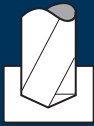


Application



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	0.135	19100	2580	18.0	0.5
3.30	180	0.145	17360	2515	21.5	0.5
3.50	180	0.155	16370	2535	24.5	0.5
3.80	180	0.170	15080	2565	29.0	0.6
4.00	180	0.185	14325	2650	33.5	0.6
4.20	180	0.200	13640	2730	38.0	0.6
4.50	180	0.230	12730	2930	46.5	0.5
4.80	180	0.245	11935	2925	53.0	0.7
5.00	180	0.255	11460	2920	57.5	0.7

Steel
500 - 850 N/mm²

3.00	160	0.115	16975	1950	14.0	0.6
3.30	160	0.125	15435	1930	16.5	0.6
3.50	160	0.135	14550	1965	19.0	0.6
3.80	160	0.145	13405	1945	22.0	0.8
4.00	160	0.160	12730	2035	25.5	0.8
4.20	160	0.170	12125	2060	28.5	0.8
4.50	160	0.195	11320	2205	35.0	0.7
4.80	160	0.210	10610	2230	40.5	0.9
5.00	160	0.215	10185	2190	43.0	1.0

Steel
850 - 1100 N/mm²

3.00	140	0.105	14855	1560	11.0	0.8
3.30	140	0.115	13505	1555	13.5	0.8
3.50	140	0.125	12730	1590	15.5	0.7
3.80	140	0.135	11725	1585	18.0	1.0
4.00	140	0.145	11140	1615	20.5	1.0
4.20	140	0.155	10610	1645	23.0	1.0
4.50	140	0.180	9905	1785	28.5	0.9
4.80	140	0.190	9285	1765	32.0	1.2
5.00	140	0.200	8915	1785	35.0	1.2

Steel
1100 - 1300 N/mm²

3.00	100	0.080	10610	850	6.0	1.4
3.30	100	0.090	9645	870	7.5	1.4
3.50	100	0.095	9095	865	8.5	1.4
3.80	100	0.100	8375	840	9.5	2.0
4.00	100	0.110	7960	875	11.0	1.8
4.20	100	0.120	7580	910	12.5	1.8
4.50	100	0.135	7075	955	15.0	1.7
4.80	100	0.145	6630	960	17.5	2.1
5.00	100	0.150	6365	955	19.0	2.2

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]
3.00	55	0.060	5835	350	2.5	3.5
3.30	55	0.070	5305	370	3.0	3.2
3.50	55	0.070	5000	350	3.5	3.4
3.80	55	0.080	4605	370	4.0	4.4
4.00	55	0.085	4375	370	4.5	4.4
4.20	55	0.090	4170	375	5.0	4.3
4.50	55	0.105	3890	410	6.5	3.9
4.80	55	0.110	3645	400	7.0	5.1
5.00	55	0.115	3500	405	8.0	5.1

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

3.00	70	0.060	7425	445	3.0	2.7
3.30	70	0.070	6750	475	4.0	2.5
3.50	70	0.070	6365	445	4.5	2.7
3.80	70	0.080	5865	470	5.5	3.5
4.00	70	0.085	5570	475	6.0	3.4
4.20	70	0.090	5305	475	6.5	3.4
4.50	70	0.105	4950	520	8.5	3.1
4.80	70	0.110	4640	510	9.0	4.0
5.00	70	0.115	4455	510	10.0	4.1

Titanium alloys
>300 HB
[Ti6Al4V]

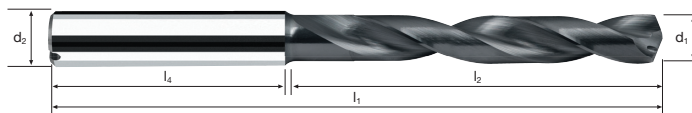
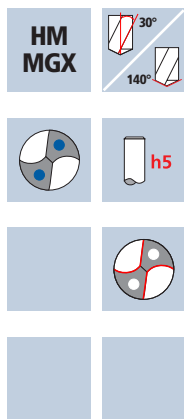
3.00	40	0.060	4245	255	2.0	4.8
3.30	40	0.070	3860	270	2.5	4.4
3.50	40	0.070	3640	255	2.5	4.6
3.80	40	0.080	3350	270	3.0	6.1
4.00	40	0.085	3185	270	3.5	6.0
4.20	40	0.090	3030	275	4.0	5.8
4.50	40	0.105	2830	295	4.5	5.4
4.80	40	0.110	2655	290	5.0	7.1
5.00	40	0.115	2545	295	6.0	7.1

Cast iron
(lamellar / spheroidal)

3.00	240	0.120	25465	3055	21.5	0.4
3.30	240	0.135	23150	3125	26.5	0.4
3.50	240	0.140	21825	3055	29.5	0.4
3.80	240	0.155	20105	3115	35.5	0.5
4.00	240	0.165	19100	3150	39.5	0.5
4.20	240	0.180	18190	3275	45.5	0.5
4.50	240	0.205	16975	3480	55.5	0.5
4.80	240	0.220	15915	3500	63.5	0.6
5.00	240	0.230	15280	3515	69.0	0.6

Spiral flute drills XDrill®

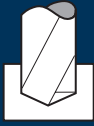
5xd



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	
							B72015		.0300		B72015	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}						
.0300	3.0	6	66	28	36	20.2						●
.0310	3.1	6	66	28	36	20.2						●
.0320	3.2	6	66	28	36	20.0						●
.0330	3.3	6	66	28	36	20.0						●
.0340	3.4	6	66	28	36	19.8						●
.0350	3.5	6	66	28	36	19.8						●
.0360	3.6	6	66	28	36	19.6						●
.0370	3.7	6	66	28	36	19.6						●
.0380	3.8	6	74	36	36	27.4						●
.0390	3.9	6	74	36	36	27.3						●
.0400	4.0	6	74	36	36	26.9						●
.0410	4.1	6	74	36	36	26.8						●
.0420	4.2	6	74	36	36	26.7						●
.0430	4.3	6	74	36	36	26.7						●
.0440	4.4	6	74	36	36	26.6						●
.0450	4.5	6	74	36	36	26.6						●
.0460	4.6	6	74	36	36	26.5						●
.0470	4.7	6	74	36	36	26.5						●
.0480	4.8	6	82	44	36	34.3						●
.0490	4.9	6	82	44	36	34.3						●
.0500	5.0	6	82	44	36	34.7						●
.0510	5.1	6	82	44	36	34.7						●
.0520	5.2	6	82	44	36	34.6						●

