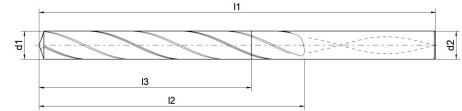


VHM-Inox-Spiralbohrer 8xd mit IK

Solid carbide twist drills 8xd with IC



Artikelnummer Article-No.	d1 m7	taps	forming taps	l1	l2	l3	d2 h6
E.3688.1.0300	3	-	-	71	34	27	6,0
E.3688.1.0310	3.1	-	-	71	34	27	6,0
E.3688.1.0320	3.2	-	-	71	34	27	6,0
E.3688.1.0330	3.3	M 4	M 3,5 x 0,5	71	34	27	6,0
E.3688.1.0340	3.4	-	-	71	34	27	6,0
E.3688.1.0350	3.5	M 4 x 0,5	-	71	34	27	6,0
E.3688.1.0360	3.6	-	-	71	34	27	6,0
E.3688.1.0370	3.7	M 4,5	M 4	71	34	27	6,0
E.3688.1.0380	3.8	-	M 4 x 0,5	86	43	35	6,0
E.3688.1.0390	3.9	-	-	86	43	35	6,0
E.3688.1.0400	4	M 4,5 x 0,5	-	86	43	35	6,0
E.3688.1.0410	4.1	-	-	86	43	35	6,0
E.3688.1.0420	4.2	M 5	M 4,5	86	43	35	6,0
E.3688.1.0430	4.3	-	M 4,5 x 0,5	86	43	35	6,0
E.3688.1.0440	4.4	-	-	86	43	35	6,0
E.3688.1.0450	4.5	M 5 x 0,5	-	86	43	35	6,0
E.3688.1.0460	4.6	M 5,5	-	86	43	35	6,0
E.3688.1.0470	4.7	-	M 5 x 0,75	95	57	35	6,0
E.3688.1.0490	4.9	-	-	95	57	45	6,0
E.3688.1.0500	5	M 6/M5,5 x 0,5	-	95	57	45	6,0
E.3688.1.0510	5.1	-	M 5,5	95	57	45	6,0
E.3688.1.0520	5.2	M 6 x 0,75	-	95	57	45	6,0
E.3688.1.0530	5.3	-	M 5,5 x 0,5	95	57	45	6,0
E.3688.1.0540	5.4	-	-	95	57	45	6,0
E.3688.1.0550	5.5	M 6 x 0,5	-	95	57	45	6,0
E.3688.1.0560	5.6	-	M 6	95	57	45	6,0
E.3688.1.0570	5.7	-	M 6 x 0,75	95	57	45	6,0
E.3688.1.0580	5.8	-	M 6 x 0,5	95	57	45	6,0
E.3688.1.0590	5.9	-	-	95	57	45	6,0
E.3688.1.0600	6	M 7	-	95	57	45	6,0
E.3688.1.0610	6.1	-	-	114	76	52	8,0
E.3688.1.0620	6.2	M 7 x 0,75	-	114	76	52	8,0
E.3688.1.0630	6.3	-	-	114	76	52	8,0
E.3688.1.0640	6.4	-	-	114	76	52	8,0
E.3688.1.0650	6.5	-	-	114	76	52	8,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	d1 m7	taps	forming taps	l1	l2	l3	d2 h6
E.3688.1.0660	6.6	-	M 7	114	76	52	8,0
E.3688.1.0670	6.7	-	M 7 x 0,75	114	76	52	8,0
E.3688.1.0680	6.8	M 8	M 7 x 0,5	114	76	52	8,0
E.3688.1.0690	6.9	-	-	114	76	52	8,0
E.3688.1.0700	7	M 8 x 1,0	-	114	76	60	8,0
E.3688.1.0710	7.1	M 8 x 0,75	-	114	76	60	8,0
E.3688.1.0720	7.2	-	-	114	76	60	8,0
E.3688.1.0730	7.3	-	-	114	76	60	8,0
E.3688.1.0740	7.4	-	M 8	114	76	60	8,0
E.3688.1.0750	7.5	M 8 x 0,5	-	114	76	60	8,0
E.3688.1.0760	7.6	-	M 8 x 1,0	114	76	60	8,0
E.3688.1.0770	7.7	-	M 8 x 0,75	114	76	60	8,0
E.3688.1.0780	7.8	M 9	M 8 x 0,5	114	76	60	8,0
E.3688.1.0790	7.9	-	-	114	76	60	8,0
E.3688.1.0800	8	M 9 x 1,0	-	114	76	60	8,0
E.3688.1.0810	8.1	-	-	142	95	68	10,0
E.3688.1.0820	8.2	M 9 x 0,75	-	142	95	68	10,0
E.3688.1.0830	8.3	-	-	142	95	68	10,0
E.3688.1.0840	8.4	-	M 9	142	95	68	10,0
E.3688.1.0850	8.5	M 10	-	142	95	68	10,0
E.3688.1.0860	8.6	-	M 9 x 1,0	142	95	68	10,0
E.3688.1.0870	8.7	-	M 9 x 0,75	142	95	68	10,0
E.3688.1.0880	8.8	M 10 x 1,25	M 9 x 0,5	142	95	68	10,0
E.3688.1.0890	8.9	-	-	142	95	68	10,0
E.3688.1.0900	9	M 10 x 1,0	-	142	95	68	10,0
E.3688.1.0910	9.1	-	-	142	95	76	10,0
E.3688.1.0920	9.2	M 10 x 0,75	-	142	95	76	10,0
E.3688.1.0930	9.3	-	M 10	142	95	76	10,0
E.3688.1.0940	9.4	-	-	142	95	76	10,0
E.3688.1.0950	9.5	M 11	-	142	95	76	10,0
E.3688.1.0960	9.6	-	M 10 x 1,0	142	95	76	10,0
E.3688.1.0970	9.7	-	M 10 x 0,75	142	95	76	10,0
E.3688.1.0980	9.8	-	M 10 x 0,5	142	95	76	10,0
E.3688.1.0990	9.9	-	-	142	95	76	10,0
E.3688.1.1000	10	M 11 x 1,0	-	142	95	76	10,0
E.3688.1.1010	10.1	-	-	162	114	90	12,0
