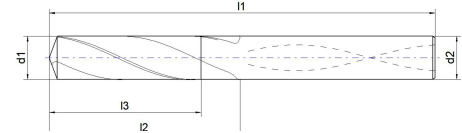


VHM-Inox-Spiralbohrer 3xD mit IK

Solid carbide twist drills 3xD for Inox with IC



Artikelnummer Article-No.	d1 m7	taps	forming taps	l1	l2	l3	d2 h6
E.3687.1.0300	3	-	-	62	20	14	6,0
E.3687.1.0310	3.1	-	-	62	20	14	6,0
E.3687.1.0320	3.2	-	-	62	20	14	6,0
E.3687.1.0330	3.3	M 4	M 3,5 x 0,5	62	20	14	6,0
E.3687.1.0340	3.4	-	-	62	20	14	6,0
E.3687.1.0350	3.5	M 4 x 0,5	-	62	20	14	6,0
E.3687.1.0360	3.6	-	-	62	20	14	6,0
E.3687.1.0370	3.7	M 4,5	M 4	62	20	14	6,0
E.3687.1.0380	3.8	-	M 4 x 0,5	66	24	17	6,0
E.3687.1.0390	3.9	-	-	66	24	17	6,0
E.3687.1.0400	4	M 4,5 x 0,5	-	66	24	17	6,0
E.3687.1.0410	4.1	-	-	66	24	17	6,0
E.3687.1.0420	4.2	M 5	M 4,5	66	24	17	6,0
E.3687.1.0430	4.3	-	M 4,5 x 0,5	66	24	17	6,0
E.3687.1.0440	4.4	-	-	66	24	17	6,0
E.3687.1.0450	4.5	M 5 x 0,5	-	66	24	17	6,0
E.3687.1.0460	4.6	M 5,5	-	66	24	17	6,0
E.3687.1.0470	4.7	-	M 5 x 0,75	66	24	17	6,0
E.3687.1.0480	4.8	-	M 5 x 0,5	66	28	20	6,0
E.3687.1.0490	4.9	-	-	66	28	20	6,0
E.3687.1.0500	5	M 6/M 5,5 x 0,5	-	66	28	20	6,0
E.3687.1.0510	5.1	-	M 5,5	66	28	20	6,0
E.3687.1.0520	5.2	M 6 x 0,75	-	66	28	20	6,0
E.3687.1.0530	5.3	-	M 5,5 x 0,5	66	28	20	6,0
E.3687.1.0540	5.4	-	-	66	28	20	6,0
E.3687.1.0550	5.5	M 6 x 0,5	-	66	28	20	6,0
E.3687.1.0560	5.6	-	M 6	66	28	20	6,0
E.3687.1.0570	5.7	-	M 6 x 0,75	66	28	20	6,0
E.3687.1.0580	5.8	-	M 6 x 0,5	66	28	20	6,0
E.3687.1.0590	5.9	-	-	66	28	20	6,0
E.3687.1.0600	6	M 7	-	66	28	20	6,0
E.3687.1.0610	6.1	-	-	79	34	24	8,0
E.3687.1.0620	6.2	M 7 x 0,75	-	79	34	24	8,0
E.3687.1.0630	6.3	-	-	79	34	24	8,0
E.3687.1.0640	6.4	-	-	79	34	24	8,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	d1 m7	taps	forming taps	l1	l2	l3	d2 h6
E.3687.1.0650	6.5	-	-	79	34	24	8,0
E.3687.1.0660	6.6	-	M 7	79	34	24	8,0
E.3687.1.0670	6.7	-	M 7 x 0,75	79	34	24	8,0
E.3687.1.0680	6.8	M 8	M 7 x 0,5	79	34	24	8,0
E.3687.1.0690	6.9	-	-	79	34	24	8,0
E.3687.1.0700	7	M 8 x 1,0	-	79	34	24	8,0
E.3687.1.0710	7.1	-	-	79	41	29	8,0
E.3687.1.0720	7.2	M 8 x 0,75	-	79	41	29	8,0
E.3687.1.0730	7.3	-	-	79	41	29	8,0
E.3687.1.0740	7.4	-	M 8	79	41	29	8,0
E.3687.1.0750	7.5	M 8 x 0,5	-	79	41	29	8,0
E.3687.1.0760	7.6	-	M 8 x 1,0	79	41	29	8,0
E.3687.1.0770	7.7	-	M 8 x 0,75	79	41	29	8,0
E.3687.1.0780	7.8	M 9	M 8 x 0,5	79	41	29	8,0
E.3687.1.0790	7.9	-	-	79	41	29	8,0
E.3687.1.0800	8	M 9 x 1,0	-	79	41	29	8,0
E.3687.1.0810	8.1	-	-	89	47	35	10,0
E.3687.1.0820	8.2	M 9 x 0,75	-	89	47	35	10,0
E.3687.1.0830	8.3	-	-	89	47	35	10,0
E.3687.1.0840	8.4	-	M 9	89	47	35	10,0
E.3687.1.0850	8.5	M 10	-	89	47	35	10,0
E.3687.1.0860	8.6	-	M 9 x 1,0	89	47	35	10,0
