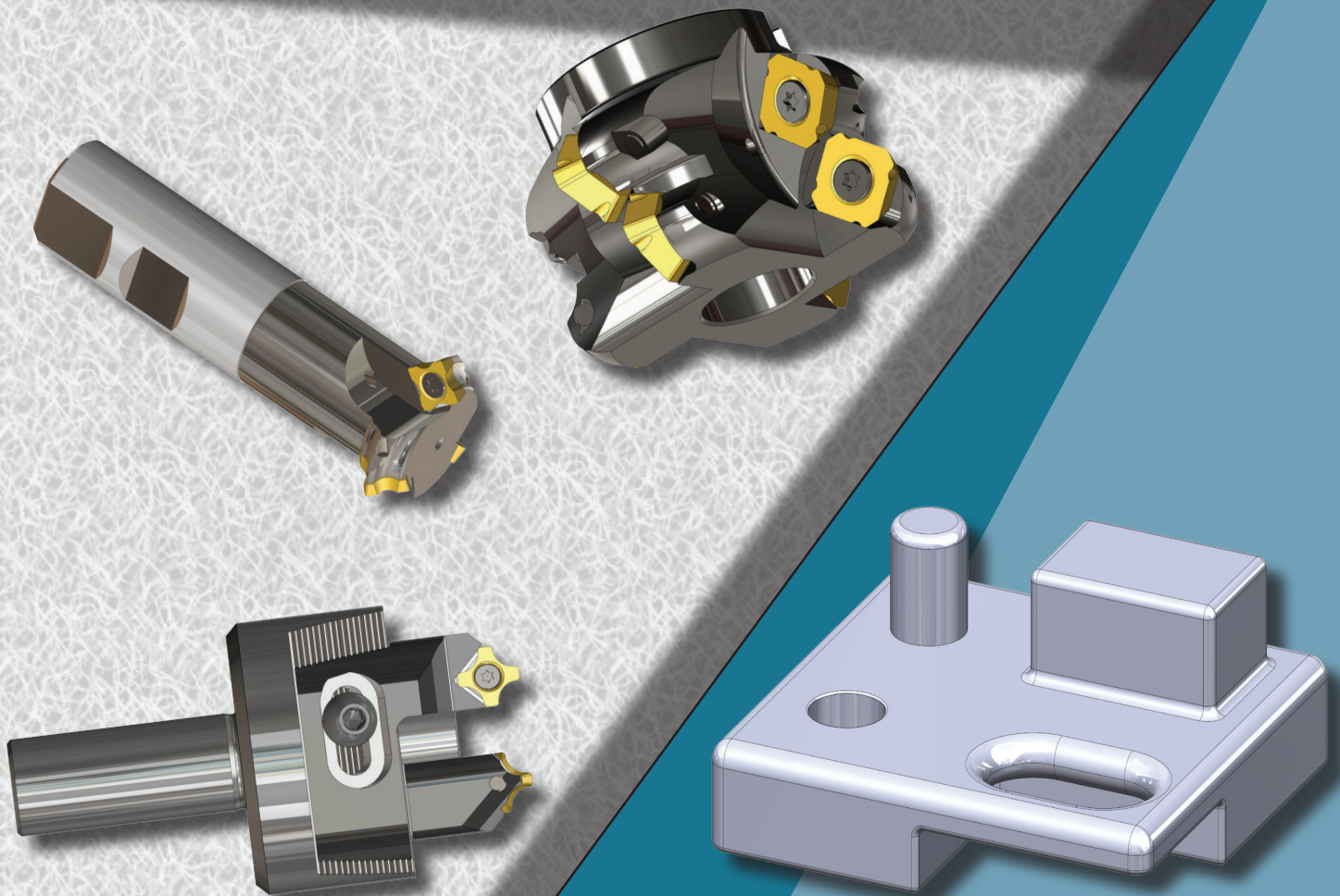


DAS THE RADIENPROGRAMM RADII PROGRAM

Serie 3016 - Serie 3017 - Serie 3018



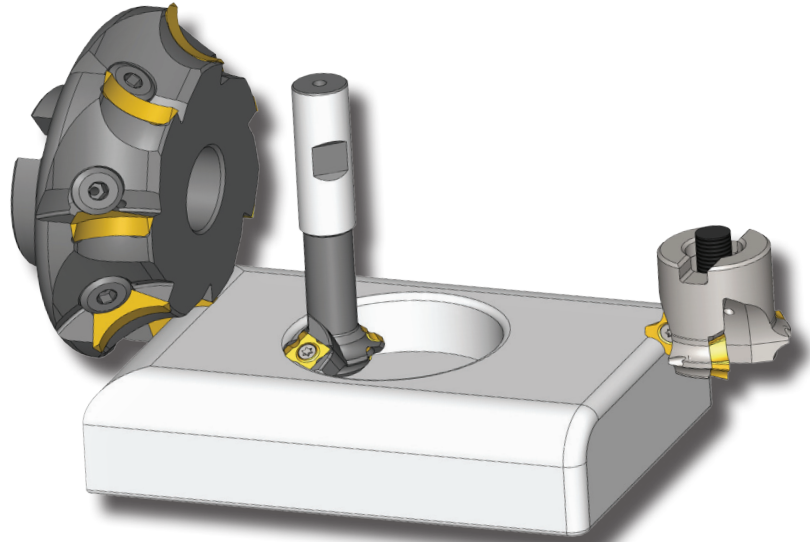
MAIER • Präzisionswerkzeuge
GmbH

Mail: info@maier-tools.de
www.maier-tools.de

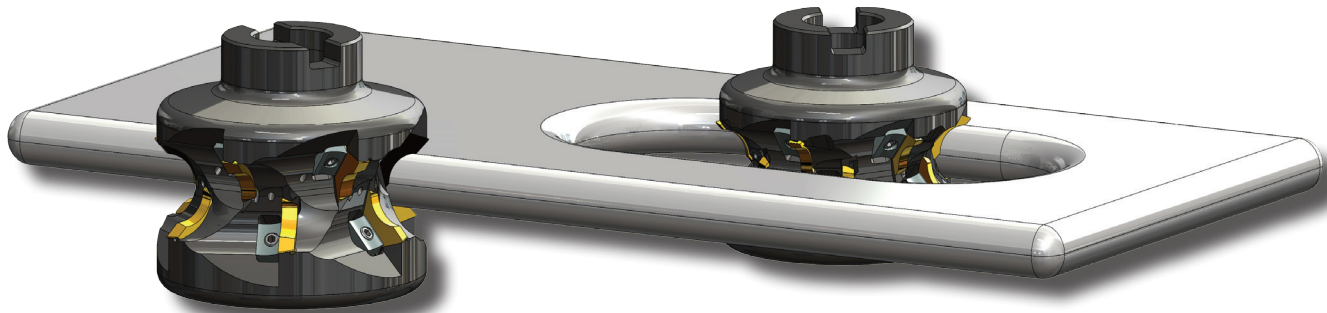
Gewerbepark Siebenkofen 2
94363 Oberschneiding
Tel. : +49 (0) 9426 / 80 26 50
Fax : +49 (0) 9426 / 80 26 51

