

# Mikromill



 **Dümmel**<sup>®</sup>  
WERKZEUGFABRIK



# MIKROMILL

## Nut- und Formzirkularfräsen

groove milling  
by circular interpolation

# Übersicht

summary



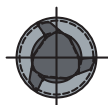
**MA6 / MB6 + MA8 / MB8**  
**Nutfräsen allgemein**  
ab Bohrungs-Ø 6 mm

*MA6 / MB6 + MA8 / MB8* ..... 3  
*groove milling general use*  
*min. bore Ø 6 mm*



**MA6 / MB6 + MA8 / MB8**  
**Vorwärts- und Rückwärtsfasen**  
ab Bohrungs-Ø 6 mm

*MA6 / MB6 + MA8 / MB8* ..... 5  
*forward and backward*  
*chamfering*  
*min. bore Ø 6 mm*



**MA3 + MA5**  
**metrisches ISO-Gewinde**  
ab Bohrungs-Ø 1,25 mm

*MA3 + MA5* ..... 6  
*metric standard threading*  
*min. bore Ø 1,25 mm*



**MA6 / MB6 + MA8 / MB8**  
**metrisches ISO-Gewinde**  
ab Bohrungs-Ø 6 mm

*MA6 / MB6 + MA8 / MB8* ..... 7  
*metric standard threading*  
*min. bore Ø 6 mm*

**Preisliste** ..... 8  
*pricelist*

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# MA6 + MA8 Nutfräsen allgemein

ab Bohrungs-Ø 6 mm

## MIKROMILL

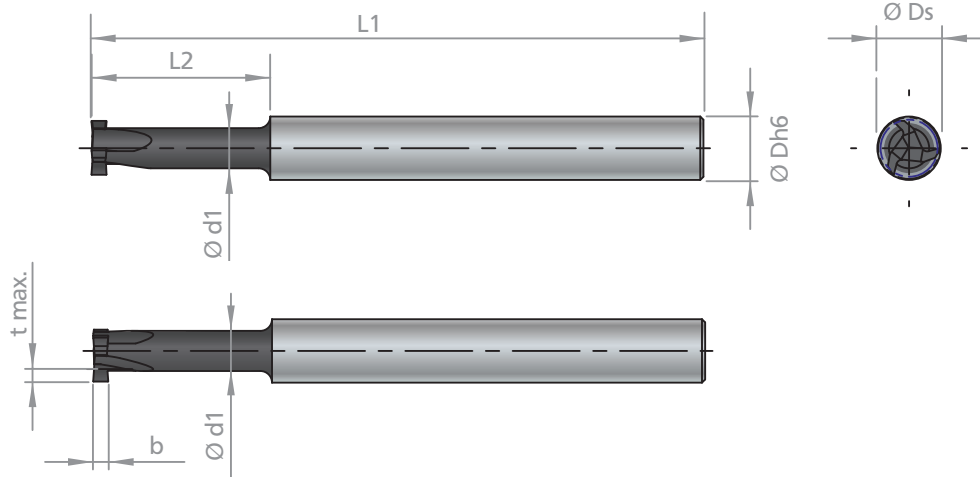
Nut- und Formzirkularfräsen



MA6/MB6 + MA8/MB8  
groove milling general use

min. bore Ø 6 mm

groove milling  
by circular interpolation



Abmessungen in mm

dimensions in mm

Version A



Schaft nach DIN 6535A

version A toolholder DIN 6535A

Bestell-Nr. part number	D min.	b ±0.02	L2	L1	Ø dh6	Ø d1	Ø DS	t max.	Schneid- denzahl cutting edge
MA6.0070.00-15	6.0	0.7	15.2	58.0	6.0	3.8	5.8	0.8	3
MA6.0080.00-15	6.0	0.8	15.2	58.0	6.0	3.8	5.8	0.8	3
MA6.0090.00-15	6.0	0.9	15.2	58.0	6.0	3.8	5.8	0.8	3
MA6.0100.00-15	6.0	1.0	15.2	58.0	6.0	3.8	5.8	0.8	3
MA6.0150.00-15	6.0	1.5	15.2	58.0	6.0	3.8	5.8	0.8	3
MA8.0070.00-25	8.0	0.7	25.4	68.0	8.0	5.0	7.8	1.2	3
MA8.0080.00-25	8.0	0.8	25.4	68.0	8.0	5.0	7.8	1.2	3
MA8.0090.00-25	8.0	0.9	25.4	68.0	8.0	5.0	7.8	1.2	3
MA8.0100.00-25	8.0	1.0	25.4	68.0	8.0	5.0	7.8	1.2	3
MA8.0150.00-25	8.0	1.5	25.4	68.0	8.0	5.0	7.8	1.2	3
MA8.0200.00-25	8.0	2.0	25.4	68.0	8.0	5.0	7.8	1.2	3

