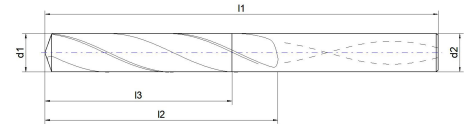


VHM-Universal-Spiralbohrer 5xd mit IK

Solid carbide universal twist drills 5xd mit IC



Artikelnummer Article-No.	forming taps	d1 m7	taps	l1	l2	l3	d2 h6
E.3617.1.0100	M 1,1	1	-	55	10	7	3,0
E.3617.1.0110	M 1,2	1.1	M 1,4	55	12	10	3,0
E.3617.1.0120	-	1.2	-	55	12	10	3,0
E.3617.1.0130	-	1.3	-	55	12	10	3,0
E.3617.1.0140	-	1.4	-	55	12	10	3,0
E.3617.1.0150	-	1.5	-	55	12	10	3,0
E.3617.1.0160	-	1.6	M 2	55	16	13	3,0
E.3617.1.0170	-	1.7	-	55	16	13	3,0
E.3617.1.0180	M 2	1.8	M 2,2	55	16	13	3,0
E.3617.1.0190	-	1.9	M 2,3	55	16	13	3,0
E.3617.1.0200	-	2	-	57	21	16	3,0
E.3617.1.0210	-	2.1	-	57	21	16	3,0
E.3617.1.0220	-	2.2	-	57	21	16	3,0
E.3617.1.0230	-	2.3	-	57	21	16	3,0
E.3617.1.0240	-	2.4	-	57	21	16	3,0
E.3617.1.0250	-	2.5	M 3	57	21	16	3,0
E.3617.1.0260	-	2.6	-	57	21	19	3,0
E.3617.1.0270	-	2.7	-	57	21	19	3,0
E.3617.1.0280	M 3	2.8	-	57	21	19	3,0
E.3617.1.0290	M 3 x 0,25	2.9	M 3,5	57	21	19	3,0
E.3617.1.0300	-	3	-	67	28	23	6,0
E.3617.1.0310	-	3.1	-	67	28	23	6,0
E.3617.1.0320	-	3.2	-	67	28	23	6,0
E.3617.1.0330	M 3,5 x 0,5	3.3	M 4	67	28	23	6,0
E.3617.1.0340	-	3.4	-	67	28	23	6,0
E.3617.1.0350	-	3.5	M 4 x 0,5	67	28	23	6,0
E.3617.1.0360	-	3.6	-	67	28	23	6,0
E.3617.1.0370	M 4	3.7	M 4,5	67	28	23	6,0
E.3617.1.0380	M 4 x 0,5	3.8	-	75	36	29	6,0
E.3617.1.0390	-	3.9	-	75	36	29	6,0
E.3617.1.0400	-	4	M 4,5 x 0,5	75	36	29	6,0
E.3617.1.0410	-	4.1	-	75	36	29	6,0
E.3617.1.0420	M 4,5	4.2	M 5	75	36	29	6,0
E.3617.1.0430	M 4,5 x 0,5	4.3	-	75	36	29	6,0
E.3617.1.0440	-	4.4	-	75	36	29	6,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	forming taps	d1 m7	taps	l1	l2	l3	d2 h6
E.3617.1.0450	-	4.5	M 5 x 0,5	75	36	29	6,0
E.3617.1.0460	-	4.6	M 5,5	75	36	29	6,0
E.3617.1.0465	M 5	4.65	-	75	36	29	6,0
E.3617.1.0470	M 5 x 0,75	4.7	-	75	36	29	6,0
E.3617.1.0480	M 5 x 0,5	4.8	-	83	44	35	6,0
E.3617.1.0490	-	4.9	-	83	44	35	6,0
E.3617.1.0500	-	5	M 6 / M5,5x0,5	83	44	35	6,0
E.3617.1.0510	M 5,5	5.1	-	83	44	35	6,0
E.3617.1.0520	-	5.2	M 6 x 0,75	83	44	35	6,0
E.3617.1.0530	M 5,5 x 0,5	5.3	-	83	44	35	6,0
E.3617.1.0540	-	5.4	-	83	44	35	6,0
E.3617.1.0550	-	5.5	M 6 x 0,5	83	44	35	6,0
E.3617.1.0555	-	5.55	-	83	44	35	6,0
E.3617.1.0560	M 6	5.6	-	83	44	35	6,0
E.3617.1.0570	M 6 x 0,75	5.7	-	83	44	35	6,0
E.3617.1.0580	M 6 x 0,5	5.8	-	83	44	35	6,0
E.3617.1.0590	-	5.9	-	83	44	35	6,0
E.3617.1.0600	-	6	M 7	83	44	35	6,0
E.3617.1.0610	-	6.1	-	92	53	43	8,0
E.3617.1.0620	-	6.2	M 7 x 0,75	92	53	43	8,0
E.3617.1.0630	-	6.3	-	92	53	43	8,0
E.3617.1.0640	-	6.4	-	92	53	43	8,0
E.3617.1.0650	-	6.5	-	92	53	43	8,0
E.3617.1.0660	M 7	6.6	-	92	53	43	8,0
