

CoroDrill® 881

Metrische Werte

ISO	MC-Nr. (CMC-Nr.)	Werkstückstoff	Härte Brinell HB	Sorte	Schnittge- schwindigkeit (m/min)	Bohrerdurch- messer D _c mm	Geometrie / Vorschub		
							2-3xD -GM1 f _n mm/U	4xD -GM1 f _n mm/U	5xD -GM1 f _n mm/U
P	P1.0.Z.AN (01.0)	Unlegierter Stahl Nicht vergütet 0.05-0.10% C	80-170	4024 4044	230-380 190-235	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.10	0.04-0.09	0.04-0.07
							0.04-0.10	0.04-0.09	0.04-0.07
							0.04-0.12	0.04-0.10	0.04-0.08
	P1.1.Z.AN (01.1)	Nicht vergütet 0.05-0.25% C	90-200	4024 4044	230-350 170-225	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.10	0.04-0.09	0.04-0.07
							0.04-0.10	0.04-0.09	0.04-0.07
							0.04-0.12	0.04-0.10	0.04-0.08
	P1.2.Z.AN (01.2)	Nicht vergütet 0.25-0.55% C	125-225	4024 4044	190-290 120-180	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.12	0.04-0.10	0.04-0.08
							0.04-0.14	0.04-0.12	0.04-0.09
							0.04-0.16	0.04-0.14	0.04-0.11
	P1.3.Z.AN (01.3)	Nicht vergütet 0.55-0.80% C	150-250	4024 4044	170-275 105-175	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.12	0.04-0.10	0.04-0.08
							0.06-0.14	0.06-0.12	0.06-0.09
							0.06-0.16	0.06-0.14	0.06-0.11
P1.3.Z.AN (01.4)	Legierter und hochlegierter Werkzeugstahl	180-275	4024 4044	200-275 105-170	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.12	0.04-0.10	0.04-0.08	
						0.06-0.14	0.06-0.12	0.06-0.09	
P2.1.Z.AN (02.1)	Niedriglegierter Stahl (nicht gehärtet)	150-260	4024 4044	180-290 115-180	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.14	0.04-0.12	0.04-0.09	
						0.06-0.16	0.06-0.13	0.06-0.11	
P2.5.Z.HT (02.2)	Gehärteter Stahl	220-450	4024 4044	90-230 75-140	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.12	0.04-0.10	0.04-0.08	
						0.06-0.14	0.06-0.12	0.06-0.09	
P3.0.Z.AN 03.11	Hochlegierter Stahl (geglüht)	150-250	4024 4044	160-275 100-170	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.10	0.04-0.08	0.04-0.07	
						0.04-0.16	0.04-0.13	0.04-0.11	
P3.0.Z.HT (03.21)	Gehärteter Stahl	250-350	4024 4044	80-200 70-125	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.12	0.04-0.10	0.04-0.08	
						0.06-0.14	0.06-0.11	0.06-0.09	
P1.5.C.UT (06.1)	Stahlguss (unlegiert)	90-225	4024 4044	140-310 125-190	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.10	0.04-0.08	0.04-0.07	
						0.04-0.10	0.04-0.08	0.04-0.07	
P2.6.C.UT (06.2)	Niedriglegiert (Legierungsanteile weniger als 5%)	150-250	4024 4044	110-250 100-150	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.12	0.04-0.10	0.04-0.08	
						0.06-0.14	0.06-0.11	0.06-0.09	
M	P5.0.Z.AN (05.11)	Rostfreier Stahl ferritisch/ martensitisch 13-25% Cr	150-270	4024	120-265	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08
				4044	115-165	17.44-20.99	0.04-0.14	0.04-0.12	0.04-0.09
M1.0.Z.AQ (05.21)	Austenitisch Ni, > 8%, 13-25% Cr	150-275	4024 4044 2044	120-250 115-180 115-180	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.12	0.04-0.10	0.04-0.08	
						0.04-0.12	0.04-0.10	0.04-0.08	
M3.1.Z.AQ (05.51)	austenitisch/ferritisch (Duplex)	200-320	4024 4044 2044	90-145 85-125 85-125	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.12	0.04-0.10	0.04-0.08	
						0.04-0.12	0.04-0.10	0.04-0.08	
M1.0.C.UT (15.21)	Austenitische Gusswerkstoffe	150-250	4024 4044 2044	150-200 80-155 80-155	12.70-17.43 17.44-20.99 21.00-25.99	0.04-0.10	0.04-0.08	0.04-0.06	
						0.04-0.12	0.04-0.10	0.04-0.08	
						0.04-0.14	0.04-0.12	0.04-0.09	

