INOX **Bohrer**

3xD - 5xD - 8xD

Spezielle Schneidengeometrie für die Bearbeitung von nichtrostenden Stählen

Applied INOX Beschichtung ergibt eine bessere Oberflächenqualität und eine längere Lebensdauer.

Hervorragende Spanabfuhr durch verbesserte Oberflächenbehandlung

Spezieller Anschliff zur besseren Zentrierung und Spanbruch

Ideal für folgende Matrialgruppen

P M S N

VHM Bohrer

Anwendungsleitfaden

Inhalt

●: sehr gutt **O**: gut

P				H		M			K				S						N								O		
11	12	13	14	15	16	21	22	23	31	32	33	34	41	42	43	51	52	53	61	62	63	64	71	72	73	74	81	82	83
o	o	o	o			●	●	●					●	●	●	o	o	o					o	o	o	o			
o	o	o	o			●	●	●					●	●	●	o	o	o					o	o	o	o			
o	o	o	o			●	●	●					●	●	●	o	o	o					o	o	o	o			
●	●	●	●						●	●	●	●																	
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●	●	●	●			o	o		●	●	●	●	o	o		o	o						o	o	o	o			
o	o	o	o			o	o		o	o	o	o	o	o		o	o						o	o	o	o			

INOX Bohrer mit Innenkühlung bis .ca. 35HRC

Code	Artikel	Abmessung	Seite Nr.
823323		3xD ø3.0mm - 20.0mm	3-4
825323		5xD ø1.5mm - 20.0mm	5-6
828323		8xD ø3.0mm - 14.0mm	7-8

Hochleistungsbohrer allgemeine Anwendung

Code	Artikel	Abmessung	Seite Nr.
803323		3xD ø3.0mm - 20.0mm	9-10
804323		5xD ø1.0mm - 20.0mm	11-12
805323		8xD ø3.0mm - 12.0mm	13-14
810323		10xD ø3.0mm - 14.0mm	15
815323		15xD ø3.0mm - 12.0mm	15
820323		20xD ø3.0mm - 12.0mm	15

Hochgehärtete Stähle bis 70HRC

Code	Artikel	Abmessung	Seite Nr.
821223		5xD ø3.0mm - 14.0mm	16

Aluminium mit Innenkühlung

Code	Artikel	Abmessung	Seite Nr.
843303		3xD ø3.0mm - 20.0mm	17-18
845303		5xD ø3.0mm - 20.0mm	19-20
848303		8xD ø3.0mm - 14.0mm	21-22

CFK Bohrer

Code	Artikel	Abmessung	Seite Nr.
850390		Jobber ø3.0mm - 14.0mm	23

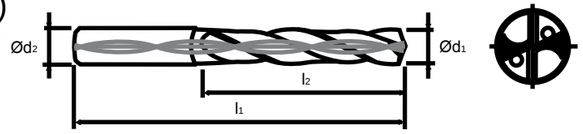
VHM Bohrer

Code	Artikel	Abmessung	Seite Nr.
807323		3xD ø3.0mm - 20.0mm	25-26
808323		5xD ø1.0mm - 20.0mm	27-28
802323		Stub TiAlN ø3.0mm - 20.0mm	29-30
800303		Stub ø1.0mm - 13.0mm	31-32
801303		Jobber ø1.0mm - 13.0mm	33-34
806303 806403		NC-Anbohrer 90° & 120° ø6.0mm - 20.0mm	24
		Schnittdaten	37

VHM INOX 3D DIN6537
mit Innenkühlung TiALN

DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr.823323 (823.121.)



Anwendung:
Zähe Werkstoffe wie rostfreier Stahl, Nickellegierungen, Titan.Bisca.35HRC und Aluminium

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8233230300	3.0	6.0	20	62
8233230310	3.1	6.0	20	62
8233230320	3.2	6.0	20	62
8233230330	3.3	6.0	20	62
8233230340	3.4	6.0	20	62
8233230350	3.5	6.0	20	62
8233230360	3.6	6.0	20	62
8233230370	3.7	6.0	20	62
8233230380	3.8	6.0	24	66
8233230390	3.9	6.0	24	66
8233230400	4.0	6.0	24	66
8233230410	4.1	6.0	24	66
8233230420	4.2	6.0	24	66
8233230430	4.3	6.0	24	66
8233230440	4.4	6.0	24	66
8233230450	4.5	6.0	24	66
8233230460	4.6	6.0	24	66
8233230470	4.7	6.0	24	66
8233230480	4.8	6.0	28	66
8233230490	4.9	6.0	28	66
8233230500	5.0	6.0	28	66
8233230510	5.1	6.0	28	66
8233230520	5.2	6.0	28	66
8233230530	5.3	6.0	28	66
8233230540	5.4	6.0	28	66
8233230550	5.5	6.0	28	66
8233230560	5.6	6.0	28	66
8233230570	5.7	6.0	28	66
8233230580	5.8	6.0	28	66
8233230590	5.9	6.0	28	66
8233230600	6.0	6.0	28	66

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8233230610	6.1	8.0	34	79
8233230620	6.2	8.0	34	79
8233230630	6.3	8.0	34	79
8233230640	6.4	8.0	34	79
8233230650	6.5	8.0	34	79
8233230660	6.6	8.0	34	79
8233230670	6.7	8.0	34	79
8233230680	6.8	8.0	34	79
8233230690	6.9	8.0	34	79
8233230700	7.0	8.0	34	79
8233230710	7.1	8.0	41	79
8233230720	7.2	8.0	41	79
8233230730	7.3	8.0	41	79
8233230740	7.4	8.0	41	79
8233230750	7.5	8.0	41	79
8233230760	7.6	8.0	41	79
8233230770	7.7	8.0	41	79
8233230780	7.8	8.0	41	79
8233230790	7.9	8.0	41	79
8233230800	8.0	8.0	41	79
8233230810	8.1	10.0	47	89
8233230820	8.2	10.0	47	89
8233230830	8.3	10.0	47	89
8233230840	8.4	10.0	47	89
8233230850	8.5	10.0	47	89
8233230860	8.6	10.0	47	89
8233230870	8.7	10.0	47	89
8233230880	8.8	10.0	47	89
8233230890	8.9	10.0	47	89
8233230900	9.0	10.0	47	89
8233230910	9.1	10.0	47	89

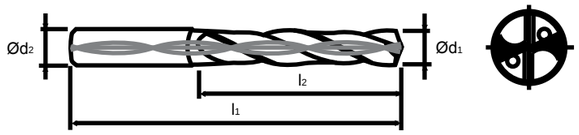
●: sehr gut **O**:gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●			●	●	●						
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●		●				O	O	O	O	O	O	O		

VHM INOX 3D DIN6537
mit Innenkühlung TiALN

DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr. 823323 (823.121.)



Anwendung:
Zähe Werkstoffe wie rostfreier Stahl, Nickellegierungen, Titan. Bis ca.35HRC und Aluminium

EUROPA CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8233230920	9.2	10.0	47	89
8233230930	9.3	10.0	47	89
8233230940	9.4	10.0	47	89
8233230950	9.5	10.0	47	89
8233230960	9.6	10.0	47	89
8233230970	9.7	10.0	47	89
8233230980	9.8	10.0	47	89
8233230990	9.9	10.0	47	89
8233231000	10.0	10.0	47	89
8233231010	10.1	12.0	55	102
8233231020	10.2	12.0	55	102
8233231030	10.3	12.0	55	102
8233231040	10.4	12.0	55	102
8233231050	10.5	12.0	55	102
8233231060	10.6	12.0	55	102
8233231070	10.7	12.0	55	102
8233231080	10.8	12.0	55	102
8233231090	10.9	12.0	55	102
8233231100	11.0	12.0	55	102
8233231110	11.1	12.0	55	102
8233231120	11.2	12.0	55	102
8233231130	11.3	12.0	55	102
8233231140	11.4	12.0	55	102

EUROPA CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8233231150	11.5	12.0	55	102
8233231160	11.6	12.0	55	102
8233231170	11.7	12.0	55	102
8233231180	11.8	12.0	55	102
8233231190	11.9	12.0	55	102
8233231200	12.0	12.0	55	102
8233231250	12.5	14.0	60	107
8233231300	13.0	14.0	60	107
8233231350	13.5	14.0	60	107
8233231400	14.0	14.0	60	107
8233231450	14.5	16.0	65	115
8233231500	15.0	16.0	65	115
8233231550	15.5	16.0	65	115
8233231600	16.0	16.0	65	115
8233231650	16.5	18.0	73	123
8233231700	17.0	18.0	73	123
8233231750	17.5	18.0	73	123
8233231800	18.0	18.0	73	123
8233231850	18.5	20.0	79	131
8233231900	19.0	20.0	79	131
8233231950	19.5	20.0	79	131
8233232000	20.0	20.0	79	131

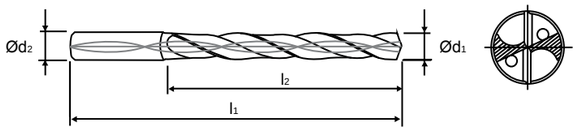
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●			●	●	●						
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●		●				O	O	O	O	O	O	O		

VHM INOX 5D DIN6537 mit Innenkühlung TiALN

DIN 6537 | MG | h6 | m7 | 140°

ArtikelNr.825323 (825.121.)



Anwendung:
Zähe Werkstoffe wie rostfreier Stahl, Nickellegierungen, Titan. Bis ca.35HRC und Aluminium

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8253230150	1.5	3.0	16	55
8253230160	1.6	3.0	16	55
8253230170	1.7	3.0	16	55
8253230180	1.8	3.0	16	55
8253230190	1.9	3.0	16	55
8253230200	2.0	4.0	21	57
8253230210	2.1	4.0	21	57
8253230220	2.2	4.0	21	57
8253230230	2.3	4.0	21	57
8253230240	2.4	4.0	21	57
8253230250	2.5	4.0	21	57
8253230260	2.6	4.0	21	57
8253230270	2.7	4.0	21	57
8253230280	2.8	4.0	21	57
8253230290	2.9	4.0	21	57
8253230300	3.0	6.0	28	66
8253230310	3.1	6.0	28	66
8253230320	3.2	6.0	28	66
8253230330	3.3	6.0	28	66
8253230340	3.4	6.0	28	66
8253230350	3.5	6.0	28	66
8253230360	3.6	6.0	28	66
8253230370	3.7	6.0	28	66
8253230380	3.8	6.0	36	74
8253230390	3.9	6.0	36	74
8253230400	4.0	6.0	36	74
8253230410	4.1	6.0	36	74
8253230420	4.2	6.0	36	74
8253230430	4.3	6.0	36	74
8253230440	4.4	6.0	36	74
8253230450	4.5	6.0	36	74

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8253230460	4.6	6.0	36	74
8253230470	4.7	6.0	36	74
8253230480	4.8	6.0	44	82
8253230490	4.9	6.0	44	82
8253230500	5.0	6.0	44	82
8253230510	5.1	6.0	44	82
8253230520	5.2	6.0	44	82
8253230530	5.3	6.0	44	82
8253230540	5.4	6.0	44	82
8253230550	5.5	6.0	44	82
8253230560	5.6	6.0	44	82
8253230570	5.7	6.0	44	82
8253230580	5.8	6.0	44	82
8253230590	5.9	6.0	44	82
8253230600	6.0	6.0	44	82
8253230610	6.1	8.0	53	91
8253230620	6.2	8.0	53	91
8253230630	6.3	8.0	53	91
8253230640	6.4	8.0	53	91
8253230650	6.5	8.0	53	91
8253230660	6.6	8.0	53	91
8253230670	6.7	8.0	53	91
8253230680	6.8	8.0	53	91
8253230690	6.9	8.0	53	91
8253230700	7.0	8.0	53	91
8253230710	7.1	8.0	53	91
8253230720	7.2	8.0	53	91
8253230730	7.3	8.0	53	91
8253230740	7.4	8.0	53	91
8253230750	7.5	8.0	53	91
8253230760	7.6	8.0	53	91

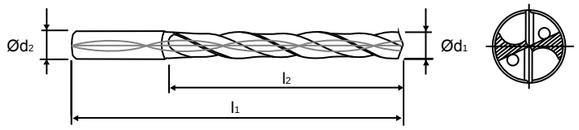
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●			●	●	●						
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●		●				O	O	O	O	O	O	O		

VHM INOX 5D DIN6537mit Innenkühlung TiALN

DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr.825323 (825.121.)



