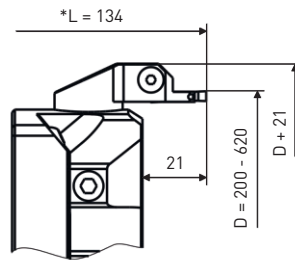
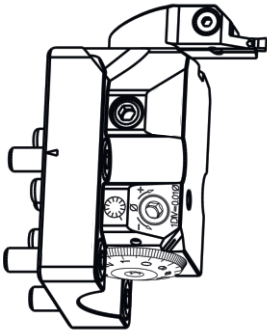


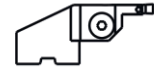
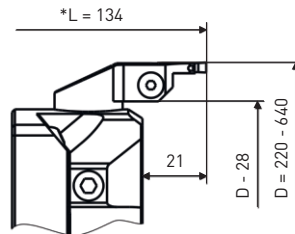


318.04

Bedienungsanleitung Stirnstechen Serie 318

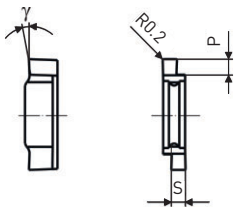


Bestell-Nr.: 626.938



Bestell-Nr.: 626.948

Wendeplatten

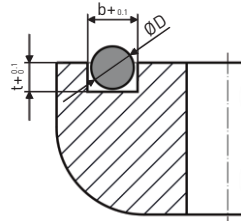


S	P	ST / GG *		Aluminium	
		Y	Bestell-Nr.	Y	Bestell-Nr.
2.5	2.7	5°	958.425	15°	958.475
3.0	3.3	5°	958.430	15°	958.480
3.3	3.6	5°	958.433	15°	958.483
3.5	3.8	5°	958.435	15°	958.485
4.0	4.3	5°	958.440	15°	948.490

* ST = Stahl / GG = Grauguss

Nutmasse

Empfohlene Nutmasse für bestimmte O-Ring
Querschnitt-Durchmesser, für statische
Abdichtung.



Dichtring ØD	Nutbreite b	Nuttiefe t
1.78	2.5	1.3
2.0	2.5	1.6
2.5	3.3	1.9
2.62	3.5	2.05
3.0	4.0	2.4

Schnittdaten

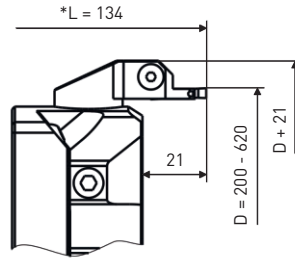
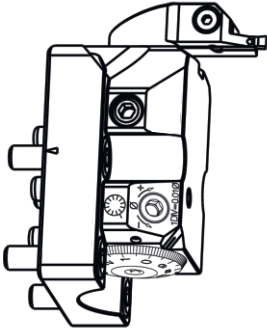
Die angegebenen Schnittdaten sind Richtwerte.
Mit den tieferen Werten starten, unter günstigen
Bedingungen können die Werte bis zum
Maximum erhöht werden.

Werkstoffe	v_c [m / min]	f_n [mm / U]
Bau- / Vergütungsstähle	120 - 240	0.08 - 0.12
Rostfreie Stähle	60 - 120	0.06 - 0.10
GGG / GGG	120 - 240	0.10 - 0.20
Aluminium / Butmetall	200 - 400	0.10 - 0.20

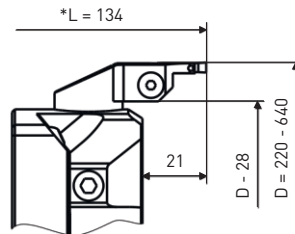
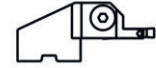


318.04

Instruction de service Gorges axiales Série 318



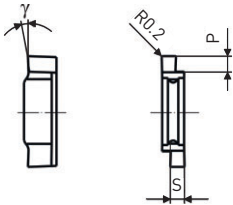
No. de réf.: 626.938



No. de réf.: 626.948



Plaquettes

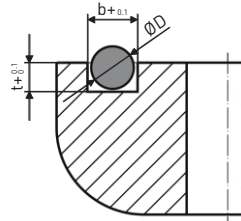


S	P	ST / GG *		Aluminium	
		Y	No. de réf.	Y	No. de réf.
2.5	2.7	5°	958.425	15°	958.475
3.0	3.3	5°	958.430	15°	958.480
3.3	3.6	5°	958.433	15°	958.483
3.5	3.8	5°	958.435	15°	958.485
4.0	4.3	5°	958.440	15°	948.490

* ST = Acier / GG = Fonte grise

Dimensions des rainures

Dimensions de rainure recommandées pour des joints toriques donnés (étanchéité statique).