GC1044 ist die optimierte Sorte für die Zentrumschneide in allen Werkstoffen

GC1144 ist die optimierte Sorte für Zentrumschneiden für ISO M Werkstoffe

CoroDrill® 881

Metrische Werte

ISO	MC-Nr. (CMC-Nr.)	Werkstückstoff	Härte Brinell	Sorte	Schnittgeschwindigkeit	Bohrerdurchmesser	Geometrie / Vorschub					
			HB	○	(m/min)	D _c mm	Bohrerlänge					
							2-3xD -GM1	4xD -GM1	5xD -GM1			
							f _n mm/U	f _n mm/U	f _n mm/U			
S	S2.0.Z.AN	Warmfeste Legierungen. Ni-basiert	140-425	2044	20-90	12.70-17.43	0.03-0.08	0.03-0.08	0.03-0.05			
	S2.0.Z.AG (20.22)			4044		17.44-20.99				0.04-0.08	0.04-0.08	0.04-0.05
	S2.0.C.NS (20.24)					21.00-25.99				0.04-0.08	0.04-0.08	0.04-0.05
	S4.2.Z.AN	Titan: Alpha-, ähnlich Alpha und Alpha+Beta Legierungen in geglühtem Zustand	R _m (MPa)	2044	40-135	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08			
	(23.21)			4044		17.44-20.99				0.06-0.14	0.06-0.12	0.06-0.09
	S4.3.Z.AG (23.22)					21.00-25.99				0.08-0.14	0.08-0.12	0.08-0.09
K	K1.1.C.NS (07.1)	Temperguss Ferritisch (kurzspanend)	110-145	4024	140-230	12.70-17.43	0.04-0.16	0.04-0.12	0.04-0.11			
			4044	80-145		17.44-20.99				0.08-0.18	0.06-0.14	0.06-0.12
	K1.1.C.NS (07.2)	Perlitisch (langspanend)	150-270	4024	105-170	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08			
			4044	65-105		17.44-20.99				0.06-0.14	0.06-0.12	0.06-0.09
	K2.1.C.UT (08.1)	Grauguss: niedrige Zugfestigkeit	150-220	4024	210-310	12.70-17.43	0.04-0.16	0.04-0.12	0.04-0.11			
			4044	130-195		17.44-20.99				0.08-0.18	0.06-0.14	0.06-0.12
K2.2.C.UT (08.2)	Hohe Festigkeit	200-330	4024	125-230	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08				
		4044	75-140		17.44-20.99				0.06-0.14	0.06-0.12	0.06-0.09	
K3.1.C.UT (09.1)	Kugelgraphitguss (ferritisch)	150-230	4024	125-215	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08				
		4044	80-135		17.44-20.99				0.06-0.14	0.06-0.12	0.06-0.09	
K3.3.C.UT (09.2)	Perlitisch	200-330	4024	110-200	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08				
		4044	70-125		17.44-20.99				0.06-0.14	0.06-0.12	0.06-0.09	
H	H1.3.Z.HA (04.1)	Vergütet	47-65	4024	30-80	12.70-17.43	0.04-0.10	0.04-0.08	0.04-0.06			
				4044		30-80				17.44-20.99	0.06-0.14	0.06-0.11
N	N1.2.Z.AG (30.12)	Aluminiumlegierungen, gewalzt oder gewalzt und ausgehärtet	30-150	4044	300-385	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08			
				4044		17.44-20.99				0.04-0.14	0.04-0.12	0.04-0.09
				4044		21.00-25.99				0.06-0.16	0.06-0.14	0.06-0.11
	N1.3.C.UT (30.21)	Gegossen. nicht ausgehärtet	40-100	4044	300-385	12.70-17.43	0.04-0.10	0.04-0.08	0.04-0.07			
				4044		17.44-20.99				0.04-0.12	0.04-0.10	0.04-0.08
N1.3.C.AG (30.22)	Gegossen oder gegossen und ausgehärtet	70-140	4044	250-335	12.70-17.43	0.04-0.10	0.04-0.08	0.04-0.07				
			4044		17.44-20.99				0.04-0.12	0.04-0.10	0.04-0.08	
N3.3.U.UT (33.1)	Kupfer und Kupferlegierungen	70-160	4044	250-380	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08				
			4044		17.44-20.99				0.04-0.14	0.04-0.12	0.04-0.09	
N3.2.C.UT (33.2)	Messing- und Bleilegierungen (Pb < 1%)	50-200	4044	180-230	12.70-17.43	0.04-0.12	0.04-0.10	0.04-0.08				
			4044		17.44-20.99				0.04-0.14	0.04-0.12	0.04-0.09	
						21.00-25.99	0.06-0.16	0.06-0.14	0.06-0.11			

