

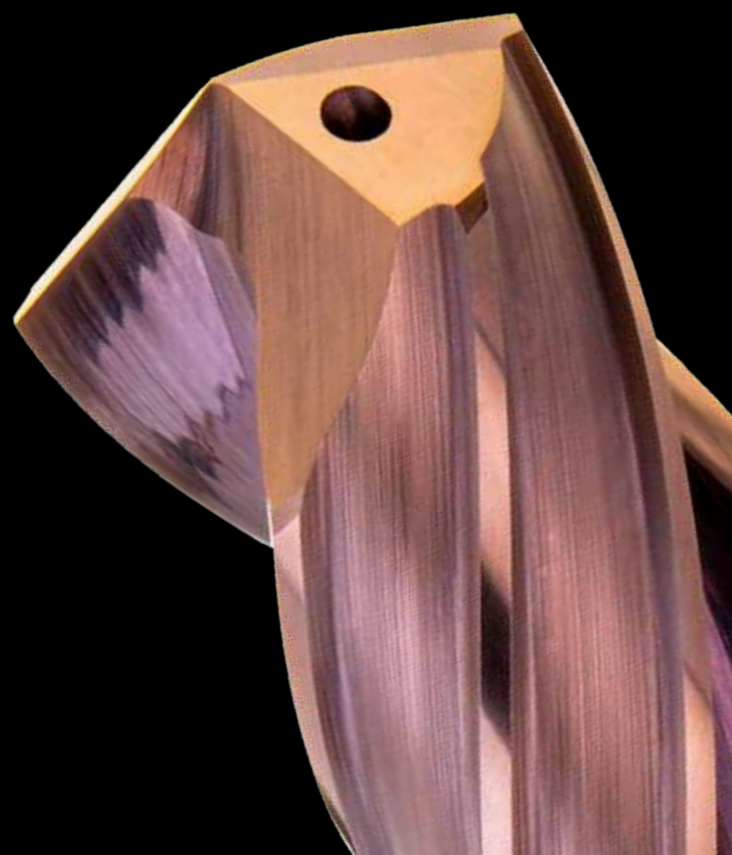
INNOVATION | QUALITY | PRODUCTIVITY

YOUR CHALLENGE OUR SOLUTION

High Performance Solid Carbide Tools

deltamill
Milling Technology

deltadrill
Drilling Technology





CUTTING EDGE TECHNOLOGY

Uw uitdaging? Onze oplossing!



Het is alweer 12 jaar geleden toen wij met onze missie begonnen! Een missie met als uitdaging één van de beste VHM frezen en VHM boren programma te ontwikkelen die meedoet in de top van de markt maar betaalbaar en bereikbaar is voor iedereen. Nu 12 jaar verder mogen we wel zeggen dat we inmiddels een betrouwbaar merk zijn geworden met sublieme prijs/kwaliteitverhouding. Top bedrijven uit de Nederlandse en Europese maakindustrie weten de weg naar ons te vinden. Continu streven we naar nieuwe en nog betere oplossingen voor uw verspaningsuitdagingen van morgen. Ons programma is weer verder uitgebreid met nieuwe innovatieve hoogwaardige frezen en boren. Onze hoogwaardige frezen worden in Duitsland geproduceerd van Duits hardmetaal en voorzien van de beste coatingen uit Duitsland. We doen absoluut geen concessie als het om kwaliteit gaat.

Wat is nieuw?

Teveel om specifiek te benoemen, in de inhoudsopgave ziet u in één oogopslag wat nieuw is. Één van onze innovaties waar we erg trots op zijn is onze **ALUMINATOR-Serie**, hoogwaardige frezen voor bewerking van Aluminium in 3xD 4xD 5xD & 6xD nek lengtes in zowel ruw als finish uitvoering. Een Unieke combo voor de hightech Aluminium CNC-frezer!

Mogen we vriendelijk uitnodigen om samen met ons de uitdaging aan te gaan en wacht niet langer uw machine standaard te voorzien van onze frezen.

Uw toekomstige uitdaging, is onze oplossing van vandaag.

Your challenge? Our solution!

It's been 12 years since we started our mission! A mission with the challenge of developing one of the best solid carbide milling and solid carbide drilling program that competes at the top of the market but is affordable and accessible to everyone. Now 12 years later, we can say that we have become a reliable brand with a sublime price/quality ratio. Top companies from the Dutch and European manufacturing industry know their way to us. We continuously strive for new and even better solutions for your machining challenges of tomorrow. Our program has been further expanded with new innovative high-quality milling and drilling tools. Our high-quality cutters are produced in Germany from German carbide and provided with the best coatings from Germany. We absolutely make no concessions when it comes to quality.

What's new?

Too many to mention, see the product overview and you will see what new is.

One of our innovations that we are very proud of is our **ALUMINATOR Series**, high-quality milling cutters for machining Aluminum in 3xD 4xD 5xD & 6xD neck lengths in both rough and finish versions. A unique combo for the high-tech Aluminum CNC-milling operator!

May we kindly invite you to take up the challenge with us and don't wait any longer to install our milling cutters as standard in your machines.

Your future challenge, is our solution today!

Inhoudsopgave hoogwaardige VHM HPC frezen

Index high quality SC HPC endmills

P-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D3900	AGRESSOR UNI		Standard	3
	D4900	AGRESSOR UNI		Standard	4
	D4900R	AGRESSOR UNI		Standard	4
	D4902R	AGRESSOR UNI		Long	4
	D4903R	AGRESSOR UNI		Extra long	4
	D4900P	AGRESSOR PERFORMER	New	Standard	4
	D5900R	AGRESSOR UNI	New	Standard	5
	D6910	XTREMA UNI		Standard	6
	D6913	XTREMA UNI		3xD	6
	D6913R	XTREMA UNI		3xD	6
	D6914	XTREMA UNI	New	4xD	6
	D6915	XTREMA UNI		5xD	6
	D6900	AGRESSOR FINISHER		Standard	6
	D6902	AGRESSOR FINISHER		3xD	6
	D6902-4D	AGRESSOR FINISHER	New	4xD	6

M-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D5923	XTREMA INOX	NEW	3xD	5

N-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D3930	AGRESSOR ALU		3xD	3
	D3932	AGRESSOR ALU		6xD	3
	D3930DLC	AGRESSOR ALU		3xD	3
	D3933	ALUMINATOR SMOOTHER	New	3xD	3
	D3934	ALUMINATOR SMOOTHER	New	4xD	3
	D3935	ALUMINATOR SMOOTHER	New	5xD	3
	D3936	ALUMINATOR SMOOTHER	New	6xD	3
	D3933I	ALUMINATOR SMOOTHER	New	3xD	3
	D3934I	ALUMINATOR SMOOTHER	New	4xD	3
	D3935I	ALUMINATOR SMOOTHER	New	5xD	3

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Materiaalgroepen / Materialgroups																			Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4	
●	●	●	●	●	●	●	●				●	●	○	○					12
●	●	●	●	●	●	●	●				●	●	○	○					14
●	●	●	●	●	●	●	●				●	●	○	○					16
●	●	●	●	●	●	●	●				●	●	○	○					18
●	●	●	●	●	●	●	●				●	●	○	○					20
●	●	●	●	●	●	●	●				●	●	○	○					22
●	●	●	●	●	●	●	●				●	●	○	○					24
●	●	●	●	●	●	●	●				●	●	○	○					26
●	●	●	●	●	●	●	●				●	●	○	○					28
●	●	●	●	●	●	●	●				●	●	○	○					30
●	●	●	●	●	●	●	●				●	●	○	○					32
●	●	●	●	●	●	●	●				●	●	○	○					34
●	●	●	●	●	●	●	●				●	●	○	○					38
●	●	●	●	●	●	●	●				●	●	○	○					40
●	●	●	●	●	●	●	●				●	●	○	○					42

Materiaalgroepen / Materialgroups																			Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4	
●	●	●	●	●	●	●													36

Materiaalgroepen / Materialgroups																			Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4	
								●	●	●									44
								●	●	●									46
								●	●	●									48
								●	●	●									50
								●	●	●									52
								●	●	●									54
								●	●	●									56
								●	●	●									58
								●	●	●									60
								●	●	●									62

Inhoudsopgave hoogwaardige VHM HPC frezen

Index high quality SC HPC endmills

N-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D3936I	ALUMINATOR SMOOTHER	New	6xD	3
	D3933R	ALUMINATOR ROUGHER	New	3xD	3
	D3934R	ALUMINATOR ROUGHER	New	4xD	3
	D3935R	ALUMINATOR ROUGHER	New	5xD	3
	D3936R	ALUMINATOR ROUGHER	New	6xD	3
	D4933	AGRESSOR ALU		3xD	4
	D3934	AGRESSOR ALU		4xD	4
	D6933	AGRESSOR ALU		3xD	6
	D6935	ALUMINATOR ROUGHER		6xD	6
	D3936ALF	ALUMINATOR ROUGHER	New	6xD	3

S-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D4950	AGRESSOR TITAN		2xD	4
	D5950	AGRESSOR TITAN		2xD	5
	D5953	AGRESSOR TITAN		3xD	5

H-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D4960	AGRESSOR HARD		2xD	4
	D6560(R)	AGRESSOR HARD		2xD	6
	D2862	AGRESSOR HARD	New	3xD	2

P-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D2380	UNILINE		Standard	2
	D4060	UNILINE	New	Standard	4
	D4090	UNILINE		Standard	4
	D4120	UNILINE	New	Standard	4
	D2090	UNILINE		Standard	2
	D4080	UNILINE		Standard	4

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								●	●	●								64
								●	●	●								66
								●	●	●								68
								●	●	●								70
								●	●	●								72
								●	●	●								74
								●	●	●								76
								●	●	●								78
								●	●	●								80
								●	●	●								82

Materiaalgroepen / Materialgroups																		Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4
				●	●	●					●	●	●	●				84
				●	●	●					●	●	●	●				86
				●	●	●					●	●	●	●				88

Materiaalgroepen / Materialgroups																		Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4
															●	●	●	90
															●	●	●	92
															●	●	●	94

Materiaalgroepen / Materialgroups																		Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4
●	●	●	●	●	●	●	●				●	●						96
●	●	●	●	●	●	●	●				●	●						98
●	●	●	●	●	●	●	●				●	●						100
●	●	●	●	●	●	●	●				●	●						102
●	●	●	●	●	●	●	●											104
●	●	●	●	●	●	●	●				●	●						106

Inhoudsopgave hoogwaardige VHM boren

Index high quality SC drills

P-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D20003	SPEEDDRILL S2	New	3xD	2
	D20005	SPEEDDRILL S2	New	5xD	2
	D21003	SPEEDDRILL S2	New	3xD	2
	D21705	SPEEDDRILL S4		5xD	2
	D21708	SPEEDDRILL S4		8xD	2

M-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D18003	SPEEDDRILL U2		3xD	2
	D18005	SPEEDDRILL U2		5xD	2
	D18708	SPEEDDRILL U4	New	8xD	2
	D18712	SPEEDDRILL U4	New	12xD	2
	D18720	DEEPDRILL U6	New	20xD	2
	D18730	DEEPDRILL U6	New	30xD	2

N-SERIE	Art.nr.	Serie		Lengte / Length	Z
	D28705	SPEEDDRILL A4		5xD	2
	D28708	SPEEDDRILL A4		8xD	2

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Materiaalgroepen / Materialgroups																			Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4	
•	•	•	•				•												110
•	•	•	•				•												112
•	•	•	•				•												114
•	•	•	•				•												116
•	•	•	•				•												118

Materiaalgroepen / Materialgroups																			Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4	
•	•	•	•	•	•	•		○	○	○	●	●	○	○					120
•	•	•	•	•	•	•		○	○	○	●	●	○	○					122
•	•	•	•	•	•	•		○	○	○	●	●	○	○					124
•	•	•	•	•	•	•		○	○	○	●	●	○	○					126
•	•	•	•	•	•	•		○	○	○	●	●	○	○					128
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Materiaalgroepen / Materialgroups																			Pagina / Page
P1.1	P2.2	P3.2	P4.2	M1.1	M2.1	M3.1	K1.2	N1.1	N1.4	N1.5	S1.1	S1.2	S1.3	S2.2	H1.1	H1.2	H1.3	H1.4	
								●	●	●									132
								●	●	●									134

Snijwaarden VHM boren / Cutting values SC drills

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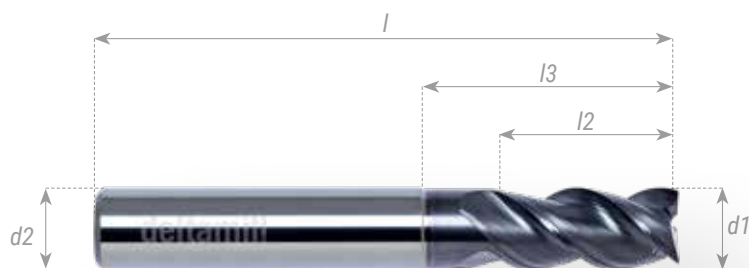


FREZEN *ENDMILLS*

deltamill
Milling Technology

VHM HPC Universeel Frees Z3

SC HPC universal endmill Z3



AGRESSOR UNI



Code	Ød1	Ød2	l2	l3	l	z	c	€
D3900-0100BT	1,0	6,0	2,5	5	57	3	0,1	37,00
D3900-0150BT	1,5	6,0	4	7,5	57	3	0,1	37,00
D3900-0200BT	2,0	6,0	5	10	57	3	0,1	37,00
D3900-0250BT	2,5	6,0	6,5	12,5	57	3	0,1	37,00
D3900-0300BT	3,0	6,0	8	15	57	3	0,1	37,00
D3900-0400BT	4,0	6,0	11	16	57	3	0,1	37,00
D3900-0500BT	5,0	6,0	13	19	57	3	0,1	37,00
D3900-0600BT	6,0	6,0	13	19	57	3	0,1	37,00
D3900-0800BT	8,0	8,0	19	25	63	3	0,2	47,00
D3900-1000BT	10,0	10,0	22	30	72	3	0,2	69,00
D3900-1200BT	12,0	12,0	26	36	83	3	0,2	94,00
D3900-1600BT	16,0	16,0	32	42	92	3	0,2	177,00
D3900-2000BT	20,0	20,0	38	52	104	3	0,2	276,00

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	190	4	0.015	3	3
	4.0	190	4	0.020	4	4
	5.0	190	4	0.025	5	5
	6.0	190	4	0.030	6	6
	8.0	190	4	0.035	8	8
	10.0	190	4	0.045	10	10
	12.0	190	4	0.055	12	12
	16.0	190	4	0.070	16	16
	20.0	190	4	0.090	20	20
	25.0	190	4	0.100	25	25
P2.2 Heat Treatable steel < 1100N/mm²	3.0	100	4	0.010	3	3
	4.0	100	4	0.015	4	4
	5.0	100	4	0.018	5	5
	6.0	100	4	0.020	6	6
	8.0	100	4	0.030	8	8
	10.0	100	4	0.040	10	10
	12.0	100	4	0.050	12	12
	16.0	100	4	0.060	16	16
P4.2 Cold working tool steel < 12% Chrom	3.0	90	4	0.010	3	3
	4.0	90	4	0.015	4	4
	5.0	90	4	0.020	5	5
	6.0	90	4	0.025	6	6
	8.0	90	4	0.035	8	8
	10.0	90	4	0.045	10	10
	12.0	90	4	0.050	12	12
	16.0	90	4	0.060	16	16
M2.1 Stainless steel Austenitic 303-304-316	3.0	80	4	0.007	3	3
	4.0	80	4	0.010	4	4
	5.0	80	4	0.015	5	5
	6.0	80	4	0.020	6	6
	8.0	80	4	0.025	8	8
	10.0	80	4	0.030	10	10
	12.0	80	4	0.035	12	12
	16.0	80	4	0.045	16	16
	20.0	80	4	0.065	20	20
	25.0	80	4	0.080	25	25
S1.2 Titanium Alloys Ti Grade 3-4	3.0	50	4	0.008	3	3
	4.0	50	4	0.012	4	4
	5.0	50	4	0.016	5	5
	6.0	50	4	0.020	6	6
	8.0	50	4	0.025	8	8
	10.0	50	4	0.040	10	10
	12.0	50	4	0.045	12	12
	16.0	50	4	0.055	16	16
S2.2 Inconel 625	3.0	35	4	0.005	3	3
	4.0	35	4	0.008	4	4
	5.0	35	4	0.010	5	5
	6.0	35	4	0.012	6	6
	8.0	35	4	0.015	8	8
	10.0	35	4	0.020	10	10
	12.0	35	4	0.025	12	12
	16.0	35	4	0.035	16	16
K1.2 Cast iron	3.0	150	4	0.015	3	3
	4.0	150	4	0.020	4	4
	5.0	150	4	0.030	5	5
	6.0	150	4	0.040	6	6
	8.0	150	4	0.045	8	8
	10.0	150	4	0.050	10	10
	12.0	150	4	0.060	12	12
	16.0	150	4	0.080	16	16
	20.0	150	4	0.100	20	20
	25.0	150	4	0.150	25	25

