



• Die Produktpalette wird zum Anfang von $\varnothing 12$ bis $\varnothing 20,90$ mit 0,1mm Steigung eingeführt.

• 2 verschiedene Längen verfügbar: 3xD und 5xD

• Die Bohrköpfe sind entweder mit einer (GP) Geometrie für ISO **P** und ISO **K** oder mit einer verstärkten Fase (TE) die beste Leistungen bei Massenproduktion auf ISO **K** garantiert, erhältlich.

• Nur 9 verschiedene Bohrerkörper decken die komplette Produktpalette ab: somit spart man 25% Lagerkosten im Vergleich zu anderen Produkten auf dem Markt!

DEXDRILL

Wechselkopf-Hochleistungsbohrsystem

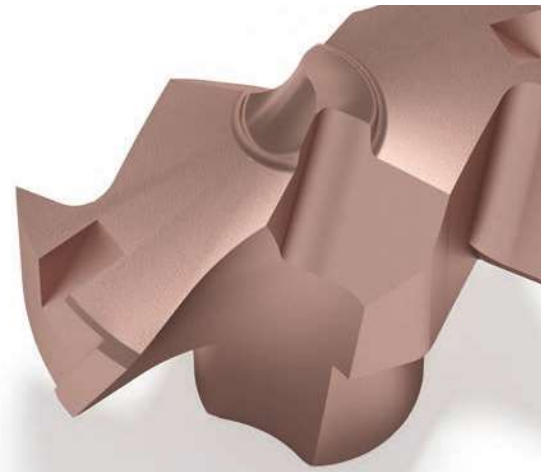
Hermann tooling-concept

Werkzeug und Bearbeitungsprozess 4.0

Jörg Hermann
Am Park 9
78147 Vöhrenbach
Mobil: +49 176 215 216 45
info@prozess-doktor.net
www.prozess-doktor.net

Angebot zur Markteinführung:
Kaufe 4 Bohrköpfe und der Bohrkörper ist
GRATIS!

nikkoTOOLS



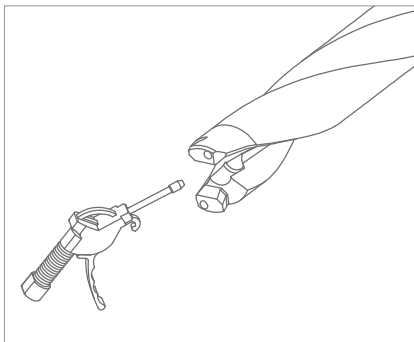
DEXDRILL

Wechselkopf-Hochleistungsbohrsystem

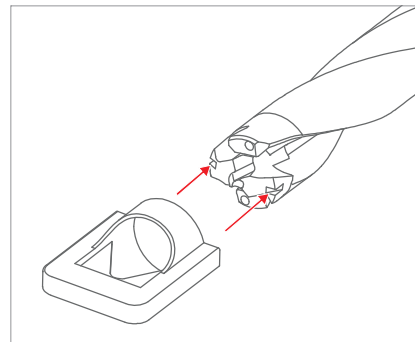
1. Wo kann man DEXdrill einsetzen?

| PLANE OBERFLÄCHE | KONKAVE OBERFLÄCHE | GESTAPELTE PLATTEN | ROHRE | SCHRÄGE OBERFLÄCHE | HALBLOCH | BOHRUNGSVERSATZ |
|------------------|--------------------|--------------------|-------|--------------------|----------|-----------------|
| | | | | | | |

2. Bohrkopf montage

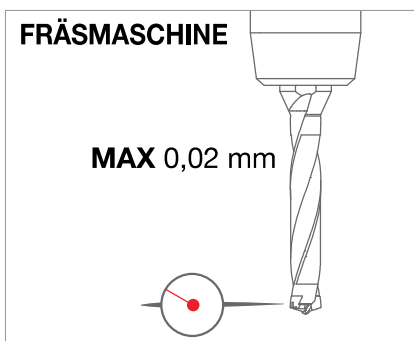


Reinige den Sitz mit Druckluft.
Stecke den Bohrkopf in den Sitz.

