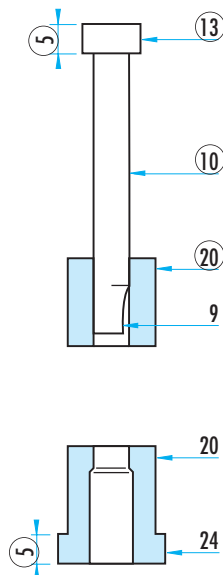


SNIJELEMENT VOLGENS ISO

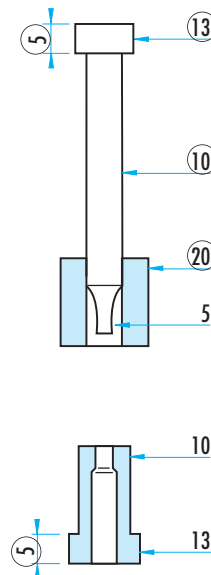
PONSNIPPELS ISO 8020 - SNIJBUSSEN ISO 8977

VOORDELEN : een beperkt aantal gereedschappen is nodig voor het vervaardigen van verschillende montageboringen, aangezien men werktuigen met dezelfde diameter of een grotere diameter kan gebruiken.

Dezelfde kraag en kophoogte
=
Dezelfde kameringsdiepte



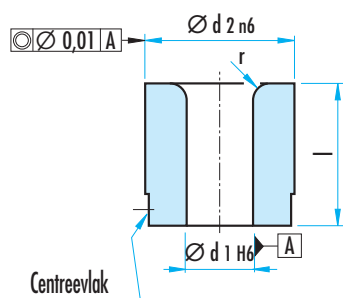
Ø snede 9 mm



Ø snede 5 mm

GELEIDINGSBUS VOOR PONSNIPPEL ISO 8978

Art. 2621.1



MATERIAAL : WS staal.

HARDHEID : 740 ± 40 HV10.

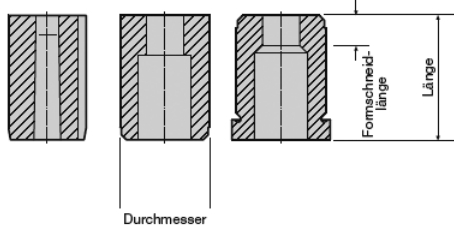
UITVOERING : Ø d1 en d2 fijn geslepen.

d1H6	grad.	d2n6	t	l	r
1,0 - 2,4	0,1	5	0,01	8	1
1,6 - 3,0	0,1	6	0,01	12,5	1
2,0 - 3,5	0,1	8	0,01	12,5	1,5
3,0 - 5,0	0,1	10	0,01	16	2
4,0 - 7,2	0,1	13	0,01	16	2
6,0 - 8,8	0,1	16	0,01	20	2
7,5 - 11,3	0,1	20	0,01	20	2,5
11,0 - 16,6	0,1	25	0,01	25	2,5
15,0 - 20,0	0,5	32	0,01	25	4
18,0 - 27,0	0,5	40	0,01	32	4
26,0 - 36,0	0,5	50	0,01	40	4

BESTELVOORBEELD :

2621.1 d1 = 2, d2 = 8 = Art. 2621.1.0200.0800

BESTELLINGSVOORBEEDEN



Hinweis: Normabmessung siehe Tabelle Sonderanfertigung auf Anfrage

2 6 4 6 . 10 F 6 . 1 3 5 0 . 0 6 5 0 A 2

Schneidbuchsen:
26 Schneidbuchsen

Formschneidlänge: l	Bestellziffer
2	= 1
3	= 2
4	= 3
5	= 4
6	= 5
8	= 6
10	= 7
12	= 8
Sonder	= X

Form Langloch:
Länge P = 13,5 mm

Form:
Langloch
Breite W = 6,5 mm

Ausführung:	Bestellziffer
⊙ Rohling (Startlochbohrung)	= 0
⊙ Rund	= 1
⊖ Quadrat	= 2
⊖ Rechteck	= 3
⊖ Langloch	= 4
⊖ Rechteck mit Radius	= 5
Sonderformen	= 9

Durchmesser: d ₂	Bestellziffer
5	= 1
6	= 2
8	= 3
10	= 4
13	= 5
16	= 6
20	= 7
22	= 8
25	= 9
32	= 10
38	= 11
40	= 12
45	= 13
50	= 14
56	= 15
63	= 16
71	= 17
76	= 18
86	= 19
90	= 20
100	= 21

Länge: l ₁	Bestellbuchstabe
13	= A
16	= B
20	= C
22	= D
25	= E
28	= F
30	= G
32	= H
35	= J
40	= K
Sonder	= X