Anwendungen applications

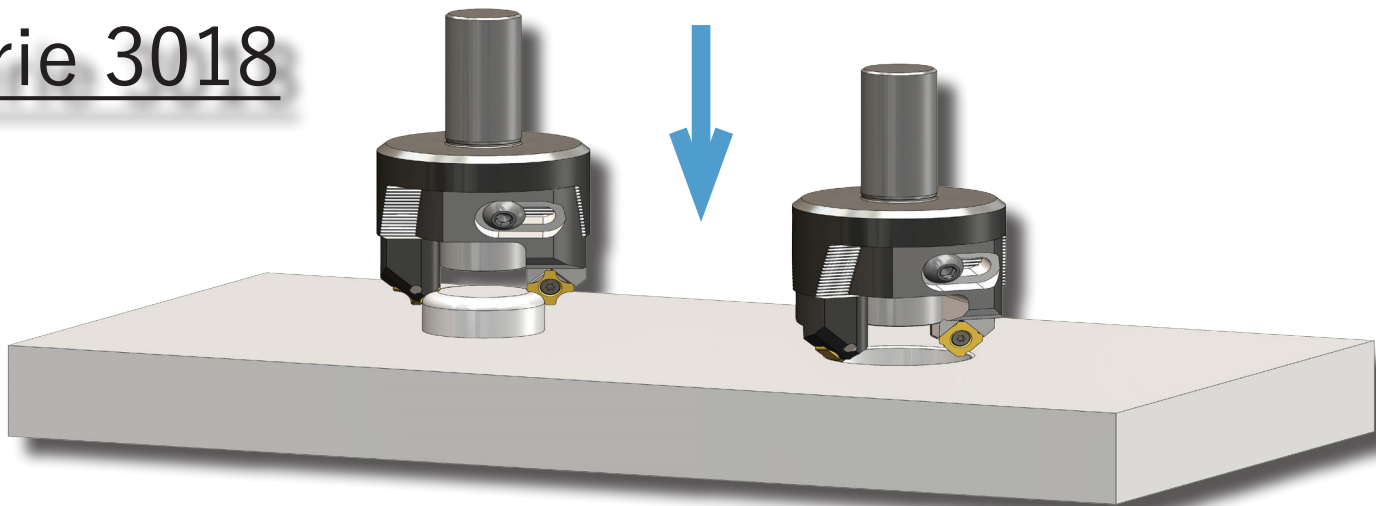
Serie 3016



Serie 3017

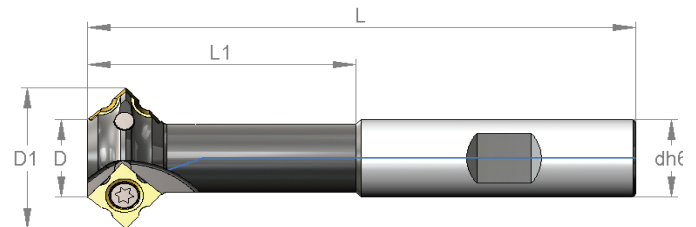
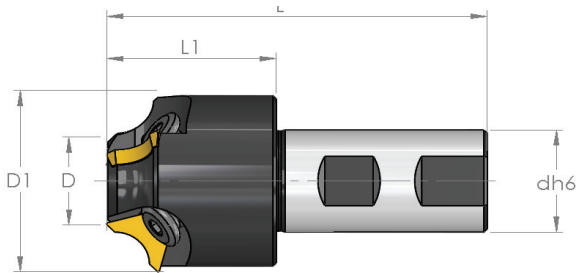


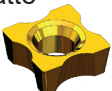


Serie 3018



Serie 3016 - Ausführungen

Serie 3016 - executions



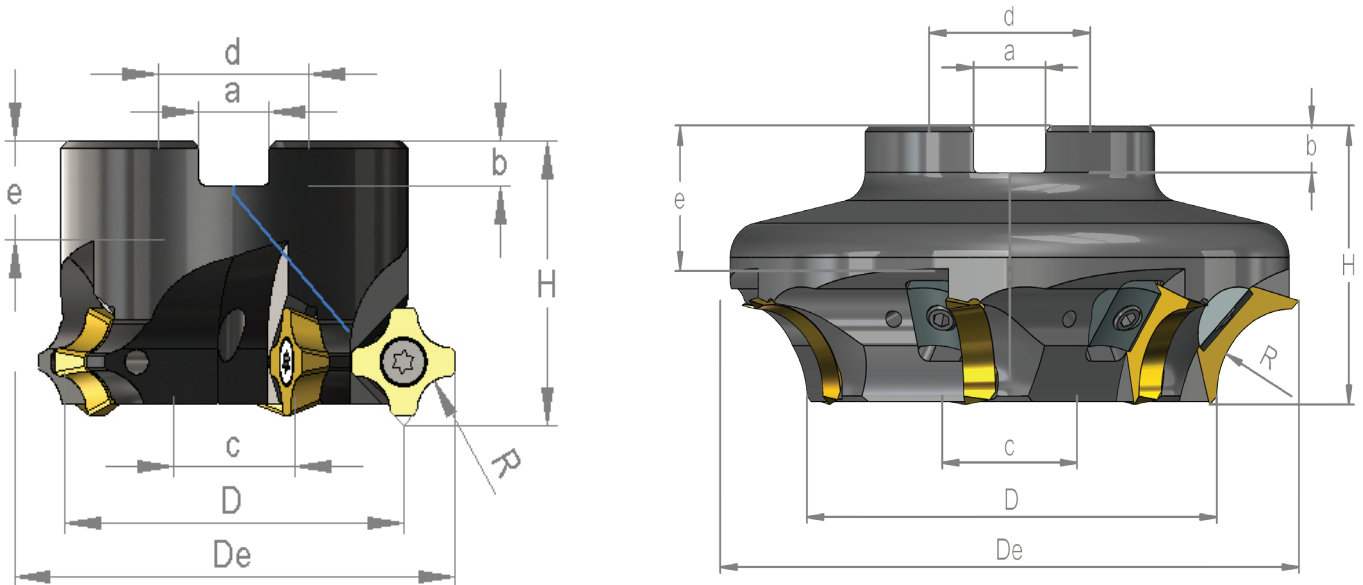
Bestell-Nr.: Order Code:	Preis : Price :	Abmessungen / Dimension (mm)						Wendepatte Insert 	Schraube Screw 	Schlüssel Key 
		D	D1	L	L1	dh6	Z			
3016-012 W-W	166,36,- €	12	23,7	100	50	16	1	SCXT 09T3 R..	M-VT40-6 3,0 Nm 3,00,- €	M-BT15 6,49,- €
3016-012 WL	185,00,- €	12	23,7	200	50	16	1			
3016-016 W-W	212,25,- €	16	28,8	100	50	16	2			
3016-016 WL	235,00,- €	16	28,8	200	50	16	2			
3016-025 W-W	228,31,- €	25	40,3	100	45	25	3			
3016-025 WL	245,00,- €	25	40,3	200	45	25	3			
3016-025 W-W-12	228,31,- €	25	40,5	100	45	25	3	SEXT 1204 R.. SEXT 1204 RR..	M-VT45 5,0 Nm 3,23,- €	M-BT20 6,49,- €
3016-025 WL-12	245,00,- €	25	40,5	200	45	25	3			
3016-032 W-W	228,31,- €	32	45	100	45	25	3			
3016-032 WL	245,00,- €	32	45	200	45	25	3	XPKN 2204 R..	M-CVB55 7,78,- €	M-CL2 3,46,- €
3016-005 W-W	235,00,- €	5	32,3	91	35	25	1			
3016-032 W-W-22	265,00,- €	32	61	110	49	32	3			

