

# Tieflochbohrer aus

**HSS**



**HSS-CO**



**VHM**



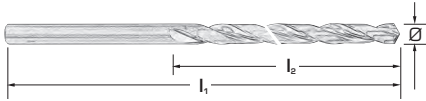
- HSS: DIN 1869 und DIN 1870
- HSS: überlange Ausführung
- HSS-Co: DIN 1869 und DIN 1870
- VHM: 12 x D bis 40 x D



## ÜBERLANG / EXTRA LONG SERIES

### Spiralbohrer mit Zylinderschaft aus HSS und HSS-Co

Twist drills with straight shank  
made of HSS and HSS-Co



Typ / Type					N	STL	STL
Schneidrichtung Cutting direction							
Schneidstoff Material					HSS	HSS	HSS-Co
Ø mm h8	Ø "	Ø No. mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6217/1	6216/1	6218/1
2,000			125	85	●	●	●
2,100			125	85	●	●	●
2,200			135	90	●	●	●
2,300			135	90	●	●	●
2,383	3/32		140	95	-	●	-
2,400			140	95	●	●	●
2,489		40	140	95	-	●	-
2,500			140	95	●	●	●
2,527		39	140	95	-	●	-
2,578		38	140	95	-	●	-
2,600			140	95	●	●	●
2,642		37	140	95	-	●	-
2,700			150	100	●	●	●
2,705		36	150	100	-	●	-
2,779	7/64		150	100	-	●	-
2,794		35	150	100	-	●	-
2,800			150	100	●	●	●
2,819		34	150	100	-	●	-
2,870		33	150	100	-	●	-
2,900			150	100	●	●	●
2,946		32	150	100	-	●	-
3,000			150	100	●	●	●
3,048		31	155	105	-	●	-
3,100			155	105	●	●	●
3,175	1/8		155	105	-	●	-
3,200			155	105	●	●	●
3,264		30	155	105	-	●	-
3,300			155	105	●	●	●
3,400			165	115	●	●	●
3,454		29	165	115	-	●	-
3,500			165	115	●	●	●
3,569		28	165	115	-	●	-
3,571	9/64		165	115	-	●	-
3,600			165	115	●	●	●
3,658		27	165	115	-	●	-
3,700			165	115	●	●	●
3,734		26	165	115	-	●	-
3,797		25	175	120	-	●	-
3,800			175	120	●	●	●
3,861		24	175	120	-	●	-

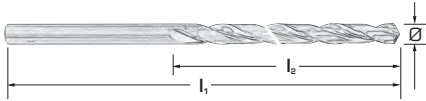
Typ / Type					N	STL	STL
Schneidrichtung Cutting direction							
Schneidstoff Material					HSS	HSS	HSS-Co
Ø mm h8	Ø "	Ø No. mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6217/1	6216/1	6218/1
3,900			175	120	●	●	●
3,912		23	175	120	-	●	-
3,970	5/32		175	120	-	●	-
3,988		22	175	120	-	●	-
4,000			175	120	●	●	●
4,039		21	175	120	-	●	-
4,089		20	175	120	-	●	-
4,100			175	120	●	●	●
4,200			175	120	●	●	●
4,216		19	175	120	-	●	-
4,300			185	125	●	●	●
4,305		18	185	125	-	●	-
4,366	11/64		185	125	-	●	-
4,394		17	185	125	-	●	-
4,400			185	125	●	●	●
4,496		16	185	125	-	●	-
4,500			185	125	●	●	●
4,572		15	185	125	-	●	-
4,600			185	125	●	●	●
4,623		14	185	125	-	●	-
4,699		13	185	125	-	●	-
4,700			185	125	●	●	●
4,763	3/16		195	135	-	●	-
4,800			195	135	●	●	●
4,801		12	195	135	-	●	-
4,851		11	195	135	-	●	-
4,900			195	135	●	●	●
4,915		10	195	135	-	●	-
4,978		9	195	135	-	●	-
5,000			195	135	●	●	●
5,055		8	195	135	-	●	-
5,100			195	135	●	●	●
5,105		7	195	135	-	●	-
5,159	13/64		195	135	-	●	-
5,182		6	195	135	-	●	-
5,200			195	135	●	●	●
5,220		5	195	135	-	●	-
5,300			195	135	●	●	●
5,309		4	205	140	-	●	-
5,400			205	140	●	●	●



