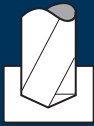


Application



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]
3.00	180	0.140	19100	2675	19.0	0.4
3.30	180	0.155	17360	2690	23.0	0.4
3.50	180	0.165	16370	2700	26.0	0.4
3.80	180	0.175	15080	2640	30.0	0.4
4.00	180	0.195	14325	2795	35.0	0.4
4.20	180	0.210	13640	2865	39.5	0.4
4.50	180	0.240	12730	3055	48.5	0.4
4.80	180	0.255	11935	3045	55.0	0.4
5.00	180	0.265	11460	3035	59.5	0.4

Steel
500 - 850 N/mm²

3.00	160	0.120	16975	2035	14.5	0.5
3.30	160	0.130	15435	2005	17.0	0.5
3.50	160	0.140	14550	2035	19.5	0.5
3.80	160	0.150	13405	2010	23.0	0.6
4.00	160	0.165	12730	2100	26.5	0.5
4.20	160	0.180	12125	2185	30.5	0.5
4.50	160	0.205	11320	2320	37.0	0.5
4.80	160	0.220	10610	2335	42.5	0.5
5.00	160	0.230	10185	2345	46.0	0.5

Steel
850 - 1100 N/mm²

3.00	140	0.110	14855	1635	11.5	0.6
3.30	140	0.120	13505	1620	14.0	0.6
3.50	140	0.130	12730	1655	16.0	0.6
3.80	140	0.140	11725	1640	18.5	0.7
4.00	140	0.155	11140	1725	21.5	0.7
4.20	140	0.165	10610	1750	24.0	0.6
4.50	140	0.190	9905	1880	30.0	0.6
4.80	140	0.200	9285	1855	33.5	0.6
5.00	140	0.210	8915	1870	36.5	0.6

Steel
1100 - 1300 N/mm²

3.00	100	0.085	10610	900	6.5	1.1
3.30	100	0.090	9645	870	7.5	1.1
3.50	100	0.100	9095	910	9.0	1.0
3.80	100	0.105	8375	880	10.0	1.3
4.00	100	0.115	7960	915	11.5	1.2
4.20	100	0.125	7580	950	13.0	1.2
4.50	100	0.145	7075	1025	16.5	1.1
4.80	100	0.155	6630	1030	18.5	1.1
5.00	100	0.160	6365	1020	20.0	1.1

Material

Steel
1300 - 1500 N/mm²

3.00	55	0.065	5835	380	2.5	2.6
3.30	55	0.070	5305	370	3.0	2.6
3.50	55	0.075	5000	375	3.5	2.5
3.80	55	0.080	4605	370	4.0	3.1
4.00	55	0.090	4375	395	5.0	2.9
4.20	55	0.095	4170	395	5.5	2.9
4.50	55	0.110	3890	430	7.0	2.6
4.80	55	0.120	3645	435	8.0	2.5
5.00	55	0.125	3500	440	8.5	2.6

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

3.00	70	0.065	7425	485	3.5	2.0
3.30	70	0.070	6750	475	4.0	2.0
3.50	70	0.075	6365	475	4.5	2.0
3.80	70	0.080	5865	470	5.5	2.5
4.00	70	0.090	5570	500	6.5	2.3
4.20	70	0.095	5305	505	7.0	2.2
4.50	70	0.110	4950	545	8.5	2.0
4.80	70	0.120	4640	555	10.0	2.0
5.00	70	0.125	4455	555	11.0	2.0

Titanium alloys
>300 HB
[Ti6Al4V]

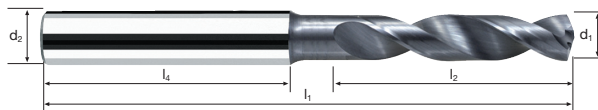
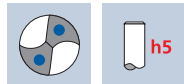
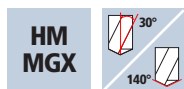
3.00	40	0.065	4245	275	2.0	3.5
3.30	40	0.070	3860	270	2.5	3.5
3.50	40	0.075	3640	275	2.5	3.4
3.80	40	0.080	3350	270	3.0	4.3
4.00	40	0.090	3185	285	3.5	4.0
4.20	40	0.095	3030	290	4.0	3.9
4.50	40	0.110	2830	310	5.0	3.6
4.80	40	0.120	2655	320	6.0	3.5
5.00	40	0.125	2545	320	6.5	3.5