Winkel:	Bestellbuchstabe
0°	= A
90°	= B
180°	= C
270°	= D
Sonder	= X

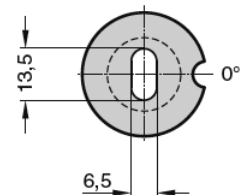
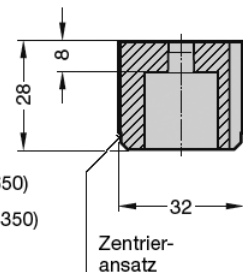
Typ:	Bestellziffer
Automobilnorm	= 5
ohne Bund ISO 8977	= 6
mit Bund ISO 8977	= 7

Verdreh-sicherung:	Bestellziffer
Stift Ø3	= 1
Stift Ø4	= 2
Stift Ø6	= 3
Anschlifffläche (durchgehend)	= 4
Anschlifffläche oben 14 mm	= 5
Anschlifffläche unten 14 mm	= 6

Bestell-Beispiel:

2 6 4 6 . 10 F 6 . 1 3 5 0 . 0 6 5 0 A 2

- Verdreh-sicherung = Stift Ø4 (2)
- Winkel = 0° (A)
- Form: Langloch Breite W = 6,5 mm (0650)
- Form: Langloch Länge P = 13,5 mm (1350)
- Formschneidlänge: l = 8 mm (6)
- Länge: l₁ = 28 mm (F)
- Durchmesser: d₂ = 32 mm (10)
- Typ = ohne Bund ISO 8977 (6)
- Ausführung: Langloch (4)
- Schneidbuchsen:
Schneidbuchsen (26)

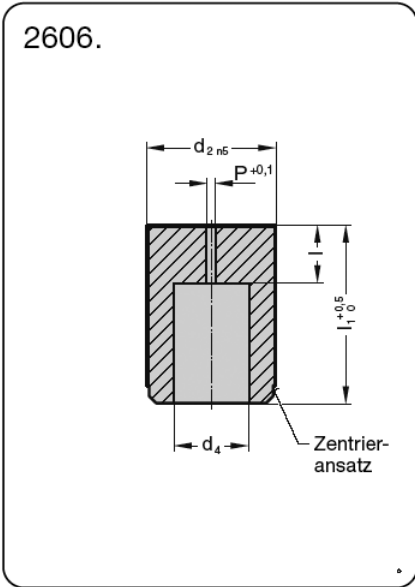


PRECISIE SNIJBUS - ISO 8977

Art. 2606 /16

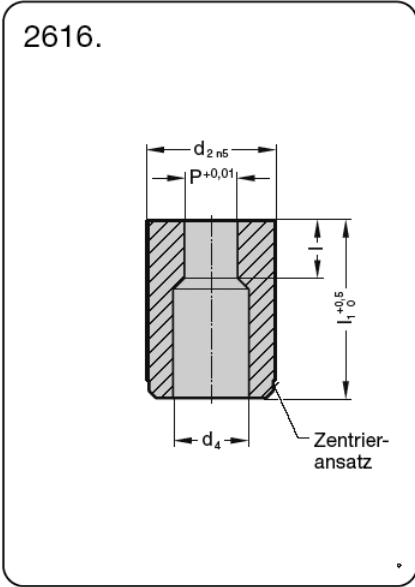
Werkstoff:
 HSS
 gehärtet: 62 ±2 HRC

Ausführung:
 Durchmesser d_2 , Zentrieransatz sowie Stirnflächen geschliffen.
 Durchmesser P ist ein gebohrtes Startloch für die Drahterosion.
 Andere Längen auf Anfrage.



Werkstoff:
 HSS
 gehärtet: 62 ±2 HRC

Ausführung:
 Durchmesser d_2 , Zentrieransatz sowie Stirnflächen geschliffen.



2606.

d_2	d_4	P	l	l_1								
				16	20	22	25	28	30	32	35	40
5	2,8	0,8	2	●	●	●	●	●	●	●	●	●
6	3,5	1,0	3	●	●	●	●	●	●	●	●	●
8	4,0	1,0	4	●	●	●	●	●	●	●	●	●
10	5,8	1,0	4	8	●	●	●	●	●	●	●	●
13	8,0	1,2	5	8	●	●	●	●	●	●	●	●
16	9,5	1,2	5	8	●	●	●	●	●	●	●	●
20	12,0	1,5	8	12	●	●	●	●	●	●	●	●
22	15,0	1,5	8	12	●	●	●	●	●	●	●	●
25	17,3	1,5	8	12	●	●	●	●	●	●	●	●
32	20,7	1,5	8	12	●	●	●	●	●	●	●	●
40	27,7	1,5	8	12	●	●	●	●	●	●	●	●
50	37,0	1,5	8	12	●	●	●	●	●	●	●	●

Bestell-Beispiel:
 siehe Ausklappseite E 63.

