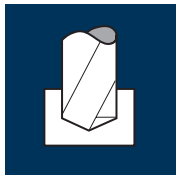
## Application



| Matières | d1 [mm] | $v_c$ [m/min] | f [mm] | n [min⁻¹] | $v_f$ [mm/min] | Q [cm³/min] | T [sek] |
|---|---|---|---|---|---|---|---|
| Aciers < 500 N/mm² | 0.80 | 140 | 0.014 | 55705 | 780 | 0.5 | 0.5 |
| | 0.90 | 140 | 0.016 | 49515 | 790 | 0.5 | 0.5 |
| | 1.00 | 140 | 0.018 | 44565 | 800 | 0.5 | 0.6 |
| | 1.10 | 140 | 0.019 | 40510 | 770 | 0.5 | 0.7 |
| | 1.25 | 140 | 0.023 | 35650 | 820 | 1.0 | 0.7 |
| | 1.40 | 140 | 0.026 | 31830 | 830 | 1.5 | 0.8 |
| | 1.50 | 140 | 0.028 | 29710 | 830 | 1.5 | 0.9 |
| | 1.65 | 140 | 0.032 | 27010 | 865 | 2.0 | 0.9 |
| | 1.80 | 140 | 0.035 | 24755 | 865 | 2.0 | 1.0 |
| Aciers 500 - 850 N/mm² | 0.80 | 100 | 0.014 | 39790 | 555 | 0.5 | 0.7 |
| | 0.90 | 100 | 0.016 | 35370 | 565 | 0.5 | 0.8 |
| | 1.00 | 100 | 0.018 | 31830 | 575 | 0.5 | 0.8 |
| | 1.10 | 100 | 0.019 | 28935 | 550 | 0.5 | 1.0 |
| | 1.25 | 100 | 0.023 | 25465 | 585 | 0.5 | 1.0 |
| | 1.40 | 100 | 0.026 | 22735 | 590 | 1.0 | 1.1 |
| | 1.50 | 100 | 0.028 | 21220 | 595 | 1.0 | 1.2 |
| | 1.65 | 100 | 0.032 | 19290 | 615 | 1.5 | 1.3 |
| | 1.80 | 100 | 0.035 | 17685 | 620 | 1.5 | 1.4 |
| Aciers 850 - 1100 N/mm² | 0.80 | 80 | 0.014 | 31830 | 445 | 0.0 | 0.9 |
| | 0.90 | 80 | 0.016 | 28295 | 455 | 0.5 | 0.9 |
| | 1.00 | 80 | 0.018 | 25465 | 460 | 0.5 | 1.0 |
| | 1.10 | 80 | 0.019 | 23150 | 440 | 0.5 | 1.2 |
| | 1.25 | 80 | 0.023 | 20370 | 470 | 0.5 | 1.3 |
| | 1.40 | 80 | 0.026 | 18190 | 475 | 0.5 | 1.4 |
| | 1.50 | 80 | 0.028 | 16975 | 475 | 1.0 | 1.5 |
| | 1.65 | 80 | 0.032 | 15435 | 495 | 1.0 | 1.6 |
| | 1.80 | 80 | 0.035 | 14145 | 495 | 1.5 | 1.7 |
| Aciers inoxydables [Cr-Ni-Mo/1.4571] | 0.80 | 60 | 0.012 | 23875 | 285 | 0.0 | 1.3 |
| | 0.90 | 60 | 0.013 | 21220 | 275 | 0.0 | 1.6 |
| | 1.00 | 60 | 0.014 | 19100 | 265 | 0.0 | 1.8 |
| | 1.10 | 60 | 0.016 | 17360 | 280 | 0.5 | 1.9 |
| | 1.25 | 60 | 0.018 | 15280 | 275 | 0.5 | 2.2 |
| | 1.40 | 60 | 0.021 | 13640 | 285 | 0.5 | 2.4 |
| | 1.50 | 60 | 0.023 | 12730 | 295 | 0.5 | 2.4 |
| | 1.65 | 60 | 0.026 | 11575 | 300 | 0.5 | 2.6 |
| | 1.80 | 60 | 0.029 | 10610 | 310 | 1.0 | 2.8 |