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	0.280	10415	2915	69.5	0.7
5.80	180	0.295	9880	2915	77.0	0.7
6.00	180	0.315	9550	3010	85.0	0.7
6.20	180	0.335	9240	3095	93.5	0.8
6.50	180	0.350	8815	3085	102.5	0.8
6.80	180	0.365	8425	3075	111.5	0.8
7.00	180	0.380	8185	3110	119.5	0.8
7.20	180	0.390	7960	3105	126.5	0.8
7.50	180	0.405	7640	3095	136.5	0.8

Steel
500 - 850 N/mm²

5.50	160	0.240	9260	2220	52.5	0.9
5.80	160	0.250	8780	2195	58.0	0.9
6.00	160	0.270	8490	2290	64.5	0.9
6.20	160	0.285	8215	2340	70.5	1.1
6.50	160	0.300	7835	2350	78.0	1.0
6.80	160	0.315	7490	2360	85.5	1.0
7.00	160	0.325	7275	2365	91.0	1.0
7.20	160	0.335	7075	2370	96.5	1.0
7.50	160	0.345	6790	2345	103.5	1.0

Steel
850 - 1100 N/mm²

5.50	140	0.220	8100	1780	42.5	1.2
5.80	140	0.230	7685	1770	47.0	1.2
6.00	140	0.250	7425	1855	52.5	1.1
6.20	140	0.265	7190	1905	57.5	1.3
6.50	140	0.275	6855	1885	62.5	1.3
6.80	140	0.290	6555	1900	69.0	1.3
7.00	140	0.300	6365	1910	73.5	1.3
7.20	140	0.305	6190	1890	77.0	1.3
7.50	140	0.320	5940	1900	84.0	1.3

Steel
1100 - 1300 N/mm²

5.50	100	0.165	5785	955	22.5	2.2
5.80	100	0.175	5490	960	25.5	2.1
6.00	100	0.190	5305	1010	28.5	2.0
6.20	100	0.200	5135	1025	31.0	2.4
6.50	100	0.210	4895	1030	34.0	2.4
6.80	100	0.220	4680	1030	37.5	2.4
7.00	100	0.225	4545	1025	39.5	2.4
7.20	100	0.235	4420	1040	42.5	2.3
7.50	100	0.245	4245	1040	46.0	2.3

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	0.130	3185	415	10.0	5.0
5.80	55	0.135	3020	410	11.0	5.0
6.00	55	0.145	2920	425	12.0	4.8
6.20	55	0.155	2825	440	13.5	5.6
6.50	55	0.160	2695	430	14.5	5.7
6.80	55	0.170	2575	440	16.0	5.6
7.00	55	0.175	2500	440	17.0	5.6
7.20	55	0.180	2430	435	17.5	5.6
7.50	55	0.185	2335	430	19.0	5.6

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

5.50	70	0.130	4050	525	12.5	3.9
5.80	70	0.135	3840	520	13.5	4.0
6.00	70	0.145	3715	540	15.5	3.8
6.20	70	0.155	3595	555	17.0	4.5
6.50	70	0.160	3430	550	18.5	4.5
6.80	70	0.170	3275	555	20.0	4.4
7.00	70	0.175	3185	555	21.5	4.4
7.20	70	0.180	3095	555	22.5	4.4
7.50	70	0.185	2970	550	24.5	4.4

Titanium alloys
>300 HB
[Ti6Al4V]

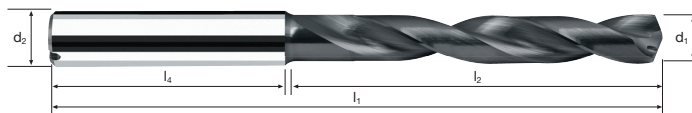
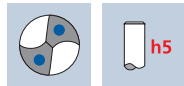
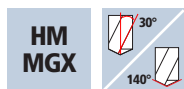
5.50	40	0.130	2315	300	7.0	6.9
5.80	40	0.135	2195	295	8.0	7.0
6.00	40	0.145	2120	305	8.5	6.7
6.20	40	0.155	2055	320	9.5	7.7
6.50	40	0.160	1960	315	10.5	7.8
6.80	40	0.170	1870	320	11.5	7.7
7.00	40	0.175	1820	320	12.5	7.6
7.20	40	0.180	1770	320	13.0	7.6
7.50	40	0.185	1700	315	14.0	7.7

Cast iron
(lamellar / spheroidal)

5.50	240	0.255	13890	3540	84.0	0.6
5.80	240	0.265	13170	3490	92.0	0.6
6.00	240	0.285	12730	3630	102.5	0.6
6.20	240	0.305	12320	3760	113.5	0.7
6.50	240	0.320	11755	3760	125.0	0.7
6.80	240	0.335	11235	3765	136.5	0.7
7.00	240	0.345	10915	3765	145.0	0.6
7.20	240	0.355	10610	3765	153.5	0.6
7.50	240	0.370	10185	3770	166.5	0.6

Spiral flute drills XDrill®

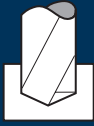
5xd



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	
							B72015		.0530		B72015	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}						
.0530	5.3	6	82	44	36	34.6						●
.0540	5.4	6	82	44	36	34.5						●
.0550	5.5	6	82	44	36	34.4						●
.0560	5.6	6	82	44	36	34.3						●
.0570	5.7	6	82	44	36	34.4						●
.0580	5.8	6	82	44	36	34.3						●
.0590	5.9	6	82	44	36	34.3						●
.0600	6.0	6	82	44	36	34.3						●
.0610	6.1	8	91	53	36	41.3						●
.0620	6.2	8	91	53	36	41.2						●
.0630	6.3	8	91	53	36	41.2						●
.0640	6.4	8	91	53	36	41.1						●
.0650	6.5	8	91	53	36	41.0						●
.0660	6.6	8	91	53	36	40.9						●
.0670	6.7	8	91	53	36	40.9						●
.0680	6.8	8	91	53	36	40.8						●
.0690	6.9	8	91	53	36	40.8						●
.0700	7.0	8	91	53	36	40.7						●
.0710	7.1	8	91	53	36	40.7						●
.0720	7.2	8	91	53	36	40.6						●
.0730	7.3	8	91	53	36	40.5						●
.0740	7.4	8	91	53	36	40.4						●
.0750	7.5	8	91	53	36	40.4						●

