







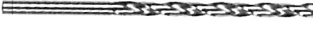
















MAY KESTAG kierukkaporat

	Malli	Materiaali	Ø -alue	Pintakäsittely	Pituus	DIN
	624	HSS	"RN" Ø = 1-20 mm	höyrypäästetty	lyhyt	338
	601	HSS	"RN" Ø = 0,4-20 mm	höyrypäästetty	lyhyt	338
	603	HSS-EC0	"RN" Ø = 1-16 mm	kirkas	lyhyt	338
	630	HSS-EC0	"RN" Ø = 2-10 mm	ALUNIT=TiAIN-2	lyhyt	338
	651	HSS	"RW" Ø = 1-13 mm	kirkas	lyhyt	338
	611	HSS-EC0	"Forte" Ø = 1-13 mm	särmänitrattu	lyhyt	338
	663	HSS-EC0	"R-AS" Ø = 2-16 mm	kirkas	lyhyt	338
	501	HSS	"RN" Ø = 1-20 mm	höyrypäästetty	pitkä	340
	503	HSS-EC0	"RN" Ø = 2-13 mm	kirkas	pitkä	340
	511	HSS	"Forte" Ø = 2-13 mm	särmänitrattu	pitkä	340
	523	HSS	"Forte W" Ø = 2-13 mm	kirkas	pitkä	340



MAY KESTAG kierukkaporat

	Malli	Materiaali	Ø -alue	Pintakäsittely	Pituus	DIN
	391	HSS	"RN" Ø = 2-16 mm	höyrypäästetty	extra lyhyt	1897
	901	HSS-ECO	"PZ" Ø = 1-13 mm	kirkas	extra lyhyt	1897
	101	HSS	"RN" Ø = 2-13 mm	höyrypäästetty	extra pitkä	1869
	201	HSS	"Forte" Ø = 3-10 mm	särmänitrattu	extra pitkä	1869
	202	HSS	"RN" Ø = 5-100 mm	höyrypäästetty	lyhyt	345
	203	HSS-ECO	"RN" Ø = 8,5-50 mm	höyrypäästetty	lyhyt	345
	242	HSS	"RN" Ø = 10-50 mm	höyrypäästetty	lyhyt	346
	832	HSS-ECO8	"PZ" Ø = 8-40 mm	kirkas	lyhyt	WN103
	222	HSS	"RN" Ø = 5-50 mm	höyrypäästetty	pitkä	341
	262	HSS	"RN" Ø = 8-50 mm	höyrypäästetty	extra pitkä	1870

MAY KESTAG NC-porat

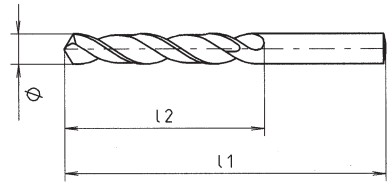
	Malli	Materiaali	Ø -alue
	554	HSS	90° Ø = 5-20 mm
	555	HSS	120° Ø = 5-20 mm

Keskiöporat

	Malli	Materiaali	Ø -alue	DIN
	021	HSS Ø = 1-10 mm	"A" - 60°	333
	031	HSS Ø = 1-10 mm	"R" - 60°	333

