

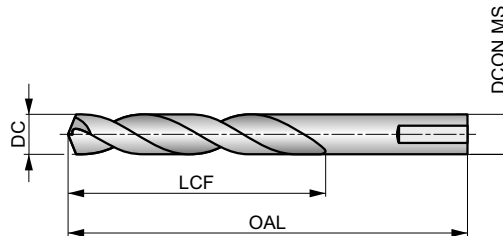
# A321

 DORMER



## Foret HSS de longueur intermédiaire, finition vapeur et bronze

Foret de conception robuste avec queue à trois méplats pour les trous de profondeur moyenne. Adapté en premier lieu pour les utilisations manuelles et les perceuses à colonne. Les trois méplats sur la queue permettent un serrage sans glissement dans le mandrin. La pointe en croix auto-centrante à 135° réduit la force de poussée et la finition de surface vapeur et bronze améliore le pouvoir lubrifiant.



|                                                                                       |                                                                                          |                                                                                   |
|---------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|
| HSS                                                                                   |  DORMER | 3.5×D                                                                             |
|  135° | ST Bronze                                                                                |  |
|  R    | DC h8                                                                                    |                                                                                   |

Adéquation du groupe de matériaux de la pièce, valeurs de départ pour la vitesse de coupe (m/min) et code Alpha d'avance. Les tableaux d'avances par tour se trouvent à partir de la page 274.

|                       |                       |                       |                       |                       |                       |                       |                       |                       |                       |                       |                       |                       |                       |
|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|
| <b>P1.1</b><br>■ 33 H | <b>P1.2</b><br>■ 37 H | <b>P1.3</b><br>■ 38 H | <b>P2.1</b><br>■ 28 H | <b>P2.2</b><br>■ 25 F | <b>P2.3</b><br>■ 22 E | <b>P3.1</b><br>■ 19 F | <b>P3.2</b><br>■ 15 F | <b>P3.3</b><br>■ 13 E | <b>P4.1</b><br>■ 11 F | <b>P4.2</b><br>■ 10 E | <b>P4.3</b><br>■ 8 D  | <b>M1.1</b><br>■ 21 E | <b>M1.2</b><br>■ 17 E |
| <b>M2.1</b><br>■ 18 E | <b>M2.2</b><br>■ 15 E | <b>M3.1</b><br>■ 9 G  | <b>M3.2</b><br>■ 8 G  | <b>M3.3</b><br>■ 7 G  | <b>M4.1</b><br>■ 9 C  | <b>K1.1</b><br>■ 30 H | <b>K1.2</b><br>■ 22 F | <b>K1.3</b><br>■ 17 F | <b>K2.1</b><br>■ 25 E | <b>K2.2</b><br>■ 20 E | <b>K2.3</b><br>■ 16 E | <b>K3.1</b><br>■ 22 E | <b>K3.2</b><br>■ 17 E |
| <b>K3.3</b><br>■ 13 E | <b>K4.1</b><br>■ 20 E | <b>K4.2</b><br>■ 15 E | <b>K4.3</b><br>■ 11 E | <b>K4.4</b><br>■ 10 E | <b>K4.5</b><br>■ 8 E  | <b>K5.1</b><br>■ 23 E | <b>K5.2</b><br>■ 17 E | <b>K5.3</b><br>■ 13 E | <b>N1.1</b><br>■ 33 J | <b>N1.2</b><br>■ 25 J | <b>N1.3</b><br>■ 17 I | <b>N2.1</b><br>■ 42 H | <b>N2.2</b><br>■ 37 H |
| <b>N2.3</b><br>■ 27 H | <b>N3.1</b><br>■ 59 H | <b>N3.2</b><br>■ 35 I | <b>N3.3</b><br>■ 18 G | <b>N4.1</b><br>■ 30 J | <b>N4.2</b><br>■ 28 H | <b>N4.3</b><br>■ 14 F | <b>S1.1</b><br>■ 23 E | <b>S1.2</b><br>■ 12 D | <b>S1.3</b><br>■ 6 B  | <b>S2.1</b><br>■ 8 E  | <b>S2.2</b><br>■ 4 A  | <b>S3.1</b><br>■ 6 E  | <b>S3.2</b><br>■ 3 A  |
| <b>S4.1</b><br>■ 5 E  | <b>S4.2</b><br>■ 2 A  |                       |                       |                       |                       |                       |                       |                       |                       |                       |                       |                       |                       |

