



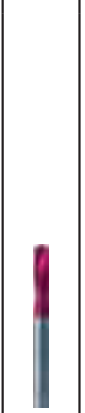
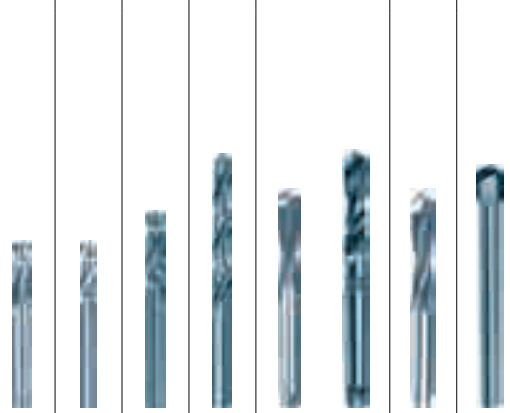
Twist drills

≤3xD drilling depth

		Carbide				Carbide-tipped		
		K10/K20	K10/K20	K10/K20	K10/K20	K10/K20	K10/K20	K10/K20
Tool material		N	N	N	Duro 150	N	N	
Carbide grade		○	○	○	○	○	○	○
Type		N	N	N	Duro 150	N	N	
Surface finish		○	○	○	○	○	○	○
Guh. no.	DIN 6537 [R]							
	DIN 6539 [R]	730/5516						
	DIN 8037 [R]					703		
	DIN 8038 [R]						704	
	G.S. [R]		702, 709	1149	710			707
MT	DIN 8041 [R]					705		

Carbide
K10/K20
N
●
2463

Carbide
K
H
●
1946



Material chart page 17

v _c m/min	Feed column no.						
80				4		4	
70				3		3	
25				2		2	2
25	4						
25	3						
25	3						
20				3		3	
10				2		2	
15	2						
90	4			4		4	
80	4			4		4	
70	4			4		4	
60	4			4		4	
10				1		1	1
20	3						
15	2						
200	7						
200	7						
150	6						
120	6						
180	5						
80	5*						
180	5*			5		5	
180	5*			5		5	
120	5						
120	5						
70	4						
50	3						
50	4	4					
40	3	3					3
150			1				
80	3	3					2

v _c m/min	Feed col. no.
104	5
91	5
104	6
91	5
104	5
91	5
78	5
78	5
104	6
78	5
65	5
65	4
32	3
32	5
32	4
32	4
26	4
20	3
117	5
104	5
91	5
104	5
26	4
20	3
260	8
260	8
195	7
156	7
234	6
104	6
234	6
234	6
156	6
156	6
91	5
65	4
65	5
52	4
104	4

v _c m/min	Feed col. no.
80	6
65	4
80	4
40	2
30	1
90	8
80	8
80	8
70	7
30	2