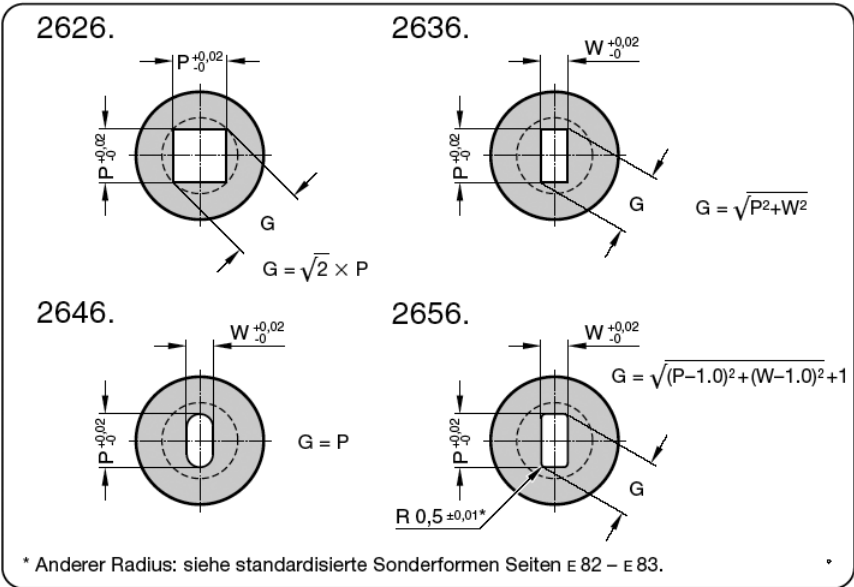
2616.

d_2	d_4	P	l	l_1								
				16	20	22	25	28	30	32	35	40
5	2,8	1,0- 2,4	2	●	●	●	●	●	●	●	●	●
6	3,5	1,6- 3,0	3	●	●	●	●	●	●	●	●	●
8	4,0	2,0- 3,5	4	●	●	●	●	●	●	●	●	●
10	5,8	2,5- 5,0	4	8	●	●	●	●	●	●	●	●
13	8,0	4,0- 7,0	5	8	●	●	●	●	●	●	●	●
16	9,5	6,0- 9,0	5	8	●	●	●	●	●	●	●	●
20	12,0	8,0-11,0	8	12	●	●	●	●	●	●	●	●
22	15,0	9,0-14,0	8	12	●	●	●	●	●	●	●	●
25	17,3	10,7-16,0	8	12	●	●	●	●	●	●	●	●
32	20,7	15,0-20,0	8	12	●	●	●	●	●	●	●	●
40	27,7	19,0-27,0	8	12	●	●	●	●	●	●	●	●
50	37,0	26,0-36,0	8	12	●	●	●	●	●	●	●	●

Bestell-Beispiel:
 siehe Ausklappseite E 63.

PRECISIE SNIJBUS - ISO 8977

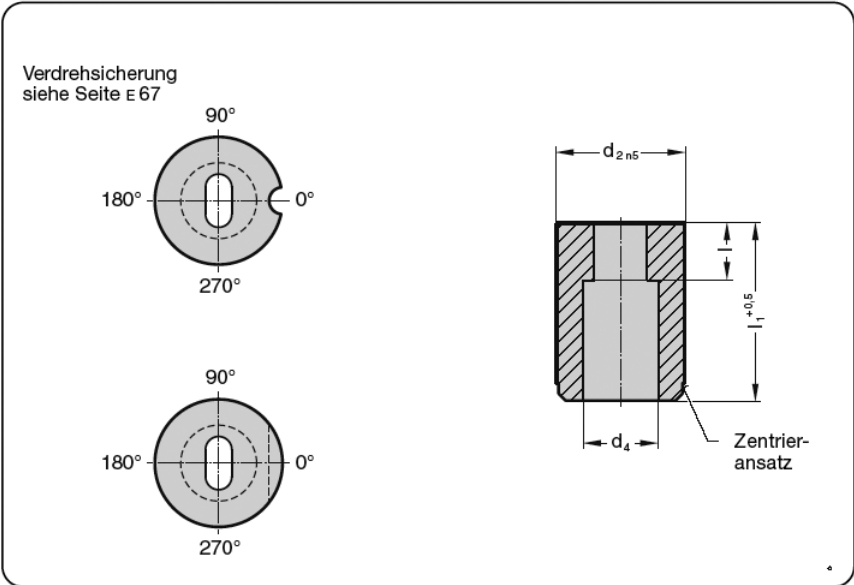
Art. 2626 /36/46/56



Werkstoff:
 HSS
 gehärtet: 62 ± 2 HRC

Ausführung:
 Durchmesser d_2 sowie Stirnflächen geschliffen.