Bestellbeispiel / Orderexample: 3016-012 W-W

W-W = Kühlmittelbohrung / W-W = coolant bores

Serie 3016 - Ausführungen

Serie 3016 - executions



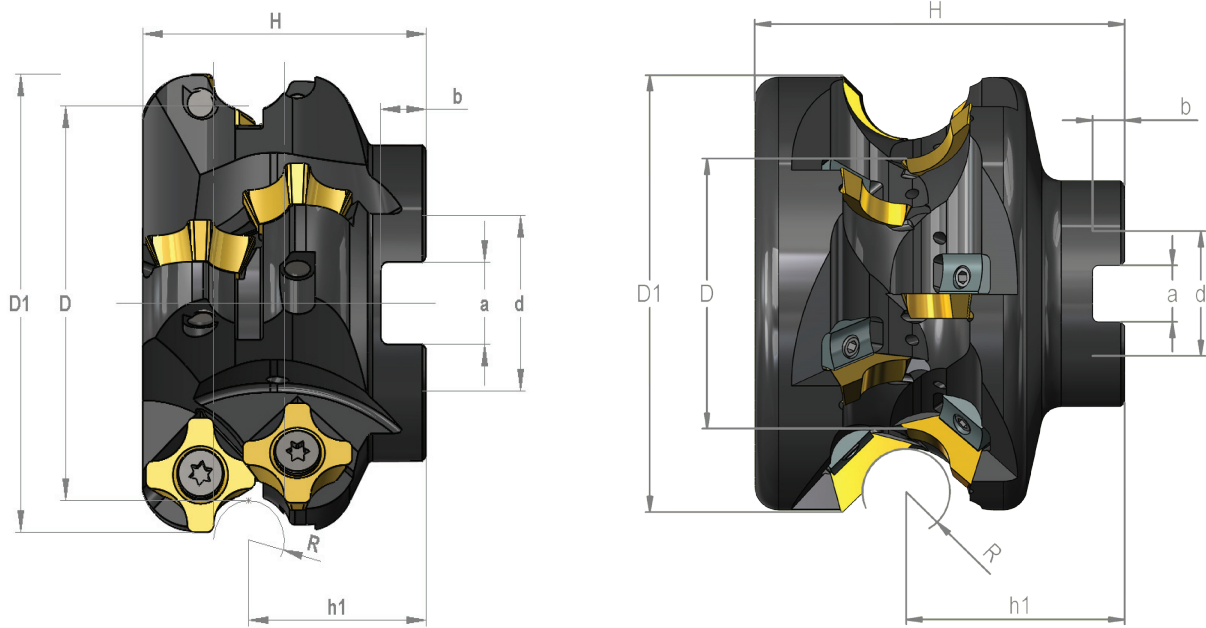
Bestell-Nr.: Order Code:	Preis : Price :	Abmessungen / Dimension (mm)									Wendeplatte Insert	Schraube Screw	Schlüssel Key	Spannkeil clamping wedge
		D	De	d	c	e	a	b	H	Z				
3016 M-W D32	231,75,- €	32	45	16	14	18	8,4	5,6	40	3	SEXT 1204 R.. SEXT 1204 RR..	M-VT45 5,0 Nm 3,23,- €	M-BT20 6,49,- €	
3016 M-W D40	251,75,- €	40	53	16	14	18	8,4	5,6	40	4				
3016 M-W D50	281,09,- €	50	63	22	18	20	10,4	6,3	48	5				
3016 M-W D63	331,56,- €	63	92,5	22	18	20	10,4	6,3	48	6	XPKN 2204 R..	M-MS 1162 5,35,- €	5003 2,01,- €	M-SK 1355 44,00,- €
3016 M-W D80	455,06,- €	80	115,8	32	27	25	14,4	8	48	7	XPKN 3106 R..	M-MS 1162 5,35,- €	5003 2,01,- €	M-SK 1355 44,00,- €




