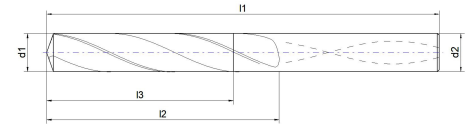


VHM-Inox-Spiralbohrer 5xd mit IK

Solid carbide twist drills 5xd with IC für Inox



Artikelnummer Article-No.	forming taps	d1	taps	l1	l2	l3	d2 h6
E.3690.1.0100	M 1,1	1	-	55	10	6.5	3,0
E.3690.1.0110	M 1,2	1.1	M 1,4	55	12	9.5	3,0
E.3690.1.0120	-	1.2	-	55	12	9.5	3,0
E.3690.1.0130	-	1.3	-	55	12	9.5	3,0
E.3690.1.0140	-	1.4	-	55	12	9.5	3,0
E.3690.1.0150	-	1.5	-	55	12	9.5	3,0
E.3690.1.0160	-	1.6	M 2	55	16	13	3,0
E.3690.1.0170	-	1.7	-	55	16	13	3,0
E.3690.1.0180	M 2	1.8	M 2,2	55	16	13	3,0
E.3690.1.0190	-	1.9	M 2,3	55	16	13	3,0
E.3690.1.0200	-	2	-	57	21	13	3,0
E.3690.1.0210	-	2.1	-	57	21	21	3,0
E.3690.1.0220	-	2.2	-	57	21	21	3,0
E.3690.1.0230	-	2.3	-	57	21	21	3,0
E.3690.1.0240	-	2.4	-	57	21	21	3,0
E.3690.1.0250	-	2.5	M 3	57	21	21	3,0
E.3690.1.0260	-	2.6	-	57	21	21	3,0
E.3690.1.0270	-	2.7	-	57	21	21	3,0
E.3690.1.0280	M 3	2.8	-	57	21	21	3,0
E.3690.1.0290	M 3 x 0,25	2.9	M 3,5	57	21	21	3,0
E.3690.1.0300	-	3	-	66	28	23	6,0
E.3690.1.0310	-	3.1	-	66	28	23	6,0
E.3690.1.0320	-	3.2	-	66	28	23	6,0
E.3690.1.0330	M 3,5 x 0,5	3.3	M 4	66	28	23	6,0
E.3690.1.0340	-	3.4	-	66	28	23	6,0
E.3690.1.0350	-	3.5	M 4 x 0,5	66	28	23	6,0
E.3690.1.0360	-	3.6	-	66	28	23	6,0
E.3690.1.0370	M 4	3.7	M 4,5	66	28	23	6,0
E.3690.1.0380	M 4 x 0,5	3.8	-	74	36	29	6,0
E.3690.1.0390	-	3.9	-	74	36	29	6,0
E.3690.1.0400	-	4	M 4,5 x 0,5	74	36	29	6,0
E.3690.1.0410	-	4.1	-	74	36	29	6,0
E.3690.1.0420	M 4,5	4.2	M 5	74	36	29	6,0
E.3690.1.0430	M 4,5 x 0,5	4.3	-	74	36	29	6,0
E.3690.1.0440	-	4.4	-	74	36	29	6,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	forming taps	d1	taps	l1	l2	l3	d2 h6
E.3690.1.0450	-	4.5	M 5 x 0,5	74	36	29	6,0
E.3690.1.0460	-	4.6	M 5,5	74	36	29	6,0
E.3690.1.0470	M 5 x 0,75	4.7	-	74	36	29	6,0
E.3690.1.0480	M 5 x 0,5	4.8	-	82	44	35	6,0
E.3690.1.0490	-	4.9	-	82	44	35	6,0
E.3690.1.0500	-	5	M 6 / M5,5x0,5	82	44	35	6,0
E.3690.1.0510	M 5,5	5.1	-	82	44	35	6,0
E.3690.1.0520	-	5.2	M 6 x 0,75	82	44	35	6,0
E.3690.1.0530	M 5,5 x 0,5	5.3	-	82	44	35	6,0
E.3690.1.0540	-	5.4	-	82	44	35	6,0
E.3690.1.0550	-	5.5	M 6 x 0,5	82	44	35	6,0
E.3690.1.0560	M 6	5.6	-	82	44	35	6,0
E.3690.1.0570	M 6 x 0,75	5.7	-	82	44	35	6,0
E.3690.1.0580	M 6 x 0,5	5.8	-	82	44	35	6,0
E.3690.1.0590	-	5.9	-	82	44	35	6,0
E.3690.1.0600	-	6	M 7	82	44	35	6,0
E.3690.1.0610	-	6.1	-	91	53	43	8,0
E.3690.1.0620	-	6.2	M 7 x 0,75	91	53	43	8,0
E.3690.1.0630	-	6.3	-	91	53	43	8,0
E.3690.1.0640	-	6.4	-	91	53	43	8,0
E.3690.1.0650	-	6.5	-	91	53	43	8,0
E.3690.1.0660	M 7	6.6	-	91	53	43	8,0
E.3690.1.0670	M 7 x 0,75	6.7	-	91	53	43	8,0
E.3690.1.0680	M 7 x 0,5	6.8	M 8	91	53	43	8,0
E.3690.1.0690	-	6.9	-	91	53	43	8,0
E.3690.1.0700	-	7	M 8 x 1	91	53	43	8,0
E.3690.1.0710	-	7.1	-	91	53	43	8,0
E.3690.1.0720	-	7.2	M 8 x 0,75	91	53	43	8,0
E.3690.1.0730	-	7.3	-	91	53	43	8,0
E.3690.1.0740	M 8	7.4	-	91	53	43	8,0
E.3690.1.0750	-	7.5	M 8 x 0,5	91	53	43	8,0
E.3690.1.0760	M 8 x 1	7.6	-	91	53	43	8,0