Anwendung:
Zähe Werkstoffe wie rostfreier Stahl, Nickellegierungen, Titan. Bis ca.35HRC und Aluminium

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8253230770	7.7	8.0	53	91
8253230780	7.8	8.0	53	91
8253230790	7.9	8.0	53	91
8253230800	8.0	8.0	53	91
8253230810	8.1	10.0	61	103
8253230820	8.2	10.0	61	103
8253230830	8.3	10.0	61	103
8253230840	8.4	10.0	61	103
8253230850	8.5	10.0	61	103
8253230860	8.6	10.0	61	103
8253230870	8.7	10.0	61	103
8253230880	8.8	10.0	61	103
8253230890	8.9	10.0	61	103
8253230900	9.0	10.0	61	103
8253230910	9.1	10.0	61	103
8253230920	9.2	10.0	61	103
8253230930	9.3	10.0	61	103
8253230940	9.4	10.0	61	103
8253230950	9.5	10.0	61	103
8253230960	9.6	10.0	61	103
8253230970	9.7	10.0	61	103
8253230980	9.8	10.0	61	103
8253230990	9.9	10.0	61	103
8253231000	10.0	10.0	61	103
8253231010	10.1	12.0	71	118
8253231020	10.2	12.0	71	118
8253231030	10.3	12.0	71	118
8253231040	10.4	12.0	71	118
8253231050	10.5	12.0	71	118
8253231060	10.6	12.0	71	118

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8253231070	10.7	12.0	71	118
8253231080	10.8	12.0	71	118
8253231090	10.9	12.0	71	118
8253231100	11.0	12.0	71	118
8253231110	11.1	12.0	71	118
8253231120	11.2	12.0	71	118
8253231130	11.3	12.0	71	118
8253231140	11.4	12.0	71	118
8253231150	11.5	12.0	71	118
8253231160	11.6	12.0	71	118
8253231170	11.7	12.0	71	118
8253231180	11.8	12.0	71	118
8253231190	11.9	12.0	71	118
8253231200	12.0	12.0	71	118
8253231250	12.5	14.0	77	124
8253231300	13.0	14.0	77	124
8253231350	13.5	14.0	77	124
8253231400	14.0	14.0	77	124
8253231450	14.5	16.0	83	133
8253231500	15.0	16.0	83	133
8253231550	15.5	16.0	83	133
8253231600	16.0	16.0	83	133
8253231650	16.5	18.0	93	143
8253231700	17.0	18.0	93	143
8253231750	17.5	18.0	93	143
8253231800	18.0	18.0	93	143
8253231850	18.5	20.0	101	153
8253231900	19.0	20.0	101	153
8253231950	19.5	20.0	101	153
8253232000	20.0	20.0	101	153

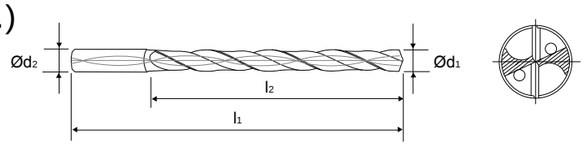
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●			●	●	●						
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●		●				O	O	O	O	O	O	O		

VHM INOX 8D DIN6537 mit Innenkühlung TiALN

DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr. 828323 (828.121.)



Anwendung:
Zähe Werkstoffe wie rostfreier Stahl, Nickellegierungen, Titan. Bis ca.35HRC und Aluminium

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8283230300	3.0	6.0	34	72
8283230310	3.1	6.0	34	72
8283230320	3.2	6.0	34	72
8283230330	3.3	6.0	34	72
8283230340	3.4	6.0	34	72
8283230350	3.5	6.0	34	72
8283230360	3.6	6.0	34	72
8283230370	3.7	6.0	34	72
8283230380	3.8	6.0	43	81
8283230390	3.9	6.0	43	81
8283230400	4.0	6.0	43	81
8283230410	4.1	6.0	43	81
8283230420	4.2	6.0	43	81
8283230430	4.3	6.0	43	81
8283230440	4.4	6.0	43	81
8283230450	4.5	6.0	43	81
8283230460	4.6	6.0	43	81
8283230470	4.7	6.0	43	81
8283230480	4.8	6.0	57	95
8283230490	4.9	6.0	57	95
8283230500	5.0	6.0	57	95
8283230510	5.1	6.0	57	95
8283230520	5.2	6.0	57	95
8283230530	5.3	6.0	57	95
8283230540	5.4	6.0	57	95
8283230550	5.5	6.0	57	95
8283230560	5.6	6.0	57	95
8283230570	5.7	6.0	57	95
8283230580	5.8	6.0	57	95
8283230590	5.9	6.0	57	95
8283230600	6.0	6.0	57	95

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8283230610	6.1	8.0	76	114
8283230620	6.2	8.0	76	114
8283230630	6.3	8.0	76	114
8283230640	6.4	8.0	76	114
8283230650	6.5	8.0	76	114
8283230660	6.6	8.0	76	114
8283230670	6.7	8.0	76	114
8283230680	6.8	8.0	76	114
8283230690	6.9	8.0	76	114
8283230700	7.0	8.0	76	114
8283230710	7.1	8.0	76	114
8283230720	7.2	8.0	76	114
8283230730	7.3	8.0	76	114
8283230740	7.4	8.0	76	114
8283230750	7.5	8.0	76	114
8283230760	7.6	8.0	76	114
8283230770	7.7	8.0	76	114
8283230780	7.8	8.0	76	114
8283230790	7.9	8.0	76	114
8283230800	8.0	8.0	76	114
8283230810	8.1	10.0	95	142
8283230820	8.2	10.0	95	142
8283230830	8.3	10.0	95	142
8283230840	8.4	10.0	95	142
8283230850	8.5	10.0	95	142
8283230860	8.6	10.0	95	142
8283230870	8.7	10.0	95	142
8283230880	8.8	10.0	95	142
8283230890	8.9	10.0	95	142
8283230900	9.0	10.0	95	142
8283230910	9.1	10.0	95	142

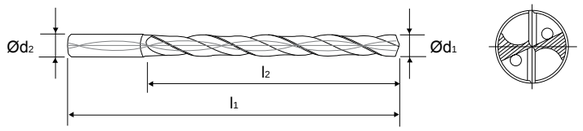
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●			●	●	●						
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●		●				O	O	O	O	O	O	O		

VHM INOX 8D DIN6537 mit Innenkühlung TiALN

DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr. 828323 (828.121.)



Anwendung:
Zähe Werkstoffe wie rostfreier Stahl, Nickellegierungen, Titan. Bis ca.35HRC und Aluminium

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8283230920	9.2	10.0	95	142
8283230930	9.3	10.0	95	142
8283230940	9.4	10.0	95	142
8283230950	9.5	10.0	95	142
8283230960	9.6	10.0	95	142
8283230970	9.7	10.0	95	142
8283230980	9.8	10.0	95	142
8283230990	9.9	10.0	95	142
8283231000	10.0	10.0	95	142
8283231010	10.1	12.0	114	162
8283231020	10.2	12.0	114	162
8283231030	10.3	12.0	114	162
8283231040	10.4	12.0	114	162
8283231050	10.5	12.0	114	162
8283231060	10.6	12.0	114	162
8283231070	10.7	12.0	114	162
8283231080	10.8	12.0	114	162

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8283231090	10.9	12.0	114	162
8283231100	11.0	12.0	114	162
8283231110	11.1	12.0	114	162
8283231120	11.2	12.0	114	162
8283231130	11.3	12.0	114	162
8283231140	11.4	12.0	114	162
8283231150	11.5	12.0	114	162
8283231160	11.6	12.0	114	162
8283231170	11.7	12.0	114	162
8283231180	11.8	12.0	114	162
8283231190	11.9	12.0	114	162
8283231200	12.0	12.0	114	162
8283231250	12.5	14.0	133	178
8283231300	13.0	14.0	133	178
8283231350	13.5	14.0	133	178
8283231400	14.0	14.0	133	178

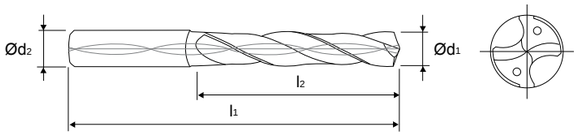
●:sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●			●	●	●						
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●		●				O	O	O	O	O	O	O		

VHM allgemeine Anwendung 3D
DIN6537 mit Innenkühlung TiALN

DIN 6537 | DIN 6535-HA | MG | h6 | m7 | 140°

ArtikelNr.803323(813.121.)



Anwendung:
Stahl, Stahlguss, Hart- und Temperguss,
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8033230300	3.0	6.0	20	62
8033230310	3.1			
8033230320	3.2			
8033230330	3.3			
8033230340	3.4			
8033230350	3.5			
8033230360	3.6			
8033230370	3.7			
8033230380	3.8	6.0	24	66
8033230390	3.9			
8033230400	4.0			
8033230410	4.1			
8033230420	4.2			
8033230430	4.3			
8033230440	4.4			
8033230450	4.5			
8033230460	4.6			
8033230470	4.7			
8033230480	4.8	6.0	28	66
8033230490	4.9			
8033230500	5.0			
8033230510	5.1			
8033230520	5.2			
8033230530	5.3			
8033230540	5.4			
8033230550	5.5			
8033230560	5.6			

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8033230570	5.7	6.0	28	66
8033230580	5.8			
8033230590	5.9			
8033230600	6.0			
8033230610	6.1	8.0	34	79
8033230620	6.2			
8033230630	6.3			
8033230640	6.4			
8033230650	6.5			
8033230660	6.6			
8033230670	6.7			
8033230680	6.8			
8033230690	6.9			
8033230700	7.0			
8033230710	7.1	8.0	41	79
8033230720	7.2			
8033230730	7.3			
8033230740	7.4			
8033230750	7.5			
8033230760	7.6			
8033230770	7.7			
8033230780	7.8			
8033230790	7.9			
8033230800	8.0			
8033230810	8.1	10.0	47	89
8033230820	8.2			
8033230830	8.3			

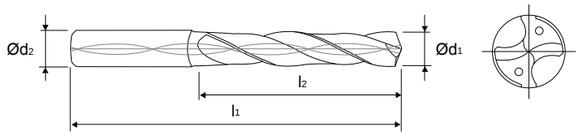
● :sehr gut **O** :gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM allgemeine Anwendung 3D
DIN6537 mit Innenkühlung TiALN

DIN 6537 | DIN 6535-HA | MG | h6 | m7 | 140°

Artikel Nr.803323 (813.121.)