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Zoll-Werte

ISO	MC-Nr. (CMC-Nr.)	Werkstückstoff	Härte Brinell HB	Sorte	Schnittge- schwindigkeit (ft/min)	Bohrerdurch- messer D _c Zoll	Geometrie / Vorschub				
							2-3xD -GM1 f _n Zoll/rev.	4xD -GM1 f _n Zoll/rev.	5xD -GM1 f _n Zoll/rev.		
P	P1.0.Z.AN (01.0)	Unlegierter Stahl Nicht vergütet 0.05-0.10% C	80-170	4024	760-1250 620-770	.500-.686	.002-.004 .002-.004 .002-.005	.002-.004 .002-.004 .002-.004	.002-.003 .002-.003 .002-.003		
				4044		.687-.826				.002-.004	.002-.003
				4044		.827-1.023				.002-.005	.002-.003
	P1.1.Z.AN (01.1)	Nicht vergütet 0.05-0.25% C	90-200	4024	750-1150 550-740	.500-.686	.002-.004 .002-.004 .002-.005	.002-.004 .002-.004 .002-.004	.002-.003 .002-.003 .002-.003		
				4044		.687-.826				.002-.004	.002-.003
				4044		.827-1.023				.002-.005	.002-.003
	P1.2.Z.AN (01.2)	Nicht vergütet 0.25-0.55% C	125-225	4024	620-950 395-590	.500-.686	.002-.005 .002-.006 .002-.006	.002-.004 .002-.005 .002-.006	.002-.003 .002-.004 .002-.004		
				4044		.687-.826				.002-.006	.002-.004
				4044		.827-1.023				.002-.006	.002-.004
	P1.3.Z.AN (01.3)	Nicht vergütet 0.55-0.80% C	150-250	4024	560-910 345-580	.500-.686	.002-.005 .002-.006 .002-.006	.002-.004 .002-.005 .002-.006	.002-.003 .002-.004 .002-.004		
				4044		.687-.826				.002-.006	.002-.004
				4044		.827-1.023				.002-.006	.002-.004
P1.3.Z.AN (01.4)	Legierter und hochlegierter Werkzeugstahl	180-275	4024	660-910 345-560	.500-.686	.002-.005 .002-.006 .002-.006	.002-.004 .002-.005 .002-.006	.002-.003 .002-.004 .002-.004			
			4044		.687-.826				.002-.006	.002-.004	
			4044		.827-1.023				.002-.006	.002-.004	
P2.1.Z.AN (02.1)	Niedriglegierter Stahl (nicht gehärtet)	150-260	4024	590-950 375-590	.500-.686	.002-.006 .002-.006 .002-.007	.002-.005 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005			
			4044		.687-.826				.002-.006	.002-.004	
			4044		.827-1.023				.002-.007	.002-.005	
P2.5.Z.HT (02.2)	Gehärteter Stahl	220-450	4024	295-750 245-460	.500-.686	.002-.005 .002-.006 .002-.006	.002-.004 .002-.005 .002-.005	.002-.003 .002-.004 .002-.004			
			4044		.687-.826				.002-.006	.002-.004	
			4044		.827-1.023				.002-.006	.002-.004	