Cast iron
(lamellar / spheroidal)

3.00	240	0.125	25465	3185	22.5	0.3
3.30	240	0.140	23150	3240	27.5	0.3
3.50	240	0.150	21825	3275	31.5	0.3
3.80	240	0.160	20105	3215	36.5	0.4
4.00	240	0.175	19100	3345	42.0	0.3
4.20	240	0.190	18190	3455	48.0	0.3
4.50	240	0.220	16975	3735	59.5	0.3
4.80	240	0.235	15915	3740	67.5	0.3
5.00	240	0.240	15280	3665	72.0	0.3

Spiral flute drills XDrill®

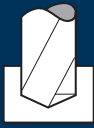
3xd



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56		Inox Stainless	Ti Titanium	GG(G)
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Example: Order-N°.		Article-N°.		ø-Code				DURO-X	
		B72011		.0300				B72011	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}			
.0300	3.0	6	62	20	36	16.2			●
.0310	3.1	6	62	20	36	16.2			●
.0320	3.2	6	62	20	36	16.0			●
.0330	3.3	6	62	20	36	16.0			●
.0340	3.4	6	62	20	36	15.8			●
.0350	3.5	6	62	20	36	15.8			●
.0360	3.6	6	62	20	36	15.6			●
.0370	3.7	6	62	20	36	15.6			●
.0380	3.8	6	66	24	36	19.4			●
.0390	3.9	6	66	24	36	19.4			●
.0400	4.0	6	66	24	36	18.9			●
.0410	4.1	6	66	24	36	18.9			●
.0420	4.2	6	66	24	36	18.8			●
.0430	4.3	6	66	24	36	18.7			●
.0440	4.4	6	66	24	36	18.6			●
.0450	4.5	6	66	24	36	18.6			●
.0460	4.6	6	66	24	36	18.5			●
.0470	4.7	6	66	24	36	18.5			●
.0480	4.8	6	66	28	36	18.4			●
.0490	4.9	6	66	28	36	18.4			●
.0500	5.0	6	66	28	36	18.7			●
.0510	5.1	6	66	28	36	18.7			●
.0520	5.2	6	66	28	36	18.6			●

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]
5.50	180	0.295	10415	3070	73.0	0.4
5.80	180	0.310	9880	3065	81.0	0.4
6.00	180	0.330	9550	3150	89.0	0.4
6.20	180	0.350	9240	3235	97.5	0.5
6.50	180	0.370	8815	3260	108.0	0.5
6.80	180	0.385	8425	3245	118.0	0.5
7.00	180	0.395	8185	3235	124.5	0.5
7.20	180	0.410	7960	3265	133.0	0.5
7.50	180	0.425	7640	3245	143.5	0.5

Steel
500 - 850 N/mm²

5.50	160	0.250	9260	2315	55.0	0.5
5.80	160	0.265	8780	2325	61.5	0.5
6.00	160	0.285	8490	2420	68.5	0.5
6.20	160	0.300	8215	2465	74.5	0.7
6.50	160	0.315	7835	2470	82.0	0.7
6.80	160	0.330	7490	2470	89.5	0.7
7.00	160	0.340	7275	2475	95.0	0.7
7.20	160	0.350	7075	2475	101.0	0.7
7.50	160	0.365	6790	2480	109.5	0.7

Steel
850 - 1100 N/mm²

5.50	140	0.230	8100	1865	44.5	0.6
5.80	140	0.245	7685	1885	50.0	0.6
6.00	140	0.260	7425	1930	54.5	0.6
6.20	140	0.275	7190	1975	59.5	0.9
6.50	140	0.290	6855	1990	66.0	0.9
6.80	140	0.305	6555	2000	72.5	0.9
7.00	140	0.315	6365	2005	77.0	0.9
7.20	140	0.320	6190	1980	80.5	0.9
7.50	140	0.335	5940	1990	88.0	0.9

Steel
1100 - 1300 N/mm²

5.50	100	0.175	5785	1010	24.0	1.1
5.80	100	0.185	5490	1015	27.0	1.1
6.00	100	0.200	5305	1060	30.0	1.0
6.20	100	0.210	5135	1080	32.5	1.6
6.50	100	0.220	4895	1075	35.5	1.6
6.80	100	0.230	4680	1075	39.0	1.6
7.00	100	0.240	4545	1090	42.0	1.6
7.20	100	0.245	4420	1085	44.0	1.6
7.50	100	0.255	4245	1080	47.5	1.6