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	0.410	7540	3090	140.0	0.8
8.00	180	0.430	7160	3080	155.0	0.8
8.20	180	0.445	6985	3110	164.0	0.9
8.50	180	0.460	6740	3100	176.0	0.9
8.80	180	0.475	6510	3090	188.0	0.9
9.00	180	0.485	6365	3085	196.5	0.9
9.20	180	0.495	6230	3085	205.0	0.9
9.50	180	0.515	6030	3105	220.0	0.9
9.80	180	0.530	5845	3100	234.0	0.9

Steel
500 - 850 N/mm²

7.60	160	0.350	6700	2345	106.5	1.0
8.00	160	0.370	6365	2355	118.5	1.0
8.20	160	0.380	6210	2360	124.5	1.2
8.50	160	0.395	5990	2365	134.0	1.2
8.80	160	0.405	5785	2345	142.5	1.2
9.00	160	0.415	5660	2350	149.5	1.2
9.20	160	0.425	5535	2350	156.0	1.2
9.50	160	0.440	5360	2360	167.5	1.2
9.80	160	0.455	5195	2365	178.5	1.1

Steel
850 - 1100 N/mm²

7.60	140	0.325	5865	1905	86.5	1.3
8.00	140	0.340	5570	1895	95.5	1.3
8.20	140	0.350	5435	1900	100.5	1.5
8.50	140	0.360	5245	1890	107.0	1.5
8.80	140	0.375	5065	1900	115.5	1.4
9.00	140	0.385	4950	1905	121.0	1.4
9.20	140	0.390	4845	1890	125.5	1.4
9.50	140	0.405	4690	1900	134.5	1.4
9.80	140	0.420	4545	1910	144.0	1.4

Steel
1100 - 1300 N/mm²

7.60	100	0.245	4190	1025	46.5	2.4
8.00	100	0.260	3980	1035	52.0	2.3
8.20	100	0.265	3880	1030	54.5	2.7
8.50	100	0.275	3745	1030	58.5	2.7
8.80	100	0.285	3615	1030	62.5	2.7
9.00	100	0.290	3535	1025	65.0	2.7
9.20	100	0.300	3460	1040	69.0	2.6
9.50	100	0.310	3350	1040	73.5	2.6
9.80	100	0.320	3250	1040	78.5	2.6

Material

Steel
1300 - 1500 N/mm²

7.60	55	0.190	2305	440	20.0	5.5
8.00	55	0.200	2190	440	22.0	5.5
8.20	55	0.205	2135	440	23.0	6.3
8.50	55	0.210	2060	435	24.5	6.3
8.80	55	0.220	1990	440	27.0	6.2
9.00	55	0.225	1945	440	28.0	6.2
9.20	55	0.230	1905	440	29.0	6.2
9.50	55	0.235	1845	435	31.0	6.3
9.80	55	0.245	1785	435	33.0	6.2

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

7.60	70	0.190	2930	555	25.0	4.4
8.00	70	0.200	2785	555	28.0	4.4
8.20	70	0.205	2715	555	29.5	5.0
8.50	70	0.210	2620	550	31.0	5.0
8.80	70	0.220	2530	555	34.0	5.0
9.00	70	0.225	2475	555	35.5	4.9
9.20	70	0.230	2420	555	37.0	4.9
9.50	70	0.235	2345	550	39.0	4.9
9.80	70	0.245	2275	555	42.0	4.9

Titanium alloys
>300 HB
[Ti6Al4V]

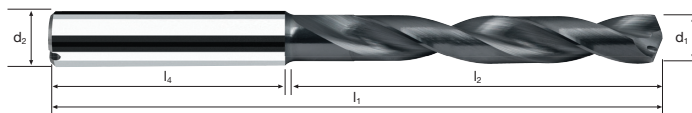
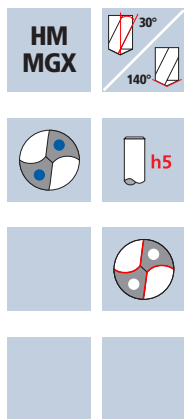
7.60	40	0.190	1675	320	14.5	7.6
8.00	40	0.200	1590	320	16.0	7.6
8.20	40	0.205	1555	320	17.0	8.7
8.50	40	0.210	1500	315	18.0	8.8
8.80	40	0.220	1445	320	19.5	8.6
9.00	40	0.225	1415	320	20.5	8.6
9.20	40	0.230	1385	320	21.5	8.5
9.50	40	0.235	1340	315	22.5	8.6
9.80	40	0.245	1300	320	24.0	8.5

Cast iron
(lamellar / spheroidal)

7.60	240	0.375	10050	3770	171.0	0.6
8.00	240	0.395	9550	3770	189.5	0.6
8.20	240	0.405	9315	3775	199.5	0.7
8.50	240	0.415	8990	3730	211.5	0.7
8.80	240	0.430	8680	3730	227.0	0.7
9.00	240	0.440	8490	3735	237.5	0.7
9.20	240	0.450	8305	3735	248.5	0.7
9.50	240	0.465	8040	3740	265.0	0.7
9.80	240	0.480	7795	3740	282.0	0.7

Spiral flute drills XDrill®

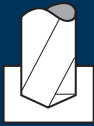
5xd



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	
							B72015		.0760		B72015	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}						
.0760	7.6	8	91	53	36	40.3						
.0770	7.7	8	91	53	36	40.3						
.0780	7.8	8	91	53	36	40.3						
.0790	7.9	8	91	53	36	40.3						
.0800	8.0	8	91	53	36	40.3						
.0810	8.1	10	103	61	40	46.3						
.0820	8.2	10	103	61	40	46.2						
.0830	8.3	10	103	61	40	46.2						
.0840	8.4	10	103	61	40	46.0						
.0850	8.5	10	103	61	40	46.0						
.0860	8.6	10	103	61	40	45.9						
.0870	8.7	10	103	61	40	45.9						
.0880	8.8	10	103	61	40	45.8						
.0890	8.9	10	103	61	40	45.8						
.0900	9.0	10	103	61	40	45.7						
.0910	9.1	10	103	61	40	45.6						
.0920	9.2	10	103	61	40	45.5						
.0930	9.3	10	103	61	40	45.5						
.0940	9.4	10	103	61	40	45.4						
.0950	9.5	10	103	61	40	45.4						
.0960	9.6	10	103	61	40	45.3						
.0970	9.7	10	103	61	40	45.3						
.0980	9.8	10	103	61	40	45.2						