E.3687.1.0870	8.7	-	M 9 x 0,75	89	47	35	10,0
E.3687.1.0880	8.8	M 10 x 1,25	M 9 x 0,5	89	47	35	10,0
E.3687.1.0890	8.9	-	-	89	47	35	10,0
E.3687.1.0900	9	M 10 x 1,0	-	89	47	35	10,0
E.3687.1.0910	9.1	-	-	89	47	35	10,0
E.3687.1.0920	9.2	M 10 x 0,75	-	89	47	35	10,0
E.3687.1.0930	9.3	-	M 10	89	47	35	10,0
E.3687.1.0940	9.4	-	-	89	47	35	10,0
E.3687.1.0950	9.5	M 11	-	89	47	35	10,0
E.3687.1.0960	9.6	-	M 10 x 1,0	89	47	35	10,0
E.3687.1.0970	9.7	-	M 10 x 0,75	89	47	35	10,0
E.3687.1.0980	9.8	-	M 10 x 0,5	89	47	35	10,0
E.3687.1.0990	9.9	-	-	89	47	35	10,0
E.3687.1.1000	10	M 11 x 1,0	-	89	47	35	10,0
E.3687.1.1010	10.1	-	-	102	55	40	12,0
E.3687.1.1020	10.2	M 12/M11 x 0,75	-	102	55	40	12,0
E.3687.1.1030	10.3	-	-	102	55	40	12,0
E.3687.1.1040	10.4	-	-	102	55	40	12,0
E.3687.1.1050	10.5	M 12 x 1,5	-	102	55	40	12,0
E.3687.1.1060	10.6	-	M 11 x 1,0	102	55	40	12,0
E.3687.1.1070	10.7	-	M 11 x 0,75	102	55	40	12,0
E.3687.1.1080	10.8	M 12 x 1,25	-	102	55	40	12,0
E.3687.1.1090	10.9	-	-	102	55	40	12,0
E.3687.1.1100	11	M 12 x 1,0	-	102	55	40	12,0
E.3687.1.1110	11.1	-	-	102	55	40	12,0
E.3687.1.1120	11.2	-	M 12	102	55	40	12,0
E.3687.1.1130	11.3	-	-	102	55	40	12,0
E.3687.1.1140	11.4	-	-	102	55	40	12,0
E.3687.1.1150	11.5	-	-	102	55	40	12,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	d1 m7	taps	forming taps	l1	l2	l3	d2 h6
E.3687.1.1160	11.6	-	M 12 x 1,0	102	55	40	12,0
E.3687.1.1170	11.7	-	M 12 x 0,75	102	55	40	12,0
E.3687.1.1180	11.8	-	-	102	55	40	12,0
E.3687.1.1190	11.9	-	-	102	55	40	12,0
E.3687.1.1200	12	M 14	-	102	55	40	12,0
E.3687.1.1230	12.3	-	-	107	60	43	14,0
E.3687.1.1250	12.5	M 14 x 1,5	-	107	60	43	14,0
E.3687.1.1280	12.8	M 14 x 1,25	-	107	60	43	14,0
E.3687.1.1300	13	M 14 x 1,0	-	107	60	43	14,0
E.3687.1.1350	13.5	-	-	107	60	43	14,0
E.3687.1.1380	13.8	-	-	107	60	43	14,0
E.3687.1.1400	14	M 16/M15 x 1,0	-	107	60	43	14,0
E.3687.1.1420	14.2	-	-	115	65	45	16,0
E.3687.1.1450	14.5	M 16 x 1,5	-	115	65	45	16,0
E.3687.1.1480	14.8	-	-	115	65	45	16,0
E.3687.1.1500	15	M 16 x 1,0	-	115	65	45	16,0
E.3687.1.1550	15.5	M 18	-	115	65	45	16,0
E.3687.1.1580	15.8	-	-	115	65	45	16,0
E.3687.1.1600	16	M 18 x 2,0	-	115	65	45	16,0
E.3687.1.1650	16.5	-	-	123	73	51	18,0
E.3687.1.1680	16.8	-	-	123	73	51	18,0
E.3687.1.1700	17	-	-	123	73	51	18,0
E.3687.1.1750	17.5	M 20	-	123	73	51	18,0
E.3687.1.1780	17.8	-	-	123	73	51	18,0
E.3687.1.1800	18	-	-	123	73	51	18,0
E.3687.1.1850	18.5	-	-	131	79	55	20,0
E.3687.1.1900	19	-	-	131	79	55	20,0
E.3687.1.1950	19.5	M 22	-	131	79	55	20,0
E.3687.1.2000	20	-	-	131	79	55	20,0



