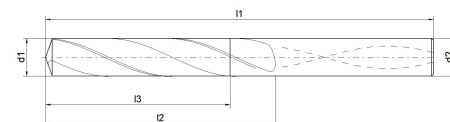


## VHM-Inox-Spiralbohrer 5xd mit Sonderanschliff

Solid carbide twist drills 5xd



Artikelnummer Article-No.	taps	forming taps	d1 m7	l1	l2	l3	d2 h6
E.3651.1.0300	-	-	3	66	28	23	6,0
E.3651.1.0310	-	-	3.1	66	28	23	6,0
E.3651.1.0320	-	-	3.2	66	28	23	6,0
E.3651.1.0330	M 4	M 3,5 x 0,5	3.3	66	28	23	6,0
E.3651.1.0340	-	-	3.4	66	28	23	6,0
E.3651.1.0350	M 4 x 0,5	-	3.5	66	28	23	6,0
E.3651.1.0360	-	-	3.6	66	28	23	6,0
E.3651.1.0370	M 4,5	M 4	3.7	66	28	23	6,0
E.3651.1.0380	-	M 4 x 0,5	3.8	74	36	29	6,0
E.3651.1.0390	-	-	3.9	74	36	29	6,0
E.3651.1.0400	M 4,5 x 0,5	-	4	74	36	29	6,0
E.3651.1.0410	-	-	4.1	74	36	29	6,0
E.3651.1.0420	M 5	M 4,5	4.2	74	36	29	6,0
E.3651.1.0430	-	M 4,5 x 0,5	4.3	74	36	29	6,0
E.3651.1.0440	-	-	4.4	74	36	29	6,0
E.3651.1.0450	M 5 x 0,5	-	4.5	74	36	29	6,0
E.3651.1.0460	M 5,5	-	4.6	74	36	29	6,0
E.3651.1.0470	-	M 5 x 0,75	4.7	74	36	29	6,0
E.3651.1.0480	-	M 5 x 0,5	4.8	82	44	35	6,0
E.3651.1.0490	-	-	4.9	82	44	35	6,0
E.3651.1.0500	M 6/M 5,5 x 0,5	-	5	82	44	35	6,0
E.3651.1.0510	-	M 5,5	5.1	82	44	35	6,0
E.3651.1.0520	M 6 x 0,75	-	5.2	82	44	35	6,0
E.3651.1.0530	-	M 5,5 x 0,5	5.3	82	44	35	6,0
E.3651.1.0540	-	-	5.4	82	44	35	6,0
E.3651.1.0550	M 6 x 0,5	-	5.5	82	44	35	6,0
E.3651.1.0560	-	M 6	5.6	82	44	35	6,0
E.3651.1.0570	-	M 6 x 0,75	5.7	82	44	35	6,0
E.3651.1.0580	-	M 6 x 0,5	5.8	82	44	35	6,0
E.3651.1.0590	-	-	5.9	82	44	35	6,0
E.3651.1.0600	M 7	-	6	82	44	35	6,0
E.3651.1.0610	-	-	6.1	91	53	43	8,0
E.3651.1.0620	M 7 x 0,75	-	6.2	91	53	43	8,0
E.3651.1.0630	-	-	6.3	91	53	43	8,0
E.3651.1.0640	-	-	6.4	91	53	43	8,0