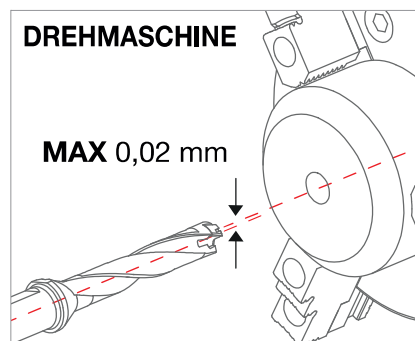


Den Schlüssel auf den seitlichen Schlitz der Wendeplatte stecken.
Langsam den Schlüssel im Uhrzeigersinn drehen.

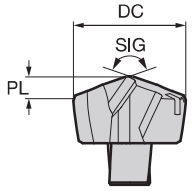
















































3. Hinweise



Die Abweichung des Mittelpunktes des Arbor soll unter 0.02mm sein.



Die maximale Abweichung zwischen dem Teil und der Spindel soll unter 0.02mm sein.

| <h1>DEX</h1> | | | Selbstsichernder Bohrkopf | | | | | | ISO513 | HC-PVD | | | | | | | | | | | | |
|---|---|-----------------|---------------------------|---------|----------------------|------|-------------|----------|---|---|---|---|---|---|--|--|--|--|--|--|--|--|
|  | DC Tolleranz | SIG | | | | | | | JP5625 | JP7625 | | | | | | | | | | | | |
| | k6 | 140° | | | | | | P | 40 160 | | | | | | | | | | | | | |
| | | | | | | | | M | | | | | | | | | | | | | | |
| | | | | | | | | K | 80 180 | 100 200 | | | | | | | | | | | | |
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| ANWENDUNGSFELD DER SORTEN | | | Hohe Stabilität | | | | | |  |  |  |  |  |  | | | | | | | | |
| |  | Haupteinsatz | Mittlere Stabilität | | | | | |  |  |  |  |  |  | | | | | | | | |
| |  | Einsetzbar | Unstabile Bearbeitung | | | | | |  |  |  |  |  |  | | | | | | | | |
| ALLGEMEIN | GP P K | DC 12,00 | DEX1200-GP | PL 2.18 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,10 | DEX1210-GP | PL 2.20 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,20 | DEX1220-GP | PL 2.22 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,30 | DEX1230-GP | PL 2.24 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,40 | DEX1240-GP | PL 2.26 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,50 | DEX1250-GP | PL 2.27 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,60 | DEX1260-GP | PL 2.29 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,70 | DEX1270-GP | PL 2.31 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,80 | DEX1280-GP | PL 2.33 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 12,90 | DEX1290-GP | PL 2.35 | $f_n \triangleright$ | 0.12 | 0.18 | 0.26 |  | | | | | | | | | | | | | |
| | | DC 13,00 | DEX1300-GP | PL 2.37 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,10 | DEX1310-GP | PL 2.38 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,20 | DEX1320-GP | PL 2.40 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,30 | DEX1330-GP | PL 2.42 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,40 | DEX1340-GP | PL 2.44 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,50 | DEX1350-GP | PL 2.46 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,60 | DEX1360-GP | PL 2.47 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,70 | DEX1370-GP | PL 2.49 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,80 | DEX1380-GP | PL 2.51 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 13,90 | DEX1390-GP | PL 2.53 | $f_n \triangleright$ | 0.14 | 0.20 | 0.28 |  | | | | | | | | | | | | | |
| | | DC 14,00 | DEX1400-GP | PL 2.55 | $f_n \triangleright$ | 0.16 | 0.22 | 0.30 |  | | | | | | | | | | | | | |
| | | DC 14,10 | DEX1410-GP | PL 2.57 | $f_n \triangleright$ | 0.16 | 0.22 | 0.30 |  | | | | | | | | | | | | | |
| | | DC 14,20 | DEX1420-GP | PL 2.58 | $f_n \triangleright$ | 0.16 | 0.22 | 0.30 |  | | | | | | | | | | | | | |
| | | DC 14,30 | DEX1430-GP | PL 2.60 | $f_n \triangleright$ | 0.16 | 0.22 | 0.30 |  | | | | | | | | | | | | | |
| | | DC 14,40 | DEX1440-GP | PL 2.62 | $f_n \triangleright$ | 0.16 | 0.22 | 0.30 |  | | | | | | | | | | | | | |
| | | DC 14,50 | DEX1450-GP | PL 2.64 | $f_n \triangleright$ | 0.16 | 0.22 | 0.30 |  | | | | | | | | | | | | | |
| | | DC 14,60 | DEX1460-GP | PL 2.66 | $f_n \triangleright$ | 0.16 | 0.22 | 0.30 |  | | | | | | | | | | | | | |
| | | DC 14,70 | DEX1470-GP | PL 2.68 | $f_n \triangleright$ | 0.16 | 0.22 | 0.30 |  | | | | | | | | | | | | | |