## ÜBERLANG / EXTRA LONG SERIES

### Spiralbohrer mit Zylinderschaft aus HSS und HSS-Co

Twist drills with straight shank  
made of HSS and HSS-Co



Typ / Type					N	STL	STL
Schneidrichtung Cutting direction							
Schneidstoff Material					HSS	HSS	HSS-Co
Ø mm h8	Ø " No.	Ø No. mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6217/1	6216/1	6218/1
5,410	3		205	140	-	●	-
5,500			205	140	●	●	●
5,558	7/32		205	140	-	●	-
5,600			205	140	●	●	●
5,613	2		205	140	-	●	-
5,700			205	140	●	●	●
5,791	1		205	140	-	●	-
5,800			205	140	●	●	●
5,900			205	140	●	●	●
5,954	15/64		205	140	-	●	-
6,000			205	140	●	●	●
6,100			215	150	●	●	●
6,200			215	150	●	●	●
6,300			215	150	●	●	●
6,350	1/4		215	150	-	●	-
6,400			215	150	●	●	●
6,500			215	150	●	●	●
6,600			215	150	●	●	●
6,700			215	150	●	●	●
6,746	17/64		225	155	-	●	-
6,800			225	155	●	●	●
6,900			225	155	●	●	●
7,000			225	155	●	●	●
7,100			225	155	●	●	●
7,145	9/32		225	155	-	●	-
7,200			225	155	●	●	●
7,300			225	155	●	●	●
7,400			225	155	●	●	●
7,500			225	155	●	●	●
7,541	19/64		240	165	-	●	-
7,600			240	165	●	●	●
7,700			240	165	●	●	●
7,800			240	165	●	●	●
7,900			240	165	●	●	●
7,938	5/16		240	165	-	●	-
8,000			240	165	●	●	●
8,100			240	165	●	●	●
8,200			240	165	●	●	●
8,300			240	165	●	●	●
8,334	21/64		240	165	-	●	-

Typ / Type					N	STL	STL
Schneidrichtung Cutting direction							
Schneidstoff Material					HSS	HSS	HSS-Co
Ø mm h8	Ø " No.	Ø No. mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6217/1	6216/1	6218/1
8,400			240	165	●	●	●
8,500			240	165	●	●	●
8,600			250	175	●	●	●
8,700			250	175	●	●	●
8,733	11/32		250	175	-	●	-
8,800			250	175	●	●	●
8,900			250	175	●	●	●
9,000			250	175	●	●	●
9,100			250	175	●	●	●
9,129	23/64		250	175	-	●	-
9,200			250	175	●	●	●
9,300			250	175	●	●	●
9,400			250	175	●	●	●
9,500			250	175	●	●	●
9,525	3/8		265	185	-	●	-
9,600			265	185	●	●	●
9,700			265	185	●	●	●
9,800			265	185	●	●	●
9,900			265	185	●	●	●
9,921	25/64		265	185	-	●	-
10,000			265	185	●	●	●
10,320	13/32		265	185	-	●	-
10,500			265	185	-	●	●
10,716	27/64		280	195	-	●	-
11,000			280	195	-	●	●
11,113	7/16		280	195	-	●	-
11,500			280	195	-	●	●
11,509	29/64		280	195	-	●	-
11,908	15/32		295	205	-	●	-
12,000			295	205	-	●	●
12,304	31/64		295	205	-	●	-
12,700	1/2		295	205	-	●	-