Material

Steel
1300 - 1500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
5.50	55	0.135	3185	430	10.0	2.6
5.80	55	0.145	3020	440	11.5	2.5
6.00	55	0.150	2920	440	12.5	2.5
6.20	55	0.160	2825	450	13.5	3.9
6.50	55	0.170	2695	460	15.5	3.8
6.80	55	0.180	2575	465	17.0	3.7
7.00	55	0.185	2500	465	18.0	3.7
7.20	55	0.190	2430	460	18.5	3.7
7.50	55	0.195	2335	455	20.0	3.8

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

5.50	70	0.135	4050	545	13.0	2.0
5.80	70	0.145	3840	555	14.5	2.0
6.00	70	0.150	3715	555	15.5	2.0
6.20	70	0.160	3595	575	17.5	3.0
6.50	70	0.170	3430	585	19.5	3.0
6.80	70	0.180	3275	590	21.5	2.9
7.00	70	0.185	3185	590	22.5	2.9
7.20	70	0.190	3095	590	24.0	2.9
7.50	70	0.195	2970	580	25.5	2.9

Titanium alloys
>300 HB
[Ti6Al4V]

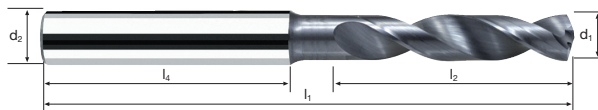
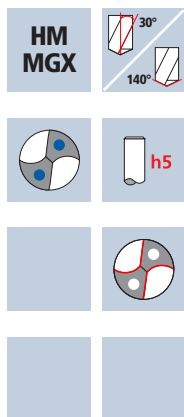
5.50	40	0.135	2315	315	7.5	3.5
5.80	40	0.145	2195	320	8.5	3.5
6.00	40	0.150	2120	320	9.0	3.5
6.20	40	0.160	2055	330	10.0	5.3
6.50	40	0.170	1960	335	11.0	5.2
6.80	40	0.180	1870	335	12.0	5.2
7.00	40	0.185	1820	335	13.0	5.1
7.20	40	0.190	1770	335	13.5	5.1
7.50	40	0.195	1700	330	14.5	5.2

Cast iron
(lamellar / spheroidal)

5.50	240	0.265	13890	3680	87.5	0.3
5.80	240	0.280	13170	3690	97.5	0.3
6.00	240	0.300	12730	3820	108.0	0.3
6.20	240	0.320	12320	3940	119.0	0.4
6.50	240	0.335	11755	3940	130.5	0.4
6.80	240	0.350	11235	3930	142.5	0.4
7.00	240	0.360	10915	3930	151.0	0.4
7.20	240	0.370	10610	3925	160.0	0.4
7.50	240	0.385	10185	3920	173.0	0.4

Spiral flute drills XDrill®

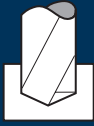
3xd



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56		Inox Stainless	Ti Titanium	GG(G)
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Example: Order-N°.		Article-N°.		ø-Code				DURO-X	
		B72011		.0530				B72011	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}			
.0530	5.3	6	66	28	36	18.6			●
.0540	5.4	6	66	28	36	18.5			●
.0550	5.5	6	66	28	36	18.5			●
.0560	5.6	6	66	28	36	18.4			●
.0570	5.7	6	66	28	36	18.4			●
.0580	5.8	6	66	28	36	18.4			●
.0590	5.9	6	66	28	36	18.4			●
.0600	6.0	6	66	28	36	18.5			●
.0610	6.1	8	79	34	36	29.3			●
.0620	6.2	8	79	34	36	29.2			●
.0630	6.3	8	79	34	36	29.2			●
.0640	6.4	8	79	34	36	29.1			●
.0650	6.5	8	79	34	36	29.1			●
.0660	6.6	8	79	34	36	29.0			●
.0670	6.7	8	79	34	36	29.0			●
.0680	6.8	8	79	34	36	28.8			●
.0690	6.9	8	79	34	36	28.8			●
.0700	7.0	8	79	34	36	28.7			●
.0710	7.1	8	79	41	36	28.7			●
.0720	7.2	8	79	41	36	28.6			●
.0730	7.3	8	79	41	36	28.6			●
.0740	7.4	8	79	41	36	28.5			●
.0750	7.5	8	79	41	36	28.5			●