Bestellbeispiel / Orderexample: 3016 M-W D32

M-W = Kühlmittelbohrung / M-W = coolant bores

Serie 3017 - Ausführungen

Serie 3017 - executions



Bestell-Nr.: Order Code:	Preis: Price:	Abmessungen / Dimension (mm)									Wendeplatte Insert 	Schraube Screw 	Schlüssel Key 	Spannkeil Clamping wedge
		D	D1	d	a	b	H	h1	Z	Zeff				
3017 M-W D50	650,00,-€	50	61,7	22	10,4	6,3	40	25	8	4	SEXT 1204 R R.. SEXT 1204 L R..	M-VT45 5,0 Nm 3,23,-€	M-BT20 6,45,-€	
3017 M-W D80	980,00,-€	80	105	32	14,4	8	75	50	12	6	XPKN 2204 R R.. XPKN 2204 L R..	M-MS 1162 5,35,-€	5003 2,01,-€	M-SK 1355 44,00,-€
3017 M-W D80-31	980,00,-€	80	112,7	32	14,4	8	85	55	12	6	XPKN 3106 R R.. XPKN 3106 L R..	M-MS 1162 5,35,-€	5003 2,01,-€	M-SK 1355 44,00,-€

Bestellbeispiel / Orderexample: 3017 M-W D80

M-W = Kühlmittelbohrung

/ M-W = coolant bores

Lieferung: inkl. Schrauben und Spannkeile

- Delivery: including screws and clamping wedges

Serie 3018 - Ausführungen

Serie 3018 - executions

Einstellzylinder für Bohrungen und Zapfen

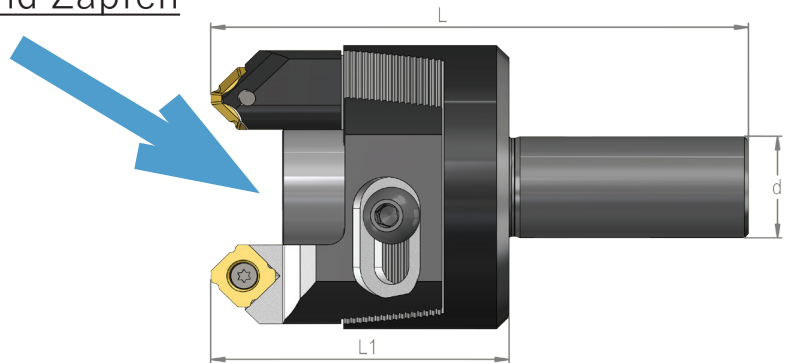
Adjustment cylinder for bores and pins

Montage:

1. Kassetten öffnen
2. Zylinder auf gewünschten Ø wechseln
3. Kassette auf Zylinderanschlag
4. Kassette anziehen

Assembly:

1. open cassettes
2. change cylinder to desired diameter
3. cassette on cylinder stop
4. tighten the cassette



Bestell-Nr.: Order Code:	Preis: Price:	Abmessungen / Dimensions			Wendepatte: Insert:	Schraube: screw:	Schlüssel: key:	Kassette: cassette:
		L	L1	d				
3018 W-W D50	890,00,-€	128	71	25	SEXT 1204 R R.. SEXT 1204 L R..	M-VT45 5,0 Nm 3,23,-€	M-BT20 6,45,-€	M-FN 450 85,00,-€

