

Technical information
Information technique
Technische Auskunft

M02

Applications
Applications
Anwendungen

M05

Boring heads
Têtes d'alésage
Bohrköpfe

M06

Arbors for boring heads
Attachements pour têtes d'alésage
Dorne für Bohrköpfe

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Kits
Ensembles
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Cutting data
Conditions de coupe
Schnittdaten

M14

Inserts

Turning

Automatic lathes

Ceramic tools

Parting & grooving

Threading

Drills

Cartridges

Brazed tools

Milling cutters

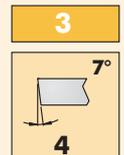
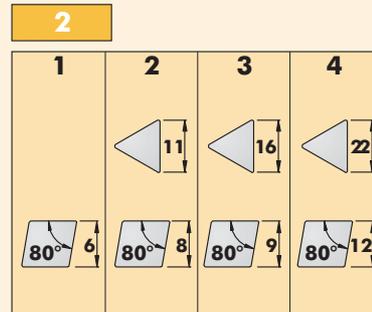
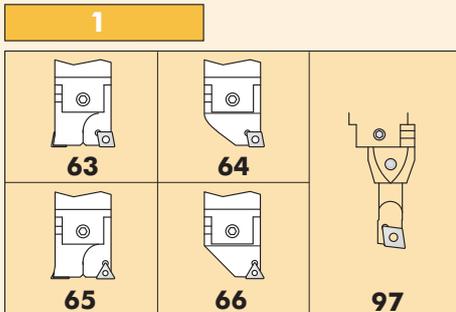
Solid carbide

Boring heads

Arbors & adaptors

Boring heads

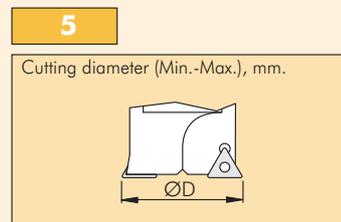
6	3	4	4	76	100125
1	2	3	4	5	



4

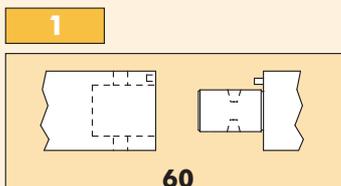
Diameter d, mm.

70	12	74	28
71	15	75	36
72	20	76	50
73	24	77	60



Arbors for Boring heads

60	43	70	35
1	2	3	4



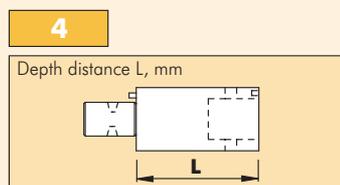
2

	ISO	DIN 2080	ISO 7388	DIN 69871 A
Ø16 Ø22 Ø27 Ø32 Ø40	ISO 30	ISO 40	ISO 50	7388 40 7388 50
16 22 27 32 40	43	44	45	47 48
ISO	BT System			
BT 40	BT 50	Ø25	Ø32	Ø40
49	50	62	63	64
		Ø22	Ø27	Ø32
		70	71	72
				73

3

Diameter d, mm

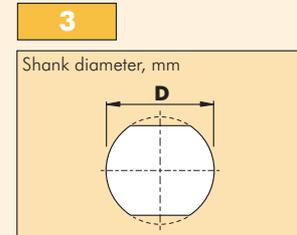
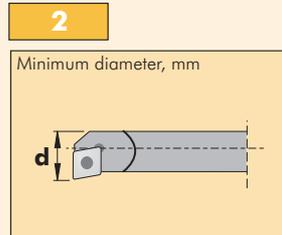
70	12	74	28
71	15	75	36
72	20	76	50
73	24	77	60