Andere Längen auf Anfrage.



d_2	d_4	$W_{min.}$	$G_{max.}$	l	l_1												
					16	20	22	25	28	30	32	35	40				
10	5,8	1,2	5,0	4	8	●	●	●	●	●	●	●	●	●	●	●	●
13	8,0	2,0	7,0	5	8	●	●	●	●	●	●	●	●	●	●	●	●
16	9,5	2,4	9,0	5	8	●	●	●	●	●	●	●	●	●	●	●	●
20	12,0	3,2	11,0	8	12	●	●	●	●	●	●	●	●	●	●	●	●
22	15,0	4,0	14,0	8	12	●	●	●	●	●	●	●	●	●	●	●	●
25	17,3	4,8	16,0	8	12	●	●	●	●	●	●	●	●	●	●	●	●
32	20,7	5,5	20,0	8	12	●	●	●	●	●	●	●	●	●	●	●	●
40	27,7	6,4	27,0	8	12	●	●	●	●	●	●	●	●	●	●	●	●
50	37,0	9,0	36,0	8	12	●	●	●	●	●	●	●	●	●	●	●	●

Bestell-Beispiel:
 siehe Ausklappseite E 63.

PRECISIE SNIJBUS - ISO 8977

Art. 2626 /36/46/56

Verdrehsicherung 1

Stift Ø3	
d ₂	F
10	5
13	6,5
16	8
20	10
22	11
25	12,5
32	16
40	20
50	25

Verdrehsicherung 2

Stift Ø4	
d ₂	F
10	6
13	7,2
16	8
20	10
22	11
25	12,5
32	16
40	20
50	25

Verdrehsicherung 3

Stift Ø6	
d ₂	F
10	7
13	8,2
16	9
20	11
22	12
25	13,5
32	16
40	20
50	25

Verdrehsicherung 4

d ₂	F
10	4
13	5,5
16	7
20	8,5
22	9,5
25	11
32	14
40	18
50	23

Verdrehsicherung 5

d ₂	F
10	4
13	5,5
16	7
20	8,5
22	9,5
25	11
32	14
40	18
50	23

Verdrehsicherung 6

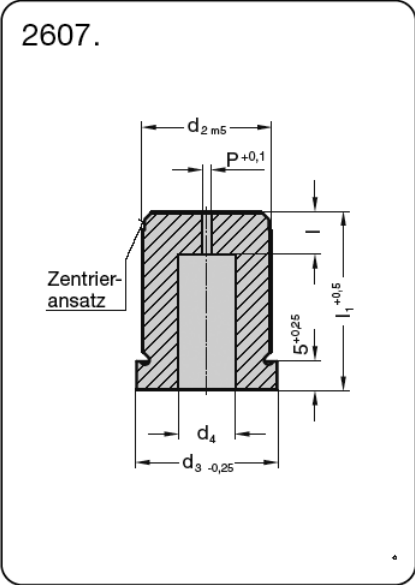
d ₂	F
10	4
13	5,5
16	7
20	8,5
22	9,5
25	11
32	14
40	18
50	23

PRECISIE SNIJBUS - ISO 8977

Art. 2607 / 2617

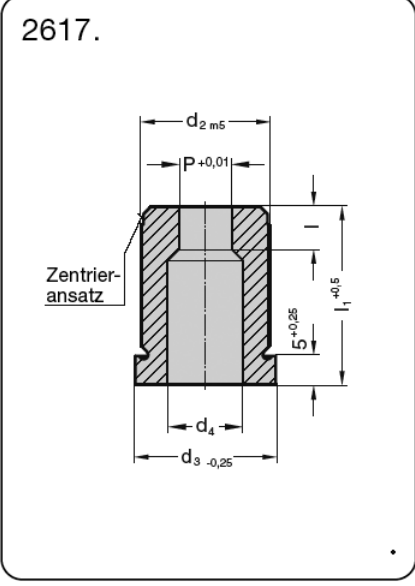
Werkstoff:
 HSS
 gehärtet: 62 ± 2 HRC

Ausführung:
 Durchmesser d_2 sowie Stirnflächen geschliffen.
 Durchmesser P ist ein gebohrtes Startloch für die Drahterosion.
 Andere Längen auf Anfrage.



Werkstoff:
 HSS
 gehärtet: 62 ± 2 HRC

Ausführung:
 Durchmesser d_2 sowie Stirnflächen geschliffen.
 Andere Längen auf Anfrage.



2607.

d_2	d_3	d_4	P	l	l_1							
					16	20	22	25	28	30	32	35
5	8	2,8	0,8	2	●	●	●	●	●	●	●	●
6	9	3,5	1,0	3	●	●	●	●	●	●	●	●
8	11	4,0	1,0	4	●	●	●	●	●	●	●	●
10	13	5,8	1,0	4	8	●	●	●	●	●	●	●
13	16	8,0	1,2	5	8	●	●	●	●	●	●	●
16	19	9,5	1,2	5	8	●	●	●	●	●	●	●
20	23	12,0	1,5	8	12	●	●	●	●	●	●	●
22	25	15,0	1,5	8	12	●	●	●	●	●	●	●
25	28	17,3	1,5	8	12	●	●	●	●	●	●	●
32	35	20,7	1,5	8	12	●	●	●	●	●	●	●
40	43	27,7	1,5	8	12	●	●	●	●	●	●	●
50	53	37,0	1,5	8	12	●	●	●	●	●	●	●

2617.

