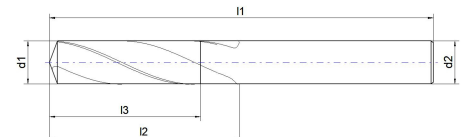


VHM-Universal-Spiralbohrer 3xd ohne IK

Solid carbide universal twist drills 3xd without IC



Artikelnummer Article-No.	forming taps	taps	d1 m7	l1	l2	l3	d2 h6
E.3645.1.0100	M 1,1	-	1	39	8	3	3,0
E.3645.1.0110	M 1,2	M 1,4	1.1	39	8	3	3,0
E.3645.1.0120	-	-	1.2	39	8	3	3,0
E.3645.1.0130	-	-	1.3	39	8	3	3,0
E.3645.1.0140	-	-	1.4	39	8	3	3,0
E.3645.1.0150	-	-	1.5	50	8	5	3,0
E.3645.1.0160	-	M 2	1.6	50	8	5	3,0
E.3645.1.0170	-	-	1.7	50	10	7	3,0
E.3645.1.0180	-	-	1.8	50	10	7	3,0
E.3645.1.0190	-	M 2,3	1.9	50	10	7	3,0
E.3645.1.0200	-	-	2	50	16	10	3,0
E.3645.1.0210	-	-	2.1	50	16	10	3,0
E.3645.1.0220	-	-	2.2	50	16	10	3,0
E.3645.1.0230	-	-	2.3	50	16	10	3,0
E.3645.1.0240	-	-	2.4	50	16	10	3,0
E.3645.1.0250	-	M 3	2.5	50	20	14	3,0
E.3645.1.0260	-	-	2.6	50	20	14	3,0
E.3645.1.0270	-	-	2.7	50	20	14	3,0
E.3645.1.0280	M 3	-	2.8	50	20	14	3,0
E.3645.1.0290	M 3 x 0,25	M 3,5	2.9	50	20	14	3,0
E.3645.1.0300	-	-	3	63	20	14	6,0
E.3645.1.0310	-	-	3.1	63	20	14	6,0
E.3645.1.0320	-	-	3.2	63	20	14	6,0
E.3645.1.0330	M 3,5 x 0,	M 4	3.3	63	20	14	6,0
E.3645.1.0340	-	-	3.4	63	20	14	6,0
E.3645.1.0350	-	M 4 x 0,5	3.5	63	20	14	6,0
E.3645.1.0360	-	-	3.6	63	20	14	6,0
E.3645.1.0370	M 4	M 4,5	3.7	63	20	14	6,0
E.3645.1.0380	M 4 x 0,5	-	3.8	67	24	17	6,0
E.3645.1.0390	-	-	3.9	67	24	17	6,0
E.3645.1.0400	-	M 4,5 x 0,	4	67	24	17	6,0
E.3645.1.0410	-	-	4.1	67	24	17	6,0
E.3645.1.0420	M 4,5	M 5	4.2	67	24	17	6,0
E.3645.1.0430	M 4,5 x 0,	-	4.3	67	24	17	6,0
E.3645.1.0440	-	-	4.4	67	24	17	6,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	forming taps	taps	d1 m7	l1	l2	l3	d2 h6
E.3645.1.0450	-	M 5 x 0,5	4.5	67	24	17	6,0
E.3645.1.0460	-	M 5,5	4.6	67	24	17	6,0
E.3645.1.0470	M 5 x 0,75	-	4.7	67	24	17	6,0
E.3645.1.0480	M 5 x 0,5	-	4.8	67	28	20	6,0
E.3645.1.0490	-	-	4.9	67	28	20	6,0