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Materialbezeichnung material description	Bearbeitung Process	Vc m/min	fz				
			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	110.00	0.130	0.180	0.280	0.350	0.370
	Bohrer VHM	100.00	0.130	0.180	0.280	0.350	0.370
	Bohrer VHM	90.00	0.130	0.180	0.280	0.350	0.370
	Bohrer VHM	80.00	0.120	0.160	0.240	0.300	0.320
	Bohrer VHM	70.00	0.095	0.135	0.200	0.250	0.270
PV Vergütungsstähle < 850N/mm² Tempering steel < 850N/mm²	Bohrer VHM	90.00	0.130	0.180	0.280	0.350	0.370
	Bohrer VHM	80.00	0.120	0.160	0.240	0.300	0.320
	Bohrer VHM	70.00	0.095	0.135	0.200	0.250	0.270
	Bohrer VHM	60.00	0.095	0.135	0.200	0.250	0.270

PRODUCT DATA SHEET



	Materialbezeichnung material description	Bearbeitung Process	Vc m/min	fz				
				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
M	Rost und säurebeständige Stähle Stainless steels	Bohrer VHM	60.00	0.085	0.120	0.170	0.210	0.220
	Rost und säurebeständige Stähle >700N/mm² Stainless steels >700N/mm²	Bohrer VHM	50.00	0.065	0.095	0.140	0.180	0.190
K	Gusseisen Cast iron	Bohrer VHM	110.00	0.160	0.230	0.360	0.430	0.500
	Temperguss Malleable cast iron	Bohrer VHM	90.00	0.150	0.210	0.310	0.370	0.430
	Gusseisen mit Kugelgraphit Nodular cast iron	Bohrer VHM	80.00	0.140	0.190	0.280	0.350	0.400
N	AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	200.00	0.160	0.220	0.360	0.430	0.500
	AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	180.00	0.160	0.220	0.360	0.430	0.500
	AL- und AL-Legierungen >12% Si AL und AL-alloys >12% Si	Bohrer VHM	140.00	0.160	0.220	0.360	0.430	0.500
	Kupfer, Messing, Bronze, Rotguss Copper, brass, bronze, red brass	Bohrer VHM	120.00	0.130	0.180	0.280	0.320	0.360
S	Nickelbasierende Stähle Nickel based alloys	Bohrer VHM	40.00	0.060	0.100	0.160	0.200	0.210
	Titan Titanium	Bohrer VHM	35.00	0.040	0.060	0.100	0.110	0.120