▲ Wird in Zukunft eingeführt

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|---------------------------|---------------------------|------|--|--|---------------------------------------|-----------|------------|--|--|--|--|--|--|--|--|--|--|--|--|--|
| <h1>DEX</h1> | Selbstsichernder Bohrkopf | | | | ISO513 | HC-PVD | | | | | | | | | | | | | | |
| | DC Tolleranz | SIG | | | P | 40 160 | JP5625 | | | | | | | | | | | | | |
| | k6 | 140° | | | M | | | | | | | | | | | | | | | |
| | | | | | K | 80 180 | 100 200 | | | | | | | | | | | | | |
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| ANWENDUNGSFELD DER SORTEN | Hohe Stabilität | | | | + H ₂ O + Zähigkeit | | | | | | | | | | | | | | | |
| Haupteinsatz | Mittlere Stabilität | | | | | | | | | | | | | | | | | | | |
| Einsetzbar | Unstabile Bearbeitung | | | | | | | | | | | | | | | | | | | |

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|----------------------|---------------|----------|------------|---------|------------------|------|-------------|------|---|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|
| ALLGEMEIN | GP P K | DC 14.80 | DEX1480-GP | PL 2.69 | f _n ▶ | 0.16 | 0.22 | 0.30 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 14.90 | DEX1490-GP | PL 2.71 | f _n ▶ | 0.16 | 0.22 | 0.30 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.00 | DEX1500-GP | PL 2.73 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.10 | DEX1510-GP | PL 2.75 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.20 | DEX1520-GP | PL 2.77 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.30 | DEX1530-GP | PL 2.78 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.40 | DEX1540-GP | PL 2.80 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.50 | DEX1550-GP | PL 2.82 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.60 | DEX1560-GP | PL 2.84 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.70 | DEX1570-GP | PL 2.86 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.80 | DEX1580-GP | PL 2.88 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 15.90 | DEX1590-GP | PL 2.89 | f _n ▶ | 0.18 | 0.25 | 0.32 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.00 | DEX1600-GP | PL 2.91 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.10 | DEX1610-GP | PL 2.93 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.20 | DEX1620-GP | PL 2.95 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.30 | DEX1630-GP | PL 2.97 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.40 | DEX1640-GP | PL 2.98 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.50 | DEX1650-GP | PL 3.00 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.60 | DEX1660-GP | PL 3.02 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.70 | DEX1670-GP | PL 3.04 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.80 | DEX1680-GP | PL 3.06 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 16.90 | DEX1690-GP | PL 3.08 | f _n ▶ | 0.20 | 0.26 | 0.34 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 17.00 | DEX1700-GP | PL 3.09 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 17.10 | DEX1710-GP | PL 3.11 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 17.20 | DEX1720-GP | PL 3.13 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 17.30 | DEX1730-GP | PL 3.15 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 17.40 | DEX1740-GP | PL 3.17 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DC 17.50 | DEX1750-GP | PL 3.18 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | | | | | | | |

