®PRESTO

# Indexable Drills
# Wendeplatten-Vollbohrer

## 2xD
## 3xD
## 4xD

PRESTO®
International UK LTD
Quality Since 1843

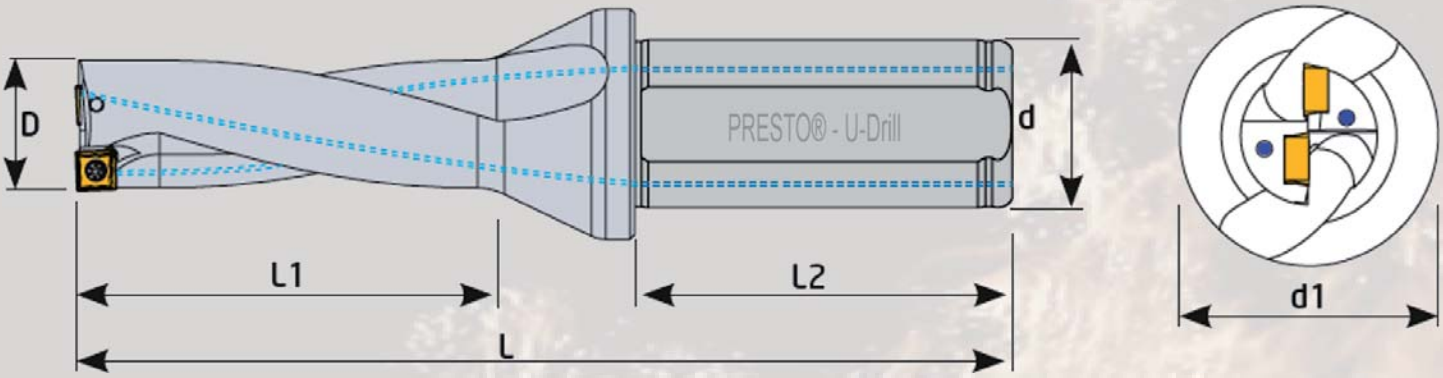
180 Jahre Erfahrung

# Wendeschneidplattenbohrer - wenn Zuverlässigkeit und Wirtschaftlichkeit Ihr Hauptanliegen sind: PRESTO® U-DRILL

Ihre erste Wahl für Bohrbearbeitungen 2xD - 3xD - 4xD

Hohe Produktivität

Sichere & zuverlässige Bohrprozesse




## Wendeschneidplatten

**SPMG-GP**
Für allgemeine Bohrbearbeitungen in Stahl, Edelstahl, Gusseisen, Exotics

**SPMG-AL**
Für allgemeine Bohrbearbeitungen in Aluminium, -Legierungen
Bedingt einsetzbar in Stahl, Edelstahl, Stahlguss

## Lieferbare Grössen

| | |
|---|---|
| SPMG | 050204 für Bohrdurchmesser 12,5 - 15,5 mm |
| | 060204 für Bohrdurchmesser 16,0 - 21,5 mm |
| | 07T308 für Bohrdurchmesser 22,0 - 27,0 mm |
| | 090408 für Bohrdurchmesser 27,5 - 33,0 mm |
| | 110408 für Bohrdurchmesser 34,0 - 41,0 mm |
| | 140512 für Bohrdurchmesser 42,0 - 50,0 mm |