Bestellbeispiel: für Sorte AL41F:  
MA6.0070.00-15/AL41F

order-example: grade AL41F  
MA6.0070.00-15/AL41F



## MIKROMILL

Nut- und Formzirkularfräsen

groove milling  
by circular interpolation

## MB6 + MB8 Nutfräsen allgemein

MA6/MB6 + MA8/MB8  
groove milling general use

ab Bohrungs-Ø 6 mm

min. bore Ø 6 mm

Version B



Schaft nach DIN 6535B

version B toolholder DIN 6535B

Bestell-Nr.  
part number

D min. b  
±0.02

L2

L1

Ø dh6

Ø d1

Ø DS

t max.

Schneid-  
denzahl  
cutting edge

MB6.0070.00-15	6.0	0.7	15.2	58.0	6.0	3.8	5.8	0.8	3
MB6.0080.00-15	6.0	0.8	15.2	58.0	6.0	3.8	5.8	0.8	3
MB6.0090.00-15	6.0	0.9	15.2	58.0	6.0	3.8	5.8	0.8	3
MB6.0100.00-15	6.0	1.0	15.2	58.0	6.0	3.8	5.8	0.8	3
MB6.0150.00-15	6.0	1.5	15.2	58.0	6.0	3.8	5.8	0.8	3
MB8.0070.00-25	8.0	0.7	25.4	68.0	8.0	5.0	7.8	1.2	3
MB8.0080.00-25	8.0	0.8	25.4	68.0	8.0	5.0	7.8	1.2	3
MB8.0090.00-25	8.0	0.9	25.4	68.0	8.0	5.0	7.8	1.2	3
MB8.0100.00-25	8.0	1.0	25.4	68.0	8.0	5.0	7.8	1.2	3
MB8.0150.00-25	8.0	1.5	25.4	68.0	8.0	5.0	7.8	1.2	3
MB8.0200.00-25	8.0	2.0	25.4	68.0	8.0	5.0	7.8	1.2	3

Bestellbeispiel: für Sorte AL41F:  
MB6.0070.00-15/AL41F

order-example: grade AL41F  
MB6.0070.00-15/AL41F

# MA6/MB6 + MA8/MB8 Vorwärts- und Rückwärtsfasen

ab Bohrungs-Ø 6 mm

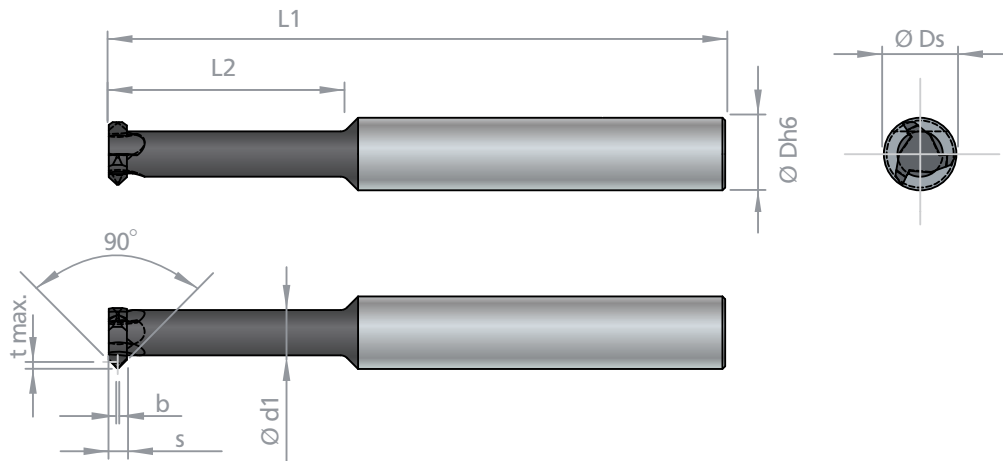
MA6/MB6 + MA8/MB8  
forward and backward chamfering