| Product | DC<br>(mm) | DC<br>(inch) | LCF<br>(mm) | OAL<br>(mm) | DCON MS<br>(mm) |
|---------|------------|--------------|-------------|-------------|-----------------|
| A3213.0 | 3.00       | 0.1180       | 37.0        | 64.0        | 3.00            |
| A3213.3 | 3.30       | 0.1300       | 40.0        | 67.0        | 3.30            |
| A3213.4 | 3.40       | 0.1340       | 40.0        | 67.0        | 3.40            |
| A3213.5 | 3.50       | 0.1380       | 40.0        | 67.0        | 3.50            |
| A3214.0 | 4.00       | 0.1580       | 47.0        | 74.0        | 4.00            |
| A3214.1 | 4.10       | 0.1610       | 47.0        | 74.0        | 4.10            |
| A3214.2 | 4.20       | 0.1650       | 47.0        | 74.0        | 4.20            |
| A3214.3 | 4.30       | 0.1690       | 47.0        | 74.0        | 4.30            |
| A3214.5 | 4.50       | 0.1770       | 49.0        | 77.0        | 4.50            |
| A3214.9 | 4.90       | 0.1930       | 50.0        | 80.0        | 4.90            |
| A3215.0 | 5.00       | 0.1970       | 50.0        | 80.0        | 5.00            |
| A3215.1 | 5.10       | 0.2010       | 50.0        | 80.0        | 5.10            |
| A3215.3 | 5.30       | 0.2090       | 52.0        | 84.0        | 5.30            |
| A3215.5 | 5.50       | 0.2170       | 52.0        | 84.0        | 5.50            |
| A3216.0 | 6.00       | 0.2360       | 52.0        | 90.0        | 6.00            |
| A3216.3 | 6.30       | 0.2480       | 52.0        | 90.0        | 6.30            |
| A3216.5 | 6.50       | 0.2560       | 55.0        | 93.0        | 6.50            |

| Product  | DC<br>(mm) | DC<br>(inch) | LCF<br>(mm) | OAL<br>(mm) | DCON MS<br>(mm) |
|----------|------------|--------------|-------------|-------------|-----------------|
| A3216.8  | 6.80       | 0.2680       | 59.0        | 97.0        | 6.80            |
| A3217.0  | 7.00       | 0.2760       | 59.0        | 97.0        | 7.00            |
| A3217.3  | 7.30       | 0.2870       | 62.0        | 100.0       | 7.30            |
| A3217.5  | 7.50       | 0.2950       | 62.0        | 100.0       | 7.50            |
| A3218.0  | 8.00       | 0.3150       | 67.0        | 105.0       | 8.00            |
| A3218.5  | 8.50       | 0.3350       | 68.0        | 107.0       | 8.50            |
| A3219.0  | 9.00       | 0.3540       | 70.0        | 108.0       | 9.00            |
| A3219.5  | 9.50       | 0.3740       | 70.0        | 110.0       | 9.50            |
| A32110.0 | 10.00      | 0.3940       | 74.0        | 113.0       | 10.00           |
| A32110.3 | 10.30      | 0.4060       | 74.0        | 113.0       | 10.30           |
| A32110.5 | 10.50      | 0.4130       | 75.0        | 115.0       | 10.50           |
| A32111.0 | 11.00      | 0.4330       | 77.0        | 117.0       | 11.00           |
| A32111.5 | 11.50      | 0.4530       | 79.0        | 120.0       | 11.50           |
| A32112.0 | 12.00      | 0.4720       | 85.0        | 126.0       | 12.00           |
| A32112.5 | 12.50      | 0.4920       | 88.0        | 130.0       | 12.50           |
| A32113.0 | 13.00      | 0.5120       | 88.0        | 130.0       | 13.00           |