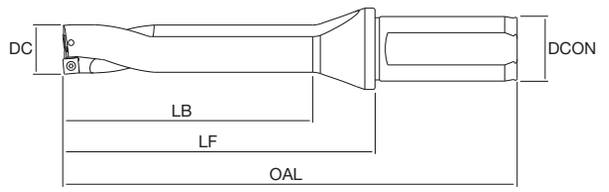
	DRS 4XD			DC	DCON	OAL	LF	LB	ADJLX Max. radialer offset	PL Form des Lochbodens	MIID
11	NT-DRS-4D	D34.00-S40-11	●	34	40	239	169	136	0.50	0.90	SPMX11 SPGX11
		D35.00-S40-11	●	35	40	244	174	140	0.50	0.90	
		D36.00-S40-11	●	36	40	249	179	144	0.50	0.90	
		D37.00-S40-11	●	37	40	254	184	148	0.50	0.90	
		D38.00-S40-11	●	38	40	259	189	152	0.50	0.90	
		D39.00-S40-11	●	39	40	263	193	156	0.50	0.90	
		D40.00-S40-11	●	40	40	268	198	160	0.25	0.90	
		D41.00-S40-11	●	41	40	273	203	164	0.25	0.90	
14	NT-DRS-4D	D42.00-S40-14	●	42	40	277	207	168	0.50	1.00	SPMX14 SPGX14
		D43.00-S40-14	●	43	40	282	212	172	0.50	1.00	
		D44.00-S40-14	●	44	40	286	216	176	0.50	1.00	
		D45.00-S40-14	●	45	40	292	222	180	0.50	1.00	
		D46.00-S40-14	●	46	40	297	227	184	0.50	1.00	
		D47.00-S40-14	●	47	40	301	231	188	0.50	1.00	
		D48.00-S40-14	●	48	40	306	236	192	0.25	1.00	
		D49.00-S40-14	●	49	40	310	240	196	0.25	1.00	
		D50.00-S40-14	●	50	40	315	245	200	0.25	1.00	

● Lagerware

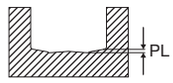
Ersatzteile	SCHRAUBE 	SCHLÜSSEL 
NT-DRS-4D D□□.□□-S□□-05	NT-ST059	NT-FTB06
NT-DRS-4D D□□.□□-S□□-06	NT-ST061	NT-FTB06
NT-DRS-4D D□□.□□-S□□-07	NT-ST062	NT-FTB07
NT-DRS-4D D□□.□□-S□□-09	NT-ST063	NT-FTB15
NT-DRS-4D D□□.□□-S□□-11	NT-ST064	NT-FTB15
NT-DRS-4D D□□.□□-S□□-14	NT-ST066	NT-FTB20