Bestellbeispiel / Orderexample: 3018 W-W D50

Lieferung inkl. Kassetten u. Schrauben - Delivery incl. cassettes and screws

EINSTELLZYLINDER FÜR BOHRUNGEN:

Ausführung: Execution:	Preis: Price:	Radius:	Schlüssel: key:
3018 SI 25	35,00,-€	R1 - R5	5004
3018 SI 26	35,00,-€	R1 - R5	5004
3018 SI 27	35,00,-€	R1 - R5	5004
3018 SI 28	35,00,-€	R1 - R5	5004
3018 SI 29	35,00,-€	R1 - R5	5004
3018 SI 30	35,00,-€	R1 - R5	5004
3018 SI 31	35,00,-€	R1 - R5	5004
3018 SI 32	35,00,-€	R1 - R5	5004
3018 SI 33	35,00,-€	R1 - R5	5004
3018 SI 34	35,00,-€	R1 - R5	5004
3018 SI 35	35,00,-€	R1 - R5	5004
3018 SI 36	35,00,-€	R1 - R5	5004
3018 SI 37	35,00,-€	R1 - R5	5004
3018 SI 38	35,00,-€	R1 - R5	5004
3018 SI 39	35,00,-€	R1 - R5	5004
3018 SI 40	35,00,-€	R1 - R5	5004
3018 SI 41	35,00,-€	R1 - R5	5004
3018 SI 42	35,00,-€	R1 - R5	5004
3018 SI 43	35,00,-€	R1 - R5	5004
3018 SI 44	35,00,-€	R1 - R5	5004
3018 SI 45	35,00,-€	R1 - R5	5004
3018 SI 46	35,00,-€	R1 - R5	5004
3018 SI 47	35,00,-€	R1 - R5	5004
3018 SI 48	35,00,-€	R1 - R5	5004
3018 SI 49	35,00,-€	R1 - R5	5004
3018 SI 50	35,00,-€	R1 - R5	5004

Bestellbeispiel / Orderexample: 3018 SI 36

Einstellbereich Bohrung / adjustment range bore Ø25-50

EINSTELLZYLINDER FÜR ZAPFEN:

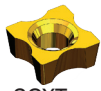
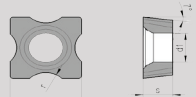
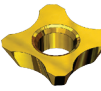
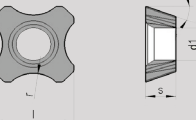
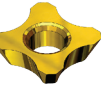
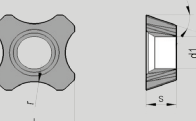
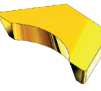
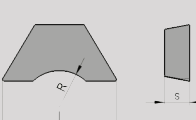
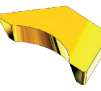
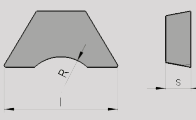
Ausführung: Execution:	Preis: Price:	Radius:	Schlüssel: key:
3018 SA 18	35,00,-€	R1 - R5	5004
3018 SA 19	35,00,-€	R1 - R5	5004
3018 SA 20	35,00,-€	R1 - R5	5004
3018 SA 21	35,00,-€	R1 - R5	5004
3018 SA 22	35,00,-€	R1 - R5	5004
3018 SA 23	35,00,-€	R1 - R5	5004
3018 SA 24	35,00,-€	R1 - R5	5004
3018 SA 25	35,00,-€	R1 - R5	5004
3018 SA 26	35,00,-€	R1 - R5	5004
3018 SA 27	35,00,-€	R1 - R5	5004
3018 SA 28	35,00,-€	R1 - R5	5004
3018 SA 29	35,00,-€	R1 - R5	5004
3018 SA 30	35,00,-€	R1 - R5	5004
3018 SA 31	35,00,-€	R1 - R5	5004
3018 SA 32	35,00,-€	R1 - R5	5004
3018 SA 33	35,00,-€	R1 - R5	5004
3018 SA 34	35,00,-€	R1 - R5	5004
3018 SA 35	35,00,-€	R1 - R5	5004
3018 SA 36	35,00,-€	R1 - R5	5004
3018 SA 37	35,00,-€	R1 - R5	5004
3018 SA 38	35,00,-€	R1 - R5	5004
3018 SA 39	35,00,-€	R1 - R5	5004
3018 SA 40	35,00,-€	R1 - R5	5004
3018 SA 41	35,00,-€	R1 - R5	5004
3018 SA 42	35,00,-€	R1 - R5	5004
3018 SA 43	35,00,-€	R1 - R5	5004