Anwendung:
Stahl, Stahlguss, Hart- und Temperguss,
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8033230840	8.4	10.0	47	89
8033230850	8.5			
8033230860	8.6			
8033230870	8.7			
8033230880	8.8			
8033230890	8.9			
8033230900	9.0			
8033230910	9.1			
8033230920	9.2			
8033230930	9.3			
8033230940	9.4			
8033230950	9.5			
8033230960	9.6			
8033230970	9.7			
8033230980	9.8			
8033230990	9.9			
8033231000	10.0			
8033231010	10.1	12.0	55	102
8033231020	10.2			
8033231030	10.3			
8033231040	10.4			
8033231050	10.5			
8033231060	10.6			
8033231070	10.7			
8033231080	10.8			
8033231090	10.9			
8033231100	11.0			

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8033231110	11.1	12.0	55	102
8033231120	11.2			
8033231130	11.3			
8033231140	11.4			
8033231150	11.5			
8033231160	11.6			
8033231170	11.7			
8033231180	11.8			
8033231190	11.9			
8033231200	12.0			
8033231250	12.5	14.0	60	107
8033231300	13.0			
8033231350	13.5			
8033231400	14.0			
8033231450	14.5	16.0	65	115
8033231500	15.0			
8033231550	15.5			
8033231600	16.0			
8033231650	16.5	18.0	73	123
8033231700	17.0			
8033231750	17.5			
8033231800	18.0			
8033231850	18.5	20.0	79	131
8033231900	19.0			
8033231950	19.5			
8033232000	20.0			

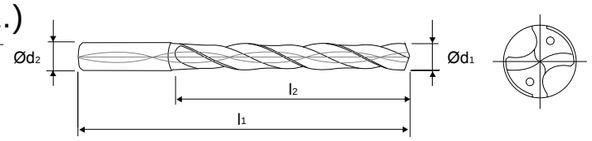
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM allgemeine Anwendung 5D
DIN6537 mit Innenkühlung TiALN

DIN 6537 | DIN 6535-HA | MG | h6 | m7 | 140°

Artikel Nr. 804323 (815.121.)



Anwendung:
Stahl, Stahlguss, Hart-und Temperguss,
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8043230100	1.0	3.0	8	55
8043230110	1.1	3.0	12	55
8043230120	1.2			
8043230130	1.3			
8043230140	1.4			
8043230150	1.5	3.0	16	55
8043230160	1.6			
8043230170	1.7			
8043230180	1.8			
8043230190	1.9			
8043230200	2.0	4.0	21	57
8043230210	2.1			
8043230220	2.2			
8043230230	2.3			
8043230240	2.4			
8043230250	2.5			
8043230260	2.6			
8043230270	2.7			
8043230280	2.8			
8043230290	2.9			
8043230300	3.0	6.0	28	66
8043230310	3.1			
8043230320	3.2			
8043230330	3.3			
8043230340	3.4			
8043230350	3.5			
8043230360	3.6			
8043230370	3.7			
8043230380	3.8	6.0	36	74
8043230390	3.9			
8043230400	4.0			
8043230410	4.1			

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8043230420	4.2	6.0	36	74
8043230430	4.3			
8043230440	4.4			
8043230450	4.5			
8043230460	4.6			
8043230470	4.7			
8043230480	4.8	6.0	44	82
8043230490	4.9			
8043230500	5.0			
8043230510	5.1			
8043230520	5.2			
8043230530	5.3			
8043230540	5.4			
8043230550	5.5			
8043230560	5.6			
8043230570	5.7			
8043230580	5.8			
8043230590	5.9			
8043230600	6.0			
8043230610	6.1	8.0	53	91
8043230620	6.2			
8043230630	6.3			
8043230640	6.4			
8043230650	6.5			
8043230660	6.6			
8043230670	6.7			
8043230680	6.8			
8043230690	6.9			
8043230700	7.0			
8043230710	7.1			
8043230720	7.2			
8043230730	7.3			

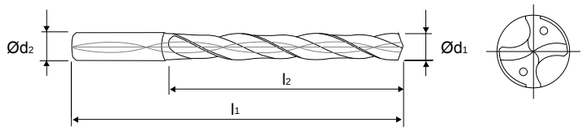
●:sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM allgemeine Anwendung 5D
DIN6537 mit Innenkühlung TiALN

DIN 6537 | DIN 6535-HA | MG | h6 | m7 | 140°

Artikel Nr. 804323 (815.121.)



Anwendung:
Stahl, Stahlguss, Hart-und Temperguss,
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8043230740	7.4	8.0	53	91
8043230750	7.5			
8043230760	7.6			
8043230770	7.7			
8043230780	7.8			
8043230790	7.9			
8043230800	8.0			
8043230810	8.1	10.0	61	103
8043230820	8.2			
8043230830	8.3			
8043230840	8.4			
8043230850	8.5			
8043230860	8.6			
8043230870	8.7			
8043230880	8.8			
8043230890	8.9			
8043230900	9.0			
8043230910	9.1			
8043230920	9.2			
8043230930	9.3			
8043230940	9.4			
8043230950	9.5			
8043230960	9.6			
8043230970	9.7			
8043230980	9.8			
8043230990	9.9			
8043231000	10.0			
8043231010	10.1	12.0	71	118
8043231020	10.2			
8043231030	10.3			
8043231040	10.4			
8043231050	10.5			

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8043231060	10.6	12.0	71	118
8043231070	10.7			
8043231080	10.8			
8043231090	10.9			
8043231100	11.0			
8043231110	11.1			
8043231120	11.2			
8043231130	11.3			
8043231140	11.4			
8043231150	11.5			
8043231160	11.6			
8043231170	11.7			
8043231180	11.8			
8043231190	11.9			
8043231200	12.0			
8043231250	12.5	14.0	77	124
8043231300	13.0			
8043231350	13.5			
8043231400	14.0			
8043231450	14.5	16.0	83	133
8043231500	15.0			
8043231550	15.5			
8043231600	16.0			
8043231650	16.5	18.0	93	143
8043231700	17.0			
8043231750	17.5			
8043231800	18.0			
8043231850	18.5	20.0	101	153
8043231900	19.0			
8043231950	19.5			
8043232000	20.0			

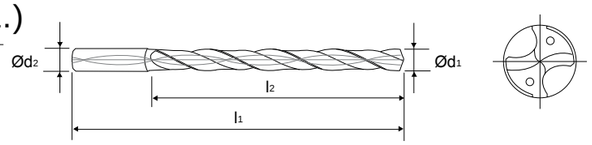
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM allgemeine Anwendung 8D
DIN6537 mit Innenkühlung TiALN

DIN 6537 | DIN 6535-HA | MG | h6 | m7 | 140°

Artikel Nr. 805323 (818.121.)



Anwendung:
Stahl, Stahlguss, Hart-undTemperguss
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8053230300	3.0	6.0	34	72
8053230310	3.1			
8053230320	3.2			
8053230330	3.3			
8053230340	3.4			
8053230350	3.5			
8053230360	3.6			
8053230370	3.7			
8053230380	3.8	6.0	43	81
8053230390	3.9			
8053230400	4.0			
8053230410	4.1			
8053230420	4.2			
8053230430	4.3			
8053230440	4.4			
8053230450	4.5			
8053230460	4.6			
8053230470	4.7			
8053230480	4.8	6.0	57	95
8053230490	4.9			
8053230500	5.0			
8053230510	5.1			
8053230520	5.2			

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8053230530	5.3	6.0	57	95
8053230540	5.4			
8053230550	5.5			
8053230560	5.6			
8053230570	5.7			
8053230580	5.8			
8053230590	5.9			
8053230600	6.0			
8053230610	6.1	8.0	76	114
8053230620	6.2			
8053230630	6.3			
8053230640	6.4			
8053230650	6.5			
8053230660	6.6			
8053230670	6.7			
8053230680	6.8			
8053230690	6.9			
8053230700	7.0			
8053230710	7.1			
8053230720	7.2			
8053230730	7.3			
8053230740	7.4			
8053230750	7.5			

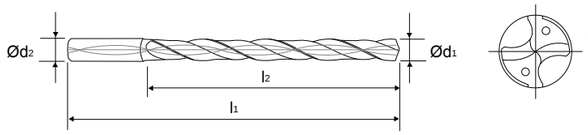
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM allgemeine Anwendung 8D
DIN6537 mit Innenkühlung TiALN

DIN 6537 | DIN 6535-HA | MG | h6 | m7 | 140°

Artikel Nr. 805323 (818.121.)



Anwendung
:Stahl, Stahlguss, Hart-undTemperguss
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8053230760	7.6	8.0	76	114
8053230770	7.7			
8053230780	7.8			
8053230790	7.9			
8053230800	8.0			
8053230810	8.1	10.0	95	142
8053230820	8.2			
8053230830	8.3			
8053230840	8.4			
8053230850	8.5			
8053230860	8.6			
8053230870	8.7			
8053230880	8.8			
8053230890	8.9			
8053230900	9.0			
8053230910	9.1			
8053230920	9.2			
8053230930	9.3			
8053230940	9.4			
8053230950	9.5			
8053230960	9.6			
8053230970	9.7			
8053230980	9.8			

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8053230990	9.9	10.0	95	142
8053231000	10.0			
8053231010	10.1	12.0	114	162
8053231020	10.2			
8053231030	10.3			
8053231040	10.4			
8053231050	10.5			
8053231060	10.6			
8053231070	10.7			
8053231080	10.8			
8053231090	10.9			
8053231100	11.0			
8053231110	11.1			
8053231120	11.2			
8053231130	11.3			
8053231140	11.4			
8053231150	11.5			
8053231160	11.6			
8053231170	11.7			
8053231180	11.8			
8053231190	11.9			
8053231200	12.0			

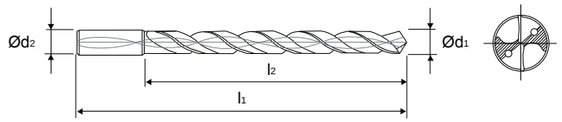
●: sehr gut **O**:gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM Tieflochbohrer TiALN 10D 15D 20D

MG | 15 ~20° | h6 | m7 | 140°

Artikel Nr.: 810323, 815323, 820323



Anwendung:
Stahl, Stahlguss, Hart-undTemperguss
Ne-Metalle, abrasiver Kunststoff

Hinweise :
Bohren ohne abzusetzen
selbstzentrierend
für minimale Schwierung (MQL) geeignet

10 X D

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8103230300	3.0	3.0	39	90
8103230330	3.3	4.0	46	97
8103230350	3.5	4.0	46	97
8103230400	4.0	4.0	52	103
8103230420	4.2	5.0	59	112
8103230450	4.5	5.0	59	112
8103230500	5.0	5.0	65	118
8103230550	5.5	6.0	72	127
8103230600	6.0	6.0	78	133
8103230650	6.5	7.0	85	141
8103230680	6.8	7.0	91	147
8103230700	7.0	7.0	91	147
8103230750	7.5	8.0	98	155
8103230800	8.0	8.0	104	161
8103230850	8.5	9.0	111	169
8103230900	9.0	9.0	117	175
8103230950	9.5	10.0	124	182
8103231000	10.0	10.0	130	188
8103231050	10.5	11.0	137	201
8103231100	11.0	11.0	143	207
8103231150	11.5	12.0	150	215
8103231200	12.0	12.0	156	221
8103231250	12.5	13.0	163	229
8103231300	13.0	13.0	169	235
8103231350	13.5	14.0	176	243
8103231400	14.0	14.0	182	249

