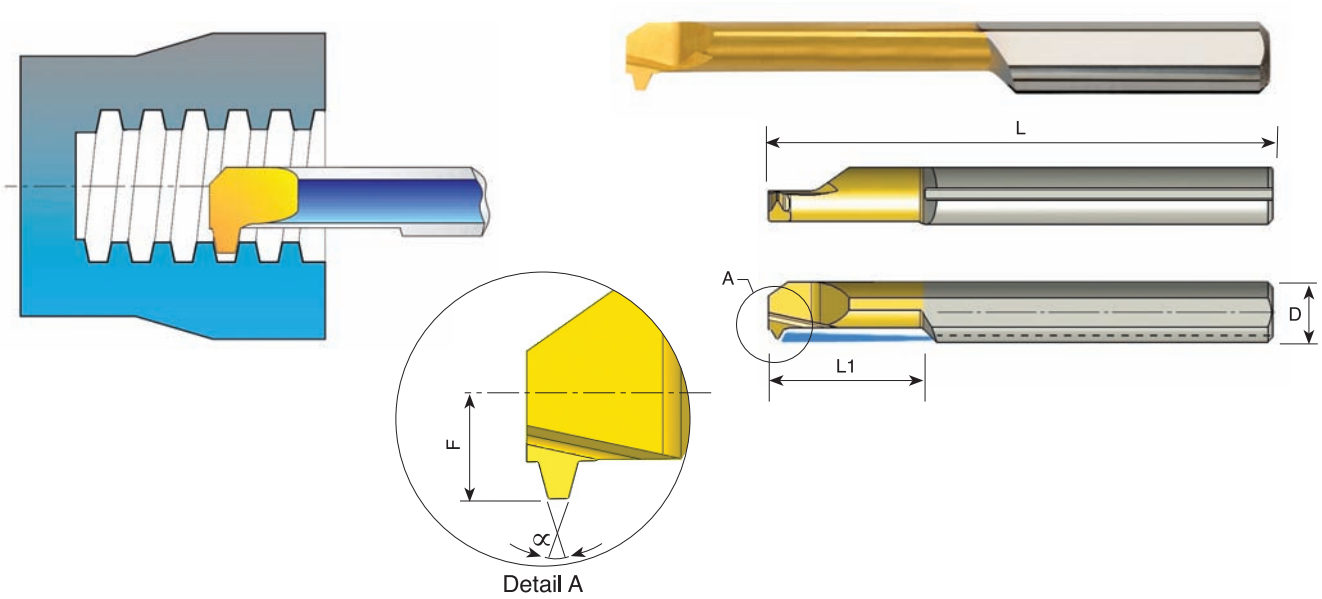
MIR-Einsätze *Gewindeschneiden mit Innenkühlung*



Teilprofil Trapez - DIN 103

D	Bestellcode	Steigung mm	L	L1	F	α	Min. Bohrungs-durchmesser	Gewinde	Halter*
7.0	**MIR 7 L25 2 TR**	2	62	25	3.2	30	6.9	Tr 9 x 2 Tr 10 x 2 Tr 11 x 2 Tr 12 x 2	SIM 0020 H7
10.0	**MIR 10 L35 2 TR**	2	73	35	4.8	30	11.0	Tr 14 x 2 Tr 16 x 2 Tr 18 x 2 Tr 20 x 2	SIM 0020 H10
7.0	**MIR 7 L35 3 TR**	3	62	35	3.3	30	7.5	Tr 11 x 3 Tr 12 x 3	SIM 0020 H7
10.0	**MIR 10 L35 3 TR**	3	73	35	4.8	30	10.5	Tr 14 x 3 Tr 22 x 3 Tr 24 x 3 Tr 26 x 3 Tr 28 x 3	SIM 0020 H10
10.0	**MIR 10 L45 4 TR**	4	105	45	4.8	30	11.5	Tr 16 x 4 Tr 18 x 4 Tr 20 x 4	SIM 0020 H10
10.0	**MIR 10 L55 5 TR**	5	105	55	4.8	30	11.0	Tr 22 x 5 Tr 24 x 5 Tr 28 x 5	SIM 0020 H10

Bestellbeispiel: MIR 10 L35 3 TR BXC
* Weitere Haltergrößen finden Sie auf Seite 184

Technical Section

Carbide Grade: **BXC (P30 - P50, K25 - K40)**
PVD TiN coated grade for low cutting speed, Works well with a wide range of stainless steels.

Cutting speed for Tiny Tools

ISO Standard	Materials	Cutting Speed m/min
P	Low & Medium Carbon Steel	20-140
	High Carbon Steel	30-100
	Alloy Steels & Treated Steels	40- 90
M	Stainless Steels	20- 90
	Cast Steels	40- 90
K	Cast Iron	40-120
N	Non-Ferrous & Aluminium	50-120
S	Super alloy and Titanium	15- 30
H	Hard Materials	13- 30

Recommended Feed Rate: 0.01 - 0.03 mm/rev

Threading Passes

Pitch:	mm	0.5	0.7	0.8	1.0	1.25	1.5
	TPI	48	36	32	24	20	16
Number of Passes		6-12	7-14	7-16	8-18	8-20	10-22