MAY KESTAG kierukkaporat 624

Pikaterästä, HSS
 DIN 338 RN
 Kärkikulma 118°
 Kierukka valssattu
 Yleiskäyttöön



LASTUAVAT
TYÖKALUT

Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
1,00	34	12	3,90	75	43	6,80	109	69	9,75	133	87
1,10	36	14	3,97	75	43	6,90	109	69	9,80	133	87
1,19	38	16	4,00	75	43	7,00	109	69	9,90	133	87
1,20	38	16	4,10	75	43	7,10	109	69	9,92	133	87
1,25	38	16	4,20	75	43	7,14	109	69	10,00	133	87
1,30	38	16	4,25	75	43	7,20	109	69	10,25	133	87
1,40	40	18	4,30	80	47	7,25	109	69	10,32	133	87
1,50	40	18	4,37	80	47	7,30	109	69	10,50	133	87
1,59	43	20	4,40	80	47	7,40	109	69	10,72	142	94
1,60	43	20	4,50	80	47	7,50	109	69	10,75	142	94
1,70	43	20	4,60	80	47	7,54	117	75	11,00	142	94
1,75	46	22	4,70	80	47	7,60	117	75	11,11	142	94
1,80	46	22	4,75	80	47	7,70	117	75	11,25	142	94
1,90	49	24	4,76	80	47	7,75	117	75	11,50	142	94
1,98	49	24	4,80	86	52	7,80	117	75	11,51	142	94
2,00	49	24	4,90	86	52	7,90	117	75	11,75	142	94
2,10	49	24	5,00	86	52	7,94	117	75	11,91	151	101
2,20	53	27	5,10	86	52	8,00	117	75	12,00	151	101
2,25	53	27	5,16	86	52	8,10	117	75	12,25	151	101
2,30	53	27	5,20	86	52	8,20	117	75	12,30	151	101
2,38	57	30	5,25	86	52	8,25	117	75	12,50	151	101
2,40	57	30	5,30	86	52	8,30	117	75	12,70	151	101
2,50	57	30	5,40	93	57	8,33	117	75	12,75	151	101
2,60	57	30	5,50	93	57	8,40	117	75	13,00	151	101
2,70	61	33	5,56	93	57	8,50	117	75	13,25	160	108
2,75	61	33	5,60	93	57	8,60	125	81	13,50	160	108
2,78	61	33	5,70	93	57	8,70	125	81	13,75	160	108
2,80	61	33	5,75	93	57	8,73	125	81	14,00	160	108
2,90	61	33	5,80	93	57	8,75	125	81	14,25	169	114
3,00	61	33	5,90	93	57	8,80	125	81	14,28	169	114
3,10	65	36	5,95	93	57	8,90	125	81	14,50	169	114
3,18	65	36	6,00	93	57	9,00	125	81	14,75	169	114
3,20	65	36	6,10	101	63	9,10	125	81	15,00	169	114
3,25	65	36	6,20	101	63	9,13	125	81	15,50	178	120
3,30	65	36	6,25	101	63	9,20	125	81	15,87	178	120
3,40	70	39	6,30	101	63	9,25	125	81	16,00	178	120
3,50	70	39	6,35	101	63	9,30	125	81			
3,57	70	39	6,40	101	63	9,40	125	81			
3,60	70	39	6,50	101	63	9,50	125	81			
3,70	70	39	6,60	101	63	9,52	133	87			
3,75	70	39	6,70	101	63	9,60	133	87			
3,80	75	43	6,75	109	69	9,70	133	87			

MAY KESTAG**kierukkaporat 601**

Pikaterästä, HSS

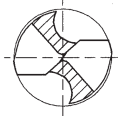
DIN 338 RN

AC-kärkiteroitus

Kärkikulma 118°

Tarkkuushiottu

Teräksille ja valuraudoille

**kobolttiporat 603**

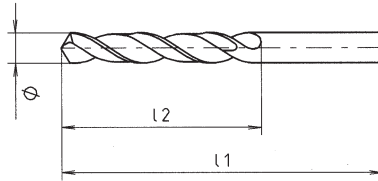
HSS-EC0 5% kobolttia

DIN 338 RN

AC-kärkiteroitus

Kärkikulma 130°

Tarkkuushiottu

Teräksille ja valuraudoille yli 800 N/mm²

Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
0,40	20	5	1,95	49	24	3,80	75	43	6,40	101	63	9,00	125	81
0,45	20	5	2,00	49	24	3,90	75	43	6,50	101	63	9,10	125	81
0,50	22	6	2,05	49	24	4,00	75	43	6,60	101	63	9,20	125	81
0,55	24	7	2,10	49	24	4,10	75	43	6,70	101	63	9,25	125	81
0,60	24	7	2,15	53	27	4,20	75	43	6,75	109	69	9,30	125	81
0,65	26	8	2,20	53	27	4,25	75	43	6,80	109	69	9,40	125	81
0,70	29	9	2,25	53	27	4,30	80	47	6,90	109	69	9,50	125	81
0,75	28	9	2,30	53	27	4,40	80	47	7,00	109	69	9,60	133	87
0,80	30	10	2,35	53	27	4,50	80	47	7,10	109	69	9,70	133	87
0,85	30	10	2,40	57	30	4,60	80	47	7,20	109	69	9,75	133	87
0,90	32	11	2,45	57	30	4,70	80	47	7,25	109	69	9,80	133	87
0,95	32	11	2,50	57	30	4,75	80	47	7,30	109	69	9,90	133	87
1,00	34	12	2,55	57	30	4,80	86	52	7,40	109	69	10,00	133	87
1,05	34	12	2,60	57	30	4,90	86	52	7,50	109	69	10,10	133	87
1,10	36	14	2,65	57	30	5,00	86	52	7,60	117	75	10,20	133	87
1,15	36	14	2,70	61	33	5,10	86	52	7,70	117	75	10,25	133	87
1,20	38	16	2,75	61	33	5,20	86	52	7,75	117	75	10,30	133	87
1,25	38	16	2,80	61	33	5,25	86	52	7,80	117	75	10,40	133	87
1,30	38	16	2,85	61	33	5,30	86	52	7,90	117	75	10,50	133	87
1,35	40	18	2,90	61	33	5,40	93	57	8,00	117	75	10,60	133	87
1,40	40	18	2,95	61	33	5,50	93	57	8,10	117	75	10,70	142	94
1,45	40	18	3,00	61	33	5,60	93	57	8,20	117	75	10,75	142	94
1,50	40	18	3,10	65	36	5,70	93	57	8,25	117	75	10,80	142	94
1,55	43	20	3,20	65	36	5,75	93	57	8,30	117	75	10,90	142	94
1,60	43	20	3,25	65	36	5,80	93	57	8,40	117	75	11,00	142	94
1,65	43	20	3,30	65	36	5,90	93	57	8,50	117	75	11,10	142	94
1,70	43	20	3,40	70	39	6,00	93	57	8,60	125	81	11,20	142	94
1,75	46	22	3,50	70	39	6,10	101	63	8,70	125	81	11,25	142	94
1,80	46	22	3,60	70	39	6,20	101	63	8,75	125	81	11,30	142	94
1,85	46	22	3,70	70	39	6,25	101	63	8,80	125	81			
1,90	46	22	3,75	70	39	6,30	101	63	8,90	125	81			

jatkuu ...