E.3645.1.0500	-	M 6/M 5,5	5	67	28	20	6,0
E.3645.1.0510	M 5,5	-	5.1	67	28	20	6,0
E.3645.1.0520	-	M 6 x 0,75	5.2	67	28	20	6,0
E.3645.1.0530	M 5,5 x 0,	-	5.3	67	28	20	6,0
E.3645.1.0540	-	-	5.4	67	28	20	6,0
E.3645.1.0550	-	M 6 x 0,5	5.5	67	28	20	6,0
E.3645.1.0560	M 6	-	5.6	67	28	20	6,0
E.3645.1.0570	M 6 x 0,75	-	5.7	67	28	20	6,0
E.3645.1.0580	M 6 x 0,5	-	5.8	67	28	20	6,0
E.3645.1.0590	-	-	5.9	67	28	20	6,0
E.3645.1.0600	-	M 7	6	67	28	20	6,0
E.3645.1.0610	-	-	6.1	80	34	24	8,0
E.3645.1.0620	-	M 7 x 0,75	6.2	80	34	24	8,0
E.3645.1.0630	-	-	6.3	80	34	24	8,0
E.3645.1.0640	-	-	6.4	80	34	24	8,0
E.3645.1.0650	-	-	6.5	80	34	24	8,0
E.3645.1.0660	M 7	-	6.6	80	34	24	8,0
E.3645.1.0670	M 7 x 0,75	-	6.7	80	34	24	8,0
E.3645.1.0680	M 7 x 0,5	M 8	6.8	80	34	24	8,0
E.3645.1.0690	-	-	6.9	80	34	24	8,0
E.3645.1.0700	-	M 8 x 1	7	80	34	24	8,0
E.3645.1.0710	-	-	7.1	80	41	29	8,0
E.3645.1.0720	-	M 8 x 0,75	7.2	80	41	29	8,0
E.3645.1.0730	-	-	7.3	80	41	29	8,0
E.3645.1.0740	M 8	-	7.4	80	41	29	8,0
E.3645.1.0750	-	M 8 x 0,5	7.5	80	41	29	8,0
E.3645.1.0760	M 8 x 1	-	7.6	80	41	29	8,0
E.3645.1.0770	M 8 x 0,75	-	7.7	80	41	29	8,0
E.3645.1.0780	M 8 x 0,5	M 9	7.8	80	41	29	8,0
E.3645.1.0790	-	-	7.9	80	41	29	8,0
E.3645.1.0800	-	M 9 x 1	8	80	41	29	8,0
E.3645.1.0810	-	-	8.1	90	47	35	10,0
E.3645.1.0820	-	M 9 x 0,75	8.2	90	47	35	10,0
E.3645.1.0830	-	-	8.3	90	47	35	10,0
E.3645.1.0840	M 9	-	8.4	90	47	35	10,0
E.3645.1.0850	-	M 10	8.5	90	47	35	10,0
E.3645.1.0860	M 9 x 1	-	8.6	90	47	35	10,0
E.3645.1.0870	M 9 x 0,75	-	8.7	90	47	35	10,0
E.3645.1.0880	M 9 x 0,5	M 10 x 1,2	8.8	90	47	35	10,0
E.3645.1.0890	-	-	8.9	90	47	35	10,0
E.3645.1.0900	-	M 10 x 1	9	90	47	35	10,0
E.3645.1.0910	-	-	9.1	90	47	35	10,0
E.3645.1.0920	-	M 10 x 0,7	9.2	90	47	35	10,0
E.3645.1.0930	M 10	-	9.3	90	47	35	10,0
E.3645.1.0940	-	-	9.4	90	47	35	10,0
E.3645.1.0950	-	M 11	9.5	90	47	35	10,0