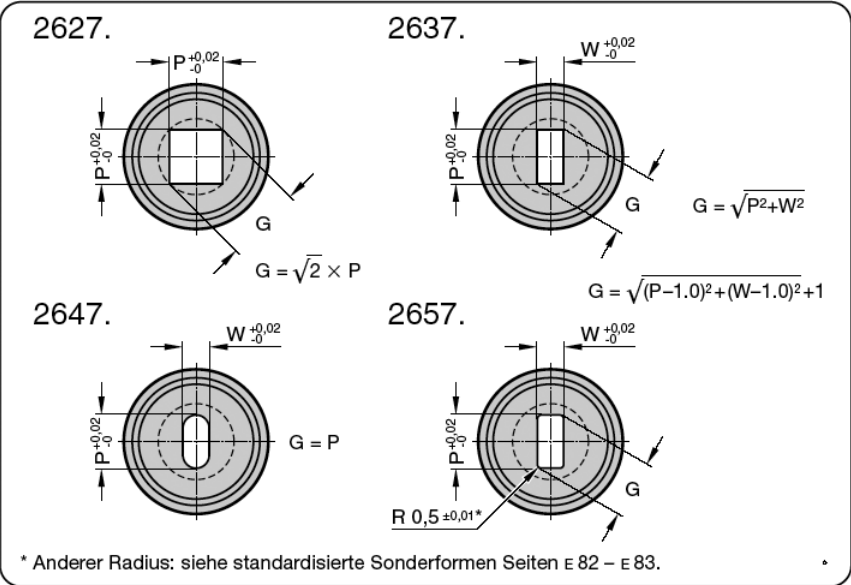
d_2	d_3	d_4	P	l	l_1							
					16	20	22	25	28	30	32	35
5	8	2,8	1,0- 2,4	2	●	●	●	●	●	●	●	●
6	9	3,5	1,6- 3,0	3	●	●	●	●	●	●	●	●
8	11	4,0	2,0- 3,5	4	●	●	●	●	●	●	●	●
10	13	5,8	2,5- 5,0	4	8	●	●	●	●	●	●	●
13	16	8,0	4,0- 7,0	5	8	●	●	●	●	●	●	●
16	19	9,5	6,0- 9,0	5	8	●	●	●	●	●	●	●
20	23	12,0	8,0-11,0	8	12	●	●	●	●	●	●	●
22	25	15,0	9,0-14,0	8	12	●	●	●	●	●	●	●
25	28	17,3	10,7-16,0	8	12	●	●	●	●	●	●	●
32	35	20,7	15,0-20,0	8	12	●	●	●	●	●	●	●
40	43	27,7	19,0-27,0	8	12	●	●	●	●	●	●	●
50	53	37,0	26,0-36,0	8	12	●	●	●	●	●	●	●

Bestell-Beispiel:
 siehe Ausklappseite E 63.

Bestell-Beispiel:
 siehe Ausklappseite E 63.

PRECISIE SNIJBUS - ISO 8977

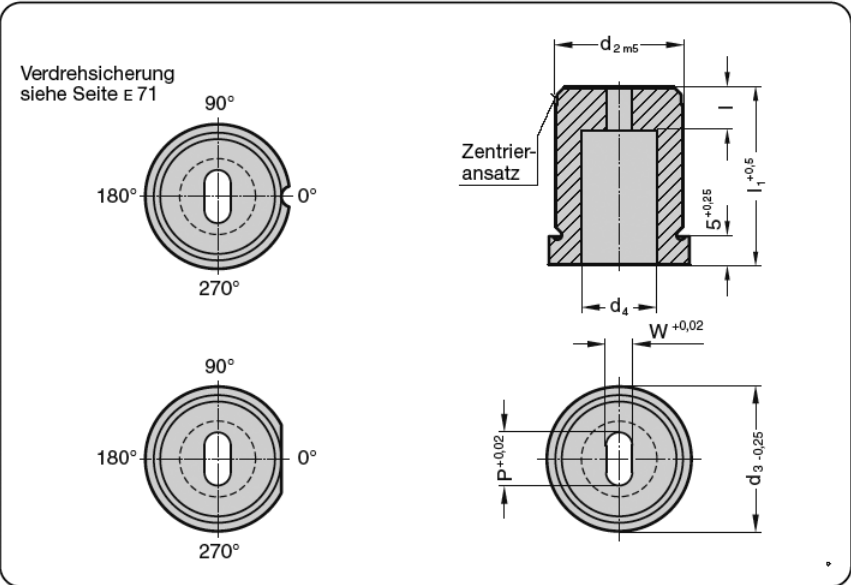
Art. 2627 /37/47/57



Werkstoff:
 HSS
 gehärtet: 62 ± 2 HRC

Ausführung:
 Durchmesser d_2 , sowie Stirnflächen geschliffen.