▲ Wird in Zukunft eingeführt

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| <h1 style="margin: 0;">DEX</h1> | Selbstsichernder Bohrkopf | | | | | ISO513 | HC-PVD | | | | | | | | | | | | | | | | | | |
| | DC Tolleranz | SIG | | | | P | 40 160 | JP5625 | JP7625 | | | | | | | | | | | | | | | | |
| | k6 | 140° | | | | M | | | | | | | | | | | | | | | | | | | |
| | | | | | | K | 80 180 | 100 200 | | | | | | | | | | | | | | | | | |
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| ANWENDUNGSFELD DER SORTEN | | Hohe Stabilität | | | - Härte + + Zähigkeit - | | | | | | | | | | | | | | | | | | | | |
| ■ Haupteinsatz | | Mittlere Stabilität | | | | | | | | | | | | | | | | | | | | | | | |
| ■ Einsetzbar | | Unstabile Bearbeitung | | | | | | | | | | | | | | | | | | | | | | | |

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|------------------|------------|-----------|------------------|----------|------------------|---------|------------------|------|-------------|------|---|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|
| ALLGEMEIN | | GP | P K | DC 17,60 | DEX1760-GP | PL 3.20 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | |
| | | DC 17,70 | DEX1770-GP | PL 3.22 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 17,80 | DEX1780-GP | PL 3.24 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 17,90 | DEX1790-GP | PL 3.26 | f _n ▶ | 0.20 | 0.28 | 0.36 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,00 | DEX1800-GP | PL 3.28 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,10 | DEX1810-GP | PL 3.29 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,20 | DEX1820-GP | PL 3.31 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,30 | DEX1830-GP | PL 3.33 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,40 | DEX1840-GP | PL 3.35 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,50 | DEX1850-GP | PL 3.37 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,60 | DEX1860-GP | PL 3.38 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,70 | DEX1870-GP | PL 3.40 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,80 | DEX1880-GP | PL 3.42 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 18,90 | DEX1890-GP | PL 3.44 | f _n ▶ | 0.22 | 0.30 | 0.40 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,00 | DEX1900-GP | PL 3.46 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,10 | DEX1910-GP | PL 3.48 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,20 | DEX1920-GP | PL 3.49 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,30 | DEX1930-GP | PL 3.51 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,40 | DEX1940-GP | PL 3.53 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,50 | DEX1950-GP | PL 3.55 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,60 | DEX1960-GP | PL 3.57 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,70 | DEX1970-GP | PL 3.59 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,80 | DEX1980-GP | PL 3.60 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 19,90 | DEX1990-GP | PL 3.62 | f _n ▶ | 0.24 | 0.32 | 0.42 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 20,00 | DEX2000-GP | PL 3.64 | f _n ▶ | 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 20,10 | DEX2010-GP | PL 3.66 | f _n ▶ | 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| | | DC 20,20 | DEX2020-GP | PL 3.68 | f _n ▶ | 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | | | | | | | | | | |
| DC 20,30 | DEX2030-GP | PL 3.69 | f _n ▶ | 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | | | | | | | | | | | | |

