

Removable drill bushes

DIN 173, part 1



Material:
Special hardened steel

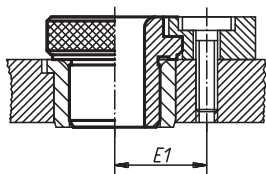
Surface finish:
Hardened and ground. Hardness 780 ±40 HV, quality class 10

Sample order:
nlm 08920-K0400X16 (removable drill bush, form K with D1 = 4 mm and L1 = 16 mm)

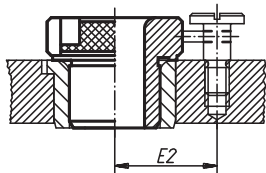
Note:
All removable drill bushes have the hole dimension and the half-length dimension inscribed on the upper surface of the collar, e.g. 15 F7.
The form K removable drill bush is used as a quick-change bush. Cylindrical pins or spiral clamping pins in conjunction with flat-head screws to DIN 173 Part 1 are used as the counter-locator for the stop pin.
The bayonet lock is secured by clamping bushes to DIN 173 Part 1 in conjunction with cylinder bolts to DIN 912.

E2 = Drill spacing should cylindrical pins or spiral clamping pins be used.

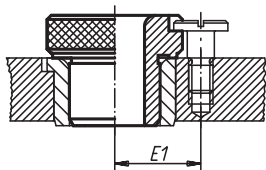
application example:



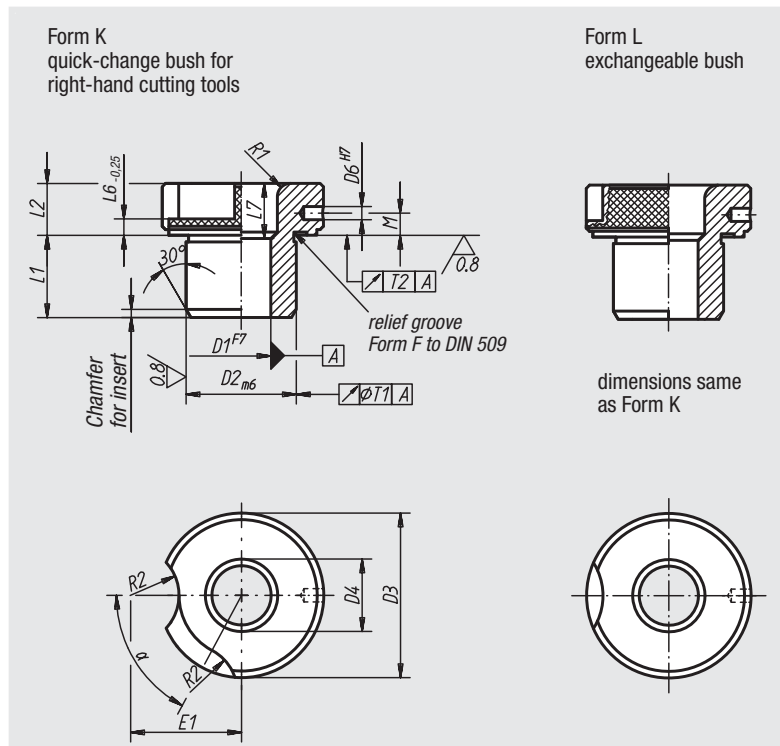
Quick-change bush Form K with Drill Bush with collar to DIN 172 or Drill Bush to DIN 179



Quick-change bush Form K with Drill Bush with collar to DIN 172 or Drill Bush to DIN 179



Exchangeable Bush Form L with Drill Bush with collar to DIN 172 or Drill Bush to DIN 179