15 X D

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8153230300	3.0	3.0	54	105
8153230350	3.5	4.0	63	114
8153230400	4.0	4.0	72	123
8153230450	4.5	5.0	81	134
8153230500	5.0	5.0	90	143
8153230550	5.5	6.0	99	154
8153230600	6.0	6.0	108	163
8153230700	7.0	7.0	126	182
8153230800	8.0	8.0	144	201
8153230900	9.0	9.0	162	220
8153231000	10.0	10.0	180	238
8153231100	11.0	11.0	198	262
8153231200	12.0	12.0	216	281

20 X D

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8203230300	3.0	3.0	69	120
8203230350	3.5	4.0	81	132
8203230400	4.0	4.0	92	143
8203230450	4.5	5.0	104	157
8203230500	5.0	5.0	115	168
8203230550	5.5	6.0	127	182
8203230600	6.0	6.0	138	193
8203230700	7.0	7.0	161	217
8203230800	8.0	8.0	184	241
8203230900	9.0	9.0	207	265
8203231000	10.0	10.0	230	288
8203231200	12.0	12.0	276	341

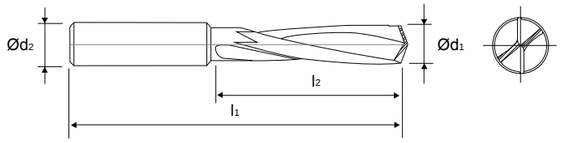
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM Bohrer TiALN bis 70 HRC

MG | h6 | m7 | 140°

Artikel Nr.: 821223



Anwendung:
Für hochfeste Stähle von 50 bis 70HRC geeignet

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8212230300	3.0	3	16	46
8212230330	3.3	4	18	48
8212230340	3.4	4	20	50
8212230350	3.5	4	20	50
8212230400	4.0	4	22	52
8212230420	4.2	6	25	65
8212230430	4.3	6	28	68
8212230440	4.4	6	28	68
8212230450	4.5	6	28	68
8212230500	5.0	6	32	72
8212230510	5.1	6	32	72
8212230520	5.2	6	32	72
8212230550	5.5	6	35	75
8212230600	6.0	6	35	75
8212230650	6.5	8	40	80
8212230680	6.8	8	45	85
8212230690	6.9	8	45	85

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8212230700	7.0	8	45	85
8212230750	7.5	8	45	85
8212230800	8.0	8	50	98
8212230850	8.5	10	50	98
8212230860	8.6	10	57	105
8212230880	8.8	10	57	105
8212230900	9.0	10	57	105
8212230950	9.5	10	57	105
8212231000	10.0	10	63	111
8212231020	10.2	12	63	111
8212231030	10.3	12	63	111
8212231050	10.5	12	63	111
8212231080	10.8	12	71	119
8212231100	11.0	12	71	119
8212231150	11.5	12	71	119
8212231200	12.0	12	71	119
8212231400	14.0	14	77	125

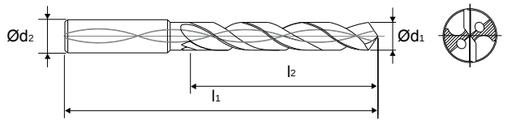
●: sehr gut **O**:gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
		●													
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
		●													

VHM Aluminium 3D DIN6537 mit Innenkühlung

DIN 6537 | MG | h6 | m7 | 118°

Artikel Nr. 843303 (833.121.)



Anwendung:
Für Aluminium und Aluminium Legierungen

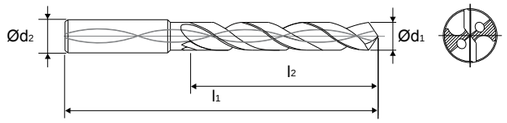
CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8433030300	3.0	6.0	20	62
8433030310	3.1	6.0	20	62
8433030320	3.2	6.0	20	62
8433030330	3.3	6.0	20	62
8433030340	3.4	6.0	20	62
8433030350	3.5	6.0	20	62
8433030360	3.6	6.0	20	62
8433030370	3.7	6.0	20	62
8433030380	3.8	6.0	24	66
8433030390	3.9	6.0	24	66
8433030400	4.0	6.0	24	66
8433030410	4.1	6.0	24	66
8433030420	4.2	6.0	24	66
8433030430	4.3	6.0	24	66
8433030440	4.4	6.0	24	66
8433030450	4.5	6.0	24	66
8433030460	4.6	6.0	24	66
8433030470	4.7	6.0	24	66
8433030480	4.8	6.0	28	66
8433030490	4.9	6.0	28	66
8433030500	5.0	6.0	28	66
8433030510	5.1	6.0	28	66
8433030520	5.2	6.0	28	66
8433030530	5.3	6.0	28	66
8433030540	5.4	6.0	28	66
8433030550	5.5	6.0	28	66
8433030560	5.6	6.0	28	66
8433030570	5.7	6.0	28	66
8433030580	5.8	6.0	28	66
8433030590	5.9	6.0	28	66
8433030600	6.0	6.0	28	66

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8433030610	6.1	8.0	34	79
8433030620	6.2	8.0	34	79
8433030630	6.3	8.0	34	79
8433030640	6.4	8.0	34	79
8433030650	6.5	8.0	34	79
8433030660	6.6	8.0	34	79
8433030670	6.7	8.0	34	79
8433030680	6.8	8.0	34	79
8433030690	6.9	8.0	34	79
8433030700	7.0	8.0	34	79
8433030710	7.1	8.0	41	79
8433030720	7.2	8.0	41	79
8433030730	7.3	8.0	41	79
8433030740	7.4	8.0	41	79
8433030750	7.5	8.0	41	79
8433030760	7.6	8.0	41	79
8433030770	7.7	8.0	41	79
8433030780	7.8	8.0	41	79
8433030790	7.9	8.0	41	79
8433030800	8.0	8.0	41	79
8433030810	8.1	10.0	47	89
8433030820	8.2	10.0	47	89
8433030830	8.3	10.0	47	89
8433030840	8.4	10.0	47	89
8433030850	8.5	10.0	47	89
8433030860	8.6	10.0	47	89
8433030870	8.7	10.0	47	89
8433030880	8.8	10.0	47	89
8433030890	8.9	10.0	47	89
8433030900	9.0	10.0	47	89
8433030910	9.1	10.0	47	89

●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
										●	●	●	●		

VHM Aluminium 3D DIN6537 mit Innenkühlung



DIN 6537 | MG | h6 | m7 | 118°

Artikel Nr. 843303 (833.121.)

Anwendung:
Für Aluminium und Aluminium Legierungen

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8433030920	9.2	10.0	47	89
8433030930	9.3	10.0	47	89
8433030940	9.4	10.0	47	89
8433030950	9.5	10.0	47	89
8433030960	9.6	10.0	47	89
8433030970	9.7	10.0	47	89
8433030980	9.8	10.0	47	89
8433030990	9.9	10.0	47	89
8433031000	10.0	10.0	47	89
8433031010	10.1	12.0	55	102
8433031020	10.2	12.0	55	102
8433031030	10.3	12.0	55	102
8433031040	10.4	12.0	55	102
8433031050	10.5	12.0	55	102
8433031060	10.6	12.0	55	102
8433031070	10.7	12.0	55	102
8433031080	10.8	12.0	55	102
8433031090	10.9	12.0	55	102
8433031100	11.0	12.0	55	102
8433031110	11.1	12.0	55	102
8433031120	11.2	12.0	55	102
8433031130	11.3	12.0	55	102
8433031140	11.4	12.0	55	102

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8433031150	11.5	12.0	55	102
8433031160	11.6	12.0	55	102
8433031170	11.7	12.0	55	102
8433031180	11.8	12.0	55	102
8433031190	11.9	12.0	55	102
8433031200	12.0	12.0	55	102
8433031250	12.5	14.0	60	107
8433031300	13.0	14.0	60	107
8433031350	13.5	14.0	60	107
8433031400	14.0	14.0	60	107
8433031450	14.5	16.0	65	115
8433031500	15.0	16.0	65	115
8433031550	15.5	16.0	65	115
8433031600	16.0	16.0	65	115
8433031650	16.5	18.0	73	123
8433031700	17.0	18.0	73	123
8433031750	17.5	18.0	73	123
8433031800	18.0	18.0	73	123
8433031850	18.5	20.0	79	131
8433031900	19.0	20.0	79	131
8433031950	19.5	20.0	79	131
8433032000	20.0	20.0	79	131

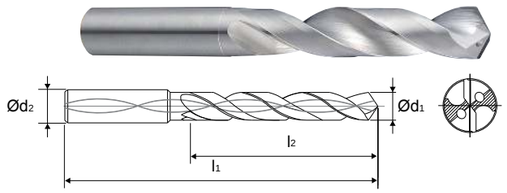
●: sehr gut **O**:gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
										●	●	●	●		

VHM Aluminium 5D DIN6537 mit Innenkühlung

DIN 6537 | MG | h6 | m7 | 118°

Artikel Nr. 845303 (835.121.)



Anwendung:
Für Aluminium und Aluminium Legierungen

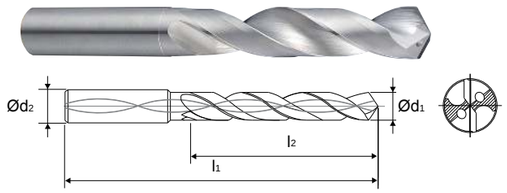
CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8453030300	3.0	6.0	28	66
8453030310	3.1	6.0	28	66
8453030320	3.2	6.0	28	66
8453030330	3.3	6.0	28	66
8453030340	3.4	6.0	28	66
8453030350	3.5	6.0	28	66
8453030360	3.6	6.0	28	66
8453030370	3.7	6.0	28	66
8453030380	3.8	6.0	36	74
8453030390	3.9	6.0	36	74
8453030400	4.0	6.0	36	74
8453030410	4.1	6.0	36	74
8453030420	4.2	6.0	36	74
8453030430	4.3	6.0	36	74
8453030440	4.4	6.0	36	74
8453030450	4.5	6.0	36	74
8453030460	4.6	6.0	36	74
8453030470	4.7	6.0	36	74
8453030480	4.8	6.0	44	82
8453030490	4.9	6.0	44	82
8453030500	5.0	6.0	44	82
8453030510	5.1	6.0	44	82
8453030520	5.2	6.0	44	82
8453030530	5.3	6.0	44	82
8453030540	5.4	6.0	44	82
8453030550	5.5	6.0	44	82
8453030560	5.6	6.0	44	82
8453030570	5.7	6.0	44	82
8453030580	5.8	6.0	44	82
8453030590	5.9	6.0	44	82
8453030600	6.0	6.0	44	82

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8453030610	6.1	8.0	53	91
8453030620	6.2	8.0	53	91
8453030630	6.3	8.0	53	91
8453030640	6.4	8.0	53	91
8453030650	6.5	8.0	53	91
8453030660	6.6	8.0	53	91
8453030670	6.7	8.0	53	91
8453030680	6.8	8.0	53	91
8453030690	6.9	8.0	53	91
8453030700	7.0	8.0	53	91
8453030710	7.1	8.0	53	91
8453030720	7.2	8.0	53	91
8453030730	7.3	8.0	53	91
8453030740	7.4	8.0	53	91
8453030750	7.5	8.0	53	91
8453030760	7.6	8.0	53	91
8453030770	7.7	8.0	53	91
8453030780	7.8	8.0	53	91
8453030790	7.9	8.0	53	91
8453030800	8.0	8.0	53	91
8453030810	8.1	10.0	61	103
8453030820	8.2	10.0	61	103
8453030830	8.3	10.0	61	103
8453030840	8.4	10.0	61	103
8453030850	8.5	10.0	61	103
8453030860	8.6	10.0	61	103
8453030870	8.7	10.0	61	103
8453030880	8.8	10.0	61	103
8453030890	8.9	10.0	61	103
8453030900	9.0	10.0	61	103
8453030910	9.1	10.0	61	103

●:sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
										●	●	●	●		

VHM Aluminium 5D DIN6537 mit Innenkühlung



DIN 6537 | MG | h6 | m7 | 118°

Artikel Nr. 845303 (835.121.)