# 2xD Serie 82017

# 3xD Serie 83017

# 4xD Serie 84017

## Generelle Einsatzhinweise / Grundvorraussetzungen

**Empfohlener Kühlmitteldruck ab 7,5 bar**

**bei Startbohrung muss der Vorschub um 30% reduziert werden**

## Schnittdaten für U-Drill Wendeplatten-Vollbohrer*

| ISO-Gruppe | Material | Härte HB | Schnitt-geschwindigkeit Vc (m/min) | Vorschub (mm/rev) Ø 12-16 | Ø 16,5-23 | Ø 23,5-29 | Ø 29,5-42 | Ø 43-50 |
|---|---|---|---|---|---|---|---|---|
| P | C-Stahl <0,15-0,45%C | 80-180 | 190 (130-250) | 0,04 - 0,08 | 0,04 - 0,08 | 0,04 - 0,08 | 0,04 - 0,08 | 0,04-0,08 |
| | C-Stahl >=0,45%C | 180-280 | 140 (80-200) | 0,04 - 0,10 | 0,04 - 0,12 | 0,05 - 0,16 | 0,08 - 0,18 | 0,10 - 0,22 |
| | Niedr. legierter Stahl | 140-260 | 130 (70-200) | 0,04 - 0,10 | 0,06 - 0,12 | 0,08 - 0,16 | 0,08 - 0,20 | 0,08 - 0,24 |
| | Niedr. legierter Stahl | 50-260 | 100 (50-160) | 0,04 - 0,18 | 0,06 - 0,12 | 0,08 - 0,16 | 0,08 - 0,18 | 0,08 - 0,22 |
| | Niedr. Vorge-härteter Stahl | 200-400 | 100 (50-150) | 0,04 - 0,10 | 0,06 - 0,12 | 0,08 - 0,16 | 0,08 - 0,18 | 0,08 - 0,22 |
| | Hoch Vorge-härteter Stahl | 220-450 | 70 (30-120) | 0,04 - 0,12 | 0,06 - 0,14 | 0,08 - 0,17 | 0,08 - 0,17 | 0,08 - 0,20 |
| M | austenitisch rostfrei | 135-275 Ni>8% | 90 (40-150) | 0,04 - 0,10 | 0,06 - 0,12 | 0,06 - 0,14 | 0,06 - 0,16 | 0,06 - 0,20 |
| | Feritisch / Martensitisch | 135-275 | 100 (60-160) | 0,04 - 0,10 | 0,04 - 0,12 | 0,06 - 0,14 | 0,06 - 0,16 | 0,06 - 0,20 |
| P | Grauguss | 150-230 | 190 (150-250) | 0,04 - 0,10 | 0,05 - 0,14 | 0,06 - 0,16 | 0,10 - 0,22 | 0,10 - 0,26 |
| | Duktiles Gusseisen | 160-260 | 150 (100-200) | 0,04 - 0,12 | 0,06 - 0,16 | 0,08 - 0,18 | 0,08 - 0,20 | 0,10 - 0,22 |
| N | Aluminium / -Legierungen | 30-150 | 300 (250-350) | 0,04-0,12 | 0,06-0,16 | 0,08-0,18 | 0,10-0,22 | 0,10-0,24 |
| | Kupfer / -Legierungen | 150-160 | 250 (200-300) | 0,04-0,12 | 0,06-0,16 | 0,08-0,18 | 0,10-0,22 | 0,10-0,24 |
| S | Chrom-Nickel Legierungen | 130-400 | 50 (30-100) | 0,04-0,06 | 0,04-0,08 | 0,04-0,10 | 0,06-0,12 | 0,06-0,12 |
| | Titan-Legierungen | 130-400 | 40 (30-90) | 0,04-0,08 | 0,04-0,10 | 0,08-0,12 | 0,08-0,14 | 0,08-0,16 |
| | Gehärteter Stahl | über 400 | 40 (20-80) | 0,04-0,08 | 0,04-0,10 | 0,08-0,12 | 0,08-0,14 | 0,08-0,16 |

*Bei 4xD (Serie 84017) Schnittkonditionen um 30-40% reduzieren.
Bei unterbrochenem Schnitt ist der Vorschub um 30-50% zu reduzieren. Stapelverarbeitung möglichst vermeiden.

