

B-1220

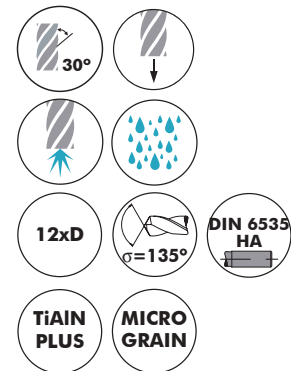
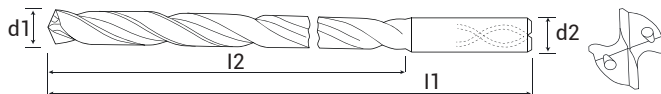
BROCAS

Broca metal duro 12xD con refrigeración interna

Solid carbide 12xD twist drill with internal coolant

Broca metal duro integral 12xD con recubrimiento TiAlN, con refrigeración interior y con corte a derecha. Ángulo de punta 135°, ángulo de espiral 30°. Geometría de corte especial para taladrado previo con broca 3xD, que garantiza una perfecta concentricidad. Afilado especial de los canales para disminuir el coeficiente de fricción, mejorando la extracción de viruta. Para trabajos con refrigeración externa.

Solid carbide 12xD twist drill, with internal coolant and TiAlN coating. Cylindrical shank, right hand cut. Point angle 135°, helix angle 30°. Special profile chip flute geometry. Before drilling, you have to use a 3xD drill. High performance spiral twist drill for highest bore hole quality and economical output. Drilling is possible both with and without external coolant.



STEEL
<55
HRC

INOX

GG

GGG

NI
ALLOYS

TITAN
INCONEL

UNI

| Ejemplo de pedido | | | Ref. final |
|-------------------|------------|-------|-------------|
| B1220 | 022 | ↓ 210 | B1220022210 |
| | d1=2,2 | | |
| B1220 | 120 | ↓ 210 | B1220120210 |
| | d2=12 | | |

Condiciones de corte | Cutting data pag. 213

| d1 | d2 | l1 | l2 | | d1 | d2 | l1 | l2 | |
|------|----|-----|------|--|------|----|-----|-----|--|
| m7 | h6 | | | | m7 | h6 | | | |
| 2,20 | 3 | 65 | 29,7 | | 4,4 | 6 | 109 | 69 | |
| 2,25 | 3 | 65 | 30,4 | | 4,5 | 6 | 109 | 69 | |
| 2,30 | 3 | 65 | 31,1 | | 4,6 | 6 | 116 | 76 | |
| 2,35 | 3 | 75 | 31,7 | | 4,7 | 6 | 116 | 76 | |
| 2,40 | 3 | 75 | 32,4 | | 4,8 | 6 | 116 | 76 | |
| 2,45 | 3 | 75 | 33,1 | | 4,9 | 6 | 116 | 76 | |
| 2,50 | 3 | 75 | 33,8 | | 5,0 | 6 | 116 | 76 | |
| 2,55 | 3 | 75 | 34,4 | | 5,1 | 6 | 124 | 84 | |
| 2,60 | 3 | 75 | 35,1 | | 5,2 | 6 | 124 | 84 | |
| 2,65 | 3 | 75 | 35,8 | | 5,3 | 6 | 124 | 84 | |
| 2,70 | 3 | 75 | 36,5 | | 5,4 | 6 | 124 | 84 | |
| 2,75 | 3 | 75 | 37,1 | | 5,5 | 6 | 124 | 84 | |
| 2,80 | 3 | 75 | 37,8 | | 5,6 | 6 | 131 | 91 | |
| 2,85 | 3 | 75 | 38,5 | | 5,7 | 6 | 131 | 91 | |
| 2,90 | 3 | 75 | 39,2 | | 5,8 | 6 | 131 | 91 | |
| 2,95 | 3 | 75 | 39,8 | | 5,9 | 6 | 131 | 91 | |
| 3,00 | 6 | 86 | 46 | | 6,0 | 6 | 131 | 91 | |
| 3,10 | 6 | 94 | 54 | | 6,5 | 8 | 139 | 99 | |
| 3,20 | 6 | 94 | 54 | | 7,0 | 8 | 146 | 106 | |
| 3,30 | 6 | 94 | 54 | | 7,5 | 8 | 154 | 114 | |
| 3,40 | 6 | 94 | 54 | | 8,0 | 8 | 161 | 121 | |
| 3,50 | 6 | 94 | 54 | | 8,5 | 10 | 173 | 129 | |
| 3,60 | 6 | 101 | 61 | | 9,0 | 10 | 180 | 136 | |
| 3,70 | 6 | 101 | 61 | | 9,5 | 10 | 189 | 145 | |
| 3,80 | 6 | 101 | 61 | | 10,0 | 10 | 196 | 152 | |
| 3,90 | 6 | 101 | 61 | | 10,5 | 12 | 209 | 160 | |
| 4,00 | 6 | 101 | 61 | | 11,0 | 12 | 216 | 167 | |
| 4,10 | 6 | 109 | 69 | | 11,3 | 12 | 216 | 167 | |
| 4,20 | 6 | 109 | 69 | | 11,5 | 12 | 224 | 175 | |
| 4,30 | 6 | 109 | 69 | | 12,0 | 12 | 231 | 182 | |