Anwendung:
Für Aluminium und Aluminium Legierungen

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8453030920	9.2	10.0	61	103
8453030930	9.3	10.0	61	103
8453030940	9.4	10.0	61	103
8453030950	9.5	10.0	61	103
8453030960	9.6	10.0	61	103
8453030970	9.7	10.0	61	103
8453030980	9.8	10.0	61	103
8453030990	9.9	10.0	61	103
8453031000	10.0	10.0	61	103
8453031010	10.1	12.0	71	118
8453031020	10.2	12.0	71	118
8453031030	10.3	12.0	71	118
8453031040	10.4	12.0	71	118
8453031050	10.5	12.0	71	118
8453031060	10.6	12.0	71	118
8453031070	10.7	12.0	71	118
8453031080	10.8	12.0	71	118
8453031090	10.9	12.0	71	118
8453031100	11.0	12.0	71	118
8453031110	11.1	12.0	71	118
8453031120	11.2	12.0	71	118
8453031130	11.3	12.0	71	118
8453031140	11.4	12.0	71	118

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8453031150	11.5	12.0	71	118
8453031160	11.6	12.0	71	118
8453031170	11.7	12.0	71	118
8453031180	11.8	12.0	71	118
8453031190	11.9	12.0	71	118
8453031200	12.0	12.0	71	118
8453031250	12.5	14.0	77	124
8453031300	13.0	14.0	77	124
8453031350	13.5	14.0	77	124
8453031400	14.0	14.0	77	124
8453031450	14.5	16.0	83	133
8453031500	15.0	16.0	83	133
8453031550	15.5	16.0	83	133
8453031600	16.0	16.0	83	133
8453031650	16.5	18.0	93	143
8453031700	17.0	18.0	93	143
8453031750	17.5	18.0	93	143
8453031800	18.0	18.0	93	143
8453031850	18.5	20.0	101	153
8453031900	19.0	20.0	101	153
8453031950	19.5	20.0	101	153
8453032000	20.0	20.0	101	153

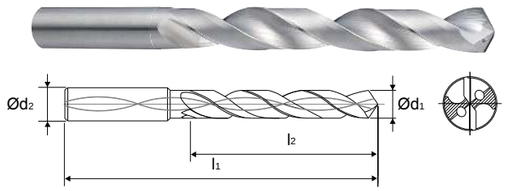
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
										●	●	●	●		

VHM Aluminium 8D DIN6537 mit Innenkühlung

DIN 6537 | MG | h6 | m7 | 118°

Artikel Nr. 848303 (838.121.)



Anwendung:
Für Aluminium und Aluminium Legierungen

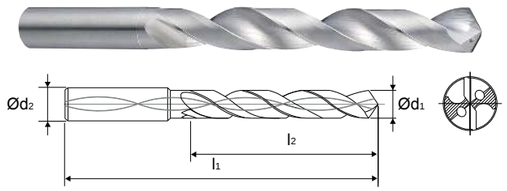
CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8483030300	3.0	6.0	34	72
8483030310	3.1	6.0	34	72
8483030320	3.2	6.0	34	72
8483030330	3.3	6.0	34	72
8483030340	3.4	6.0	34	72
8483030350	3.5	6.0	34	72
8483030360	3.6	6.0	34	72
8483030370	3.7	6.0	34	72
8483030380	3.8	6.0	43	81
8483030390	3.9	6.0	43	81
8483030400	4.0	6.0	43	81
8483030410	4.1	6.0	43	81
8483030420	4.2	6.0	43	81
8483030430	4.3	6.0	43	81
8483030440	4.4	6.0	43	81
8483030450	4.5	6.0	43	81
8483030460	4.6	6.0	43	81
8483030470	4.7	6.0	43	81
8483030480	4.8	6.0	57	95
8483030490	4.9	6.0	57	95
8483030500	5.0	6.0	57	95
8483030510	5.1	6.0	57	95
8483030520	5.2	6.0	57	95
8483030530	5.3	6.0	57	95
8483030540	5.4	6.0	57	95
8483030550	5.5	6.0	57	95
8483030560	5.6	6.0	57	95
8483030570	5.7	6.0	57	95
8483030580	5.8	6.0	57	95
8483030590	5.9	6.0	57	95
8483030600	6.0	6.0	57	95

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8483030610	6.1	8.0	76	114
8483030620	6.2	8.0	76	114
8483030630	6.3	8.0	76	114
8483030640	6.4	8.0	76	114
8483030650	6.5	8.0	76	114
8483030660	6.6	8.0	76	114
8483030670	6.7	8.0	76	114
8483030680	6.8	8.0	76	114
8483030690	6.9	8.0	76	114
8483030700	7.0	8.0	76	114
8483030710	7.1	8.0	76	114
8483030720	7.2	8.0	76	114
8483030730	7.3	8.0	76	114
8483030740	7.4	8.0	76	114
8483030750	7.5	8.0	76	114
8483030760	7.6	8.0	76	114
8483030770	7.7	8.0	76	114
8483030780	7.8	8.0	76	114
8483030790	7.9	8.0	76	114
8483030800	8.0	8.0	76	114
8483030810	8.1	10.0	95	142
8483030820	8.2	10.0	95	142
8483030830	8.3	10.0	95	142
8483030840	8.4	10.0	95	142
8483030850	8.5	10.0	95	142
8483030860	8.6	10.0	95	142
8483030870	8.7	10.0	95	142
8483030880	8.8	10.0	95	142
8483030890	8.9	10.0	95	142
8483030900	9.0	10.0	95	142
8483030910	9.1	10.0	95	142

●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
										●	●	●	●		

VHM Aluminium 8D DIN6537 mit Innenkühlung



DIN 6537 | MG | h6 | m7 | 118°

Artikel Nr. 848303 (838.121.)

Anwendung:
Für Aluminium und Aluminium Legierungen

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8483030920	9.2	10.0	95	142
8483030930	9.3	10.0	95	142
8483030940	9.4	10.0	95	142
8483030950	9.5	10.0	95	142
8483030960	9.6	10.0	95	142
8483030970	9.7	10.0	95	142
8483030980	9.8	10.0	95	142
8483030990	9.9	10.0	95	142
8483031000	10.0	10.0	95	142
8483031010	10.1	12.0	114	162
8483031020	10.2	12.0	114	162
8483031030	10.3	12.0	114	162
8483031040	10.4	12.0	114	162
8483031050	10.5	12.0	114	162
8483031060	10.6	12.0	114	162
8483031070	10.7	12.0	114	162
8483031080	10.8	12.0	114	162

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8483031090	10.9	12.0	114	162
8483031100	11.0	12.0	114	162
8483031110	11.1	12.0	114	162
8483031120	11.2	12.0	114	162
8483031130	11.3	12.0	114	162
8483031140	11.4	12.0	114	162
8483031150	11.5	12.0	114	162
8483031160	11.6	12.0	114	162
8483031170	11.7	12.0	114	162
8483031180	11.8	12.0	114	162
8483031190	11.9	12.0	114	162
8483031200	12.0	12.0	114	162
8483031250	12.5	14.0	133	178
8483031300	13.0	14.0	133	178
8483031350	13.5	14.0	133	178
8483031400	14.0	14.0	133	178

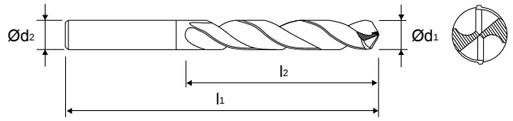
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
										●	●	●	●		

VHM CFK Bohrer DIN6537 Diamantbeschichtet

DIN 6537 | MG | h6 | m7 | 118°

Artikel Nr. 850390



Anwendung:
Composit Materialien

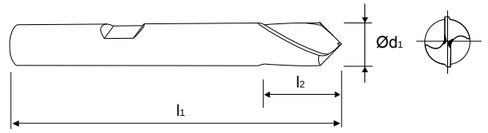
CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8503900250	2.5	6.0	24	66
8503900300	3.0	6.0	28	66
8503900400	4.0	6.0	36	74
8503900500	5.0	6.0	44	82
8503900600	6.0	6.0	44	82
8503900800	8.0	8.0	53	91
8503900900	9.0	10.0	61	103
8503901000	10.0	10.0	61	103
8503901100	11.0	12.0	71	118
8503901200	12.0	12.0	71	118

●:sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
														●	

VHM NC-Anbohrer 90° und 120°

MG | DIN 6535HB | h6 | 90° | 120°



Anwendung:
hochfeste Stähle, Stahlguss, Grauguss, Hartguss, CrNi Stähle, Buntmetalle

Artikel Nr. 90° = 806303 (C180VHM)
120° = 806403 (C181VHM)

CODE 90°	CODE 120°	O.D d_1	FL l_2	OAL l_1
8063030600	**8064030600**	6.0	13	50
8063030800	**8064030800**	8.0	23	60
8063031000	**8064031000**	10.0	24	70
8063031200	**8064031200**	12.0		
8063031600	**8064031600**	16.0	29	75
8063032000	**8064032000**	20.0	35	100

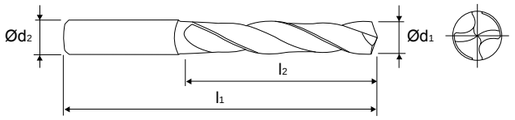
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
O	**O**		**O**	**O**	**O**	**O**	**O**	**O**							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
O	**O**				**O**	**O**	**O**	**O**		**O**	**O**	**O**	**O**		

VHM Bohrer 3D TiALN

DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr. 807323 (813.021.)

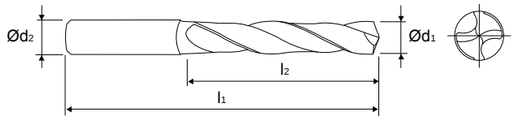


Anwendung:
Stahl,Stahlguss,Hart-und Temperguss
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8073230300	3.0	6.0	20	62
8073230310	3.1	6.0	20	62
8073230320	3.2	6.0	20	62
8073230330	3.3	6.0	20	62
8073230340	3.4	6.0	20	62
8073230350	3.5	6.0	20	62
8073230360	3.6	6.0	20	62
8073230370	3.7	6.0	20	62
8073230380	3.8	6.0	24	66
8073230390	3.9	6.0	24	66
8073230400	4.0	6.0	24	66
8073230410	4.1	6.0	24	66
8073230420	4.2	6.0	24	66
8073230430	4.3	6.0	24	66
8073230440	4.4	6.0	24	66
8073230450	4.5	6.0	24	66
8073230460	4.6	6.0	24	66
8073230470	4.7	6.0	24	66
8073230480	4.8	6.0	28	66
8073230490	4.9	6.0	28	66
8073230500	5.0	6.0	28	66
8073230510	5.1	6.0	28	66
8073230520	5.2	6.0	28	66
8073230530	5.3	6.0	28	66
8073230540	5.4	6.0	28	66
8073230550	5.5	6.0	28	66
8073230560	5.6	6.0	28	66
8073230570	5.7	6.0	28	66
8073230580	5.8	6.0	28	66
8073230590	5.9	6.0	28	66
8073230600	6.0	6.0	28	66

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8073230610	6.1	8.0	34	79
8073230620	6.2	8.0	34	79
8073230630	6.3	8.0	34	79
8073230640	6.4	8.0	34	79
8073230650	6.5	8.0	34	79
8073230660	6.6	8.0	34	79
8073230670	6.7	8.0	34	79
8073230680	6.8	8.0	34	79
8073230690	6.9	8.0	34	79
8073230700	7.0	8.0	34	79
8073230710	7.1	8.0	41	79
8073230720	7.2	8.0	41	79
8073230730	7.3	8.0	41	79
8073230740	7.4	8.0	41	79
8073230750	7.5	8.0	41	79
8073230760	7.6	8.0	41	79
8073230770	7.7	8.0	41	79
8073230780	7.8	8.0	41	79
8073230790	7.9	8.0	41	79
8073230800	8.0	8.0	41	79
8073230810	8.1	10.0	47	89
8073230820	8.2	10.0	47	89
8073230830	8.3	10.0	47	89
8073230840	8.4	10.0	47	89
8073230850	8.5	10.0	47	89
8073230860	8.6	10.0	47	89
8073230870	8.7	10.0	47	89
8073230880	8.8	10.0	47	89
8073230890	8.9	10.0	47	89
8073230900	9.0	10.0	47	89
8073230910	9.1	10.0	47	89

VHM Bohrer 3D TiALN



DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr. 807323 (813.021.)