# PRODUCT DATA SHEET



Artikelnummer Article-No.	taps	forming taps	d1 m7	l1	l2	l3	d2 h6
E.3651.1.0650	-	-	6.5	91	53	43	8,0
E.3651.1.0660	-	M 7	6.6	91	53	43	8,0
E.3651.1.0670	-	M 7 x 0,75	6.7	91	53	43	8,0
E.3651.1.0680	M 8	M 7 x 0,5	6.8	91	53	43	8,0
E.3651.1.0690	-	-	6.9	91	53	43	8,0
E.3651.1.0700	M 8 x 1	-	7	91	53	43	8,0
E.3651.1.0710	-	-	7.1	91	53	43	8,0
E.3651.1.0720	M 8 x 0,75	-	7.2	91	53	43	8,0
E.3651.1.0730	-	-	7.3	91	53	43	8,0
E.3651.1.0740	-	M 8	7.4	91	53	43	8,0
E.3651.1.0750	M 8 x 0,5	-	7.5	91	53	43	8,0
E.3651.1.0760	-	M 8 x 1	7.6	91	53	43	8,0
E.3651.1.0770	-	M 8 x 0,75	7.7	91	53	43	8,0
E.3651.1.0780	M 9	M 8 x 0,5	7.8	91	53	43	8,0
E.3651.1.0790	-	-	7.9	91	53	43	8,0
E.3651.1.0800	M 9 x 1	-	8	91	53	43	8,0
E.3651.1.0810	-	-	8.1	103	61	49	10,0
E.3651.1.0820	M 9 x 0,75	-	8.2	103	61	49	10,0
E.3651.1.0830	-	-	8.3	103	61	49	10,0
E.3651.1.0840	-	M 9	8.4	103	61	49	10,0
E.3651.1.0850	M 10	-	8.5	103	61	49	10,0
E.3651.1.0860	-	M 9 x 1	8.6	103	61	49	10,0
E.3651.1.0870	-	M 9 x 0,75	8.7	103	61	49	10,0
E.3651.1.0880	M 10 x 1,25	M 9 x 0,5	8.8	103	61	49	10,0
E.3651.1.0890	-	-	8.9	103	61	49	10,0
E.3651.1.0900	M 10 x 1	-	9	103	61	49	10,0
E.3651.1.0910	-	-	9.1	103	61	49	10,0
E.3651.1.0920	M 10 x 0,75	-	9.2	103	61	49	10,0
E.3651.1.0930	-	M 10	9.3	103	61	49	10,0
E.3651.1.0940	-	-	9.4	103	61	49	10,0
E.3651.1.0950	M 11	-	9.5	103	61	49	10,0
E.3651.1.0960	-	M 10 x 1	9.6	103	61	49	10,0
E.3651.1.0970	-	M 10 x 0,75	9.7	103	61	49	10,0
E.3651.1.0980	-	M 10 x 0,5	9.8	103	61	49	10,0
E.3651.1.0990	-	-	9.9	103	61	49	10,0
E.3651.1.1000	M 11 x 1	-	10	103	61	49	10,0
E.3651.1.1010	-	-	10.1	118	71	56	12,0
E.3651.1.1020	M 12/M11x0,75	-	10.2	118	71	56	12,0
E.3651.1.1030	-	-	10.3	118	71	56	12,0
E.3651.1.1040	-	-	10.4	118	71	56	12,0
E.3651.1.1050	M 12 x 1,5	-	10.5	118	71	56	12,0
E.3651.1.1060	-	M 11 x 1	10.6	118	71	56	12,0
E.3651.1.1070	-	M 11 x 0,75	10.7	118	71	56	12,0
E.3651.1.1080	M 12 x 1,25	-	10.8	118	71	56	12,0
E.3651.1.1090	-	-	10.9	118	71	56	12,0
E.3651.1.1100	M 12 x 1	-	11	118	71	56	12,0
E.3651.1.1110	-	-	11.1	118	71	56	12,0
E.3651.1.1120	-	M 12	11.2	118	71	56	12,0
E.3651.1.1130	-	-	11.3	118	71	56	12,0
E.3651.1.1140	-	-	11.4	118	71	56	12,0
E.3651.1.1150	-	-	11.5	118	71	56	12,0