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	0.540	5730	3095	243.0	0.9
10.20	180	0.545	5615	3060	250.0	1.0
10.50	180	0.565	5455	3080	266.5	1.0
10.80	180	0.575	5305	3050	279.5	1.0
11.00	180	0.585	5210	3050	290.0	1.0
11.20	180	0.585	5115	2990	294.5	1.1
11.50	180	0.590	4980	2940	305.5	1.1
11.80	180	0.600	4855	2915	319.0	1.1
12.00	180	0.610	4775	2915	329.5	1.1

Steel
500 - 850 N/mm²

10.00	160	0.465	5095	2370	186.0	1.1
10.20	160	0.470	4995	2350	192.0	1.4
10.50	160	0.485	4850	2350	203.5	1.4
10.80	160	0.495	4715	2335	214.0	1.4
11.00	160	0.500	4630	2315	220.0	1.4
11.20	160	0.500	4545	2275	224.0	1.4
11.50	160	0.505	4430	2235	232.0	1.4
11.80	160	0.510	4315	2200	240.5	1.4
12.00	160	0.520	4245	2205	249.5	1.4

Steel
850 - 1100 N/mm²

10.00	140	0.425	4455	1895	149.0	1.4
10.20	140	0.430	4370	1880	153.5	1.7
10.50	140	0.445	4245	1890	163.5	1.7
10.80	140	0.455	4125	1875	172.0	1.7
11.00	140	0.460	4050	1865	177.0	1.7
11.20	140	0.465	3980	1850	182.5	1.7
11.50	140	0.465	3875	1800	187.0	1.7
11.80	140	0.470	3775	1775	194.0	1.8
12.00	140	0.480	3715	1785	202.0	1.8

Steel
1100 - 1300 N/mm²

10.00	100	0.325	3185	1035	81.5	2.6
10.20	100	0.330	3120	1030	84.0	3.1
10.50	100	0.340	3030	1030	89.0	3.1
10.80	100	0.345	2945	1015	93.0	3.1
11.00	100	0.350	2895	1015	96.5	3.1
11.20	100	0.350	2840	995	98.0	3.2
11.50	100	0.355	2770	985	102.5	3.2
11.80	100	0.360	2700	970	106.0	3.2
12.00	100	0.365	2655	970	109.5	3.2

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	0.250	1750	440	34.5	6.2
10.20	55	0.255	1715	435	35.5	7.3
10.50	55	0.260	1665	435	37.5	7.3
10.80	55	0.265	1620	430	39.5	7.4
11.00	55	0.270	1590	430	41.0	7.3
11.20	55	0.270	1565	425	42.0	7.4
11.50	55	0.270	1520	410	42.5	7.7
11.80	55	0.275	1485	410	45.0	7.6
12.00	55	0.280	1460	410	46.5	7.6

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

10.00	70	0.250	2230	560	44.0	4.8
10.20	70	0.255	2185	555	45.5	5.7
10.50	70	0.260	2120	550	47.5	5.8
10.80	70	0.265	2065	545	50.0	5.8
11.00	70	0.270	2025	545	52.0	5.8
11.20	70	0.270	1990	535	52.5	5.9
11.50	70	0.270	1940	525	54.5	6.0
11.80	70	0.275	1890	520	57.0	6.0
12.00	70	0.280	1855	520	59.0	6.0

Titanium alloys
>300 HB
[Ti6Al4V]

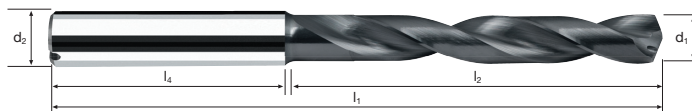
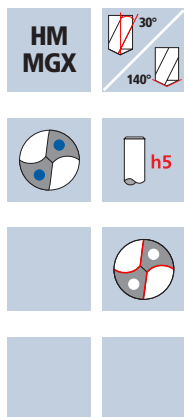
10.00	40	0.250	1275	320	25.0	8.5
10.20	40	0.255	1250	320	26.0	10.0
10.50	40	0.260	1215	315	27.5	10.1
10.80	40	0.265	1180	315	29.0	10.1
11.00	40	0.270	1155	310	29.5	10.2
11.20	40	0.270	1135	305	30.0	10.3
11.50	40	0.270	1105	300	31.0	10.5
11.80	40	0.275	1080	295	32.5	10.6
12.00	40	0.280	1060	295	33.5	10.6

Cast iron
(lamellar / spheroidal)

10.00	240	0.490	7640	3745	294.0	0.7
10.20	240	0.500	7490	3745	306.0	0.9
10.50	240	0.510	7275	3710	321.0	0.9
10.80	240	0.525	7075	3715	340.5	0.9
11.00	240	0.530	6945	3680	349.5	0.9
11.20	240	0.535	6820	3650	359.5	0.9
11.50	240	0.535	6645	3555	369.5	0.9
11.80	240	0.545	6475	3530	386.0	0.9
12.00	240	0.555	6365	3535	400.0	0.9

Spiral flute drills XDrill®

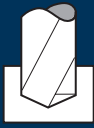
5xd



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	
		B72015		.0990				B72015	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}			
.0990	9.9	10	103	61	40	45.3			●
.1000	10.0	10	103	61	40	45.2			●
.1010	10.1	12	118	71	45	53.2			●
.1020	10.2	12	118	71	45	53.1			●
.1030	10.3	12	118	71	45	53.1			●
.1040	10.4	12	118	71	45	53.0			●
.1050	10.5	12	118	71	45	53.0			●
.1060	10.6	12	118	71	45	52.9			●
.1070	10.7	12	118	71	45	52.9			●
.1080	10.8	12	118	71	45	52.8			●
.1090	10.9	12	118	71	45	52.7			●
.1100	11.0	12	118	71	45	52.6			●
.1110	11.1	12	118	71	45	52.6			●
.1120	11.2	12	118	71	45	52.5			●
.1130	11.3	12	118	71	45	52.5			●
.1140	11.4	12	118	71	45	52.4			●
.1150	11.5	12	118	71	45	52.4			●
.1160	11.6	12	118	71	45	52.3			●
.1170	11.7	12	118	71	45	52.3			●
.1180	11.8	12	118	71	45	52.2			●
.1190	11.9	12	118	71	45	52.2			●
.1200	12.0	12	118	71	45	52.2			●

