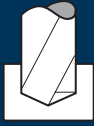


Application



Material

Steel
< 500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
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

Steel
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

Steel
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

Stainless steel
[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

Material

Cast iron
(lamellar / spheroidal)

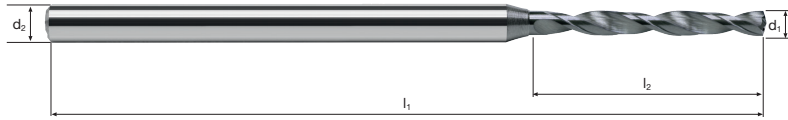
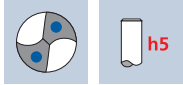
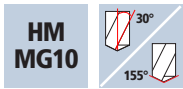
d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
0.80	150	0.016	59685	955	0.5	0.4
0.90	150	0.019	53050	1010	0.5	0.4
1.00	150	0.021	47745	1005	1.0	0.5
1.10	150	0.023	43405	1000	1.0	0.5
1.25	150	0.026	38195	995	1.0	0.6
1.40	150	0.030	34105	1025	1.5	0.7
1.50	150	0.032	31830	1020	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

Wrought aluminium
alloys 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

Micro drills Microdrill NX

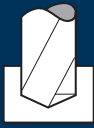
8xd



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	GG(G) Aluminium
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Example: Order-N°.							Article-N°.		ø-Code		DURO-SD	
							B57020		.0080		B57020	
ø Code	d1 m7	d2 h5	l1	l2	L _{max}							
.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



Material

Steel
< 500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
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

Steel
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

Steel
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

Stainless steel
[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

Material

Cast iron
(lamellar / spheroidal)

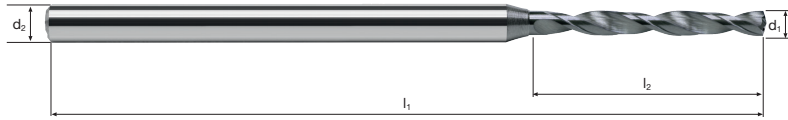
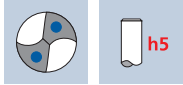
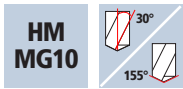
d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
2.00	150	0.046	23875	1100	3.5	0.9
2.10	150	0.048	22735	1090	4.0	0.9
2.20	150	0.050	21705	1085	4.0	1.0
2.35	150	0.055	20320	1120	5.0	1.0
2.50	150	0.059	19100	1125	5.5	1.1
2.60	150	0.063	18365	1155	6.0	1.1
2.75	150	0.067	17360	1165	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

Wrought aluminium
alloys 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

Micro drills Microdrill NX

8xd



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	GG(G) Aluminium
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Example: Order-N°.		Article-N°.		ø-Code			DURO-SD
		B57020		.0190		<input type="text"/>	B57020
ø Code	d1 m7	d2 h5	l1	l2	L _{max}		
.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		●