| Matières | d1 [mm] | $v_c$ [m/min] | f [mm] | n [min⁻¹] | $v_f$ [mm/min] | Q [cm³/min] | T [sek] |
|---|---|---|---|---|---|---|---|
| Fonte grise / sphéroïdale | 0.80 | 150 | 0.016 | 59685 | 955 | 0.5 | 0.4 |
| | 0.90 | 150 | 0.019 | 53050 | 1010 | 0.5 | 0.4 |
| | 1.00 | 150 | 0.021 | 47745 | 1005 | 1.0 | 0.5 |
| | 1.10 | 150 | 0.023 | 43405 | 1000 | 1.0 | 0.5 |
| | 1.25 | 150 | 0.026 | 38195 | 995 | 1.0 | 0.6 |
| | 1.40 | 150 | 0.030 | 34105 | 1025 | 1.5 | 0.7 |
| | 1.50 | 150 | 0.032 | 31830 | 1020 | 2.0 | 0.7 |
| | 1.65 | 150 | 0.036 | 28935 | 1040 | 2.0 | 0.8 |
| | 1.80 | 150 | 0.040 | 26525 | 1060 | 2.5 | 0.8 |
| Aluminium corroyé Si < 6% | 0.80 | 200 | 0.016 | 60000 | 960 | 0.5 | 0.4 |
| | 0.90 | 200 | 0.019 | 60000 | 1140 | 0.5 | 0.4 |
| | 1.00 | 200 | 0.021 | 60000 | 1260 | 1.0 | 0.4 |
| | 1.10 | 200 | 0.023 | 57875 | 1330 | 1.5 | 0.4 |
| | 1.25 | 200 | 0.026 | 50930 | 1325 | 1.5 | 0.5 |
| | 1.40 | 200 | 0.030 | 45475 | 1365 | 2.0 | 0.5 |
| | 1.50 | 200 | 0.032 | 42440 | 1360 | 2.5 | 0.5 |
| | 1.65 | 200 | 0.036 | 38585 | 1390 | 3.0 | 0.6 |
| | 1.80 | 200 | 0.040 | 35370 | 1415 | 3.5 | 0.6 |

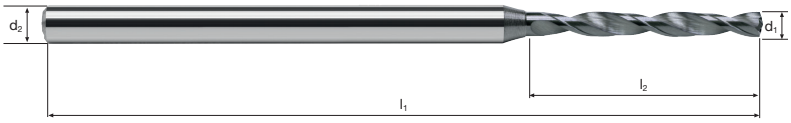
# Microforets Microdrill NX

8xd

HM MG10

30° 155°

h5

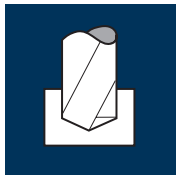



| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | | | | | Inox Stainless | | GG(G) Aluminium |
|---|---|---|---|---|---|---|---|---|---|

Exemple:
**N° cde** **B57020** (N° d'article) **.0080** (Code-ø)

| ø Code | d1 m7 | d2 h5 | l1 | l2 | Lmax | | DURO-SD B57020 |
|---|---|---|---|---|---|---|---|
| .0080 | 0.80 | 3 | 46 | 7.6 | 6.4 | | ● |
| .0085 | 0.85 | 3 | 46 | 8.1 | 6.8 | | ● |
| .0090 | 0.90 | 3 | 46 | 8.5 | 7.2 | | ● |
| .0095 | 0.95 | 3 | 46 | 9.0 | 7.6 | | ● |
| .0100 | 1.00 | 3 | 48 | 9.5 | 8.0 | | ● |
| .0105 | 1.05 | 3 | 48 | 10.0 | 8.4 | | ● |
| .0110 | 1.10 | 3 | 48 | 10.4 | 8.8 | | ● |
| .0115 | 1.15 | 3 | 48 | 10.9 | 9.2 | | ● |
| .0120 | 1.20 | 3 | 48 | 11.4 | 9.6 | | ● |
| .0125 | 1.25 | 3 | 48 | 11.9 | 10.0 | | ● |
| .0130 | 1.30 | 3 | 48 | 12.3 | 10.4 | | ● |
| .0135 | 1.35 | 3 | 48 | 12.8 | 10.8 | | ● |
| .0140 | 1.40 | 3 | 50 | 13.3 | 11.2 | | ● |
| .0145 | 1.45 | 3 | 50 | 13.8 | 11.6 | | ● |
| .0150 | 1.50 | 3 | 50 | 14.2 | 12.0 | | ● |
| .0155 | 1.55 | 3 | 50 | 14.7 | 12.4 | | ● |
| .0160 | 1.60 | 3 | 50 | 15.2 | 12.8 | | ● |
| .0165 | 1.65 | 3 | 50 | 15.7 | 13.2 | | ● |
| .0170 | 1.70 | 3 | 52 | 16.1 | 13.6 | | ● |
| .0175 | 1.75 | 3 | 52 | 16.6 | 14.0 | | ● |
| .0180 | 1.80 | 3 | 52 | 17.1 | 14.4 | | ● |
| .0185 | 1.85 | 3 | 52 | 17.6 | 14.8 | | ● |