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# 2xD

| Nenn-Ø mm | Gesamtlänge mm | Schneidenlänge mm | Schaft-Ø mm | Wendeschneid-platte | Schraube | Artikel-Code |
|---|---|---|---|---|---|---|
| 12,5 | 94,0 | 26,0 | 20 | SPMG 050204-.. | M2,2 x 5 T6 | 82017.1250 |
| 13,0 | 96,0 | 28,0 | 20 | | | 82017.1300 |
| 13,5 | 96,0 | 28,0 | 20 | | | 82017.1350 |
| 14,0 | 96,0 | 28,0 | 25 | | | 82017.1400 |
| 14,5 | 99,0 | 30,0 | 25 | | | 82017.1450 |
| 15,0 | 99,0 | 30,0 | 25 | | | 82017.1500 |
| 15,5 | 108,0 | 32,0 | 25 | | | 82017.1550 |
| 16,0 | 108,0 | 32,0 | 25 | SPMG 060204-.. | M2,2 x 5,5 T7 | 82017.1600 |
| 16,5 | 110,0 | 34,0 | 25 | | | 82017.1650 |
| 17,0 | 110,0 | 34,0 | 25 | | | 82017.1700 |
| 17,5 | 113,0 | 36,0 | 25 | | | 82017.1750 |
| 18,0 | 113,0 | 36,0 | 25 | | | 82017.1800 |
| 18,5 | 115,0 | 38,0 | 25 | | | 82017.1850 |
| 19,0 | 115,0 | 38,0 | 25 | | | 82017.1900 |
| 19,5 | 119,0 | 40,0 | 25 | | | 82017.1950 |
| 20,0 | 119,0 | 40,0 | 25 | | | 82017.2000 |
| 20,5 | 121,0 | 42,0 | 25 | | | 82017.2050 |
| 21,0 | 121,0 | 42,0 | 25 | | | 82017.2100 |
| 21,5 | 123,0 | 44,0 | 25 | | | 82017.2150 |
| 22,0 | 123,0 | 44,0 | 25 | SPMG 07T308-.. | M2,5 x 8 T8 | 82017.2200 |
| 22,5 | 131,0 | 46,0 | 25 | | | 82017.2250 |
| 23,0 | 131,0 | 46,0 | 25 | | | 82017.2300 |
| 23,5 | 134,0 | 48,0 | 25 | | | 82017.2350 |
| 24,0 | 134,0 | 48,0 | 25 | | | 82017.2400 |
| 24,5 | 137,0 | 50,0 | 25 | | | 82017.2450 |
| 25,0 | 137,0 | 50,0 | 32 | | | 82017.2500 |
| 25,5 | 139,0 | 52,0 | 32 | | | 82017.2550 |
| 26,0 | 139,0 | 52,0 | 32 | | | 82017.2600 |
| 26,5 | 142,0 | 54,0 | 32 | | | 82017.2650 |
| 27,0 | 142,0 | 54,0 | 32 | | | 82017.2700 |
| 27,5 | 144,0 | 56,0 | 32 | SPMG 090408-.. | M3,5 x 9 T15 | 82017.2750 |
| 28,0 | 144,0 | 56,0 | 32 | | | 82017.2800 |
| 28,5 | 146,0 | 58,0 | 32 | | | 82017.2850 |
| 29,0 | 146,0 | 58,0 | 32 | | | 82017.2900 |
| 29,5 | 148,0 | 60,0 | 32 | | | 82017.2950 |
| 30,0 | 148,0 | 60,0 | 32 | | | 82017.3000 |

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| Nenn-Ø mm | Gesamtlänge mm | Schneidenlänge mm | Schaft-Ø mm | Wendeschneid-platte | Schraube | Artikel-Code |
|---|---|---|---|---|---|---|
| 30,5 | 150,0 | 62,0 | 32 | SPMG 090408-.. | M3,5 x 9 T15 | 82017.3050 |
| 31,0 | 150,0 | 62,0 | 32 | | | 82017.3100 |
| 31,5 | 152,0 | 64,0 | 32 | | | 82017.3150 |
| 32,0 | 152,0 | 64,0 | 32 | | | 82017.3200 |
| 32,5 | 154,0 | 66,0 | 32 | | | 82017.3250 |
| 33,0 | 154,0 | 66,0 | 32 | | | 82017.3300 |
| 34,0 | 156,0 | 68,0 | 32 | SPMG 110408-.. | M4 x 10 T15 | 82017.3400 |
| 35,0 | 158,0 | 70,0 | 32 | | | 82017.3500 |
| 36,0 | 160,0 | 72,0 | 32 | | | 82017.3600 |
| 37,0 | 162,0 | 74,0 | 32 | | | 82017.3700 |
| 38,0 | 164,0 | 76,0 | 32 | | | 82017.3800 |
| 39,0 | 166,0 | 78,0 | 32 | | | 82017.3900 |
| 40,0 | 185,0 | 80,0 | 32 | | | 82017.4000 |
| 41,0 | 187,0 | 82,0 | 32 | | | 82017.4100 |
| 42,0 | 189,0 | 84,0 | 40 | SPMG 140512-.. | M5 x11 T20 | 82017.4200 |
| 43,0 | 181,0 | 86,0 | 40 | | | 82017.4300 |
| 44,0 | 193,0 | 88,0 | 40 | | | 82017.4400 |
| 45,0 | 195,0 | 90,0 | 40 | | | 82017.4500 |
| 46,0 | 197,0 | 92,0 | 40 | | | 82017.4600 |
| 47,0 | 199,0 | 94,0 | 40 | | | 82017.4700 |
| 48,0 | 201,0 | 96,0 | 40 | | | 82017.4800 |
| 49,0 | 203,0 | 98,0 | 40 | | | 82017.4900 |
| 50,0 | 205,0 | 100,0 | 40 | | | 82017.5000 |

