

Ratio Drills

# ≤7xD drilling depth 2-fluted

# ≤10xD

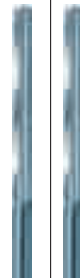
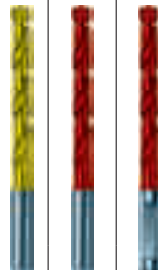
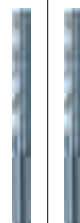
Tool material	<b>Carb-tippec</b>
Carbide grade	P
Type	RT 80 U
Surface finish	Ⓢ
Cooling	■
Guh. no.	1173
DIN 6538 HE	Ⓡ
G.S.	HA Ⓡ
	HE Ⓡ

<b>Carbide</b>	
K	
RT 150 GG	
○ ○	
■	■
769	6069

<b>Carbide</b>			
K/P			
RT 100 U			
Ⓢ	Ⓡ	Ⓡ	Ⓡ
■	■	■	■
2711	4044/5512	4045/5612	

<b>Carbide</b>	
K/P	
RT 100 R	
Ⓡ	
■	
6502	

<b>Carbide</b>		
K		
RT 150 GG		
○ ○		
■	■	■
770/5513	6070	



Material chart page 5

Vc m/min	Feed col. no.
95	4
75	3
90	5
75	4
80	4
75	4
60	4
75	4
60	3
90	5
75	4
55	3
75	4
55	3
40	3
35	3
40	2
35	1
33	1
25	1
150	5
110	5
110	5
90	4
180	6
180	6
160	6
130	5
280	7
110	6
80	5

Vc m/min	Feed column no.
120	6
100	6
90	6
80	6
40	2
410	8
410	8
380	8
330	8
280	7
110	6
80	5

Ⓢ Vc m/min	Ⓡ Vc m/min	Feed column no.	
110	145	5	6
90	120	4	5
130	170	6	7
110	145	6	7
100	130	6	7
95	125	5	6
90	120	5	6
90	120	5	6
80	105	5	6
110	145	6	7
90	120	5	6
65	85	3	4
80	110	5	6
75	105	4	4
55	80	4	5
40	65	3	4
45	60	2	4
45	60	1	2
45	60	3	4
40	55	3	4
35	45	3	4
40	55	1	2
25	35	1	1
25	35	2	3
150	210	7	8
120	180	7	8
100	160	7	8
95	130	6	7
30	40	1	2
35	40	1	3
30	40	1	2
220	310	7	8
220	310	7	8
200	260	7	8
170	220	7	8
230	280	6	7
95	125	6	6
250	325	7	7
170	220	6	6
95	125	6	6
80	105	5	5
70	90	5	5
60	80	5	5

Vc m/min	Feed col. no.
210	8
160	8
130	7
100	7
80	7
60	7
180	8
130	7

Vc m/min	Feed column no.
120	6
100	6
90	6
80	6
40	2
410	8
410	8
380	8
330	8
280	7
110	6
80	5

○ bright

● steam tempered

● nitrided lands

● nitrided

● golden brown

Ⓡ TiAlN