Joint ØD	Largeur de rainure b	Profondeur de rainure t
1.78	2.5	1.3
2.0	2.5	1.6
2.5	3.3	1.9
2.62	3.5	2.05
3.0	4.0	2.4

Conditions de coupe

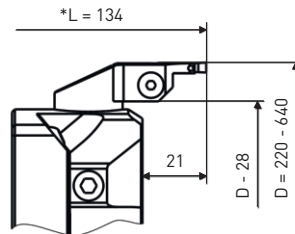
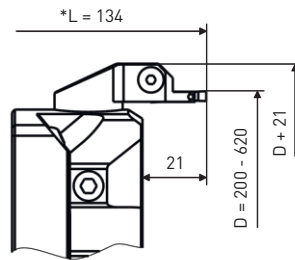
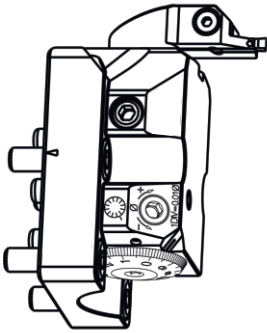
Les paramètres de coupe sont des valeurs indicatives. Commencer avec les valeurs inférieures, celles-ci peuvent être augmentées dans des conditions favorables jusqu'au maximum.

Matériau	v_c [m / min]	f_n [mm / tour]
Aciers de construction / d'amélioration	120 - 240	0.08 - 0.12
Aciers inoxydables	60 - 120	0.06 - 0.10
GGG / GGG	120 - 240	0.10 - 0.20
AL / Métaux non ferreux	200 - 400	0.10 - 0.20



318.04

Operating instruction Face grooving Series 318

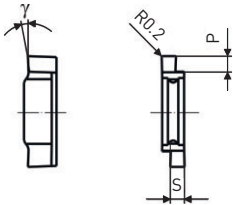


Order No.: 626.938



Order No.: 626.948

Inserts

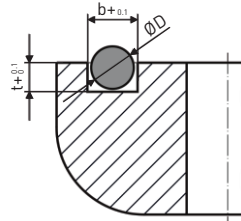


S	P	ST / GG *		Aluminium	
		Y	Order No.	Y	Order No.
2.5	2.7	5°	958.425	15°	958.475
3.0	3.3	5°	958.430	15°	958.480
3.3	3.6	5°	958.433	15°	958.483
3.5	3.8	5°	958.435	15°	958.485
4.0	4.3	5°	958.440	15°	948.490

* ST = Steel / GG = Cast iron

Groove dimensions

Recommended groove dimensions for given cross section diameters of O-Rings, for static sealing.



Seal ring ØD	Groove width b	Groove depth t
1.78	2.5	1.3
2.0	2.5	1.6
2.5	3.3	1.9
2.62	3.5	2.05
3.0	4.0	2.4

Cutting data

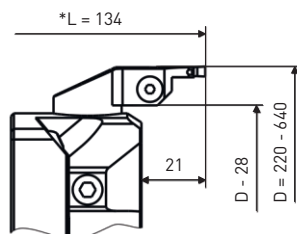
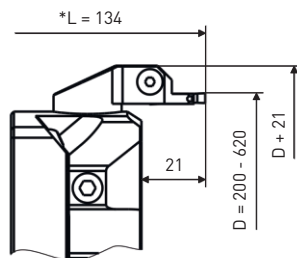
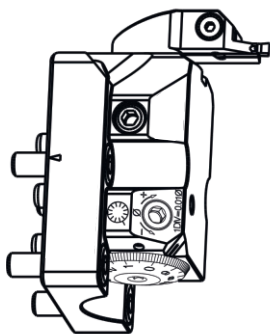
The given cutting data are guide values. We recommend to start with the lower values. Under favorable conditions they can be increased to the maximum.

Work piece material	v_c [m / min]	f_n [mm / rev]
Construction- / Heat treatable steels	120 - 240	0.08 - 0.12
Stainless steels	60 - 120	0.06 - 0.10
GGG / GGG	120 - 240	0.10 - 0.20
AL / Non-ferrous metals	200 - 400	0.10 - 0.20



318.04

Istruzioni d'uso Incisione frontale Serie 318

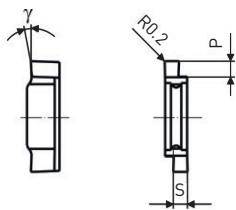


Articolo n.: 626.938



Articolo n.: 626.948

Inseri

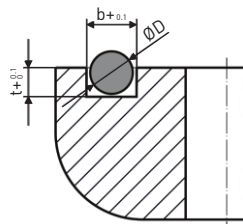


S	P	ST / GG *		Alluminio	
		Y	Articolo n.	Y	Articolo n.
2.5	2.7	5°	958.425	15°	958.475
3.0	3.3	5°	958.430	15°	958.480
3.3	3.6	5°	958.433	15°	958.483
3.5	3.8	5°	958.435	15°	958.485
4.0	4.3	5°	958.440	15°	948.490

* ST = acciaio / GG = ghisa grigia

Dimensioni della scanalatura

Dimensioni della scanalatura consigliate per determinati diametri di sezione trasversale di guarnizione circolare, per chiusura a tenuta statica.



Anello di tenuta ØD	Larghezza scanalatura b	Profondità scanalatura t
1.78	2.5	1.3
2.0	2.5	1.6
2.5	3.3	1.9
2.62	3.5	2.05
3.0	4.0	2.4

Dati di taglio

I dati di taglio indicati sono valori indicativi. Iniziare con i valori più bassi, in condizioni favorevoli i valori possono essere aumentati fino al massimo.

Materiale	v_c [m / min]	f_n [mm / giro]
Acciai da costruzione / da bonifica	120 - 240	0.08 - 0.12
Acciai inossidabili	60 - 120	0.06 - 0.10
GGG / GGG	120 - 240	0.10 - 0.20
Alluminio / metallo non ferroso	200 - 400	0.10 - 0.20