

FLX02

6 x D



GJL/GJS

ALU

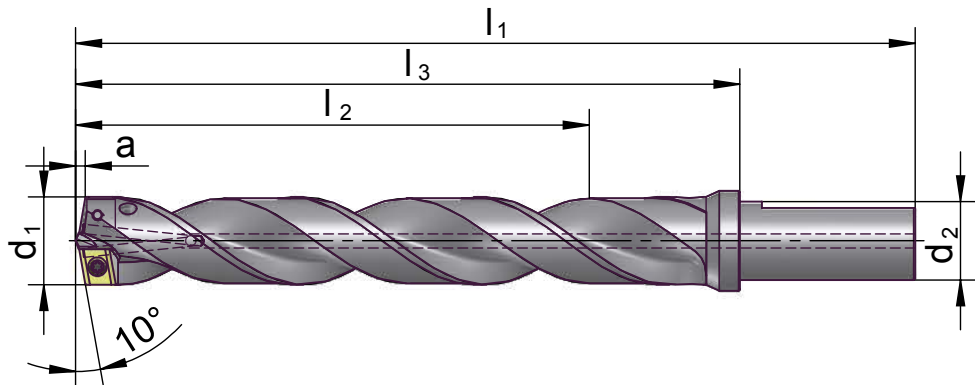
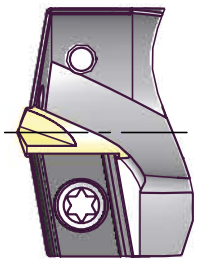
ST(AHL)

Vorteile:

- Selbstzentrierend durch Kernschneide und zwei symmetrische Wendeschneidplatten
- Hohe Zähigkeit im Zentrum beim Anbohren durch HSS-Kernschneide
- Hoher Vorschub durch 2 Schneiden
- Enge Bohrungstoleranzen (H11)
- Geradliniger Bohrungsverlauf durch Führungsfasen an den WSP
- Universell mit HM- und HSSE-WSP einsetzbar
- Auch für labilen Einsatzbedingungen geeignet
- Paketbearbeitung möglich
- Polierte Spankammern für sichere Spanabfuhr

Advantages:

- Self-centering by means of core cutter and symmetrically positioned indexable inserts
- High toughness due to HSS-core cutter in the centre
- High feed rate with two inserts
- Close drilling tolerances (H11)
- Straight bores due to guiding chamfers on the inserts
- Universally usable with carbide and HSS inserts
- Also usable in unstable conditions
- Machining of stacked bores possible
- Polished chip-flutes for good chip-flow






FLX02

| d ₁ ±0,05 | a | l ₁ | l ₂ | l ₃ | d ₂ BZM | Best.-Nr./ Ord.-No |
|----------------------|-----|----------------|----------------|----------------|-----------------------|-----------------------|
| | | | | | | FLX02 |
| 18 | 2,2 | 200 | 120 | 150 | 20 | FLX02 18 A |
| 19 | 2,3 | 200 | 120 | 150 | 20 | FLX02 19 A |
| 20 | 2,4 | 200 | 120 | 150 | 20 | FLX02 20 A |
| 21 | 2,5 | 230 | 144 | 174 | 25 | FLX02 21 A |
| 22 | 2,6 | 230 | 144 | 174 | 25 | FLX02 22 A |
| 23 | 2,7 | 230 | 144 | 174 | 25 | FLX02 23 A |
| 24 | 2,8 | 230 | 144 | 174 | 25 | FLX02 24 A |
| 25 | 3,0 | 250 | 162 | 194 | 25 | FLX02 25 A |
| 26 | 3,1 | 250 | 162 | 194 | 25 | FLX02 26 A |
| 27 | 3,2 | 250 | 162 | 194 | 25 | FLX02 27 A |
| 28 | 3,3 | 280 | 186 | 224 | 25 | FLX02 28 A |
| 29 | 3,4 | 280 | 186 | 224 | 25 | FLX02 29 A |
| 30 | 3,4 | 280 | 186 | 224 | 25 | FLX02 30 A |
| 31 | 3,5 | 280 | 186 | 224 | 25 | FLX02 31 A |
| 32 | 3,8 | 325 | 222 | 265 | 32 | FLX02 32 A |
| 33 | 3,9 | 325 | 222 | 265 | 32 | FLX02 33 A |
| 34 | 4,0 | 325 | 222 | 265 | 32 | FLX02 34 A |
| 35 | 4,1 | 325 | 222 | 265 | 32 | FLX02 35 A |
| 36 | 4,2 | 325 | 222 | 265 | 32 | FLX02 36 A |
| 37 | 4,3 | 325 | 222 | 265 | 32 | FLX02 37 A |
| 38 | 4,5 | 340 | 234 | 280 | 32 | FLX02 38 A |
| 39 | 4,6 | 340 | 234 | 280 | 32 | FLX02 39 A |

Andere Abmessungen und Ausführungen auf Anfrage / Other dimensions and designs upon request