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]
7.60	180	0.430	7540	3240	147.0	0.5
8.00	180	0.455	7160	3260	164.0	0.5
8.20	180	0.465	6985	3250	171.5	0.6
8.50	180	0.480	6740	3235	183.5	0.6
8.80	180	0.500	6510	3255	198.0	0.6
9.00	180	0.510	6365	3245	206.5	0.6
9.20	180	0.520	6230	3240	215.5	0.6
9.50	180	0.540	6030	3255	230.5	0.6
9.80	180	0.555	5845	3245	245.0	0.6

Steel
500 - 850 N/mm²

7.60	160	0.370	6700	2480	112.5	0.7
8.00	160	0.390	6365	2480	124.5	0.7
8.20	160	0.400	6210	2485	131.0	0.8
8.50	160	0.415	5990	2485	141.0	0.8
8.80	160	0.425	5785	2460	149.5	0.8
9.00	160	0.435	5660	2460	156.5	0.8
9.20	160	0.445	5535	2465	164.0	0.8
9.50	160	0.460	5360	2465	174.5	0.8
9.80	160	0.475	5195	2470	186.5	0.8

Steel
850 - 1100 N/mm²

7.60	140	0.340	5865	1995	90.5	0.9
8.00	140	0.360	5570	2005	101.0	0.8
8.20	140	0.365	5435	1985	105.0	1.0
8.50	140	0.380	5245	1995	113.0	1.0
8.80	140	0.395	5065	2000	121.5	1.0
9.00	140	0.405	4950	2005	127.5	0.9
9.20	140	0.410	4845	1985	132.0	1.0
9.50	140	0.425	4690	1995	141.5	0.9
9.80	140	0.440	4545	2000	151.0	0.9

Steel
1100 - 1300 N/mm²

7.60	100	0.260	4190	1090	49.5	1.6
8.00	100	0.270	3980	1075	54.0	1.6
8.20	100	0.280	3880	1085	57.5	1.8
8.50	100	0.290	3745	1085	61.5	1.8
8.80	100	0.300	3615	1085	66.0	1.8
9.00	100	0.305	3535	1080	68.5	1.8
9.20	100	0.315	3460	1090	72.5	1.7
9.50	100	0.325	3350	1090	77.5	1.7
9.80	100	0.335	3250	1090	82.0	1.7

Material

Steel
1300 - 1500 N/mm²

7.60	55	0.200	2305	460	21.0	3.7
8.00	55	0.210	2190	460	23.0	3.7
8.20	55	0.215	2135	460	24.5	4.2
8.50	55	0.220	2060	455	26.0	4.2
8.80	55	0.230	1990	460	28.0	4.1
9.00	55	0.235	1945	455	29.0	4.2
9.20	55	0.240	1905	455	30.0	4.2
9.50	55	0.250	1845	460	32.5	4.1
9.80	55	0.255	1785	455	34.5	4.1

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

7.60	70	0.200	2930	585	26.5	2.9
8.00	70	0.210	2785	585	29.5	2.9
8.20	70	0.215	2715	585	31.0	3.3
8.50	70	0.220	2620	575	32.5	3.3
8.80	70	0.230	2530	580	35.5	3.3
9.00	70	0.235	2475	580	37.0	3.3
9.20	70	0.240	2420	580	38.5	3.3
9.50	70	0.250	2345	585	41.5	3.2
9.80	70	0.255	2275	580	43.5	3.2

Titanium alloys
>300 HB
[Ti6Al4V]

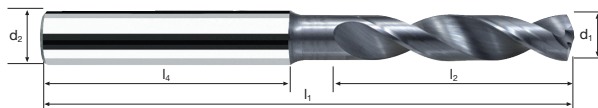
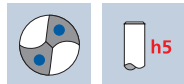
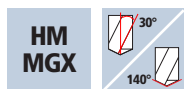
7.60	40	0.200	1675	335	15.0	5.1
8.00	40	0.210	1590	335	17.0	5.1
8.20	40	0.215	1555	335	17.5	5.8
8.50	40	0.220	1500	330	18.5	5.8
8.80	40	0.230	1445	330	20.0	5.8
9.00	40	0.235	1415	335	21.5	5.7
9.20	40	0.240	1385	330	22.0	5.7
9.50	40	0.250	1340	335	23.5	5.6
9.80	40	0.255	1300	330	25.0	5.7

Cast iron
(lamellar / spheroidal)