Andere Längen auf Anfrage.



d ₂	d ₃	d ₄	W _{min.}	G _{max.}	l	l ₁							
						16	20	22	25	28	30	32	35
8	11	4,0	1,2	3,5	4	●	●	●	●	●	●	●	●
10	13	5,8	1,2	5,0	4 8	●	●	●	●	●	●	●	●
13	16	8,0	2,0	7,0	5 8	●	●	●	●	●	●	●	●
16	19	9,5	2,4	9,0	5 8	●	●	●	●	●	●	●	●
20	23	12,0	3,2	11,0	8 12	●	●	●	●	●	●	●	●
22	25	15,0	4,0	14,0	8 12	●	●	●	●	●	●	●	●
25	28	17,3	4,8	16,0	8 12	●	●	●	●	●	●	●	●
32	35	20,7	5,5	20,0	8 12	●	●	●	●	●	●	●	●
40	43	27,7	6,4	27,0	8 12	●	●	●	●	●	●	●	●
50	53	37,0	6,4	36,0	8 12	●	●	●	●	●	●	●	●

Bestell-Beispiel:
 siehe Ausklappseite E 63.

PRECISIE SNIJBUS - ISO 8977

Art. 2627 /37/47/57

Verdrehsicherung 1
Zentrier-
ansatz

Stift Ø3	
d ₂	F
8	5,5
10	6,5
13	8
16	9,5
20	11,5
22	12,5
25	14
32	17,5
40	21,5
50	26,5

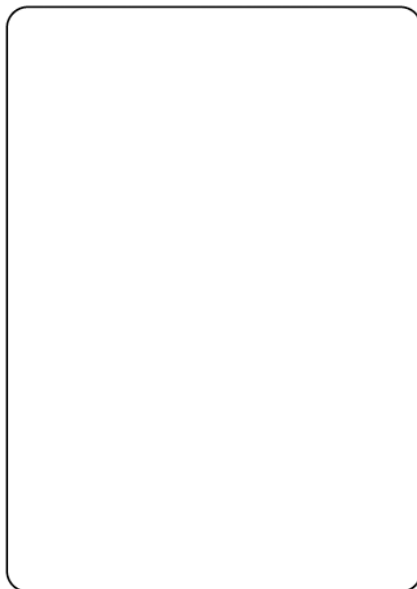
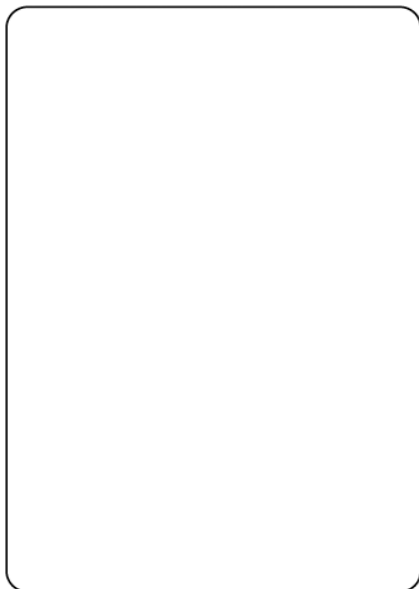
Verdrehsicherung 2
Zentrier-
ansatz

Stift Ø4	
d ₂	F
8	6
10	7
13	8,5
16	10
20	12
22	13
25	14,5
32	18
40	22
50	27

Verdrehsicherung 3
Zentrier-
ansatz

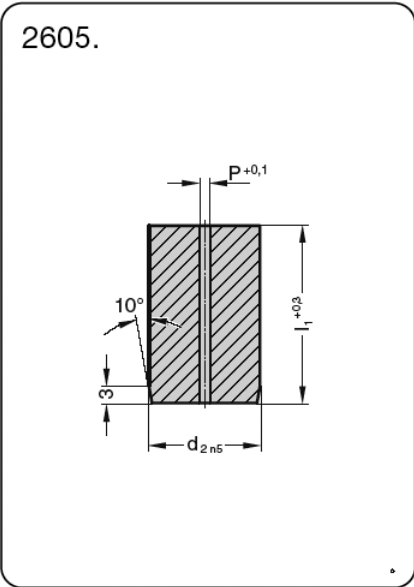
Stift Ø6	
d ₂	F
8	7
10	8
13	9,5
16	11
20	13
22	14
25	15,5
32	19
40	23
50	28