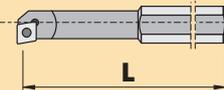


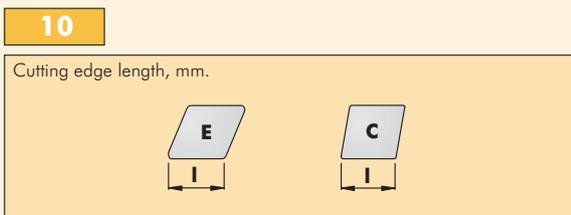
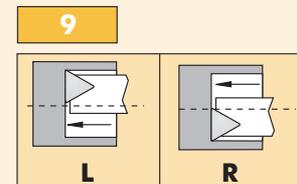
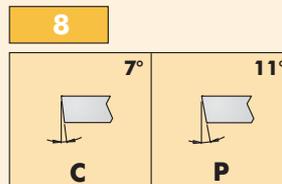
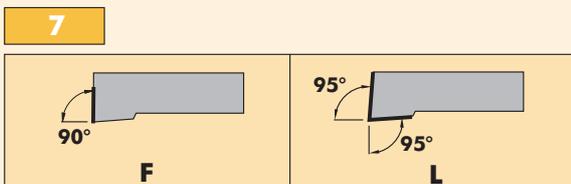
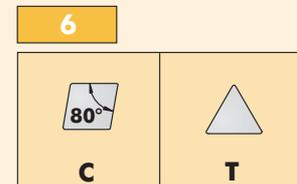
Tools for Boring heads

S	08	16	F	S	C	L	C	R	06
1	2	3	4	5	6	7	8	9	10

1
Type of bar
A Steel shank with coolant hole
H Heavy metal
J Heavy metal with coolant hole
S Steel shank



4
Bar length, mm

E 70 I 110
F 80 J 115
G 90 X Special
H 100



Inserts

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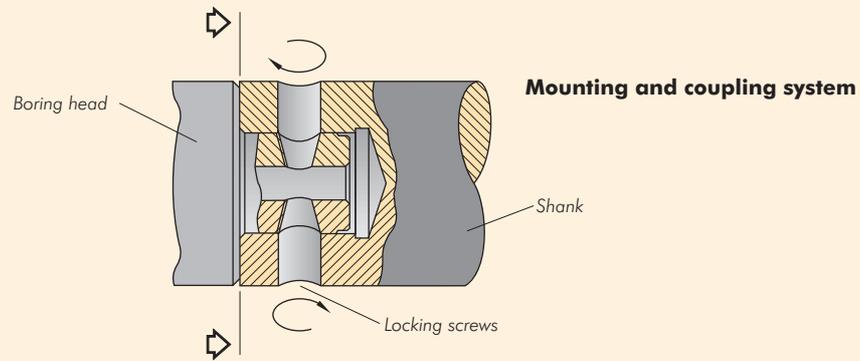
Boring heads

The boring heads are made of Nickel-Chrome alloy steel, with a core toughness of 113,786 to 128,000 lbs/in².

All the component parts of the head are heat treated to prolong life and minimise wear on moving parts.

The slides are precision ground and close tolerances are maintained in order that the heads provide and maintain accuracy of adjustment throughout their working life.

The micrometer adjusting screw of the "finishing heads" has a ground precision thread.



Adjustable boring bar - -

<p>611 Adjustable boring bar</p>  <p>CC.. 0602.. TC.. 1102.. TC.. 16T3..</p> <p>Page M.08</p>					
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Special boring heads - -

<p>433 Special boring head</p>  <p>Page M.07</p>	<p>434 Special boring head</p>  <p>Page M.07</p>				
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Boring heads - -

<p>97.71 Boring head</p>  <p>Page M.06</p>	<p>SCLC Tools for boring heads</p>  <p>Page M.06</p>	<p>STFC Tools for boring heads</p>  <p>Page M.06</p>			
<p>63 1/4.74 Roughing boring heads</p>  <p>Page M.08</p>	<p>6344.75 Roughing boring heads</p>  <p>Page M.08</p>	<p>64 1/4.74 Roughing boring heads</p>  <p>Page M.09</p>	<p>6444.75 Finishing boring heads</p>  <p>Page M.09</p>	<p>6634.74 Finishing boring heads</p>  <p>Page M.09</p>	<p>6634.75 Finishing boring heads</p>  <p>Page M.10</p>