Verspanings parameters *Cutting Data*

Correctie *Correction*

Ae	Ap	Vc	fz
Ae= <0,4xD	1xD	+20%	+20%
Ae= <0,4xD	1,5xD	+10%	+10%
Ae= <0,05xD	2xD	+20%	-



Slotting Ap<1xD
and Ae<1xD



Contour Ap<1,5xD
and Ae<0,4xD

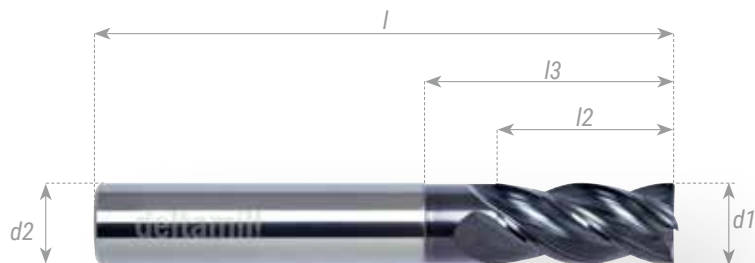


Finish Ap<2xD
and Ae 0,05xD



VHM HPC Universeel frees Z4

SC HPC Universal endmill Z4



AGRESSOR UNI



Code	Ød1	Ød2	l2	l3	l	z	c	€
D4900-0300BA	3,0	6,0	8	-	57	4	0,1	37,00
D4900-0400BA	4,0	6,0	11	-	57	4	0,1	37,00
D4900-0500BA	5,0	6,0	13	18	57	4	0,1	37,00
D4900-0600BA	6,0	6,0	13	18	57	4	0,1	37,00
D4900-0800BA	8,0	8,0	21	25	63	4	0,2	47,00
D4900-1000BA	10,0	10,0	22	30	72	4	0,2	69,00
D4900-1200BA	12,0	12,0	26	36	83	4	0,3	95,00
D4900-1600BA	16,0	16,0	36	42	92	4	0,3	177,00
D4900-2000BA	20,0	20,0	41	52	103	4	0,3	284,00
D4900-2500BA	25,0	25,0	55	66	126	4	0,4	571,00

Verspanings parameters Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	180	4	0.015	3	3
	4.0	180	4	0.020	4	4
	5.0	180	4	0.030	5	5
	6.0	180	4	0.030	6	6
	8.0	180	4	0.040	8	8
	10.0	180	4	0.065	10	10
	12.0	180	4	0.070	12	12
	16.0	180	4	0.090	16	16
	20.0	180	4	0.110	20	20
	25.0	180	4	0.150	25	25
P2.2 Heat Treatable steel < 1100N/mm²	3.0	140	4	0.010	3	3
	4.0	140	4	0.015	4	4
	5.0	140	4	0.020	5	5
	6.0	140	4	0.025	6	6
	8.0	140	4	0.030	8	8
	10.0	140	4	0.050	10	10
	12.0	140	4	0.060	12	12
	16.0	140	4	0.070	16	16
	20.0	140	4	0.080	20	20
	25.0	140	4	0.090	25	25
P3.2 High Alloy steels < 1600N/mm²	3.0	60	4	0.010	3	3
	4.0	60	4	0.020	4	4
	5.0	60	4	0.025	5	5
	6.0	60	4	0.030	6	6
	8.0	60	4	0.040	8	8
	10.0	60	4	0.060	10	10
	12.0	60	4	0.070	12	12
	16.0	60	4	0.085	16	16
	20.0	60	4	0.100	20	20
	25.0	60	4	0.120	25	25
P4.2 Cold working tool steel 12% Chrom	3.0	80	4	0.010	3	3
	4.0	80	4	0.015	4	4
	5.0	80	4	0.020	5	5
	6.0	80	4	0.025	6	6
	8.0	80	4	0.030	8	8
	10.0	80	4	0.050	10	10
	12.0	80	4	0.060	12	12
	16.0	80	4	0.065	16	16
	20.0	80	4	0.085	20	20
	25.0	80	4	0.095	25	25
M2.1 Stainless steel Austenitic 303-304-316	3.0	80	4	0.008	3	3
	4.0	80	4	0.010	4	4
	5.0	80	4	0.015	5	5
	6.0	80	4	0.020	6	6
	8.0	80	4	0.025	8	8
	10.0	80	4	0.030	10	10
	12.0	80	4	0.040	12	12
	16.0	80	4	0.050	16	16
	20.0	80	4	0.070	20	20
	25.0	80	4	0.100	25	25
K1.2 Cast iron	3.0	150	4	0.015	3	3
	4.0	150	4	0.020	4	4
	5.0	150	4	0.025	5	5
	6.0	150	4	0.030	6	6
	8.0	150	4	0.050	8	8
	10.0	150	4	0.070	10	10
	12.0	150	4	0.080	12	12
	16.0	150	4	0.090	16	16
	20.0	150	4	0.100	20	20
	25.0	150	4	0.150	25	25

Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1xD	20%	20%
Ae= <0,4xD	1,5xD	10%	10%
Ae= <0,05xD	2xD	20%	100%



Slotting Ap1xD
en Ae1xD



Contour Ap<1,5xD
en Ae<0,4xD

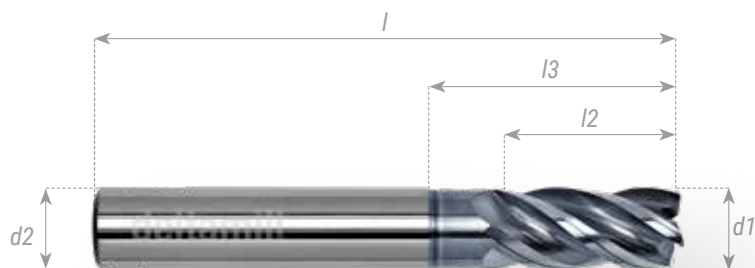


Finish Ap<2xD
en Ae 0,05xD



VHM HPC Universeel frees Z4

Solid Carbide HPC universal endmill Z4



AGRESSOR UNI



Code	Ød1	Ød2	l2	l3	l	z	r	€
D4900-0300RBA	3,0	6,0	8	14	57	4	0,3	37,00
D4900-0400RBA	4,0	6,0	11	16	57	4	0,3	37,00
D4900-0500RBA	5,0	6,0	13	18	57	4	0,3	37,00
D4900-0600RBA	6,0	6,0	13	20	57	4	0,3	37,00
D4900-0800RBA	8,0	8,0	21	25	63	4	0,3	47,00
D4900-0805RBA	8,0	8,0	21	25	63	4	0,5	47,00
D4900-0810RBA	8,0	8,0	21	25	63	4	1,0	47,00
D4900-1000RBA	10,0	10,0	22	30	72	4	0,3	69,00
D4900-1005RBA	10,0	10,0	22	30	72	4	0,5	69,00
D4900-1010RBA	10,0	10,0	22	30	72	4	1,0	69,00
D4900-1020RBA	10,0	10,0	22	30	72	4	2,0	69,00
D4900-1200RBA	12,0	12,0	26	36	83	4	0,5	95,00
D4900-1210RBA	12,0	12,0	26	36	83	4	1,0	95,00
D4900-1220RBA	12,0	12,0	26	36	83	4	2,0	95,00
D4900-1605RBA	16,0	16,0	36	42	92	4	0,5	177,00
D4900-1610RBA	16,0	16,0	36	42	92	4	1,0	177,00
D4900-1620RBA	16,0	16,0	36	42	92	4	2,0	177,00
D4900-2000RBA	20,0	20,0	38	55	104	4	1,0	276,00
D4900-2500RBA	25,0	25,0	45	65	120	4	1,0	571,00

Verspanings parameters Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1	3.0	180	4	0.015	3	3
	4.0	180	4	0.020	4	4
	5.0	180	4	0.030	5	5
	6.0	180	4	0.030	6	6
	8.0	180	4	0.040	8	8
	10.0	180	4	0.065	10	10
	12.0	180	4	0.070	12	12
	16.0	180	4	0.090	16	16
	20.0	180	4	0.110	20	20
	25.0	180	4	0.150	25	25
P2.2	3.0	140	4	0.010	3	3
	4.0	140	4	0.015	4	4
	5.0	140	4	0.020	5	5
	6.0	140	4	0.025	6	6
	8.0	140	4	0.030	8	8
	10.0	140	4	0.050	10	10
	12.0	140	4	0.060	12	12
	16.0	140	4	0.070	16	16
	20.0	140	4	0.080	20	20
	25.0	140	4	0.090	25	25
P3.2	3.0	60	4	0.010	3	3
	4.0	60	4	0.020	4	4
	5.0	60	4	0.025	5	5
	6.0	60	4	0.030	6	6
	8.0	60	4	0.040	8	8
	10.0	60	4	0.060	10	10
	12.0	60	4	0.070	12	12
	16.0	60	4	0.085	16	16
	20.0	60	4	0.100	20	20
	25.0	60	4	0.120	25	25
P4.2	3.0	80	4	0.010	3	3
	4.0	80	4	0.015	4	4
	5.0	80	4	0.020	5	5
	6.0	80	4	0.025	6	6
	8.0	80	4	0.030	8	8
	10.0	80	4	0.050	10	10
	12.0	80	4	0.060	12	12
	16.0	80	4	0.065	16	16
	20.0	80	4	0.085	20	20
	25.0	80	4	0.095	25	25
M2.1	3.0	80	4	0.008	3	3
	4.0	80	4	0.010	4	4
	5.0	80	4	0.015	5	5
	6.0	80	4	0.020	6	6
	8.0	80	4	0.025	8	8
	10.0	80	4	0.030	10	10
	12.0	80	4	0.040	12	12
	16.0	80	4	0.050	16	16
	20.0	80	4	0.070	20	20
	25.0	80	4	0.100	25	25
K1.2	3.0	150	4	0.015	3	3
	4.0	150	4	0.020	4	4
	5.0	150	4	0.025	5	5
	6.0	150	4	0.030	6	6
	8.0	150	4	0.050	8	8
	10.0	150	4	0.070	10	10
	12.0	150	4	0.080	12	12
	16.0	150	4	0.090	16	16
	20.0	150	4	0.100	20	20
	25.0	150	4	0.150	25	25

Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1xD	20%	20%
Ae= <0,4xD	1,5xD	10%	10%
Ae= <0,05xD	2xD	20%	100%



Slotting Ap1xD
en Ae1xD



Contour Ap<1,5xD
en Ae<0,4xD

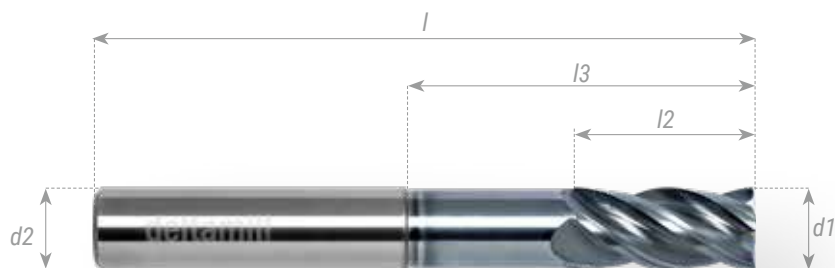


Finish Ap<2xD
en Ae 0,05xD



VHM HPC Universeel frees lang Z4

SC HPC Universal endmill long Z4



AGRESSOR UNI



Code	Ød1	Ød2	l2	l3	l	z	r	€
D4902-0300RBA	3,0	6,0	8	20	57	4	0,3	39,00
D4902-0402RBA	4,0	6,0	11	22	57	4	0,2	43,00
D4902-0400RBA	4,0	6,0	11	22	57	4	0,3	39,00
D4902-0502RBA	5,0	6,0	13	26	62	4	0,2	47,00
D4902-0500RBA	5,0	6,0	13	26	62	4	0,3	43,00
D4902-0602RBA	6,0	6,0	13	26	62	4	0,2	47,00
D4902-0600RBA	6,0	6,0	13	26	62	4	0,5	43,00
D4902-0802RBA	8,0	8,0	19	34	70	4	0,2	62,00
D4902-0800RBA	8,0	8,0	19	34	70	4	0,5	58,00
D4902-1002RBA	10,0	10,0	22	40	80	4	0,2	87,00
D4902-1000RBA	10,0	10,0	22	40	80	4	0,5	81,00
D4902-1202RBA	12,0	12,0	26	50	95	4	0,2	136,00
D4902-1200RBA	12,0	12,0	26	50	95	4	0,5	125,00
D4902-1610RBA	16,0	16,0	32	55	105	4	1,0	244,00
D4902-1602RBA	16,0	16,0	32	75	125	4	0,2	275,00
D4902-1611RBA	16,0	16,0	32	75	125	4	1,0	275,00
D4902-2000RBA	20,0	20,0	38	70	124	4	1,0	364,00
D4902-2001RBA	20,0	20,0	38	92	140	4	1,0	404,00

Verspanings parameters Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	180	4	0.015	3	3
	4.0	180	4	0.020	4	4
	5.0	180	4	0.030	5	5
	6.0	180	4	0.030	6	6
	8.0	180	4	0.040	8	8
	10.0	180	4	0.065	10	10
	12.0	180	4	0.070	12	12
	16.0	180	4	0.090	16	16
	20.0	180	4	0.110	20	20
	25.0	180	4	0.150	25	25
P2.2 Heat Treatable steel < 1100N/mm²	3.0	140	4	0.010	3	3
	4.0	140	4	0.015	4	4
	5.0	140	4	0.020	5	5
	6.0	140	4	0.025	6	6
	8.0	140	4	0.030	8	8
	10.0	140	4	0.050	10	10
	12.0	140	4	0.060	12	12
	16.0	140	4	0.070	16	16
	20.0	140	4	0.080	20	20
	25.0	140	4	0.090	25	25
P3.2 High Alloy steels < 1600N/mm²	3.0	60	4	0.010	3	3
	4.0	60	4	0.020	4	4
	5.0	60	4	0.025	5	5
	6.0	60	4	0.030	6	6
	8.0	60	4	0.040	8	8
	10.0	60	4	0.060	10	10
	12.0	60	4	0.070	12	12
	16.0	60	4	0.085	16	16
	20.0	60	4	0.100	20	20
	25.0	60	4	0.120	25	25
P4.2 Cold working tool steel 12% Chrom	3.0	80	4	0.010	3	3
	4.0	80	4	0.015	4	4
	5.0	80	4	0.020	5	5
	6.0	80	4	0.025	6	6
	8.0	80	4	0.030	8	8
	10.0	80	4	0.050	10	10
	12.0	80	4	0.060	12	12
	16.0	80	4	0.065	16	16
	20.0	80	4	0.085	20	20
	25.0	80	4	0.095	25	25
M2.1 Stainless steel Austenitic 303-304-316	3.0	80	4	0.008	3	3
	4.0	80	4	0.010	4	4
	5.0	80	4	0.015	5	5
	6.0	80	4	0.020	6	6
	8.0	80	4	0.025	8	8
	10.0	80	4	0.030	10	10
	12.0	80	4	0.040	12	12
	16.0	80	4	0.050	16	16
	20.0	80	4	0.070	20	20
	25.0	80	4	0.100	25	25
K1.2 Cast iron	3.0	150	4	0.015	3	3
	4.0	150	4	0.020	4	4
	5.0	150	4	0.025	5	5
	6.0	150	4	0.030	6	6
	8.0	150	4	0.050	8	8
	10.0	150	4	0.070	10	10
	12.0	150	4	0.080	12	12
	16.0	150	4	0.090	16	16
	20.0	150	4	0.100	20	20
	25.0	150	4	0.150	25	25

Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1xD	20%	20%
Ae= <0,4xD	1,5xD	10%	10%
Ae= <0,05xD	2xD	20%	100%