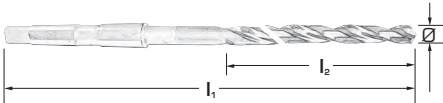






## ÜBERLANG / EXTRA LONG SERIES

**Spiralbohrer mit Morsekegel aus HSS e HSS-Co**  
Twist drills with Morse taper shank  
made of HSS and HSS-Co



Typ / Type				N	STL	STL
Schneidrichtung Cutting direction						
Schneidstoff Material				HSS	HSS	HSS-Co
Ø mm h8	l <sub>1</sub> mm	l <sub>2</sub> mm	CM MT	6220/2	6221/2	6219/2
8,0	330	210	1	●	●	-
8,5	330	210	1	●	●	-
9,0	345	220	1	●	●	-
9,5	345	220	1	●	-	-
10,0	360	235	1	●	●	●
10,5	360	235	1	●	●	●
11,0	375	250	1	●	●	●
11,5	375	250	1	●	●	●
12,0	395	260	1	●	●	●
12,5	395	260	1	●	●	●
13,0	395	260	1	●	●	●
13,5	410	275	1	●	●	●
14,0	410	275	1	●	●	●
14,5	425	275	2	●	●	●
15,0	425	275	2	●	●	●
15,5	445	295	2	●	●	●
16,0	445	295	2	●	●	●
16,5	445	295	2	●	●	●
17,0	445	295	2	●	●	●
17,5	465	310	2	●	●	●
18,0	465	310	2	●	●	●
18,5	465	310	2	●	●	●
19,0	465	310	2	●	●	●
19,5	490	325	2	●	●	●
20,0	490	325	2	●	●	●
20,5	490	325	2	●	-	■
21,0	490	325	2	●	●	●
21,5	515	345	2	●	-	-
22,0	515	345	2	●	●	●
22,5	515	345	2	●	-	-
23,0	515	345	2	●	●	●
23,5	535	345	3	●	-	-
24,0	555	365	3	●	●	●
24,5	555	365	3	●	-	-
25,0	555	365	3	●	●	●
25,5	555	365	3	●	-	-
26,0	555	365	3	●	●	●
26,5	555	365	3	●	-	-
27,0	580	385	3	●	●	●
27,5	580	385	3	■	-	-



Typ / Type				N	STL	STL
Schneidrichtung Cutting direction						
Schneidstoff Material				HSS	HSS	HSS-Co
Ø mm h8	l <sub>1</sub> mm	l <sub>2</sub> mm	CM MT	6220/2	6221/2	6219/2
28,0	580	385	3	●	●	●
28,5	580	385	3	■	-	-
29,0	580	385	3	●	●	●
29,5	580	385	3	●	-	-
30,0	580	385	3	●	●	●
31,0	610	410	3	●	●	-
32,0	635	410	4	●	●	-
33,0	635	410	4	●	●	-
34,0	665	430	4	●	●	-
35,0	665	430	4	●	●	-
36,0	665	430	4	●	-	-
37,0	665	430	4	●	-	-
38,0	695	460	4	●	●	-
39,0	695	460	4	●	-	-
40,0	695	460	4	●	●	-
41,0	695	460	4	●	-	-
42,0	695	460	4	●	-	-
45,0	735	490	4	●	-	-
48,0	765	510	4	●	-	-
50,0	765	510	4	●	-	-