Arbors for boring heads - -

<p>60.16 DIN 2080 Arbors for boring heads</p>  <p>Page M.11</p>	<p>60.43 DIN 2080 Arbors for boring heads</p>  <p>Page M.11</p>	<p>60.47 DIN 69871/A Arbors for boring heads</p>  <p>Page M.11</p>	<p>60.49 MAS BT Arbors for boring heads</p>  <p>Page M.11</p>	<p>60.62 Arbors for boring heads</p>  <p>Page M.12</p>	<p>60.70 Arbors for boring heads</p>  <p>Page M.12</p>
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Kits - Ensembles - Sätze

<p>KIT 97</p>  <p>Page M.13</p>	<p>KIT 7072</p>  <p>Page M.13</p>	<p>KIT 7074</p>  <p>Page M.13</p>			
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Inserts

Turning

Automatic lathes

Ceramic tools

Parting & grooving

Threading

Drills

Cartridges

Brazed tools

Milling cutters

Solid carbide

Boring heads

Arbors & adaptors



Inserts

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Solid carbide

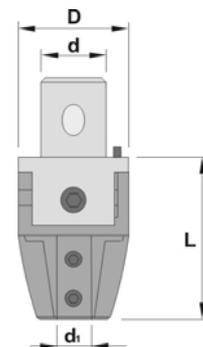
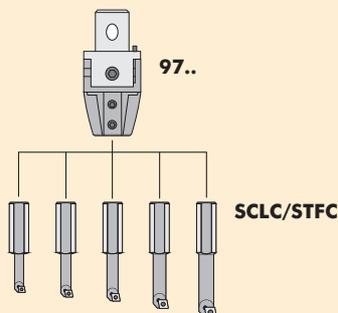
Boring heads

Arbors & adaptors

97. ⁷¹/₇₃



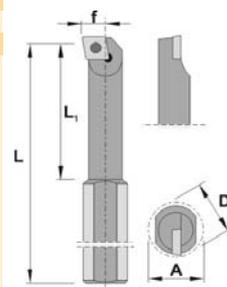
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97.71.08	27	50	15	8	10	21	101	505	504	503	158
97.72.08	32	58	20	8	10	21	101	505	504	503	158
97.72.10	32	58	20	10	13	25	101	505	504	503	158
97.73.10	42	70	24	10	13	29	101	505	504	503	158
97.73.12	42	70	24	12	16	34	101	505	504	503	158
97.73.16	42	70	24	16	20	38	101	505	504	503	158



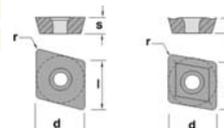
SCLC



REF.	D	L	L1	f	Bore Range MIN MAX	CC..		
S0816F SCLC R 06	16	80	35	4	10 28	0602..	155	507
S1016G SCLC R 06	16	90	45	6	13 31	0602..	155	507
S1216H SCLC R 06	16	100	57	7	16 34	0602..	155	507
S1616I SCLC R 09	16	110	73	9	20 38	09T3..	138	515



REF.	l	s	d
CC.. 0602..	6,45	2,38	6,35
CC.. 09T3..	9,65	3,97	9,52

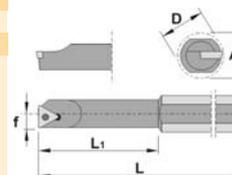


For more information see page: A.38

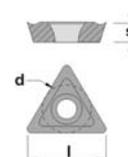
STFC



REF.	D	L	L1	f	Bore Range MIN MAX	TC..		
S0816F STFC R 09	16	80	35	5	10 28	0902..	122	506
S1016G STFC R 09	16	90	45	6	13 31	0902..	122	506
S1216H STFC R 09	16	100	57	7	16 34	0902..	122	506
S1616I STFC R 09	16	110	73	9	20 38	0902..	122	506
S1616I STFC R 16	16	110	73	11	20 38	16T3..	155	515



REF.	l	s	d
TC.. 0602..	9,62	2,38	5,55
TC.. 16T3..	16,50	3,97	9,52

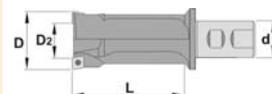


For more information see page: A.51,52

433



REF.	Z	D	D ₂	d	L	CC..		
433.040	3	40	20	25	105	09T3..	140	535
433.045	3	45	25	25	105	09T3..	140	535
433.050	3	50	30	25	105	09T3..	140	535
433.055	3	55	35	25	105	09T3..	140	535