E.3690.1.0770	M 8 x 0,75	7.7	-	91	53	43	8,0
E.3690.1.0780	M 8 x 0,5	7.8	M 9	91	53	43	8,0
E.3690.1.0790	-	7.9	-	91	53	43	8,0
E.3690.1.0800	-	8	M 9 x 1	91	53	43	8,0
E.3690.1.0810	-	8.1	-	103	61	49	10,0
E.3690.1.0820	-	8.2	M 9 x 0,75	103	61	49	10,0
E.3690.1.0830	-	8.3	-	103	61	49	10,0
E.3690.1.0840	M 9	8.4	-	103	61	49	10,0
E.3690.1.0850	-	8.5	M 10	103	61	49	10,0
E.3690.1.0860	M 9 x 1	8.6	-	103	61	49	10,0
E.3690.1.0870	M 9 x 0,75	8.7	-	103	61	49	10,0
E.3690.1.0880	M 9 x 0,5	8.8	M 10 x 1,25	103	61	49	10,0
E.3690.1.0890	-	8.9	-	103	61	49	10,0
E.3690.1.0900	-	9	M 10 x 1	103	61	49	10,0
E.3690.1.0910	-	9.1	-	103	61	49	10,0
E.3690.1.0920	-	9.2	M 10 x 0,75	103	61	49	10,0
E.3690.1.0930	M 10	9.3	-	103	61	49	10,0
E.3690.1.0940	-	9.4	-	103	61	49	10,0
E.3690.1.0950	-	9.5	M 11	103	61	49	10,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	forming taps	d1	taps	l1	l2	l3	d2 h6
E.3690.1.0960	M 10 x 1	9.6	-	103	61	49	10,0
E.3690.1.0970	M 10 x 0,75	9.7	-	103	61	49	10,0
E.3690.1.0980	M 10 x 0,5	9.8	-	103	61	49	10,0
E.3690.1.0990	-	9.9	-	103	61	49	10,0
E.3690.1.1000	-	10	M 11 x 1	103	61	49	10,0
E.3690.1.1010	-	10.1	-	118	71	56	12,0
E.3690.1.1020	-	10.2	M 12 / M11x0,75	118	71	56	12,0
E.3690.1.1030	-	10.3	-	118	71	56	12,0
E.3690.1.1040	-	10.4	-	118	71	56	12,0
E.3690.1.1050	-	10.5	M 12 x 1,5	118	71	56	12,0
E.3690.1.1060	M 11 x 1	10.6	-	118	71	56	12,0
E.3690.1.1070	M 11 x 0,75	10.7	-	118	71	56	12,0
E.3690.1.1080	-	10.8	M 12 x 1,25	118	71	56	12,0
E.3690.1.1090	-	10.9	-	118	71	56	12,0
E.3690.1.1100	-	11	M 12 x 1	118	71	56	12,0
E.3690.1.1110	-	11.1	-	118	71	56	12,0
E.3690.1.1120	M 12	11.2	-	118	71	56	12,0
E.3690.1.1130	-	11.3	-	118	71	56	12,0
E.3690.1.1140	-	11.4	-	118	71	56	12,0
E.3690.1.1150	-	11.5	-	118	71	56	12,0
E.3690.1.1160	M 12 x 1	11.6	-	118	71	56	12,0
E.3690.1.1170	M 12 x 0,75	11.7	-	118	71	56	12,0
E.3690.1.1180	-	11.8	-	118	71	56	12,0
E.3690.1.1190	-	11.9	-	118	71	56	12,0
E.3690.1.1200	-	12	M 14	118	71	56	12,0
E.3690.1.1220	-	12.2	-	124	77	60	14,0
E.3690.1.1230	-	12.3	-	124	77	60	14,0
E.3690.1.1250	-	12.5	M 14 x 1,5	124	77	60	14,0
E.3690.1.1280	-	12.8	M 14 x 1,25	124	77	60	14,0
E.3690.1.1300	-	13	M 14 x 1	124	77	60	14,0
E.3690.1.1350	-	13.5	-	124	77	60	14,0
E.3690.1.1380	-	13.8	-	124	77	60	14,0
E.3690.1.1400	-	14	M 16 / M 15 x 1	124	77	60	14,0
E.3690.1.1450	-	14.5	M 16 x 1,5	133	83	63	16,0
E.3690.1.1480	-	14.8	-	133	83	63	16,0
E.3690.1.1500	-	15	M 16 x 1	133	83	63	16,0
E.3690.1.1550	-	15.5	M 18	133	83	63	16,0
E.3690.1.1580	-	15.8	-	133	83	63	16,0
E.3690.1.1600	-	16	M 18 x 2	133	83	63	16,0
E.3690.1.1650	-	16.5	-	143	93	71	18,0
E.3690.1.1680	-	16.8	-	143	93	71	18,0
E.3690.1.1700	-	17	-	143	93	71	18,0
E.3690.1.1750	-	17.5	M 20	143	93	71	18,0
E.3690.1.1780	-	17.8	-	143	93	71	18,0
E.3690.1.1800	-	18	-	143	93	71	18,0
E.3690.1.1850	-	18.5	-	153	101	77	20,0
E.3690.1.1900	-	19	-	153	101	77	20,0
E.3690.1.1950	-	19.5	M 22	153	101	77	20,0
E.3690.1.2000	-	20	-	153	101	77	20,0