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# 3xD

| Nenn-Ø mm | Gesamtlänge mm | Schneidenlänge mm | Schaft-Ø mm | Wendeschneid-platte | Schraube | Artikel-Code |
|---|---|---|---|---|---|---|
| 12,5 | 123,5 | 38,5 | 20 | SPMG 050204-.. | M2,2 x 5 T6 | 83017.1250 |
| 13,0 | 125,0 | 39,0 | 20 | | | 83017.1300 |
| 13,5 | 126,5 | 40,5 | 20 | | | 83017.1350 |
| 14,0 | 128,0 | 42,0 | 25 | | | 83017.1400 |
| 14,5 | 129,5 | 43,5 | 25 | | | 83017.1450 |
| 15,0 | 131,0 | 45,0 | 25 | | | 83017.1500 |
| 15,5 | 132,5 | 46,5 | 25 | | | 83017.1550 |
| 16,0 | 134,0 | 48,0 | 25 | SPMG 060204-.. | M2,2 x 5,5 T7 | 83017.1600 |
| 16,5 | 135,5 | 49,5 | 25 | | | 83017.1650 |
| 17,0 | 137,0 | 51,0 | 25 | | | 83017.1700 |
| 17,5 | 138,5 | 52,5 | 25 | | | 83017.1750 |
| 18,0 | 140,0 | 54,0 | 25 | | | 83017.1800 |
| 18,5 | 141,5 | 55,5 | 25 | | | 83017.1850 |
| 19,0 | 143,0 | 57,0 | 25 | | | 83017.1900 |
| 19,5 | 144,5 | 58,5 | 25 | | | 83017.1950 |
| 20,0 | 146,0 | 60,0 | 25 | | | 83017.2000 |
| 20,5 | 147,5 | 61,5 | 25 | | | 83017.2050 |
| 21,0 | 158,0 | 63,0 | 25 | | | 83017.2100 |
| 21,5 | 159,5 | 64,5 | 25 | | | 83017.2150 |
| 22,0 | 161,0 | 66,0 | 25 | SPMG 07T308-.. | M 2,5 x 8 T8 | 83017.2200 |
| 22,5 | 162,5 | 67,5 | 25 | | | 83017.2250 |
| 23,0 | 164,0 | 69,0 | 25 | | | 83017.2300 |
| 23,5 | 165,5 | 70,5 | 25 | | | 83017.2350 |
| 24,0 | 167,0 | 72,0 | 25 | | | 83017.2400 |
| 24,5 | 168,5 | 73,5 | 25 | | | 83017.2450 |
| 25,0 | 170,0 | 75,0 | 32 | | | 83017.2500 |
| 25,5 | 171,5 | 76,5 | 32 | | | 83017.2550 |
| 26,0 | 173,0 | 78,0 | 32 | | | 83017.2600 |
| 26,5 | 174,5 | 79,5 | 32 | | | 83017.2650 |
| 27,0 | 176,0 | 81,0 | 32 | | | 83017.2700 |
| 27,5 | 177,5 | 82,5 | 32 | SPMG 090408-.. | M 3,5 x 9 T15 | 83017.2750 |
| 28,0 | 179,0 | 84,0 | 32 | | | 83017.2800 |
| 28,5 | 180,5 | 85,5 | 32 | | | 83017.2850 |
| 29,0 | 182,0 | 87,0 | 32 | | | 83017.2900 |
| 29,5 | 183,5 | 88,5 | 32 | | | 83017.2950 |
| 30,0 | 185,0 | 90,0 | 32 | | | 83017.3000 |