D1	Surface finish	D2	D3	D4	D6	L1	L2	L6	L7	M	T1	T2	R1	R2	E1	E2	α
from 2.3 up to 4.0	short	8	15	-	2,5	10	8	3	-	4,25	0,02	0,005	1,5	7	11,5	15	65°
from 2.3 up to 4.0	medium	8	15	4,5	2,5	16	8	3	6	4,25	0,02	0,005	1,5	7	11,5	15	65°
from 4.1 up to 6.0	short	10	18	-	2,5	12	8	3	-	4,25	0,02	0,005	2	7	13	17	65°
from 4.1 up to 6.0	medium	10	18	6,5	2,5	20	8	3	8	4,25	0,02	0,005	2	7	13	17	65°
from 4.1 up to 6.0	long	10	18	6,5	2,5	25	8	3	13	4,25	0,02	0,005	2	7	13	17	65°
from 6.1 up to 8.0	short	12	22	-	3	12	10	4	-	6	0,02	0,005	2	8,5	16,5	20	60°
from 6.1 up to 8.0	medium	12	22	8,5	3	20	10	4	8	6	0,02	0,005	2	8,5	16,5	20	60°
from 6.1 up to 8.0	long	12	22	8,5	3	25	10	4	13	6	0,02	0,005	2	8,5	16,5	20	60°
from 8.1 up to 10.0	short	15	26	-	3	16	10	4	-	6	0,02	0,005	2	8,5	18	22	50°
from 8.1 up to 10.0	medium	15	26	10,5	3	28	10	4	12	6	0,02	0,005	2	8,5	18	22	50°
from 8.1 up to 10.0	long	15	26	10,5	3	36	10	4	20	6	0,02	0,005	2	8,5	18	22	50°
from 10.1 up to 12.0	short	18	30	-	3	16	10	4	-	6	0,02	0,005	2	8,5	20	24	50°
from 10.1 up to 12.0	medium	18	30	12,5	3	28	10	4	12	6	0,02	0,005	2	8,5	20	24	50°
from 10.1 up to 12.0	long	18	30	12,5	3	36	10	4	20	6	0,02	0,005	2	8,5	20	24	50°
from 12.1 up to 15.0	short	22	34	-	5	20	12	5,5	-	7	0,02	0,005	3	10,5	23,5	28	35°
from 12.1 up to 15.0	medium	22	34	15,5	5	36	12	5,5	16	7	0,02	0,005	3	10,5	23,5	28	35°
from 12.1 up to 15.0	long	22	34	15,5	5	45	12	5,5	25	7	0,02	0,005	3	10,5	23,5	28	35°
from 15.5 up to 18.0	short	26	39	-	5	20	12	5,5	-	7	0,02	0,005	3	10,5	26	31	35°
from 15.5 up to 18.0	medium	26	39	19	5	36	12	5,5	16	7	0,02	0,005	3	10,5	26	31	35°
from 15.5 up to 18.0	long	26	39	19	5	45	12	5,5	25	7	0,02	0,005	3	10,5	26	31	35°
from 18.5 up to 22.0	short	30	46	-	5	25	12	5,5	-	7	0,02	0,005	3	10,5	29,5	35	30°
from 18.5 up to 22.0	medium	30	46	23	5	45	12	5,5	20	7	0,02	0,005	3	10,5	29,5	35	30°
from 18.5 up to 22.0	long	30	46	23	5	56	12	5,5	31	7	0,02	0,005	3	10,5	29,5	35	30°
from 22.5 up to 26.0	short	35	52	-	6	25	12	5,5	-	7	0,04	0,008	3	10,5	32,5	37	30°
from 22.5 up to 26.0	medium	35	52	27	6	45	12	5,5	20	7	0,04	0,008	3	10,5	32,5	37	30°
from 22.5 up to 26.0	long	35	52	27	6	56	12	5,5	31	7	0,04	0,008	3	10,5	32,5	37	30°
from 26.5 up to 30.0	short	42	59	-	6	30	12	5,5	-	7	0,04	0,008	3	10,5	36	41	30°
from 26.5 up to 30.0	medium	42	59	31	6	56	12	5,5	26	7	0,04	0,008	3	10,5	36	41	30°
from 26.5 up to 30.0	long	42	59	31	6	67	12	5,5	37	7	0,04	0,008	3	10,5	36	41	30°

01000 02000 03000 04000 05000 06000 07000 08000 09000 20000 21000 22000 23000