# DIN 6537K



## EINHEITSSCHAFT / UNIFIED SHANK

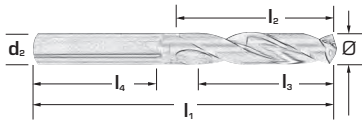
### DIN 6535 HA

Hochleistungs-Spiralbohrer, mit Kühlkanälen, kurz Ausführung

High Performance twist drills, with internal coolant, jobber length series

## Pilotbohrer

### Record 2 S iVHM / Solid carbide



Typ / Type							2 Si
Schneidrichtung Cutting direction							
Schneidstoff / Material							K 30F
Ø mm m7	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	l <sub>4</sub> mm	d <sub>2</sub> h <sub>6</sub>	6011 TF	
3,0	62	20	14	36	6	●	
3,1	62	20	14	36	6	●	
3,2	62	20	14	36	6	●	
3,3	62	20	14	36	6	●	
3,4	62	20	14	36	6	●	
3,5	62	20	14	36	6	●	
3,6	62	20	14	36	6	●	
3,7	62	20	14	36	6	●	
3,8	66	24	17	36	6	●	
3,9	66	24	17	36	6	●	
4,0	66	24	17	36	6	●	
4,1	66	24	17	36	6	●	
4,2	66	24	17	36	6	●	
4,3	66	24	17	36	6	●	
4,4	66	24	17	36	6	●	
4,5	66	24	17	36	6	●	
4,6	66	24	17	36	6	●	
4,7	66	24	17	36	6	●	
4,8	66	28	20	36	6	●	
4,9	66	28	20	36	6	●	
5,0	66	28	20	36	6	●	
5,1	66	28	20	36	6	●	
5,2	66	28	20	36	6	●	
5,3	66	28	20	36	6	●	
5,4	66	28	20	36	6	●	
5,5	66	28	20	36	6	●	
5,6	66	28	20	36	6	●	
5,7	66	28	20	36	6	●	
5,8	66	28	20	36	6	●	
5,9	66	28	20	36	6	●	
6,0	66	28	20	36	6	●	
6,1	79	34	24	36	8	●	
6,2	79	34	24	36	8	●	
6,3	79	34	24	36	8	●	
6,4	79	34	24	36	8	●	
6,5	79	34	24	36	8	●	
6,6	79	34	24	36	8	●	
6,7	79	34	24	36	8	●	
6,8	79	34	24	36	8	●	
6,9	79	34	24	36	8	●	

Typ / Type							2 Si
Schneidrichtung Cutting direction							
Schneidstoff / Material							K 30F
Ø mm m7	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	l <sub>4</sub> mm	d <sub>2</sub> h <sub>6</sub>	6011 TF	
7,0	79	41	29	36	8	●	
7,1	79	41	29	36	8	●	
7,2	79	41	29	36	8	●	
7,3	79	41	29	36	8	●	
7,4	79	41	29	36	8	●	
7,5	79	41	29	36	8	●	
7,6	79	41	29	36	8	●	
7,7	79	41	29	36	8	●	
7,8	79	41	29	36	8	●	
7,9	79	41	29	36	8	●	
8,0	79	41	29	36	8	●	
8,1	89	47	35	40	10	●	
8,2	89	47	35	40	10	●	
8,3	89	47	35	40	10	●	
8,4	89	47	35	40	10	●	
8,5	89	47	35	40	10	●	
8,6	89	47	35	40	10	●	
8,7	89	47	35	40	10	●	
8,8	89	47	35	40	10	●	
8,9	89	47	35	40	10	●	
9,0	89	47	35	40	10	●	
9,1	89	47	35	40	10	●	
9,2	89	47	35	40	10	●	
9,3	89	47	35	40	10	●	
9,4	89	47	35	40	10	●	
9,5	89	47	35	40	10	●	
9,6	89	47	35	40	10	●	
9,7	89	47	35	40	10	●	
9,8	89	47	35	40	10	●	
9,9	89	47	35	40	10	●	
10,0	89	47	35	40	10	●	
10,1	102	55	40	45	12	●	
10,2	102	55	40	45	12	●	
10,3	102	55	40	45	12	●	
10,4	102	55	40	45	12	●	
10,5	102	55	40	45	12	●	
10,6	102	55	40	45	12	●	
10,7	102	55	40	45	12	●	
10,8	102	55	40	45	12	●	
10,9	102	55	40	45	12	●	



