

Hartmetallwerkzeuge zum Innendrehen kleinster Dimensionen System Tip Bar

Outils en carbure p. le tournage intérieur de dimensions minces System Tip Bar

Carbide tools for internal turning of micro dimensions System Tip Bar



Vorteile

- **Ausgezeichnete Spanabfuhr** wegen der flachen, ebenen Konstruktion des Schneideinsatzes
- **aussergewöhnliche Feinstbearbeitung**, ohne Oberflächenverletzung, Riefen

Avantages

- **très bonne évacuation des copeaux** à cause de la géométrie plate des burins
- **très bonne qualité d'usinage**, excellent état de surface

Advantages

- **excellent chip evacuation** due to complete flat top face of insert
- **superior finishing** without chips scratching or biting

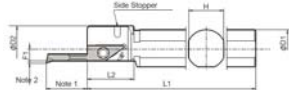
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Halter für Tip-Bar-Innendrehesystem AR mit rundem Schaft

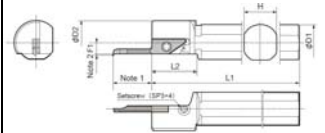
Porte-burin pour système Tip Bar pour le tournage intérieur à tige ronde

Insert holder for Tip-Bar-carbide inserts with round shank

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Beschreibung Désignation Description	Art.Nr./no.cde. order no	Dimension [mm]						Ersatzteile, pièces de rechange, spare parts				
		D1	D2	H	L1	L2	F1	Sp.-Schraube Vice de serr. Clamp screw	Schlüssel vice Wrench	Anschl.-Schraube vice p. arrêt screw stopper	Setz-Schraube vice p. poser Setscrew	Schlüssel vice wrench
S12F-SVNR12N	374110.050	12	20	11	80	23	4	SB-3080TR	FT-10		SP3X4	3.74110215
S14G-SVNR12N	374110.100	14	20	13	90	23	4					
S16H-SVNR12N	374110.150	16	24	15	100	23	6					
S20H-SVNR12N	374110.200	20	24	18	100	24	6					



Mit rechteckigem Schaft

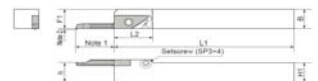
À tige rectangulaire

With rectangular shank

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Beschreibung Désignation Description	Art.Nr./no.cde. order no	Dimension [mm]						Ersatzteile, pièces de rechange, spare parts		
		H1=h	B	L1	L2	F1	F3	Sp.-Schraube Vice de serr. Clamp screw	Schlüssel vice Wrench	Setz-Schraube vice p. poser Setscrew
SVNR 1010H-12N	374112.050	10	10	100	22	10	-	SB-3080TR	FT-10	SP3X4
SVNR 1212K-12N	374112.100	12	12	125	22	16	-			
SVNR 1616K-12N	374112.150	16	16	125	22	16	-			
SVNR 2020K-12N	374112.200	20	20	125	22	20	-			
SVNR 2525M-12N	374112.250	25	25	150	22	25	-			



VNB../VNB-S

Innendrehen

VNB../VNB-S

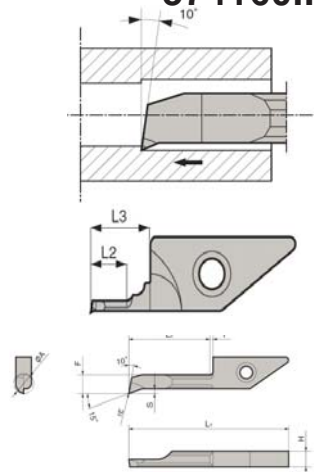
Tournage intérieur

VNB../VNB-S

Boring

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Beschreibung Désignation Description	Art.Nr./no.cde. order no	Dimension [mm]										Hartmetall/métal dur/ grades	
		Min.Dreh-Ø Ø min.tourn. Min.bore Ø ØA[mm]	H	L1	L2	L3	F	S	re	PVD-besch revêtue PVD PVD coated	unbeschicht pas revêtue uncoated		
VNBR	0105-0055	374160.105005	1.0	3.9	26.5	5	7	0.9	0.2	0.05	●		
	0206-02	374160.20602	2.0	3.9	26.5	6	-	1.8	0.3	0.20	●		
	0311-02	374160.31102	3.0	3.9	30.8	11	-	2.6	0.4	0.20	●		
	0411-02	374160.41102	4.0	3.9	30.8	11	-	3.5	0.5	0.20	●		
	0420-02S	374160.42002	4.0	3.9	39.8	20	-	3.5	0.5	0.20	●		
	0511-02	374160.51102	5.0	3.9	30.8	11	-	4.5	0.7	0.20	●		
	0630-02	374160.63002	6.0	3.9	49.8	30	-	5.3	1	0.20	●	3.74160215	