E.3688.1.1020	10.2	M 12/M11 x 0,75	-	162	114	90	12,0
E.3688.1.1030	10.3	-	-	162	114	90	12,0
E.3688.1.1040	10.4	-	-	162	114	90	12,0
E.3688.1.1050	10.5	M 12 x 1,5	-	162	114	90	12,0
E.3688.1.1060	10.6	-	M 11 x 1,0	162	114	90	12,0
E.3688.1.1070	10.7	-	M 11 x 0,75	162	114	90	12,0
E.3688.1.1080	10.8	M 12 x 1,25	-	162	114	90	12,0
E.3688.1.1090	10.9	-	-	162	114	90	12,0
E.3688.1.1100	11	M 12 x 1,0	-	162	114	90	12,0
E.3688.1.1110	11.1	-	-	162	114	90	12,0
E.3688.1.1120	11.2	-	M 12	162	114	90	12,0
E.3688.1.1130	11.3	-	-	162	114	90	12,0
E.3688.1.1140	11.4	-	-	162	114	90	12,0
E.3688.1.1150	11.5	-	-	162	114	90	12,0
E.3688.1.1160	11.6	-	M 12 x 1,0	162	114	90	12,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	d1 m7	taps	forming taps	l1	l2	l3	d2 h6
E.3688.1.1170	11.7	-	M 12 x 0,75	162	114	90	12,0
E.3688.1.1180	11.8	-	-	162	114	90	12,0
E.3688.1.1190	11.9	-	-	162	114	90	12,0
E.3688.1.1200	12	M 14	-	162	114	90	12,0
E.3688.1.1250	12.5	M 14 x 1,5	-	184	133	106	14,0
E.3688.1.1280	12.8	M 14 x 1,25	-	184	133	106	14,0
E.3688.1.1300	13	M 14 x 1,0	-	184	133	106	14,0
E.3688.1.1350	13.5	-	-	184	133	106	14,0
E.3688.1.1400	14	M 16/M15 x 1,0	-	184	133	106	14,0
E.3688.1.1450	14.5	M 16 x 1,5	-	203	152	122	16,0
E.3688.1.1500	15	M 16 x 1,0	-	203	152	122	16,0
E.3688.1.1550	15.5	M 18	-	203	152	122	16,0
E.3688.1.1600	16	M 18 x 2,0	-	203	152	122	16,0
E.3688.1.1650	16.5	-	-	222	171	150	18,0
E.3688.1.1700	17	-	-	222	171	150	18,0
E.3688.1.1750	17.5	M 20	-	222	171	150	18,0
E.3688.1.1800	18	-	-	222	171	150	18,0
E.3688.1.1850	18.5	-	-	243	190	170	20,0
E.3688.1.1900	19	-	-	243	190	170	20,0
E.3688.1.2000	20	M 22	-	243	190	170	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 12.00-15.50	Ø 16.00-20.00
PA allg. Stähle General steels	Bohrer VHM	100.00	0.130	0.170	0.260	0.300	0.340
	Bohrer VHM	90.00	0.130	0.170	0.260	0.300	0.340
	Bohrer VHM	80.00	0.130	0.170	0.260	0.300	0.340
	Bohrer VHM	70.00	0.110	0.150	0.230	0.270	0.300
	Bohrer VHM	60.00	0.090	0.125	0.190	0.230	0.260
PV Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ²	Bohrer VHM	80.00	0.130	0.170	0.260	0.300	0.340
	Bohrer VHM	70.00	0.110	0.150	0.230	0.270	0.300
	Bohrer VHM	60.00	0.090	0.125	0.190	0.230	0.260
	Bohrer VHM	50.00	0.090	0.125	0.190	0.230	0.260
M Rost und säurebeständige Stähle Stainless steels	Bohrer VHM	60.00	0.085	0.120	0.150	0.180	0.230
	Bohrer VHM	50.00	0.085	0.120	0.150	0.180	0.230
K Gusseisen Cast iron	Bohrer VHM	110.00	0.160	0.022	0.280	0.340	0.420
	Bohrer VHM	100.00	0.160	0.220	0.280	0.340	0.420
	Bohrer VHM	90.00	0.160	0.220	0.280	0.340	0.420

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 12.00-15.50	Ø 16.00-20.00
N	AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	145.00	0.200	0.250	0.320	0.370	0.400
	AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	135.00	0.200	0.250	0.320	0.370	0.400
	AL- und AL-Legierungen >12% Si AL und AL-alloys >12% Si	Bohrer VHM	125.00	0.200	0.250	0.300	0.350	0.400
	Kupfer, Messing, Bronze, Rotguss Copper, brass, bronze, red brass	Bohrer VHM	120.00	0.200	0.220	0.280	0.320	0.370
S	Nickelbasierende Stähle Nickel based alloys	Bohrer VHM	35.00	0.080	0.100	0.160	0.200	0.220
	Titan Titanium	Bohrer VHM	30.00	0.045	0.060	0.090	0.110	0.120