Anwendung:
Stahl,Stahlguss,Hart-und Temperguss
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8073230920	9.2	10.0	47	89
8073230930	9.3	10.0	47	89
8073230940	9.4	10.0	47	89
8073230950	9.5	10.0	47	89
8073230960	9.6	10.0	47	89
8073230970	9.7	10.0	47	89
8073230980	9.8	10.0	47	89
8073230990	9.9	10.0	47	89
8073231000	10.0	10.0	47	89
8073231010	10.1	12.0	55	102
8073231020	10.2	12.0	55	102
8073231030	10.3	12.0	55	102
8073231040	10.4	12.0	55	102
8073231050	10.5	12.0	55	102
8073231060	10.6	12.0	55	102
8073231070	10.7	12.0	55	102
8073231080	10.8	12.0	55	102
8073231090	10.9	12.0	55	102
8073231100	11.0	12.0	55	102
8073231110	11.1	12.0	55	102
8073231120	11.2	12.0	55	102
8073231130	11.3	12.0	55	102
8073231140	11.4	12.0	55	102
8073231150	11.5	12.0	55	102
8073231160	11.6	12.0	55	102
8073231170	11.7	12.0	55	102
8073231180	11.8	12.0	55	102

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8073231190	11.9	12.0	55	102
8073231200	12.0	12.0	55	102
8073231230	12.3	14.0	60	107
8073231250	12.5	14.0	60	107
8073231280	12.8	14.0	60	107
8073231300	13.0	14.0	60	107
8073231350	13.5	14.0	60	107
8073231380	13.8	14.0	60	107
8073231400	14.0	14.0	60	107
8073231450	14.5	16.0	65	115
8073231480	14.8	16.0	65	115
8073231500	15.0	16.0	65	115
8073231550	15.5	16.0	65	115
8073231580	15.8	16.0	65	115
8073231600	16.0	16.0	65	115
8073231650	16.5	18.0	73	123
8073231680	16.8	18.0	73	123
8073231700	17.0	18.0	73	123
8073231750	17.5	18.0	73	123
8073231780	17.8	18.0	73	123
8073231800	18.0	18.0	73	123
8073231850	18.5	20.0	79	131
8073231900	19.0	20.0	79	131
8073231950	19.5	20.0	79	131
8073231980	19.8	20.0	79	131
8073232000	20.0	20.0	79	131

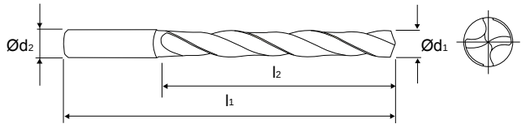
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM Bohrer 5D TiALN

DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr. 808323 (815.021.)



Anwendung:
Stahl, Stahlguss, Hart-und Temperguss
Ne-Metalle, abrasiver Kunststoff

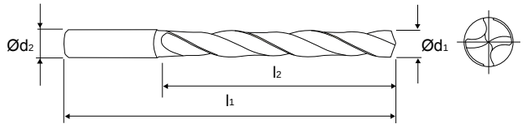
CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8083230100	1.0	3.0	8	55
8083230110	1.1	3.0	12	55
8083230120	1.2	3.0	12	55
8083230130	1.3	3.0	12	55
8083230140	1.4	3.0	12	55
8083230150	1.5	3.0	16	55
8083230160	1.6	3.0	16	55
8083230170	1.7	3.0	16	55
8083230180	1.8	3.0	16	55
8083230190	1.9	3.0	16	55
8083230200	2.0	4.0	21	57
8083230210	2.1	4.0	21	57
8083230220	2.2	4.0	21	57
8083230230	2.3	4.0	21	57
8083230240	2.4	4.0	21	57
8083230250	2.5	4.0	21	57
8083230260	2.6	4.0	21	57
8083230270	2.7	4.0	21	57
8083230280	2.8	4.0	21	57
8083230290	2.9	4.0	21	57
8083230300	3.0	6.0	28	66
8083230310	3.1	6.0	28	66
8083230320	3.2	6.0	28	66
8083230330	3.3	6.0	28	66
8083230340	3.4	6.0	28	66
8083230350	3.5	6.0	28	66
8083230360	3.6	6.0	28	66
8083230370	3.7	6.0	28	66
8083230380	3.8	6.0	36	74
8083230390	3.9	6.0	36	74
8083230400	4.0	6.0	36	74
8083230410	4.1	6.0	36	74
8083230420	4.2	6.0	36	74
8083230430	4.3	6.0	36	74
8083230440	4.4	6.0	36	74
8083230450	4.5	6.0	36	74

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8083230460	4.6	6.0	36	74
8083230470	4.7	6.0	36	74
8083230480	4.8	6.0	44	82
8083230490	4.9	6.0	44	82
8083230500	5.0	6.0	44	82
8083230510	5.1	6.0	44	82
8083230520	5.2	6.0	44	82
8083230530	5.3	6.0	44	82
8083230540	5.4	6.0	44	82
8083230550	5.5	6.0	44	82
8083230560	5.6	6.0	44	82
8083230570	5.7	6.0	44	82
8083230580	5.8	6.0	44	82
8083230590	5.9	6.0	44	82
8083230600	6.0	6.0	44	82
8083230610	6.1	8.0	53	91
8083230620	6.2	8.0	53	91
8083230630	6.3	8.0	53	91
8083230640	6.4	8.0	53	91
8083230650	6.5	8.0	53	91
8083230660	6.6	8.0	53	91
8083230670	6.7	8.0	53	91
8083230680	6.8	8.0	53	91
8083230690	6.9	8.0	53	91
8083230700	7.0	8.0	53	91
8083230710	7.1	8.0	53	91
8083230720	7.2	8.0	53	91
8083230730	7.3	8.0	53	91
8083230740	7.4	8.0	53	91
8083230750	7.5	8.0	53	91
8083230760	7.6	8.0	53	91
8083230770	7.7	8.0	53	91
8083230780	7.8	8.0	53	91
8083230790	7.9	8.0	53	91
8083230800	8.0	8.0	53	91
8083230810	8.1	10.0	61	103

VHM Bohrer 5D TiALN

DIN 6537 | MG | h6 | m7 | 140°

Artikel Nr. 808323 (815.021.)



Anwendung:
Stahl, Stahlguss, Hart-und Temperguss
Ne-Metalle, abrasiver Kunststoff

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8083230820	8.2	10.0	61	103
8083230830	8.3	10.0	61	103
8083230840	8.4	10.0	61	103
8083230850	8.5	10.0	61	103
8083230860	8.6	10.0	61	103
8083230870	8.7	10.0	61	103
8083230880	8.8	10.0	61	103
8083230890	8.9	10.0	61	103
8083230900	9.0	10.0	61	103
8083230910	9.1	10.0	61	103
8083230920	9.2	10.0	61	103
8083230930	9.3	10.0	61	103
8083230940	9.4	10.0	61	103
8083230950	9.5	10.0	61	103
8083230960	9.6	10.0	61	103
8083230970	9.7	10.0	61	103
8083230980	9.8	10.0	61	103
8083230990	9.9	10.0	61	103
8083231000	10.0	10.0	61	103
8083231010	10.1	12.0	71	118
8083231020	10.2	12.0	71	118
8083231030	10.3	12.0	71	118
8083231040	10.4	12.0	71	118
8083231050	10.5	12.0	71	118
8083231060	10.6	12.0	71	118
8083231070	10.7	12.0	71	118
8083231080	10.8	12.0	71	118
8083231090	10.9	12.0	71	118
8083231100	11.0	12.0	71	118
8083231110	11.1	12.0	71	118
8083231120	11.2	12.0	71	118
8083231130	11.3	12.0	71	118

CODE	O.D d_1	S.D d_2	FL l_2	OAL l_1
8083231140	11.4	12.0	71	118
8083231150	11.5	12.0	71	118
8083231160	11.6	12.0	71	118
8083231170	11.7	12.0	71	118
8083231180	11.8	12.0	71	118
8083231190	11.9	12.0	71	118
8083231200	12.0	12.0	71	118
8083231230	12.3	14.0	77	124
8083231250	12.5	14.0	77	124
8083231280	12.8	14.0	77	124
8083231300	13.0	14.0	77	124
8083231350	13.5	14.0	77	124
8083231380	13.8	14.0	77	124
8083231400	14.0	14.0	77	124
8083231450	14.5	16.0	83	133
8083231480	14.8	16.0	83	133
8083231500	15.0	16.0	83	133
8083231550	15.5	16.0	83	133
8083231580	15.8	16.0	83	133
8083231600	16.0	16.0	83	133
8083231650	16.5	18.0	93	143
8083231680	16.8	18.0	93	143
8083231700	17.0	18.0	93	143
8083231750	17.5	18.0	93	143
8083231780	17.8	18.0	93	143
8083231800	18.0	18.0	93	143
8083231850	18.5	20.0	101	153
8083231900	19.0	20.0	101	153
8083231950	19.5	20.0	101	153
8083231980	19.8	20.0	101	153
8083232000	20.0	20.0	101	153

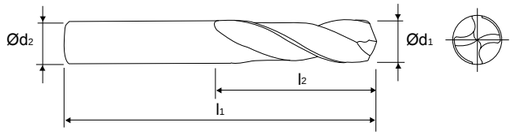
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM Bohrer TiALN DIN6539

DIN 6539 | MG | h6 | h7 | 140°

Artikel Nr. 802323



Anwendung:
Stahl, Stahlguss, Hart-und Temperguss
Ne-Metalle, abrasiver Kunststoff

Hinweis:
Selbstzentrierend

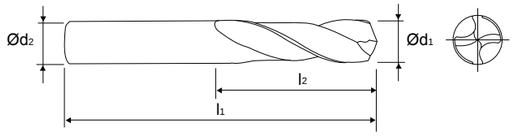
CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8023230300	3.0	16	46
8023230310	3.1	18	49
8023230320	3.2		
8023230330	3.3		
8023230340	3.4	20	52
8023230350	3.5		
8023230360	3.6		
8023230370	3.7		
8023230380	3.8	22	55
8023230390	3.9		
8023230400	4.0		
8023230410	4.1		
8023230420	4.2		
8023230430	4.3	24	58
8023230440	4.4		
8023230450	4.5		
8023230460	4.6		
8023230470	4.7		
8023230480	4.8	26	62
8023230490	4.9		
8023230500	5.0		
8023230510	5.1		
8023230520	5.2		

