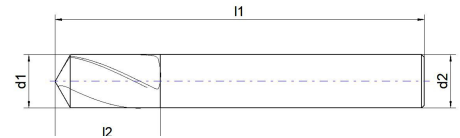
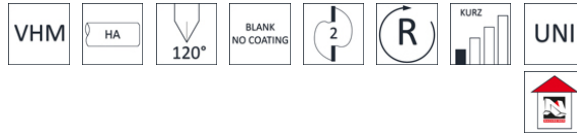


VHM-NC-Anbohrer Solid carbide NC-center drills



| Artikelnummer Article-No. | d1 h6 | l1 | l2 | d2 |
|------------------------------|-------|----|----|------|
| E.3633.0.0300 | 3 | 32 | 8 | 3,0 |
| E.3633.0.0400 | 4 | 40 | 10 | 4,0 |
| E.3633.0.0500 | 5 | 50 | 13 | 5,0 |
| E.3633.0.0600 | 6 | 50 | 13 | 6,0 |
| E.3633.0.0800 | 8 | 63 | 16 | 8,0 |
| E.3633.0.1000 | 10 | 72 | 20 | 10,0 |
| E.3633.0.1200 | 12 | 73 | 24 | 12,0 |
| E.3633.0.1600 | 16 | 82 | 28 | 16,0 |



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

| Materialbezeichnung material description | Bearbeitung Process | Vc m/min | fz | | | |
|--|------------------------|-------------|----------------|----------------|-----------------|------------------|
| | | | ∅ 3.00-4.00 | ∅ 5.00-6.00 | ∅ 8.00-10.00 | ∅ 12.00-16.00 |
| PA allg. Stähle General steels | Bohrer VHM | 90.00 | 0.120 | 0.170 | 0.300 | 0.400 |
| | Bohrer VHM | 80.00 | 0.120 | 0.170 | 0.300 | 0.400 |
| | Bohrer VHM | 80.00 | 0.120 | 0.170 | 0.300 | 0.400 |
| | Bohrer VHM | 60.00 | 0.080 | 0.140 | 0.250 | 0.330 |
| | Bohrer VHM | 50.00 | 0.065 | 0.120 | 0.200 | 0.270 |
| PV Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ² | Bohrer VHM | 50.00 | 0.075 | 0.130 | 0.230 | 0.300 |
| | Bohrer VHM | 40.00 | 0.065 | 0.120 | 0.200 | 0.270 |
| | Bohrer VHM | 35.00 | 0.060 | 0.100 | 0.180 | 0.250 |
| M Vergütungsstähle > 1400N/mm ² Tempering steel > 1400N/mm ² | Bohrer VHM | 35.00 | 0.060 | 0.100 | 0.180 | 0.250 |
| | Bohrer VHM | 40.00 | 0.070 | 0.140 | 0.200 | 0.300 |
| K Rost und säurebeständige Stähle Stainless steels | Bohrer VHM | 30.00 | 0.070 | 0.140 | 0.200 | 0.300 |
| | Bohrer VHM | 90.00 | 0.110 | 0.200 | 0.330 | 0.420 |
| K Gusseisen Cast iron | Bohrer VHM | 85.00 | 0.090 | 0.150 | 0.300 | 0.400 |
| | Bohrer VHM | 80.00 | 0.090 | 0.150 | 0.300 | 0.400 |

PRODUCT DATA SHEET



| Materialbezeichnung material description | Bearbeitung Process | Vc m/min | fz | | | | |
|---|---|-------------|----------------|----------------|-----------------|------------------|-------|
| | | | ∅ 3.00-4.00 | ∅ 5.00-6.00 | ∅ 8.00-10.00 | ∅ 12.00-16.00 | |
| N | AL- und AL-Legierungen AL und AL-alloys | Bohrer VHM | 200.00 | 0.130 | 0.200 | 0.250 | 0.300 |
| | AL- und AL-Legierungen AL und AL-alloys | Bohrer VHM | 180.00 | 0.130 | 0.200 | 0.250 | 0.300 |
| | AL- und AL-Legierungen >12% Si AL und AL-alloys >12% Si | Bohrer VHM | 140.00 | 0.130 | 0.200 | 0.250 | 0.300 |
| | Kupfer, Messing, Bronze, Rotguss Copper, brass, bronze, red brass | Bohrer VHM | 105.00 | 0.130 | 0.200 | 0.250 | 0.300 |
| | Kunststoff Thermoplaste | Bohrer VHM | 120.00 | 0.130 | 0.200 | 0.250 | 0.300 |
| | Duroplaste Duroplast | Bohrer VHM | 100.00 | 0.130 | 0.200 | 0.250 | 0.300 |
| S | Nickelbasierende Stähle Nickel based alloys | Bohrer VHM | 30.00 | 0.060 | 0.130 | 0.180 | 0.270 |
| | Titan Titanium | Bohrer VHM | 35.00 | 0.070 | 0.150 | 0.200 | 0.300 |