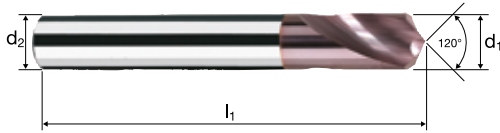


Center drills

120°

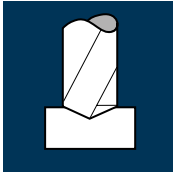
HM MG10	



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless		GG(G) Aluminium
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Example: Order-N°.				Article-N°	σ-Code		U-4XD	
				B92020	0300		B92020	
∅ Code	d ₁ h6	d ₂ h6	l ₁					
0300	3.00	3.0	50.0					●
0400	4.00	4.0	50.0					●
0500	5.00	5.0	50.0					●
0600	6.00	6.0	57.0					●
0800	8.00	8.0	63.0					●
1000	10.00	10.0	72.0					●
1200	12.00	12.0	83.0					●
1600	16.00	16.0	92.0					●

Application



Material

Steel
< 500 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Steel
1300 - 1500 N/mm²



Stainless steel
[Cr-Ni/1.4301]



Cast iron
(lamellar / spheroidal)



Wrought aluminium alloys
Si < 6%
hardened



d_1 [mm]	v_c [m/min]	f [mm]	n [min ⁻¹]	v_f [mm/min]
3.00	160	0.0700	16975	1188
4.00	160	0.0950	12730	1209
5.00	160	0.1200	10185	1222
6.00	160	0.1450	8490	1231
8.00	160	0.1900	6365	1209
10.00	160	0.2400	5095	1223
12.00	160	0.2850	4245	1210
16.00	160	0.3800	3185	1210
3.00	120	0.0700	12730	891
4.00	120	0.0950	9550	907
5.00	120	0.1200	7640	917
6.00	120	0.1450	6365	923
8.00	120	0.1900	4775	907
10.00	120	0.2400	3820	917
12.00	120	0.2850	3185	908
16.00	120	0.3800	2385	906
3.00	90	0.0600	9550	573
4.00	90	0.0750	7160	537
5.00	90	0.0950	5730	544
6.00	90	0.1150	4775	549
8.00	90	0.1550	3580	555
10.00	90	0.1900	2865	544
12.00	90	0.2300	2385	549
16.00	90	0.3100	1790	555
3.00	60	0.0500	6365	318
4.00	60	0.0650	4775	310
5.00	60	0.0800	3820	306
6.00	60	0.0950	3185	303
8.00	60	0.1250	2385	298
10.00	60	0.1600	1910	306
12.00	60	0.1900	1590	302
16.00	60	0.2550	1195	305
3.00	30	0.0500	3185	159
4.00	30	0.0650	2385	155
5.00	30	0.0800	1910	153
6.00	30	0.0950	1590	151
8.00	30	0.1250	1195	149
10.00	30	0.1600	955	153
12.00	30	0.1900	795	151
16.00	30	0.2550	595	152
3.00	60	0.0400	6365	255
4.00	60	0.0550	4775	263
5.00	60	0.0700	3820	267
6.00	60	0.0800	3185	255
8.00	60	0.1100	2385	262
10.00	60	0.1350	1910	258
12.00	60	0.1650	1590	262
16.00	60	0.2200	1195	263
3.00	180	0.0800	19100	1528
4.00	180	0.1050	14325	1504
5.00	180	0.1300	11460	1490
6.00	180	0.1600	9550	1528
8.00	180	0.2100	7160	1504
10.00	180	0.2650	5730	1519
12.00	180	0.3150	4775	1504
16.00	180	0.4200	3580	1504
3.00	220	0.0800	23345	1868
4.00	220	0.1050	17505	1838
5.00	220	0.1300	14005	1821
6.00	220	0.1600	11670	1867
8.00	220	0.2100	8755	1839
10.00	220	0.2650	7005	1856
12.00	220	0.3150	5835	1838
16.00	220	0.4200	4375	1838