

Application



Material

Steel
< 500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]
3	160	0.070	16975	1190
4	160	0.095	12730	1210
5	160	0.120	10185	1220
6	160	0.145	8490	1230
8	160	0.190	6365	1210
10	160	0.240	5095	1225
12	160	0.285	4245	1210
16	160	0.380	3185	1210

Steel
500 - 850 N/mm²

3	120	0.070	12730	890
4	120	0.095	9550	905
5	120	0.120	7640	915
6	120	0.145	6365	925
8	120	0.190	4775	905
10	120	0.240	3820	915
12	120	0.285	3185	910
16	120	0.380	2385	905

Steel
850 - 1100 N/mm²

3	90	0.030	9550	285
4	90	0.040	7160	285
5	90	0.050	5730	285
6	90	0.060	4775	285
8	90	0.080	3580	285
10	90	0.095	2865	270
12	90	0.115	2385	275
16	90	0.155	1790	275

Steel
1100 - 1300 N/mm²

3	60	0.025	6365	160
4	60	0.035	4775	165
5	60	0.040	3820	155
6	60	0.050	3185	160
8	60	0.065	2385	155
10	60	0.080	1910	155
12	60	0.095	1590	150
16	60	0.130	1195	155

Material

Steel
1300 - 1500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]
3	30	0.025	3185	80
4	30	0.035	2385	85
5	30	0.040	1910	75
6	30	0.050	1590	80
8	30	0.065	1195	80
10	30	0.080	955	75
12	30	0.095	795	75
16	30	0.130	595	75

Cold work tool steel
(12% Cr)
high alloyed
[1.2379]
Stainless steel
[Cr-Ni/1.4301]

3	40	0.015	4245	65
4	40	0.020	3185	65
5	40	0.025	2545	65
6	40	0.030	2120	65
8	40	0.040	1590	65
10	40	0.045	1275	55
12	40	0.060	1060	65
16	40	0.075	795	60

Cast iron
(lamellar / spheroidal)

3	180	0.075	19100	1435
4	180	0.105	14325	1505
5	180	0.130	11460	1490
6	180	0.160	9550	1530
8	180	0.210	7160	1505
10	180	0.265	5730	1520
12	180	0.315	4775	1505
16	180	0.420	3580	1505

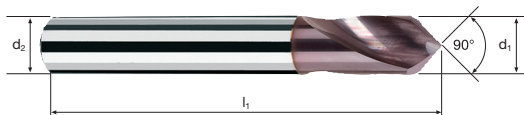
Wrought aluminium
alloys Si < 6%

3	220	0.075	23345	1750
4	220	0.105	17505	1840
5	220	0.130	14005	1820
6	220	0.160	11670	1865
8	220	0.210	8755	1840
10	220	0.265	7005	1855
12	220	0.315	5835	1840
16	220	0.420	4375	1840

Center drills

90°

HM MG10	



Rm < 850	Rm 850-1100	Rm 1100-1300				Inox Stainless	GG(G) Aluminium
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					U-4XD
Example: Order-N°.		Article-N°	ø-Code		B92040
		B92040	.0300	<input type="text"/>	
ø Code	d1 h6	d2 h6	l1		
.0300	3	3	50		•
.0400	4	4	50		•
.0500	5	5	50		•
.0600	6	6	57		•
.0800	8	8	63		•
.1000	10	10	72		•
.1200	12	12	83		•
.1600	16	16	92		•

Application



Material

Steel
< 500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]
3	160	0.070	16975	1190
4	160	0.095	12730	1210
5	160	0.120	10185	1220
6	160	0.145	8490	1230
8	160	0.190	6365	1210
10	160	0.240	5095	1225
12	160	0.285	4245	1210
16	160	0.380	3185	1210

Steel
500 - 850 N/mm²

3	120	0.070	12730	890
4	120	0.095	9550	905
5	120	0.120	7640	915
6	120	0.145	6365	925
8	120	0.190	4775	905
10	120	0.240	3820	915
12	120	0.285	3185	910
16	120	0.380	2385	905

Steel
850 - 1100 N/mm²

3	90	0.060	9550	575
4	90	0.075	7160	535
5	90	0.095	5730	545
6	90	0.115	4775	550
8	90	0.155	3580	555
10	90	0.190	2865	545
12	90	0.230	2385	550
16	90	0.310	1790	555

Steel
1100 - 1300 N/mm²

3	60	0.050	6365	320
4	60	0.065	4775	310
5	60	0.080	3820	305
6	60	0.095	3185	305
8	60	0.125	2385	300
10	60	0.160	1910	305
12	60	0.190	1590	300
16	60	0.255	1195	305

Material

Steel
1300 - 1500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]
3	30	0.050	3185	160
4	30	0.065	2385	155
5	30	0.080	1910	155
6	30	0.095	1590	150
8	30	0.125	1195	150
10	30	0.160	955	155
12	30	0.190	795	150
16	30	0.255	595	150

Cold work tool steel
(12% Cr)
high alloyed
[1.2379]
Stainless steel
[Cr-Ni/1.4301]