Slotting Ap1xD
en Ae1xD



Contour Ap<1,5xD
en Ae<0,5xD

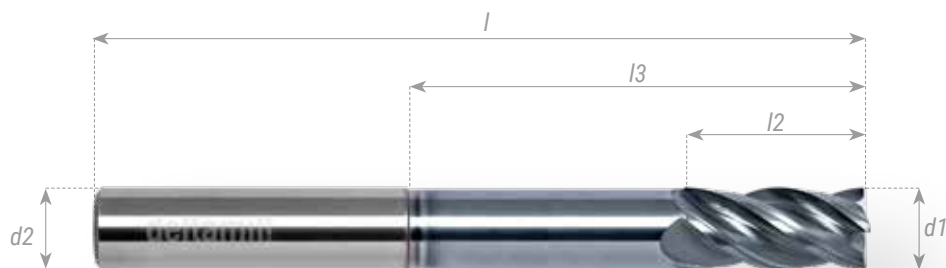


Finish Ap<2xD
en Ae 0,05xD



VHM HPC Universeel frees extra lang Z4

SC HPC Universal endmill extra long Z4



AGRESSOR UNI



Code	Ød1	Ød2	l2	l3	l	z	r	€
D4903-0300RBA	3,0	6,0	8	25	63	4	0,3	46,00
D4903-0400RBA	4,0	6,0	11	30	66	4	0,3	48,00
D4903-0500RBA	5,0	6,0	13	35	72	4	0,3	50,00
D4903-0600RBA	6,0	6,0	13	40	76	4	0,3	52,00
D4903-0800RBA	8,0	8,0	19	48	84	4	0,3	70,00
D4903-1000RBA	10,0	10,0	22	60	100	4	0,5	110,00
D4903-1200RBA	12,0	12,0	26	75	120	4	0,5	160,00
D4903-1600RBA	16,0	16,0	32	100	150	4	1,0	339,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	180	4	0.015	3	1,5
	4.0	180	4	0.020	4	2
	5.0	180	4	0.030	5	2,5
	6.0	180	4	0.030	6	3
	8.0	180	4	0.040	8	4
	10.0	180	4	0.065	10	5
	12.0	180	4	0.070	12	6
	16.0	180	4	0.090	16	8
	20.0	180	4	0.110	20	10
	25.0	180	4	0.150	25	12,5
P2.2 Heat Treatable steel < 1100N/mm²	3.0	140	4	0.010	3	1,2
	4.0	140	4	0.015	4	2
	5.0	140	4	0.020	5	2,5
	6.0	140	4	0.025	6	3
	8.0	140	4	0.030	8	4
	10.0	140	4	0.050	10	5
	12.0	140	4	0.060	12	6
	16.0	140	4	0.070	16	8
	20.0	140	4	0.080	20	10
	25.0	140	4	0.090	25	12,5
P3.2 High Alloy steels < 1600N/mm²	3.0	60	4	0.010	3	1,2
	4.0	60	4	0.020	4	2
	5.0	60	4	0.025	5	2,5
	6.0	60	4	0.030	6	3
	8.0	60	4	0.040	8	4
	10.0	60	4	0.060	10	5
	12.0	60	4	0.070	12	6
	16.0	60	4	0.085	16	8
	20.0	60	4	0.100	20	10
	25.0	60	4	0.120	25	12,5
P4.2 Cold working tool steel 12% Chrom	3.0	80	4	0.010	3	1,2
	4.0	80	4	0.015	4	2
	5.0	80	4	0.020	5	2,5
	6.0	80	4	0.025	6	3
	8.0	80	4	0.030	8	4
	10.0	80	4	0.050	10	5
	12.0	80	4	0.060	12	6
	16.0	80	4	0.065	16	8
	20.0	80	4	0.085	20	10
	25.0	80	4	0.095	25	12,5
M2.1 Stainless steel Austenitic 303-304-316	3.0	80	4	0.008	3	1,2
	4.0	80	4	0.010	4	2
	5.0	80	4	0.015	5	2,5
	6.0	80	4	0.020	6	3
	8.0	80	4	0.025	8	4
	10.0	80	4	0.030	10	5
	12.0	80	4	0.040	12	6
	16.0	80	4	0.050	16	8
	20.0	80	4	0.070	20	10
	25.0	80	4	0.100	25	12,5
K1.2 Cast iron	3.0	150	4	0.015	3	1,2
	4.0	150	4	0.020	4	2
	5.0	150	4	0.025	5	2,5
	6.0	150	4	0.030	6	3
	8.0	150	4	0.050	8	4
	10.0	150	4	0.070	10	5
	12.0	150	4	0.080	12	6
	16.0	150	4	0.090	16	8
	20.0	150	4	0.100	20	10
	25.0	150	4	0.150	25	12,5

Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1xD	20%	20%
Ae= <0,4xD	1,5xD	10%	10%
Ae= <0,05xD	2xD	20%	100%



Slotting Ap1xD
en Ae1xD



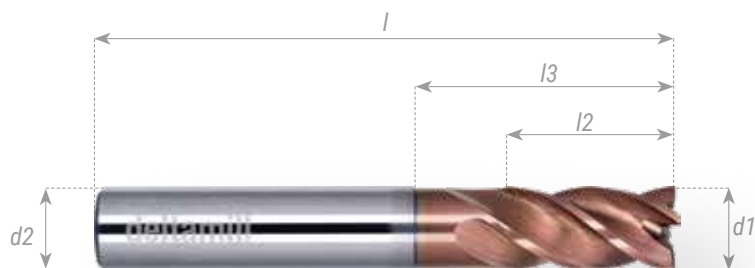
Contour Ap<1,5xD
en Ae<0,5xD



Finish Ap<2xD
en Ae 0,05xD



VHM HPC Performer frees Z4 SC HPC Performer endmill Z4



AGRESSOR PERFORMER



Code	Ød1	Ød2	L2	L3	L	z	r	€
D4900-0300P	3,0	6,0	8	-	57	4	0,1	37,00
D4900-0400P	4,0	6,0	11	-	57	4	0,1	37,00
D4900-0500P	5,0	6,0	13	18	57	4	0,1	37,00
D4900-0600P	6,0	6,0	13	18	57	4	0,1	37,00
D4900-0800P	8,0	8,0	21	25	63	4	0,2	47,00
D4900-1000P	10,0	10,0	22	30	72	4	0,2	69,00
D4900-1200P	12,0	12,0	26	36	83	4	0,3	95,00
D4900-1600P	16,0	16,0	36	42	92	4	0,3	177,00
D4900-2000P	20,0	20,0	41	52	103	4	0,3	284,00

Verspanings parameters Cutting Data

Mat.	ØD	Vc M/min	Z	slotting fz mm	ap mm	ae mm	trochidal fz mm ae=10% x D	drilling fz mm
P1.1 Steel < 800N/mm ²	3.0	180	4	0.015	3	3	0.03	0.015
	4.0	180	4	0.020	4	4	0.06	0.020
	5.0	180	4	0.030	5	5	0.08	0.030
	6.0	180	4	0.030	6	6	0.09	0.030
	8.0	180	4	0.040	8	8	0.11	0.040
	10.0	180	4	0.065	10	10	0.14	0.065
	12.0	180	4	0.070	12	12	0.18	0.070
	16.0	180	4	0.090	16	16	0.21	0.090
	20.0	180	4	0.110	20	20	0.24	0.110
P2.2 Heat Treatable steel < 1100N/mm ²	3.0	140	4	0.010	3	3	0.01	0.010
	4.0	140	4	0.015	4	4	0.04	0.015
	5.0	140	4	0.020	5	5	0.05	0.020
	6.0	140	4	0.025	6	6	0.08	0.025
	8.0	140	4	0.030	8	8	0.10	0.030
	10.0	140	4	0.050	10	10	0.13	0.050
	12.0	140	4	0.060	12	12	0.16	0.060
	16.0	140	4	0.070	16	16	0.19	0.070
	20.0	140	4	0.080	20	20	0.21	0.080
P3.2 High Alloy steels < 1600N/mm ²	3.0	60	4	0.010	3	3	0.01	0.010
	4.0	60	4	0.020	4	4	0.04	0.020
	5.0	60	4	0.025	5	5	0.05	0.025
	6.0	60	4	0.030	6	6	0.08	0.030
	8.0	60	4	0.040	8	8	0.10	0.040
	10.0	60	4	0.060	10	10	0.13	0.060
	12.0	60	4	0.070	12	12	0.16	0.070
	16.0	60	4	0.085	16	16	0.19	0.085
	20.0	60	4	0.100	20	20	0.21	0.100
P4.2 Cold working tool steel 12% Chrom	3.0	80	4	0.010	3	3	0.01	0.010
	4.0	80	4	0.015	4	4	0.04	0.015
	5.0	80	4	0.020	5	5	0.05	0.020
	6.0	80	4	0.025	6	6	0.08	0.025
	8.0	80	4	0.030	8	8	0.10	0.030
	10.0	80	4	0.050	10	10	0.13	0.050
	12.0	80	4	0.060	12	12	0.16	0.060
	16.0	80	4	0.065	16	16	0.19	0.065
	20.0	80	4	0.085	20	20	0.21	0.085
M2.1 Stainless steel Austenitic 303-304-316	3.0	80	4	0.008	3	3	0.03	0.008
	4.0	80	4	0.010	4	4	0.04	0.010
	5.0	80	4	0.015	5	5	0.05	0.015
	6.0	80	4	0.020	6	6	0.06	0.020
	8.0	80	4	0.025	8	8	0.07	0.025
	10.0	80	4	0.030	10	10	0.09	0.030
	12.0	80	4	0.040	12	12	0.11	0.040
	16.0	80	4	0.050	16	16	0.13	0.050
	20.0	80	4	0.070	20	20	0.19	0.070
K1.2 Cast iron	3.0	150	4	0.015	3	3	0.01	0.015
	4.0	150	4	0.020	4	4	0.04	0.020
	5.0	150	4	0.025	5	5	0.05	0.025
	6.0	150	4	0.030	6	6	0.08	0.030
	8.0	150	4	0.050	8	8	0.10	0.050
	10.0	150	4	0.070	10	10	0.13	0.070
	12.0	150	4	0.080	12	12	0.16	0.080
	16.0	150	4	0.090	16	16	0.19	0.090
	20.0	150	4	0.100	20	20	0.21	0.100



Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1xD	20%	20%
Ae= <0,4xD	1,5xD	10%	10%



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD



Contour Ap<1,5xD
en Ae<0,4xD

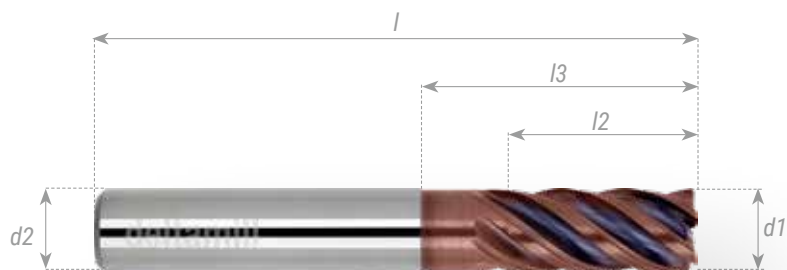


Finish Ap<2xD
en Ae 0,05xD



VHM HPC Universal frees Z5

SC HPC Universal endmill Z5



AGRESSOR UNI



Code	Ød1	Ød2	l2	l3	l	z	r	€
D5900-0805RBA	8,0	8,0	19	25	63	5	0,5	52,00
D5900-1005RBA	10,0	10,0	22	31	72	5	0,5	76,00
D5900-1205RBA	12,0	12,0	26	38	84	5	0,5	109,00
D5900-1605RBA	16,0	16,0	35	50	100	5	0,5	216,00
D5901-1610RBA	16,0	16,0	35	65	117	5	1,0	259,00
D5902-1610RBA	16,0	16,0	35	82	135	5	1,0	303,00

Verspanings parameters Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1	3.0	220	5	0.015	3	3
	4.0	220	5	0.020	4	4
	5.0	220	5	0.030	5	5
	6.0	220	5	0.030	6	6
	8.0	220	5	0.040	8	8
	10.0	220	5	0.065	10	10
	12.0	220	5	0.070	12	12
	16.0	220	5	0.090	16	16
	20.0	220	5	0.110	20	20
	25.0	220	5	0.150	25	25
P2.2	3.0	150	5	0.010	3	3
	4.0	150	5	0.015	4	4
	5.0	150	5	0.020	5	5
	6.0	150	5	0.025	6	6
	8.0	150	5	0.030	8	8
	10.0	150	5	0.050	10	10
	12.0	150	5	0.060	12	12
	16.0	150	5	0.070	16	16
	20.0	150	5	0.080	20	20
	25.0	150	5	0.090	25	25
P3.2	3.0	70	5	0.010	3	3
	4.0	70	5	0.020	4	4
	5.0	70	5	0.025	5	5
	6.0	70	5	0.030	6	6
	8.0	70	5	0.040	8	8
	10.0	70	5	0.060	10	10
	12.0	70	5	0.070	12	12
	16.0	70	5	0.085	16	16
	20.0	70	5	0.100	20	20
	25.0	70	5	0.120	25	25
P4.2	3.0	80	5	0.010	3	3
	4.0	80	5	0.015	4	4
	5.0	80	5	0.020	5	5
	6.0	80	5	0.025	6	6
	8.0	80	5	0.030	8	8
	10.0	80	5	0.050	10	10
	12.0	80	5	0.060	12	12
	16.0	80	5	0.065	16	16
	20.0	80	5	0.085	20	20
	25.0	80	5	0.095	25	25
M2.1	3.0	120	5	0.008	3	3
	4.0	120	5	0.010	4	4
	5.0	120	5	0.015	5	5
	6.0	120	5	0.020	6	6
	8.0	120	5	0.025	8	8
	10.0	120	5	0.030	10	10
	12.0	120	5	0.040	12	12
	16.0	120	5	0.050	16	16
	20.0	120	5	0.070	20	20
	25.0	120	5	0.100	25	25
K1.2	3.0	180	5	0.015	3	3
	4.0	180	5	0.020	4	4
	5.0	180	5	0.025	5	5
	6.0	180	5	0.030	6	6
	8.0	180	5	0.050	8	8
	10.0	180	5	0.070	10	10
	12.0	180	5	0.080	12	12
	16.0	180	5	0.090	16	16
	20.0	180	5	0.100	20	20
	25.0	180	5	0.150	25	25

Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1xD	20%	20%
Ae= <0,4xD	1,5xD	10%	10%
Ae= <0,05xD	2xD	20%	100%



Contour $Ap < 1,5xD$
en $Ae < 0,5xD$

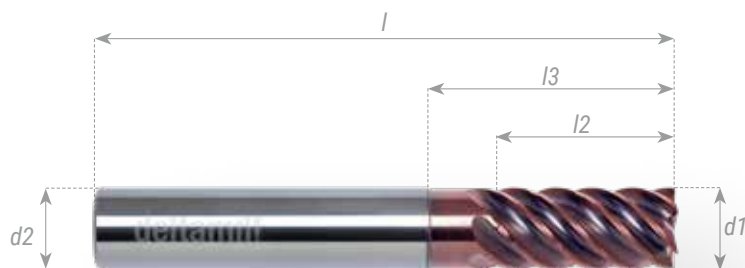


Finish $Ap < 2xD$
en $Ae 0,05xD$

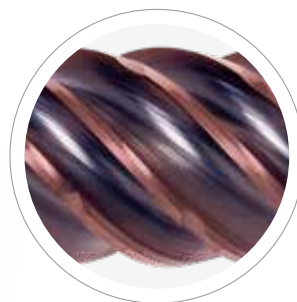


VHM Trochiodaal frees 2xD

SC Trochiodal endmill 2xD



XTREMA UNI



Code	Ød1	Ød2	L2	L3	L	z	c	€
D6910-0300HEX	3,0	6,0	8	15	57	5	0,1	50,00
D6910-0400HEX	4,0	6,0	11	16	57	5	0,1	50,00
D6910-0500HEX	5,0	6,0	13	19	57	6	0,1	50,00
D6910-0600HEX	6,0	6,0	13	19	57	6	0,1	50,00
D6910-0800HEX	8,0	8,0	19	25	63	6	0,2	77,00
D6910-1000HEX	10,0	10,0	22	30	72	6	0,2	92,00
D6910-1200HEX	12,0	12,0	26	36	83	6	0,3	114,00
D6910-1600HEX	16,0	16,0	32	42	92	6	0,3	213,00
D6910-2000HEX	20,0	20,0	38	52	103	6	0,3	293,00

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 15% x D	hm* mm
P1.1 Steel < 800N/mm ²	3.0	300	5	50°	8	0.05	0.03	0.02	0.010
	4.0	300	5	50°	11	0.08	0.06	0.05	0.015
	5.0	300	6	50°	13	0.10	0.08	0.07	0.020
	6.0	300	6	50°	13	0.13	0.09	0.08	0.030
	8.0	300	6	50°	19	0.16	0.11	0.09	0.050
	10.0	300	6	50°	22	0.20	0.14	0.12	0.054
	12.0	300	6	50°	26	0.25	0.18	0.15	0.057
	16.0	300	6	50°	32	0.29	0.21	0.17	0.065
	20.0	300	6	50°	38	0.34	0.24	0.19	0.075
P2.2 Heat Treatable steel < 1100N/mm ²	3.0	240	5	50°	8	0.04	0.01	0.005	0.008
	4.0	240	5	50°	11	0.07	0.04	0.02	0.013
	5.0	240	6	50°	13	0.09	0.05	0.03	0.018
	6.0	240	6	50°	13	0.11	0.08	0.06	0.025
	8.0	240	6	50°	19	0.14	0.10	0.08	0.032
	10.0	240	6	50°	22	0.18	0.13	0.10	0.040
	12.0	240	6	50°	26	0.23	0.16	0.13	0.051
	16.0	240	6	50°	32	0.27	0.19	0.15	0.060
	20.0	240	6	50°	38	0.29	0.21	0.17	0.065
P3.2 High Alloy steels < 1600N/mm ²	3.0	210	5	50°	8	0.04	0.01	0.005	0.008
	4.0	210	5	50°	11	0.07	0.04	0.02	0.013
	5.0	210	6	50°	13	0.09	0.05	0.03	0.018
	6.0	210	6	50°	13	0.11	0.08	0.06	0.025
	8.0	210	6	50°	19	0.14	0.10	0.08	0.032
	10.0	210	6	50°	22	0.18	0.13	0.10	0.040
	12.0	210	6	50°	26	0.23	0.16	0.13	0.051
	16.0	210	6	50°	32	0.27	0.19	0.15	0.060
	20.0	210	6	50°	38	0.29	0.21	0.17	0.065
P4.2 Cold working tool steel 12% Chrom	3.0	230	5	45°	8	0.04	0.01	0.005	0.008
	4.0	230	5	45°	11	0.07	0.04	0.02	0.013
	5.0	230	6	45°	13	0.09	0.05	0.03	0.018
	6.0	230	6	45°	13	0.11	0.08	0.06	0.025
	8.0	230	6	45°	19	0.14	0.10	0.08	0.032
	10.0	230	6	45°	22	0.18	0.13	0.10	0.040
	12.0	230	6	45°	26	0.23	0.16	0.13	0.051
	16.0	230	6	45°	32	0.27	0.19	0.15	0.060
	20.0	230	6	45°	38	0.29	0.21	0.17	0.065
M2.1 Stainless steel Austenitic 303-304-316	3.0	170	5	45°	8	0.04	0.03	0.025	0.015
	4.0	170	5	45°	11	0.05	0.04	0.03	0.025
	5.0	170	6	45°	13	0.07	0.05	0.035	0.045
	6.0	170	6	45°	13	0.08	0.06	0.05	0.045
	8.0	170	6	45°	19	0.10	0.07	0.06	0.045
	10.0	170	6	45°	22	0.13	0.09	0.07	0.075
	12.0	170	6	45°	26	0.16	0.11	0.09	0.075
	16.0	170	6	45°	32	0.19	0.13	0.11	0.090
	20.0	170	6	45°	38	0.27	0.19	0.15	0.125
K1.2 Cast iron	3.0	290	5	50°	8	0.04	0.01	0.005	0.008
	4.0	290	5	50°	11	0.07	0.04	0.02	0.013
	5.0	290	6	50°	13	0.09	0.05	0.03	0.018
	6.0	290	6	50°	13	0.11	0.08	0.06	0.025
	8.0	290	6	50°	19	0.14	0.01	0.08	0.032
	10.0	290	6	50°	22	0.18	0.13	0.10	0.040
	12.0	290	6	50°	26	0.23	0.16	0.13	0.051
	16.0	290	6	50°	32	0.27	0.19	0.15	0.060
	20.0	290	6	50°	38	0.29	0.21	0.17	0.065
	25.0	290	6	50°	76	0.33	0.23	0.18	0.080