Bestellbeispiel / Orderexample: 3018 SA 28

Einstellbereich Zapfen / adjustment range pin Ø18-43

Wendepplatten

Inserts

	Form Figure	Abmessungen Dimensions					Bezeichnung Designation	Schraube screw	Schlüssel key	Preis Price	Beschichtet Sorten coated grades						
		l	d	s	d1	r					PTT20	PTV28	PTT35	PAP28	MTM10	KTE20	
 SCXT ..		9,52		3,97		1,0	SCXT 09T3 R1	M-VT40-6	M-BT 15	31,19,- €		■	■	■		■	
		9,52		3,97		2,0	SCXT 09T3 R2	M-VT40-6	M-BT 15	31,19,- €		■	■	■		■	
		9,52		3,97		3,0	SCXT 09T3 R3	M-VT40-6	M-BT 15	31,19,- €		■		■		■	
 SEXT ..		12,70		4,76		1,0	SEXT 1204 R1	M-VT 45	M-BT 20	34,93,- €		■	■	■		■	
		12,70		4,76		2,0	SEXT 1204 R2	M-VT 45	M-BT 20	34,93,- €		■	■	■		■	
		12,70		4,76		3,0	SEXT 1204 R3	M-VT 45	M-BT 20	34,93,- €		■	■	■		■	
		12,70		4,76		4,0	SEXT 1204 R4	M-VT 45	M-BT 20	34,93,- €		■	■	■		■	
		12,70		4,76		5,0	SEXT 1204 R5	M-VT 45	M-BT 20	34,93,- €		■	■	■		■	
		12,70		4,76		1,0	SEXT 1204 RR1	M-VT 45	M-BT 20	34,93,-€	■	■	■		■		
		12,70		4,76		2,0	SEXT 1204 RR2	M-VT 45	M-BT 20	34,93,-€	■	■	■		■		
		12,70		4,76		3,0	SEXT 1204 RR3	M-VT 45	M-BT 20	34,93,-€	■	■	■		■		
		12,70		4,76		4,0	SEXT 1204 RR4	M-VT 45	M-BT 20	34,93,-€	■	■	■		■		
 SEXT ..		12,70		4,76		1,0	SEXT 1204 L R1	M-VT 45	M-BT 20	34,93,-€		■	■	■		■	
		12,70		4,76		2,0	SEXT 1204 L R2	M-VT 45	M-BT 20	34,93,-€		■	■	■		■	
		12,70		4,76		3,0	SEXT 1204 L R3	M-VT 45	M-BT 20	34,93,-€		■	■	■		■	
		12,70		4,76		4,0	SEXT 1204 L R4	M-VT 45	M-BT 20	34,93,-€		■	■	■		■	
		12,70		4,76		5,0	SEXT 1204 L R5	M-VT 45	M-BT 20	34,93,-€		■	■		■		
 XPKN ..		21,00		4,76		6,0	XPKN 2204 R R6			21,82,-€		□	■			□	
		21,00		4,76		7,0	XPKN 2204 R R7			21,82,-€		□	■				□
		21,00		4,76		8,0	XPKN 2204 R R8			21,82,-€		□	■				□
		21,00		4,76		10,0	XPKN 2204 R R10			22,45,-€		□	■				□
		25,35		6,35		11,0	XPKN 3106 R R11			38,85,-€			■	□			
		25,35		6,35		12,0	XPKN 3106 R R12			38,85,-€			■	□			
		25,35		6,35		13,0	XPKN 3106 R R13			38,85,-€			■	□			
		25,35		6,35		14,0	XPKN 3106 R R14			38,85,-€			■	□			
		25,35		6,35		15,0	XPKN 3106 R R15			38,85,-€			■	□			
 XPKN ..		21,00		4,76		6,0	XPKN 2204 L R6			21,82,-€		□	■			□	
		21,00		4,76		7,0	XPKN 2204 L R7			21,82,-€		□	■				□
		21,00		4,76		8,0	XPKN 2204 L R8			21,82,-€		□	■				□
		21,00		4,76		10,0	XPKN 2204 L R10			22,45,-€		□	■				□
		25,35		6,35		11,0	XPKN 3106 L R11			38,85,-€			■	□			
		25,35		6,35		12,0	XPKN 3106 L R12			38,85,-€			■	□			
		25,35		6,35		13,0	XPKN 3106 L R13			38,85,-€			■	□			
		25,35		6,35		14,0	XPKN 3106 L R14			38,85,-€			■	□			
		25,35		6,35		15,0	XPKN 3106 L R15			38,85,-€			■	□			