## Application



| Matières | d1 [mm] | $v_c$ [m/min] | f [mm] | n [min⁻¹] | $v_f$ [mm/min] | Q [cm³/min] | T [sek] |
|---|---|---|---|---|---|---|---|
| Aciers < 500 N/mm² | 2.00 | 140 | 0.039 | 22280 | 870 | 2.5 | 1.1 |
| | 2.10 | 140 | 0.041 | 21220 | 870 | 3.0 | 1.2 |
| | 2.20 | 140 | 0.043 | 20255 | 870 | 3.5 | 1.2 |
| | 2.35 | 140 | 0.047 | 18965 | 890 | 4.0 | 1.3 |
| | 2.50 | 140 | 0.051 | 17825 | 910 | 4.5 | 1.3 |
| | 2.60 | 140 | 0.053 | 17140 | 910 | 5.0 | 1.4 |
| | 2.75 | 140 | 0.058 | 16205 | 940 | 5.5 | 1.4 |
| | 2.85 | 140 | 0.060 | 15635 | 940 | 6.0 | 1.5 |
| | 2.95 | 140 | 0.064 | 15105 | 965 | 6.5 | 1.5 |
| Aciers 500 - 850 N/mm² | 2.00 | 100 | 0.039 | 15915 | 620 | 2.0 | 1.5 |
| | 2.10 | 100 | 0.041 | 15160 | 620 | 2.0 | 1.6 |
| | 2.20 | 100 | 0.043 | 14470 | 620 | 2.5 | 1.7 |
| | 2.35 | 100 | 0.047 | 13545 | 635 | 3.0 | 1.8 |
| | 2.50 | 100 | 0.051 | 12730 | 650 | 3.0 | 1.9 |
| | 2.60 | 100 | 0.053 | 12245 | 650 | 3.5 | 1.9 |
| | 2.75 | 100 | 0.058 | 11575 | 670 | 4.0 | 2.0 |
| | 2.85 | 100 | 0.060 | 11170 | 670 | 4.5 | 2.0 |
| | 2.95 | 100 | 0.064 | 10790 | 690 | 4.5 | 2.1 |
| Aciers 850 - 1100 N/mm² | 2.00 | 80 | 0.039 | 12730 | 495 | 1.5 | 1.9 |
| | 2.10 | 80 | 0.041 | 12125 | 495 | 1.5 | 2.0 |
| | 2.20 | 80 | 0.043 | 11575 | 500 | 2.0 | 2.1 |
| | 2.35 | 80 | 0.047 | 10835 | 510 | 2.0 | 2.2 |
| | 2.50 | 80 | 0.051 | 10185 | 520 | 2.5 | 2.3 |
| | 2.60 | 80 | 0.053 | 9795 | 520 | 3.0 | 2.4 |
| | 2.75 | 80 | 0.058 | 9260 | 535 | 3.0 | 2.5 |
| | 2.85 | 80 | 0.060 | 8935 | 535 | 3.5 | 2.6 |
| | 2.95 | 80 | 0.064 | 8630 | 550 | 4.0 | 2.6 |
| Aciers inoxydables [Cr-Ni-Mo/1.4571] | 2.00 | 60 | 0.036 | 9550 | 345 | 1.0 | 2.8 |
| | 2.10 | 60 | 0.038 | 9095 | 345 | 1.0 | 2.9 |
| | 2.20 | 60 | 0.040 | 8680 | 345 | 1.5 | 3.1 |
| | 2.35 | 60 | 0.044 | 8125 | 360 | 1.5 | 3.1 |
| | 2.50 | 60 | 0.047 | 7640 | 360 | 2.0 | 3.4 |
| | 2.60 | 60 | 0.050 | 7345 | 365 | 2.0 | 3.4 |
| | 2.75 | 60 | 0.054 | 6945 | 375 | 2.0 | 3.5 |
| | 2.85 | 60 | 0.057 | 6700 | 380 | 2.5 | 3.6 |
| | 2.95 | 60 | 0.059 | 6475 | 380 | 2.5 | 3.7 |