Verspanings parameters *Cutting Data*

*hm= gemiddelde spaandikte
*hm= average chip thickness

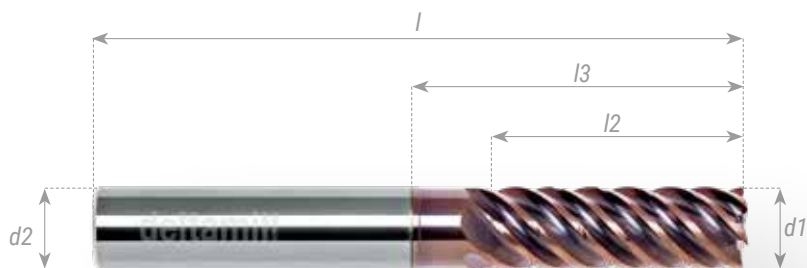


Trochiodal Max Ap
Ae max 15% x D



VHM Trochiodaal frees 3xD

SC Trochiodal endmill 3xD


XTREMA UNI


Code	Ød1	Ød2	l2	l3	l	z	c	€
D6913-0300HEX	3,0	6,0	14	23	62	5	0,1	59,00
D6913-0400HEX	4,0	6,0	15	23	62	5	0,1	59,00
D6913-0500HEX	5,0	6,0	16	24	62	6	0,1	59,00
D6913-0600HEX	6,0	6,0	19	24	62	6	0,1	59,00
D6913-0800HEX	8,0	8,0	25	30	68	6	0,2	85,00
D6913-1000HEX	10,0	10,0	31	38	80	6	0,2	111,00
D6913-1200HEX	12,0	12,0	37	46	93	6	0,3	136,00
D6913-1600HEX	16,0	16,0	49	58	108	6	0,3	245,00
D6913-2000HEX	20,0	20,0	61	74	126	6	0,3	347,00

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 15% x D	hm* mm
P1.1 Steel < 800N/mm ²	3.0	300	5	50°	14	0.050	0.030	0.020	0.010
	4.0	300	5	50°	15	0.080	0.060	0.050	0.015
	5.0	300	6	50°	16	0.100	0.080	0.070	0.020
	6.0	300	6	50°	19	0.130	0.090	0.080	0.030
	8.0	300	6	50°	25	0.160	0.110	0.090	0.050
	10.0	300	6	50°	31	0.200	0.140	0.120	0.054
	12.0	300	6	50°	37	0.250	0.180	0.150	0.057
	16.0	300	6	50°	49	0.290	0.210	0.170	0.065
	20.0	300	6	50°	61	0.340	0.240	0.190	0.075
P2.2 Heat Treatable steel < 1100N/mm ²	3.0	240	5	50°	14	0.040	0.010	0.005	0.008
	4.0	240	5	50°	15	0.070	0.040	0.020	0.013
	5.0	240	6	50°	16	0.090	0.050	0.030	0.018
	6.0	240	6	50°	19	0.110	0.080	0.060	0.025
	8.0	240	6	50°	25	0.140	0.100	0.080	0.032
	10.0	240	6	50°	31	0.180	0.130	0.100	0.040
	12.0	240	6	50°	37	0.230	0.160	0.130	0.051
	16.0	240	6	50°	49	0.270	0.190	0.150	0.060
	20.0	240	6	50°	61	0.290	0.210	0.170	0.065
P3.2 High Alloy steels < 1600N/mm ²	3.0	210	5	50°	14	0.040	0.010	0.005	0.008
	4.0	210	5	50°	15	0.070	0.040	0.020	0.013
	5.0	210	6	50°	16	0.090	0.050	0.030	0.018
	6.0	210	6	50°	19	0.110	0.080	0.060	0.025
	8.0	210	6	50°	25	0.140	0.100	0.080	0.032
	10.0	210	6	50°	31	0.180	0.130	0.100	0.040
	12.0	210	6	50°	37	0.230	0.160	0.130	0.051
	16.0	210	6	50°	49	0.270	0.190	0.150	0.060
	20.0	210	6	50°	61	0.290	0.210	0.170	0.065
P4.2 Cold working tool steel 12% Chrom	3.0	230	5	45°	14	0.040	0.010	0.005	0.008
	4.0	230	5	45°	15	0.070	0.040	0.020	0.013
	5.0	230	6	45°	16	0.090	0.050	0.030	0.018
	6.0	230	6	45°	19	0.110	0.080	0.060	0.025
	8.0	230	6	45°	25	0.140	0.100	0.080	0.032
	10.0	230	6	45°	31	0.180	0.130	0.100	0.040
	12.0	230	6	45°	37	0.230	0.160	0.130	0.051
	16.0	230	6	45°	49	0.270	0.190	0.150	0.060
	20.0	230	6	45°	61	0.290	0.210	0.170	0.065
M2.1 Stainless steel Austenitic 303-304-316	3.0	170	5	45°	14	0.040	0.030	0.025	0.015
	4.0	170	5	45°	15	0.050	0.040	0.030	0.025
	5.0	170	6	45°	16	0.070	0.050	0.035	0.045
	6.0	170	6	45°	19	0.080	0.060	0.050	0.045
	8.0	170	6	45°	25	0.100	0.070	0.060	0.045
	10.0	170	6	45°	31	0.130	0.090	0.070	0.075
	12.0	170	6	45°	37	0.160	0.110	0.090	0.075
	16.0	170	6	45°	49	0.190	0.130	0.110	0.090
	20.0	170	6	45°	61	0.270	0.190	0.150	0.125
K1.2 Cast iron	3.0	290	5	50°	14	0.040	0.010	0.005	0.008
	4.0	290	5	50°	15	0.070	0.040	0.020	0.013
	5.0	290	6	50°	16	0.090	0.050	0.030	0.018
	6.0	290	6	50°	19	0.110	0.080	0.060	0.025
	8.0	290	6	50°	25	0.140	0.100	0.080	0.032
	10.0	290	6	50°	31	0.180	0.130	0.100	0.040
	12.0	290	6	50°	37	0.230	0.160	0.130	0.051
	16.0	290	6	50°	49	0.270	0.190	0.150	0.060
	20.0	290	6	50°	61	0.290	0.210	0.170	0.065
	25.0	290	6	50°	76	0.330	0.230	0.180	0.080

Verspanings parameters *Cutting Data*

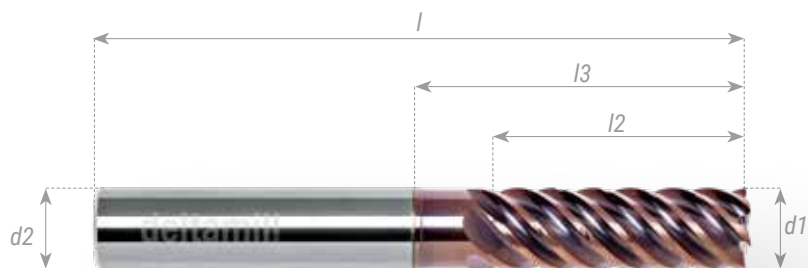
*hm= gemiddelde spaandikte
*hm= average chip thickness



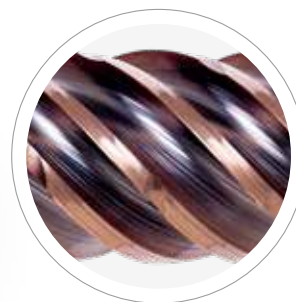
**Trochiodal Max Ap
and Ae max 15%**



VHM Trochiodaal frees 3xD, Radius SC Trochiodal endmill 3xD, Radius



XTREMA UNI



Code	Ød1	Ød2	l2	l3	l	z	r	€
D6913-0605RHEX	6,0	6,0	19	23	62	6	0,5	70,00
D6913-0610RHEX	6,0	6,0	19	23	62	6	1,0	70,00
D6913-0805RHEX	8,0	8,0	25	30	68	6	0,5	96,00
D6913-0810RHEX	8,0	8,0	25	30	68	6	1,0	96,00
D6913-1005RHEX	10,0	10,0	31	38	80	6	0,5	126,00
D6913-1010RHEX	10,0	10,0	31	38	80	6	1,0	126,00
D6913-1020RHEX	10,0	10,0	31	38	80	6	2,0	126,00
D6913-1205RHEX	12,0	12,0	37	46	93	6	0,5	156,00
D6913-1210RHEX	12,0	12,0	37	46	93	6	1,0	156,00
D6913-1220RHEX	12,0	12,0	37	46	93	6	2,0	156,00
D6913-1610RHEX	16,0	16,0	49	68	120	6	1,0	288,00
D6913-1610R-4D	16,0	16,0	49	58	108	6	1,0	270,00
D6913-1620RHEX	16,0	16,0	49	58	108	6	2,0	270,00
D6913-2010RHEX	20,0	20,0	61	74	126	6	1,0	380,00
D6913-2010R-4D	20,0	20,0	61	83	135	6	1,0	380,00
D6913-2020RHEX	20,0	20,0	61	74	126	6	2,0	380,00

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 15% x D	hm* mm
P1.1	6.0	300	6	50°	19	0.130	0.090	0.080	0.030
	8.0	300	6	50°	25	0.160	0.110	0.090	0.050
	10.0	300	6	50°	31	0.200	0.140	0.120	0.054
	12.0	300	6	50°	37	0.250	0.180	0.150	0.057
	16.0	300	6	50°	49	0.290	0.210	0.170	0.065
	20.0	300	6	50°	61	0.340	0.240	0.190	0.075
Steel < 800N/mm²									
P2.2	6.0	240	6	50°	19	0.110	0.080	0.060	0.025
	8.0	240	6	50°	25	0.140	0.100	0.080	0.032
	10.0	240	6	50°	31	0.180	0.130	0.100	0.040
	12.0	240	6	50°	37	0.230	0.160	0.130	0.051
	16.0	240	6	50°	49	0.270	0.190	0.150	0.060
	20.0	240	6	50°	61	0.290	0.210	0.170	0.065
Heat Treatable steel < 1100N/mm²									
P3.2	6.0	210	6	50°	19	0.110	0.080	0.060	0.025
	8.0	210	6	50°	25	0.140	0.100	0.080	0.032
	10.0	210	6	50°	31	0.180	0.130	0.100	0.040
	12.0	210	6	50°	37	0.230	0.160	0.130	0.051
	16.0	210	6	50°	49	0.270	0.190	0.150	0.060
	20.0	210	6	50°	61	0.290	0.210	0.170	0.065
High Alloy steels < 1600N/mm²									
P4.2	6.0	230	6	45°	19	0.110	0.080	0.060	0.025
	8.0	230	6	45°	25	0.140	0.100	0.080	0.032
	10.0	230	6	45°	31	0.180	0.130	0.100	0.040
	12.0	230	6	45°	37	0.230	0.160	0.130	0.051
	16.0	230	6	45°	49	0.270	0.190	0.150	0.060
	20.0	230	6	45°	61	0.290	0.210	0.170	0.065
Cold working tool steel 12% Chrom									
M2.1	6.0	170	6	45°	19	0.080	0.060	0.050	0.045
	8.0	170	6	45°	25	0.100	0.070	0.060	0.045
	10.0	170	6	45°	31	0.130	0.090	0.070	0.075
	12.0	170	6	45°	37	0.160	0.110	0.090	0.075
	16.0	170	6	45°	49	0.190	0.130	0.110	0.090
	20.0	170	6	45°	61	0.270	0.190	0.150	0.125
Stainless steel Austenitic 303-304-316									
K1.2	6.0	290	6	50°	19	0.110	0.080	0.060	0.025
	8.0	290	6	50°	25	0.140	0.100	0.080	0.032
	10.0	290	6	50°	31	0.180	0.130	0.100	0.040
	12.0	290	6	50°	37	0.230	0.160	0.130	0.051
	16.0	290	6	50°	49	0.270	0.190	0.150	0.060
	20.0	290	6	50°	61	0.290	0.210	0.170	0.065
Cast iron	25.0	290	6	50°	76	0.330	0.230	0.180	0.080

Verspanings parameters *Cutting Data*

*hm= gemiddelde spaandikte
*hm= average chip thickness

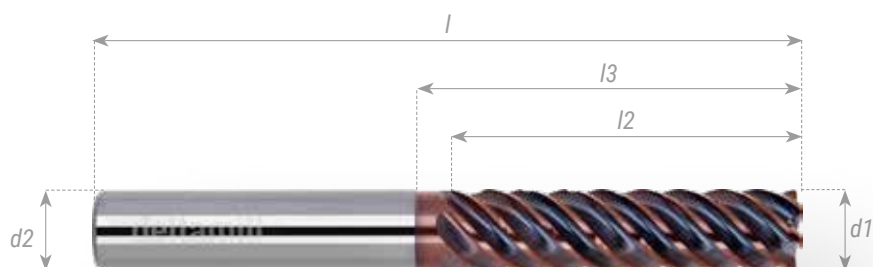


Trochiodal Max Ap
and Ae max 15%

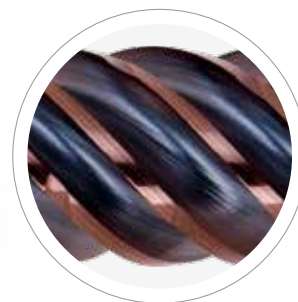


VHM Trochiodaal frees 4xD

SC Trochiodal endmill 4xD



XTREMA UNI



Code	Ød1	Ød2	l2	l3	l	z	r	€
D6914-0600HEX	6,0	6,0	26	35	72	6	0,2	67,00
D6914-0800HEX	8,0	8,0	34	45	80	6	0,2	93,00
D6914-1000HEX	10,0	10,0	42	55	90	6	0,2	126,00
D6914-1200HEX	12,0	12,0	50	55	103	6	0,3	173,00
D6914-1600HEX	16,0	16,0	66	75	125	6	0,3	340,00
D6914-2000HEX	20,0	20,0	82	90	140	6	0,3	537,00