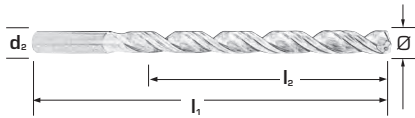
## EINHEITSSCHAFT / UNIFIED SHANK

### DIN 6535 HA

### Hochleistungs-Spiralbohrer, mit Kühlkanälen, extra lange Ausführung

High performance twist drills, with internal coolant, extra long series

### Record DH i VHM Feinstkorn / Solid carbide micro grain



Typ / Type				DH i
Schneidrichtung Cutting direction				
Schneidstoff / Material				K 20F
Ø mm m7	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h6	6027 TT
3.0	92	54	6	
3.3	92	54	6	
3.4	92	54	6	
3.5	92	54	6	
3.8	102	64	6	
4.0	102	64	6	
4.2	102	64	6	
4.3	102	64	6	
4.5	102	64	6	
4.8	121	83	6	
5.0	121	83	6	
5.1	121	83	6	
5.2	121	83	6	
5.5	121	83	6	
5.6	121	83	6	
5.8	121	83	6	
6.0	121	83	6	
6.1	148	110	8	
6.5	148	110	8	
6.6	148	110	8	
6.8	148	110	8	
6.9	148	110	8	
7.0	148	110	8	
7.4	148	110	8	
7.5	148	110	8	
7.8	148	110	8	
8.0	148	110	8	
8.1	180	138	10	
8.3	180	138	10	
8.4	180	138	10	
8.5	180	138	10	
8.6	180	138	10	
8.7	180	138	10	
8.8	180	138	10	
9.0	180	138	10	
9.3	180	138	10	
9.5	180	138	10	
9.8	180	138	10	
10.0	180	138	10	
10.2	206	158	12	

Typ / Type				DH i
Schneidrichtung Cutting direction				
Schneidstoff / Material				K 20F
Ø mm m7	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h6	6027 TT
10.3	206	158	12	
10.4	206	158	12	
10.5	206	158	12	
10.8	206	158	12	
11.0	206	158	12	
11.2	206	158	12	
11.5	206	158	12	
11.8	206	158	12	
12.0	206	158	12	
12.5	230	182	14	
13.0	230	182	14	
13.5	230	182	14	
14.0	230	182	14	
14.5	260	208	16	
15.0	260	208	16	
15.5	260	208	16	
16.0	260	208	16	
16.5	285	234	18	
17.0	285	234	18	
17.5	285	234	18	
18.0	285	234	18	
18.5	310	258	20	
19.0	310	258	20	
19.5	310	258	20	
20.0	310	258	20	

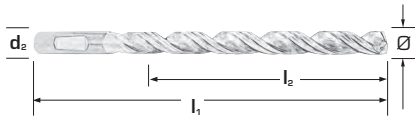
## EINHEITSSCHAFT / UNIFIED SHANK

### DIN 6535 HE

### Hochleistungs-Spiralbohrer, mit Kühlkanälen, extra lange Ausführung

High performance twist drills, with internal coolant, extra long series

### Record DH i VHM Feinstkorn / Solid carbide micro grain



Typ / Type				DH i
Schneidrichtung Cutting direction				
Schneidstoff / Material				K 20F
Ø mm m7	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h6	6028 TT
3.0	92	54	6	
3.3	92	54	6	
3.4	92	54	6	
3.5	92	54	6	
3.8	102	64	6	
4.0	102	64	6	
4.2	102	64	6	
4.3	102	64	6	
4.5	102	64	6	
4.8	121	83	6	
5.0	121	83	6	
5.1	121	83	6	
5.2	121	83	6	
5.5	121	83	6	
5.6	121	83	6	
5.8	121	83	6	
6.0	121	83	6	
6.1	148	110	8	
6.5	148	110	8	
6.6	148	110	8	
6.8	148	110	8	
6.9	148	110	8	
7.0	148	110	8	
7.4	148	110	8	
7.5	148	110	8	
7.8	148	110	8	
8.0	148	110	8	
8.1	180	138	10	
8.3	180	138	10	
8.4	180	138	10	
8.5	180	138	10	
8.6	180	138	10	
8.7	180	138	10	
8.8	180	138	10	
9.0	180	138	10	
9.3	180	138	10	
9.5	180	138	10	
9.8	180	138	10	
10.0	180	138	10	
10.2	206	158	12	