P3.0.Z.AN (03.11)	Hochlegierter Stahl (geglüht)	150-250	4024	520-900 325-560	.500-.686	.002-.004 .002-.006 .002-.007	.002-.003 .002-.005 .002-.006	.002-.003 .002-.004 .002-.005			
			4044		.687-.826				.002-.006	.002-.004	
			4044		.827-1.023				.002-.007	.002-.005	
P3.0.Z.HT (03.21)	Gehärteter Stahl	250-350	4024	265-660 230-410	.500-.686	.002-.005 .002-.006 .002-.006	.002-.004 .002-.004 .002-.005	.002-.003 .002-.004 .002-.004			
			4044		.687-.826				.002-.006	.002-.004	
			4044		.827-1.023				.002-.006	.002-.004	
P1.5.C.UT (06.1)	Stahlguss (unlegiert)	90-225	4024	455-1000 405-620	.500-.686	.002-.004 .002-.004 .002-.005	.002-.003 .002-.003 .002-.004	.002-.003 .002-.003 .002-.003			
			4044		.687-.826				.002-.004	.002-.003	
			4044		.827-1.023				.002-.005	.002-.003	
P2.6.C.UT (06.2)	Niedriglegiert (Legierungsanteile weniger als 5%)	150-250	4024	360-820 325-490	.500-.686	.002-.005 .002-.006 .002-.006	.002-.004 .002-.004 .002-.005	.002-.003 .002-.004 .002-.004			
			4044		.687-.826				.002-.006	.002-.004	
			4044		.827-1.023				.002-.006	.002-.004	
M	P5.0.Z.AN (05.11)	Rostfreier Stahl ferritisch/ martensitisch 13-25% Cr	150-270	4024	390-870 375-540 375-540	.500-.686	.002-.005 .002-.006 .002-.007	.002-.004 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005		
				4044		.687-.826				.002-.006	.002-.004
				2044		.827-1.023				.002-.007	.002-.005
	M1.0.Z.AQ (05.21)	Austenitisch Ni, > 8%, 13-25% Cr	150-275	4024	390-820 375-590 375-590	.500-.686	.002-.005 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005	.002-.004 .002-.004 .002-.004		
				4044		.687-.826				.002-.005	.002-.004
				2044		.827-1.023				.002-.006	.002-.005
	M3.1.Z.AQ (05.51)	austenitisch/ferritisch (Duplex)	200-320	4024	295-475 280-410 280-410	.500-.686	.002-.005 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005	.002-.004 .002-.004 .002-.004		
				4044		.687-.826				.002-.005	.002-.004
				2044		.827-1.023				.002-.006	.002-.005
	M1.0.C.UT (15.21)	Austenitische Gusswerkstoffe	150-250	4024	495-660 265-510 265-510	.500-.686	.002-.004 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005	.002-.003 .002-.004 .002-.004		
				4044		.687-.826				.002-.005	.002-.004
				2044		.827-1.023				.002-.006	.002-.005