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 15% x D	hm* mm
P1.1	6.0	300	6	50°	24	0.130	0.090	0.080	0.030
	8.0	300	6	50°	32	0.160	0.110	0.090	0.050
	10.0	300	6	50°	40	0.200	0.140	0.120	0.054
	12.0	300	6	50°	48	0.250	0.180	0.150	0.057
	16.0	300	6	50°	64	0.290	0.210	0.170	0.065
	20.0	300	6	50°	80	0.340	0.240	0.190	0.075
Steel < 800N/mm²									
P2.2	6.0	240	6	50°	13	0.110	0.080	0.060	0.025
	8.0	240	6	50°	19	0.140	0.100	0.080	0.032
	10.0	240	6	50°	22	0.180	0.130	0.100	0.040
	12.0	240	6	50°	26	0.230	0.160	0.130	0.051
	16.0	240	6	50°	32	0.270	0.190	0.150	0.060
	20.0	240	6	50°	38	0.290	0.210	0.170	0.065
Heat Treatable steel < 1100N/mm²									
P3.2	6.0	240	6	50°	13	0.110	0.080	0.060	0.025
	8.0	240	6	50°	19	0.140	0.100	0.080	0.032
	10.0	240	6	50°	22	0.180	0.130	0.100	0.040
	12.0	240	6	50°	26	0.230	0.160	0.130	0.051
	16.0	240	6	50°	32	0.270	0.190	0.150	0.060
	20.0	240	6	50°	38	0.290	0.210	0.170	0.065
High Alloy steels < 1600N/mm²									
P4.2	6.0	230	6	45°	13	0.110	0.080	0.060	0.025
	8.0	230	6	45°	19	0.140	0.100	0.080	0.032
	10.0	230	6	45°	22	0.180	0.130	0.100	0.040
	12.0	230	6	45°	26	0.230	0.160	0.130	0.051
	16.0	230	6	45°	32	0.270	0.190	0.150	0.060
	20.0	230	6	45°	38	0.290	0.210	0.170	0.065
Cold working tool steel 12% Chrom									
M2.1	6.0	170	6	45°	13	0.080	0.060	0.050	0.045
	8.0	170	6	45°	19	0.100	0.070	0.060	0.045
	10.0	170	6	45°	22	0.130	0.090	0.070	0.075
	12.0	170	6	45°	26	0.160	0.110	0.090	0.075
	16.0	170	6	45°	32	0.190	0.130	0.110	0.090
	20.0	170	6	45°	38	0.270	0.150	0.150	0.125
Stainless steel Austenitic 303-304-316									
K1.2	6.0	290	6	50°	13	0.110	0.080	0.060	0.025
	8.0	290	6	50°	19	0.140	0.100	0.080	0.032
	10.0	290	6	50°	22	0.180	0.130	0.100	0.040
	12.0	290	6	50°	26	0.230	0.160	0.130	0.051
	16.0	290	6	50°	32	0.270	0.190	0.150	0.060
	20.0	290	6	50°	38	0.290	0.210	0.170	0.065
Cast iron	25.0	290	6	50°	76	0.330	0.230	0.180	0.080

Verspanings parameters *Cutting Data*

*hm= gemiddelde spaandikte
*hm= average chip thickness

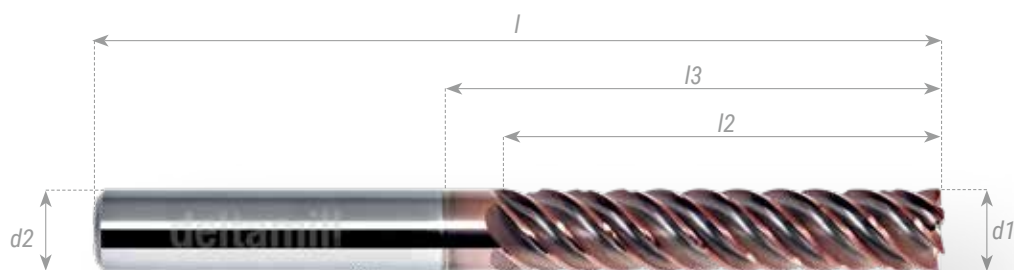


Trochiodal Max Ap
Ae max 15% x D



VHM Trochiodaal frees 5xD

SC Trochiodal endmill 5xD



XTREMA UNI



Code	Ød1	Ød2	l2	l3	l	z	r	€
D6915-0600HEX	6,0	6,0	32	-	70	6	0,2	68,00
D6915-0800HEX	8,0	8,0	42	-	80	6	0,2	96,00
D6915-1000HEX	10,0	10,0	52	-	100	6	0,2	126,00
D6915-1200HEX	12,0	12,0	62	-	116	6	0,3	175,00
D6915-1600HEX	16,0	16,0	82	-	140	6	0,3	342,00
D6915-2000HEX	20,0	20,0	102	-	163	6	0,3	583,00

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 15% x D	hm* mm
P1.1	6.0	300	6	50°	30	0.130	0.090	0.080	0.030
	8.0	300	6	50°	40	0.160	0.110	0.090	0.050
	10.0	300	6	50°	50	0.200	0.140	0.120	0.054
	12.0	300	6	50°	60	0.250	0.180	0.150	0.057
	16.0	300	6	50°	80	0.290	0.210	0.170	0.065
	20.0	300	6	50°	100	0.340	0.240	0.190	0.075
Steel < 800N/mm²									
P2.2	6.0	240	6	50°	30	0.110	0.080	0.060	0.025
	8.0	240	6	50°	40	0.140	0.100	0.080	0.032
	10.0	240	6	50°	50	0.180	0.130	0.100	0.040
	12.0	240	6	50°	60	0.230	0.160	0.130	0.051
	16.0	240	6	50°	80	0.270	0.190	0.150	0.060
	20.0	240	6	50°	100	0.290	0.210	0.170	0.065
Heat Treatable steel < 1100N/mm²									
P3.2	6.0	240	6	50°	30	0.110	0.080	0.060	0.025
	8.0	240	6	50°	40	0.140	0.100	0.080	0.032
	10.0	240	6	50°	50	0.180	0.130	0.100	0.040
	12.0	240	6	50°	60	0.230	0.160	0.130	0.051
	16.0	240	6	50°	80	0.270	0.190	0.150	0.060
	20.0	240	6	50°	100	0.290	0.210	0.170	0.065
High Alloy steels < 1600N/mm²									
P4.2	6.0	230	6	45°	30	0.110	0.080	0.060	0.025
	8.0	230	6	45°	40	0.140	0.100	0.080	0.032
	10.0	230	6	45°	50	0.180	0.130	0.100	0.040
	12.0	230	6	45°	60	0.230	0.160	0.130	0.051
	16.0	230	6	45°	80	0.270	0.190	0.150	0.060
	20.0	230	6	45°	100	0.290	0.210	0.170	0.065
Cold working tool steel 12% Chrom									
M2.1	6.0	170	6	45°	30	0.080	0.060	0.050	0.045
	8.0	170	6	45°	40	0.100	0.070	0.060	0.045
	10.0	170	6	45°	50	0.130	0.090	0.070	0.075
	12.0	170	6	45°	60	0.160	0.110	0.090	0.075
	16.0	170	6	45°	80	0.190	0.130	0.110	0.090
	20.0	170	6	45°	100	0.270	0.150	0.150	0.125
Stainless steel Austenitic 303-304-316									
K1.2	6.0	290	6	50°	30	0.110	0.080	0.060	0.025
	8.0	290	6	50°	40	0.140	0.100	0.080	0.032
	10.0	290	6	50°	50	0.180	0.130	0.100	0.040
	12.0	290	6	50°	60	0.230	0.160	0.130	0.051
	16.0	290	6	50°	80	0.270	0.190	0.150	0.060
	20.0	290	6	50°	100	0.290	0.210	0.170	0.065
Cast iron									

Verspanings parameters *Cutting Data*

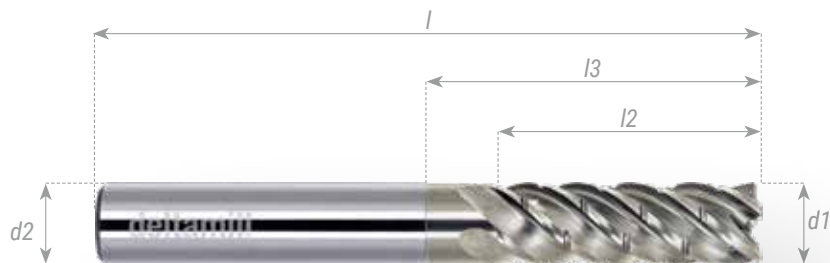
*hm= gemiddelde spaandikte
*hm= average chip thickness



Trochiodal Max Ap
and Ae max 15%

VHM Trochiodaal frees INOX 3xD

SC Trochiodal endmill INOX 3xD



XTREMA INOX



Code	Ød1	Ød2	l2	l3	l	z	c	€
D5923-0600SI2	6,0	6,0	19	24	62	5	0,1	74,00
D5923-0800SI2	8,0	8,0	25	30	68	5	0,2	88,00
D5923-1000SI2	10,0	10,0	31	38	80	5	0,2	118,00
D5923-1200SI2	12,0	12,0	37	47	93	5	0,3	142,00
D5923-1600SI2	16,0	16,0	49	58	108	5	0,3	264,00
D5923-2000SI2	20,0	20,0	61	74	126	5	0,3	352,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 15% x D	hm* mm
M1.1	6.0	180	5	45°	18	0.08	0.06	0.05	0.045
	8.0	180	5	45°	24	0.10	0.07	0.06	0.045
	10.0	180	5	45°	30	0.13	0.09	0.07	0.075
	12.0	180	5	45°	36	0.16	0.17	0.09	0.075
	16.0	180	5	45°	48	0.19	0.13	0.11	0.090
	20.0	180	5	45°	60	0.27	0.19	0.15	0.125
Stainless Steel Ferritic									
M1.2	6.0	185	5	45°	18	0.08	0.06	0.05	0.045
	8.0	185	5	45°	24	0.10	0.07	0.06	0.045
	10.0	185	5	45°	30	0.13	0.09	0.07	0.075
	12.0	185	5	45°	36	0.16	0.17	0.09	0.075
	16.0	185	5	45°	48	0.19	0.13	0.11	0.090
	20.0	185	5	45°	60	0.27	0.19	0.15	0.125
Stainless steel Martensitic									
M1.3	6.0	185	5	45°	18	0.08	0.06	0.05	0.045
	8.0	185	5	45°	24	0.10	0.07	0.06	0.045
	10.0	185	5	45°	30	0.13	0.09	0.07	0.075
	12.0	185	5	45°	36	0.16	0.17	0.09	0.075
	16.0	185	5	45°	48	0.19	0.13	0.11	0.090
	20.0	185	5	45°	60	0.27	0.19	0.15	0.125
Stainless steel Hardenable									
M2.1	6.0	170	5	45°	18	0.08	0.06	0.05	0.045
	8.0	170	5	45°	24	0.10	0.07	0.06	0.045
	10.0	170	5	45°	30	0.13	0.09	0.07	0.075
	12.0	170	5	45°	36	0.16	0.17	0.09	0.075
	16.0	170	5	45°	48	0.19	0.13	0.11	0.090
	20.0	170	5	45°	60	0.27	0.19	0.15	0.125
Stainless steel Austenitic									
M3.1	6.0	185	5	45°	18	0.08	0.06	0.05	0.045
	8.0	185	5	45°	24	0.10	0.07	0.06	0.045
	10.0	185	5	45°	30	0.13	0.09	0.07	0.075
	12.0	185	5	45°	36	0.16	0.17	0.09	0.075
	16.0	185	5	45°	48	0.19	0.13	0.11	0.090
	20.0	185	5	45°	60	0.27	0.19	0.15	0.125
Stainless steel Duplex									

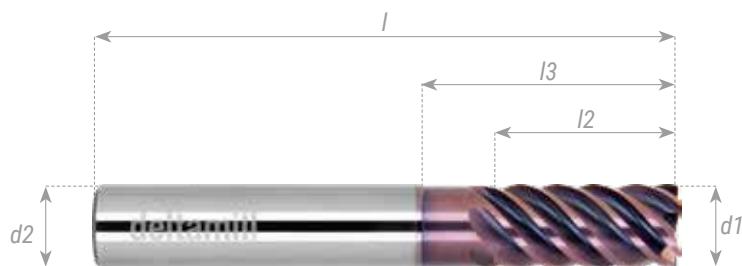
*hm= gemiddelde spaandikte
*hm= average chip thickness



Trochiodal Max Ap
and Ae max 15% x D



VHM HPC Finish Frees 2xD SC HPC endmill for finishing 2xD



AGRESSOR FINISHER



Code	Ød1	Ød2	l2	l3	l	z	c	€
D6900-0300BA	3,0	6,0	8	14	57	6	-	39,00
D6900-0400BA	4,0	6,0	11	16	57	6	-	39,00
D6900-0500BA	5,0	6,0	13	17	57	6	-	39,00
D6900-0600BA	6,0	6,0	13	20	57	6	-	39,00
D6900-0800BA	8,0	8,0	19	25	63	6	-	53,00
D6900-1000BA	10,0	10,0	22	30	72	6	-	73,00
D6900-1200BA	12,0	12,0	26	36	83	6	-	96,00
D6900-1600BA	16,0	16,0	32	42	92	8	-	174,00
D6900-2000BA	20,0	20,0	38	52	104	8	-	247,00

Verspanings parameters

Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	220	6	0.01	6	0.15
	4.0	220	6	0.015	8	0.20
	5.0	220	6	0.02	10	0.25
	6.0	220	6	0.025	12	0.30
	8.0	220	6	0.04	16	0.40
	10.0	220	6	0.05	20	0.50
	12.0	220	6	0.06	24	0.60
	16.0	220	6	0.08	32	0.80
	20.0	220	6	0.10	40	1.00
P2.2 Heat Treatable steel < 1100N/mm²	3.0	200	6	0.01	6	0.15
	4.0	200	6	0.015	8	0.20
	5.0	200	6	0.02	10	0.25
	6.0	200	6	0.025	12	0.30
	8.0	200	6	0.04	16	0.40
	10.0	200	6	0.05	20	0.50
	12.0	200	6	0.06	24	0.60
	16.0	200	6	0.08	32	0.80
	20.0	200	6	0.10	40	1.00
P3.2 High Alloy steels < 1600N/mm²	3.0	180	6	0.01	6	0.15
	4.0	180	6	0.015	8	0.20
	5.0	180	6	0.02	10	0.25
	6.0	180	6	0.025	12	0.30
	8.0	180	6	0.04	16	0.40
	10.0	180	6	0.05	20	0.50
	12.0	180	6	0.06	24	0.60
	16.0	180	6	0.08	32	0.80
	20.0	180	6	0.10	40	1.00
P4.2 Cold working tool steel 12% Chrom	3.0	170	6	0.01	6	0.15
	4.0	170	6	0.015	8	0.20
	5.0	170	6	0.02	10	0.25
	6.0	170	6	0.025	12	0.30
	8.0	170	6	0.04	16	0.40
	10.0	170	6	0.05	20	0.50
	12.0	170	6	0.06	24	0.60
	16.0	170	6	0.08	32	0.80
	20.0	170	6	0.10	40	1.00
M2.1 Stainless steel Austenitic 303-304-316	3.0	100	6	0.01	6	0.15
	4.0	100	6	0.02	8	0.20
	5.0	100	6	0.025	10	0.25
	6.0	100	6	0.025	12	0.30
	8.0	100	6	0.03	16	0.40
	10.0	100	6	0.04	20	0.50
	12.0	100	6	0.05	24	0.60
	16.0	100	6	0.07	32	0.80
	20.0	100	6	0.09	40	1.00
K1.2 Cast iron	3.0	220	6	0.015	6	0.15
	4.0	220	6	0.02	8	0.20
	5.0	220	6	0.025	10	0.25
	6.0	220	6	0.035	12	0.30
	8.0	220	6	0.05	16	0.40
	10.0	220	6	0.07	20	0.50
	12.0	220	6	0.08	24	0.60
	16.0	220	6	0.10	32	0.80
	20.0	220	6	0.12	40	1.00



Finish $A_p < \max$
en $A_e 0,05 \times D$



VHM HPC Finish frees 3xD

SC HPC endmill for finishing 3xD



AGRESSOR FINISHER



Code	Ød1	Ød2	l2	l3	l	z	c	€
D6902-0400BA	4,0	6,0	16	-	62	6	-	41,00
D6902-0500BA	5,0	6,0	18	-	62	6	-	41,00
D6902-0600BA	6,0	6,0	18	-	62	6	-	41,00
D6902-0800BA	8,0	8,0	24	-	68	6	-	59,00
D6902-1000BA	10,0	10,0	30	-	80	6	-	83,00
D6902-1200BA	12,0	12,0	36	-	93	6	-	121,00
D6902-1600BA	16,0	16,0	48	-	108	8	-	193,00
D6902-2000BA	20,0	20,0	60	-	126	8	-	262,00

