≤3×D Drilling depth

Tool material		Solid carbide	Solid carbide	
Carbide grade		K	K	
Type		RT 100 VA	RT 100 VA	
Surface finish		TiAlN nanoA	TiAlN nanoA	
Cooling		■	■	
No. DIN 6537	HA R	8510	8510	
	HE R	8610	8610	
for dia. range		d1 ≤ 10 mm	d1 > 10 mm	

v_c m/min	Feed column no.	v_c m/min	Feed column no.
80	5	80	5
60	3	90	2
80	5	80	5
30	2	30	2
35	2	35	2

≤5×D Drilling depth

Tool material	Solid carbide	Solid carbide	
Carbide grade	K	K	
Type	RT 100 VA	RT 100 VA	
Surface finish	TiAlN nanoA	TiAlN nanoA	
Cooling	■	■	
No. DIN 6537 HA R	8511	8511	
HE R	8611	8611	
for dia. range	d1 ≤ 10 mm	d1 > 10 mm	

v_c m/min	Feed column no.	v_c m/min	Feed column no.
80	5	80	5
60	3	90	2
80	5	80	5
30	2	30	2
35	2	35	2