Application



Material

Steel < 500 N/mm ²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
12.20	180	0.620	4695	2910	340.0	1.2
12.50	180	0.635	4585	2910	357.0	1.2
12.60	180	0.640	4545	2910	363.0	1.2
12.80	180	0.650	4475	2910	374.5	1.1
13.00	180	0.660	4405	2905	385.5	1.1
13.20	180	0.670	4340	2910	398.0	1.1
13.50	180	0.675	4245	2865	410.0	1.2
13.80	180	0.675	4150	2800	419.0	1.2
14.00	180	0.680	4095	2785	428.5	1.2

Steel 500 - 850 N/mm ²

12.20	160	0.530	4175	2215	259.0	1.5
12.50	160	0.545	4075	2220	272.5	1.5
12.60	160	0.545	4040	2200	274.5	1.5
12.80	160	0.555	3980	2210	284.5	1.5
13.00	160	0.565	3920	2215	294.0	1.5
13.20	160	0.575	3860	2220	304.0	1.5
13.50	160	0.580	3775	2190	313.5	1.5
13.80	160	0.580	3690	2140	320.0	1.5
14.00	160	0.585	3640	2130	328.0	1.6

Steel 850 - 1100 N/mm ²

12.20	140	0.490	3655	1790	209.0	1.9
12.50	140	0.500	3565	1785	219.0	1.9
12.60	140	0.505	3535	1785	222.5	1.9
12.80	140	0.510	3480	1775	228.5	1.9
13.00	140	0.520	3430	1785	237.0	1.9
13.20	140	0.530	3375	1790	245.0	1.9
13.50	140	0.535	3300	1765	252.5	1.9
13.80	140	0.535	3230	1730	259.0	1.9
14.00	140	0.540	3185	1720	265.0	1.9

Steel 1100 - 1300 N/mm ²
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12.20	100	0.370	2610	965	113.0	3.5
12.50	100	0.380	2545	965	118.5	3.5
12.60	100	0.385	2525	970	121.0	3.5
12.80	100	0.390	2485	970	125.0	3.4
13.00	100	0.395	2450	970	129.0	3.4
13.20	100	0.400	2410	965	132.0	3.5
13.50	100	0.405	2360	955	136.5	3.5
13.80	100	0.405	2305	935	140.0	3.5
14.00	100	0.410	2275	935	144.0	3.5

Material

Steel 1300 - 1500 N/mm ²
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d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
12.20	55	0.285	1435	410	48.0	8.2
12.50	55	0.290	1400	405	49.5	8.3
12.60	55	0.295	1390	410	51.0	8.2
12.80	55	0.300	1370	410	53.0	8.2
13.00	55	0.305	1345	410	54.5	8.1
13.20	55	0.310	1325	410	56.0	8.1
13.50	55	0.310	1295	400	57.5	8.3
13.80	55	0.310	1270	395	59.0	8.4
14.00	55	0.315	1250	395	61.0	8.4

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

12.20	70	0.285	1825	520	61.0	6.5
12.50	70	0.290	1785	520	64.0	6.5
12.60	70	0.295	1770	520	65.0	6.5
12.80	70	0.300	1740	520	67.0	6.4
13.00	70	0.305	1715	525	69.5	6.4
13.20	70	0.310	1690	525	72.0	6.3
13.50	70	0.310	1650	510	73.0	6.5
13.80	70	0.310	1615	500	75.0	6.6
14.00	70	0.315	1590	500	77.0	6.6

Titanium alloys >300 HB [Ti6Al4V]

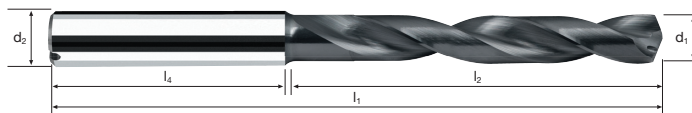
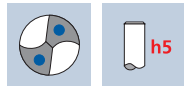
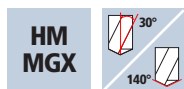
12.20	40	0.285	1045	300	35.0	11.2
12.50	40	0.290	1020	295	36.0	11.4
12.60	40	0.295	1010	300	37.5	11.2
12.80	40	0.300	995	300	38.5	11.1
13.00	40	0.305	980	300	40.0	11.1
13.20	40	0.310	965	300	41.0	11.1
13.50	40	0.310	945	295	42.0	11.2
13.80	40	0.310	925	285	42.5	11.6
14.00	40	0.315	910	285	44.0	11.6

Cast iron (lamellar / spheroidal)

12.20	240	0.560	6260	3505	409.5	1.0
12.50	240	0.575	6110	3515	431.5	1.0
12.60	240	0.580	6065	3520	439.0	1.0
12.80	240	0.590	5970	3520	453.0	0.9
13.00	240	0.600	5875	3525	468.0	0.9
13.20	240	0.610	5785	3530	483.0	0.9
13.50	240	0.615	5660	3480	498.0	1.0
13.80	240	0.615	5535	3405	509.5	1.0
14.00	240	0.620	5455	3380	520.5	1.0

