



NEW

LIEFERPROGRAMM
DELIVERY PROGRAM
PROGRAMME DE VENTE
PROGRAMMA DI VENDITA

Schnitt- & Stanztechnik
Cutting & Punching industry
Industrie de Découpage-Emboutissage & Frappe
Tranciatura & Stampaggio

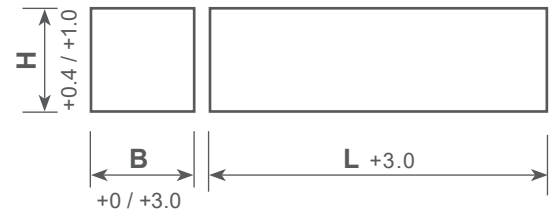
EXTRAMET
WE LIVE FOR CHALLENGES 

Erodierblöcke | sinterroh | mit Schleifzugabe

Carbide blocks for wire erosion | sintered | with grinding allowance

Blocs pour l'électroérosion par fil | bruts | avec surépaisseurs

Blocchi per elettroerosione | sinterizzati | con sovrametallo



Abmessungen in mm | Dimensions in mm | Dimensioni in mm | Dimensioni in mm

H	B	L	EMT				Artikel Nr.
			210	409	812	815	Item No Nr. Réf.
3.5	100	100	●	●	○	○	086035100100xxx
3.5	100	150	●	●	○	○	086035100150xxx
4.5	100	100	●	●	○	○	086045100100xxx
4.5	100	150	●	●	○	○	086045100150xxx
6.5	100	100	●	●	○	○	086065100100xxx
6.5	100	150	●	●	○	○	086065100150xxx
8.5	100	100	●	●	○	○	086085100100xxx
8.5	100	150	●	●	○	○	086085100150xxx
10.5	100	100	●	●	●	○	086105100100xxx
10.5	100	150	●	●	●	○	086105100150xxx
12.5	100	100	●	●	●	○	086125100100xxx
12.5	100	150	●	●	●	○	086125100150xxx
13.5	100	100	●	●	●	○	086135100100xxx
13.5	100	150	●	●	●	○	086135100150xxx
15.5	100	100	●	●	●	○	086155100100xxx
15.5	100	150	●	●	●	○	086155100150xxx
16.5	100	100	●	●	●	○	086165100100xxx
16.5	100	150	●	●	●	○	086165100150xxx
18.5	100	100	●	●	●	○	086185100100xxx
18.5	100	150	●	●	●	○	086185100150xxx
20.5	100	100	●	●	●	○	086205100100xxx
20.5	100	150	●	●	●	○	086205100150xxx
22.5	100	100	●	●	●	○	086225100100xxx
22.5	100	150	●	●	●	○	086225100150xxx
25.5	100	100	●	●	●	○	086255100100xxx
25.5	100	150	●	●	●	○	086255100150xxx
30.5	100	100	●	●	●	○	086305100100xxx
30.5	100	150	●	●	●	○	086305100150xxx
35.5	100	150	●	●	●	○	086355100150xxx
40.5	100	150	●	●	●	○	086405100150xxx
45.5	100	150	●	●	●	○	086455100150xxx
55.5	100	150	●	●	●	○	086555100150xxx

● Standard
○ auf Kundenwunsch
andere Abmessungen auf Anfrage

standard
upon customer request
other dimensions on demand

standard
sur demande du client
autres dimensions sur demande

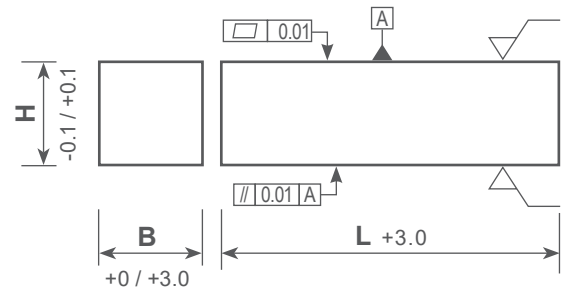
standard
su richiesta del cliente
altre dimensioni su richiesta