PRODUCT DATA SHEET



Individuelle Schnittdaten online im
Schnittdaten-Rechner berechnen lassen:
Calculate individual cutting
data online in the cutting data calculator
www.nachreiner-schnittdaten.eu

PRODUCT DATA SHEET



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	0.130	0.190	0.290	0.360	0.380
	Bohrer VHM	110.00	0.060	0.130	0.190	0.290	0.360	0.380
	Bohrer VHM	100.00	0.060	0.130	0.190	0.290	0.360	0.380
	Bohrer VHM	90.00	0.060	0.120	0.170	0.250	0.310	0.330
	Bohrer VHM	80.00	0.045	0.090	0.140	0.210	0.260	0.285
PV Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ²	Bohrer VHM	100.00	0.025	0.130	0.220	0.280	0.320	0.350
	Bohrer VHM	90.00	0.025	0.120	0.220	0.280	0.320	0.350
	Bohrer VHM	80.00	0.020	0.090	0.180	0.250	0.300	
	Bohrer VHM	70.00	0.020	0.090	0.180	0.250	0.300	
M Rost und säurebeständige Stähle Stainless steels	Bohrer VHM	60.00	0.040	0.085	0.120	0.150	0.190	0.250
	Bohrer VHM	50.00	0.030	0.060	0.090	0.130	0.170	0.210
K Gusseisen Cast iron	Bohrer VHM	120.00	0.060	0.120	0.200	0.210	0.270	0.350
	Bohrer VHM	100.00	0.050	0.120	0.200	0.210	0.270	0.350
	Bohrer VHM	90.00	0.050	0.110	0.180	0.200	0.230	0.300
N AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	200.00	0.070	0.150	0.250	0.340	0.410	0.490
	Bohrer VHM	180.00	0.070	0.150	0.250	0.340	0.410	0.490
	Bohrer VHM	160.00	0.070	0.150	0.250	0.340	0.410	0.490
	Bohrer VHM	140.00	0.060	0.140	0.190	0.260	0.320	0.360
S Nickelbasierende Stähle Nickel based alloys	Bohrer VHM	40.00	0.035	0.080	0.120	0.160	0.200	0.230
	Bohrer VHM	35.00	0.030	0.050	0.060	0.090	0.110	0.130