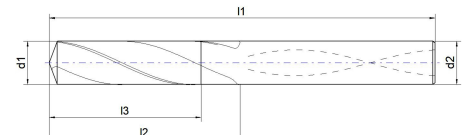


VHM-Inox-Spiralbohrer 3xD mit IK

Solid carbide twist drills 3xD for Inox with IC



Artikelnummer Article-No.	Gewindebohrer	Gewindeformer	d1 m7	l1	l2	l3	d2 h6
E.3687.1.0300	-	-	3	62	20	14	6,0
E.3687.1.0310	-	-	3.1	62	20	14	6,0
E.3687.1.0320	-	-	3.2	62	20	14	6,0
E.3687.1.0330	M 4	M 3,5 x 0,	3.3	62	20	14	6,0
E.3687.1.0340	-	-	3.4	62	20	14	6,0
E.3687.1.0350	M 4 x 0,5	-	3.5	62	20	14	6,0
E.3687.1.0360	-	-	3.6	62	20	14	6,0
E.3687.1.0370	M 4,5	M 4	3.7	62	20	14	6,0
E.3687.1.0380	-	M 4 x 0,5	3.8	66	24	17	6,0
E.3687.1.0390	-	-	3.9	66	24	17	6,0
E.3687.1.0400	M 4,5 x 0,	-	4	66	24	17	6,0
E.3687.1.0410	-	-	4.1	66	24	17	6,0
E.3687.1.0420	M 5	M 4,5	4.2	66	24	17	6,0
E.3687.1.0430	-	M 4,5 x 0,	4.3	66	24	17	6,0
E.3687.1.0440	-	-	4.4	66	24	17	6,0
E.3687.1.0450	M 5 x 0,5	-	4.5	66	24	17	6,0
E.3687.1.0460	M 5,5	-	4.6	66	24	17	6,0
E.3687.1.0470	-	M 5 x 0,75	4.7	66	24	17	6,0
E.3687.1.0480	-	M 5 x 0,5	4.8	66	28	20	6,0
E.3687.1.0490	-	-	4.9	66	28	20	6,0
E.3687.1.0500	M 6/M 5,5	-	5	66	28	20	6,0
E.3687.1.0510	-	M 5,5	5.1	66	28	20	6,0
E.3687.1.0520	M 6 x 0,75	-	5.2	66	28	20	6,0
E.3687.1.0530	-	M 5,5 x 0,	5.3	66	28	20	6,0
E.3687.1.0540	-	-	5.4	66	28	20	6,0
E.3687.1.0550	M 6 x 0,5	-	5.5	66	28	20	6,0
E.3687.1.0560	-	M 6	5.6	66	28	20	6,0
E.3687.1.0570	-	M 6 x 0,75	5.7	66	28	20	6,0
E.3687.1.0580	-	M 6 x 0,5	5.8	66	28	20	6,0
E.3687.1.0590	-	-	5.9	66	28	20	6,0
E.3687.1.0600	M 7	-	6	66	28	20	6,0
E.3687.1.0610	-	-	6.1	79	34	24	8,0
E.3687.1.0620	M 7 x 0,75	-	6.2	79	34	24	8,0
E.3687.1.0630	-	-	6.3	79	34	24	8,0
E.3687.1.0640	-	-	6.4	79	34	24	8,0