7.60	240	0.390	10050	3920	178.0	0.4
8.00	240	0.410	9550	3915	197.0	0.4
8.20	240	0.420	9315	3910	206.5	0.5
8.50	240	0.440	8990	3955	224.5	0.5
8.80	240	0.455	8680	3950	240.0	0.5
9.00	240	0.465	8490	3950	251.5	0.5
9.20	240	0.475	8305	3945	262.0	0.5
9.50	240	0.490	8040	3940	279.5	0.5
9.80	240	0.505	7795	3935	297.0	0.5

Spiral flute drills XDrill®

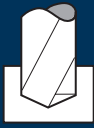
3xd



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56		Inox Stainless	Ti Titanium	GG(G)
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Example: Order-N°.							Article-N°.		ø-Code		DURO-X	
							B72011		.0760		B72011	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}						
.0760	7.6	8	79	41	36	28.4						●
.0770	7.7	8	79	41	36	28.4						●
.0780	7.8	8	79	41	36	28.3						●
.0790	7.9	8	79	41	36	28.4						●
.0800	8.0	8	79	41	36	28.4						●
.0810	8.1	10	89	47	40	32.3						●
.0820	8.2	10	89	47	40	32.2						●
.0830	8.3	10	89	47	40	32.2						●
.0840	8.4	10	89	47	40	32.1						●
.0850	8.5	10	89	47	40	32.1						●
.0860	8.6	10	89	47	40	31.9						●
.0870	8.7	10	89	47	40	31.9						●
.0880	8.8	10	89	47	40	31.8						●
.0890	8.9	10	89	47	40	31.8						●
.0900	9.0	10	89	47	40	31.7						●
.0910	9.1	10	89	47	40	31.7						●
.0920	9.2	10	89	47	40	31.6						●
.0930	9.3	10	89	47	40	31.6						●
.0940	9.4	10	89	47	40	31.4						●
.0950	9.5	10	89	47	40	31.4						●
.0960	9.6	10	89	47	40	31.3						●
.0970	9.7	10	89	47	40	31.3						●
.0980	9.8	10	89	47	40	31.3						●

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]
10.00	180	0.565	5730	3235	254.0	0.6
10.20	180	0.575	5615	3230	264.0	0.7
10.50	180	0.590	5455	3220	279.0	0.7
10.80	180	0.605	5305	3210	294.0	0.7
11.00	180	0.610	5210	3180	302.0	0.7
11.20	180	0.615	5115	3145	310.0	0.7
11.50	180	0.620	4980	3090	321.0	0.7
11.80	180	0.630	4855	3060	334.5	0.7
12.00	180	0.640	4775	3055	345.5	0.7

Steel
500 - 850 N/mm²

10.00	160	0.485	5095	2470	194.0	0.8
10.20	160	0.495	4995	2475	202.0	0.9
10.50	160	0.505	4850	2450	212.0	0.9
10.80	160	0.520	4715	2450	224.5	0.9
11.00	160	0.525	4630	2430	231.0	0.9
11.20	160	0.530	4545	2410	237.5	0.9
11.50	160	0.530	4430	2350	244.0	0.9
11.80	160	0.540	4315	2330	255.0	0.9
12.00	160	0.550	4245	2335	264.0	0.9

Steel
850 - 1100 N/mm²

10.00	140	0.445	4455	1980	155.5	0.9
10.20	140	0.455	4370	1990	162.5	1.1
10.50	140	0.465	4245	1975	171.0	1.1
10.80	140	0.475	4125	1960	179.5	1.1
11.00	140	0.485	4050	1965	186.5	1.1
11.20	140	0.485	3980	1930	190.0	1.1
11.50	140	0.490	3875	1900	197.5	1.1
11.80	140	0.495	3775	1870	204.5	1.2
12.00	140	0.505	3715	1875	212.0	1.2

Steel
1100 - 1300 N/mm²

10.00	100	0.340	3185	1085	85.0	1.7
10.20	100	0.345	3120	1075	88.0	2.1
10.50	100	0.355	3030	1075	93.0	2.1
10.80	100	0.365	2945	1075	98.5	2.1
11.00	100	0.365	2895	1055	100.5	2.1
11.20	100	0.370	2840	1050	103.5	2.1
11.50	100	0.375	2770	1040	108.0	2.1
11.80	100	0.380	2700	1025	112.0	2.1
12.00	100	0.385	2655	1020	115.5	2.1