Typ / Type				DH i
Schneidrichtung Cutting direction				
Schneidstoff / Material				K 20F
Ø mm m7	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h6	6028 TT
10.3	206	158	12	
10.4	206	158	12	
10.5	206	158	12	
10.8	206	158	12	
11.0	206	158	12	
11.2	206	158	12	
11.5	206	158	12	
11.8	206	158	12	
12.0	206	158	12	
12.5	230	182	14	
13.0	230	182	14	
13.5	230	182	14	
14.0	230	182	14	
14.5	260	208	16	
15.0	260	208	16	
15.5	260	208	16	
16.0	260	208	16	
16.5	285	234	18	
17.0	285	234	18	
17.5	285	234	18	
18.0	285	234	18	
18.5	310	258	20	
19.0	310	258	20	
19.5	310	258	20	
20.0	310	258	20	









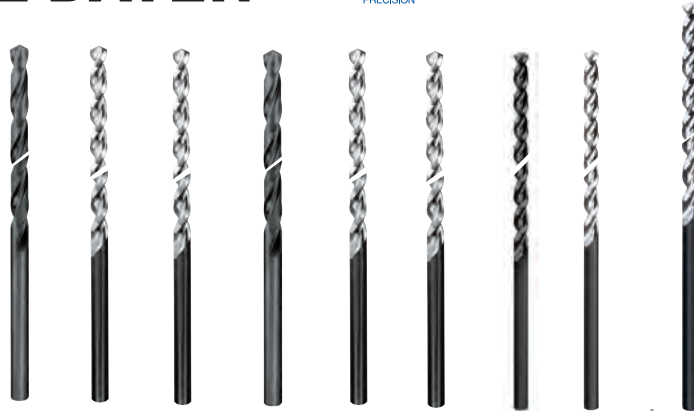




# TECHNISCHE DATEN



## TECHNICAL DATA



Typ Type	N		STL		STL		N		STL		STL		N		STL		STL		
ILIX Typ-siehe Seite Ilix Type -See page	158		162		166		158		162		166		158		158		162		
DIN	1869-1						1869-2						1869-3						Ilix Norm.
Bohrtiefe Drilling depth	16xd						22xd						30xd						60/70 xd
Schneidrichtung Cutting direction																			
Schneidstoff Material	HSS		HSS		HSS-CO		HSS		HSS		HSS-CO		HSS		HSS		HSS		
Spitzenwinkel Point angle	120°		130°		130°		120°		130°		130°		120°		130°		130°		
Beschichtung Coating	VAP		FASE NIT.		FASE NIT.		VP		FASE NIT.		FASE NIT.		VP		FASE NIT.		FASE NIT.		
Innenliegende Kühlkanäle Internal coolant	-		-		-		-		-		-		-		-		-		
Verstärkter Schaft Reinforced shank	-		-		-		-		-		-		-		-		-		
	<b>6217/1</b>		<b>6216/1</b>		<b>6218/1</b>		<b>6217/2</b>		<b>6216/2</b>		<b>6218/2</b>		<b>6217/3</b>		<b>6216/3</b>		<b>6130</b>		
	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	
<b>P</b> < 800 N/mm <sup>2</sup>	20	7	22	7	23	8	19	7	21	7	21	8	18	7	20	8	14	6	
<b>P</b> 700-1000 N/mm <sup>2</sup>	13	6	16	6	18	7	12	6	16	6	21	7	11	6	16	7	9	5	
<b>P</b> 1000-1300 N/mm <sup>2</sup>	6	5	10	5	14	6	5	5	12	9	12	6	4	5	9	6	4	4	
<b>M</b> Austenitisch	4	4	-	-	-	-	3	4	-	-	-	-	3	3	-	-	5	3	
<b>M</b> Austenitisch / ferritisch	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
<b>K</b> GG	13	6	20	7	25	7	12	6	20	6	23	6	11	7	20	5	18	5	
<b>K</b> GGG	7	5	10	5	15	6	6	5	10	4	20	6	5	5	10	3	9	3	
<b>N</b> Aluminium	28	6	30	6	30	10	27	6	30	6	35	10	26	9	30	10	20	6	
<b>N</b> NE-Metalle	21	5	25	5	25	7	20	5	22	5	30	7	19	5	25	7	20	5	
<b>S</b> Titan	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
<b>S</b> Sonderlegierungen basiert auf Ni	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
<b>H</b> Gehärteter Stahl 38 / 48 HRC	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
<b>H</b> Gehärteter Stahl 48 / 58 HRC	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
<b>H</b> Gehärteter Stahl 58 / 68 HRC	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