Wendeplattenbohrer Grundkörper

nikkoTOOLS



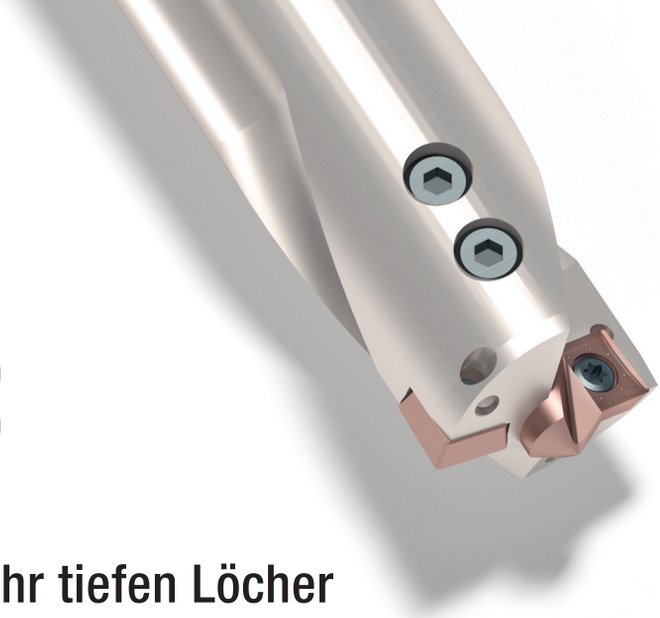
TOLLERANZ DER BOHRUNG 0/+0.35mm



	DRS 5XD			DC	DCON	OAL	LF	LB	ADJLX Max. radialer offset	PL Form des Lochbodens	MIID
05	NT-DRS-5D	D13.00-S20-05	●	13	20	133	83	65	0.50	0.40	SPMX05 SPGX05
		D14.00-S20-05	●	14	20	138	88	70	0.50	0.40	
		D15.00-S20-05	●	15	20	144	94	75	0.50	0.40	
06	NT-DRS-5D	D16.00-S25-06	●	16	25	156	100	80	0.50	0.50	SPMX06 SPGX06
		D17.00-S25-06	●	17	25	161	105	85	0.50	0.50	
		D18.00-S25-06	●	18	25	167	111	90	0.50	0.50	
		D19.00-S25-06	●	19	25	172	116	95	0.50	0.50	
		D20.00-S25-06	●	20	25	179	123	100	0.50	0.50	
		D21.00-S25-06	●	21	25	184	128	105	0.25	0.50	
07	NT-DRS-5D	D22.00-S25-07	●	22	25	189	133	110	0.50	0.50	SPMX07 SPGX07
		D23.00-S32-07	●	23	32	200	140	115	0.50	0.50	
		D24.00-S32-07	●	24	32	206	146	120	0.50	0.50	
		D25.00-S32-07	●	25	32	212	152	125	0.50	0.50	
		D26.00-S32-07	●	26	32	217	157	130	0.25	0.60	
		D27.00-S32-07	●	27	32	222	162	135	0.25	0.60	
09	NT-DRS-5D	D28.00-S32-09	●	28	32	228	168	140	0.50	0.80	SPMX09 SPGX09
		D29.00-S32-09	●	29	32	233	173	145	0.50	0.80	
		D30.00-S32-09	●	30	32	241	181	150	0.50	0.80	
		D31.00-S32-09	●	31	32	247	187	155	0.25	0.80	
		D32.00-S32-09	●	32	32	252	192	160	0.25	0.80	
		D33.00-S32-09	●	33	32	258	198	165	0.25	0.80	
11	NT-DRS-5D	D34.00-S40-11	●	34	40	273	203	170	0.50	0.90	SPMX11 SPGX11
		D35.00-S40-11	●	35	40	279	209	175	0.50	0.90	
		D36.00-S40-11	●	36	40	285	215	180	0.50	0.90	
		D37.00-S40-11	●	37	40	291	221	185	0.50	0.90	
		D38.00-S40-11	●	38	40	297	227	190	0.50	0.90	
		D39.00-S40-11	●	39	40	302	232	195	0.50	0.90	
		D40.00-S40-11	●	40	40	308	238	200	0.25	0.90	
		D41.00-S40-11	●	41	40	314	244	205	0.25	0.90	
14	NT-DRS-5D	D42.00-S40-14	●	42	40	319	249	210	0.50	1.00	SPMX14 SPGX14
		D43.00-S40-14	●	43	40	325	255	215	0.50	1.00	
		D44.00-S40-14	●	44	40	330	260	220	0.50	1.00	
		D45.00-S40-14	●	45	40	337	267	225	0.50	1.00	
		D46.00-S40-14	●	46	40	343	273	230	0.50	1.00	
		D47.00-S40-14	●	47	40	348	278	235	0.50	1.00	
		D48.00-S40-14	●	48	40	354	284	240	0.25	1.00	
		D49.00-S40-14	●	49	40	359	289	245	0.25	1.00	
		D50.00-S40-14	●	50	40	365	295	250	0.25	1.00	