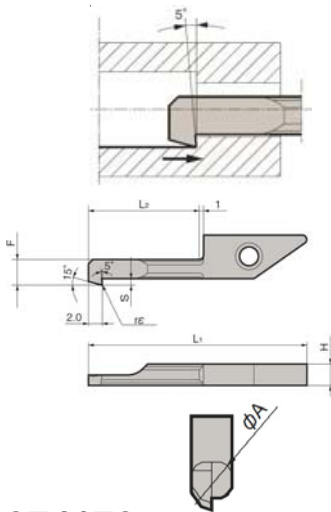


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Rückwärtsinnendrehen

Micro-alésage inverse

Backboring



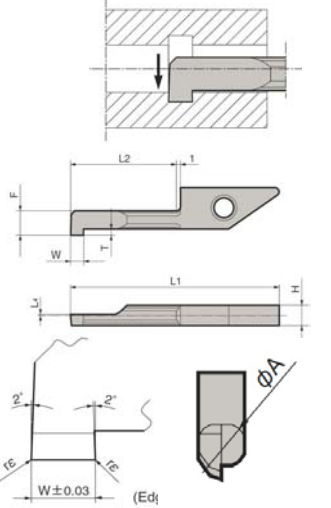
Beschreibung Désignation Description	Art.Nr./no.cde. order no	Dimension [mm]										Hartmetall/métal dur/ grades			
		Min.Dreh- ϕ ϕ min.tourn.											PVD-besch revêtue PVD	unbeschichtet pas revêtue	
		Min.bore ϕ ϕA [mm]	H	L1	L2	L3	F	S	re						
VNBTR	0411-003	374165.0411003	4.0	3.9	30.8	11	-	3.6	1.0	0.03				●	
	0420-003	374165.0420003	4.0	3.9	39.8	20	-	3.6	1.0	0.03				●	
	0511-003	374165.0511003	5.0	3.9	30.8	11	-	4.6	1.3	0.03				●	
	0520-003	374165.0520003	5.0	3.9	39.8	20	-	4.6	1.3	0.03				●	
	0411-01	374165.041101	4.0	3.9	30.8	11	-	3.6	1.0	0.1				●	
	0420-01	374165.042001	4.0	3.9	39.8	20	-	3.6	1.0	0.1				●	
	0511-01	374165.051101	5.0	3.9	30.8	11	-	4.6	1.3	0.1				●	
	0520-01	374165.052001	5.0	3.9	39.8	20	-	4.6	1.3	0.1				●	3.74165215

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Micro-Inneneinstechen

Micro rainurage interne

Micro internal grooving



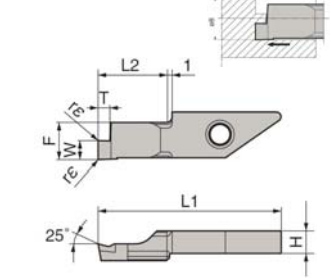
Beschreibung Désignation Description	Art.Nr./no.cde. order no	Dimension [mm]										Hartmetall/métal dur/ grades				
		Min.Dreh- ϕ ϕ min.tourn.											PVD-besch revêtue PVD	unbeschichtet pas revêtue		
		Min.bore ϕ ϕA [mm]	W	re	L2	L1	L4	F	T							
3.74170215															PR930	KW10
VNGR	0410-11	374170.041011	4.0	1.0	0.05	11	30.8	0.1	3.5	0.8				●	●	
	0420-11	374170.042011	4.0	2.0	0.10	11	30.8	0.1	3.5	0.8				●	●	
	0510-11	374170.051011	5.0	1.0	0.05	11	30.8	0.1	4.4	1.0				●	●	
	0520-11	374170.052011	5.0	2.0	0.10	11	30.8	0.1	4.4	1.0				●	●	
	0610-20	374170.061020	6.0	1.0	0.05	20	39.8	0.3	5.2	1.8				●	●	
	0620-20	374170.062020	6.0	2.0	0.10	20	39.8	0.3	5.2	1.8				●	●	
	0710-20	374170.071020	7.0	1.0	0.05	20	39.8	0.3	6.2	2.0				●	●	
	0720-20	374170.072020	7.0	2.0	0.10	20	39.8	0.3	6.2	2.0				●	●	