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| Nenn-Ø mm | Gesamtlänge mm | Schneidenlänge mm | Schaft-Ø mm | Wendeschneid-platte | Schraube | Artikel-Code |
|---|---|---|---|---|---|---|
| 30,5 | 186,5 | 91,5 | 32 | SPMG 090408-.. | M3,5 x 9 T15 | 83017.3050 |
| 31,0 | 188,0 | 93,0 | 32 | | | 83017.3100 |
| 31,5 | 189,5 | 94,5 | 32 | | | 83017.3150 |
| 32,0 | 191,0 | 96,0 | 32 | | | 83017.3200 |
| 32,5 | 192,5 | 97,5 | 32 | | | 83017.3250 |
| 33,0 | 194,0 | 99,0 | 32 | | | 83017.3300 |
| 34,0 | 197,0 | 102,0 | 32 | SPMG 110408-.. | M4 x 10 T15 | 83017.3400 |
| 35,0 | 200,0 | 105,0 | 32 | | | 83017.3500 |
| 36,0 | 203,0 | 108,0 | 32 | | | 83017.3600 |
| 37,0 | 206,0 | 111,0 | 32 | | | 83017.3700 |
| 38,0 | 209,0 | 114,0 | 32 | | | 83017.3800 |
| 39,0 | 212,0 | 117,0 | 32 | | | 83017.3900 |
| 40,0 | 215,0 | 120,0 | 32 | | | 83017.4000 |
| 41,0 | 218,0 | 123,0 | 32 | | | 83017.4100 |
| 42,0 | 221,0 | 126,0 | 40 | SPMG 140512-.. | M5 x 11 T20 | 83017.4200 |
| 43,0 | 239,0 | 129,0 | 40 | | | 83017.4300 |
| 44,0 | 242,0 | 132,0 | 40 | | | 83017.4400 |
| 45,0 | 245,0 | 135,0 | 40 | | | 83017.4500 |
| 46,0 | 248,0 | 138,0 | 40 | | | 83017.4600 |
| 47,0 | 251,0 | 141,0 | 40 | | | 83017.4700 |
| 48,0 | 254,0 | 144,0 | 40 | | | 83017.4800 |
| 49,0 | 257,0 | 147,0 | 40 | | | 83017.4900 |
| 50,0 | 260,0 | 150,0 | 40 | | | 83017.5000 |