Verdrehsicherung 4
Zentrier-
ansatz



PRECISIE SNIJBUS - AUTOMOBIEL NORM

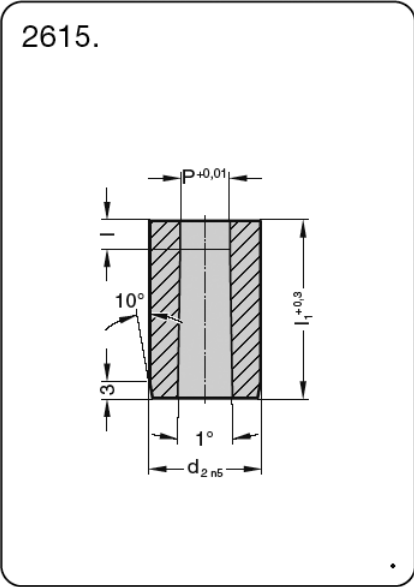
Art. 2605 / 2615



Werkstoff:
HSS gehärtet 62±2 HRC

Ausführung:
Durchmesser d_2 , sowie Stirnflächen geschliffen.
Durchmesser P ist ein gebohrtes Startloch für die Drahterosion.

Andere Längen auf Anfrage.



Werkstoff:
HSS gehärtet 62±2 HRC

Ausführung:
Durchmesser d_2 , sowie Stirnflächen geschliffen.

Andere Längen auf Anfrage.

2605.

d_2	P	13	16	20	22	25	28	30	32	35	40
10	0,8	●	●	●	●	●	●	●	●	●	●
13	0,8	●	●	●	●	●	●	●	●	●	●
16	1,5			●	●	●	●	●	●	●	●
20	2,4			●	●	●	●	●	●	●	●
22	3,0			●	●	●	●	●	●	●	●
25	3,0			●	●	●	●	●	●	●	●
32	3,0			●	●	●	●	●	●	●	●
38	3,0		●	●	●	●	●	●	●	●	●
40	3,0		●	●	●	●	●	●	●	●	●
45	3,0			●	●	●	●	●	●	●	●
50	3,0			●	●	●	●	●	●	●	●
56	3,0			●	●	●	●	●	●	●	●
63	3,0			●	●	●	●	●	●	●	●
71	3,0			●	●	●	●	●	●	●	●
76	3,0				●	●	●	●	●	●	●
86	3,0				●	●	●	●	●	●	●
90	3,0				●	●	●	●	●	●	●
100	3,0				●	●	●	●	●	●	●

Bestell-Beispiel: siehe Ausklappseite E 63.

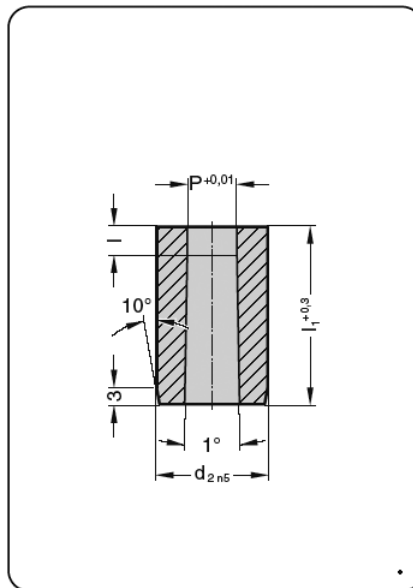
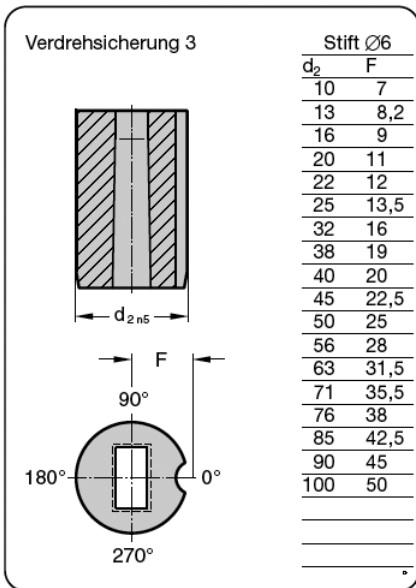
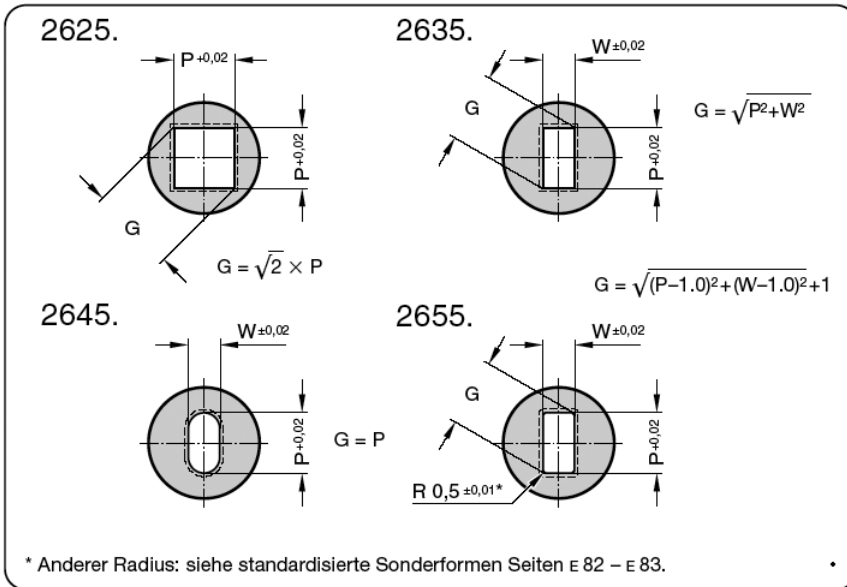
2615.