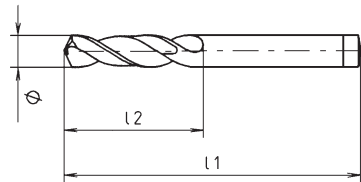
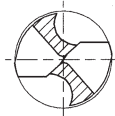
MAY KESTAG *kierukkaporat 601* *kobolttiporat 603*

... jatkoa

Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
11,40	142	94	12,20	151	101	12,90	151	101	15,00	169	114	18,50	198	135
11,50	142	94	12,25	151	101	13,00	151	101	15,25	178	120	19,00	198	135
11,60	142	94	12,30	151	101	13,25	160	108	15,50	178	120	19,50	205	140
11,70	142	94	12,40	151	101	13,50	160	108	15,75	178	120	20,00	205	140
11,75	142	94	12,50	151	101	13,75	160	108	16,00	178	120			
11,80	142	94	12,60	151	101	14,00	160	108	16,50	184	125			
11,90	151	101	12,70	151	101	14,25	169	114	17,00	184	125			
12,00	151	101	12,75	151	101	14,50	169	114	17,50	191	130			
12,10	151	101	12,80	151	101	14,75	169	114	18,00	191	130			

Lyhyet kierukkaporat 901

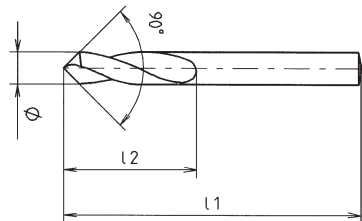
HSS-EC_o 5% kobolttia
DIN 1897 RN
AC-kärkiteroitus
Kärkikulma 118°
Koville materiaaleille



Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
1,00	26	6	3,00	46	16	5,00	62	26	7,00	74	34	9,00	84	40
1,10	28	7	3,10	49	18	5,10	62	26	7,10	74	34	9,10	84	40
1,20	30	8	3,20	49	18	5,20	62	26	7,20	74	34	9,20	84	40
1,30	30	8	3,30	49	18	5,30	62	26	7,30	74	34	9,30	84	40
1,40	32	9	3,40	52	20	5,40	66	28	7,40	74	34	9,40	84	40
1,50	32	9	3,50	52	20	5,50	66	28	7,50	74	34	9,50	84	40
1,60	34	10	3,60	52	20	5,60	66	28	7,60	79	37	9,60	89	43
1,70	34	10	3,70	52	20	5,70	66	28	7,70	79	37	9,70	89	43
1,80	36	11	3,80	55	22	5,80	66	28	7,80	79	37	9,80	89	43
1,90	36	11	3,90	55	22	5,90	66	28	7,90	79	37	9,90	89	43
2,00	38	12	4,00	55	22	6,00	66	28	8,00	79	37	10,00	89	43
2,10	38	12	4,10	55	22	6,10	70	31	8,10	79	37	10,20	89	43
2,20	40	13	4,20	55	22	6,20	70	31	8,20	79	37	10,50	89	43
2,30	40	13	4,30	58	24	6,30	70	31	8,30	79	37	11,00	95	47
2,40	43	14	4,40	58	24	6,40	70	31	8,40	79	37	11,50	95	47
2,50	43	14	4,50	58	24	6,50	70	31	8,50	79	37	12,00	102	51
2,60	43	14	4,60	58	24	6,60	70	31	8,60	84	40	12,50	102	51
2,70	46	16	4,70	58	24	6,70	70	31	8,70	84	40	13,00	102	51
2,80	46	16	4,80	62	26	6,80	74	34	8,80	84	40			
2,90	46	16	4,90	62	26	6,90	74	34	8,90	84	40			

MAY KESTAG NC-porat 554

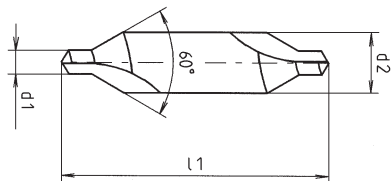
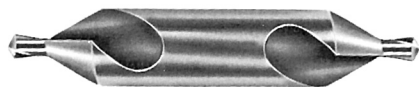
Kärkikulma 90°