PRODUCT DATA SHEET



Artikelnummer Article-No.	forming taps	taps	d1 m7	l1	l2	l3	d2 h6
E.3645.1.0960	M 10 x 1	-	9.6	90	47	35	10,0
E.3645.1.0970	M 10 x 0,7	-	9.7	90	47	35	10,0
E.3645.1.0980	M 10 x 0,5	-	9.8	90	47	35	10,0
E.3645.1.0990	-	-	9.9	90	47	35	10,0
E.3645.1.1000	-	M 11 x 1	10	90	47	35	10,0
E.3645.1.1010	-	-	10.1	104	55	40	12,0
E.3645.1.1020	-	M 12/M11x0	10.2	104	55	40	12,0
E.3645.1.1030	-	-	10.3	104	55	40	12,0
E.3645.1.1040	-	-	10.4	104	55	40	12,0
E.3645.1.1050	-	M 12 x 1,5	10.5	104	55	40	12,0
E.3645.1.1060	M 11 x 1	-	10.6	104	55	40	12,0
E.3645.1.1070	M 11 x 0,7	-	10.7	104	55	40	12,0
E.3645.1.1080	-	M 12 x 1,2	10.8	104	55	40	12,0
E.3645.1.1090	-	-	10.9	104	55	40	12,0
E.3645.1.1100	-	M 12 x 1	11	104	55	40	12,0
E.3645.1.1110	-	-	11.1	104	55	40	12,0
E.3645.1.1120	M 12	-	11.2	104	55	40	12,0
E.3645.1.1130	-	-	11.3	104	55	40	12,0
E.3645.1.1140	-	-	11.4	104	55	40	12,0
E.3645.1.1150	-	-	11.5	104	55	40	12,0
E.3645.1.1160	M 12 x 1	-	11.6	104	55	40	12,0
E.3645.1.1170	M 12 x 0,7	-	11.7	104	55	40	12,0
E.3645.1.1180	-	-	11.8	104	55	40	12,0
E.3645.1.1190	-	-	11.9	104	55	40	12,0
E.3645.1.1200	-	M 14	12	104	55	40	12,0
E.3645.1.1230	-	-	12.3	109	60	43	14,0
E.3645.1.1250	-	M 14 x 1,5	12.5	109	60	43	14,0
E.3645.1.1280	-	M 14 x 1,2	12.8	109	60	43	14,0
E.3645.1.1300	-	M 14 x 1	13	109	60	43	14,0
E.3645.1.1350	-	-	13.5	109	60	43	14,0
E.3645.1.1380	-	-	13.8	109	60	43	14,0
E.3645.1.1400	-	M 16 / M 1	14	109	60	43	14,0
E.3645.1.1450	-	M 16 x 1,5	14.5	117.5	65	45	16,0
E.3645.1.1480	-	-	14.8	117.5	65	45	16,0
E.3645.1.1500	-	M 16 x 1	15	117.5	65	45	16,0
E.3645.1.1550	-	M 18	15.5	117.5	65	45	16,0
E.3645.1.1580	-	-	15.8	117.5	65	45	16,0
E.3645.1.1600	-	M 18 x 2	16	117.5	65	45	16,0
E.3645.1.1650	-	-	16.5	125	73	51	18,0
E.3645.1.1680	-	-	16.8	125	73	51	18,0
E.3645.1.1700	-	-	17	125	73	51	18,0
E.3645.1.1750	-	M 20	17.5	125	73	51	18,0
E.3645.1.1780	-	-	17.8	125	73	51	18,0
E.3645.1.1800	-	-	18	125	73	51	18,0
E.3645.1.1850	-	-	18.5	135	79	55	20,0
E.3645.1.1900	-	-	19	135	79	55	20,0
E.3645.1.1950	-	M 22	19.5	135	79	55	20,0
E.3645.1.1980	-	-	19.8	135	79	55	20,0
E.3645.1.2000	-	-	20	135	79	55	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 0.060	Ø 0.140	Ø 0.200	Ø 0.260	Ø 0.350	Ø 0.370
PA allg. Stähle General steels	Bohrer VHM	120.00	0.060	0.140	0.200	0.260	0.350	0.370
	Bohrer VHM	110.00	0.060	0.140	0.200	0.260	0.350	0.370
	Bohrer VHM	110.00	0.060	0.140	0.200	0.260	0.350	0.370
	Bohrer VHM	80.00	0.055	0.120	0.160	0.200	0.300	0.330
	Bohrer VHM	70.00	0.050	0.100	0.130	0.170	0.260	0.300
PV Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ²	Bohrer VHM	90.00	0.060	0.140	0.200	0.260	0.350	0.370
	Bohrer VHM	80.00	0.055	0.120	0.160	0.200	0.300	0.330
	Bohrer VHM	80.00	0.050	0.100	0.130	0.170	0.260	0.300
	Bohrer VHM	70.00	0.040	0.080	0.120	0.160	0.250	0.290
M Rost und säurebeständige Stähle Stainless steels	Bohrer VHM	45.00	0.022	0.055	0.110	0.200	0.250	0.300
	Bohrer VHM	35.00	0.020	0.052	0.090	0.180	0.200	0.250
K Gusseisen Cast iron	Bohrer VHM	95.00	0.075	0.140	0.220	0.350	0.500	0.520
	Bohrer VHM	85.00	0.070	0.140	0.210	0.350	0.430	0.450
	Bohrer VHM	60.00	0.060	0.130	0.200	0.300	0.400	0.420
N AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	200.00	0.070	0.130	0.220	0.320	0.350	0.400
	Bohrer VHM	180.00	0.070	0.130	0.220	0.320	0.350	0.400
	Bohrer VHM	160.00	0.070	0.120	0.160	0.210	0.270	0.300
	Bohrer VHM	110.00	0.070	0.120	0.160	0.210	0.270	0.300
	Bohrer VHM	100.00	0.050	0.085	0.110	0.150	0.190	0.250