3	60	0.040	6365	255
4	60	0.055	4775	265
5	60	0.070	3820	265
6	60	0.080	3185	255
8	60	0.110	2385	260
10	60	0.135	1910	260
12	60	0.165	1590	260
16	60	0.220	1195	265

Cast iron
(lamellar / spheroidal)

3	180	0.080	19100	1530
4	180	0.105	14325	1505
5	180	0.130	11460	1490
6	180	0.160	9550	1530
8	180	0.210	7160	1505
10	180	0.265	5730	1520
12	180	0.315	4775	1505
16	180	0.420	3580	1505

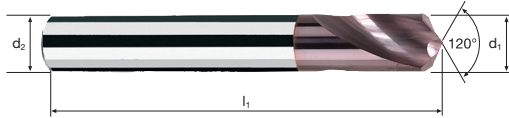
Wrought aluminium
alloys Si < 6%

3	220	0.080	23345	1870
4	220	0.105	17505	1840
5	220	0.130	14005	1820
6	220	0.160	11670	1865
8	220	0.210	8755	1840
10	220	0.265	7005	1855
12	220	0.315	5835	1840
16	220	0.420	4375	1840

Center drills

120°

HM MG10	



Rm < 850	Rm 850-1100	Rm 1100-1300				Inox Stainless		GG(G) Aluminium
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Example: Order-N°.		Article-N°.		ø-Code			U-4XD
		B92020		.0300		<input type="text"/>	B92020
ø Code	d1 h6	d2 h6	l1				
.0300	3	3	50				
.0400	4	4	50				
.0500	5	5	50				
.0600	6	6	57				
.0800	8	8	63				
.1000	10	10	72				
.1200	12	12	83				
.1600	16	16	92				

Application



Material

Steel
< 500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]
3	160	0.070	16975	1190
4	160	0.095	12730	1210
5	160	0.120	10185	1220
6	160	0.145	8490	1230
8	160	0.190	6365	1210
10	160	0.240	5095	1225
12	160	0.285	4245	1210
16	160	0.380	3185	1210

Steel
500 - 850 N/mm²

3	120	0.070	12730	890
4	120	0.095	9550	905
5	120	0.120	7640	915
6	120	0.145	6365	925
8	120	0.190	4775	905
10	120	0.240	3820	915
12	120	0.285	3185	910
16	120	0.380	2385	905

Steel
850 - 1100 N/mm²

3	90	0.060	9550	575
4	90	0.075	7160	535
5	90	0.095	5730	545
6	90	0.115	4775	550
8	90	0.155	3580	555
10	90	0.190	2865	545
12	90	0.230	2385	550
16	90	0.310	1790	555

Steel
1100 - 1300 N/mm²

3	60	0.050	6365	320
4	60	0.065	4775	310
5	60	0.080	3820	305
6	60	0.095	3185	305
8	60	0.125	2385	300
10	60	0.160	1910	305
12	60	0.190	1590	300
16	60	0.255	1195	305

Material

Steel
1300 - 1500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]
3	30	0.050	3185	160
4	30	0.065	2385	155
5	30	0.080	1910	155
6	30	0.095	1590	150
8	30	0.125	1195	150
10	30	0.160	955	155
12	30	0.190	795	150
16	30	0.255	595	150

Cold work tool steel
(12% Cr)
high alloyed
[1.2379]
Stainless steel
[Cr-Ni/1.4301]

3	60	0.040	6365	255
4	60	0.055	4775	265
5	60	0.070	3820	265
6	60	0.080	3185	255
8	60	0.110	2385	260
10	60	0.135	1910	260
12	60	0.165	1590	260
16	60	0.220	1195	265

Cast iron
(lamellar / spheroidal)

3	180	0.080	19100	1530
4	180	0.105	14325	1505
5	180	0.130	11460	1490
6	180	0.160	9550	1530
8	180	0.210	7160	1505
10	180	0.265	5730	1520
12	180	0.315	4775	1505
16	180	0.420	3580	1505

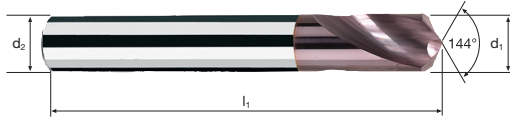
Wrought aluminium
alloys Si < 6%

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4	220	0.105	17505	1840
5	220	0.130	14005	1820
6	220	0.160	11670	1865
8	220	0.210	8755	1840
10	220	0.265	7005	1855
12	220	0.315	5835	1840
16	220	0.420	4375	1840

Center drills

144°

HM MG10	



Rm < 850	Rm 850-1100	Rm 1100-1300				Inox Stainless	GG(G) Aluminium
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Example: Order-N°.				Article-N°	ø-Code		U-4XD
				B92008	.0300	<input type="text"/>	B92008
ø Code	d1 h6	d2 h6	l1				
.0300	3	3	50				●
.0400	4	4	50				●
.0500	5	5	50				●
.0600	6	6	57				●
.0800	8	8	63				●
.1000	10	10	72				●
.1200	12	12	83				●
.1600	16	16	92				●