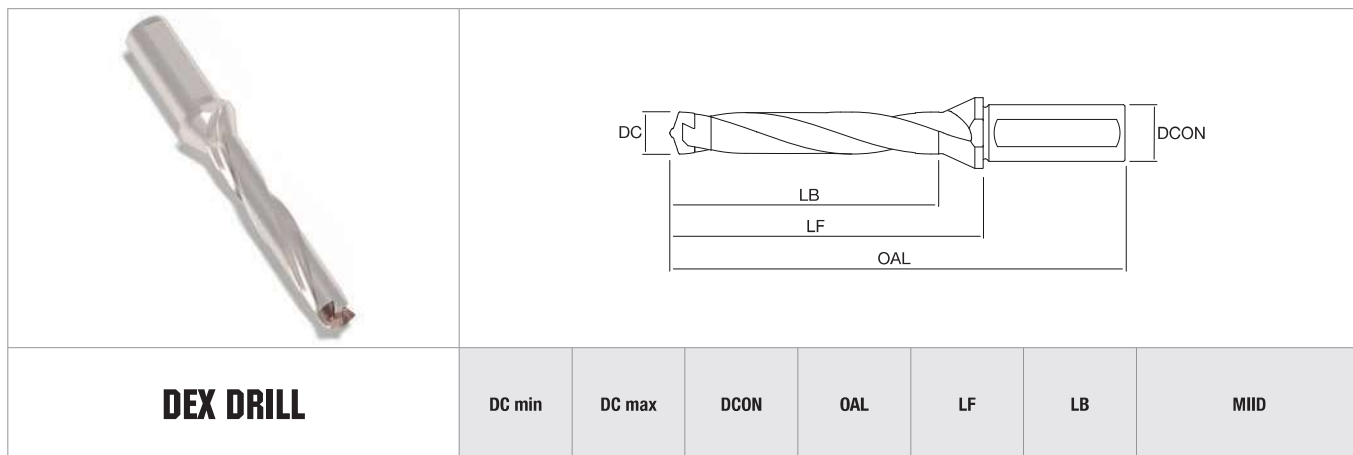
▲ Wird in Zukunft eingeführt

| | | | | | | | | | | | | | | | | | | | | | |
|--------------------------------|---------------------------|------|--|-----------------------------------|--------|-----------|------------|--------|--|--|--|--|--|--|--|--|--|--|--|--|--|
| <h1>DEX</h1> | Selbstsichernder Bohrkopf | | | | ISO513 | HC-PVD | | | | | | | | | | | | | | | |
| | DC Tolleranz | SIG | | | P | 40 160 | JP5625 | JP7625 | | | | | | | | | | | | | |
| | k6 | 140° | | | M | | | | | | | | | | | | | | | | |
| | | | | | K | 80 180 | 100 200 | | | | | | | | | | | | | | |
| | | | | | N | | | | | | | | | | | | | | | | |
| | | | | | S | | | | | | | | | | | | | | | | |
| | | | | | H | | | | | | | | | | | | | | | | |
| ANWENDEUNGSFELD DER SORTEN | Hohe Stabilität | | | + Härte - Zähigkeit + | | | | | | | | | | | | | | | | | |
| ■ Haupteinsatz ■ Einsetzbar | Mittlere Stabilität | | | | | | | | | | | | | | | | | | | | |
| | Unstabile Bearbeitung | | | | | | | | | | | | | | | | | | | | |