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Axial-Einstechen

p. gorges frontales

Face grooving



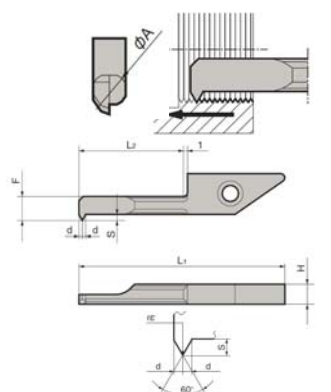
Beschreibung Désignation	order no	Dimension [mm]										Hartmetall/métal dur/ grades				
		Min.Dreh- ϕ ϕ min.tourn.											PVD-besch revêtue PVD	unbeschichtet pas revêtue		
		ϕA [mm]	W ± 0.03	re	H	L1	L2	F	T							
3.74175215															PR930	KW10
VNFGR	0810-10	374175.081010	8.0	∞	1.0	0.05	3.9	29.6	10	7.30	2.00				●	●
	0820-10	374175.082010	8.0	∞	2.0	0.05	3.9	29.6	10	7.30	2.00				●	●
	0830-10	374170.083010	8.0	∞	3.0	0.05	3.9	29.6	10	7.30	3.00				●	●

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Micro-innengewinde-drehen

Micro filletage intérieur

Face grooving



Beschreibung Désignation	Art.Nr./no.cde. order no	Dimension [mm]										Hartmetall/métal dur/ grades				
		Mn.Dreh- ϕ ϕ min.tourn.											PVD-besch revêtue PVD	unbeschichtet pas revêtue		
		ϕA [mm]	H	L1	L2	F	S	d	re							
3.74180215															PR930	KW10
VNTR	045-11	374180.04511	45	39	30.8	11	36	13	0.60	0.05					●	●
	060-11	374180.06011	60	39	30.8	11	46	16	0.80	0.05					●	●

Das System für hohe Bearbeitungsgenauigkeit
Sytem Tip Bar Kit 2
 zum Innendrehen, Rückwärts-Innendrehen, Stechen, Axialstechen & Gewindefschneiden

le système pour une grande précision de tournage
Le système Tip Bar Kit 2
 p. tournage intérieur, alésage inverse, rainurage, gorges frontals & micro filetage

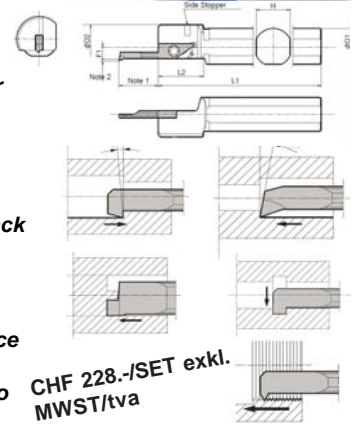
Tool system for a high precision in turning
The system Tip Bar Kit 2
 for internal turning, back-turning, internal grooving, face grooving & micro threading



- S16H-SVNR12N **Standardhalter rund mit Einspannflächen**
- VNBR0411-02PR930 **zum Innendrehen**
- VNBTR0411-01PR930 **zum Rückwärts-Innendrehen**
- VNGR0420-11PR930 **zum Micro Innen-Einstecken**
- VNFR0820-10PR930 **z. Axial-Einstecken**
- VNTR045-11PR930 **z. Micro-Innengewindedrehen**
- Hartmetallsorte PR930

- S16H-SVNR12N **porte-plaquette standard ronde** *plâtes pour le serrage*
- VNBR0411-02PR930 **p. tournage intérieur**
- VNBTR0411-01PR930 **p. alésage inverse**
- VNGR0420-11PR930 **p. micro rainurage interne**
- VNFR0820-10PR930 **p. gorges frontals**
- VNTR045-11PR930 **p. micro filletage intérieur**
- Nuance métal dur PR930