Flexispeed FLX02

Schneiden, Ersatzteile und Zubehör
 Inserts, Spare Parts and Accessories

| |  | |  |  | |
|---------|---|--|---|---|--|
| mm Ø | FLX02 6 x D, zyl. / cyl. | | Kernschneiden / Core Cutter HSSE-TiAlN* | Wendeschneidplatte* / Insert | |
| 18 | FLX02 18 A | | KEN03052A | XCEX 070204 FRZ ... | |
| 19 | FLX02 19 A | | KEN03052A | XCEX 075204 FRZ ... | |
| 20 | FLX02 20 A | | KEN03052A | XCEX 080204 FRZ ... | |
| 21 | FLX02 21 A | | KEN03052A | XCEX 085304 FRZ ... | |
| 22 | FLX02 22 A | | KEN03052A | XCEX 090304 FRZ ... | |
| 23 | FLX02 23 A | | KEN03052A | XCEX 095304 FRZ ... | |
| 24 | FLX02 24 A | | KEN03052A | XCEX 100304 FRZ ... | |
| 25 | FLX02 25 A | | KEN03062A | XCEX 100304 FRZ ... | |
| 26 | FLX02 26 A | | KEN03062A | XCEX 105304 FRZ ... | |
| 27 | FLX02 27 A | | KEN03062A | XCEX 110304 FRZ ... | |
| 28 | FLX02 28 A | | KEN03062A | XCEX 115304 FRZ ... | |
| 29 | FLX02 29 A | | KEN03062A | XCEX 120304 FRZ ... | |
| 30 | FLX02 30 A | | KEN03062A | XCEX 125304 FRZ ... | |
| 31 | FLX02 31 A | | KEN03062A | XCEX 130304 FRZ ... | |
| 32 | FLX02 32 A | | KEN03082A | XCEX 125304 FRZ ... | |
| 33 | FLX02 33 A | | KEN03082A | XCEX 130304 FRZ ... | |
| 34 | FLX02 34 A | | KEN03082A | XCEX 135404 FRZ ... | |
| 35 | FLX02 35 A | | KEN03082A | XCEX 140404 FRZ ... | |
| 36 | FLX02 36 A | | KEN03082A | XCEX 145404 FRZ ... | |
| 37 | FLX02 37 A | | KEN03082A | XCEX 150404 FRZ ... | |
| 38 | FLX02 38 A | | KEN03102A | XCEX 145404 FRZ ... | |
| 39 | FLX02 39 A | | KEN03102A | XCEX 150404 FRZ ... | |

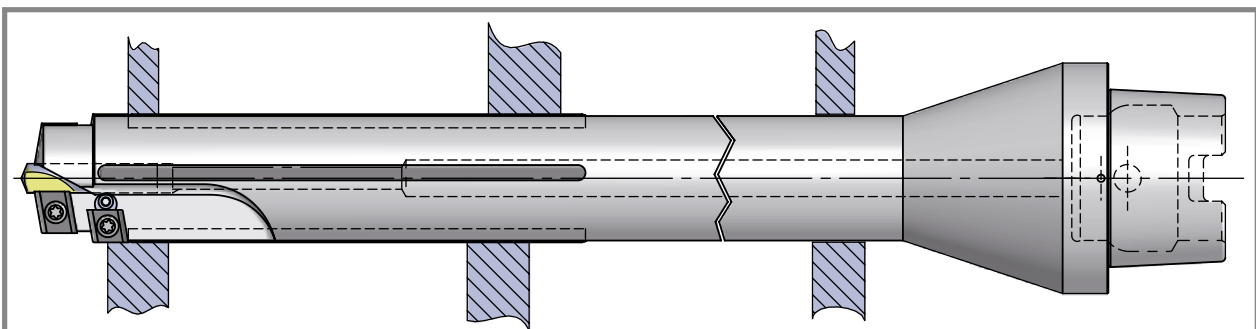
* Separat bestellen / Order separately




Andere Abmessungen (auch größere Durchmesser) auf Anfrage /
 Other dimensions (also larger diameters) upon request

HM-Kernschneiden auf Anfrage / Carbide core cutters on request

WSP mit Spanteiler und andere Ausführungen auf Anfrage /
 Inserts with chip splitter and other designs on request

Flexispeed Sonderlösung mit Führungsleisten und einstellbaren WSP /
 Flexispeed in special design with guide pads and adjustable inserts



| | | | | | |  |  |  |
|--|--------|-------|---|-------|-------|--|---|---|
| Werkstoffgruppe (s. S. 22) / Material class (s. p. 22) | | | | | | Klemmschraube für Kernschneide / Fixing screw for core cutter | | |
| N K S | K | K | P | P | P K S | | | |
| Schneidstoffsorte / Grade | | | | | | | | |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010406 | TX 25050 | TX 208 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010406 | TX 25050 | TX 208 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010406 | TX 25050 | TX 208 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010406 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010406 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010406 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010406 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010508 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010508 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010508 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010508 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010508 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010508 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010508 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010610 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010610 | TX 35075 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010610 | TX 45115 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010610 | TX 45115 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010612 | TX 45115 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010612 | TX 45115 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010612 | TX 45115 | TX 215 |
| ...AK1 | ... K1 | ...K9 | | ...P9 | ...S6 | KLS 010612 | TX 45115 | TX 215 |

Schneidstoffsorten / Grades

| Sorte Grade | DIN-ISO 513 | Schneidstoff Cutting material | Werkstoffgruppe / Material class | | | |
|----------------|-------------|----------------------------------|-------------------------------------|------------------------|---|---|
| | | | Stahl Steel | Gusseisen Cast iron | Nichteisen- metalle Nonferrous metal | Speziallegier- ungen und Titan Special alloys and Titanium |
| | | | P | K | N | S |
| AK1 | HW - N20 | HM / Carbide | | o | + | o |
| K1 | HF - K20 | HM / Carbide | | + | | |
| K9 | HC - K10 | HM- / Carbide TiAlN | | + | | |
| P9 | HC - P40 | HM- / Carbide TiAlN | + | o | | |
| S6 | | HSSE-TiN | + | o | | + |

Bestellbeispiel / Order example:

- 2 Stück/pieces FLX0227A
- 6 Stück/pieces KEN03062A
- 10 Stück/pieces XCEX 110304 FRZP9
- 1 Stück/piece TX 215
- 10 Stück/pieces TX 35075
- 5 Stück/pieces KLS 010508

+ = Hauptanwendung / Main application
o = Nebenanwendung / Minor application