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# 4xD

| Nenn-Ø mm | Gesamtlänge mm | Schneidenlänge mm | Schaft-Ø mm | Wendeschneid-platte | Schraube | Artikel-Code |
|---|---|---|---|---|---|---|
| 12,5 | 136,0 | 50,0 | 20 | SPMG 050204-.. | M2,2 x 5 T6 | 84017.1250 |
| 13,0 | 138,0 | 52,0 | 20 | | | 84017.1300 |
| 13,5 | 140,0 | 54,0 | 20 | | | 84017.1350 |
| 14,0 | 142,0 | 56,0 | 25 | | | 84017.1400 |
| 14,5 | 144,0 | 58,0 | 25 | | | 84017.1450 |
| 15,0 | 146,0 | 60,0 | 25 | | | 84017.1500 |
| 15,5 | 148,0 | 62,0 | 25 | | | 84017.1550 |
| 16,0 | 150,0 | 64,0 | 25 | SPMG 060204-.. | M2,2 x 5,5 T7 | 84017.1600 |
| 16,5 | 152,0 | 66,0 | 25 | | | 84017.1650 |
| 17,0 | 154,0 | 68,0 | 25 | | | 84017.1700 |
| 17,5 | 156,0 | 70,0 | 25 | | | 84017.1750 |
| 18,0 | 158,0 | 72,0 | 25 | | | 84017.1800 |
| 18,5 | 160,0 | 74,0 | 25 | | | 84017.1850 |
| 19,0 | 162,0 | 76,0 | 25 | | | 84017.1900 |
| 19,5 | 164,0 | 78,0 | 25 | | | 84017.1950 |
| 20,0 | 166,0 | 80,0 | 25 | | | 84017.2000 |
| 20,5 | 168,0 | 82,0 | 25 | | | 84017.2050 |
| 21,0 | 179,0 | 84,0 | 25 | | | 84017.2100 |
| 21,5 | 181,0 | 86,0 | 25 | | | 84017.2150 |
| 22,0 | 183,0 | 88,0 | 25 | SPMG 07T308-.. | M2,5 x 8 T8 | 84017.2200 |
| 22,5 | 185,0 | 90,0 | 25 | | | 84017.2250 |
| 23,0 | 187,0 | 92,0 | 25 | | | 84017.2300 |
| 23,5 | 189,0 | 94,0 | 25 | | | 84017.2350 |
| 24,0 | 191,0 | 96,0 | 25 | | | 84017.2400 |
| 24,5 | 193,0 | 98,0 | 25 | | | 84017.2450 |
| 25,0 | 195,0 | 100,0 | 32 | | | 84017.2500 |
| 25,5 | 197,0 | 102,0 | 32 | | | 84017.2550 |
| 26,0 | 199,0 | 104,0 | 32 | | | 84017.2600 |
| 26,5 | 201,0 | 106,0 | 32 | | | 84017.2650 |
| 27,0 | 203,0 | 108,0 | 32 | | | 84017.2700 |
| 27,5 | 205,0 | 110,0 | 32 | SPMG 090408-.. | M3,5 x 9 T15 | 84017.2750 |
| 28,0 | 207,0 | 112,0 | 32 | | | 84017.2800 |
| 28,5 | 209,0 | 114,0 | 32 | | | 84017.2850 |
| 29,0 | 211,0 | 116,0 | 32 | | | 84017.2900 |
| 29,5 | 213,0 | 118,0 | 32 | | | 84017.2950 |
| 30,0 | 215,0 | 120,0 | 32 | | | 84017.3000 |

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| Nenn-Ø mm | Gesamtlänge mm | Schneidenlänge mm | Schaft-Ø mm | Wendeschneid-platte | Schraube | Artikel-Code |
|---|---|---|---|---|---|---|
| 30,5 | 217,0 | 122,0 | 32 | SPMG 090408-.. | M3,5 x 9 T15 | 84017.3050 |
| 31,0 | 219,0 | 124,0 | 32 | | | 84017.3100 |
| 31,5 | 221,0 | 126,0 | 32 | | | 84017.3150 |
| 32,0 | 223,0 | 128,0 | 32 | | | 84017.3200 |
| 32,5 | 225,0 | 130,0 | 32 | | | 84017.3250 |
| 33,0 | 227,0 | 132,0 | 32 | | | 84017.3300 |
| 34,0 | 231,0 | 136,0 | 32 | SPMG 110408-.. | M4 x 10 T15 | 84017.3400 |
| 35,0 | 235,0 | 140,0 | 32 | | | 84017.3500 |
| 36,0 | 239,0 | 144,0 | 32 | | | 84017.3600 |
| 37,0 | 243,0 | 148,0 | 32 | | | 84017.3700 |
| 38,0 | 247,0 | 152,0 | 32 | | | 84017.3800 |
| 39,0 | 251,0 | 156,0 | 32 | | | 84017.3900 |
| 40,0 | 255,0 | 160,0 | 32 | | | 84017.4000 |
| 41,0 | 259,0 | 164,0 | 32 | | | 84017.4100 |
| 42,0 | 263,0 | 168,0 | 40 | SPMG 140512-.. | M5 x 11 T20 | 84017.4200 |
| 43,0 | 282,0 | 172,0 | 40 | | | 84017.4300 |
| 44,0 | 286,0 | 176,0 | 40 | | | 84017.4400 |
| 45,0 | 290,0 | 180,0 | 40 | | | 84017.4500 |
| 46,0 | 294,0 | 184,0 | 40 | | | 84017.4600 |
| 47,0 | 298,0 | 188,0 | 40 | | | 84017.4700 |
| 48,0 | 302,0 | 192,0 | 40 | | | 84017.4800 |
| 49,0 | 306,0 | 196,0 | 40 | | | 84017.4900 |
| 50,0 | 310,0 | 200,0 | 40 | | | 84017.5000 |

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