Material

Steel
1300 - 1500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
10.00	55	0.260	1750	455	35.5	4.1
10.20	55	0.265	1715	455	37.0	4.9
10.50	55	0.275	1665	460	40.0	4.8
10.80	55	0.280	1620	455	41.5	4.9
11.00	55	0.285	1590	455	43.0	4.8
11.20	55	0.285	1565	445	44.0	4.9
11.50	55	0.285	1520	435	45.0	5.0
11.80	55	0.290	1485	430	47.0	5.1
12.00	55	0.295	1460	430	48.5	5.1

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

10.00	70	0.260	2230	580	45.5	3.2
10.20	70	0.265	2185	580	47.5	3.8
10.50	70	0.275	2120	585	50.5	3.8
10.80	70	0.280	2065	580	53.0	3.8
11.00	70	0.285	2025	575	54.5	3.8
11.20	70	0.285	1990	565	55.5	3.9
11.50	70	0.285	1940	555	57.5	3.9
11.80	70	0.290	1890	550	60.0	3.9
12.00	70	0.295	1855	545	61.5	4.0

Titanium alloys
>300 HB
[Ti6Al4V]

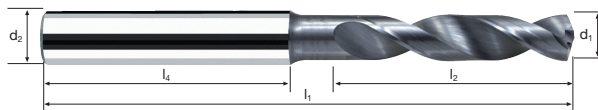
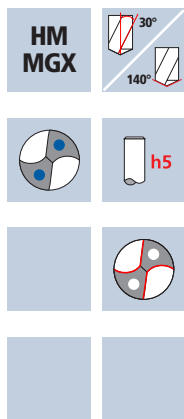
10.00	40	0.260	1275	330	26.0	5.7
10.20	40	0.265	1250	330	27.0	6.8
10.50	40	0.275	1215	335	29.0	6.6
10.80	40	0.280	1180	330	30.0	6.7
11.00	40	0.285	1155	330	31.5	6.7
11.20	40	0.285	1135	325	32.0	6.7
11.50	40	0.285	1105	315	32.5	6.9
11.80	40	0.290	1080	315	34.5	6.9
12.00	40	0.295	1060	315	35.5	6.9

Cast iron
(lamellar / spheroidal)

10.00	240	0.515	7640	3935	309.0	0.5
10.20	240	0.520	7490	3895	318.5	0.6
10.50	240	0.540	7275	3930	340.5	0.6
10.80	240	0.550	7075	3890	356.5	0.6
11.00	240	0.555	6945	3855	366.5	0.6
11.20	240	0.560	6820	3820	376.5	0.6
11.50	240	0.565	6645	3755	390.0	0.6
11.80	240	0.570	6475	3690	403.5	0.6
12.00	240	0.580	6365	3690	417.5	0.6

Spiral flute drills XDrill®

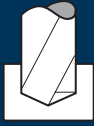
3xd



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56		Inox Stainless	Ti Titanium	GG(G)
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Example: Order-N°.		Article-N°.		ø-Code				DURO-X	
		B72011		.0990				B72011	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}			
.0990	9.9	10	89	47	40	31.3			●
.1000	10.0	10	89	47	40	31.3			●
.1010	10.1	12	102	55	45	37.3			●
.1020	10.2	12	102	55	45	37.2			●
.1030	10.3	12	102	55	45	37.2			●
.1040	10.4	12	102	55	45	37.1			●
.1050	10.5	12	102	55	45	37.0			●
.1060	10.6	12	102	55	45	36.9			●
.1070	10.7	12	102	55	45	36.9			●
.1080	10.8	12	102	55	45	36.8			●
.1090	10.9	12	102	55	45	36.8			●
.1100	11.0	12	102	55	45	36.7			●
.1110	11.1	12	102	55	45	36.7			●
.1120	11.2	12	102	55	45	36.5			●
.1130	11.3	12	102	55	45	36.5			●
.1140	11.4	12	102	55	45	36.4			●
.1150	11.5	12	102	55	45	36.4			●
.1160	11.6	12	102	55	45	36.3			●
.1170	11.7	12	102	55	45	36.3			●
.1180	11.8	12	102	55	45	36.2			●
.1190	11.9	12	102	55	45	36.3			●
.1200	12.0	12	102	55	45	36.3			●