● Lagerware

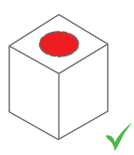
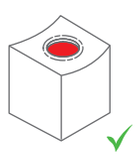
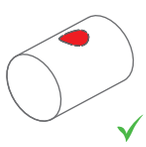
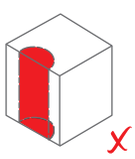
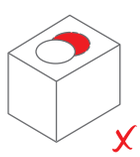
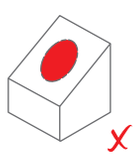
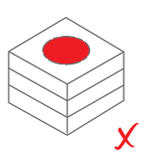
Ersatzteile	SCHRAUBE 	SCHLÜSSEL 
NT-DRS-5D D□□.□□-S□□-05	NT-ST059	NT-FTB06
NT-DRS-5D D□□.□□-S□□-06	NT-ST061	NT-FTB06
NT-DRS-5D D□□.□□-S□□-07	NT-ST062	NT-FTB07
NT-DRS-5D D□□.□□-S□□-09	NT-ST063	NT-FTB15
NT-DRS-5D D□□.□□-S□□-11	NT-ST064	NT-FTB15
NT-DRS-5D D□□.□□-S□□-14	NT-ST066	NT-FTB20



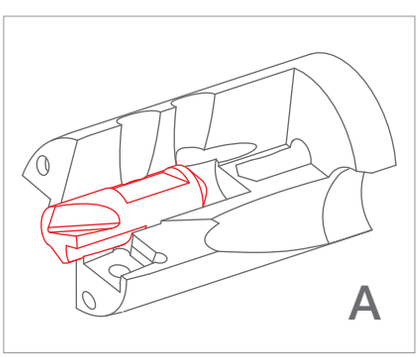
DRSPILOT 6XD 9XD

Perfektes Zentrieren auch auf sehr tiefen Löcher

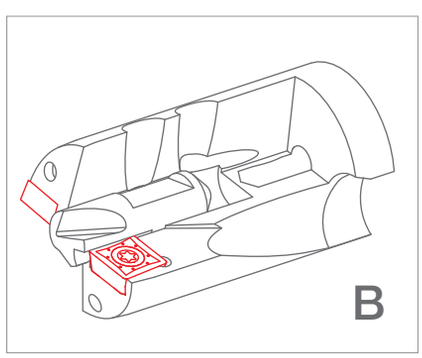
1. Wo kann man DRSpilot einsetzten?

PLANE OBERFLÄCHE	KONKAVE OBERFLÄCHE	ROHRE	HALBLOCH	BOHRUNGSVERSATZ	SCHRÄGE OBERFLÄCHE	GESTAPELTE PLATTEN
						

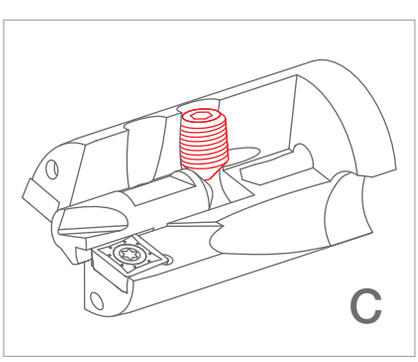
2. Montage von Wendeplatten und Pilot drill



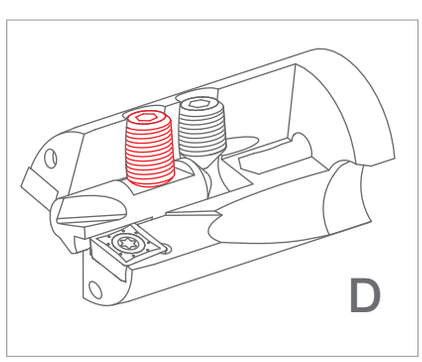
Setze den DRSP pilot in den Grundkörper ein.



Montiere die SPMX/SPGX Wendeplatte.



Die Höhe des DRSP pilot durch die Einstellschraube abstimmen, siehe dazu Zeichung, nach den Angaben der Tabelle auf Seite 11.