- S16H-SVNR12N **standard round tool-holder, flats for clamping**
- VNBR0411-02PR930 **for internal turning**
- VNBTR0411-01PR930 **for back turning**
- VNGR0420-11PR930 **for micro internal grooving**
- VNFR0820-10PR930 **for face grooving**
- VNTR045-11PR930 **for micro threading**
- Carbide grade PR930



Bestellnummer/ no.commande Tip Bar Set 2: 374100.100 228.-CHF/Set

System-Tip-Bar-Set 3 , D=16mm Halter, nur zum Innendrehen. bestehend aus:

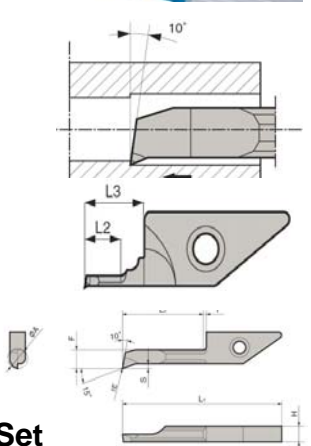
- Halter(16mm) S16H-SVNR12 N
- Ausdreheinsatz 1,0mm : VNBR0105-005S PR930
- Ausdreheinsatz 2,0mm : VNBR0206-02 PR930
- Ausdreheinsatz 3,0mm : VNBR0311-02 PR930
- Ausdreheinsatz 4,0mm : VNBR0411-02 PR930
- Ausdreheinsatz 5,0mm : VNBR0511-02 PR930

Système-Tip-Bar-Set 3 D=16mm porte outil, p. tournage intérieur existante de:

- Porte outil(16mm) S16H-SVNR12 N
- Barre 1,0mm : VNBR0105-005S PR930
- Barre 2,0mm : VNBR0206-02 PR930
- Barre 3,0mm : VNBR0311-02 PR930
- Barre 4,0mm : VNBR0411-02 PR930
- Barre 5,0mm : VNBR0511-02 PR930

System-Tip-Bar-Set 3 D=16mm tool holder, for internal turning, composed of:

- Bar holder(16mm) S16H-SVNR12 N
- Bar 1,0mm : VNBR0105-005S PR930
- Bar 2,0mm : VNBR0206-02 PR930
- Bar 3,0mm : VNBR0311-02 PR930
- Bar 4,0mm : VNBR0411-02 PR930
- Bar 5,0mm : VNBR0511-02 PR930



Bestellnummer/ no.commande Tip Bar Set 3: 374100.200 228.-CHF/Set

Empfohlenen Schnittdaten für VNB, VNB-NB, VNBTR

Vitesses de coupe et avances recommandées p. VNB, VNB-NB, VNBTR

Recommneded cutting conditions for VNB, VNB-NB, VNBTR

3.74160DrehenVNB_SW Material Werkstück matériel de la pièce Workpiece Material	Empfohlene Hartmetallsorten, nuances carbure recomm.,recomm.insert grades (Schnittgeschwindigkeit, vitesse de coupe, cutting Speed: m/min)							VNB02 Type		VNB03 Type		VNB04 VNB04 Type		VNB05 VNB06 VNB07 Type VNB05		Remarks
	Cermet	PVD Coated Carbide		Carbide	CBN	PCD		Cut: ap(mm), Feed: f(mm/rev)								
	TC60	PR915	PR930	KW10	KBN510	KPD001	KPD010	ap	f	ap	f	ap	f	ap	f	
Kohlenstoff-Stähle, legierte Stähle/aciers de construction,aciers alliés/ carbon steel / alloy Steel	☆	☆	★					~0.3	~0.03	~0.4	~0.04	~0.45	~0.07	~0.5	~0.1	Kühlmittel lubrication
INOX-Stähle, aciers inoxydables,Stainless Steel	☆	☆	★					~0.3	~0.02	~0.4	~0.03	~0.45	~0.05	~0.5	~0.07	
Nichtmetallische Werkstoffe, matériel non métalliques,non-ferrous metals				☆		★	☆	~0.3	~0.05	~0.4	~0.06	~0.45	~0.1	~0.5	~0.15	

*gei gnet /appr cpr i é/appropriate