Inserts

Turning

Automatic lathes

Ceramic tools

Parting & grooving

Threading

Drills

Cartridges

Brazed tools

Milling cutters

Solid carbide

Boring heads

Arbors & adaptors

M07



REF.	l	s	d
CC.. 09T3..	9,65	3,97	9,52

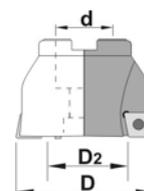


For more information see page: A.38

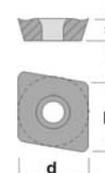
434



REF.	Z	D	D ₂	d	CC..		
434.060	3	60	40	16	09T3..	140	535
434.065	3	65	45	22	09T3..	140	535
434.070	3	70	50	22	09T3..	140	535
434.075	3	75	55	27	1204..	150	522
434.080	3	80	60	27	1204..	150	522
434.085	3	85	65	32	1204..	150	522
434.090	3	90	70	32	1204..	150	522
434.095	3	95	75	32	1204..	150	522
434.100	3	100	80	32	1204..	150	522
434.105	3	105	85	40	1204..	150	522
434.110	3	110	90	40	1204..	150	522
434.115	3	115	95	40	1204..	150	522
434.120	3	120	100	40	1204..	150	522
434.125	3	125	105	40	1204..	150	522
434.130	3	130	110	40	1204..	150	522
434.135	3	135	115	40	1204..	150	522
434.140	3	140	120	40	1204..	150	522
434.145	3	145	125	40	1204..	150	522
434.150	3	150	130	40	1204..	150	522
434.155	3	155	135	40	1204..	150	522



REF.	l	s	d
CC.. 09T3..	9,65	3,97	9,52
CC.. 1204..	12,90	4,76	12,70



For more information see page: A.38

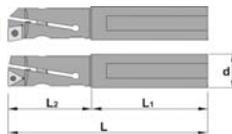


- Inserts
- Turning
- Automatic lathes
- Ceramic tools
- Parting & grooving
- Threading
- Drills
- Cartridges
- Brazed tools
- Milling cutters
- Solid carbide
- Boring heads
- Arbors & adaptors

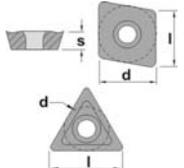
661



REF.	L	L1	L2	d	Ø MIN	Ø MAX	CC../TC..							
661.2430	105	70	35	12	12	15	CC.. 0602..	159	153	155	-	545	520	507
661.2940	110	60	50	16	15	20	CC.. 0602..	481	154	155	-	502	552	507
661.3950	120	60	60	20	20	25	TC.. 1102..	478	157	125	157	525	552	507
661.4965	140	70	70	25	25	30	TC.. 16T3..	478	437	140	437	525	552	515
661.6382	160	70	90	25	30	35	TC.. 16T3..	478	437	140	437	525	552	515



REF.	l	s	d
CC.. 0602..	6,45	2,38	6,35
TC.. 1102..	11,00	2,38	6,35
TC.. 16T3..	16,50	3,97	9,52

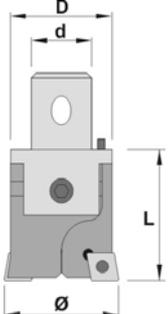


For more information see page: A.38,51,52

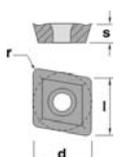
63.14.70⁷⁴



REF.	D	L	d	Ø MIN	Ø MAX	CC..				
6314.70.2430	22	34	12	24	30	0602..	155	517	503	502
6334.71.2940	27	42	15	29	40	09T3..	140	535	504	502
6334.72.3950	32	45	20	39	50	09T3..	140	535	504	525
6344.73.4965	42	56	24	49	65	1204..	150	522	505	503
6344.74.6382	54	56	28	63	82	1204..	150	522	506	503




REF.	l	s	d
CC.. 0602..	6,45	2,38	6,35
CC.. 09T3..	9,65	3,97	9,52
CC.. 1204..	12,90	4,76	12,70