PRODUKTDATENBLATT



Artikelnummer Article-No.	Gewindebohrer	Gewindeformer	d1 m7	l1	l2	l3	d2 h6
E.3687.1.0650	-	-	6.5	79	34	24	8,0
E.3687.1.0660	-	M 7	6.6	79	34	24	8,0
E.3687.1.0670	-	M 7 x 0,75	6.7	79	34	24	8,0
E.3687.1.0680	M 8	M 7 x 0,5	6.8	79	34	24	8,0
E.3687.1.0690	-	-	6.9	79	34	24	8,0
E.3687.1.0700	M 8 x 1,0	-	7	79	34	24	8,0
E.3687.1.0710	-	-	7.1	79	41	29	8,0
E.3687.1.0720	M 8 x 0,75	-	7.2	79	41	29	8,0
E.3687.1.0730	-	-	7.3	79	41	29	8,0
E.3687.1.0740	-	M 8	7.4	79	41	29	8,0
E.3687.1.0750	M 8 x 0,5	-	7.5	79	41	29	8,0
E.3687.1.0760	-	M 8 x 1,0	7.6	79	41	29	8,0
E.3687.1.0770	-	M 8 x 0,75	7.7	79	41	29	8,0
E.3687.1.0780	M 9	M 8 x 0,5	7.8	79	41	29	8,0
E.3687.1.0790	-	-	7.9	79	41	29	8,0
E.3687.1.0800	M 9 x 1,0	-	8	79	41	29	8,0
E.3687.1.0810	-	-	8.1	89	47	35	10,0
E.3687.1.0820	M 9 x 0,75	-	8.2	89	47	35	10,0
E.3687.1.0830	-	-	8.3	89	47	35	10,0
E.3687.1.0840	-	M 9	8.4	89	47	35	10,0
E.3687.1.0850	M 10	-	8.5	89	47	35	10,0
E.3687.1.0860	-	M 9 x 1,0	8.6	89	47	35	10,0
E.3687.1.0870	-	M 9 x 0,75	8.7	89	47	35	10,0
E.3687.1.0880	M 10 x 1,2	M 9 x 0,5	8.8	89	47	35	10,0
E.3687.1.0890	-	-	8.9	89	47	35	10,0
E.3687.1.0900	M 10 x 1,0	-	9	89	47	35	10,0
E.3687.1.0910	-	-	9.1	89	47	35	10,0
E.3687.1.0920	M 10 x 0,7	-	9.2	89	47	35	10,0
E.3687.1.0930	-	M 10	9.3	89	47	35	10,0
E.3687.1.0940	-	-	9.4	89	47	35	10,0
E.3687.1.0950	M 11	-	9.5	89	47	35	10,0
E.3687.1.0960	-	M 10 x 1,0	9.6	89	47	35	10,0
E.3687.1.0970	-	M 10 x 0,7	9.7	89	47	35	10,0
E.3687.1.0980	-	M 10 x 0,5	9.8	89	47	35	10,0
E.3687.1.0990	-	-	9.9	89	47	35	10,0
E.3687.1.1000	M 11 x 1,0	-	10	89	47	35	10,0
E.3687.1.1010	-	-	10.1	102	55	40	12,0
E.3687.1.1020	M 12/M11 x	-	10.2	102	55	40	12,0
E.3687.1.1030	-	-	10.3	102	55	40	12,0
E.3687.1.1040	-	-	10.4	102	55	40	12,0
E.3687.1.1050	M 12 x 1,5	-	10.5	102	55	40	12,0
E.3687.1.1060	-	M 11 x 1,0	10.6	102	55	40	12,0
E.3687.1.1070	-	M 11 x 0,7	10.7	102	55	40	12,0
E.3687.1.1080	M 12 x 1,2	-	10.8	102	55	40	12,0
E.3687.1.1090	-	-	10.9	102	55	40	12,0
E.3687.1.1100	M 12 x 1,0	-	11	102	55	40	12,0
E.3687.1.1110	-	-	11.1	102	55	40	12,0
E.3687.1.1120	-	M 12	11.2	102	55	40	12,0
E.3687.1.1130	-	-	11.3	102	55	40	12,0
E.3687.1.1140	-	-	11.4	102	55	40	12,0
E.3687.1.1150	-	-	11.5	102	55	40	12,0