Verspanings parameters *Cutting Data*

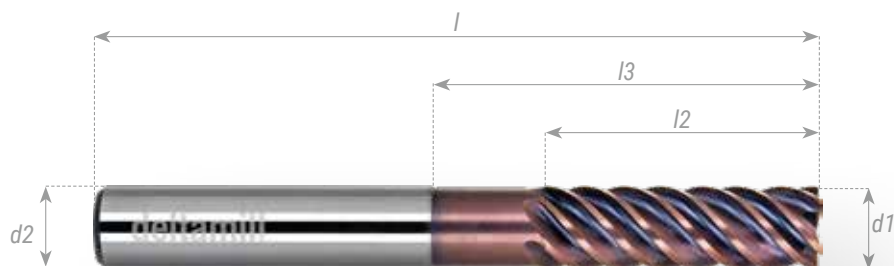
Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	220	6	0.01	6	0.15
	4.0	220	6	0.015	8	0.20
	5.0	220	6	0.02	10	0.25
	6.0	220	6	0.025	12	0.30
	8.0	220	6	0.04	16	0.40
	10.0	220	6	0.05	20	0.50
	12.0	220	6	0.06	24	0.60
	16.0	220	6	0.08	32	0.80
	20.0	220	6	0.10	40	1.00
P2.2 Heat Treatable steel < 1100N/mm²	3.0	200	6	0.01	6	0.15
	4.0	200	6	0.015	8	0.20
	5.0	200	6	0.02	10	0.25
	6.0	200	6	0.025	12	0.30
	8.0	200	6	0.04	16	0.40
	10.0	200	6	0.05	20	0.50
	12.0	200	6	0.06	24	0.60
	16.0	200	6	0.08	32	0.80
	20.0	200	6	0.10	40	1.00
P3.2 High Alloy steels < 1600N/mm²	3.0	180	6	0.01	6	0.15
	4.0	180	6	0.015	8	0.20
	5.0	180	6	0.02	10	0.25
	6.0	180	6	0.025	12	0.30
	8.0	180	6	0.04	16	0.40
	10.0	180	6	0.05	20	0.50
	12.0	180	6	0.06	24	0.60
	16.0	180	6	0.08	32	0.80
	20.0	180	6	0.10	40	1.00
P4.2 Cold working tool steel 12% Chrom	3.0	170	6	0.01	6	0.15
	4.0	170	6	0.015	8	0.20
	5.0	170	6	0.02	10	0.25
	6.0	170	6	0.025	12	0.30
	8.0	170	6	0.04	16	0.40
	10.0	170	6	0.05	20	0.50
	12.0	170	6	0.06	24	0.60
	16.0	170	6	0.08	32	0.80
	20.0	170	6	0.10	40	1.00
M2.1 Stainless steel Austenitic 303-304-316	3.0	100	6	0.01	6	0.15
	4.0	100	6	0.02	8	0.20
	5.0	100	6	0.025	10	0.25
	6.0	100	6	0.025	12	0.30
	8.0	100	6	0.03	16	0.40
	10.0	100	6	0.04	20	0.50
	12.0	100	6	0.05	24	0.60
	16.0	100	6	0.07	32	0.80
	20.0	100	6	0.09	40	1.00
K1.2 Cast iron	3.0	220	6	0.015	6	0.15
	4.0	220	6	0.02	8	0.20
	5.0	220	6	0.025	10	0.25
	6.0	220	6	0.035	12	0.30
	8.0	220	6	0.05	16	0.40
	10.0	220	6	0.07	20	0.50
	12.0	220	6	0.08	24	0.60
	16.0	220	6	0.10	32	0.80
	20.0	220	6	0.12	40	1.00



Finish $A_p < \max$
en $A_e 0,05 \times D$



VHM HPC Finish frees 3xD (nek 4xD) SC- HPC endmill for finishing 3xD (Neckrelief 4xD)



AGRESSOR FINISHER



Code	Ød1	Ød2	l2	l3	l	z	r	€
D6902-0600-4D	6,0	6,0	19	26	72	6	-	50,00
D6902-0800-4D	8,0	8,0	27	35	80	6	-	69,00
D6902-1000-4D	10,0	10,0	32	45	90	6	-	101,00
D6902-1005-4D	10,0	10,0	32	45	90	6	0,5	124,00
D6902-1010-4D	10,0	10,0	32	45	90	6	1,0	124,00
D6902-1200-4D	12,0	12,0	39	55	103	6	-	129,00
D6902-1205-4D	12,0	12,0	39	55	103	6	0,5	147,00
D6902-1210-4D	12,0	12,0	39	55	103	6	1,0	147,00
D6902-1600-4D	16,0	16,0	50	66	115	6	-	230,00
D6902-1610-4D	16,0	16,0	50	66	115	6	1,0	270,00
D6902-1600-4D	16,0	16,0	50	66	115	6	2,0	270,00
D6902-2000-4D	20,0	20,0	63	80	130	6	-	284,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	220	6	0.01	6	0.15
	4.0	220	6	0.015	8	0.20
	5.0	220	6	0.02	10	0.25
	6.0	220	6	0.025	12	0.30
	8.0	220	6	0.04	16	0.40
	10.0	220	6	0.05	20	0.50
	12.0	220	6	0.06	24	0.60
	16.0	220	6	0.08	32	0.80
	20.0	220	6	0.10	40	1.00
P2.2 Heat Treatable steel < 1100N/mm²	3.0	200	6	0.01	6	0.15
	4.0	200	6	0.015	8	0.20
	5.0	200	6	0.02	10	0.25
	6.0	200	6	0.025	12	0.30
	8.0	200	6	0.04	16	0.40
	10.0	200	6	0.05	20	0.50
	12.0	200	6	0.06	24	0.60
	16.0	200	6	0.08	32	0.80
	20.0	200	6	0.10	40	1.00
P3.2 High Alloy steels < 1600N/mm²	3.0	180	6	0.01	6	0.15
	4.0	180	6	0.015	8	0.20
	5.0	180	6	0.02	10	0.25
	6.0	180	6	0.025	12	0.30
	8.0	180	6	0.04	16	0.40
	10.0	180	6	0.05	20	0.50
	12.0	180	6	0.06	24	0.60
	16.0	180	6	0.08	32	0.80
	20.0	180	6	0.10	40	1.00
P4.2 Cold working tool steel 12% Chrom	3.0	170	6	0.01	6	0.15
	4.0	170	6	0.015	8	0.20
	5.0	170	6	0.02	10	0.25
	6.0	170	6	0.025	12	0.30
	8.0	170	6	0.04	16	0.40
	10.0	170	6	0.05	20	0.50
	12.0	170	6	0.06	24	0.60
	16.0	170	6	0.08	32	0.80
	20.0	170	6	0.10	40	1.00
M2.1 Stainless steel Austenitic 303-304-316	3.0	100	6	0.01	6	0.15
	4.0	100	6	0.02	8	0.20
	5.0	100	6	0.025	10	0.25
	6.0	100	6	0.025	12	0.30
	8.0	100	6	0.03	16	0.40
	10.0	100	6	0.04	20	0.50
	12.0	100	6	0.05	24	0.60
	16.0	100	6	0.07	32	0.80
	20.0	100	6	0.09	40	1.00
K1.2 Cast iron	3.0	220	6	0.015	6	0.15
	4.0	220	6	0.02	8	0.20
	5.0	220	6	0.025	10	0.25
	6.0	220	6	0.035	12	0.30
	8.0	220	6	0.05	16	0.40
	10.0	220	6	0.07	20	0.50
	12.0	220	6	0.08	24	0.60
	16.0	220	6	0.10	32	0.80
	20.0	220	6	0.12	40	1.00

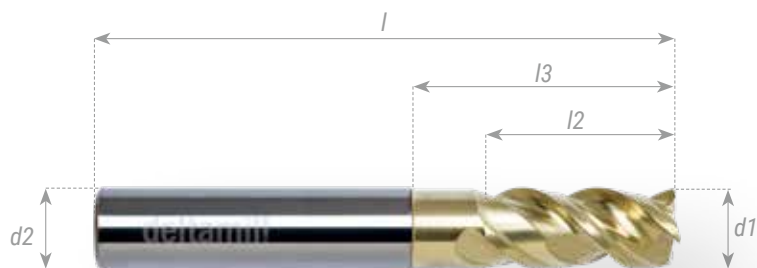


Finish $A_p < \max$
en $A_e 0,05 \times D$



VHM HPC Frees

SC HPC endmill


AGRESSOR ALU

HPC

ALU

POLISH
FLUTECOATING
ZrN

Code	Ød1	Ød2	l2	l3	l	z	c	€
D3930-0300(A)(B)ZOX	3,0	6,0	8	12	57	3	0,1	44,00
D3930-0400(A)(B)ZOX	4,0	6,0	13	17	57	3	0,1	44,00
D3930-0500(A)(B)ZOX	5,0	6,0	13	18	57	3	0,1	44,00
D3930-0600(A)(B)ZOX	6,0	6,0	16	19	57	3	0,2	44,00
D3930-0800(A)(B)ZOX	8,0	8,0	21	25	63	3	0,2	59,00
D3930-1000(A)(B)ZOX	10,0	10,0	22	30	72	3	0,2	92,00
D3930-1200(A)(B)ZOX	12,0	12,0	26	36	83	3	0,2	111,00
D3930-1600(A)(B)ZOX	16,0	16,0	36	42	92	3	0,2	213,00
D3930-2000(A)(B)ZOX	20,0	10,0	41	52	104	3	0,2	313,00

Te bestellen in zowel Cilindrische (HA) AZOX als met Weldon (HB) BZOX
 You can order in cylindrical (HA) AZOX or with Weldon-flat (HB) BZOX

Uitlopend artikel, nieuw artikel zie D3933-Serie
 Expiring article, new article see D3933-Serie

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
N1.1 Aluminium wrought alloys	3.0	600	3	0.020	3	3
	4.0	600	3	0.035	4	4
	5.0	600	3	0.040	5	5
	6.0	600	3	0.045	6	6
	8.0	600	3	0.060	8	8
	10.0	600	3	0.065	10	10
	12.0	600	3	0.070	12	12
	16.0	600	3	0.090	16	16
	20.0	600	3	0.120	20	20
N1.4 Aluminium cast alloys 6-12% Si	3.0	360	3	0.015	3	3
	4.0	360	3	0.030	4	4
	5.0	360	3	0.035	5	5
	6.0	360	3	0.040	6	6
	8.0	360	3	0.050	8	8
	10.0	360	3	0.060	10	10
	12.0	360	3	0.070	12	12
	16.0	360	3	0.120	16	16
	20.0	360	3	0.170	20	20
N1.5 Aluminium cast alloys <12%Si	3.0	240	3	0.015	3	3
	4.0	240	3	0.030	4	4
	5.0	240	3	0.035	5	5
	6.0	240	3	0.040	6	6
	8.0	240	3	0.050	8	8
	10.0	240	3	0.060	10	10
	12.0	240	3	0.070	12	12
	16.0	240	3	0.120	16	16
	20.0	240	3	0.170	20	20
N2.1 Copper	3.0	150	3	0.010	3	3
	4.0	150	3	0.020	4	4
	5.0	150	3	0.025	5	5
	6.0	150	3	0.030	6	6
	8.0	150	3	0.040	8	8
	10.0	150	3	0.050	10	10
	12.0	150	3	0.060	12	12
	16.0	150	3	0.080	16	16
	20.0	150	3	0.120	20	20
N2.2 Brass	3.0	240	3	0.015	3	3
	4.0	240	3	0.030	4	4
	5.0	240	3	0.035	5	5
	6.0	240	3	0.040	6	6
	8.0	240	3	0.050	8	8
	10.0	240	3	0.060	10	10
	12.0	240	3	0.070	12	12
	16.0	240	3	0.120	16	16
	20.0	240	3	0.170	20	20
N2.3 Bronze	3.0	150	3	0.010	3	3
	4.0	150	3	0.020	4	4
	5.0	150	3	0.025	5	5
	6.0	150	3	0.030	6	6
	8.0	150	3	0.040	8	8
	10.0	150	3	0.050	10	10
	12.0	150	3	0.060	12	12
	16.0	150	3	0.080	16	16
	20.0	150	3	0.120	20	20
N2.5 Ampco	3.0	55	3	0.008	3	3
	4.0	55	3	0.015	4	4
	5.0	55	3	0.020	5	5
	6.0	55	3	0.025	6	6
	8.0	55	3	0.030	8	8
	10.0	55	3	0.040	10	10
	12.0	55	3	0.050	12	12
	16.0	55	3	0.065	16	16
	20.0	55	3	0.100	20	20

Verspanings parameters *Cutting Data*

Correctie *Correction*

Ae	Ap	Vc	fz
Ae= <0,4xD	1 x D	20%	20%
Ae= <0,4xD	1,5 x D	10%	10%
Ae= <0,05xD	2 x D	-	100%



Slotting Ap1xD
en Ae1xD



Contour Ap<1,5xD
en Ae<0,5xD

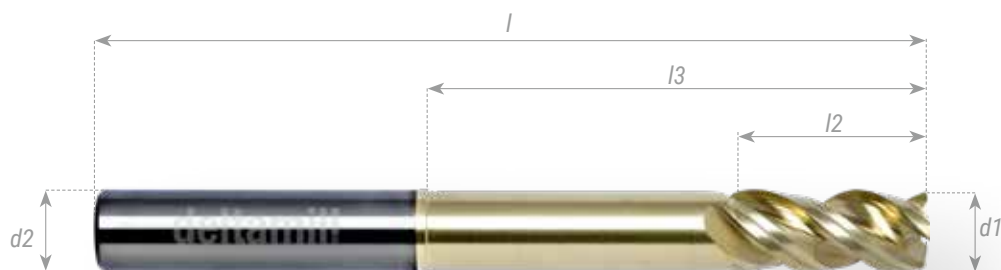


Finish Ap<2xD
en Ae 0,05xD



VHM HPC Frees extra lang

SC HPC endmill extra long


AGRESSOR ALU

HPC

ALU



POLISH FLUTE



COATING

ZrN



WET

Code	Ød1	Ød2	l2	l3	l	z	r	€
D3932-0300(A)(B)ZOX	3,0	6,0	8	20	60	3	0,1	48,00
D3932-0400(A)(B)ZOX	4,0	6,0	11	22	65	3	0,1	52,00
D3932-0500(A)(B)ZOX	5,0	6,0	13	26	76	3	0,1	68,00
D3932-0600(A)(B)ZOX	6,0	6,0	16	42	80	3	0,2	68,00
D3932-0800(A)(B)ZOX	8,0	8,0	21	62	100	3	0,2	80,00
D3932-1000(A)(B)ZOX	10,0	10,0	25	62	100	3	0,2	111,00
D3932-1200(A)(B)ZOX	12,0	12,0	26	73	120	3	0,2	135,00
D3932-1600(A)(B)ZOX	16,0	16,0	36	100	150	3	0,2	276,00
D3932-2000(A)(B)ZOX	20,0	20,0	41	100	150	3	0,2	313,00

Te bestellen in zowel Cilindrische (HA) AZOX als met Weldon (HB) BZOX

You can order in cylindrical (HA) AZOX or with Weldon-flat (HB) BZOX

Uitlopend artikel, nieuw artikel zie D3936-Serie

Expiring article, new article see D3933-Serie

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
N1.1 Aluminium wrought alloys	3.0	300	3	0.020	3	3
	4.0	300	3	0.035	4	4
	5.0	300	3	0.040	5	5
	6.0	300	3	0.045	6	6
	8.0	300	3	0.060	8	8
	10.0	300	3	0.065	10	10
	12.0	300	3	0.070	12	12
	16.0	300	3	0.090	16	16
	20.0	300	3	0.120	20	20
N1.4 Aluminium cast alloys 6-12% Si	3.0	200	3	0.010	3	3
	4.0	200	3	0.020	4	4
	5.0	200	3	0.025	5	5
	6.0	200	3	0.030	6	6
	8.0	200	3	0.040	8	8
	10.0	200	3	0.050	10	10
	12.0	200	3	0.055	12	12
	16.0	200	3	0.090	16	16
	20.0	200	3	0.140	20	20
N1.5 Aluminium cast alloys <12% Si	3.0	130	3	0.010	3	3
	4.0	130	3	0.020	4	4
	5.0	130	3	0.025	5	5
	6.0	130	3	0.030	6	6
	8.0	130	3	0.040	8	8
	10.0	130	3	0.050	10	10
	12.0	130	3	0.055	12	12
	16.0	130	3	0.090	16	16
	20.0	130	3	0.140	20	20
N2.1 Copper	3.0	80	3	0.080	3	3
	4.0	80	3	0.015	4	4
	5.0	80	3	0.020	5	5
	6.0	80	3	0.025	6	6
	8.0	80	3	0.030	8	8
	10.0	80	3	0.040	10	10
	12.0	80	3	0.050	12	12
	16.0	80	3	0.065	16	16
	20.0	80	3	0.100	20	20
N2.2 Brass	3.0	130	3	0.010	3	3
	4.0	130	3	0.020	4	4
	5.0	130	3	0.025	5	5
	6.0	130	3	0.030	6	6
	8.0	130	3	0.040	8	8
	10.0	130	3	0.050	10	10
	12.0	130	3	0.055	12	12
	16.0	130	3	0.090	16	16
	20.0	130	3	0.140	20	20
N2.3 Bronze	3.0	80	3	0.080	3	3
	4.0	80	3	0.015	4	4
	5.0	80	3	0.020	5	5
	6.0	80	3	0.025	6	6
	8.0	80	3	0.030	8	8
	10.0	80	3	0.040	10	10
	12.0	80	3	0.050	12	12
	16.0	80	3	0.065	16	16
	20.0	80	3	0.100	20	20
N2.5 Ampco	3.0	50	3	0.080	3	3
	4.0	50	3	0.015	4	4
	5.0	50	3	0.020	5	5
	6.0	50	3	0.025	6	6
	8.0	50	3	0.030	8	8
	10.0	50	3	0.040	10	10
	12.0	50	3	0.050	12	12
	16.0	50	3	0.065	16	16
	20.0	50	3	0.100	20	20

Verspanings parameters *Cutting Data*

Correctie *Correction*

Ae	Ap	Vc	fz
Ae= <0,4xD	1 x D	20%	20%
Ae= <0,4xD	1,5 x D	10%	10%
Ae= <0,05xD	2 x D	-	100%