d_2	P	l	13	16	20	22	25	28	30	32	35	40
10	1,6- 6,8	3 4 5	●	●	●	●	●	●	●	●	●	●
13	3,0- 8,8	3 5 8	●	●	●	●	●	●	●	●	●	●
16	7,4-10,8	3 5 8			●	●	●	●	●	●	●	●
20	9,5-13,6	3 5 10			●	●	●	●	●	●	●	●
22	10,5-15,0	3 6 10			●	●	●	●	●	●	●	●
25	12,0-17,0	3 6 10			●	●	●	●	●	●	●	●
32	16,0-22,0	3 6 12			●	●	●	●	●	●	●	●
38	18,0-27,0	3 8 12			●	●	●	●	●	●	●	●
40	18,0-27,0	3 8 12			●	●	●	●	●	●	●	●
45	18,0-35,0	3 8 12			●	●	●	●	●	●	●	●
50	18,0-40,0	3 8 12			●	●	●	●	●	●	●	●
56	18,0-45,0	3 8 12			●	●	●	●	●	●	●	●
63	18,0-50,0	3 8 12			●	●	●	●	●	●	●	●
71	18,0-56,0	3 8 12			●	●	●	●	●	●	●	●
76	25,0-60,0	3 8 12				●	●	●	●	●	●	●
86	25,0-66,0	3 8 12				●	●	●	●	●	●	●
90	32,0-70,0	3 8 12				●	●	●	●	●	●	●
100	32,0-78,0	3 8 12				●	●	●	●	●	●	●

Bestell-Beispiel: siehe Ausklappseite E 63.

PRECISIE SNIJBUS - AUTOMOBIEL NORM

Art. 2625 /35/45/55



Werkstoff:

HSS
gehärtet 62±2 HRC

Ausführung:

Durchmesser d₂, sowie Stirnfläche geschliffen.

Andere Längen auf Anfrage.

d ₂	W _{min} , G _{max.}	l	l ₁											
			13	16	20	22	25	28	30	32	35	40		
10	1,3 - 6,8	3 4 5	●	●	●	●	●	●	●	●	●	●	●	
13	1,9 - 8,8	3 5 8	●	●	●	●	●	●	●	●	●	●	●	
16	1,9 - 10,8	3 5 8		●	●	●	●	●	●	●	●	●	●	
20	1,9 - 13,6	3 5 10			●	●	●	●	●	●	●	●	●	
22	1,9 - 15,0	3 6 10			●	●	●	●	●	●	●	●	●	
25	1,9 - 17,0	3 6 10			●	●	●	●	●	●	●	●	●	
32	1,9 - 22,0	3 6 12			●	●	●	●	●	●	●	●	●	
38	1,9 - 27,0	3 8 12			●	●	●	●	●	●	●	●	●	
40	1,9 - 27,0	3 8 12			●	●	●	●	●	●	●	●	●	
45	2,4 - 35,0	3 8 12			●	●	●	●	●	●	●	●	●	
50	4,0 - 40,0	3 8 12			●	●	●	●	●	●	●	●	●	
56	4,0 - 45,0	3 8 12			●	●	●	●	●	●	●	●	●	
63	4,0 - 50,0	3 8 12			●	●	●	●	●	●	●	●	●	
71	4,0 - 56,0	3 8 12			●	●	●	●	●	●	●	●	●	
76	5,6 - 60,0	3 8 12			●	●	●	●	●	●	●	●	●	
86	5,6 - 66,0	3 8 12			●	●	●	●	●	●	●	●	●	
90	5,6 - 70,0	3 8 12			●	●	●	●	●	●	●	●	●	
100	5,6 - 78,0	3 8 12			●	●	●	●	●	●	●	●	●	

Bestell-Beispiel: siehe Ausklappseite E 63.