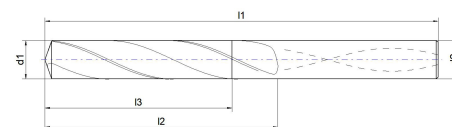


VHM-Universal-Spiralbohrer 5xd mit IK

Solid carbide universal twist drills 5xd mit IK



Artikelnummer Article-No.	taps	forming taps	d1 m7	l1	l2	l3	d2 h6
E.3617.1.0100	-	M 1,1	1	55	10	7	3,0
E.3617.1.0110	M 1,4	M 1,2	1.1	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	M 2	-	1.6	55	16	13	3,0
E.3617.1.0170	-	-	1.7	55	16	13	3,0
E.3617.1.0180	M 2,2	M 2	1.8	55	16	13	3,0
E.3617.1.0190	M 2,3	-	1.9	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	M 3	-	2.5	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 3,5	M 3 x 0,25	2.9	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 4	M 3,5 x 0,5	3.3	67	28	23	6,0
E.3617.1.0340	-	-	3.4	67	28	23	6,0
E.3617.1.0350	M 4 x 0,5	-	3.5	67	28	23	6,0
E.3617.1.0360	-	-	3.6	67	28	23	6,0
E.3617.1.0370	M 4,5	M 4	3.7	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	M 4,5 x 0,5	-	4	75	36	29	6,0
E.3617.1.0410	-	-	4.1	75	36	29	6,0
E.3617.1.0420	M 5	M 4,5	4.2	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.	taps	forming taps	d1 m7	l1	l2	l3	d2 h6
E.3617.1.0450	M 5 x 0,5	-	4.5	75	36	29	6,0
E.3617.1.0460	M 5,5	-	4.6	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	M 6 / M5,5x0,5	-	5	83	44	35	6,0
E.3617.1.0510	-	M 5,5	5.1	83	44	35	6,0
E.3617.1.0520	M 6 x 0,75	-	5.2	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	M 6 x 0,5	-	5.5	83	44	35	6,0
E.3617.1.0555	-	M 6	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	M 7	-	6	83	44	35	6,0
E.3617.1.0610	-	-	6.1	92	53	43	8,0
E.3617.1.0620	M 7 x 0,75	-	6.2	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 8	M 7 x 0,5	6.8	92	53	43	8,0
E.3617.1.0690	-	-	6.9	92	53	43	8,0
E.3617.1.0700	M 8 x 1	-	7	92	53	43	8,0
E.3617.1.0710	-	-	7.1	92	53	43	8,0
E.3617.1.0720	M 8 x 0,75	-	7.2	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	M 8 x 0,5	-	7.5	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 9	M 8 x 0,5	7.8	92	53	43	8,0
E.3617.1.0790	-	-	7.9	92	53	43	8,0
E.3617.1.0800	M 9 x 1	-	8	92	53	43	8,0
E.3617.1.0810	-	-	8.1	104	61	49	10,0
E.3617.1.0820	M 9 x 0,75	-	8.2	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	M 10	-	8.5	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 10 x 1,25	M 9 x 0,5	8.8	104	61	49	10,0
E.3617.1.0890	-	-	8.9	104	61	49	10,0
E.3617.1.0900	M 10 x 1	-	9	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	M 10 x 0,75	-	9.2	104	61	49	10,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	taps	forming taps	d1 m7	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	M 11	-	9.5	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	M 11 x 1	-	10	104	61	49	10,0
E.3617.1.1010	-	-	10.1	120	71	56	12,0
E.3617.1.1020	M 12 / M11x0,75	-	10.2	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	M 12 x 1,5	-	10.5	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	M 12 x 1,25	-	10.8	120	71	56	12,0
E.3617.1.1090	-	-	10.9	120	71	56	12,0
E.3617.1.1100	M 12 x 1	-	11	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	M 14	-	12	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	M 14 x 1,5	-	12.5	126	77	60	14,0
E.3617.1.1280	M 14 x 1,25	-	12.8	126	77	60	14,0
E.3617.1.1300	M 14 x 1	-	13	126	77	60	14,0
E.3617.1.1310	M 14 x 1	-	13.1	126	77	60	14,0
E.3617.1.1320	M 14 x 1	-	13.2	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	M 16 / M 15 x 1	-	14	126	77	60	14,0
E.3617.1.1420	M 16 x 1,5	-	14.5	135	83	63	16,0
E.3617.1.1450	M 16 x 1,5	-	14.5	135	83	63	16,0
E.3617.1.1480	-	-	14.8	135	83	63	16,0
E.3617.1.1500	M 16 x 1	-	15	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	M 18	-	15.5	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	M 18 x 2	-	16	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

PRODUCT DATA SHEET



Artikelnummer Article-No.	taps	forming taps	d1 m7	l1	l2	l3	d2 h6
E.3617.1.1700	-	-	17	145	93	71	18,0
E.3617.1.1750	M 20	-	17.5	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	M 22	-	19.5	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											
			∅ 1.00-2.90	∅ 3.00-5.90	∅ 6.00-8.90	∅ 9.00-11.90	∅ 12.00-15.50	∅ 15.70	∅ 15.80	∅ 16.00	∅ 16.20	∅ 16.50		
PA allg. Stähle General steels	Bohrer VHM	120.00	0.060	0.140	0.200	0.260	0.350	0.350	0.370	0.3				
	Bohrer VHM	110.00	0.060	0.140	0.200	0.260	0.350	0.350	0.370	0.3				
	Bohrer VHM	100.00	0.060	0.140	0.200	0.260	0.350	0.350	0.370	0.3				
	Bohrer VHM	90.00	0.055	0.120	0.160	0.200	0.300	0.300	0.330	0.3				
PV Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ²	Bohrer VHM	100.00	0.060	0.140	0.200	0.260	0.350	0.350	0.370	0.3				
	Bohrer VHM	90.00	0.060	0.120	0.160	0.200	0.300	0.300	0.330	0.3				
	Bohrer VHM	80.00	0.050	0.100	0.130	0.170	0.260	0.260	0.300	0.3				
	Bohrer VHM	80.00	0.040	0.090	0.120	0.160	0.250	0.250	0.290	0.2				
M Rost und säurebeständige Stähle Stainless steels	Bohrer VHM	60.00	0.022	0.055	0.110	0.200	0.250	0.250	0.300	0.3				
	Bohrer VHM	50.00	0.020	0.052	0.090	0.180	0.200	0.200	0.250	0.2				
K Gusseisen Cast iron	Bohrer VHM	120.00	0.075	0.140	0.220	0.350	0.500	0.500	0.520	0.5				
	Bohrer VHM	90.00	0.070	0.140	0.210	0.350	0.430	0.430	0.450	0.4				
	Bohrer VHM	90.00	0.065	0.130	0.200	0.300	0.400	0.400	0.420	0.4				
N AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	220.00	0.070	0.130	0.220	0.320	0.350	0.350	0.400	0.4				
	Bohrer VHM	200.00	0.070	0.120	0.220	0.320	0.350	0.350	0.400	0.4				
	Bohrer VHM	180.00	0.070	0.120	0.220	0.320	0.350	0.350	0.400	0.4				
	Bohrer VHM	130.00	0.070	0.120	0.160	0.210	0.270	0.270	0.300	0.3				
Kunststoff Thermoplaste	Bohrer VHM	120.00	0.050	0.085	0.110	0.150	0.190	0.190	0.250	0.2				