Slotting Ap1xD
en Ae1xD

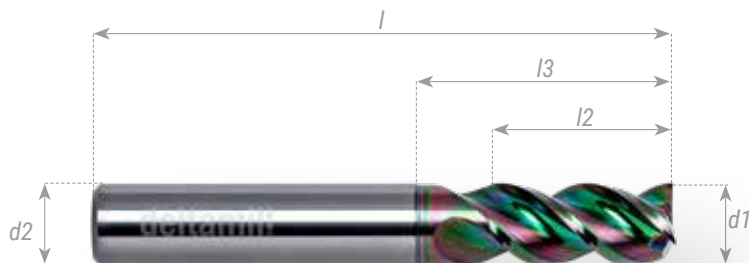


Contour Ap<1,5xD
en Ae<0,5xD



Finish Ap<2xD
en Ae 0,05xD





AGRESSOR ALU



Code	Ød1	Ød2	l2	l3	l	z	c/r	€
D3930-0100DLC	1,0	4,0	1,5	-	38	3	-	39,00
D3930-0200DLC	2,0	4,0	2,5	-	38	3	-	39,00
D3930-0300DLC	3,0	6,0	8	13	57	3	-	48,00
D3930-0400DLC	4,0	6,0	11	17	57	3	-	48,00
D3930-0500DLC	5,0	6,0	13	18	57	3	-	48,00
D3930-0600DLC	6,0	6,0	13	18	57	3	-	48,00
D3930-0800DLC	8,0	8,0	21	25	64	3	-	68,00
D3930-1000DLC	10,0	10,0	22	30	72	3	-	92,00
D3930-1200DLC	12,0	12,0	26	36	83	3	-	121,00
D3930-1600DLC	16,0	16,0	36	42	92	3	-	250,00
D3930-2000DLC	20,0	20,0	41	52	104	3	-	372,00
D3930-2500DLC	25,0	25,0	55	66	126	3	-	646,00

Verspanings parameters Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
N1.1 Aluminium wrought alloys	3.0	500	3	0.008	3	3
	4.0	500	3	0.015	4	4
	5.0	500	3	0.015	5	5
	6.0	500	3	0.025	6	6
	8.0	500	3	0.030	8	8
	10.0	500	3	0.040	10	10
	12.0	500	3	0.050	12	12
	16.0	500	3	0.065	16	16
	20.0	500	3	0.065	20	20
N1.4 Aluminium cast alloys 6-12% Si	3.0	460	3	0.015	3	3
	4.0	460	3	0.030	4	4
	5.0	460	3	0.035	5	5
	6.0	460	3	0.040	6	6
	8.0	460	3	0.050	8	8
	10.0	460	3	0.060	10	10
	12.0	460	3	0.070	12	12
	16.0	460	3	0.120	16	16
	20.0	460	3	0.170	20	20
N1.5 Aluminium cast alloys <12% Si	3.0	240	3	0.015	3	3
	4.0	240	3	0.030	4	4
	5.0	240	3	0.035	5	5
	6.0	240	3	0.040	6	6
	8.0	240	3	0.050	8	8
	10.0	240	3	0.060	10	10
	12.0	240	3	0.070	12	12
	16.0	240	3	0.120	16	16
	20.0	240	3	0.170	20	20
N2.1 Copper	3.0	150	3	0.010	3	3
	4.0	150	3	0.020	4	4
	5.0	150	3	0.025	5	5
	6.0	150	3	0.030	6	6
	8.0	150	3	0.040	8	8
	10.0	150	3	0.050	10	10
	12.0	150	3	0.060	12	12
	16.0	150	3	0.080	16	16
	20.0	150	3	0.120	20	20
N2.2 Brass	3.0	240	3	0.015	3	3
	4.0	240	3	0.030	4	4
	5.0	240	3	0.035	5	5
	6.0	240	3	0.040	6	6
	8.0	240	3	0.050	8	8
	10.0	240	3	0.060	10	10
	12.0	240	3	0.070	12	12
	16.0	240	3	0.120	16	16
	20.0	240	3	0.170	20	20
N2.3 Bronze	3.0	150	3	0.010	3	3
	4.0	150	3	0.020	4	4
	5.0	150	3	0.025	5	5
	6.0	150	3	0.030	6	6
	8.0	150	3	0.040	8	8
	10.0	150	3	0.050	10	10
	12.0	150	3	0.060	12	12
	16.0	150	3	0.080	16	16
	20.0	150	3	0.120	20	20
N2.5 Ampco	3.0	55	3	0.008	3	3
	4.0	55	3	0.015	4	4
	5.0	55	3	0.020	5	5
	6.0	55	3	0.025	6	6
	8.0	55	3	0.030	8	8
	10.0	55	3	0.040	10	10
	12.0	55	3	0.050	12	12
	16.0	55	3	0.065	16	16
	20.0	55	3	0.100	20	20

Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1 x D	20%	20%
Ae= <0,4xD	1,5 x D	10%	10%
Ae= <0,05xD	2 x D	-	100%



Slotting Ap1xD
en Ae1xD



Contour Ap<1,5xD
en Ae<0,5xD

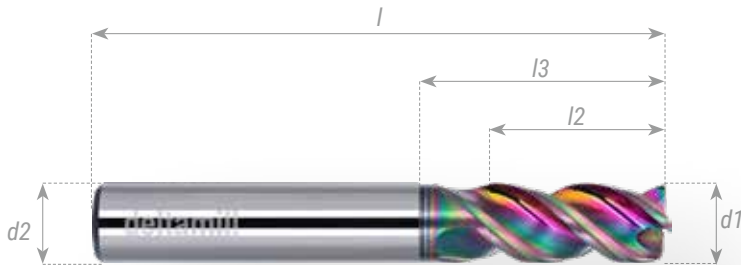


Finish Ap<2xD
en Ae 0,05xD



VHM UPC Frees 3xD neklengte

SC UPC endmill 3xD neckrelief



ALUMINATOR SMOOTHER



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3933-0300DLC	3,0	6,0	6	9	58	3	0,1	58,00
D3933-0400DLC	4,0	6,0	8	12	58	3	0,1	56,00
D3933-0500DLC	5,0	6,0	9	15	58	3	0,2	54,00
D3933-0600DLC	6,0	6,0	13	18	58	3	0,2	54,00
D3933-0800DLC	8,0	8,0	21	25	63	3	0,2	68,00
D3933-1000DLC	10,0	10,0	22	30	72	3	0,2	104,00
D3933-1200DLC	12,0	12,0	26	36	84	3	0,2	118,00
D3933-1600DLC	16,0	16,0	36	48	100	3	0,2	320,00
D3933-2000DLC	20,0	20,0	41	60	110	3	0,2	380,00

Andere diameters op aanvraag.
Other dimensions on request.

Ook leverbaar met interne koeling zie D3933IDL - page 58
Also available with intern coolant see D3933IDL - page 58

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm Ae 1xD Ap 2xD	ap mm	ae mm	fz mm Ae 0,6xD Ap 2xD	drilling fz mm
N1.1	3,0	550	3	0.03	6	3	0.05	0.03
	4,0	550	3	0.035	8	4	0.06	0.035
	5,0	550	3	0.04	10	5	0.07	0.04
	6,0	550	3	0.05	12	6	0.09	0.05
	8,0	550	3	0.06	16	8	0.11	0.06
	10,0	550	3	0.07	20	10	0.13	0.07
	12,0	550	3	0.08	24	12	0.15	0.08
	16,0	550	3	0.12	32	16	0.16	0.12
Aluminium wrought alloys	20,0	550	3	0.18	40	20	0.22	0.18
	3,0	550	3	0.03	6	3	0.05	0.03
	4,0	550	3	0.035	8	4	0.06	0.035
	5,0	550	3	0.04	9	5	0.07	0.04
	6,0	550	3	0.05	12	6	0.09	0.05
	8,0	550	3	0.06	16	8	0.11	0.06
	10,0	550	3	0.07	20	10	0.13	0.07
	12,0	550	3	0.08	24	12	0.15	0.08
Aluminium cast alloys 6-12% Si	16,0	550	3	0.12	32	16	0.16	0.12
	20,0	550	3	0.18	40	20	0.22	0.18
	3,0	400	3	0.03	6	3	0.05	0.03
	4,0	400	3	0.035	8	4	0.06	0.035
	5,0	400	3	0.04	9	5	0.07	0.04
	6,0	400	3	0.05	12	6	0.09	0.05
	8,0	400	3	0.06	16	8	0.11	0.06
	10,0	400	3	0.07	20	10	0.13	0.07
Aluminium cast alloys <12%Si	12,0	400	3	0.08	24	12	0.15	0.08
	16,0	400	3	0.12	32	16	0.16	0.12
	20,0	400	3	0.18	40	20	0.22	0.18
	3,0	300	3	0.03	6	3	0.05	0.03
	4,0	300	3	0.035	8	4	0.06	0.035
	5,0	300	3	0.04	9	5	0.07	0.04
	6,0	300	3	0.05	12	6	0.09	0.05
	8,0	300	3	0.06	16	8	0.11	0.06
N2.1	10,0	300	3	0.07	20	10	0.13	0.07
	12,0	300	3	0.08	24	12	0.15	0.08
	16,0	300	3	0.12	32	16	0.16	0.12
	20,0	300	3	0.18	40	20	0.22	0.18
Copper	3,0	180	3	0.03	6	3	0.05	0.03
	4,0	180	3	0.035	8	4	0.06	0.035
	5,0	180	3	0.04	9	5	0.07	0.04
	6,0	180	3	0.05	12	6	0.09	0.05
	8,0	180	3	0.06	16	8	0.11	0.06
	10,0	180	3	0.07	20	10	0.13	0.07
	12,0	180	3	0.08	24	12	0.15	0.08
	16,0	180	3	0.12	32	16	0.16	0.12
N2.5	20,0	180	3	0.18	40	20	0.22	0.18
	3,0	180	3	0.03	6	3	0.05	0.03
	4,0	180	3	0.035	8	4	0.06	0.035
	5,0	180	3	0.04	9	5	0.07	0.04
	6,0	180	3	0.05	12	6	0.09	0.05
	8,0	180	3	0.06	16	8	0.11	0.06
	10,0	180	3	0.07	20	10	0.13	0.07
	12,0	180	3	0.08	24	12	0.15	0.08
Ampco	16,0	180	3	0.12	32	16	0.16	0.12
	20,0	180	3	0.18	40	20	0.22	0.18



Drilling Ap1xD



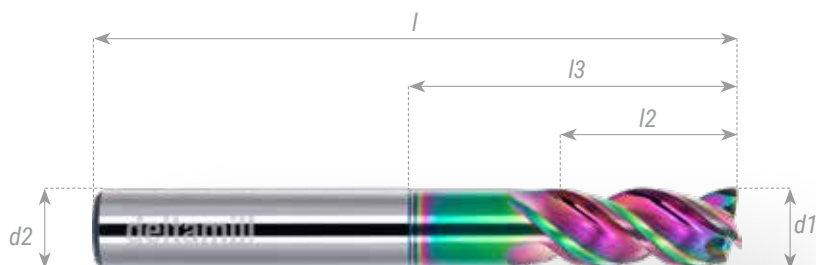
Slotting Ap1xD
en Ae1xD



Contour Ap<2,0xD
en Ae<0,6xD



VHM UPC Frees 4xD neklengte SC UPC endmill 4xD neckrelief



ALUMINATOR SMOOTHER



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3934-0300DLC	3,0	6,0	6	12	58	3	0,1	58,00
D3934-0400DLC	4,0	6,0	8	16	58	3	0,1	58,00
D3934-0500DLC	5,0	6,0	9	20	62	3	0,2	78,00
D3934-0600DLC	6,0	6,0	13	24	62	3	0,2	78,00
D3934-0800DLC	8,0	8,0	21	34	68	3	0,2	92,00
D3934-1000DLC	10,0	10,0	22	40	80	3	0,2	124,00
D3934-1200DLC	12,0	12,0	26	48	94	3	0,2	144,00
D3934-1600DLC	16,0	16,0	36	64	113	3	0,2	360,00
D3934-2000DLC	20,0	20,0	41	80	131	3	0,2	560,00

Andere diameters op aanvraag.
Other dimensions on request.

Ook leverbaar met interne koeling zie D3934IDL - page 60
Also available with intern coolant see D3934IDL - page 60

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm Ae 1xD Ap 2xD	ap mm	ae mm	fz mm Ae 0,6xD Ap 2xD	drilling fz mm
N1.1	3,0	550	3	0.03	6	3	0.05	0.03
	4,0	550	3	0.035	8	4	0.06	0.035
	5,0	550	3	0.04	10	5	0.07	0.04
	6,0	550	3	0.05	12	6	0.09	0.05
	8,0	550	3	0.06	16	8	0.11	0.06
	10,0	550	3	0.07	20	10	0.13	0.07
	12,0	550	3	0.08	24	12	0.15	0.08
	16,0	550	3	0.12	32	16	0.16	0.12
Aluminium wrought alloys	20,0	550	3	0.18	40	20	0.22	0.18
	3,0	550	3	0.03	6	3	0.05	0.03
	4,0	550	3	0.035	8	4	0.06	0.035
	5,0	550	3	0.04	9	5	0.07	0.04
	6,0	550	3	0.05	12	6	0.09	0.05
	8,0	550	3	0.06	16	8	0.11	0.06
	10,0	550	3	0.07	20	10	0.13	0.07
	12,0	550	3	0.08	24	12	0.15	0.08
Aluminium cast alloys 6-12% Si	16,0	550	3	0.12	32	16	0.16	0.12
	20,0	550	3	0.18	40	20	0.22	0.18
	3,0	400	3	0.03	6	3	0.05	0.03
	4,0	400	3	0.035	8	4	0.06	0.035
	5,0	400	3	0.04	9	5	0.07	0.04
	6,0	400	3	0.05	12	6	0.09	0.05
	8,0	400	3	0.06	16	8	0.11	0.06
	10,0	400	3	0.07	20	10	0.13	0.07
Aluminium cast alloys <12%Si	12,0	400	3	0.08	24	12	0.15	0.08
	16,0	400	3	0.12	32	16	0.16	0.12
	20,0	400	3	0.18	40	20	0.22	0.18
	3,0	300	3	0.03	6	3	0.05	0.03
	4,0	300	3	0.035	8	4	0.06	0.035
	5,0	300	3	0.04	9	5	0.07	0.04
	6,0	300	3	0.05	12	6	0.09	0.05
	8,0	300	3	0.06	16	8	0.11	0.06
N2.1	10,0	300	3	0.07	20	10	0.13	0.07
	12,0	300	3	0.08	24	12	0.15	0.08
	16,0	300	3	0.12	32	16	0.16	0.12
	20,0	300	3	0.18	40	20	0.22	0.18
	3,0	300	3	0.03	6	3	0.05	0.03
	4,0	300	3	0.035	8	4	0.06	0.035
	5,0	300	3	0.04	9	5	0.07	0.04
	6,0	300	3	0.05	12	6	0.09	0.05
Copper	8,0	300	3	0.06	16	8	0.11	0.06
	10,0	300	3	0.07	20	10	0.13	0.07
	12,0	300	3	0.08	24	12	0.15	0.08
	16,0	300	3	0.12	32	16	0.16	0.12
	20,0	300	3	0.18	40	20	0.22	0.18
	3,0	180	3	0.03	6	3	0.05	0.03
	4,0	180	3	0.035	8	4	0.06	0.035
	5,0	180	3	0.04	9	5	0.07	0.04
N2.5	6,0	180	3	0.05	12	6	0.09	0.05
	8,0	180	3	0.06	16	8	0.11	0.06
	10,0	180	3	0.07	20	10	0.13	0.07
	12,0	180	3	0.08	24	12	0.15	0.08
	16,0	180	3	0.12	32	16	0.16	0.12
	20,0	180	3	0.18	40	20	0.22	0.18
	3,0	180	3	0.03	6	3	0.05	0.03
	4,0	180	3	0.035	8	4	0.06	0.035
Ampco	5,0	180	3	0.04	9	5	0.07	0.04
	6,0	180	3	0.05	12	6	0.09	0.05
	8,0	180	3	0.06	16	8	0.11	0.06
	10,0	180	3	0.07	20	10	0.13	0.07
	12,0	180	3	0.08	24	12	0.15	0.08
	16,0	180	3	0.12	32	16	0.16	0.12
	20,0	180	3	0.18	40	20	0.22	0.18
	3,0	180	3	0.03	6	3	0.05	0.03



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

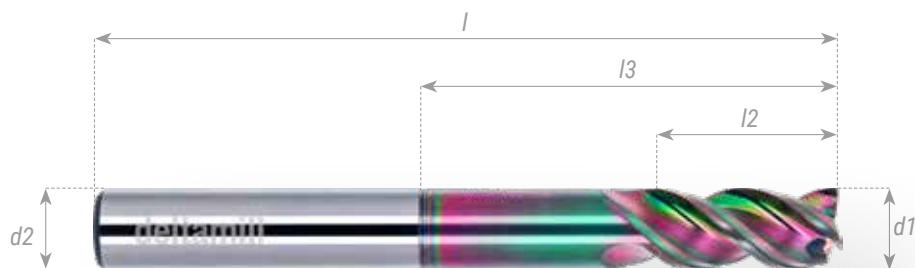


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Frees 5xD neklengte

SC UPC endmill 5xD neckrelief



ALUMINATOR SMOOTHER



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3935-0300DLC	3,0	6,0	6	15	62	3	0,2	78,00
D3935-0400DLC	4,0	5,0	8	20	62	3	0,2	78,00
D3935-0500DLC	5,0	5,0	9	25	70	3	0,2	82,00
D3935-0600DLC	6,0	6,0	13	30	70	3	0,2	82,00
D3935-0800DLC	8,0	8,0	21	40	80	3	0,2	104,00
D3935-1000DLC	10,0	10,0	22	50	91	3	0,2	144,00
D3935-1200DLC	12,0	12,0	26	60	106	3	0,2	192,00
D3935-1600DLC	16,0	16,0	36	81	131	3	0,2	380,00
D3935-2000DLC	20,0	20,0	41	100	151	3	0,2	592,00

Andere diameters op aanvraag.
Other dimensions on request.