# PRODUCT DATA SHEET



Artikelnummer Article-No.	taps	forming taps	d1 m7	l1	l2	l3	d2 h6
E.3651.1.1160	-	M 12 x 1	11.6	118	71	56	12,0
E.3651.1.1170	-	M 12 x 0,75	11.7	118	71	56	12,0
E.3651.1.1180	-	-	11.8	118	71	56	12,0
E.3651.1.1190	-	-	11.9	118	71	56	12,0
E.3651.1.1200	M 14	-	12	118	71	56	12,0
E.3651.1.1220	-	-	12.2	124	77	60	14,0
E.3651.1.1230	-	-	12.3	124	77	60	14,0
E.3651.1.1250	M 14 x 1,5	-	12.5	124	77	60	14,0
E.3651.1.1280	M 14 x 1,25	-	12.8	124	77	60	14,0
E.3651.1.1300	M 14 x 1	-	13	124	77	60	14,0
E.3651.1.1350	-	-	13.5	124	77	60	14,0
E.3651.1.1380	-	-	13.8	124	77	60	14,0
E.3651.1.1400	M 16 / M 15 x 1	-	14	124	77	60	14,0
E.3651.1.1450	M 16 x 1,5	-	14.5	133	83	63	16,0
E.3651.1.1480	-	-	14.8	133	83	63	16,0
E.3651.1.1500	M 16 x 1	-	15	133	83	63	16,0
E.3651.1.1550	M 18	-	15.5	133	83	63	16,0
E.3651.1.1580	-	-	15.8	133	83	63	16,0
E.3651.1.1600	M 18 x 2	-	16	133	83	63	16,0
E.3651.1.1650	-	-	16.5	143	93	71	18,0
E.3651.1.1680	-	-	16.8	143	93	71	18,0
E.3651.1.1700	-	-	17	143	93	71	18,0
E.3651.1.1750	M 20	-	17.5	143	93	71	18,0
E.3651.1.1780	-	-	17.8	143	93	71	18,0
E.3651.1.1800	-	-	18	143	93	71	18,0
E.3651.1.1850	-	-	18.5	153	101	77	20,0
E.3651.1.1900	-	-	19	153	101	77	20,0
E.3651.1.1950	M 22	-	19.5	153	101	77	20,0
E.3651.1.2000	-	-	20	153	101	77	20,0



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Materialbezeichnung material description	Bearbeitung Process	Vc m/min	fz				
			∅ 3.00-5.90	∅ 6.00-8.90	∅ 9.00-11.90	∅ 12.00-15.80	∅ 16.00-20.00
PA allg. Stähle General steels	Bohrer VHM	110.00	0.120	0.170	0.260	0.320	0.340
	Bohrer VHM	100.00	0.120	0.170	0.260	0.320	0.340
	Bohrer VHM	90.00	0.120	0.170	0.260	0.320	0.340
	Bohrer VHM	80.00	0.100	0.150	0.220	0.280	0.300
PV allg. Stähle General steels	Bohrer VHM	70.00	0.090	0.120	0.190	0.230	0.260
	Bohrer VHM	90.00	0.120	0.170	0.260	0.320	0.340
	Bohrer VHM	80.00	0.100	0.150	0.220	0.280	0.300
	Bohrer VHM	70.00	0.090	0.120	0.190	0.230	0.260
Vergütungsstähle < 850N/mm <sup>2</sup> Tempering steel < 850N/mm <sup>2</sup>	Bohrer VHM	90.00	0.120	0.170	0.260	0.320	0.340
	Bohrer VHM	80.00	0.100	0.150	0.220	0.280	0.300
Vergütungsstähle < 1400N/mm <sup>2</sup> Tempering steel < 1400N/mm <sup>2</sup>	Bohrer VHM	70.00	0.090	0.120	0.190	0.230	0.260
	Bohrer VHM	60.00	0.090	0.120	0.190	0.230	0.260
Vergütungsstähle > 1400N/mm <sup>2</sup> Tempering steel > 1400N/mm <sup>2</sup>	Bohrer VHM	60.00	0.090	0.120	0.190	0.230	0.260

# PRODUCT DATA SHEET



Materialbezeichnung material description	Bearbeitung Process	Vc m/min	fz				
			∅ 3.00-5.90	∅ 6.00-8.90	∅ 9.00-11.90	∅ 12.00-15.80	∅ 16.00-20.00
M Rost und säurebeständige Stähle Stainless steels	Bohrer VHM	60.00	0.085	0.120	0.170	0.210	0.220
	Bohrer VHM	50.00	0.065	0.095	0.140	0.180	0.190
K Gusseisen Cast iron	Bohrer VHM	110.00	0.160	0.230	0.360	0.430	0.500
	Bohrer VHM	90.00	0.150	0.210	0.310	0.370	0.430
	Bohrer VHM	80.00	0.140	0.190	0.280	0.350	0.400
N AL- und AL-Legierungen AL and AL-alloys	Bohrer VHM	200.00	0.160	0.220	0.360	0.430	0.500
	Bohrer VHM	180.00	0.160	0.220	0.360	0.430	0.500
	Bohrer VHM	140.00	0.160	0.220	0.360	0.430	0.500
	Bohrer VHM	120.00	0.130	0.180	0.280	0.320	0.360
S Nickelbasierende Stähle Nickel based alloys	Bohrer VHM	40.00	0.060	0.100	0.160	0.200	0.210
	Bohrer VHM	35.00	0.040	0.060	0.100	0.110	0.120