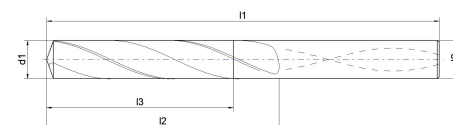


## VHM-Inox-Spiralbohrer 5xd mit IK

Solid carbide twist drills 5xd with IC für Inox



Artikelnummer Article-No.	d1	taps	forming taps	l1	l2	l3	d2 h6
E.3690.1.0100	1	-	M 1,1	55	10	6.5	3,0
E.3690.1.0110	1.1	M 1,4	M 1,2	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	1.8	M 2,2	M 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	2.8	-	M 3	57	21	21	3,0
E.3690.1.0290	2.9	M 3,5	M 3 x 0,25	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	3.3	M 4	M 3,5 x 0,5	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	3.7	M 4,5	M 4	66	28	23	6,0
E.3690.1.0380	3.8	-	M 4 x 0,5	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	4.2	M 5	M 4,5	74	36	29	6,0
E.3690.1.0430	4.3	-	M 4,5 x 0,5	74	36	29	6,0
E.3690.1.0440	4.4	-	-	74	36	29	6,0

# PRODUCT DATA SHEET



Artikelnummer Article-No.	d1	taps	forming 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	4.7	-	M 5 x 0,75	74	36	29	6,0
E.3690.1.0480	4.8	-	M 5 x 0,5	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	5.1	-	M 5,5	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	5.3	-	M 5,5 x 0,5	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	5.6	-	M 6	82	44	35	6,0
E.3690.1.0570	5.7	-	M 6 x 0,75	82	44	35	6,0
E.3690.1.0580	5.8	-	M 6 x 0,5	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	6.6	-	M 7	91	53	43	8,0
E.3690.1.0670	6.7	-	M 7 x 0,75	91	53	43	8,0
E.3690.1.0680	6.8	M 8	M 7 x 0,5	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	7.4	-	M 8	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	7.6	-	M 8 x 1	91	53	43	8,0
E.3690.1.0770	7.7	-	M 8 x 0,75	91	53	43	8,0
E.3690.1.0780	7.8	M 9	M 8 x 0,5	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	8.4	-	M 9	103	61	49	10,0
E.3690.1.0850	8.5	M 10	-	103	61	49	10,0
E.3690.1.0860	8.6	-	M 9 x 1	103	61	49	10,0
E.3690.1.0870	8.7	-	M 9 x 0,75	103	61	49	10,0
E.3690.1.0880	8.8	M 10 x 1,25	M 9 x 0,5	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	9.3	-	M 10	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.	d1	taps	forming taps	l1	l2	l3	d2 h6
E.3690.1.0960	9.6	-	M 10 x 1	103	61	49	10,0
E.3690.1.0970	9.7	-	M 10 x 0,75	103	61	49	10,0
E.3690.1.0980	9.8	-	M 10 x 0,5	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	10.6	-	M 11 x 1	118	71	56	12,0
E.3690.1.1070	10.7	-	M 11 x 0,75	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	11.2	-	M 12	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	11.6	-	M 12 x 1	118	71	56	12,0
E.3690.1.1170	11.7	-	M 12 x 0,75	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](http://www.nachreiner-schnittdaten.eu)

# PRODUCT DATA SHEET



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	∅ 12.00-15.80	∅ 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 <sup>2</sup> Tempering steel < 850N/mm <sup>2</sup>	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