min. bore Ø 6 mm

## MIKROMILL

Nut- und Formzirkularfräsen

groove milling  
by circular interpolation



Abmessungen in mm

dimensions in mm

### Version A



Schaft nach DIN 6535A

version A toolholder DIN 6535A

Bestell-Nr. part number	D min.	b	L2	L1	s	Ø dh6	Ø d1	Ø DS	t max.	Schneidenzahl cutting edge
MA6.4545.02-15	6.0	0.2	15.2	58.0	2.0	6.0	4.2	5.8	0.8	3
MA6.4545.02-25	6.0	0.2	25.4	68.0	2.0	6.0	4.2	5.8	0.8	3
MA8.4545.02-25	8.0	0.2	25.4	68.0	2.0	8.0	5.0	7.8	1.2	3
MA8.4545.02-35	8.0	0.2	35.6	78.0	2.0	8.0	5.0	7.8	1.2	3

### Version B



Schaft nach DIN 6535B

version B toolholder DIN 6535B

Bestell-Nr. part number	D min.	b	L2	L1	s	Ø dh6	Ø d1	Ø DS	t max.	Schneidenzahl cutting edge
MB6.4545.02-15	6.0	0.2	15.2	58.0	2.0	6.0	4.2	5.8	0.6	3
MB6.4545.02-25	6.0	0.2	25.4	68.0	2.0	6.0	4.2	5.8	0.6	3
MB8.4545.02-25	8.0	0.2	25.4	68.0	2.0	8.0	5.0	7.8	1.2	3
MB8.4545.02-35	8.0	0.2	35.6	78.0	2.0	8.0	5.0	7.8	1.2	3

Bestellbeispiel: für Sorte AL41F:  
MA6.4545.02-15/AL41F

order-example: grade AL41F  
MA6.4545.02-15/AL41F



# MIKROMILL

Nut- und Formzirkularfräsen

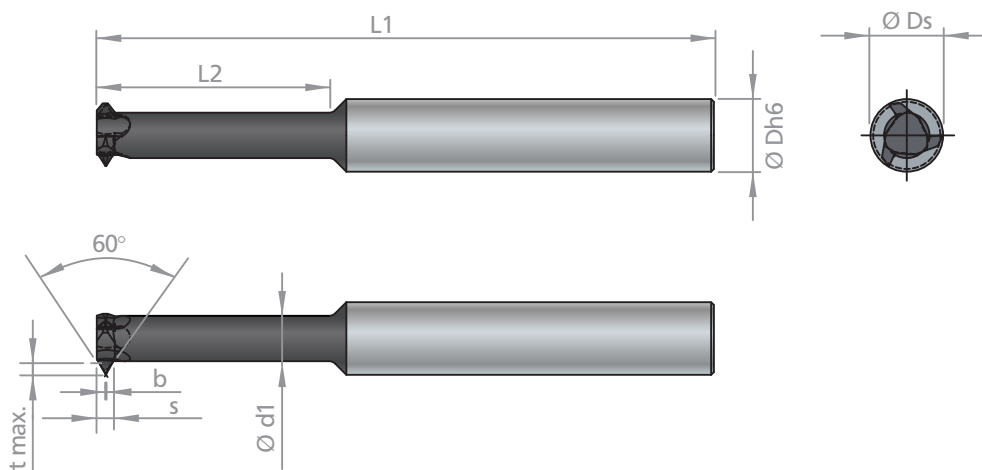
groove milling  
by circular interpolation

# MA3/MA5 metrisches ISO-Gewinde

im Teilprofil  
ab Bohrungs-Ø 1,25 mm

MA3/MA5  
metric standard threading

internal partial profile  
min. bore Ø 1,25 mm



Abmessungen in mm

dimensions in mm

Version A



Schaft nach DIN 6535A

version A toolholder DIN 6535A

Bestell-Nr. part number	Gewinde thread	D min.	Steigung P	L2	L1	b	s	t max.	Ø dh6	Ø d1	Ø DS	Schneid- denzahl cutting edge
MA3.0035.01-4	M1.6	1.4	0.35	4.1	32	0.04	0.4	0.15	3.0	0.6	1.2	3
MA3.0035.01-5	M1.8	1.6	0.35	5.1	32	0.04	0.4	0.18	3.0	0.7	1.4	3
MA3.0040.01-5	M2.0	1.7	0.40	5.1	32	0.06	0.6	0.22	3.0	0.8	1.5	4
MA3.0045.01-6	M2.5	2.2	0.45	6.1	32	0.06	0.6	0.25	3.0	1.2	2.0	4
MA3.0050.01-7	M3.0	2.6	0.50	7.1	32	0.06	0.6	0.27	3.0	1.6	2.4	4
MA3.0060.01-8	M3.5	3.0	0.60	8.1	32	0.08	0.8	0.33	3.0	1.8	2.8	4
MA5.0070.01-9	M4.0	3.3	0.70	9.1	44	0.09	0.8	0.38	5.0	2.0	3.1	4
MA5.0080.01-12	M5.0	4.3	0.80	12.2	44	0.10	1.0	0.43	5.0	2.3	4.1	4
MA5.0100.01-15	M6.0	5.1	1.00	15.2	44	0.13	1.2	0.54	5.0	3.3	4.5	4