| | | | | | | | | | | | | | | | | | | | | |
|-----------|---------------|-------------|------------|------------|-----------------------|-----------------------|-------------|------|---|--|--|--|--|--|--|--|--|--|--|--|
| ALLGEMEIN | GP P K | DC 20,40 | DEX2040-GP | PL 3.71 | f _n ▶ 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | |
| | | DC 20,50 | DEX2050-GP | PL 3.73 | f _n ▶ 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | |
| | | DC 20,60 | DEX2060-GP | PL 3.75 | f _n ▶ 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | |
| | | DC 20,70 | DEX2070-GP | PL 3.77 | f _n ▶ 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | |
| | | DC 20,80 | DEX2080-GP | PL 3.79 | f _n ▶ 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | |
| | | DC 20,90 | DEX2090-GP | PL 3.80 | f _n ▶ 0.26 | 0.35 | 0.44 | ▲ | | | | | | | | | | | | |
| | VERSTÄRKT | TE K | DC 12,00 | DEX1200-TE | PL 2.18 | f _n ▶ 0.24 | 0.28 | 0.34 | ▲ | | | | | | | | | | | |
| | | DC 12,50 | DEX1250-TE | PL 2.27 | f _n ▶ 0.24 | 0.28 | 0.34 | ▲ | | | | | | | | | | | | |
| | | DC 13,00 | DEX1300-TE | PL 2.37 | f _n ▶ 0.26 | 0.30 | 0.36 | ▲ | | | | | | | | | | | | |
| | | DC 13,50 | DEX1350-TE | PL 2.46 | f _n ▶ 0.26 | 0.30 | 0.36 | ▲ | | | | | | | | | | | | |
| | | DC 14,00 | DEX1400-TE | PL 2.55 | f _n ▶ 0.28 | 0.32 | 0.38 | ▲ | | | | | | | | | | | | |
| | | DC 14,50 | DEX1450-TE | PL 2.64 | f _n ▶ 0.28 | 0.32 | 0.38 | ▲ | | | | | | | | | | | | |
| | | DC 15,00 | DEX1500-TE | PL 2.73 | f _n ▶ 0.30 | 0.34 | 0.40 | ▲ | | | | | | | | | | | | |
| | | DC 15,50 | DEX1550-TE | PL 2.82 | f _n ▶ 0.30 | 0.34 | 0.40 | ▲ | | | | | | | | | | | | |
| | | DC 16,00 | DEX1600-TE | PL 2.91 | f _n ▶ 0.32 | 0.36 | 0.42 | ▲ | | | | | | | | | | | | |
| | | DC 16,50 | DEX1650-TE | PL 3.00 | f _n ▶ 0.32 | 0.36 | 0.42 | ▲ | | | | | | | | | | | | |
| | | DC 17,00 | DEX1700-TE | PL 3.09 | f _n ▶ 0.34 | 0.38 | 0.44 | ▲ | | | | | | | | | | | | |
| | | DC 17,50 | DEX1750-TE | PL 3.18 | f _n ▶ 0.34 | 0.38 | 0.44 | ▲ | | | | | | | | | | | | |
| | | DC 18,00 | DEX1800-TE | PL 3.28 | f _n ▶ 0.36 | 0.40 | 0.46 | ▲ | | | | | | | | | | | | |
| | | DC 18,50 | DEX1850-TE | PL 3.37 | f _n ▶ 0.36 | 0.40 | 0.46 | ▲ | | | | | | | | | | | | |
| | | DC 19,00 | DEX1900-TE | PL 3.46 | f _n ▶ 0.38 | 0.42 | 0.48 | ▲ | | | | | | | | | | | | |
| | | DC 19,50 | DEX1950-TE | PL 3.55 | f _n ▶ 0.38 | 0.42 | 0.48 | ▲ | | | | | | | | | | | | |
| | | DC 20,00 | DEX2000-TE | PL 3.64 | f _n ▶ 0.40 | 0.44 | 0.50 | ▲ | | | | | | | | | | | | |
| | | DC 20,50 | DEX2050-TE | PL 3.73 | f _n ▶ 0.40 | 0.44 | 0.50 | ▲ | | | | | | | | | | | | |