PRODUKTDATENBLATT



Artikelnummer Article-No.	Gewindebohrer	Gewindeformer	d1 m7	l1	l2	l3	d2 h6
E.3687.1.1160	-	M 12 x 1,0	11.6	102	55	40	12,0
E.3687.1.1170	-	M 12 x 0,7	11.7	102	55	40	12,0
E.3687.1.1180	-	-	11.8	102	55	40	12,0
E.3687.1.1190	-	-	11.9	102	55	40	12,0
E.3687.1.1200	M 14	-	12	102	55	40	12,0
E.3687.1.1230	-	-	12.3	107	60	43	14,0
E.3687.1.1250	M 14 x 1,5	-	12.5	107	60	43	14,0
E.3687.1.1280	M 14 x 1,2	-	12.8	107	60	43	14,0
E.3687.1.1300	M 14 x 1,0	-	13	107	60	43	14,0
E.3687.1.1350	-	-	13.5	107	60	43	14,0
E.3687.1.1380	-	-	13.8	107	60	43	14,0
E.3687.1.1400	M 16/M15 x	-	14	107	60	43	14,0
E.3687.1.1420	-	-	14.2	115	65	45	16,0
E.3687.1.1450	M 16 x 1,5	-	14.5	115	65	45	16,0
E.3687.1.1480	-	-	14.8	115	65	45	16,0
E.3687.1.1500	M 16 x 1,0	-	15	115	65	45	16,0
E.3687.1.1550	M 18	-	15.5	115	65	45	16,0
E.3687.1.1580	-	-	15.8	115	65	45	16,0
E.3687.1.1600	M 18 x 2,0	-	16	115	65	45	16,0
E.3687.1.1650	-	-	16.5	123	73	51	18,0
E.3687.1.1680	-	-	16.8	123	73	51	18,0
E.3687.1.1700	-	-	17	123	73	51	18,0
E.3687.1.1750	M 20	-	17.5	123	73	51	18,0
E.3687.1.1780	-	-	17.8	123	73	51	18,0
E.3687.1.1800	-	-	18	123	73	51	18,0
E.3687.1.1850	-	-	18.5	131	79	55	20,0
E.3687.1.1900	-	-	19	131	79	55	20,0
E.3687.1.1950	M 22	-	19.5	131	79	55	20,0
E.3687.1.2000	-	-	20	131	79	55	20,0



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				
				Ø 0.130	Ø 0.180	Ø 0.280	Ø 0.350	Ø 0.370
PA	allg. Stähle General steels	Bohrer VHM	110.00	0.130	0.180	0.280	0.350	0.370
	allg. Stähle General steels	Bohrer VHM	100.00	0.130	0.180	0.280	0.350	0.370
	allg. Stähle General steels	Bohrer VHM	90.00	0.130	0.180	0.280	0.350	0.370
	allg. Stähle General steels	Bohrer VHM	80.00	0.120	0.160	0.240	0.300	0.320
	allg. Stähle General steels	Bohrer VHM	70.00	0.095	0.135	0.200	0.250	0.270
PV	Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ²	Bohrer VHM	90.00	0.130	0.180	0.280	0.350	0.370
	Vergütungsstähle < 1400N/mm ² Tempering steel < 1400N/mm ²	Bohrer VHM	80.00	0.120	0.160	0.240	0.300	0.320
	Vergütungsstähle < 1400N/mm ² Tempering steel < 1400N/mm ²	Bohrer VHM	70.00	0.095	0.135	0.200	0.250	0.270
	Vergütungsstähle > 1400N/mm ² Tempering steel > 1400N/mm ²	Bohrer VHM	60.00	0.095	0.135	0.200	0.250	0.270

PRODUKTDATENBLATT



	Materialbezeichnung material description	Bearbeitung Process	Vc m/min	fz				
				Ø 0.130	Ø 0.180	Ø 0.280	Ø 0.350	Ø 0.370
M	Rost und säurebeständige Stähle Stainless steels	Bohrer VHM	60.00	0.085	0.120	0.170	0.210	0.220
	Rost und säurebeständige Stähle >700N/mm² Stainless steels >700N/mm²	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
	Temperguss Malleable cast iron	Bohrer VHM	90.00	0.150	0.210	0.310	0.370	0.430
	Gusseisen mit Kugelgraphit Nodular cast iron	Bohrer VHM	80.00	0.140	0.190	0.280	0.350	0.400
N	AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	200.00	0.160	0.220	0.360	0.430	0.500
	AL- und AL-Legierungen AL und AL-alloys	Bohrer VHM	180.00	0.160	0.220	0.360	0.430	0.500
	AL- und AL-Legierungen >12% Si AL und AL-alloys >12% Si	Bohrer VHM	140.00	0.160	0.220	0.360	0.430	0.500
	Kupfer, Messing, Bronze, Rotguss Copper, brass, bronze, red brass	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
	Titan Titanium	Bohrer VHM	35.00	0.040	0.060	0.100	0.110	0.120