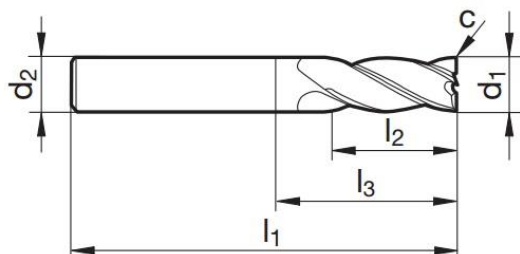


NOVO U PONUDI !!!

Predstavljamo **MIKRA Plus HPC** tvrdometalna glodala iznimne kvalitete, za univerzalnu upotrebu, proizvedena u Njemačkoj. Odlike glodala su visoka učinkovitost, varijabilni kut spirale, TiAlN nano presvlaka, centralno rezanje, obrada materijala do 54 HRC.



P	●
M	●
K	●
N	○
S	●
H	○



d1 e8 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm	c mm x 45°	z	Broj za narudžbu	Cijena (bez PDV-a) KN/kom
3	6	57	8	11,4	0,06	4	19981.3,000	93,96
4	6	57	11	14,9	0,08	4	19981.4,000	93,96
5	6	57	13	17,4	0,10	4	19981.5,000	113,68
6	6	57	13	21	0,12	4	19981.6,000	113,68
8	8	63	19	27	0,16	4	19981.8,000	125,28
10	10	72	22	32	0,20	4	19981.10,000	189,08
12	12	83	26	38	0,24	4	19981.12,000	237,80
16	16	92	32	44	0,32	4	19981.16,000	412,96
20	20	104	38	54	0,40	4	19981.20,000	635,68

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HPC

54HRC



a_e = 0,5-1,0 x D



a_p = 1 x D

Cutter-Ø mm	Feed column no.															
	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52
	f _z (mm/tooth)															
2,00	0,001	0,001	0,001	0,002	0,002	0,004	0,005	0,006	0,007	0,008	0,010	0,012	0,014	0,016	0,018	0,020
3,00	0,002	0,002	0,003	0,003	0,004	0,007	0,010	0,010	0,010	0,015	0,016	0,013	0,019	0,022	0,024	0,030
5,00	0,005	0,006	0,007	0,009	0,010	0,014	0,020	0,020	0,022	0,025	0,026	0,026	0,028	0,030	0,032	0,038
6,00	0,006	0,008	0,009	0,011	0,013	0,017	0,024	0,025	0,027	0,031	0,029	0,033	0,039	0,036	0,041	0,047
8,00	0,010	0,012	0,014	0,016	0,019	0,024	0,032	0,032	0,035	0,042	0,042	0,047	0,053	0,052	0,058	0,064
10,00	0,013	0,015	0,018	0,021	0,025	0,030	0,038	0,039	0,044	0,050	0,053	0,059	0,065	0,066	0,073	0,080
12,00	0,010	0,018	0,022	0,026	0,030	0,036	0,046	0,048	0,052	0,059	0,063	0,072	0,079	0,085	0,090	0,100
16,00	0,020	0,023	0,027	0,032	0,038	0,045	0,054	0,058	0,063	0,071	0,079	0,088	0,095	0,100	0,110	0,120
20,00	0,023	0,028	0,033	0,038	0,045	0,057	0,066	0,073	0,080	0,090	0,097	0,100	0,110	0,120	0,130	0,140
25,00	0,030	0,035	0,040	0,045	0,055	0,065	0,075	0,100	0,120	0,130	0,140	0,150	0,165	0,170	0,180	0,190

Material group	Material examples Figures in bold = material no. to DIN EN 10 027	Tensile strength MPa (N/mm ²)	Hardness	V _c m/min	Feed col. no.
Common structural steels	1.0035 S185(S133), 1.0486 P275N(StE285), 1.0345 P235G H(M1), 1.0425 P265G H(M2) 1.0050 E295 (S150-2), 1.0070 E360 (S170-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		170 - 208 157 - 193	51 50
Free-cutting steels	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		170 - 208 126 - 154	50 49
Unalloyed heat-treatable steels	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		170 - 208 151 - 185 126 - 154	50 50 49
Alloyed heat-treatable steels	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤400		151 - 185 126 - 154	49 48
Unalloyed case hard. steels	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		189 - 231	50
Alloyed case hardened steels	1.7276 10CrMo11, 1.5125 11MnSi6 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1000 ≤400		151 - 185 113 - 139	50 49
Nitriding steels	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlN7	≤1000 ≤400		170 - 208 151 - 185	50 48
Tool steels	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤400		151 - 185 126 - 154	50 48
High speed steels	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤400		94 - 116	49
Spring steels	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	94 - 116	48
Hardened steels	-		≤48 HRC ≤66 HRC	44 - 54	46
Stainless steels, sulphured austenitic martensitic	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9 1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi17-12-2 (V4A) 1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤900 ≤100 ≤500		80 - 100 70 - 90 65 - 70	49 48 49
Cast iron	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤40 HB ≤350 HB	220 - 270 201 - 247	50 49
Spheroidal graphite iron and malleable cast iron	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35) 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤40 HB ≤350 HB	182 - 224 157 - 193	50 49
Chilled cast iron	-		≤350 HB	107 - 131	47
New cast materials GG V	EN-GJV250 (GGV25), EN-GJV350 (GGV35) EN-GJV400 (GGV40), EN-GJV500 (GGV50), SIMO 6		≤220 HB ≤300 HB		
New cast materials ADI	EN-GJS-800-8 (ADI800), EN-GJS-1000-5 (ADI1000) EN-GJS-1200-2 (ADI1200), EN-GJS-1400-1 (ADI1400)	≤1000 ≤400			
Special alloys	Nimonic, Inconel, Monel, Hastelloy	≤2000		56 - 70	48
Ti and Ti-alloys	3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤850 ≤400		54 - 86 44 - 72	43 42
Aluminium and Al-alloys	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400			
Al wrought alloys	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650			
Al cast alloys ≤10 % Si ≤ 2% S	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9 3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600 ≤600			
Magnesium alloys	3.5200 MgMn2, 3.5812.05 G-MgAlZn1, 3.5612.05 G-MgAl6Zn1	≤400			
Copper, low-alloyed	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500			
Brass, short-chipping long-chipping	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600 ≤600			
Bronze, short-chipping	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 ≤850			
Bronze, long-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl1Ni, 2.1247 CuBe2	≤850 ≤1000			
Duroplastics	Epoxy resin, Resopal, Pertinax, Molltopen	≤50			
Thermoplastics	Plexiglass, Hostalen, Novodur, Makralon	≤100			
Kevlar	Kevlar	≤1000			
Glass, carbon concentr. plastics	GFK/CFK	≤1000			

Corrections V_c and f_z a_e = 1,5 x D = 50% a_p = 0,25 x D = 150%