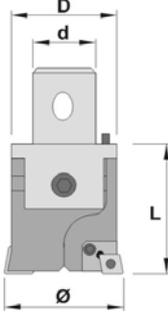


For more information see page: A.38

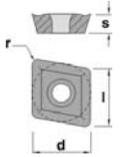
6344.75⁷⁷



REF.	D	L	d	Ø MIN	Ø MAX	CC..					
6344.75.080102	68	86	36	80	102	1204..	150	522	508	504	641
6344.76.100125	85	100	50	100	125	1204..	150	522	508	505	641
6344.77.125160	110	100	60	125	160	1204..	150	522	508	505	641
6344.77.160220	145	100	60	160	220	1204..	150	522	508	505	641




REF.	l	s	d
CC.. 1204..	12,90	4,76	12,70

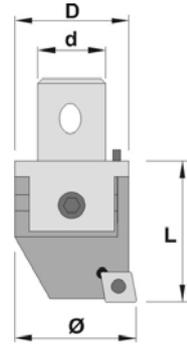


For more information see page: A.38

64¹⁴4⁷⁰₇₄



REF.	D	L	d	Ø MIN	Ø MAX	CC..				
6414.70.2430	22	34	12	24	30	0602..	155	517	503	502
6434.71.2940	27	42	15	29	40	09T3..	140	535	504	502
6434.72.3950	32	45	20	39	50	09T3..	140	535	504	525
6444.73.4965	42	56	24	49	65	1204..	150	522	505	503
6444.74.6382	54	56	28	63	82	1204..	150	522	506	503



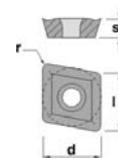
Inserts

Turning

Automatic lathes

Ceramic tools

REF.	l	s	d
CC.. 0602..	6,45	2,38	6,35
CC.. 09T3..	9,65	3,97	9,52
CC.. 1204..	12,90	4,76	12,70

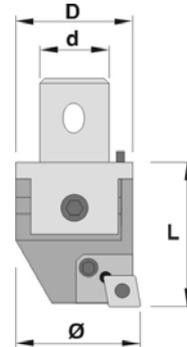


For more information see page: A.38

6444⁷⁵₇₇



REF.	D	L	d	Ø MIN	Ø MAX	CC..					
6444.75.080102	68	86	36	80	102	1204..	150	522	508	504	641
6444.76.100125	85	100	50	100	125	1204..	150	522	508	505	641
6444.77.125160	110	100	60	125	160	1204..	150	522	508	505	641
6444.77.160220	145	100	60	160	220	1204..	150	522	508	505	641

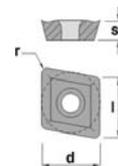


Parting & grooving

Threading

Drills

REF.	l	s	d
CC.. 1204..	12,90	4,76	12,70



For more information see page: A.38

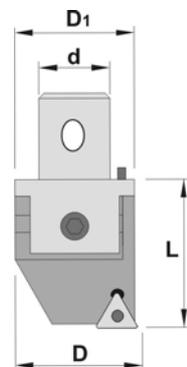
Cartridges

Brazed tools

6634⁷²₇₄



REF.	D1	L	d	Ø MIN	Ø MAX	TC..				
6634.72.3950	32	45	20	39	50	16T3..	140	535	504	525
6634.73.4965	42	56	24	49	65	16T3..	150	522	505	503
6634.74.6382	54	66	28	63	82	16T3..	150	522	526	503

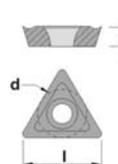


Milling cutters

Solid carbide

Boring heads

REF.	l	s	d
TC.. 16T3..	16,50	3,97	9,52



For more information see page: A.51,52

Arbors & adaptors

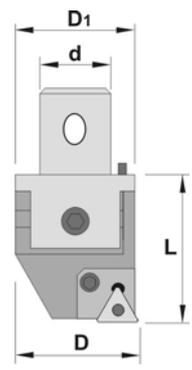


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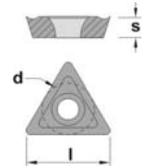
6634.⁷⁵/₇₇