E.3617.1.0670	M 7 x 0,75	6.7	-	92	53	43	8,0
E.3617.1.0680	M 7 x 0,5	6.8	M 8	92	53	43	8,0
E.3617.1.0690	-	6.9	-	92	53	43	8,0
E.3617.1.0700	-	7	M 8 x 1	92	53	43	8,0
E.3617.1.0710	-	7.1	-	92	53	43	8,0
E.3617.1.0720	-	7.2	M 8 x 0,75	92	53	43	8,0
E.3617.1.0730	-	7.3	-	92	53	43	8,0
E.3617.1.0740	M 8	7.4	-	92	53	43	8,0
E.3617.1.0750	-	7.5	M 8 x 0,5	92	53	43	8,0
E.3617.1.0760	M 8 x 1	7.6	-	92	53	43	8,0
E.3617.1.0770	M 8 x 0,75	7.7	-	92	53	43	8,0
E.3617.1.0780	M 8 x 0,5	7.8	M 9	92	53	43	8,0
E.3617.1.0790	-	7.9	-	92	53	43	8,0
E.3617.1.0800	-	8	M 9 x 1	92	53	43	8,0
E.3617.1.0810	-	8.1	-	104	61	49	10,0
E.3617.1.0820	-	8.2	M 9 x 0,75	104	61	49	10,0
E.3617.1.0830	-	8.3	-	104	61	49	10,0
E.3617.1.0840	M 9	8.4	-	104	61	49	10,0
E.3617.1.0850	-	8.5	M 10	104	61	49	10,0
E.3617.1.0860	M 9 x 1	8.6	-	104	61	49	10,0
E.3617.1.0870	M 9 x 0,75	8.7	-	104	61	49	10,0
E.3617.1.0880	M 9 x 0,5	8.8	M 10 x 1,25	104	61	49	10,0
E.3617.1.0890	-	8.9	-	104	61	49	10,0
E.3617.1.0900	-	9	M 10 x 1	104	61	49	10,0
E.3617.1.0905	-	9.05	-	104	61	49	10,0
E.3617.1.0910	-	9.1	-	104	61	49	10,0
E.3617.1.0920	-	9.2	M 10 x 0,75	104	61	49	10,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	forming taps	d1 m7	taps	l1	l2	l3	d2 h6
E.3617.1.0930	M 10	9.3	-	104	61	49	10,0
E.3617.1.0940	-	9.4	-	104	61	49	10,0
E.3617.1.0950	-	9.5	M 11	104	61	49	10,0
E.3617.1.0960	M 10 x 1	9.6	-	104	61	49	10,0
E.3617.1.0970	M 10 x 0,75	9.7	-	104	61	49	10,0
E.3617.1.0980	M 10 x 0,5	9.8	-	104	61	49	10,0
E.3617.1.0990	-	9.9	-	104	61	49	10,0
E.3617.1.1000	-	10	M 11 x 1	104	61	49	10,0
E.3617.1.1010	-	10.1	-	120	71	56	12,0
E.3617.1.1020	-	10.2	M 12 / M11x0,75	120	71	56	12,0
E.3617.1.1030	-	10.3	-	120	71	56	12,0
E.3617.1.1040	-	10.4	-	120	71	56	12,0
E.3617.1.1050	-	10.5	M 12 x 1,5	120	71	56	12,0
E.3617.1.1060	M 11 x 1	10.6	-	120	71	56	12,0
E.3617.1.1070	M 11 x 0,75	10.7	-	120	71	56	12,0
E.3617.1.1080	-	10.8	M 12 x 1,25	120	71	56	12,0
E.3617.1.1090	-	10.9	-	120	71	56	12,0
E.3617.1.1100	-	11	M 12 x 1	120	71	56	12,0
E.3617.1.1110	-	11.1	-	120	71	56	12,0
E.3617.1.1120	M 12	11.2	-	120	71	56	12,0
E.3617.1.1130	-	11.3	-	120	71	56	12,0
E.3617.1.1140	-	11.4	-	120	71	56	12,0
E.3617.1.1150	-	11.5	-	120	71	56	12,0
E.3617.1.1160	M 12 x 1	11.6	-	120	71	56	12,0
E.3617.1.1170	M 12 x 0,75	11.7	-	120	71	56	12,0
E.3617.1.1180	-	11.8	-	120	71	56	12,0
E.3617.1.1190	-	11.9	-	120	71	56	12,0
E.3617.1.1200	-	12	M 14	120	71	56	12,0
E.3617.1.1220	-	12.2	-	126	77	60	14,0
E.3617.1.1230	-	12.3	-	126	77	60	14,0
E.3617.1.1250	-	12.5	M 14 x 1,5	126	77	60	14,0
E.3617.1.1280	-	12.8	M 14 x 1,25	126	77	60	14,0
E.3617.1.1300	-	13	M 14 x 1	126	77	60	14,0