Spiral flute drills XDrill®

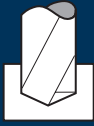
5xd



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	
		B72015		.1210				B72015	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}			
.1210	12.1	14	124	77	45	56.2			●
.1220	12.2	14	124	77	45	56.1			●
.1230	12.3	14	124	77	45	56.1			●
.1240	12.4	14	124	77	45	56.0			●
.1250	12.5	14	124	77	45	56.0			●
.1260	12.6	14	124	77	45	55.9			●
.1270	12.7	14	124	77	45	55.8			●
.1280	12.8	14	124	77	45	55.7			●
.1290	12.9	14	124	77	45	55.7			●
.1300	13.0	14	124	77	45	55.6			●
.1310	13.1	14	124	77	45	55.6			●
.1320	13.2	14	124	77	45	55.5			●
.1330	13.3	14	124	77	45	55.5			●
.1340	13.4	14	124	77	45	55.4			●
.1350	13.5	14	124	77	45	55.3			●
.1360	13.6	14	124	77	45	55.2			●
.1370	13.7	14	124	77	45	55.2			●
.1380	13.8	14	124	77	45	55.1			●
.1390	13.9	14	124	77	45	55.2			●
.1400	14.0	14	124	77	45	55.1			●

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]
14.20	180	0.685	4035	2765	438.0	1.3
14.50	180	0.690	3950	2725	450.0	1.3
14.80	180	0.700	3870	2710	466.0	1.3
15.00	180	0.710	3820	2710	479.0	1.3
15.20	180	0.720	3770	2715	492.5	1.3
15.50	180	0.725	3695	2680	505.5	1.3
15.70	180	0.725	3650	2645	512.0	1.3
15.80	180	0.730	3625	2645	518.5	1.3
16.00	180	0.735	3580	2630	529.0	1.3

Steel
500 - 850 N/mm²

14.20	160	0.590	3585	2115	335.0	1.7
14.50	160	0.590	3510	2070	342.0	1.7
14.80	160	0.600	3440	2065	355.0	1.7
15.00	160	0.610	3395	2070	366.0	1.7
15.20	160	0.615	3350	2060	374.0	1.7
15.50	160	0.620	3285	2035	384.0	1.7
15.70	160	0.625	3245	2030	393.0	1.7
15.80	160	0.625	3225	2015	395.0	1.7
16.00	160	0.630	3185	2005	403.0	1.7

Steel
850 - 1100 N/mm²

14.20	140	0.540	3140	1695	268.5	2.1
14.50	140	0.545	3075	1675	276.5	2.1
14.80	140	0.555	3010	1670	287.5	2.1
15.00	140	0.560	2970	1665	294.0	2.1
15.20	140	0.570	2930	1670	303.0	2.1
15.50	140	0.570	2875	1640	309.5	2.1
15.70	140	0.575	2840	1635	316.5	2.1
15.80	140	0.580	2820	1635	320.5	2.1
16.00	140	0.580	2785	1615	324.5	2.2

Steel
1100 - 1300 N/mm²

14.20	100	0.410	2240	920	145.5	3.9
14.50	100	0.415	2195	910	150.5	3.9
14.80	100	0.420	2150	905	155.5	3.9
15.00	100	0.425	2120	900	159.0	3.9
15.20	100	0.430	2095	900	163.5	3.9
15.50	100	0.435	2055	895	169.0	3.9
15.70	100	0.435	2025	880	170.5	4.0
15.80	100	0.440	2015	885	173.5	3.9
16.00	100	0.440	1990	875	176.0	4.0

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]
14.20	55	0.315	1235	390	62.0	9.1
14.50	55	0.320	1205	385	63.5	9.2
14.80	55	0.325	1185	385	66.0	9.1
15.00	55	0.330	1165	385	68.0	9.1
15.20	55	0.330	1150	380	69.0	9.2
15.50	55	0.335	1130	380	71.5	9.2
15.70	55	0.335	1115	375	72.5	9.3
15.80	55	0.340	1110	375	73.5	9.3
16.00	55	0.340	1095	370	74.5	9.4

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

14.20	70	0.315	1570	495	78.5	7.2
14.50	70	0.320	1535	490	81.0	7.2
14.80	70	0.325	1505	490	84.5	7.2
15.00	70	0.330	1485	490	86.5	7.2
15.20	70	0.330	1465	485	88.0	7.2
15.50	70	0.335	1440	480	90.5	7.3
15.70	70	0.335	1420	475	92.0	7.3
15.80	70	0.340	1410	480	94.0	7.3
16.00	70	0.340	1395	475	95.5	7.3

Titanium alloys
>300 HB
[Ti6Al4V]

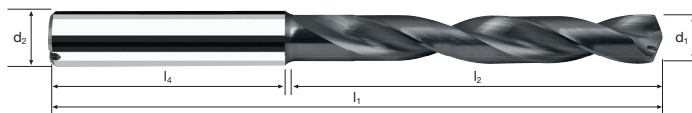
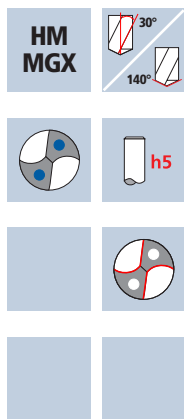
14.20	40	0.315	895	280	44.5	12.7
14.50	40	0.320	880	280	46.0	12.6
14.80	40	0.325	860	280	48.0	12.6
15.00	40	0.330	850	280	49.5	12.6
15.20	40	0.330	840	275	50.0	12.8
15.50	40	0.335	820	275	52.0	12.7
15.70	40	0.335	810	270	52.5	12.9
15.80	40	0.340	805	275	54.0	12.7
16.00	40	0.340	795	270	54.5	12.9

Cast iron
(lamellar / spheroidal)

14.20	240	0.625	5380	3365	533.0	1.1
14.50	240	0.630	5270	3320	548.0	1.1
14.80	240	0.635	5160	3275	563.5	1.1
15.00	240	0.645	5095	3285	580.5	1.1
15.20	240	0.655	5025	3290	597.0	1.1
15.50	240	0.660	4930	3255	614.0	1.1
15.70	240	0.660	4865	3210	621.5	1.1
15.80	240	0.665	4835	3215	630.5	1.1
16.00	240	0.670	4775	3200	643.5	1.1