REF.	D1	L	d	Ø MIN	Ø MAX	TC..					
6634.75.080102	68	86	36	80	102	16T3..	150	522	508	504	641
6634.76.100125	85	100	50	100	125	16T3..	150	522	508	505	641
6634.77.125160	110	100	60	125	160	16T3..	150	522	508	505	641
6634.77.160220	145	100	60	160	220	16T3..	150	522	508	505	641



REF.	l	s	d
TC.. 16T3..	16,50	3,97	9,52

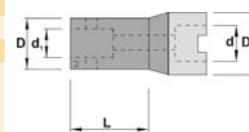


For more information see page: A.51,52

60.¹⁶₄₀



REF.	D	D1	L	d1	d
60.16.70	22	32	90	12	16
60.16.71	27	32	90	15	16
60.22.72	32	40	90	20	22
60.22.73	42	40	130	24	22
60.27.74	54	48	120	28	27
60.32.75	68	58	130	36	32
60.40.76	85	70	120	50	40



Inserts

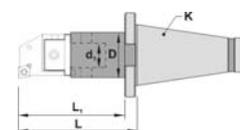
Turning

Automatic lathes

60.⁴³₄₅



REF.	K	D	L	L1	d1
60.43.70.100	30	22	115	100	12
60.43.71.100	30	27	115	100	15
60.43.72.100	30	32	115	100	20
60.44.70.100	40	22	115	100	12
60.44.71.100	40	27	115	100	15
60.44.72.100	40	32	115	100	20
60.44.73.160	40	42	175	160	24
60.44.74.160	40	54	175	160	28
60.44.75.160	50	68	176	160	36
60.45.70.100	50	22	119	100	12
60.45.71.100	50	27	119	100	15
60.45.72.130	50	32	149	130	20
60.45.73.160	50	42	179	160	24
60.45.74.160	50	54	179	160	28
60.45.75.200	50	68	220	200	36
60.45.76.200	50	85	221	200	50
60.45.77.260	50	100	281	260	60



Ceramic tools

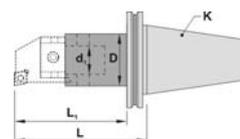
Parting & grooving

Threading

60.⁴⁷₄₈



REF.	K	D	L	L1	d1
60.47.70.100	40	22	115	100	12
60.47.71.100	40	27	115	100	15
60.47.72.100	40	32	115	100	20
60.47.73.160	40	42	175	160	24
60.47.74.160	40	54	175	160	28
60.47.75.160	40	68	176	160	36
60.48.70.100	50	22	119	100	12
60.48.71.100	50	27	119	100	15
60.48.72.130	50	32	149	130	20
60.48.73.160	50	42	179	160	24
60.48.74.160	50	54	179	160	28
60.48.75.200	50	68	220	200	36
60.48.76.200	50	85	221	200	50
60.48.77.260	50	100	281	260	60



Drills

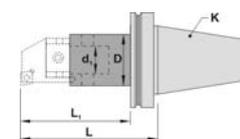
Cartridges

Brazed tools

60.⁴⁹₅₀



REF.	K	K1	L	L1	d1
60.49.70.100	40	22	115	100	12
60.49.71.100	40	27	115	100	15
60.49.72.100	40	32	115	100	20
60.49.73.160	40	42	175	160	24
60.49.74.160	40	54	175	160	28
60.49.75.160	40	68	176	160	36
60.50.70.100	50	22	119	100	12
60.50.71.100	50	27	119	100	15
60.50.72.130	50	32	149	130	20
60.50.73.160	50	42	179	160	24
60.50.74.160	50	54	179	160	28
60.50.75.200	50	68	220	200	36
60.50.76.200	50	85	221	200	50
60.50.77.260	50	100	281	260	60



Milling cutters

Solid carbide

Boring heads

Arbors & adaptors



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Arbors & adaptors

60.⁶²/₆₄



REF.	D	d	L	d1
60.62.70	22	20	20	12
60.62.71	27	20	30	15
60.63.70	22	20	30	12
60.63.71	27	20	45	15
60.63.72	32	25	35	20
60.64.70	22	20	52	12
60.64.71	27	20	52	15
60.64.72	32	20	52	20
60.64.73	42	25	60	24