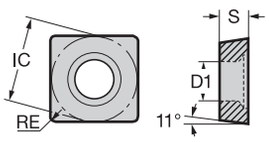


Ziehe die Einstellschraube fest an.

nikkoTOOLS

SP□X

DRS PILOT
Wendeplatten mit 4 Schneiden



4 edges

Grösse	IC	S	D1	RE
05	5.00	2.38	2.50	0.40
06	6.00	2.38	2.80	0.40
07	7.94	3.97	2.80	0.80

ISO513	HC-PVD JP5625	HC-PVD JP5530	HC-PVD JP9635	HW JU6520
P	60 220	60 220		
M			40 160	
K	100 190	100 190		
N				150 300
S				
H				

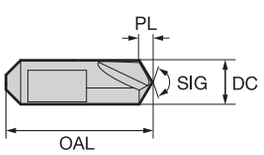
ANWENDUNGSFELD DER SORTEN	Hohe Stabilität	Härte + / –	Zähigkeit – / +
Haupteinsatz	Mittlere Stabilität		
Einsetzbar	Unstabile Bearbeitung		

ALLGEMEIN	GP P M K 	SPMX 050204-GP	6xD f_n▸ 0.08 **0.10** 0.12 9xD f_n▸ 0.06 **0.08** 0.10	●	●	●					
		SPMX 060204-GP	6xD f_n▸ 0.08 **0.10** 0.12 9xD f_n▸ 0.06 **0.08** 0.10	●	●	●					
		SPMX 07T308-GP	6xD f_n▸ 0.09 **0.11** 0.13 9xD f_n▸ 0.07 **0.09** 0.11	●	●	●					
ALUMINIUM	AL N  polierte Oberfläche	SPGX 050204-AL	6xD f_n▸ 0.05 **0.07** 0.09 9xD f_n▸ 0.04 **0.06** 0.08				●				
		SPGX 060204-AL	6xD f_n▸ 0.05 **0.07** 0.09 9xD f_n▸ 0.04 **0.06** 0.08				●				
		SPGX 07T308-AL	6xD f_n▸ 0.06 **0.08** 0.10 9xD f_n▸ 0.05 **0.07** 0.09				●				

● Lagerware

DRSP

DRS PILOT
austauschbarer Zentrierbohrer

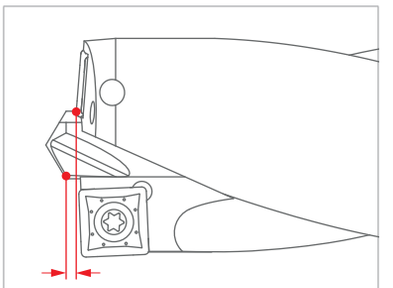


Grösse	DC	OAL	PL	SIG
06	6	20	1.5	118°
08	8	25	2.1	118°

ALLGEMEIN	GP P M K N 	DRSP 06-GP HSS TIN ●
		DRSP 08-GP HSS TIN ●

● Lagerware

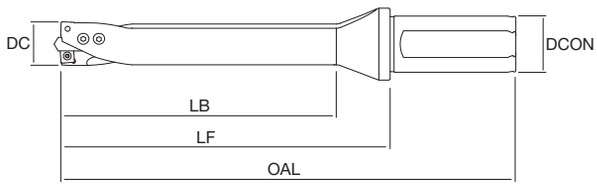
HÖHENEINSTELLUNG



MATERIAL	6xD	9xD
P M K	1.0 mm	1.4 mm
N	1.5 mm	1.7 mm

MATERIAL

P M K N S H p. 14-15



	DRS PILOT 6XD			DC	DCON	OAL	LF	LB		MIID Wendeplatte	MIID Pilot
05	NT-DRS-6D	D18.00-S25-05P6	●	18	25	191	135	112		SPMX05 SPGX05	DRSP06
		D19.00-S25-05P6	●	19	25	197	141	118			
06	NT-DRS-6D	D20.00-S25-06P6	●	20	25	203	147	124		SPMX06 SPGX06	DRSP06
		D21.00-S25-06P6	●	21	25	209	153	130			
		D22.00-S25-06P6	●	22	25	215	159	136			
		D23.00-S32-06P6	●	23	32	228	168	142			
		D24.00-S32-06P6	●	24	32	234	174	148			
		D25.00-S32-06P6	●	25	32	240	180	154			
07	NT-DRS-6D	D26.00-S32-07P8	●	26	32	246	186	160		SPMX07 SPGX07	DRSP08
		D27.00-S32-07P8	●	27	32	252	192	166			
		D28.00-S32-07P8	●	28	32	258	198	172			
		D29.00-S32-07P8	●	29	32	264	204	178			
		D30.00-S32-07P8	●	30	32	270	210	184			