Erodierblöcke | Stärke (H) vorgeschliffen

Carbide blocks for wire erosion | thickness (H) pre-ground

Blocs pour l'électroérosion par fil | épaisseur (H) pré-rectifiée

Blocchi per elettroerosione | spessore (H) pre-rettificato



H	B	L	EMT				Artikel Nr.	
			210	409	812	815	Item No Nr. Réf.	
3.5	100	100	●	●	○	○	286035100100xxx	
3.5	100	150	●	●	○	○	286035100150xxx	
4.5	100	100	●	●	○	○	286045100100xxx	
4.5	100	150	●	●	○	○	286045100150xxx	
6.5	100	100	●	●	○	○	286065100100xxx	
6.5	100	150	●	●	○	○	286065100150xxx	
8.5	100	100	●	●	○	○	286085100100xxx	
8.5	100	150	●	●	○	○	286085100150xxx	
10.5	100	100	●	●	●	○	286105100100xxx	
10.5	100	150	●	●	●	○	286105100150xxx	
12.5	100	100	●	●	●	○	286125100100xxx	
12.5	100	150	●	●	●	○	286125100150xxx	
13.5	100	100	●	●	●	○	286135100100xxx	
13.5	100	150	●	●	●	○	286135100150xxx	
15.5	100	100	●	●	●	○	286155100100xxx	
15.5	100	150	●	●	●	○	286155100150xxx	
16.5	100	100	●	●	●	○	286165100100xxx	
16.5	100	150	●	●	●	○	286165100150xxx	
18.5	100	100	●	●	●	○	286185100100xxx	
18.5	100	150	●	●	●	○	286185100150xxx	
20.5	100	100	●	●	●	○	286205100100xxx	
20.5	100	150	●	●	●	○	286205100150xxx	
22.5	100	100	●	●	●	○	286225100100xxx	
22.5	100	150	●	●	●	○	286225100150xxx	
25.5	100	100	●	●	●	○	286255100100xxx	
25.5	100	150	●	●	●	○	286255100150xxx	
30.5	100	100	●	●	●	○	286305100100xxx	
30.5	100	150	●	●	●	○	286305100150xxx	
35.5	100	150	●	●	●	○	286355100150xxx	
40.5	100	150	●	●	●	○	286405100150xxx	
45.5	100	150	●	●	●	○	286455100150xxx	
55.5	100	150	●	●	●	○	286555100150xxx	

Ihre Sortenauswahl - unsere Artikelreferenz

Ersetzen Sie die Ziffern « xxx » am Ende der Artikelnummer mit der gewünschten HM-Sorte z.B. 010100**100**, 010100**210** oder 010100**409** ...

Your selected grade - our item number

Please replace the « xxx » at the end of the item no. with the grade of your choice e.g. 010100**100**, 010100**210** or 010100**409** ...

Votre choix- notre nr. référence

Veillez remplacer les codes « xxx » à la fin de la référence avec la nuance de votre choix par ex. 010100**100**, 010100**210** ou 010100**409** ...

Vostra scelta - il nostro numero di articolo

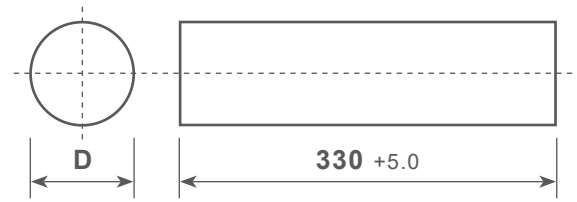
Si prega di sostituire « xxx » alla fine del numero dell'articolo con il grado di vostra scelta es. 010100**100**, 010100**210** ou 010100**409** ...