Ø h8 mm	l1 mm	l2 mm
5,00	62	26,50
6,00	66	30,00
8,00	79	33,00
10,00	89	35,00
12,00	102	40,00
16,00	115	40,00
20,00	131	55,00

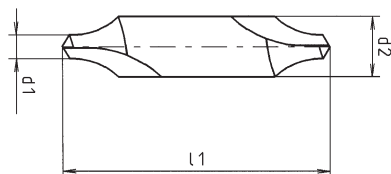
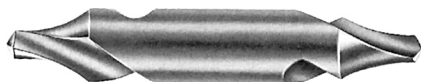
Keskiöporat 021

DIN 333 A



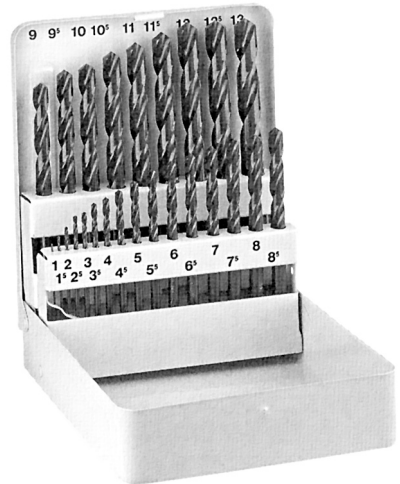
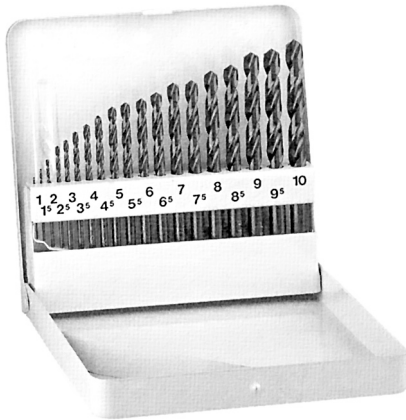
Ø d1 h8 mm	l1 mm	l2 mm
1,00	3,15	31,50
1,25	3,15	31,50
1,60	4,00	35,50
2,00	5,00	40,00
2,50	6,30	45,00
3,15	8,00	50,00
4,00	10,00	56,00
5,00	12,50	63,00
6,30	16,00	71,00
8,00	20,00	80,00
10,00	25,00	100,00

DIN 333 R



Porasarjat

May Kestag	KM 19	HSS valssattu	Ø 1,0 - 10,0	0,5 välein
	KM 25	HSS valssattu	Ø 1,0 - 13,0	0,5 välein
	KM 50	HSS	Ø 1,0 - 5,9	0,1 välein
	KM 41	HSS	Ø 6,0 - 10,0	0,1 välein
	KM 170	HSS	10 x Ø 1,0 - 8,0	0,5 välein
	”	”	5 x Ø 8,5 - 10,0	0,5 välein
ZPS	10085.04	HSS Koboltti	Ø 1,0 - 10,0	0,5 välein
	10085.05	HSS Koboltti	Ø 1,0 - 13,0	0,5 välein

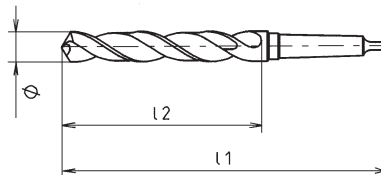
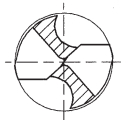


MAY KESTAG kartiovirtiset porat 202

HSS


DIN 345 RN

Kärkikulma 135°



Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2	Ø h8	l1	l2
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
5,00	133	52	22,00	248	150	39,00	349	200	62,00	427	240
5,50	138	57	22,50	253	155	39,50	349	200	63,00	427	240
6,00	138	57	23,00	253	155	40,00	349	200	64,00	432	245
6,50	144	63	23,50	276	155	40,50	354	205	65,00	432	245
7,00	150	69	24,00	281	160	41,00	354	205	66,00	432	245
7,50	150	69	24,50	281	160	41,50	354	205	67,00	432	245
8,00	156	75	25,00	281	160	42,00	354	205	68,00	437	250
8,50	156	75	25,50	286	165	42,50	354	205	69,00	437	250
9,00	162	81	26,00	286	165	43,00	359	210	70,00	437	250
9,50	162	81	26,50	286	165	43,50	359	210	71,00	437	250
10,00	168	87	27,00	291	170	44,00	359	210	72,00	442	255
10,50	168	87	27,50	291	170	44,50	359	210	73,00	442	255
11,00	175	94	28,00	291	170	45,00	359	210	74,00	442	255
11,50	175	94	28,50	296	175	45,50	364	215	75,00	442	255
12,00	182	101	29,00	296	175	46,00	364	215	76,00	447	260
12,50	182	101	29,50	296	175	46,50	364	215	77,00	514	260
13,00	182	101	30,00	296	175	47,00	364	215	78,00	514	260
13,50	189	108	30,50	301	180	47,50	364	215	79,00	514	260
14,00	189	108	31,00	301	180	48,00	369	220	80,00	514	260
14,50	212	114	31,50	301	180	48,50	369	220	81,00	519	265
15,00	212	114	32,00	334	185	49,00	369	220	82,00	519	265
15,50	218	120	32,50	334	185	49,50	369	220	83,00	519	265
16,00	218	120	33,00	334	185	50,00	369	220	84,00	519	265
16,50	223	125	33,50	334	185	51,00	412	225	85,00	519	265
17,00	223	125	34,00	339	190	52,00	412	225	86,00	524	270
17,50	228	130	34,50	339	190	53,00	412	225	87,00	524	270
18,00	228	130	35,00	339	190	54,00	417	230	88,00	524	270
18,50	233	135	35,50	339	190	55,00	417	230	89,00	524	270
19,00	233	135	36,00	344	195	56,00	417	230	90,00	524	270
19,50	238	140	36,50	344	195	57,00	422	235	95,00	529	275
20,00	238	140	37,00	344	195	58,00	422	235	100,00	534	280
20,50	243	145	37,50	344	195	59,00	422	235			
21,00	243	145	38,00	349	200	60,00	422	235			
21,50	248	150	38,50	349	200	61,00	427	240			