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8023230530	5.3	26	62
8023230540	5.4	28	66
8023230550	5.5		
8023230560	5.6		
8023230570	5.7		
8023230580	5.8		
8023230590	5.9		
8023230600	6.0		
8023230610	6.1	31	70
8023230620	6.2		
8023230630	6.3		
8023230640	6.4		
8023230650	6.5		
8023230660	6.6		
8023230670	6.7		
8023230680	6.8	34	74
8023230690	6.9		
8023230700	7.0		
8023230710	7.1		
8023230720	7.2		
8023230730	7.3		
8023230740	7.4		
8023230750	7.5		

●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM Bohrer TiALN DIN6539



DIN 6539 | MG | h6 | h7 | 140°

Artikel Nr. 802323

Anwendung:
Stahl, Stahlguss, Hart-und Temperguss
Ne-Metalle, abrasiver Kunststoff

Hinweis:
Selbstzentrierend

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8023230760	7.6	37	79
8023230770	7.7		
8023230780	7.8		
8023230790	7.9		
8023230800	8.0		
8023230810	8.1		
8023230820	8.2		
8023230830	8.3		
8023230840	8.4		
8023230850	8.5		
8023230860	8.6	40	84
8023230870	8.7		
8023230880	8.8		
8023230890	8.9		
8023230900	9.0		
8023230910	9.1		
8023230920	9.2		
8023230930	9.3		
8023230940	9.4		
8023230950	9.5		
8023230960	9.6	43	89
8023230970	9.7		
8023230980	9.8		

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8023230990	9.9	43	89
8023231000	10.0		
8023231020	10.2		
8023231050	10.5		
8023231100	11.0	47	95
8023231150	11.5		
8023231200	12.0	51	102
8023231300	13.0		
8023231350	13.5	54	107
8023231400	14.0		
8023231450	14.5	56	111
8023231500	15.0		
8023231550	15.5	58	115
8023231600	16.0		
8023231650	16.5	60	119
8023231700	17.0		
8023231750	17.5	62	123
8023231800	18.0		
8023231850	18.5	64	127
8023231900	19.0		
8023231950	19.5	66	131
8023232000	20.0		

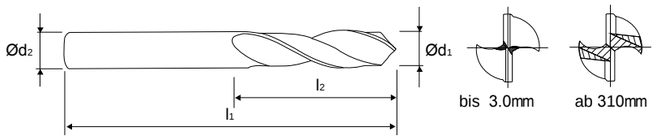
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●				●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●									

VHM Bohrer extra kurz DIN6539

DIN 6539 | MG | h6 | h7 | 118°

Artikel Nr. 800303



Anwendung:
Stahl, Stahlguss, Hart-und Temperguss
Ne-Metalle, abrasiver Kunststoff

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8003030100	1.0	6	26
8003030110	1.1	7	28
8003030120	1.2	8	30
8003030130	1.3		
8003030140	1.4	9	32
8003030150	1.5		
8003030160	1.6	10	34
8003030170	1.7		
8003030180	1.8	11	36
8003030190	1.9		
8003030200	2.0	12	38
8003030210	2.1		
8003030220	2.2	13	40
8003030230	2.3		
8003030240	2.4	14	43
8003030250	2.5		
8003030260	2.6		
8003030270	2.7	16	46
8003030280	2.8		
8003030290	2.9		
8003030300	3.0		
8003030310	3.1	18	49
8003030320	3.2		
8003030330	3.3		
8003030340	3.4	20	52
8003030350	3.5		
8003030360	3.6		
8003030370	3.7		
8003030380	3.8		
8003030390	3.9	22	55
8003030400	4.0		

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8003030410	4.1	22	55
8003030420	4.2		
8003030430	4.3	24	58
8003030440	4.4		
8003030450	4.5		
8003030460	4.6		
8003030470	4.7		
8003030480	4.8	26	62
8003030490	4.9		
8003030500	5.0		
8003030510	5.1		
8003030520	5.2		
8003030530	5.3		
8003030540	5.4	28	66
8003030550	5.5		
8003030560	5.6		
8003030570	5.7		
8003030580	5.8		
8003030590	5.9		
8003030600	6.0		
8003030610	6.1	31	70
8003030620	6.2		
8003030630	6.3		
8003030640	6.4		
8003030650	6.5		
8003030660	6.6		
8003030670	6.7		

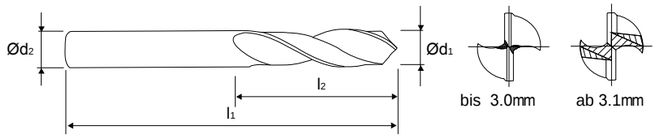
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		O	O	●	●	O	O							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	O	O		O	O	O	O		

VHM Bohrer extra kurz DIN6539

DIN 6539 | MG | h6 | h7 | 118°

Artikel Nr. 800303



Anwendung:
Stahl, Stahlguss, Hart-und TempergussNe-
Metalle, abrasiver Kunststoff

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8003030680	6.8	34	74
8003030690	6.9		
8003030700	7.0		
8003030710	7.1		
8003030720	7.2		
8003030730	7.3		
8003030740	7.4		
8003030750	7.5		
8003030760	7.6	37	79
8003030770	7.7		
8003030780	7.8		
8003030790	7.9		
8003030800	8.0		
8003030810	8.1		
8003030820	8.2		
8003030830	8.3		
8003030840	8.4		
8003030850	8.5		
8003030860	8.6	40	84
8003030870	8.7		

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8003030880	8.8	40	84
8003030890	8.9		
8003030900	9.0		
8003030910	9.1		
8003030920	9.2		
8003030930	9.3		
8003030940	9.4		
8003030950	9.5		
8003030960	9.6	43	89
8003030970	9.7		
8003030980	9.8		
8003030990	9.9		
8003031000	10.0		
8003031020	10.2		
8003031050	10.5		
8003031100	11.0	47	95
8003031150	11.5		
8003031200	12.0	51	102
8003031300	13.0		

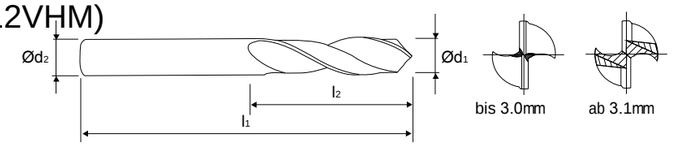
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		O	O	●	●	O	O							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	O	O		O	O	O	O		

VHM Bohrer DIN338

DIN 338 | MG | h6 | h7 | 118°

Artikel Nr. 801303 (C112VHM)



Anwendung:
Stahl, Stahlguss, Hart-undTemperguss
Ne-Metalle, abrasiver Kunststoff

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8013030100	1.0	12	34
8013030110	1.1	14	36
8013030120	1.2	16	38
8013030130	1.3		
8013030140	1.4	18	40
8013030150	1.5		
8013030160	1.6	20	43
8013030170	1.7		
8013030180	1.8	22	46
8013030190	1.9		
8013030200	2.0	24	49
8013030210	2.1		
8013030220	2.2	27	53
8013030230	2.3		
8013030240	2.4	30	57
8013030250	2.5		
8013030260	2.6		

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8013030270	2.7	33	61
8013030280	2.8		
8013030290	2.9		
8013030300	3.0		
8013030310	3.1	36	65
8013030320	3.2		
8013030330	3.3		
8013030340	3.4	39	70
8013030350	3.5		
8013030360	3.6		
8013030370	3.7		
8013030380	3.8	43	75
8013030390	3.9		
8013030400	4.0		
8013030410	4.1		
8013030420	4.2		
8013030430	4.3	47	80

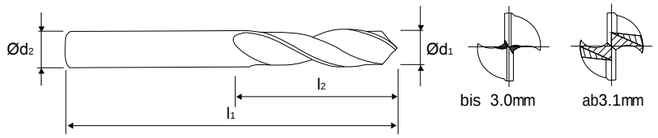
●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		O	O	●	●	O	O							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	O	O		O	O	O	O		

VHM Bohrer DIN338

DIN 338 | MG | h6 | h7 | 118°

Artikel Nr. 801303(C112VHM)



Anwendung:
Stahl, Stahlguss, Hart-undTemperguss
Ne-Metalle, abrasiver Kunststoff

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8013030440	4.4	47	80
8013030450	4.5		
8013030460	4.6		
8013030470	4.7		
8013030480	4.8	52	86
8013030490	4.9		
8013030500	5.0		
8013030510	5.1		
8013030520	5.2		
8013030530	5.3		
8013030540	5.4	57	93
8013030550	5.5		
8013030560	5.6		
8013030570	5.7		
8013030580	5.8		
8013030590	5.9		
8013030600	6.0		

CODE	O.D = S.D $d_1 = d_2$	FL l_2	OAL l_1
8013030610	6.1	63	101
8013030620	6.2		
8013030630	6.3		
8013030640	6.4		
8013030650	6.5		
8013030680	6.8	69	109
8013030700	7.0		
8013030800	8.0	75	117
8013030850	8.5		
8013031000	10.0	87	113
8013031020	10.2		
8013031050	10.5		
8013031100	11.0	94	142
8013031150	11.5		
8013031200	12.0	101	151
8013031300	13.0		

●: sehr gut **O**: gut

P		H	M		K		S			N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		O	O	●	●	O	O							
13	14	16	23		33	34	51	52	53	71	72	73	74	83	
●	●				●	●	O	O		O	O	O	O		

VHM Bohrer Schnittdaten

EUROPA TOOL

Clarkson

osborn

VHM Bohrer 3D 5D 8D Inox Schnittdaten

823323, 825323, 828323 (Inox)

Material Gruppe		v_c (m/min)	fn (mm/U)													
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
P	11 12	**115 (105-125)**	0.02	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12	0.15	0.20	0.22	0.24
P	13 14	**105 (95-115)**	0.02	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12	0.15	0.20	0.22	0.24
M	21 22	**65 (60-70)**	0.02	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12	0.16	0.20	0.22	0.24
M	23	**40 (35-45)**	0.02	0.03	0.03	0.03	0.03	0.04	0.05	0.06	0.08	0.10	0.12	0.15	0.17	0.19
S	41 42	**45 (40-50)**	0.01	0.02	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.10	0.12	0.14	0.16	0.18
S	43	**40 (35-45)**	0.01	0.02	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.10	0.12	0.14	0.16	0.18
S	51 52	**30 (25-35)**	0.05	0.05	0.06	0.08	0.08	0.10	0.10	0.11	0.12	0.14	0.14	0.15	0.15	0.15
S	53	**25 (20-30)**	0.03	0.03	0.04	0.06	0.06	0.08	0.08	0.09	0.10	0.12	0.12	0.13	0.13	0.13
N	71 72	**210 (200-220)**	0.04	0.08	0.12	0.18	0.20	0.25	0.28	0.30	0.40	0.50	0.60	0.80	1.00	1.20
N	73 74	**165 (155-175)**	0.03	0.06	0.10	0.15	0.18	0.25	0.28	0.30	0.35	0.40	0.50	0.60	0.70	0.80

▶ 8xD Bohrer Vorschub um 15% reduzieren

803323, 804323, 805323 (T/Coolant)