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]
12.50	180	0.665	4585	3050	374.5	0.8
13.00	180	0.695	4405	3060	406.0	0.8
13.50	180	0.705	4340	3060	419.0	0.8
14.00	180	0.715	4095	2930	451.0	0.8
14.50	180	0.725	3950	2865	473.0	0.9
15.00	180	0.745	3820	2845	503.0	0.9
15.50	180	0.760	3695	2810	530.0	0.9
15.80	180	0.770	3625	2790	547.0	0.9
16.00	180	0.775	3580	2775	558.0	0.9

Steel
500 - 850 N/mm²

12.50	160	0.570	4075	2325	285.5	1.0
13.00	160	0.595	3920	2330	309.5	1.0
13.50	160	0.605	3860	2335	319.5	1.0
14.00	160	0.610	3640	2220	341.5	1.0
14.50	160	0.620	3510	2175	359.0	1.1
15.00	160	0.640	3395	2175	384.5	1.1
15.50	160	0.650	3285	2135	403.0	1.1
15.80	160	0.660	3225	2130	417.5	1.1
16.00	160	0.665	3185	2120	426.5	1.1

Steel
850 - 1100 N/mm²

12.50	140	0.525	3565	1870	229.5	1.2
13.00	140	0.545	3430	1870	248.0	1.2
13.50	140	0.555	3375	1875	256.5	1.2
14.00	140	0.565	3185	1800	277.0	1.3
14.50	140	0.570	3075	1755	290.0	1.4
15.00	140	0.590	2970	1750	309.5	1.4
15.50	140	0.600	2875	1725	325.5	1.4
15.80	140	0.605	2820	1705	334.5	1.4
16.00	140	0.610	2785	1700	342.0	1.4

Steel
1100 - 1300 N/mm²

12.50	100	0.400	2545	1020	125.0	2.3
13.00	100	0.415	2450	1015	134.5	2.3
13.50	100	0.420	2410	1010	138.0	2.3
14.00	100	0.430	2275	980	151.0	2.3
14.50	100	0.435	2195	955	157.5	2.6
15.00	100	0.445	2120	945	167.0	2.6
15.50	100	0.455	2055	935	176.5	2.6
15.80	100	0.460	2015	925	181.5	2.6
16.00	100	0.465	1990	925	186.0	2.6

Material

Steel
1300 - 1500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
12.50	55	0.310	1400	435	53.5	5.4
13.00	55	0.320	1345	430	57.0	5.4
13.50	55	0.325	1325	430	59.0	5.4
14.00	55	0.330	1250	415	64.0	5.5
14.50	55	0.335	1205	405	67.0	6.1
15.00	55	0.345	1165	400	70.5	6.1
15.50	55	0.350	1130	395	74.5	6.1
15.80	55	0.355	1110	395	77.5	6.1
16.00	55	0.355	1095	390	78.5	6.2

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

12.50	70	0.310	1785	555	68.0	4.2
13.00	70	0.320	1715	550	73.0	4.2
13.50	70	0.325	1690	550	75.5	4.2
14.00	70	0.330	1590	525	81.0	4.4
14.50	70	0.335	1535	515	85.0	4.8
15.00	70	0.345	1485	510	90.0	4.8
15.50	70	0.350	1440	505	95.5	4.8
15.80	70	0.355	1410	500	98.0	4.8
16.00	70	0.355	1395	495	99.5	4.9

Titanium alloys
>300 HB
[Ti6Al4V]

12.50	40	0.310	1020	315	38.5	7.4
13.00	40	0.320	980	315	42.0	7.4
13.50	40	0.325	965	315	43.0	7.3
14.00	40	0.330	910	300	46.0	7.6
14.50	40	0.335	880	295	48.5	8.3
15.00	40	0.345	850	295	52.0	8.3
15.50	40	0.350	820	285	54.0	8.5
15.80	40	0.355	805	285	56.0	8.5
16.00	40	0.355	795	280	56.5	8.6

Cast iron
(lamellar / spheroidal)

12.50	240	0.605	6110	3695	453.5	0.6
13.00	240	0.630	5875	3700	491.0	0.6
13.50	240	0.640	5785	3700	506.5	0.6
14.00	240	0.650	5455	3545	545.5	0.6
14.50	240	0.660	5270	3480	574.5	0.7
15.00	240	0.675	5095	3440	608.0	0.7
15.50	240	0.690	4930	3400	641.5	0.7
15.80	240	0.700	4835	3385	663.5	0.7
16.00	240	0.705	4775	3365	676.5	0.7

