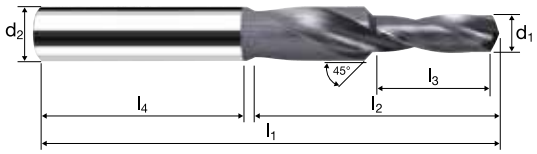
Step drills

3xd, for core drill sizes for taps

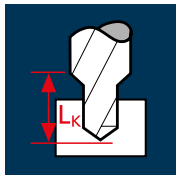
HM



Rm < 850 | **Rm** 850-1100 | **Rm** 1100-1300 | **GG(G)** Aluminium

Example: **Order-N°.** Article-N°. **B52801** ø-Code **0250**

Ø Code	d	d_1 m7	d_2 h6	l_1	l_2	l_3	l_4	DURO-D² B52801
0250	M 3	2.50	6.0	62.0	20.0	8.8	36	●
0330	M 4	3.30	6.0	62.0	24.0	11.4	36	●
0420	M 5	4.20	6.0	66.0	28.0	13.6	36	●
0500	M 6	5.00	8.0	79.0	34.0	16.5	36	●
0680	M 8	6.80	10.0	89.0	47.0	21.0	40	●
0850	M 10	8.50	12.0	102.0	55.0	25.5	45	●
1020	M 12	10.20	14.0	107.0	60.0	30.0	45	●
1400	M 16	14.00	18.0	123.0	73.0	38.5	48	●

Application	Material	d_1 [mm]	d	v_c [m/min]	f [mm]	LK [mm]	n [min^{-1}]	v_f [mm/min]	Q [cm^3/min]
	Steel < 500 N/mm²	2.50	M 3	110	0.0450	9.6	14005	630	3.1
		3.30	M 4	110	0.0550	12.5	10610	584	5.0
		4.20	M 5	110	0.0700	14.9	8335	584	8.1
		5.00	M 6	110	0.0850	18.1	7005	595	11.7
		6.80	M 8	110	0.1150	23.0	5150	592	21.5
		8.50	M 10	110	0.1450	28.0	4120	597	33.9
		10.20	M 12	110	0.1700	33.1	3435	584	47.7
		14.00	M 16	110	0.2300	42.4	2500	575	88.5
	Steel 500 - 850 N/mm²	2.50	M 3	80	0.0450	9.6	10185	458	2.2
		3.30	M 4	80	0.0550	12.5	7715	424	3.6
		4.20	M 5	80	0.0700	14.9	6065	425	5.9
		5.00	M 6	80	0.0850	18.1	5095	433	8.5
		6.80	M 8	80	0.1150	23.0	3745	431	15.6
		8.50	M 10	80	0.1450	28.0	2995	434	24.6
		10.20	M 12	80	0.1700	33.1	2495	424	34.7
		14.00	M 16	80	0.2300	42.4	1820	419	64.4
	Steel 850 - 1100 N/mm²	2.50	M 3	55	0.0400	9.6	7005	280	1.4
		3.30	M 4	55	0.0500	12.5	5305	265	2.3
		4.20	M 5	55	0.0650	14.9	4170	271	3.8
		5.00	M 6	55	0.0750	18.1	3500	263	5.2
		6.80	M 8	55	0.1000	23.0	2575	258	9.4
		8.50	M 10	55	0.1250	28.0	2060	258	14.6
		10.20	M 12	55	0.1500	33.1	1715	257	21.0
		14.00	M 16	55	0.2000	42.4	1250	250	38.5
	Cast iron (lamellar / spheroidal)	2.50	M 3	160	0.0800	9.6	20370	1630	8.0
		3.30	M 4	160	0.1050	12.5	15435	1621	13.9
		4.20	M 5	160	0.1300	14.9	12125	1576	21.8
		5.00	M 6	160	0.1600	18.1	10185	1630	32.0
		6.80	M 8	160	0.2100	23.0	7490	1573	57.1
		8.50	M 10	160	0.2650	28.0	5990	1587	90.1
		10.20	M 12	160	0.3150	33.1	4995	1573	128.6
		14.00	M 16	160	0.4200	42.4	3640	1529	235.3
	Wrought aluminium alloys Si < 6% hardened	2.50	M 3	200	0.0800	9.6	25465	2037	10.0
		3.30	M 4	200	0.1050	12.5	19290	2026	17.3
		4.20	M 5	200	0.1300	14.9	15160	1971	27.3
		5.00	M 6	200	0.1600	18.1	12730	2037	40.0
		6.80	M 8	200	0.2100	23.0	9360	1966	71.4
		8.50	M 10	200	0.2650	28.0	7490	1985	112.6
		10.20	M 12	200	0.3150	33.1	6240	1966	160.6
		14.00	M 16	200	0.4200	42.4	4545	1909	293.9