für hochfeste Werkstoffe

- Titan
- gehärtete Werkstoffe bis 65 HRC

Bestellbeispiel: für Sorte AL41F:  
MA3.0035.01-4/AL41F

order-example: grade AL41F  
MA3.0035.01-4/AL41F

# MA6/MB6 + MA8/MB8 metrisches ISO-Gewinde

im Teilprofil  
ab Bohrungs-Ø 6 mm

# MIKROMILL

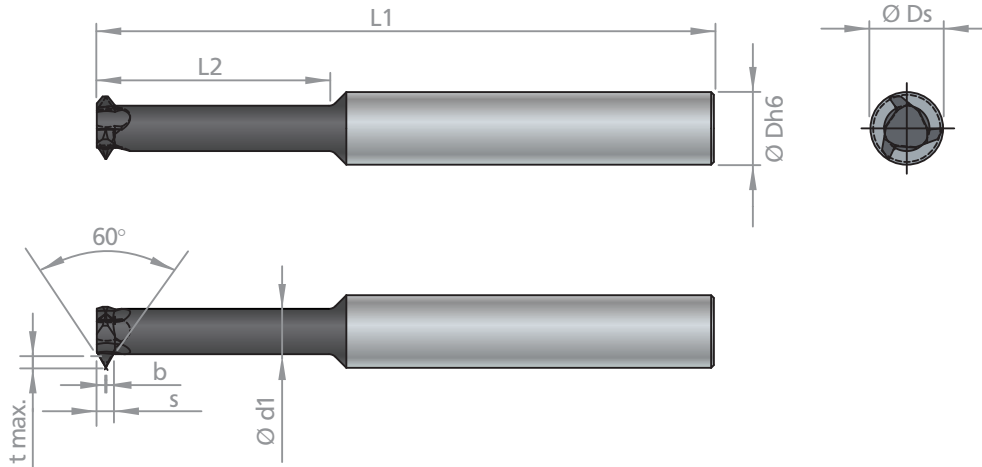
Nut- und Formzirkularfräsen



MA6/MB6 MA8/MB8  
metric standard threading

internal partial profile  
min. bore Ø 6 mm

groove milling  
by circular interpolation



Abmessungen in mm

dimensions in mm

## Version A



Schaft nach DIN 6535A

version A toolholder DIN 6535A

Bestell-Nr. part number	D min.	Steigung P	L2	L1	b	s	t max.	Ø dh6	Ø d1	Ø DS	Schneid- denzahl cutting edge
MA6.0815.01-15	6.0	0.5 - 1.5	15.2	58.0	0.06	2.0	0.91	6.0	3.5	5.8	3
MA8.0815.01-25	8.0	0.5 - 1.5	25.4	68.0	0.06	2.0	0.91	8.0	5.5	7.8	3
MA8.1020.01-25	8.0	1.0 - 2.0	25.4	68.0	0.12	2.0	1.19	8.0	5.0	7.8	3

## Version B



Schaft nach DIN 6535B

version B toolholder DIN 6535B

Bestell-Nr. part number	D min.	Steigung P	L2	L1	b	s	t max.	Ø dh6	Ø d1	Ø DS	Schneid- denzahl cutting edge
MB6.0815.01-15	6.0	0.5 - 1.5	15.2	58.0	0.06	2.0	0.91	6.0	3.5	5.8	3
MB8.0815.01-25	8.0	0.5 - 1.5	25.4	68.0	0.06	2.0	0.91	8.0	5.5	7.8	3
MB8.1020.01-25	8.0	1.0 - 2.0	25.4	68.0	0.12	2.0	1.19	8.0	5.0	7.8	3

Bestellbeispiel: für Sorte AL41F:  
MA6.0815.01-15/AL41F

order-example: grade AL41F  
MA6.0815.01-15/AL41F