Rundstäbe | voll | sinterroh

Round bars | solid | sintered

Barreaux ronds | pleins | bruts

Cilindretti | integrali | sinterizzati



Abmessungen in mm | Dimensions in mm | Dimensioni in mm | Dimensioni in mm

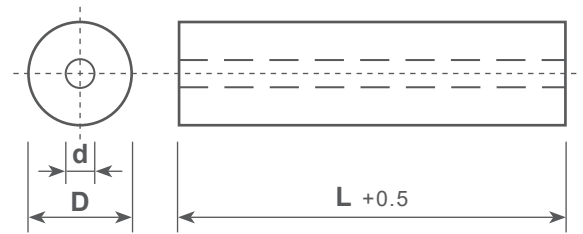
D	Tol.	EMT								Artikel Nr.
		100	210	212	409	412	609	612	812	Item No Nr. Réf.
1.25	-0.05 / +0.15	●	●				○	●		010020xxx
1.60	-0.05 / +0.15	○	●							010035xxx
1.80	-0.05 / +0.15	●	●				●	●		010040xxx
2.25	-0.05 / +0.15	●	●				●	●		010050xxx
2.50	-0.05 / +0.15	●	●							010055xxx
2.75	-0.05 / +0.15	●	●							010060xxx
3.25	-0.05 / +0.15	●	●	●	●	●	●	●	○	010080xxx
3.45	-0.05 / +0.15	●	●		●	●	●	●		010085xxx
3.75	-0.05 / +0.15	●	●							010090xxx
4.25	-0.05 / +0.15	●	●	●	●	●	●	●	○	010100xxx
4.75	-0.05 / +0.15	●	●							010110xxx
5.25	-0.05 / +0.15	●	●		○	●	●	●		010125xxx
5.80	-0.05 / +0.15	●	●							010140xxx
6.30	-0.05 / +0.20	●	●	●	●	●	●	●	○	010150xxx
6.70	-0.05 / +0.20	●	●	○	○	●	●	●		010160xxx
7.30	-0.05 / +0.20	●	●							010180xxx
8.30	-0.05 / +0.20	●	●	●	●	●	●	●	○	010200xxx
8.80	-0.05 / +0.20	●	●							010210xxx
9.30	-0.05 / +0.20	●	●						○	010230xxx
9.80	-0.05 / +0.20	●	●		○	●	○	●		010240xxx
10.30	-0.05 / +0.20	●	●	●	●	●	●	●	○	010250xxx
10.80	-0.05 / +0.25	●	●							010260xxx
11.35	-0.05 / +0.25	●	●							010280xxx
12.30	-0.05 / +0.25	●	●	●	●	●	●	●	○	010300xxx
13.00	-0.05 / +0.25	●	●		○	●	●	●		010315xxx
13.30	-0.05 / +0.25	●	●							010320xxx
14.30	-0.05 / +0.25	●	●	○	●	●	●	●	○	010350xxx
14.80	-0.05 / +0.25	●	●							010360xxx
15.30	-0.05 / +0.30	●	●							010380xxx
16.30	-0.05 / +0.30	●	●	●	●	●	●	●	○	010400xxx
16.80	-0.05 / +0.30	○	○							010410xxx
17.30	-0.05 / +0.30	○	○							010430xxx
18.30	-0.05 / +0.30	●	●	○	●	●	●	●	○	010450xxx
19.30	-0.05 / +0.30	○	●	○		○		○		010480xxx
20.30	-0.05 / +0.30	●	●	●	●	●	●	●	○	010500xxx
21.30	-0.05 / +0.40	○	●							010520xxx
22.30	-0.05 / +0.40	○	●						○	010550xxx
23.30	-0.05 / +0.40	●	●						○	010570xxx
24.30	-0.05 / +0.40	○	●							010600xxx
25.30	-0.05 / +0.40	●	●	●	○	○	●	●	○	010630xxx
25.80	-0.05 / +0.40	○	●	○						010640xxx

Rundstäbe | 1 Kühlkanal zentral | sinterroh

Round bars | 1 coolant hole central | sintered

Barreaux ronds | 1 trou central | bruts

Cilindretti | 1 foro centrale di refrigerazione | sinterizzati



D	Tol.	d	Tol.	L	EMT			Artikel Nr.
					210	409	812	Item No Nr. Réf.
5.25	-0.05 / 0.15	0.50	-0.05	100	●	●	●	031125005xxx
6.30	-0.05 / 0.20	0.50	-0.05	100	●	●	●	031150005xxx
7.30	-0.05 / 0.20	0.50	-0.05	100	●	●	●	031180005xxx
8.30	-0.05 / 0.20	1.00	-0.10	100	●	●	●	031200010xxx
9.30	-0.05 / 0.20	1.00	-0.10	100	●	●	●	031230010xxx
10.30	-0.05 / 0.20	1.00	-0.10	100	●	●	●	031250010xxx
12.30	-0.05 / 0.25	2.00	-0.10	100	●	●	●	031300020xxx
14.30	-0.05 / 0.25	2.00	-0.10	100	●	●	●	031350020xxx
16.30	-0.05 / 0.30	2.00	-0.10	100	●	●	●	031400020xxx
18.30	-0.05 / 0.30	2.00	-0.10	100	●	●	●	031450020xxx
20.30	-0.05 / 0.30	2.00	-0.10	100	●	●	●	031500020xxx
22.30	-0.05 / 0.40	2.00	-0.10	100	●	●	●	031550020xxx
25.30	-0.05 / 0.40	2.00	-0.10	100	●	●	●	031630020xxx
30.30	-0.05 / 0.50	2.00	-0.10	100	●	●	●	031700020xxx
32.60	-0.10 / 0.60	2.00	-0.10	100	●	●	●	0319326020xxx