# TECHNISCHE DATEN



## TECHNICAL DATA



Typ Type	N		STL		STL		N		STL		STL		STL	
ILIX Typ-siehe Seite Ilrix Type -See page	160		164		166		160		164		166		164	
DIN	1870-1						1870-2						Ilrix Norm.	
Bohrtiefe Drilling depth	16xd						22xd						40xd	
Schneidrichtung Cutting direction														
Schneidstoff Material	HSS		HSS		HSS-CO		HSS		HSS		HSS-CO		HSS	
Spitzenwinkel Point angle	120°		130°		130°		120°		130°		130°		130°	
Beschichtung Coating	VAP		FASE NIT.		FASE NIT.		VP		FASE NIT.		FASE NIT.		FASE NIT.	
Innenliegende Kühlkanäle Internal coolant	-		-		-		-		-		-		-	
Verstärkter Schaft Reinforced shank	-		-		-		-		-		-		-	
	6220/1		6221/1		6219/1		6220/2		6221/2		6219/2		6150	
	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*
<b>P</b> < 800 N/mm <sup>2</sup>	18	7	20	7	22	8	15	6	17	6	20	7	20	7
<b>P</b> 700-1000 N/mm <sup>2</sup>	10	6	12	6	15	7	8	5	9	5	13	6	15	6
<b>P</b> 1000-1300 N/mm <sup>2</sup>	6	5	8	5	10	6	5	4	6	4	8	4	11	5
<b>M</b> Austenitisch	4	3	-	-	-	-	3	2	-	-	-	-	-	-
<b>M</b> Austenitisch / ferritisch	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>K</b> GG	15	7	20	7	25	7	13	6	13	7	15	7	13	7
<b>K</b> GGG	7	5	12	6	15	6	6	4	8	6	10	6	8	6
<b>N</b> Aluminium	35	8	37	8	40	9	30	7	33	7	37	8	28	6
<b>N</b> NE-Metalle	17	6	20	6	22	7	14	5	16	5	20	6	21	5
<b>S</b> Titan	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>S</b> Sonderlegierungen basiert auf Ni	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b> Gehärteter Stahl 38 / 48 HRC	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b> Gehärteter Stahl 48 / 58 HRC	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b> Gehärteter Stahl 58 / 68 HRC	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

# TECHNISCHE DATEN

## TECHNICAL DATA



Pilotbohrer



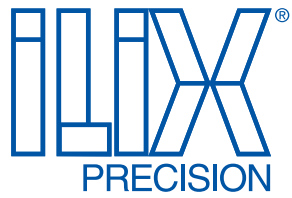
Typ Type	RECORD DHi	RECORD DHi	RECORD DHi	RECORD DHi	RECORD DHi	RECORD DHi	RECORD 2Si							
DIN	ILIX Norm			ILIX Norm			6537K							
Bohrtiefe Drilling depth	12xD	15xD	20xD	25xD	30xD	40xD	3xD							
Schneidrichtung Cutting direction														
Schneidstoff Material	K20F	K30F	K30F	K30F	K30F	K30F	K30F							
Spitzenwinkel Point angle	140°	135°	135°	135°	135°	135°	140°							
Beschichtung Coating	TT	TT	TT	TT	TT	TT	TF							
Innenliegende Kühlkanäle Internal coolant							IK							
Verstärkter Schaft Reinforced shank														
	6027-6028 TT		6032 TT		6034 TT		6035 TT		6036 TT		6038 TT		6011 TF	
	VC	f*	VC	f*	VC	f*	VC	f*	VC	f*	VC	f*	VC	f*
<b>P</b> < 800 N/mm <sup>2</sup>	75	10	80	12	75	9	70	9	70	9	60	8	110	12
<b>P</b> 700-1000 N/mm <sup>2</sup>	65	9	70	9	65	8	60	8	60	8	50	7	90	10
<b>P</b> 1000-1300 N/mm <sup>2</sup>	60	8	65	8	60	7	55	7	55	7	40	6	70	10
<b>M</b> Austenitisch	35	4	45	5	40	5	35	4	35	4	25	4	40	6
<b>M</b> Austenitisch / ferritisch	-	-	35	4	30	4	27	3	27	3	20	3	-	-
<b>K</b> GG	75	12	70	12	65	13	60	12	60	12	50	12	100	12
<b>K</b> GGG	55	9	60	8	55	10	50	9	50	9	40	9	80	10
<b>N</b> Aluminium	80	16	100	12	100	12	90	10	90	10	80	9	150	12
<b>N</b> NE-Metalle	70	10	70	10	65	10	60	8	60	8	50	7	120	10
<b>S</b> Titan	-	-	25	5	22	5	20	4	20	4	15	4	-	-
<b>S</b> Sonderlegierungen basiert auf Ni	-	-	20	4	18	4	16	3	16	3	11	3	-	-
<b>H</b> Gehärteter Stahl 38 / 48 HRC	-	-	15	3	13	3	10	2	10	2	8	2	18	4
<b>H</b> Gehärteter Stahl 48 / 58 HRC	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b> Gehärteter Stahl 58 / 68 HRC	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions



## Bohrer-Kegelsenker-Aufbohrer / Drills-Countersinking-Core Drilling

		Vorschub F (mm/U x Bohrerdurchmesser (mm)) in HSS - VHM - HM bestückt feed f (mm/rev) for HSS - solid carbide drills - solid carbide inserts															
		Ø 1	Ø 1,5	Ø 2	Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 15	Ø 20	Ø 25	Ø 30	Ø 40	Ø 50
Vorschub-Kennzahl Nr. Feed	1	0,005	0,006	0,006	0,007	0,008	0,009	0,010	0,012	0,013	0,015	0,017	0,019	0,022	0,024	0,028	0,031
	2	0,008	0,009	0,011	0,013	0,015	0,018	0,021	0,024	0,028	0,033	0,038	0,045	0,053	0,062	0,072	0,084
	3	0,010	0,012	0,014	0,016	0,019	0,023	0,027	0,032	0,038	0,044	0,052	0,062	0,073	0,086	0,101	0,120
	4	0,013	0,015	0,018	0,022	0,026	0,031	0,037	0,044	0,052	0,062	0,074	0,088	0,105	0,125	0,148	0,177
	5	0,017	0,020	0,024	0,029	0,035	0,042	0,051	0,061	0,073	0,088	0,105	0,126	0,152	0,182	0,218	0,262
	6	0,020	0,024	0,029	0,035	0,043	0,052	0,063	0,076	0,092	0,111	0,135	0,163	0,197	0,238	0,288	0,349
	7	0,023	0,028	0,034	0,042	0,051	0,062	0,076	0,093	0,113	0,138	0,168	0,205	0,250	0,305	0,372	0,454
	8	0,027	0,033	0,041	0,050	0,062	0,076	0,093	0,115	0,141	0,174	0,214	0,263	0,324	0,398	0,490	0,602
	9	0,030	0,037	0,046	0,057	0,070	0,086	0,106	0,131	0,162	0,201	0,248	0,306	0,378	0,466	0,576	0,711
	10	0,033	0,041	0,050	0,061	0,076	0,093	0,114	0,141	0,173	0,213	0,262	0,322	0,396	0,487	0,599	0,736
	12	0,037	0,045	0,055	0,067	0,082	0,100	0,122	0,149	0,182	0,222	0,270	0,330	0,402	0,491	0,599	0,730
16	0,043	0,052	0,063	0,076	0,092	0,112	0,135	0,163	0,198	0,239	0,289	0,350	0,424	0,512	0,620	0,750	
20	0,050	0,061	0,073	0,089	0,107	0,130	0,157	0,190	0,230	0,278	0,336	0,407	0,492	0,596	0,721	0,872	



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