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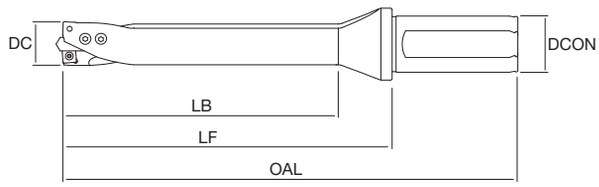
Ersatzteile	SCHRAUBE	SCHLÜSSEL
NT-DRS-6D D□□.□□-S□□-05P6	NT-ST059	NT-FTB06
NT-DRS-6D D□□.□□-S□□-06P6	NT-ST061	NT-FTB06
NT-DRS-6D D□□.□□-S□□-07P8	NT-ST062	NT-FTB07

Ersatzteile	VERSCHLUSS-SCHRAUBE	EINSTEL-LSCHRAUBE	SCHLÜSSEL
DC 18÷22	NT-ST042	NT-ST043	NT-WR025
DC 23÷25	NT-ST044	NT-ST045	
DC 26÷30	NT-ST046	NT-ST047	NT-WR030



	DRS PILOT 9XD			DC	DCON	OAL	LF	LB		MIID Wendeplatte	MIID Pilot
05	NT-DRS-9D	D18.00-S25-05P6	●	18	25	245	189	166		SPMX05 SPGX05	DRSP06
		D19.00-S25-05P6	●	19	25	254	198	175			
06	NT-DRS-9D	D20.00-S25-06P6	●	20	25	263	207	184		SPMX06 SPGX06	DRSP06
		D21.00-S25-06P6	●	21	25	272	216	193			
		D22.00-S25-06P6	●	22	25	281	225	202			
		D23.00-S32-06P6	●	23	32	297	237	211			
		D24.00-S32-06P6	●	24	32	306	246	220			
		D25.00-S32-06P6	●	25	32	315	255	229			
07	NT-DRS-9D	D26.00-S32-07P8	●	26	32	324	264	238		SPMX07 SPGX07	DRSP08
		D27.00-S32-07P8	●	27	32	333	273	247			
		D28.00-S32-07P8	●	28	32	342	282	256			
		D29.00-S32-07P8	●	29	32	351	291	265			
		D30.00-S32-07P8	●	30	32	360	300	274			

● Lagerware

Ersatzteile	SCHRAUBE	SCHLÜSSEL
NT-DRS-9D D□□.□□-S□□-05P6	NT-ST059	NT-FTB06
NT-DRS-9D D□□.□□-S□□-06P6	NT-ST061	NT-FTB06
NT-DRS-9D D□□.□□-S□□-07P8	NT-ST062	NT-FTB07

Ersatzteile	VERSCHLUSS-SCHRAUBE	EINSTEL-LSCHRAUBE	SCHLÜSSEL
DC 18÷22	NT-ST042	NT-ST043	NT-WR025
DC 23÷25	NT-ST044	NT-ST045	
DC 26÷30	NT-ST046	NT-ST047	NT-WR030

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SCHNITTGESCHWINDIGKEIT [m/min]