| Matières | d1 [mm] | $v_c$ [m/min] | f [mm] | n [min⁻¹] | $v_f$ [mm/min] | Q [cm³/min] | T [sek] |
|---|---|---|---|---|---|---|---|
| Fonte grise / sphéroïdale | 2.00 | 150 | 0.046 | 23875 | 1100 | 3.5 | 0.9 |
| | 2.10 | 150 | 0.048 | 22735 | 1090 | 4.0 | 0.9 |
| | 2.20 | 150 | 0.050 | 21705 | 1085 | 4.0 | 1.0 |
| | 2.35 | 150 | 0.055 | 20320 | 1120 | 5.0 | 1.0 |
| | 2.50 | 150 | 0.059 | 19100 | 1125 | 5.5 | 1.1 |
| | 2.60 | 150 | 0.063 | 18365 | 1155 | 6.0 | 1.1 |
| | 2.75 | 150 | 0.067 | 17360 | 1165 | 7.0 | 1.1 |
| | 2.85 | 150 | 0.069 | 16755 | 1155 | 7.5 | 1.2 |
| | 2.95 | 150 | 0.072 | 16185 | 1165 | 8.0 | 1.2 |
| Aluminium corroyé Si < 6% | 2.00 | 200 | 0.046 | 31830 | 1465 | 4.5 | 0.7 |
| | 2.10 | 200 | 0.048 | 30315 | 1455 | 5.0 | 0.7 |
| | 2.20 | 200 | 0.050 | 28935 | 1445 | 5.5 | 0.7 |
| | 2.35 | 200 | 0.055 | 27090 | 1490 | 6.5 | 0.8 |
| | 2.50 | 200 | 0.059 | 25465 | 1500 | 7.5 | 0.8 |
| | 2.60 | 200 | 0.063 | 24485 | 1545 | 8.0 | 0.8 |
| | 2.75 | 200 | 0.067 | 23150 | 1550 | 9.0 | 0.9 |
| | 2.85 | 200 | 0.069 | 22340 | 1540 | 10.0 | 0.9 |
| | 2.95 | 200 | 0.072 | 21580 | 1555 | 10.5 | 0.9 |

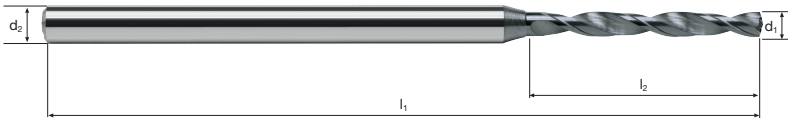
# Microforets Microdrill NX

8xd

HM MG10

30° 155°

h5




| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | | | | | Inox Stainless | | GG(G) Aluminium |
|---|---|---|---|---|---|---|---|---|---|

Exemple:
**N° cde** **B57020** **.0190**

N° d'article — Code-ø

| ø Code | d1 m7 | d2 h5 | l1 | l2 | Lmax | | DURO-SD B57020 |
|---|---|---|---|---|---|---|---|
| .0190 | 1.90 | 3 | 52 | 18.0 | 15.2 | | ● |
| .0195 | 1.95 | 3 | 52 | 18.5 | 15.6 | | ● |
| .0200 | 2.00 | 3 | 56 | 19.0 | 16.0 | | ● |
| .0205 | 2.05 | 3 | 56 | 19.5 | 16.4 | | ● |
| .0210 | 2.10 | 3 | 56 | 20.0 | 16.9 | | ● |
| .0215 | 2.15 | 3 | 56 | 20.4 | 17.2 | | ● |
| .0220 | 2.20 | 3 | 56 | 20.9 | 17.6 | | ● |
| .0225 | 2.25 | 3 | 56 | 21.4 | 18.0 | | ● |
| .0230 | 2.30 | 3 | 56 | 21.9 | 18.5 | | ● |
| .0235 | 2.35 | 3 | 56 | 22.3 | 18.8 | | ● |
| .0240 | 2.40 | 3 | 56 | 22.8 | 19.2 | | ● |
| .0245 | 2.45 | 3 | 56 | 23.3 | 19.6 | | ● |
| .0250 | 2.50 | 3 | 56 | 23.8 | 20.1 | | ● |
| .0255 | 2.55 | 3 | 60 | 24.2 | 20.4 | | ● |
| .0260 | 2.60 | 3 | 60 | 24.7 | 20.8 | | ● |
| .0265 | 2.65 | 3 | 60 | 25.2 | 21.2 | | ● |
| .0270 | 2.70 | 3 | 60 | 25.7 | 21.7 | | ● |
| .0275 | 2.75 | 3 | 60 | 26.1 | 22.0 | | ● |
| .0280 | 2.80 | 3 | 60 | 26.6 | 22.4 | | ● |
| .0285 | 2.85 | 3 | 60 | 27.1 | 22.8 | | ● |
| .0290 | 2.90 | 3 | 60 | 27.6 | 23.3 | | ● |
| .0295 | 2.95 | 3 | 60 | 28.0 | 23.6 | | ● |