Spiral flute drills XDrill®

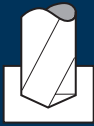
5xd



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	
							B72015	.1410	B72015	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}				
.1410	14.1	16	133	83	48	59.2			●	
.1420	14.2	16	133	83	48	59.1			●	
.1430	14.3	16	133	83	48	59.1			●	
.1440	14.4	16	133	83	48	59.0			●	
.1450	14.5	16	133	83	48	59.0			●	
.1460	14.6	16	133	83	48	58.8			●	
.1470	14.7	16	133	83	48	58.8			●	
.1480	14.8	16	133	83	48	58.7			●	
.1490	14.9	16	133	83	48	58.7			●	
.1500	15.0	16	133	83	48	58.6			●	
.1510	15.1	16	133	83	48	58.6			●	
.1520	15.2	16	133	83	48	58.5			●	
.1530	15.3	16	133	83	48	58.5			●	
.1540	15.4	16	133	83	48	58.3			●	
.1550	15.5	16	133	83	48	58.3			●	
.1560	15.6	16	133	83	48	58.2			●	
.1570	15.7	16	133	83	48	58.2			●	
.1580	15.8	16	133	83	48	58.1			●	
.1590	15.9	16	133	83	48	58.1			●	
.1600	16.0	16	133	83	48	58.1			●	

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]
16.20	180	0.740	3535	2615	539.0	1.5
16.40	180	0.750	3495	2620	553.5	1.5
16.50	180	0.755	3470	2620	560.0	1.5
16.80	180	0.755	3410	2575	571.0	1.5
17.00	180	0.760	3370	2560	581.0	1.5
17.20	180	0.765	3330	2545	591.5	1.5
17.50	180	0.770	3275	2520	606.0	1.6
17.70	180	0.775	3235	2505	616.5	1.6
18.00	180	0.780	3185	2485	632.5	1.6

Steel
500 - 850 N/mm²

16.20	160	0.635	3145	1995	411.0	2.0
16.40	160	0.640	3105	1985	419.5	2.0
16.50	160	0.645	3085	1990	425.5	2.0
16.80	160	0.650	3030	1970	436.5	2.0
17.00	160	0.650	2995	1945	441.5	2.0
17.20	160	0.655	2960	1940	451.0	2.0
17.50	160	0.660	2910	1920	462.0	2.0
17.70	160	0.660	2875	1900	467.5	2.1
18.00	160	0.670	2830	1895	482.0	2.1

Steel
850 - 1100 N/mm²

16.20	140	0.585	2750	1610	332.0	2.5
16.40	140	0.590	2715	1600	338.0	2.5
16.50	140	0.595	2700	1605	343.0	2.5
16.80	140	0.595	2655	1580	350.0	2.5
17.00	140	0.600	2620	1570	356.5	2.5
17.20	140	0.600	2590	1555	361.5	2.5
17.50	140	0.610	2545	1550	373.0	2.5
17.70	140	0.610	2520	1535	377.5	2.5
18.00	140	0.615	2475	1520	387.0	2.6

Steel
1100 - 1300 N/mm²

16.20	100	0.445	1965	875	180.5	4.5
16.40	100	0.450	1940	875	185.0	4.5
16.50	100	0.450	1930	870	186.0	4.5
16.80	100	0.455	1895	860	190.5	4.6
17.00	100	0.455	1870	850	193.0	4.6
17.20	100	0.460	1850	850	197.5	4.6
17.50	100	0.460	1820	835	201.0	4.7
17.70	100	0.465	1800	835	205.5	4.7
18.00	100	0.470	1770	830	211.0	4.7

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]
16.20	55	0.340	1080	365	75.0	10.9
16.40	55	0.345	1070	370	78.0	10.7
16.50	55	0.350	1060	370	79.0	10.7
16.80	55	0.350	1040	365	81.0	10.8
17.00	55	0.350	1030	360	81.5	10.9
17.20	55	0.350	1020	355	82.5	11.1
17.50	55	0.355	1000	355	85.5	11.0
17.70	55	0.355	990	350	86.0	11.2
18.00	55	0.360	975	350	89.0	11.1

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

16.20	70	0.340	1375	470	97.0	8.4
16.40	70	0.345	1360	470	99.5	8.4
16.50	70	0.350	1350	475	101.5	8.3
16.80	70	0.350	1325	465	103.0	8.5
17.00	70	0.350	1310	460	104.5	8.6
17.20	70	0.350	1295	455	105.5	8.6
17.50	70	0.355	1275	455	109.5	8.6
17.70	70	0.355	1260	445	109.5	8.8
18.00	70	0.360	1240	445	113.0	8.8

Titanium alloys
>300 HB
[Ti6Al4V]

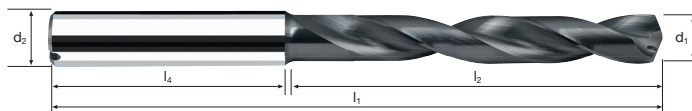
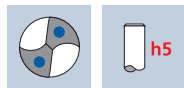
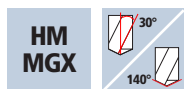
16.20	40	0.340	785	265	54.5	15.0
16.40	40	0.345	775	265	56.0	14.9
16.50	40	0.350	770	270	57.5	14.6
16.80	40	0.350	760	265	58.5	14.9
17.00	40	0.350	750	265	60.0	14.9
17.20	40	0.350	740	260	60.5	15.1
17.50	40	0.355	730	260	62.5	15.1
17.70	40	0.355	720	255	62.5	15.3
18.00	40	0.360	705	255	65.0	15.3

Cast iron
(lamellar / spheroidal)

16.20	240	0.675	4715	3185	656.5	1.2
16.40	240	0.680	4660	3170	669.5	1.2
16.50	240	0.685	4630	3170	678.0	1.2
16.80	240	0.685	4545	3115	690.5	1.3
17.00	240	0.690	4495	3100	703.5	1.3
17.20	240	0.695	4440	3085	717.0	1.3
17.50	240	0.700	4365	3055	735.0	1.3
17.70	240	0.705	4315	3040	748.0	1.3
18.00	240	0.710	4245	3015	767.0	1.3

Spiral flute drills XDrill®

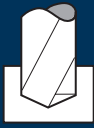
5xd



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	
		B72015		.1610				B72015	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}			
.1610	16.1	18	143	93	48	66.2			●
.1620	16.2	18	143	93	48	66.1			●
.1630	16.3	18	143	93	48	66.1			●
.1640	16.4	18	143	93	48	65.9			●
.1650	16.5	18	143	93	48	65.9			●
.1660	16.6	18	143	93	48	65.8			●
.1670	16.7	18	143	93	48	65.8			●
.1680	16.8	18	143	93	48	65.7			●
.1690	16.9	18	143	93	48	65.7			●
.1700	17.0	18	143	93	48	65.6			●
.1710	17.1	18	143	93	48	65.5			●
.1720	17.2	18	143	93	48	65.4			●
.1730	17.3	18	143	93	48	65.4			●
.1740	17.4	18	143	93	48	65.3			●
.1750	17.5	18	143	93	48	65.3			●
.1760	17.6	18	143	93	48	65.2			●
.1770	17.7	18	143	93	48	65.2			●
.1780	17.8	18	143	93	48	65.1			●
.1790	17.9	18	143	93	48	65.1			●
.1800	18.0	18	143	93	48	65.0			●