- Standard
 - auf Kundenwunsch
andere Abmessungen auf Anfrage
- | | | |
|---|---|---|
| standard
upon customer request
other dimensions on demand | <i>standard</i>
<i>sur demande du client</i>
<i>autres dimensions sur demande</i> | standard
su richiesta del cliente
altre dimensioni su richiesta |
|---|---|---|

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Vostra scelta - il nostro numero di articolo

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UNSERE HARTMETALLSORTEN | OUR TUNGSTEN CARBIDE GRADES | NOS NUANCES DE CARBURE

	Feinstkorn submicron grain <i>micron grain</i>		Feinkorn fine grain <i>grain fin</i>		Ultrafeinkorn ultrafine grain <i>grain ultrafin</i>		Mittelkorn medium grain <i>grain moyen</i>		Feinstkorn submicron grain <i>micron grain</i>	
	EMT100	EMT210	EMT212	EMT409	EMT412	EMT609	EMT612	EMT812	EMT815	EMT909
WC	93%	89%	87%	90%	87%	89.5%	86.5%	86.8%	85%	90.5%
Co	6%	10%	12%	9%	12%	9%	12%	12%	15%	—
Ni	—	—	—	—	—	—	—	—	—	8.5%
Zusatzkarbide Other carbides <i>Autres carbures</i>	1%	1%	1%	1%	1%	1.5%	1.5%	1.2%	0%	1%
Korngrösse Average grain size <i>Dimension des grains</i>	~0.8	~0.8	~0.8	~1.2	~1.2	~0.5	~0.5	~2.5	~2.5	<1.0
Dichte ISO 3369 Density <i>Densité</i>	14.80 ±0.1	14.45 ±0.1	14.20 ±0.1	14.50 ±0.1	14.25 ±0.1	14.40 ±0.1	14.10 ±0.1	14.15 ±0.1	14.10 ±0.1	14.50 ±0.1
Härte ISO3878 Hardness <i>Dureté</i>	HV 30	1'800 ±60	1'600 ±60	1'550 ±60	1'440 ±60	1'930 ±60	1'720 ±60	1'320 ±60	1'120 ±60	1'600 ±60
Biegefestigkeit Transverse rupture strength <i>Résistance à la flexion</i>	N/mm ²	>3'800	>4'300	>4'300	>3'500	>4'000	>4'200	>3'200	>3'200	>3'600
Bruchzähigkeit K_{1c} Fracture toughness <i>Résistance à la rupture</i>	MPa*m ^{1/2}	9.4	10.0	11.5	10.5	12.3	7.7	7.8	12.5	14.0

K_{1c} nach Palmquist

Die Daten in dieser Tabelle sind typische Materialkennwerte. Änderungen der Daten im Rahmen des technischen Fortschritts oder durch betrieblich bedingte Weiterentwicklung behalten wir uns vor. K_{1c}: Die gemessenen kritischen Spannungsfestfaktoren (K_{1c}) sind in hohem Masse von der Probengeometrie und Probenpräparation abhängig. Ein direkter Vergleich mit Werten, die mit einer anderen Verfahrensweise ermittelt wurden, ist daher nicht zulässig.

The data in this table are typical material parameters. We reserve the right to modify the data due to technical progress or due to further development within our company. K_{1c}: The measured critical tension intensity factors (K_{1c}) depend to a high degree on the sample geometry and sample preparation. A direct comparison with parameters which have been determined by means of a different method is therefore not admissible.

Les données figurant dans ce tableau représentent les paramètres spécifiques matière. Nous nous réservons le droit de modifier ces données en fonction des progrès technologiques ou de nos futurs développements. *K_{1c}: Les facteurs critiques d'intensité de contraintes (K_{1c}) dépendent fortement de la géométrie et de la préparation de l'échantillon. Une comparaison directe avec des valeurs obtenues par une autre méthode n'est donc pas possible.