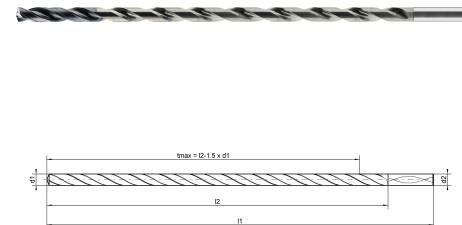


VHM-Tiefloch-Spiralbohrer 25xD mit IK

Solid carbide deep hole drills 25xD with IC



| Artikelnummer Article-No. | d1 h7 | l1 | l2 | d2 h6 |
|------------------------------|-------|-----|-------|-------|
| E.3693.1.0300 | 3 | 130 | 85.5 | 6,0 |
| E.3693.1.0320 | 3.2 | 140 | 95.5 | 6,0 |
| E.3693.1.0330 | 3.3 | 140 | 95.5 | 6,0 |
| E.3693.1.0350 | 3.5 | 150 | 100.5 | 6,0 |
| E.3693.1.0380 | 3.8 | 150 | 105.5 | 6,0 |
| E.3693.1.0400 | 4 | 160 | 110.5 | 6,0 |
| E.3693.1.0420 | 4.2 | 170 | 120.5 | 6,0 |
| E.3693.1.0450 | 4.5 | 180 | 130.5 | 6,0 |
| E.3693.1.0480 | 4.8 | 190 | 140.5 | 6,0 |
| E.3693.1.0500 | 5 | 190 | 140.5 | 6,0 |
| E.3693.1.0550 | 5.5 | 210 | 160.5 | 6,0 |
| E.3693.1.0580 | 5.8 | 210 | 160.5 | 6,0 |
| E.3693.1.0600 | 6 | 220 | 170.5 | 6,0 |
| E.3693.1.0650 | 6.5 | 230 | 191 | 8,0 |
| E.3693.1.0680 | 6.8 | 230 | 191 | 8,0 |
| E.3693.1.0700 | 7 | 240 | 201 | 8,0 |
| E.3693.1.0750 | 7.5 | 250 | 214 | 8,0 |
| E.3693.1.0780 | 7.8 | 260 | 224 | 8,0 |
| E.3693.1.0800 | 8 | 260 | 224 | 8,0 |
| E.3693.1.0850 | 8.5 | 280 | 237 | 10,0 |
| E.3693.1.0880 | 8.8 | 290 | 247 | 10,0 |
| E.3693.1.0900 | 9 | 290 | 247 | 10,0 |
| E.3693.1.0950 | 9.5 | 310 | 267 | 10,0 |
| E.3693.1.0980 | 9.8 | 310 | 267 | 10,0 |
| E.3693.1.1000 | 10 | 310 | 267 | 10,0 |
| E.3693.1.1020 | 10.2 | 340 | 292 | 12,0 |
| E.3693.1.1080 | 10.8 | 350 | 302 | 12,0 |
| E.3693.1.1180 | 11.8 | 375 | 327 | 12,0 |
| E.3693.1.1200 | 12 | 375 | 327 | 12,0 |



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 | | | | | | |
|-----------------------------------------------------------------------------------------|-------------------------------------------------|-------------|-----------|----------------|----------------|----------------|----------------|-----------------|------------------|
| | | | ∅ 3.00 | ∅ 3.20-4.00 | ∅ 4.20-5.00 | ∅ 5.50-6.00 | ∅ 6.50-8.00 | ∅ 8.50-10.00 | ∅ 10.20-12.00 |
| PA allg. Stähle General steels | Bohrer VHM | 95.00 | 0.085 | 0.120 | 0.160 | 0.190 | 0.220 | 0.280 | 0.350 |
| | Bohrer VHM | 90.00 | 0.085 | 0.110 | 0.150 | 0.180 | 0.210 | 0.260 | 0.330 |
| | Bohrer VHM | 85.00 | 0.082 | 0.100 | 0.130 | 0.150 | 0.180 | 0.230 | 0.300 |
| | Bohrer VHM | 80.00 | 0.082 | 0.100 | 0.130 | 0.150 | 0.180 | 0.230 | 0.300 |
| | Bohrer VHM | 70.00 | 0.075 | 0.090 | 0.110 | 0.140 | 0.160 | 0.200 | 0.250 |
| PV Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ² | Bohrer VHM | 85.00 | 0.082 | 0.100 | 0.130 | 0.150 | 0.180 | 0.230 | 0.300 |
| | Bohrer VHM | 80.00 | 0.082 | 0.100 | 0.130 | 0.150 | 0.180 | 0.230 | 0.300 |
| | Bohrer VHM | 70.00 | 0.075 | 0.090 | 0.110 | 0.140 | 0.160 | 0.200 | 0.250 |
| M Rost und säurebeständige Stähle Stainless steels | Bohrer VHM | 55.00 | 0.055 | 0.065 | 0.080 | 0.100 | 0.120 | 0.150 | 0.180 |
| K Gusseisen Cast iron | Bohrer VHM | 95.00 | 0.085 | 0.120 | 0.160 | 0.190 | 0.220 | 0.280 | 0.350 |
| | Bohrer VHM | 75.00 | 0.075 | 0.100 | 0.130 | 0.150 | 0.180 | 0.230 | 0.300 |
| | Bohrer VHM | 75.00 | 0.075 | 0.100 | 0.130 | 0.150 | 0.180 | 0.230 | 0.300 |
| | Gusseisen mit Kugelgraphit Nodular cast iron | | | | | | | | |