E.3617.1.1310	-	13.1	M 14 x 1	126	77	60	14,0
E.3617.1.1320	-	13.2	M 14 x 1	126	77	60	14,0
E.3617.1.1350	-	13.5	-	126	77	60	14,0
E.3617.1.1380	-	13.8	-	126	77	60	14,0
E.3617.1.1400	-	14	M 16 / M 15 x 1	126	77	60	14,0
E.3617.1.1450	-	14.5	M 16 x 1,5	135	83	63	16,0
E.3617.1.1480	-	14.8	-	135	83	63	16,0
E.3617.1.1500	-	15	M 16 x 1	135	83	63	16,0
E.3617.1.1510	M 16	15.1	-	135	83	63	16,0
E.3617.1.1520	M 16	15.2	-	135	83	63	16,0
E.3617.1.1550	-	15.5	M 18	135	83	63	16,0
E.3617.1.1570	-	15.7	-	135	83	63	16,0
E.3617.1.1580	-	15.8	-	135	83	63	16,0
E.3617.1.1600	-	16	M 18 x 2	135	83	63	16,0
E.3617.1.1620	-	16.2	-	145	93	71	18,0
E.3617.1.1650	-	16.5	-	145	93	71	18,0
E.3617.1.1680	-	16.8	-	145	93	71	18,0
E.3617.1.1700	-	17	-	145	93	71	18,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	forming taps	d1 m7	taps	l1	l2	l3	d2 h6
E.3617.1.1750	-	17.5	M 20	145	93	71	18,0
E.3617.1.1780	-	17.8	-	145	93	71	18,0
E.3617.1.1800	-	18	-	145	93	71	18,0
E.3617.1.1850	-	18.5	-	156	101	77	20,0
E.3617.1.1900	-	19	-	156	101	77	20,0
E.3617.1.1950	-	19.5	M 22	156	101	77	20,0
E.3617.1.2000	-	20	-	156	101	77	20,0



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Materialbezeichnung material description	Bearbeitung Process	Vc m/min	fz					
			Ø 1.00-2.90	Ø 3.00-5.90	Ø 6.00-8.90	Ø 9.00-11.90	Ø 12.00-15.80	Ø 16.00-20.00
PA allg. Stähle General steels	Bohrer VHM	120.00	0.060	0.140	0.200	0.260	0.350	0.370
	Bohrer VHM	110.00	0.060	0.140	0.200	0.260	0.350	0.370
	Bohrer VHM	100.00	0.060	0.140	0.200	0.260	0.350	0.370
	Bohrer VHM	90.00	0.055	0.120	0.160	0.200	0.300	0.330
	Bohrer VHM	80.00	0.050	0.100	0.130	0.170	0.260	0.300
PV Vergütungsstähle < 850N/mm² Tempering steel < 850N/mm²	Bohrer VHM	100.00	0.060	0.140	0.200	0.260	0.350	0.370
	Bohrer VHM	90.00	0.060	0.120	0.160	0.200	0.300	0.330
	Bohrer VHM	80.00	0.050	0.100	0.130	0.170	0.260	0.300
	Bohrer VHM	80.00	0.040	0.090	0.120	0.160	0.250	0.290
M Rost und säurebeständige Stähle Stainless steels	Bohrer VHM	60.00	0.022	0.055	0.110	0.200	0.250	0.300
	Bohrer VHM	50.00	0.020	0.052	0.090	0.180	0.200	0.250
K Gusseisen Cast iron	Bohrer VHM	120.00	0.075	0.140	0.220	0.350	0.500	0.520
	Bohrer VHM	90.00	0.070	0.140	0.210	0.350	0.430	0.450
	Bohrer VHM	90.00	0.065	0.130	0.200	0.300	0.400	0.420
N AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	220.00	0.070	0.130	0.220	0.320	0.350	0.400
	Bohrer VHM	200.00	0.070	0.120	0.220	0.320	0.350	0.400
	Bohrer VHM	180.00	0.070	0.120	0.220	0.320	0.350	0.400
	Bohrer VHM	130.00	0.070	0.120	0.160	0.210	0.270	0.300
Kunststoff Thermoplaste	Bohrer VHM	120.00	0.050	0.085	0.110	0.150	0.190	0.250