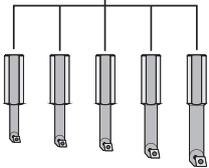
60.⁷⁰/₇₃



REF.	D	d	L	d1
60.70.70.20	22	12	20	12
60.70.70.30	22	12	30	12
60.71.71.30	27	15	30	15
60.71.71.45	27	15	45	15
60.72.72.35	32	20	35	20
60.72.72.52	32	20	52	20
60.73.73.40	42	24	40	24
60.73.73.60	42	24	60	24

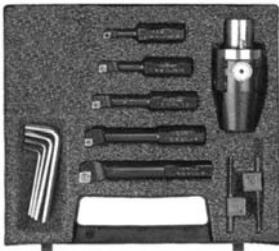


KIT 97



REF.	Boring head	Boring bars	Bore Range	
			MIN	MAX
97.SCLC	97.73.16	S0816F SCLC R 06	10	28
		S1016G SCLC R 06	13	31
		S1216H SCLC R 06	16	34
		S1616I SCLC R 09	20	38
97.STFC	97.73.16	S0816F STFC R 09	10	28
		S1016G STFC R 09	13	31
		S1216H STFC R 09	16	34
		S1616I STFC R 09	20	38
		S1616I STFC R 16	20	38

KIT 7072



REF.	Roughing boring head	Finishing boring head	Boring head	Boring bars	Bore Range	
					MIN	MAX
SET 7072	6314.70.2430	6414.70.2430	97.73.16	S0816F SCLC R 06	10	28
	6334.71.2940	6434.71.2940		S1016G SCLC R 06	13	31
	6334.72.3950	6434.72.3950		S1216H SCLC R 06	16	34
				S1616I SCLC R 09	20	38

KIT 7074



REF.	Roughing boring head	Finishing boring head	Boring head	Boring bars	Bore Range	
					MIN	MAX
SET 7074	6314.70.2430	6414.70.2430	97.73.16	S0816F SCLC R 06	10	28
	6334.71.2940	6434.71.2940		S1016G SCLC R 06	13	31
	6334.72.3950	6434.72.3950		S1216H SCLC R 06	16	34
	6344.73.4965	6444.73.4965				
	6344.74.6382	6444.74.6382		S1616I SCLC R 09	20	38

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Cutting data for boring heads