Hohe Leistung auf Guss
verstärkte Fase

▲ Wird in Zukunft eingeführt



| DEX DRILL | | | DC min | DC max | DCON | OAL | LF | LB | MIID | |
|------------------|------------------|-----------------|--------|--------|-------|-------|-------|-------------------|------|-------------------|
| 3xD | NT-DEX-3D | D12-S16F | ▲ | 12.00 | 12.99 | 16 | 103 | 55 | 42 | DEX1200 ÷ DEX1290 |
| | | D13-S16F | ▲ | 13.00 | 13.99 | 16 | 106.5 | 58.5 | 45.5 | DEX1300 ÷ DEX1390 |
| | | D14-S16F | ▲ | 14.00 | 14.99 | 16 | 110 | 62 | 49 | DEX1400 ÷ DEX1490 |
| | | D15-S20F | ▲ | 15.00 | 15.99 | 20 | 118.5 | 68.5 | 52.5 | DEX1500 ÷ DEX1590 |
| | | D16-S20F | ▲ | 16.00 | 16.99 | 20 | 122 | 72 | 56 | DEX1600 ÷ DEX1690 |
| | | D17-S20F | ▲ | 17.00 | 17.99 | 20 | 125.5 | 75.5 | 59.5 | DEX1700 ÷ DEX1790 |
| | | D18-S25F | ▲ | 18.00 | 18.99 | 25 | 139 | 83 | 63 | DEX1800 ÷ DEX1890 |
| | | D19-S25F | ▲ | 19.00 | 19.99 | 25 | 142.5 | 86.5 | 66.5 | DEX1900 ÷ DEX1990 |
| 5xD | NT-DEX-5D | D20-S25F | ▲ | 20.00 | 20.99 | 25 | 146 | 90 | 70 | DEX2000 ÷ DEX2090 |
| | | D12-S16F | ▲ | 12.00 | 12.99 | 16 | 127 | 79 | 66 | DEX1200 ÷ DEX1290 |
| | | D13-S16F | ▲ | 13.00 | 13.99 | 16 | 132.5 | 84.5 | 71.5 | DEX1300 ÷ DEX1390 |
| | | D14-S16F | ▲ | 14.00 | 14.99 | 16 | 138 | 90 | 77 | DEX1400 ÷ DEX1490 |
| | | D15-S20F | ▲ | 15.00 | 15.99 | 20 | 148.5 | 98.5 | 82.5 | DEX1500 ÷ DEX1590 |
| | | D16-S20F | ▲ | 16.00 | 16.99 | 20 | 154 | 104 | 88 | DEX1600 ÷ DEX1690 |
| | | D17-S20F | ▲ | 17.00 | 17.99 | 20 | 159.5 | 109.5 | 93.5 | DEX1700 ÷ DEX1790 |
| | | D18-S25F | ▲ | 18.00 | 18.99 | 25 | 175 | 119 | 99 | DEX1800 ÷ DEX1890 |
| D19-S25F | ▲ | 19.00 | 19.99 | 25 | 180.5 | 124.5 | 104.5 | DEX1900 ÷ DEX1990 | | |
| D20-S25F | ▲ | 20.00 | 20.99 | 25 | 186 | 130 | 110 | DEX2000 ÷ DEX2090 | | |

▲ Wird in Zukunft eingeführt

| KÖRPER Ø | SCHLÜSSEL |
|-----------------|--|
| 12÷16 |  NT-WR1216 |
| 17÷20 | NT-WR1720 |

SCHNITTGESCHWINDIGKEIT [m/min]

| | MATERIAL (Härte/Rm) | W.-Nr | DIN | AISI-ASTM | TRADE MARK | JP5625 | JP7625 |
|-----------|--|------------------|----------------------------------|--------------------------------|--------------|---------------|---------------|
| P1 | Automatenstähle und Baustähle (< 500 N/mm ²) | 1.0715 1.0765 | 9 SMn 28 36 SMnPb 14 | 1213 A29 | AVP PR80 | 100÷160 | |
| P2 | Kohlenstoff-Stähle und niedriglegierte Stähle (500-700 N/mm ²) | 1.7147 1.0511 | 20 MnCr 5 C 40 | 5120 1040 | - - | 80÷140 | |
| P3 | Mittellegierte Stähle und Vergütungsstähle (600-800 N/mm ²) | 1.1201 1.6511 | 42 CrMo 4 36 CrNiMo 4 | 4142, 4140 9840 | - - | 60÷100 | |
| P4 | Hochlegierte Stähle (800-1000 N/mm ²) | 1.1663 1.3505 | C 125 W 100 Cr 6 | W1 52100 | - - | 50÷90 | |
| P5 | Werkzeugstähle (900-1200 N/mm ²) | 1.2080 1.2379 | X 210 Cr 12 X 155 CrV Mo 12 1 | D3 - | K100 K110 | 40÷80 | |
| K1 | Grauguss (150-250 HB) | 0.6020 0.6025 | GG-20 GG-25 | A48 30 B A48 35 B | - - | 80÷180 | 100÷200 |
| K2 | Sphäroguss (150-350 HB) | 0.7050 0.7070 | GGG-50 GGG-70 | A536 80-55-6 A536 100-70-03 | - - | 80÷140 | 100÷160 |

Hermann tooling-concept
Werkzeug und Bearbeitungsprozess 4.0

Jörg Hermann
Am Park 9
78147 Vöhrnbach
Mobil: +49 176 215 216 45
info@prozess-doktor.net
www.prozess-doktor.net



PROZESS-DOKTOR.NET
Werkzeug und Bearbeitungsprozess 4.0