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]
18.50	180	0.785	3095	2430	653.0	1.7
18.70	180	0.785	3065	2405	660.5	1.8
19.00	180	0.790	3015	2380	675.0	1.8
19.20	180	0.795	2985	2375	687.5	1.8
19.30	180	0.800	2970	2375	695.0	1.8
19.50	180	0.805	2940	2365	706.5	1.8
19.70	180	0.810	2910	2355	718.0	1.8
19.80	180	0.810	2895	2345	722.0	1.8
20.00	180	0.820	2865	2350	738.5	1.8

Steel
500 - 850 N/mm²

18.50	160	0.670	2755	1845	496.0	2.3
18.70	160	0.675	2725	1840	505.5	2.3
19.00	160	0.680	2680	1820	516.0	2.3
19.20	160	0.680	2655	1805	522.5	2.3
19.30	160	0.685	2640	1810	529.5	2.3
19.50	160	0.690	2610	1800	537.5	2.3
19.70	160	0.690	2585	1785	544.0	2.4
19.80	160	0.695	2570	1785	549.5	2.4
20.00	160	0.705	2545	1795	564.0	2.3

Steel
850 - 1100 N/mm²

18.50	140	0.620	2410	1495	402.0	2.8
18.70	140	0.620	2385	1480	406.5	2.9
19.00	140	0.625	2345	1465	415.5	2.9
19.20	140	0.625	2320	1450	420.0	2.9
19.30	140	0.630	2310	1455	425.5	2.9
19.50	140	0.635	2285	1450	433.0	2.9
19.70	140	0.640	2260	1445	440.5	2.9
19.80	140	0.640	2250	1440	443.5	2.9
20.00	140	0.645	2230	1440	452.5	2.9

Steel
1100 - 1300 N/mm²

18.50	100	0.470	1720	810	217.5	5.2
18.70	100	0.470	1700	800	219.5	5.3
19.00	100	0.475	1675	795	225.5	5.3
19.20	100	0.475	1660	790	228.5	5.3
19.30	100	0.480	1650	790	231.0	5.3
19.50	100	0.485	1630	790	236.0	5.3
19.70	100	0.485	1615	785	239.5	5.4
19.80	100	0.485	1610	780	240.0	5.4
20.00	100	0.490	1590	780	245.0	5.4

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]
18.50	55	0.360	945	340	91.5	12.5
18.70	55	0.360	935	335	92.0	12.7
19.00	55	0.365	920	335	95.0	12.6
19.20	55	0.365	910	330	95.5	12.8
19.30	55	0.370	905	335	98.0	12.6
19.50	55	0.370	900	335	100.0	12.6
19.70	55	0.375	890	335	102.0	12.6
19.80	55	0.375	885	330	101.5	12.7
20.00	55	0.380	875	335	105.0	12.5

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

18.50	70	0.360	1205	435	117.0	9.8
18.70	70	0.360	1190	430	118.0	9.9
19.00	70	0.365	1175	430	122.0	9.8
19.20	70	0.365	1160	425	123.0	9.9
19.30	70	0.370	1155	425	124.5	9.9
19.50	70	0.370	1145	425	127.0	9.9
19.70	70	0.375	1130	425	129.5	9.9
19.80	70	0.375	1125	420	129.5	10.0
20.00	70	0.380	1115	425	133.5	9.9

Titanium alloys
>300 HB
[Ti6Al4V]

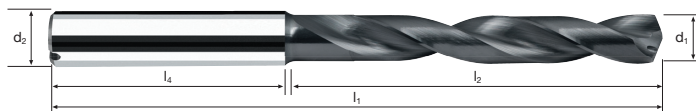
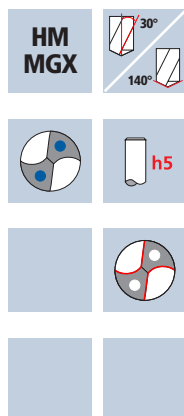
18.50	40	0.360	690	250	67.0	17.0
18.70	40	0.360	680	245	67.5	17.3
19.00	40	0.365	670	245	69.5	17.3
19.20	40	0.365	665	245	71.0	17.2
19.30	40	0.370	660	245	71.5	17.2
19.50	40	0.370	655	240	71.5	17.6
19.70	40	0.375	645	240	73.0	17.5
19.80	40	0.375	645	240	74.0	17.5
20.00	40	0.380	635	240	75.5	17.5

Cast iron
(lamellar / spheroidal)

18.50	240	0.710	4130	2930	787.5	1.5
18.70	240	0.715	4085	2920	802.0	1.5
19.00	240	0.720	4020	2895	821.0	1.5
19.20	240	0.720	3980	2865	829.5	1.5
19.30	240	0.725	3960	2870	839.5	1.5
19.50	240	0.735	3920	2880	860.0	1.5
19.70	240	0.735	3880	2850	868.5	1.5
19.80	240	0.740	3860	2855	879.0	1.5
20.00	240	0.745	3820	2845	894.0	1.5

Spiral flute drills XDrill®

5xd



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	
		B72015		.1850				B72015	
ø Code	d1 m7	d2 h5	l1	l2	l4	L _{max}			
.1850	18.5	20	153	101	50	70.9			●
.1870	18.7	20	153	101	50	70.8			●
.1900	19.0	20	153	101	50	70.5			●
.1910	19.1	20	153	101	50	70.5			●
.1920	19.2	20	153	101	50	70.4			●
.1930	19.3	20	153	101	50	70.4			●
.1950	19.5	20	153	101	50	70.3			●
.1970	19.7	20	153	101	50	70.2			●
.1980	19.8	20	153	101	50	70.1			●
.2000	20.0	20	153	101	50	70.0			●