MAY KESTAG käsikalvaimet

	Malli	Materiaali	Ø -alue	Nimitys	DIN	Toleranssit		
						d1	a	d2
	3020	HSS	Käsikalvaimet B Ø = 2-50 mm		206	H7	h12	e9


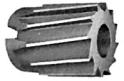


Konekalvaimet

	Malli	Materiaali	Ø -alue	Nimitys	DIN	Toleranssit		
						d1	a	d2
	3060	HSS-E	Konekalvaimet A + C Ø = 1,4-20 mm		212	H7	h9	
	3080	HSS-E	Konekalvaimet B + D Ø = 1,4-20 mm		212	H7	h9	
	3110	HSS-E	Konekalvaimet E Ø = 3-20 mm		212	H7	h9	
	3120	HSS-E	Konekalvaimet A Mk-varrella Ø = 3-50 mm		208	H7		
	3130	HSS-E	Konekalvaimet B Mk-varrella Ø = 3-50 mm		208	H7		
	3150	HSS-E	Konekalvaimet C Mk-varrella Ø = 5-32 mm		208	H7		
	3270	HSS	Niitinreikäkalvaimet Mk-varrella Ø = 6,4-40 mm		311	k11		

MAY KESTAG kartiokalvaimet

	Malli	Materiaali	Ø -alue	Nimitys	Toleranssit			
					DIN	d1	a	d2
	3300	HSS		Kartiokalvaimet B 1:50 Ø = 3-50 mm	9		h12	
	3320	HSS-E		Konekartiokalvaimet 1:50 Ø = 3-12 mm	2179			
	3340	HSS-E		Konekartiokalvaimet Mk-varrella 1:50 Ø = 12-50 mm	2180			

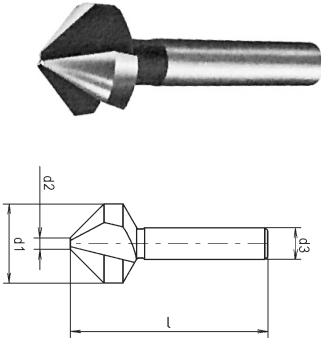
Irtovartiset kalvaimet

	Malli	Materiaali	Ø -alue	Nimitys	Toleranssit			
					DIN	d1	a	d2
	3470	HSS-E		Irtovartiset kalvaimet A Reikä 1:30 Ø = 25-100 mm	219	H7		
	3480	HSS-E		Irtovartiset kalvaimet B Reikä 1:30 Ø = 25-100 mm	219	H7		
	3490	HSS-E		Irtovartiset kalvaimet C Reikä 1:30 Ø = 25-100 mm	219	H7		
	2520			Irtovarret kalvaimille Mk-varrella Kartio 1:30	217A			

MAY KESTAG kärkiupottimet 90° 2290

HSS-EC₀
 DIN 335 C
 Z = 3

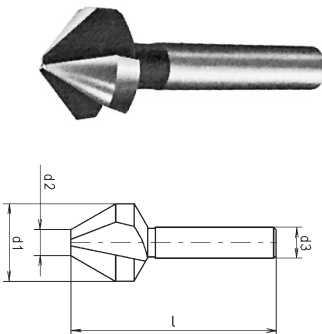
2297 = TiAlN-pinnoitettu



d1 mm	d2 mm	d3 _{h9} mm	l mm
4,3	1,30	4	40
5	1,50	4	40
5,3	1,50	4	40
6	1,50	5	45
6,3	1,50	5	45
8	2,00	6	50
8,3	2,00	6	50
9,4	2,20	6	50
10	2,50	6	50
10,4	2,50	6	50
11,5	2,80	8	56
12,4	2,80	8	56
13,4	2,90	8	56
15	3,20	10	60
16,5	3,20	10	60
19	3,50	10	63
20,5	3,50	10	63
23	3,80	10	67
25	3,80	10	67
31	4,20	12	71