	MATERIAL	Härte/Rm	W.-Nr	DIN	AISI-ASTM	TRADE MARK
P1	Automatenstähle und Baustähle	< 500 N/mm²	1.0715 1.0765	9 SMn 28 36 SMnPb 14	1213 A29	AVP PR80
P2	Kohlenstoff-Stähle und niedriglegierte Stähle	500-700 N/mm²	1.7147 1.0511	20 MnCr 5 C 40	5120 1040	- -
P3	Mittellegierte Stähle und Vergütungsstähle	600-800 N/mm²	1.1201 1.6511	42 CrMo 4 36 CrNiMo 4	4142, 4140 9840	- -
P4	Hochlegierte Stähle	800-1000 N/mm²	1.1663 1.3505	C 125 W 100 Cr 6	W1 52100	- -
P5	Werkzeugstähle	900-1200 N/mm²	1.2080 1.2379	X 210 Cr 12 X 155 CrVMo 12 1	D3 -	K100 K110
M1	Ferritische Edelstähle	400-700 N/mm²	1.4016 1.4104	X 6 Cr 17 X 12 CrMoS 17	430 430 F	- -
M2	Austenitische Edelstähle - gute Verarbeitbarkeit	500-750 N/mm²	1.4305 1.4301	X 10 CrNiS 18 9 X 6 CrNi 18 10	303 304, 304 H	- -
M3	Austenitische Edelstähle - mittlere Verarbeitbarkeit	550-850 N/mm²	1.4401 1.4462	X 5 CrNiMo 17 12 2 X 2 CrNiMoN 22 5	316 F 51-329 A	- DUPLEX
M4	Martensitische Edelstähle	650-950 N/mm²	1.4021 1.4410	X 20 Cr 13 X 2 CrNiMoN 25 7 4	420 F 53-329 S1	- SUPER DUPLEX
M5	Ausscheidungshärtbare Edelstähle	800-1250 N/mm²	1.4540 1.4542	X 4 CrNiCuNb 16 4 X 5 CrNiNb 16 4	XM-12 631	15-5-PH 17-4-PH
K1	Grauguss	150-250 HB	0.6020 0.6025	GG-20 GG-25	A48 30 B A48 35 B	- -
K2	Sphäroguss	150-350 HB	0.7050 0.7070	GGG-50 GGG-70	A536 80-55-6 A536 100-70-03	- -
N1	Aluminiumlegierungen ≤ 12% Si		3.3547 3.2315	AlMg4.5Mn AlMgSi 1	5083 6082	Peraluman 440 Anticorodal 100
N2	Aluminiumlegierungen > 12% Si		3.2582	GD-AlSi12 G-AlSi6Cu4	A413.0 319	
N3	Kupfer		2.0940-01 2.1176	CuAl10Fe CuPb10Sn	CA952 CA937	
N4	Bronze und Messing		2.0401	Cu Zn39Pb3		OT58 AMPCO 18

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DRSDRILL				DRSPILOT						
JP5625	JP5530	JP9635	JU6520	JP5625	JP5530	JP9635	JU6520	MATERIAL	Härte/Rm	
180÷300	180÷300			130÷220	130÷220			Automatenstähle und Baustähle	< 500 N/mm²	P1
140÷240	140÷240			100÷180	100÷180			Kohlenstoff-Stähle und niedriglegierte Stähle	500-700 N/mm²	P2
100÷220	100÷220			80÷170	80÷170			Mittellegierte Stähle und Vergütungsstähle	600-800 N/mm²	P3
100÷180	100÷180			80÷140	80÷140			Hochlegierte Stähle	800-1000 N/mm²	P4
80÷150	80÷150			60÷120	60÷120			Werkzeugstähle	900-1200 N/mm²	P5
		120÷220				90÷160		Ferritische Edelstähle	400-700 N/mm²	M1
		80÷180				60÷130		Austenitische Edelstähle - gute Verarbeitbarkeit	500-750 N/mm²	M2
		60÷150				50÷110		Austenitische Edelstähle - mittlere Verarbeitbarkeit	550-850 N/mm²	M3
		60÷150				50÷110		Martensitische Edelstähle	650-950 N/mm²	M4
		50÷120				40÷100		Ausscheidungshärtbare Edelstähle	800-1250 N/mm²	M5
180÷250	180÷250			130÷190	130÷190			Grauguss	150-250 HB	K1
120÷180	120÷180			100÷140	100÷140			Sphäroguss	150-350 HB	K2
			250÷400				200÷300	Aluminiumlegierungen ≤ 12% Si		N1
			150÷300				120÷240	Aluminiumlegierungen > 12% Si		N2
			200÷300				150÷240	Kupfer		N3
			200÷300				150÷240	Bronze und Messing		N4

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SORMA
DIAMOND & CUTTING TOOLS

Via Don F. Tosatto, 8
30174 Mestre - Venezia
+39 041.959179
info@nikkotools.com