Für Bearbeitung an Zapfen: Linke Wendeschneidplatte
 Für Bearbeitung an Bohrungen: Rechte Wendeschneidplatte

For machining on pins: Left-hand indexable insert
 For machining on bores: Right-hand indexable insert

Schnittwerte / cutting speed

TYP 3016 - 3017

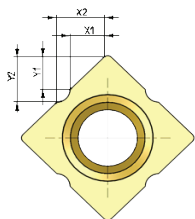
Vc (m/min)	Alu			Stahl										INOX		GG(G)	TITAN	Graphit GFK CFK	Öl	Emulsion	MMS	Trocken	Druckluft
	Kunststoff		Guss	< 500 N	< 750 N	< 900 N	< 1100 N	< 1400 N	< 55 HRC	< 60 HRC	< 65 HRC	< 67 HRC	< 70 HRC	< 900 N	> 900 N								
ISO-Code	N	N	N	P	P	P	P	P	H	H	H	H	H	M	M	K	S	N					
PTV28					180	180	160	120												■			■
PTT35					180	180	160	120						120	100					■			■
PAP28																							
MTM10																140				■			■
KTE20	400	400	300																	■			■
K10																							
fz	0,1-0,15																	■ geeignet	□ bedingt geeignet				

TYP 3018

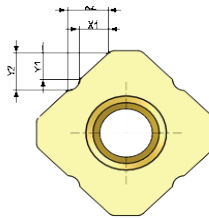
Vc (m/min)	Alu			Stahl										INOX		GG(G)	TITAN	Graphit GFK CFK	Öl	Emulsion	MMS	Trocken	Druckluft
	Kunststoff		Guss	< 500 N	< 750 N	< 900 N	< 1100 N	< 1400 N	< 55 HRC	< 60 HRC	< 65 HRC	< 67 HRC	< 70 HRC	< 900 N	> 900 N								
ISO-Code	N	N	N	P	P	P	P	P	H	H	H	H	H	M	M	K	S	N					
					180	180	160	120												■			■
					180	180	160	120						120	100					■			■
																140				■			■
	400	400	300																	■			■
fz	0,05-0,08																	■ geeignet	□ bedingt geeignet				

Je nach Einsatzbedingung können die Schnittdaten nach oben oder nach unten korrigiert werden.
Depending on the application condition, the cutting data can be corrected upwards or downwards.

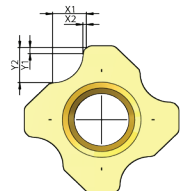
Parameter / parameters



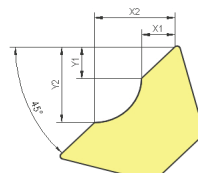
	X1	X2	Y1	Y2
SCXT 09T3 R1	2,59	3,59	2,59	3,59
SCXT 09T3 R2	2,09	4,09	2,09	4,09
SCXT 09T3 R3	1,59	4,59	1,59	4,59



	X1	X2	Y1	Y2
SEXT 1204 R1	2,49	3,49	2,49	3,49
SEXT 1204 R2	1,99	3,99	1,99	3,99
SEXT 1204 R3	1,49	4,49	1,49	4,49
SEXT 1204 R4	0,99	4,99	0,99	4,99
SEXT 1204 R5	0,49	5,49	0,49	5,49



	X1	X2	Y1	Y2
SEXT 1204 RR1	0,34	1,34	0,63	1,63
SEXT 1204 RR2	0,34	2,34	0,63	2,63
SEXT 1204 RR3	0,34	3,34	0,63	3,63
SEXT 1204 RR4	0,34	4,34	0,63	4,63
SEXT 1204 RR5	0,34	5,34	0,63	5,63



	X1	X2	Y1	Y2
XPKN 2204 R6	4,26	10,26	4,26	10,26
XPKN 2204 R7	3,76	10,76	3,76	10,76
XPKN 2204 R8	3,26	11,26	3,26	11,26
XPKN 2204 R10	2,26	12,26	2,26	12,26
XPKN 3106 R11	3,46	14,46	3,46	14,46
XPKN 3106 R12	2,96	14,96	2,96	14,96
XPKN 3106 R13	2,46	15,46	2,46	15,46
XPKN 3106 R14	1,96	15,96	1,96	15,96
XPKN 3106 R15	1,46	16,46	1,46	16,46

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