Material Gruppe		v_c (m/min)	fn (mm/U)													
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
P	11 12	**140 (130-150)**	0.05	0.07	0.16	0.17	0.18	0.20	0.22	0.25	0.30	0.33	0.36	0.39	0.42	0.45
P	13 14	**125 (115-135)**	0.05	0.07	0.16	0.17	0.18	0.20	0.22	0.25	0.30	0.33	0.36	0.39	0.42	0.45
K	31 32	**240 (230-250)**	0.15	0.07	0.16	0.17	0.18	0.20	0.22	0.25	0.30	0.33	0.36	0.39	0.42	0.45
K	33 34	**150 (140-160)**	0.15	0.07	0.16	0.17	0.18	0.20	0.22	0.25	0.30	0.33	0.36	0.39	0.42	0.45

▶ 8xD Bohrer Vorschub um 15% reduzieren
▶ Bohrer unter 3mm Schnittgeschwindigkeit auf 40% reduzieren

v_c - Schnittgeschwindigkeit (m/min)
n - RPM (U/min)
fn - Vorschub (mm/U)
ø - Bohrer Durchmesser (mm)

To calculate RPM from cutting speed: $n = \frac{v_c * 1000}{\pi * ø}$

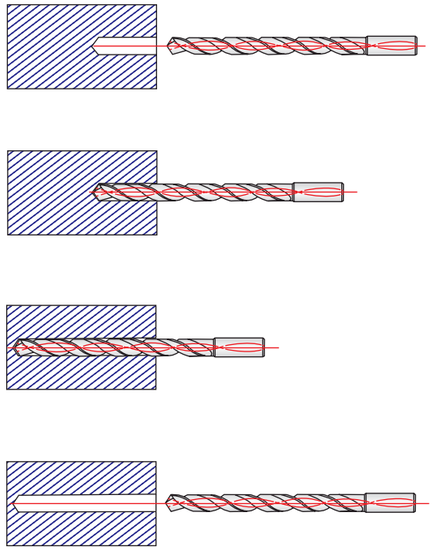
To calculate cutting speed from RPM: $v_c = \frac{n * \pi * ø}{1000}$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

VHM Bohrer 10D 15D 20D Schnittdaten

810323, 815323, 820323 (MQL)

Material Gruppe		v_c (m/min)	fn (mm/U)													
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
P	11 12	**95 (65-125)**	-	-	0.09	0.12	0.15	0.18	-	0.22	0.28	0.33	0.37	-	-	-
P	13 14	**85 (60-115)**	-	-	0.09	0.12	0.15	0.18	-	0.22	0.28	0.33	0.37	-	-	-
K	31 32	**95 (65-125)**	-	-	0.09	0.12	0.15	0.18	-	0.22	0.28	0.33	0.37	-	-	-
K	33 34	**70 (60-80)**	-	-	0.09	0.12	0.15	0.18	-	0.22	0.28	0.33	0.37	-	-	-



1.Durchmesserdes Vorbohrers +0,1mm
Vorbohrtiefe ca. 3xD bis 5xD

2. Im Bereich der Vorbohrung mit niedriger Drehzahl starten.
(Drehzahl 300 U/min; Vorschub 400mm/min.)

3. Kurz vor Ende der Vorbohrung den Vorschub stoppen.
Drehzahl ensprechend der Tabelle erhöhen.

4.Vorschub entsprechen der Tabelle erhöhen.
Nicht entspanen.

5. Drehzahl bei Austritt aus dem Werkstück auf 300 U/min und Vorschub auf 1000 mm/min reduzieren.

6. Schnittgeschwindigkeit bei Rückzug auf 50% reduzieren..

v_c - Schnittgeschwindigkeit (m/min)
n - RPM (U/min)
fn - Vorschub (mm/U)
ø - Bohrer Durchmesser (mm)

To calculate RPM from cutting speed: $n = \frac{v_c * 1000}{\pi * ø}$

To calculate cutting speed from RPM: $v_c = \frac{n * \pi * ø}{1000}$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

VHM Bohrer Schnittdaten

821223 (70 HRC)

Material Gruppe		Hardness HRc	vc (m/min)	fn (mm/U)											
				ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
H	15 16	**50-55**	**18 (14-22)**	0.04	0.04	0.04	0.04	-	0.04	0.04	0.04	0.04	-	-	-
		55-60	**13 (10-16)**	0.04	0.04	0.04	0.04	-	0.04	0.04	0.04	0.04	-	-	-
		60-70	**10 (8-13)**	0.04	0.04	0.04	0.04	-	0.04	0.04	0.04	0.04	-	-	-

843303, 845303, 848303 (ALU)

Material Gruppe		vc (m/min)	fn (mm/U)													
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
N	71 72	**140 (80-200)**	-	-	0.20	0.30	0.40	0.50	0.50	0.60	0.60	0.70	0.70	0.80	0.90	1.00
	73 74	**140 (80-200)**	-	-	0.15	0.20	0.25	0.30	0.30	0.35	0.35	0.40	0.40	0.40	0.40	0.40

▶8xD Bohrer Vorschub um 15% reduzieren

850390 (CFK)

Material Gruppe		vc (m/min)	fn (mm/U)													
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
O	83	**125 (100-150)**	-	0.03	0.04	0.04	0.05	0.05	0.06	0.06	0.07	0.07	-	-	-	-

v_c - Schnittgeschwindigkeit (m/min)
n - RPM (U/min)
fn - Vorschub (mm/U)
ø - Bohrer Durchmesser (mm)

To calculate RPM from cutting speed: $n = \frac{v_c * 1000}{\pi * ø}$

To calculate cutting speed from RPM: $v_c = \frac{n * \pi * ø}{1000}$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

VHM Bohrer Schnittdaten

802323, 807323, 808323 (TiAlN)

Material Gruppe		vc (m/min)	fn (mm/U)													
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
P	11 12	**100 (100-120)**	0.04	0.06	0.13	0.14	0.15	0.17	0.19	0.22	0.25	0.27	0.29	0.31	0.33	0.35
	13 14	**95 (85-105)**	0.04	0.06	0.13	0.14	0.15	0.17	0.19	0.22	0.25	0.27	0.29	0.31	0.33	0.35
K	31 32	**240 (180-200)**	0.04	0.06	0.13	0.14	0.15	0.17	0.19	0.22	0.25	0.27	0.29	0.31	0.33	0.35
	33 34	**120 (110-130)**	0.04	0.16	0.13	0.14	0.15	0.17	0.19	0.22	0.25	0.27	0.29	0.31	0.33	0.35

▶ 8xD Bohrer Vorschub um 15% reduzieren
Bohrer unter 3mm Schnittgeschwindigkeit auf 40% reduzieren

800303, 801303, 806303, 806403

Material Gruppe		vc (m/min)	fn (mm/U)													
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
P	11 12	**70 (65-75)**	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.11	0.13	0.15	-	-	-	-
	13 14	**50 (45-55)**	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.11	0.13	0.15	-	-	-	-
M	21 22	**35 (30-40)**	0.03	0.04	0.04	0.05	0.06	0.07	0.08	0.10	0.12	0.13	-	-	-	-
K	31 32	**90 (80-100)**	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.13	0.17	0.20	-	-	-	-
	33 34	**60 (50-70)**	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.13	0.17	0.20	-	-	-	-
S	41 42	**35 (33-40)**	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.10	0.12	0.13	-	-	-	-
	51 52	**18 (15-20)**	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.09	0.11	0.12	-	-	-	-
N	71 72	**160 (150-170)**	0.05	0.06	0.07	0.08	0.09	0.11	0.13	0.16	0.20	0.24	-	-	-	-
	73 74	**120 (110-130)**	0.05	0.06	0.07	0.08	0.09	0.11	0.13	0.16	0.20	0.24	-	-	-	-

vc - Schnittgeschwindigkeit (m/min)
n - RPM (U/min)
fn - Vorschub (mm/U)
ø - Bohrer Durchmesser (mm)

To calculate RPM from cutting speed: $n = \frac{v_c * 1000}{\pi * ø}$

To calculate cutting speed from RPM: $v_c = \frac{n * \pi * ø}{1000}$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

Materialgruppen Beispiele

Stahl **P**	**11** Magnet. weicher Stahl	**12** Bau.- Einsatzstahl	**13** Kohlenstoffstahl	**14** Legierter Stahl
	EN1 EN2 OSOA12 230Mo7	EN3A, 4, 5, 6, 7, 8 060A35 040A10 EN32 210M15	EN9, 10 EN43 070M20 060A62 080M46	EN16, 17, 19 BO1 BO2 D2 D3
Gehärteter Stahl **H**	**15** Gehärteter Stahl	**16** Gehärteter Stahl		
	S95 S98, S99 BH11 BH13 830M31	>38 HRc Hardox400 Hardox500 P20		
Rostfreier Stahl **M**	**21** Free machining	**22** Austenitisch	**23** Martensitisch/Ferritisch	
	EN56, 58 303S21 304S15 316S 321S17	EN58J 420S37 431S29	Duplex Super Duplex 17-4 PH S130	
Guss **K**	**31** Grauguss	**32** Grauguss	**33** Spähroguss	**34** Spähroguss
	GG10 GG20 GG30 GG40	GG25 GG35 GF150	GGG40 GGG50 SG Iron	GGG70 GGG80 Meehanite
Titan **S**	**41** Titan unlegiert	**42** Titan Legierungen	**43** Titan Legierungen	
	Pure Titanium TA1 - 9 Ti99.0	Ti6Al4V Ti6Al2Sn4Zr2Mo Ti4Al4Mo2Sn0.5Si	Ti10Al2Fe3Al Ti5Al5V5Mo3Cr Ti7Al4Mo Ti3Al8V6Cr4Zr4Mo Ti6Al6V6Sn Ti15V3 Cr3Sn3Al	
Nickel **S**	**51** Nickel unlegiert	**52** Hitzebeständige Legierung	**53** Hitzebeständige Legierung	
	NA11 NA12 Nickel 200	Nimonic 75 Hastelloy C Inconel 601, 617, 625 Incoloy 800, 825 Monel 400	Nimonic 80 Rene 41 Inconel 718, 750-X Incoloy 925 Monel K-500	
Kupfer **N**	**61** Kupfer unlegiert	**62** kurzspanend legiert	**63** langspanend legiert	**64** Cu - Al - Fe Legierung
	Commercially pure C101	CZ120 PB104 G-CuSn5ZnPb	CZ106 CZ108 CuZn37	Ampco18 Ampco20 Ampco26
Aluminium **N**	**71** Aluminium unlegiert	**72** Aluminium, Si <0.5%	**73** Aluminium, Si 0.5-10%	**74** Aluminium, Si >10%
	Al99.5H Al99.9 Al99.9Mg0.5	AlMn1 AlMn1Mg0.5 LM5, 10, 12 6061	HE9, 30 LM2, 4, 16, 18, 21-27 6082 6063	G-AlSi10Mg G-AlSi12 G-MgAl6 LM6,12, 13, 20, 28-30
Synthetics **O**	81 Thermoplastics	82 Thermosetting plastics	83 Reinforced plastics	
	Nylon Acetal	Tufnol	CFRP, GFRP Circuit Board Kevlar	

Empfohlener Kühlmittelduck

Typ	Abmessung					
Inox Standard Alu	<ø3.0	ø3.0 -5.0	ø5.0 -8.0	ø8.0 -12.0	ø12.0 -16.0	ø16.0 -20.0
3xD to 5xD	60 bar	50 bar	30 bar	25 bar	20 bar	15 bar
8xD	80 bar	60 bar	40 bar	30 bar	25 bar	20 bar

Empfohlener Kühlmitteldruck für MQL Schmierung

Type	Abmessung					
MQL	<ø3.0	ø3.0 -5.0	ø5.0 -8.0	ø8.0 -12.0	ø12.0 -16.0	ø16.0 -20.0
10xD to 30xD	14 bar	12 bar	10 bar	9 bar	9 bar	8 bar