Kärkiupottimet 60° 2280

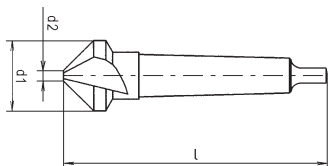
HSS-EC₀
 DIN 334 C
 Z = 3



d1 mm	d2 mm	d3 _{h9} mm	l mm
6,3	1,60	5	45
8	2,00	6	50
12,5	3,20	8	56
16	4,00	10	63
20	5,00	10	67
25	6,30	10	71

MAY KESTAG kartiovirtiset kärkiupottimet 90° 2330

HSS-EC₀
DIN 335 D
Z = 3

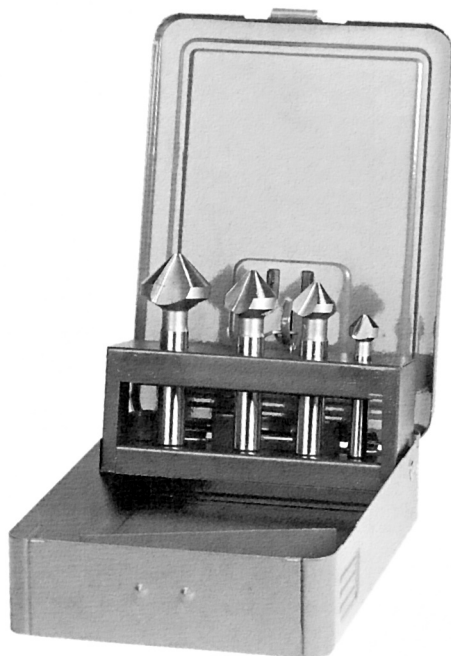


d1 mm	d2 mm	l mm	MK Nr.
15	3,20	85	1
16,5	3,20	85	1
19	3,20	100	2
20,5	3,50	100	2
23	3,80	106	2
25	3,80	106	2
28	4,00	112	2
31	4,20	112	2
34	4,50	118	2
37	4,80	118	2
40	10,00	140	3

Kärkiupottinsarjat

DIN 335 C

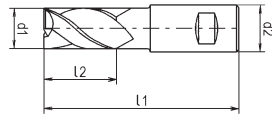
Sisältö: Ø 10,4
Ø 16,5
Ø 20,5
Ø 25,0



KESTAG kiilaurajyrsimet

Poraavat DIN 327
2-leikkuiset

1026 = HSS-EC_o 8% Co
1027 = TiAlN-pinnoitettu
1086 = pitkä HSS-EC_o 8% Co
220418 = ZPS HSS-EC_o 8% Co

**1026****1027****220418**

d1 _{e8}	l2	l1	d2 _{h6}	d1 _{e8}	l2	l1	d2 _{h6}
2	4	48	6	23	22	88	20
2,5	5	49	6	24	26	102	25
3	5	49	6	25	26	102	25
3,5	6	50	6	26	26	102	25
4	7	51	6	28	26	102	25
4,5	7	51	6	30	26	102	25
5	8	52	6	32	32	112	32
5,5	8	52	6	34	32	112	32
6	8	52	6	35	32	112	32
6,5	10	60	10	36	32	112	32
7	10	60	10	38	38	118	32
7,5	10	60	10	40	38	118	32
8	11	61	10				
8,5	11	61	10				
9	11	61	10				
9,5	11	61	10				
10	13	63	10				
10,5	13	70	12				
11	13	70	12				
11,5	13	70	12				
12	16	73	12				
13	16	73	12				
14	16	73	12				
15	16	73	12				
16	19	79	16				
17	19	79	16				
18	19	79	16				
19	19	79	16				
20	22	88	20				
21	22	88	20				
22	22	88	20				

1086

d1 _{e8}	l2	l1	d2 _{h6}
4	11	63	6
5	13	68	6
6	13	68	6
7	16	80	10
8	19	88	10
9	19	88	10
10	22	95	10
11	22	102	12
12	26	110	12
13	26	110	12
14	26	110	12
15	26	110	12
16	32	123	16
18	32	123	16
20	38	141	20
20	38	129	16
22	38	141	20
22	38	159	25
24	45	166	25
25	45	166	25
26	45	166	25
28	45	166	25
30	45	166	25
32	53	186	32
34	53	186	32
35	53	186	32
36	53	186	32
38	63	196	32
40	63	196	32
45	63	196	32
50	75	208	32

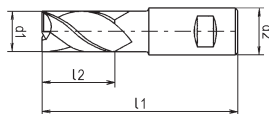
KESTAG kiilaurajyrsimet

Poraavat
3-leikkuiset

1156 = HSS-EC_o 8% Co

1186 = DIN 844 N HSS-EC_o 8% Co

1187 = DIN 844 N TiAlN-pinnoitettu



1156

d1 _{e8}	l2	l1	d2 _{h6}
3	5	49	6
4	7	51	6
5	8	52	6
6	8	52	6
7	10	60	10
8	11	61	10
10	13	63	10
12	16	73	12
14	16	73	12
16	19	79	16
18	19	79	16
20	22	88	20
20	22	82	16
22	22	88	20
22	22	102	25
24	26	102	25
25	26	102	25