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Zoll-Werte

ISO	MC-Nr. (CMC-Nr.)	Werkstückstoff	Härte Brinell	Sorte	Schnittgeschwindigkeit	Bohrerdurchmesser	Geometrie / Vorschub		
			HB	○	(ft/min)	D _c Zoll	Bohrerlänge		
							2-3xD -GM1	4xD -GM	5xD -GM
							f _n mm/U	f _n mm/U	f _n mm/U
S	S2.0.Z.AN	Warmfeste Legierungen. Ni-basiert	140-425	2044	65-290	.500-.686	.001-.004	.001-.004	.001-.003
	S2.0.Z.AG (20.22)			4044	65-290	.687-.826	.002-.004	.002-.004	.002-.003
	S2.0.C.NS (20.24)					.827-1.023	.002-.004	.002-.004	.002-.003
	S4.2.Z.AN (23.21)	Titan: Alpha-, ähnlich Alpha und Alpha+Beta Legierungen in geglühtem Zustand	R _m (MPa)	2044 4044	135-440 135-440	.500-.686 .687-.826 .827-1.023	.002-.005 .002-.006 .003-.006	.002-.004 .002-.005 .003-.005	.002-.004 .002-.004 .003-.004
S4.3.Z.AG (23.22)	Titan: Alfa- und Betalegierungen in ausgehärtetem Zustand, Betalegierungen geglüht oder ausgehärtet	600-1500							
K	K1.1.C.NS (07.1)	Temperguss Ferritisch (kurzspanend)	110-145	4024 4044	460-750 260-475	.500-.686 .687-.826 .827-1.023	.002-.007 .003-.008 .004-.009	.002-.005 .002-.006 .003-.007	.002-.005 .002-.005 .002-.006
	K1.1.C.NS (07.2)	Perlitisch (langspanend)	150-270	4024 4044	345-560 210-345	.500-.686 .687-.826 .827-1.023	.002-.005 .002-.006 .003-.007	.002-.004 .002-.005 .003-.006	.002-.004 .002-.004 .003-.005
	K2.1.C.UT (08.1)	Grauguss: niedrige Zugfestigkeit	150-220	4024 4044	690-1000 430-640	.500-.686 .687-.826 .827-1.023	.002-.007 .003-.008 .004-.009	.002-.005 .002-.006 .003-.007	.002-.005 .002-.005 .002-.006
	K2.2.C.UT (08.2)	Hohe Festigkeit	200-330	4024 4044	410-750 245-460	.500-.686 .687-.826 .827-1.023	.002-.005 .002-.006 .003-.007	.002-.004 .002-.005 .003-.006	.002-.004 .002-.004 .003-.005
	K3.1.C.UT (09.1)	Kugelgraphitguss (ferritisch)	150-230	4024 4044	410-750 260-440	.500-.686 .687-.826 .827-1.023	.002-.005 .002-.006 .003-.007	.002-.004 .002-.005 .003-.006	.002-.004 .002-.004 .003-.005
	K3.3.C.UT (09.2)	Perlitisch	200-330	4024 4044	110-200 70-125	.500-.686 .687-.826 .827-1.023	.002-.005 .002-.006 .003-.007	.002-.004 .002-.005 .003-.006	.002-.004 .002-.004 .003-.005
H	H1.3.Z.HA (04.1)	Vergütet	47-65	4024 4044	100-265 100-265	.500-.686 .687-.826 .827-1.023	.002-.004 .002-.006 .002-.007	.002-.004 .002-.005 .002-.006	.002-.003 .002-.004 .002-.005
N	N1.2.Z.AG (30.12)	Aluminiumlegierungen, gewalzt oder gewalzt und ausgehärtet	30-150	4044	980-1250	.500-.686 .687-.826 .827-1.023	.002-.005 .002-.006 .002-.007	.002-.004 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005
	N1.3.C.UT (30.21)	Gegossen. nicht ausgehärtet	40-100	4044	980-1250	.500-.686 .687-.826 .827-1.023	.002-.004 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005	.002-.003 .002-.004 .002-.004
	N1.3.C.AG (30.22)	Gegossen oder gegossen und ausgehärtet	70-140	4044	820-1100	.500-.686 .687-.826 .827-1.023	.002-.004 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005	.002-.003 .002-.004 .002-.004
	N3.3.U.UT (33.1)	Kupfer und Kupferlegierungen	70-160	4044	820-1250	.500-.686 .687-.826 .827-1.023	.002-.005 .002-.006 .002-.007	.002-.004 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005
	N3.2.C.UT (33.2)	Messing- und Bleilegierungen (Pb < 1%)	50-200	4044	590-750	.500-.686 .687-.826 .827-1.023	.002-.005 .002-.006 .002-.007	.002-.004 .002-.005 .002-.006	.002-.004 .002-.004 .002-.005

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