Material	Head size	Diameter	Finishing heads			Roughing heads		
			Cutting Speed	Feed	Cutting Depth	Cutting Speed	Feed	Cutting Depth (max)
Plain carbon steel	22	24 ÷ 30	110 - 140	0,05 - 0,15	0,05 - 0,30	100 - 130	0,15 - 0,25	4,2
	27	29 ÷ 40	115 - 150	0,05 - 0,15	0,05 - 0,30	105 - 140	0,15 - 0,30	5,7
	32	39 ÷ 50	115 - 150	0,05 - 0,15	0,06 - 0,35	105 - 150	0,20 - 0,30	5,7
	42 - 54 - 68	49 ÷ 102	115 - 150	0,10 - 0,20	0,06 - 0,35	105 - 150	0,25 - 0,35	6,3
	85 - 110 - 145	100 ÷ 220	115 - 150	0,10 - 0,20	0,07 - 0,50	105 - 150	0,30 - 0,40	6,3
Alloy steels	22	24 ÷ 30	100 - 130	0,05 - 0,15	0,05 - 0,30	90 - 120	0,15 - 0,25	4,2
	27	29 ÷ 40	110 - 140	0,05 - 0,15	0,05 - 0,30	100 - 130	0,15 - 0,30	5,7
	32	39 ÷ 50	110 - 150	0,05 - 0,15	0,06 - 0,35	100 - 130	0,20 - 0,30	5,7
	42 - 54 - 68	49 ÷ 102	110 - 150	0,10 - 0,20	0,06 - 0,35	100 - 130	0,25 - 0,35	6,3
	85 - 110 - 145	100 ÷ 220	110 - 150	0,10 - 0,20	0,07 - 0,50	100 - 130	0,30 - 0,40	6,3
Stainless steels	22	24 ÷ 30	70 - 100	0,07 - 0,15	0,12 - 0,35	60 - 90	0,12 - 0,20	4,2
	27	29 ÷ 40	80 - 110	0,07 - 0,15	0,12 - 0,35	70 - 100	0,15 - 0,25	5,7
	32	39 ÷ 50	80 - 110	0,07 - 0,15	0,20 - 0,50	70 - 100	0,15 - 0,25	5,7
	42 - 54 - 68	49 ÷ 102	80 - 110	0,10 - 0,20	0,20 - 0,50	70 - 100	0,20 - 0,30	6,3
	85 - 110 - 145	100 ÷ 220	80 - 110	0,12 - 0,20	0,25 - 0,75	70 - 100	0,25 - 0,35	6,3
Cast iron	22	24 ÷ 30	70 - 110	0,07 - 0,15	0,12 - 0,35	60 - 110	0,20 - 0,30	4,2
	27	29 ÷ 40	80 - 115	0,07 - 0,15	0,12 - 0,35	60 - 110	0,25 - 0,35	5,7
	32	39 ÷ 50	80 - 115	0,07 - 0,15	0,20 - 0,50	60 - 110	0,25 - 0,35	5,7
	42 - 54 - 68	49 ÷ 102	80 - 115	0,12 - 0,20	0,20 - 0,50	60 - 110	0,30 - 0,45	6,3
	85 - 110 - 145	100 ÷ 220	80 - 115	0,12 - 0,20	0,25 - 0,75	60 - 110	0,30 - 0,45	6,3
Aluminium and aluminium alloys	22	24 ÷ 30	150 - 300	0,05 - 0,15	0,12 - 0,35	120 - 300	0,20 - 0,30	4,2
	27	29 ÷ 40	150 - 360	0,10 - 0,20	0,12 - 0,35	150 - 370	0,25 - 0,35	5,7
	32	39 ÷ 50	150 - 360	0,10 - 0,20	0,20 - 0,50	150 - 370	0,25 - 0,35	5,7
	42 - 54 - 68	49 ÷ 102	150 - 360	0,10 - 0,20	0,20 - 0,50	150 - 370	0,30 - 0,45	6,3
	85 - 110 - 145	100 ÷ 220	150 - 360	0,10 - 0,25	0,25 - 0,75	150 - 370	0,30 - 0,45	6,3
Titanium	22	24 ÷ 30	30 - 40	0,07 - 0,15	0,12 - 0,35	25 - 35	0,12 - 0,20	4,2
	27	29 ÷ 40	30 - 45	0,07 - 0,15	0,12 - 0,35	30 - 40	0,15 - 0,25	5,7
	32	39 ÷ 50	30 - 45	0,07 - 0,15	0,20 - 0,50	30 - 40	0,15 - 0,25	5,7
	42 - 54 - 68	49 ÷ 102	30 - 45	0,10 - 0,20	0,20 - 0,50	30 - 40	0,20 - 0,30	6,3
	85 - 110 - 145	100 ÷ 220	30 - 45	0,10 - 0,20	0,25 - 0,75	30 - 40	0,20 - 0,35	6,3
High tempered alloys	22	24 ÷ 30	30 - 40	0,07 - 0,15	0,12 - 0,35	25 - 35	0,12 - 0,20	4,2
	27	29 ÷ 40	30 - 45	0,07 - 0,15	0,12 - 0,35	30 - 40	0,15 - 0,25	5,7
	32	39 ÷ 50	30 - 45	0,07 - 0,15	0,20 - 0,50	30 - 40	0,15 - 0,25	5,7
	42 - 54 - 68	49 ÷ 102	30 - 45	0,10 - 0,20	0,20 - 0,50	30 - 40	0,20 - 0,30	6,3
	85 - 110 - 145	100 ÷ 220	30 - 45	0,10 - 0,20	0,25 - 0,75	30 - 40	0,20 - 0,35	6,3