1186

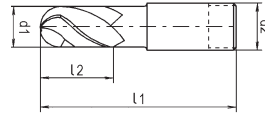
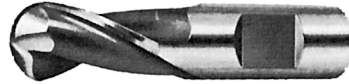
1187

d1 _{e8}	l2	l1	d2 _{h6}
2	7	51	6
2,5	8	52	6
3	8	52	6
3,5	10	54	6
4	11	55	6
4,5	11	55	6
5	13	57	6
5,5	13	57	6
6	13	57	6
6,5	16	66	10
7	16	66	10
8	19	69	10
8,5	19	69	10
9	19	69	10
10	22	72	10
11	22	79	12
12	26	83	12
13	26	83	12
14	26	83	12
15	26	83	12
16	32	92	16
18	32	92	16
20	38	104	20
22	38	104	20
24	45	121	25
25	45	121	25

ZPS varsijyrsimet

Pallopäiset
2-leikkuiset

510418 = HSS-EC_o TIALN-pinnoitettu



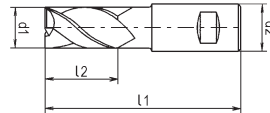
d1 _{h10}	l2	l1	d2 _{h6}
4	7	51	6
5	8	52	6
6	8	52	6
7	10	60	10
8	11	61	10
9	11	61	10
10	13	63	10
11	13	70	12
12	16	73	12
13	16	73	12
14	16	73	12
15	16	73	12
16	19	49	16
18	19	79	16
20	22	88	20
22	22	88	20
24	26	102	25
25	26	102	25
28	26	102	25
30	26	102	25
32	32	112	32

KESTAG kertakäyttöjyrsimet

Poraavat
3-leikkuiset

1246 = lyhyt HSSE-EC_o 8% Co

1256 = pitkä HSSE-EC_o 8% Co



1246

d1 _{k12}	l2	l1	d2 _{h6}
1,5	3	34	6
2	4	35	6
2,5	5	36	6
3	5	36	6
3,5	6	37	6
4	7	38	6
4,5	7	38	6
5	8	39	6
5,5	8	39	6
6	8	39	6

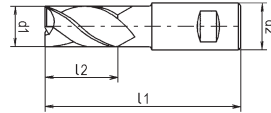
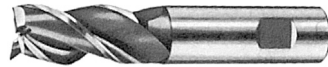
1256

d1 _{k12}	l2	l1	d2 _{h6}
2	7	38	6
2,5	8	39	6
3	8	39	6
3,5	10	41	6
4	11	42	6
4,5	11	42	6
5	13	44	6
5,5	13	44	6
6	13	44	6

ZPS varsijyrsimet

Poraavat DIN 844
3-leikkuiset

140408 = HSS-Co 5% Co
111405 = pitkä HSS-Co 5% Co

**140408**

d1 _{k10}	l2	l1	d2 _{h6}
4	11	55	6
5	13	57	6
6	13	57	6
7	16	66	10
8	19	69	10
9	19	69	10
10	22	72	10
11	22	79	12
12	26	83	12
13	26	83	12
14	26	83	12
15	26	83	12
16	32	92	16
18	32	92	16
20	38	104	20

111405

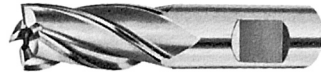
d1 _{k10}	l2	l1	d2 _{h6}
6	24	68	6
7	30	80	10
8	38	88	10
9	38	88	10
10	45	95	10
12	53	110	12
14	53	110	12
16	63	123	16
18	63	123	16
20	75	141	20

KESTAG varsijyrsimet

Poraavat < 22 mm DIN 844

4-leikkuiset < 22 mm

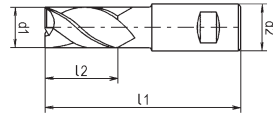
6-leikkuiset > 22 mm



1816 = HSS-EC_o 8% Co

1817 = TiAlN-pinnoitettu

1786 = HSS-EC_o 8% Co 40° nousu



1816

1817 ≤ 25

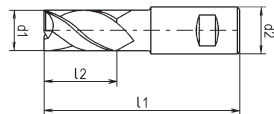
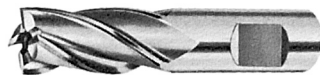
d1 _{k10}	l2	l1	d2 _{h6}	Z
2	7	51	6	3
2,5	8	52	6	3
3	8	52	6	4
3,5	10	54	6	4
4	11	55	6	4
4,5	11	55	6	4
5	13	57	6	4
5,5	13	57	6	4
6	13	57	6	4
6,5	16	66	10	4
7	16	66	10	4
7,5	16	66	10	4
8	19	69	10	4
8,5	19	69	10	4
9	19	69	10	4
9,5	19	69	10	4
10	22	72	10	4
11	22	79	12	4
12	26	83	12	4
13	26	83	12	4
14	26	83	12	4
15	26	83	12	4
16	32	92	16	4
18	32	92	16	4
20	38	104	20	4
22	38	104	20	6
24	45	121	25	6
25	45	121	25	6
28	45	121	25	6
30	45	121	25	6
32	53	133	32	6

