

## GEWINDEBOHRER

Machine taps  
Tarauds machine  
Maschi a macchina



## AUSKLAPPSEITE

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Pieghevole

### AUSWAHLÜBERSICHT

DIE ANGEGBENEN SCHNITTGESCHWINDIGKEITEN (VC IN M/MIN) SIND RICHTWERTE UND MÜSSEN DEN INDIVIDUELLEN ARBEITSBEDINGUNGEN ANGEPAßT WERDEN.

\* Für konische und Tr-Gewinde müssen die Schnittwerte um 50% reduziert werden.

### GUIDE DE SELECTION

LES VALEURS DE VITESSE DE COUPE (VC EN M/MIN) INDIQUÉES DANS LES COLONNES RESPECTIVES NE SONT QU'INDICATIVES ET DOIVENT ÊTRE ADAPTÉES INDIVIDUELLEMENT AUX CONDITIONS D'USINAGE.

\* Pour les filetages coniques et trapézoïdaux les valeurs de coupe doivent être réduites de 50%.

### SUMMARY OF ASSORTMENT

THE LISTED CUTTING SPEEDS (VC IN M/MIN) ARE STANDARD VALUES. THIS VALUES HAVE TO BE ADJUSTED TO INDIVIDUAL WORK CONDITIONS.

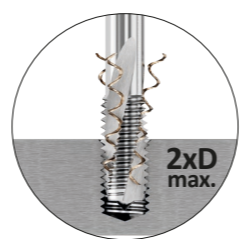
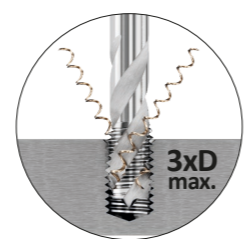
\* For conical threads and trapezoidal threads the cutting speeds have to be reduced by 50%.

### SCelta DEGLI UTENSILI

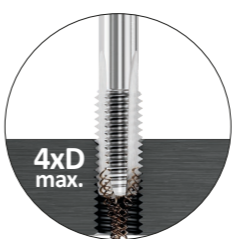
I VALORI DI VELOCITÀ DI TAGLIO (VC IN M/MIN) QUI ELENCATI SONO PURAMENTE INDICATIVI E DEVONO ESSERE ADATTATI ALLE CONDIZIONI D'IMPIEGO.

\* Per filetti conici e filetti trapezoidali le velocità di tagli o devono essere ridotte del 50 %.

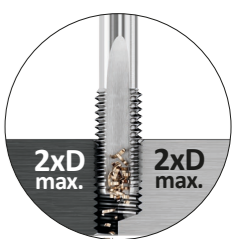
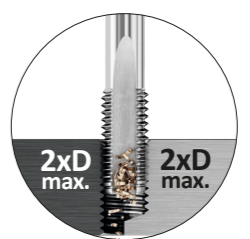
### SACKLOCH-GEWINDE/BLINDHOLETHREADS TROUSBORGNES/FORICIECHI



### DURCHGANGLSCH-GEWINDE/THROUGHHOLETHREADS TROUSDÉBOUCHANTS/FORIPASSANTI



### DURCHGANGLSCH+ SACKLOCH-GEWINDE/THROUGHHOLETHREADS+BLINDHOLETHREADS TROUSDÉBOUCHANTS+TROUSBORGNES/FORIPASSANTI+FORICIECHI



Legend table for material types and grades, including M, MF, UNC, UNF, UNEF, UN8, G, Rp, Rc, BSW, BSF, W, NPT, NPTF, NPSM, NPSF, MJ, UNIC, UNJF, EG, (ST)I, TR, Rd, Pg.

Table for NORISSALOREX drill bits, showing cutting speeds for various materials and grades.

Table for NORISSL15/SL25/SL30 drill bits, showing cutting speeds for various materials and grades.

Table for NORISSTABIL drill bits, showing cutting speeds for various materials and grades.

Table for NORISDL15 drill bits, showing cutting speeds for various materials and grades.

Table for NORISTWIN drill bits, showing cutting speeds for various materials and grades.

Table for NORISINNENSPAN RA15 drill bits, showing cutting speeds for various materials and grades.

Table for SATZ ERGO ERGOFIT drill bits, showing cutting speeds for various materials and grades.



Main selection table with columns for material type (e.g., Stahlwerkstoffe, Rostfreistähle, Gusswerkstoffe, Nichteisenwerkstoffe, Spezialwerkstoffe, Gehärtete Werkstoffe) and material grade (e.g., P1.1, P1.2, P1.3, P2.1, M1.1, M1.2, K1.1, K2.1, N1.1, N1.2, N1.3, N2.1, N2.2, N2.3, N3.1, N4.1, N5.1, N5.2, S1.1, S1.2, S1.3, S2.1, S2.2, H1.1, H1.2, H1.3).

Table for Vcm/min values for NORISSALOREX drill bits.

Table for Vcm/min values for NORISSL15/SL25/SL30 drill bits.

Table for Vcm/min values for NORISSTABIL drill bits.

Table for Vcm/min values for NORISDL15 drill bits.

Table for Vcm/min values for NORISTWIN drill bits.

Table for Vcm/min values for NORISINNENSPAN RA15 drill bits.

Table for Vcm/min values for SATZ ERGO ERGOFIT drill bits.

SCHEMERMITTELEMPFEHLUNG • LUBRICANT RECOMMENDATION  
LUBRIFICATION RECOMMANDÉE • RACCOMANDAZIONI PER I LUBRIFICANTI

EMULSION • EMULSION  
EMULSION • EMULSION

SCHNEIDÖL • CUTTING OIL  
HUILE DE COUPE • OLIO DA TAGLIO

TROCKEN • DRY  
SÈCHE • SECCO

TROCKEN • DRY  
SÈCHE • SECCO

TROCKEN • DRY  
SÈCHE • SECCO

TROCKEN • DRY  
SÈCHE • SECCO

TROCKEN • DRY  
SÈCHE • SECCO