1786

d1 _{k10}	l2	l1	d2 _{h6}	Z
3	8	52	6	4
4	11	55	6	4
5	13	57	6	4
6	13	57	6	4
8	19	69	10	4
10	22	72	10	4
12	26	83	12	4
14	26	83	12	4
16	32	92	16	4
18	32	92	16	4
20	38	104	20	4
22	38	104	20	6
25	45	121	25	6

ZPS varsijyrsimet

DIN 844

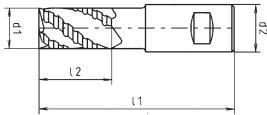
140218 = HSS-EC_o 8% Co

$d1_{k10}$	l_2	l_1	$d2_{h6}$	Z
2	7	51	6	3
2,5	8	52	6	3
3	8	52	6	4
3,5	10	54	6	4
4	11	55	6	4
4,5	11	55	6	4
5	13	57	6	4
6	13	57	6	4
7	16	66	10	4
8	19	69	10	4
9	19	69	10	4
10	22	72	10	4
11	22	79	12	4
12	26	83	12	4
13	26	83	12	4
14	26	83	12	4
15	26	83	12	4
16	32	92	16	4
18	32	92	16	4
20	38	104	20	4
22	38	104	20	5
24	45	121	25	5
25	45	121	25	5
28	45	121	25	5
30	45	121	25	6
32	53	133	32	6
36	53	133	32	6
40	63	143	32	6
40	63	155	40	6

KESTAG rouhintavarsijyrsimet

Poraavat
3-leikkuiset

2216 = Tasaharjainen NF
HSS-EC0 8% Co



DIN 844 B
NF



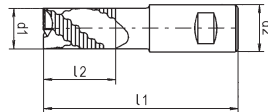
d1 _{k12}	l2	l1	d2 _{h6}
6	13	57	6
7	16	66	10
8	19	69	10
9	19	69	10
10	22	72	10
11	22	79	12
12	26	83	12
13	26	83	12
14	26	83	12
15	26	83	12
16	32	92	16
18	32	92	16
20	38	104	20
20	38	98	16
22	38	104	20
22	38	114	25
25	45	121	25
28	45	121	25
30	45	121	25
32	53	133	32

Poraavat DIN 844

2047 = pyöreäharjainen HR TIALN-pinnoitettu
2287 = pyöreäharjainen NR TIALN-pinnoitettu
124618 = ZPS pyöreäharjainen NR HSS-Co 8% Co

2047 ≤ 32
2287 ≤ 25
124618

d1 _{k10}	l2	l1	d2 _{h6}	Z
6	13	57	6	3
8	19	69	10	4
10	22	72	10	4
12	26	83	12	4
14	26	83	12	4
16	32	92	16	4
18	32	92	16	4
20	38	104	20	4
22	38	104	20	5
25	45	121	25	5
30	45	121	25	5
32	53	133	32	6
40	63	143	32	6



DIN 844 B
HR



DIN 844 B
NR



KESTAG rouhintavarsijyrsimet

DIN 844

2026 = pyöreäharjainen NR HSS-Co 8% Co

2156 = tasaharjainen NF HSS-Co 8% Co

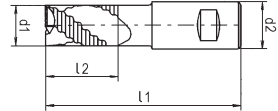
142218 = ZPS tasaharjainen NF HSS-Co 8% Co

LASTUAVAT
TYÖKALUT

2026

2156 ≤ 40

142218 ≤ 40



d1 _{k10}	l2	l1	d2 _{h6}	Z
5	13	57	6	3
6	13	57	6	3
7	16	66	10	3
8	19	69	10	4
9	19	69	10	4
10	22	72	10	4
11	22	79	12	4
12	26	83	12	4
13	26	83	12	4
14	26	83	12	4
15	26	83	12	4
16	32	92	16	4
18	32	92	16	4
20	38	104	20	4
20	38	98	16	4
22	38	104	20	5
22	38	114	25	5
24	45	121	25	5
25	45	121	25	5
26	45	121	25	5
28	45	121	25	5
30	45	121	25	5
32	53	133	32	5
34	53	133	32	6
35	53	133	32	6
36	53	133	32	6
38	63	143	32	6
40	63	143	32	6
45	63	155	40	6
45	63	143	32	6
50	75	167	40	6
50	75	155	32	6
63	90	182	40	8

DIN 844 B
NRDIN 844 B
NF