Ook leverbaar met interne koeling zie D3935IDLC - page 62
Also available with intern coolant see D3935IDLC - page 62

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm Ae 1xD Ap 1xD	ap mm	ae mm	fz mm Ae 0,6xD	drilling fz mm
N1.1	3.0	450	3	0.015	6	3	0.03	0.015
	4.0	450	3	0.02	8	4	0.04	0.02
	5.0	450	3	0.025	10	5	0.06	0.025
	6.0	450	3	0.035	12	6	0.07	0.035
	8.0	450	3	0.04	16	8	0.08	0.04
	10.0	450	3	0.05	20	10	0.10	0.05
	12.0	450	3	0.06	24	12	0.11	0.06
	16.0	450	3	0.09	32	16	0.12	0.09
Aluminium wrought alloys	20.0	450	3	0.13	40	20	0.16	0.13
	3.0	400	3	0.015	3	3	0.03	0.015
	4.0	400	3	0.02	4	4	0.04	0.02
	5.0	400	3	0.025	5	5	0.06	0.025
	6.0	400	3	0.035	6	6	0.07	0.035
	8.0	400	3	0.04	8	8	0.08	0.04
	10.0	400	3	0.05	10	10	0.10	0.05
	12.0	400	3	0.06	12	12	0.11	0.06
Aluminium cast alloys 6-12% Si	16.0	400	3	0.09	16	16	0.12	0.09
	20.0	400	3	0.13	20	20	0.16	0.13
	3.0	300	3	0.015	3	3	0.03	0.015
	4.0	300	3	0.02	4	4	0.04	0.02
	5.0	300	3	0.025	5	5	0.06	0.025
	6.0	300	3	0.035	6	6	0.07	0.035
	8.0	300	3	0.04	8	8	0.08	0.04
	10.0	300	3	0.05	10	10	0.10	0.05
Aluminium cast alloys <12%Si	12.0	300	3	0.06	12	12	0.11	0.06
	16.0	300	3	0.09	16	16	0.12	0.09
	20.0	300	3	0.13	20	20	0.16	0.13
N2.1	3.0	200	3	0.015	3	3	0.03	0.015
	4.0	200	3	0.02	4	4	0.04	0.02
	5.0	200	3	0.025	5	5	0.06	0.025
	6.0	200	3	0.035	6	6	0.07	0.035
	8.0	200	3	0.04	8	8	0.08	0.04
	10.0	200	3	0.05	10	10	0.10	0.05
	12.0	200	3	0.06	12	12	0.11	0.06
	16.0	200	3	0.09	16	16	0.12	0.09
Copper	20.0	200	3	0.13	20	20	0.16	0.13
	3.0	100	3	0.015	3	3	0.03	0.015
	4.0	100	3	0.02	4	4	0.04	0.02
	5.0	100	3	0.025	5	5	0.06	0.025
	6.0	100	3	0.035	6	6	0.07	0.035
	8.0	100	3	0.04	8	8	0.08	0.04
	10.0	100	3	0.05	10	10	0.10	0.05
	12.0	100	3	0.06	12	12	0.11	0.06
N2.5	16.0	100	3	0.09	16	16	0.12	0.09
	20.0	100	3	0.13	20	20	0.16	0.13
Ampco	3.0	100	3	0.015	3	3	0.03	0.015
	4.0	100	3	0.02	4	4	0.04	0.02
	5.0	100	3	0.025	5	5	0.06	0.025
	6.0	100	3	0.035	6	6	0.07	0.035
	8.0	100	3	0.04	8	8	0.08	0.04
	10.0	100	3	0.05	10	10	0.10	0.05
	12.0	100	3	0.06	12	12	0.11	0.06
	16.0	100	3	0.09	16	16	0.12	0.09
	20.0	100	3	0.13	20	20	0.16	0.13



Drilling Ap1xD



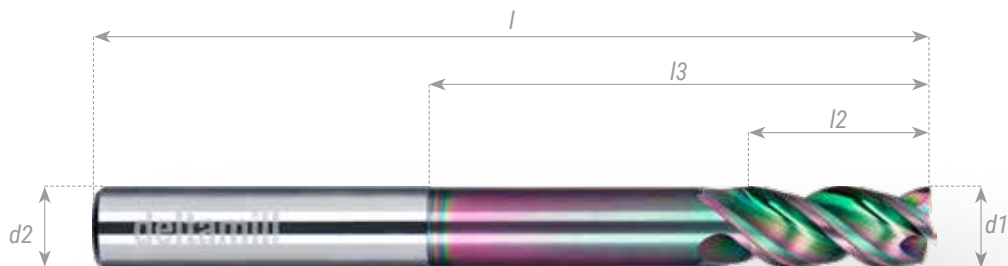
Slotting Ap1xD
en Ae1xD



Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Frees 6xD neklengte SC UPC endmill 6xD neckrelief



ALUMINATOR SMOOTHER



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3936-0300DLC	3,0	6,0	6	18	62	3	0,2	78,00
D3936-0400DLC	4,0	6,0	8	24	70	3	0,2	82,00
D3936-0500DLC	5,0	6,0	9	30	70	3	0,2	82,00
D3936-0600DLC	6,0	6,0	13	36	75	3	0,2	72,00
D3936-0800DLC	8,0	8,0	21	48	90	3	0,2	112,00
D3936-1000DLC	10,0	10,0	22	60	100	3	0,2	144,00
D3936-1200DLC	12,0	12,0	26	72	120	3	0,2	192,00
D3936-1600DLC	16,0	16,0	36	96	145	3	0,2	380,00
D3936-2000DLC	20,0	20,0	41	120	170	3	0,2	678,00

Andere diameters op aanvraag.
Other dimensions on request.

Ook leverbaar met interne koeling zie D3936IDLC - page 64
Also available with intern coolant see D3936IDLC - page 64

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm Ae 1xD Ap 1xD	ap mm	ae mm	fz mm Ae 0,6xD	drilling fz mm
N1.1	3.0	450	3	0.015	6	3	0.03	0.015
	4.0	450	3	0.02	8	4	0.04	0.02
	5.0	450	3	0.025	10	5	0.06	0.025
	6.0	450	3	0.035	12	6	0.07	0.035
	8.0	450	3	0.04	16	8	0.08	0.04
	10.0	450	3	0.05	20	10	0.10	0.05
	12.0	450	3	0.06	24	12	0.11	0.06
	16.0	450	3	0.09	32	16	0.12	0.09
Aluminium wrought alloys	20.0	450	3	0.13	40	20	0.16	0.13
	3.0	400	3	0.015	3	3	0.03	0.015
	4.0	400	3	0.02	4	4	0.04	0.02
	5.0	400	3	0.025	5	5	0.06	0.025
	6.0	400	3	0.035	6	6	0.07	0.035
	8.0	400	3	0.04	8	8	0.08	0.04
	10.0	400	3	0.05	10	10	0.10	0.05
	12.0	400	3	0.06	12	12	0.11	0.06
Aluminium cast alloys 6-12% Si	16.0	400	3	0.09	16	16	0.12	0.09
	20.0	400	3	0.13	20	20	0.16	0.13
	3.0	300	3	0.015	3	3	0.03	0.015
	4.0	300	3	0.02	4	4	0.04	0.02
	5.0	300	3	0.025	5	5	0.06	0.025
	6.0	300	3	0.035	6	6	0.07	0.035
	8.0	300	3	0.04	8	8	0.08	0.04
	10.0	300	3	0.05	10	10	0.10	0.05
Aluminium cast alloys <12%Si	12.0	300	3	0.06	12	12	0.11	0.06
	16.0	300	3	0.09	16	16	0.12	0.09
	20.0	300	3	0.13	20	20	0.16	0.13
N2.1	3.0	200	3	0.015	3	3	0.03	0.015
	4.0	200	3	0.02	4	4	0.04	0.02
	5.0	200	3	0.025	5	5	0.06	0.025
	6.0	200	3	0.035	6	6	0.07	0.035
	8.0	200	3	0.04	8	8	0.08	0.04
	10.0	200	3	0.05	10	10	0.10	0.05
	12.0	200	3	0.06	12	12	0.11	0.06
	16.0	200	3	0.09	16	16	0.12	0.09
Copper	20.0	200	3	0.13	20	20	0.16	0.13
	3.0	100	3	0.015	3	3	0.03	0.015
	4.0	100	3	0.02	4	4	0.04	0.02
	5.0	100	3	0.025	5	5	0.06	0.025
	6.0	100	3	0.035	6	6	0.07	0.035
	8.0	100	3	0.04	8	8	0.08	0.04
	10.0	100	3	0.05	10	10	0.10	0.05
	12.0	100	3	0.06	12	12	0.11	0.06
N2.5	16.0	100	3	0.09	16	16	0.12	0.09
	20.0	100	3	0.13	20	20	0.16	0.13
Ampco	3.0	100	3	0.015	3	3	0.03	0.015
	4.0	100	3	0.02	4	4	0.04	0.02
	5.0	100	3	0.025	5	5	0.06	0.025
	6.0	100	3	0.035	6	6	0.07	0.035
	8.0	100	3	0.04	8	8	0.08	0.04
	10.0	100	3	0.05	10	10	0.10	0.05
	12.0	100	3	0.06	12	12	0.11	0.06
	16.0	100	3	0.09	16	16	0.12	0.09
	20.0	100	3	0.13	20	20	0.16	0.13



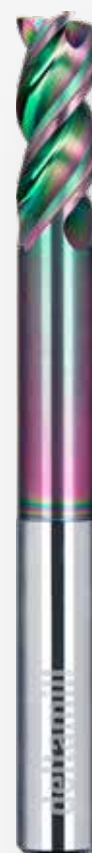
Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

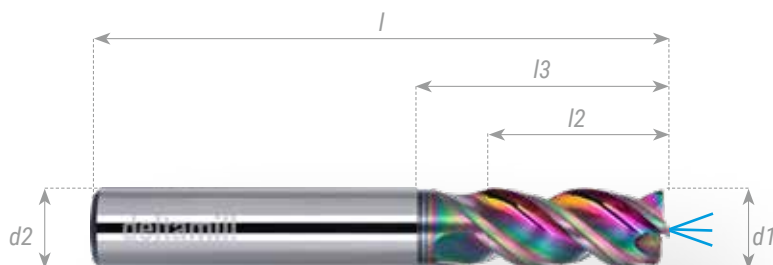


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Frees 3xD nek lengte, kopkoeling

SC UPC endmill 3xD neckrelief, coolant



ALUMINATOR SMOOTHER



Code	Ød1	Ød2	L2	L3	L	z	r	€
D3933-0300DLCI	3,0	6,0	6	9	58	3	0,1	68,00
D3933-0400DLCI	4,0	6,0	8	12	58	3	0,1	66,00
D3933-0500DLCI	5,0	6,0	9	15	58	3	0,2	64,00
D3933-0600DLCI	6,0	6,0	13	18	58	3	0,2	64,00
D3933-0800DLCI	8,0	8,0	21	25	63	3	0,2	80,00
D3933-1000DLCI	10,0	10,0	22	30	72	3	0,2	124,00
D3933-1200DLCI	12,0	12,0	26	36	84	3	0,2	144,00
D3933-1600DLCI	16,0	16,0	36	48	100	3	0,2	384,00
D3933-2000DLCI	20,0	20,0	41	60	110	3	0,2	456,00

Andere diameters op aanvraag.
Other dimensions on request.

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm Ae 1xD Ap 1xD	ap mm	ae mm	fz mm Ae 0,6xD	drilling fz mm
N1.1	3,0	550	3	0.03	6	3	0.05	0.03
	4,0	550	3	0.035	8	4	0.06	0.035
	5,0	550	3	0.04	10	5	0.07	0.04
	6,0	550	3	0.05	12	6	0.09	0.05
	8,0	550	3	0.06	16	8	0.11	0.06
	10,0	550	3	0.07	20	10	0.13	0.07
	12,0	550	3	0.08	24	12	0.15	0.08
	16,0	550	3	0.12	32	16	0.16	0.12
Aluminium wrought alloys	20,0	550	3	0.18	40	20	0.22	0.18
	3,0	550	3	0.03	6	3	0.05	0.03
	4,0	550	3	0.035	8	4	0.06	0.035
	5,0	550	3	0.04	9	5	0.07	0.04
	6,0	550	3	0.05	12	6	0.09	0.05
	8,0	550	3	0.06	16	8	0.11	0.06
	10,0	550	3	0.07	20	10	0.13	0.07
	12,0	550	3	0.08	24	12	0.15	0.08
Aluminium cast alloys 6-12% Si	16,0	550	3	0.12	32	16	0.16	0.12
	20,0	550	3	0.18	40	20	0.22	0.18
	3,0	400	3	0.03	6	3	0.05	0.03
	4,0	400	3	0.035	8	4	0.06	0.035
	5,0	400	3	0.04	9	5	0.07	0.04
	6,0	400	3	0.05	12	6	0.09	0.05
	8,0	400	3	0.06	16	8	0.11	0.06
	10,0	400	3	0.07	20	10	0.13	0.07
Aluminium cast alloys <12%Si	12,0	400	3	0.08	24	12	0.15	0.08
	16,0	400	3	0.12	32	16	0.16	0.12
	20,0	400	3	0.18	40	20	0.22	0.18
	3,0	300	3	0.03	6	3	0.05	0.03
	4,0	300	3	0.035	8	4	0.06	0.035
	5,0	300	3	0.04	9	5	0.07	0.04
	6,0	300	3	0.05	12	6	0.09	0.05
	8,0	300	3	0.06	16	8	0.11	0.06
N2.1	10,0	300	3	0.07	20	10	0.13	0.07
	12,0	300	3	0.08	24	12	0.15	0.08
	16,0	300	3	0.12	32	16	0.16	0.12
	20,0	300	3	0.18	40	20	0.22	0.18
Copper	3,0	180	3	0.03	6	3	0.05	0.03
	4,0	180	3	0.035	8	4	0.06	0.035
	5,0	180	3	0.04	9	5	0.07	0.04
	6,0	180	3	0.05	12	6	0.09	0.05
	8,0	180	3	0.06	16	8	0.11	0.06
	10,0	180	3	0.07	20	10	0.13	0.07
	12,0	180	3	0.08	24	12	0.15	0.08
	16,0	180	3	0.12	32	16	0.16	0.12
N2.5	20,0	180	3	0.18	40	20	0.22	0.18
	3,0	180	3	0.03	6	3	0.05	0.03
	4,0	180	3	0.035	8	4	0.06	0.035
	5,0	180	3	0.04	9	5	0.07	0.04
	6,0	180	3	0.05	12	6	0.09	0.05
	8,0	180	3	0.06	16	8	0.11	0.06
	10,0	180	3	0.07	20	10	0.13	0.07
	12,0	180	3	0.08	24	12	0.15	0.08
Ampco	16,0	180	3	0.12	32	16	0.16	0.12
	20,0	180	3	0.18	40	20	0.22	0.18



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

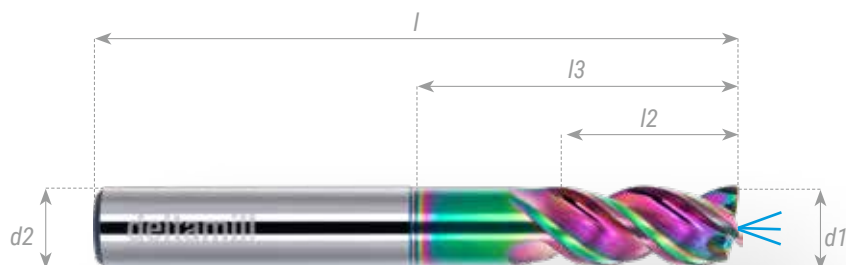


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Frees 4xD nek lengte, kopkoeling

SC UPC endmill 4xD neckrelief, coolant



ALUMINATOR SMOOTHER



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3934-0300DLCI	3,0	6,0	6	12	58	3	0,1	68,00
D3934-0400DLCI	4,0	6,0	8	16	58	3	0,1	64,00
D3934-0500DLCI	5,0	6,0	9	20	62	3	0,2	84,00
D3934-0600DLCI	6,0	6,0	13	24	62	3	0,2	84,00
D3934-0800DLCI	8,0	8,0	21	34	68	3	0,2	112,00
D3934-1000DLCI	10,0	10,0	22	40	80	3	0,2	148,00
D3934-1200DLCI	12,0	12,0	26	48	94	3	0,2	172,00
D3934-1600DLCI	16,0	16,0	36	64	113	3	0,2	432,00
D3934-2000DLCI	20,0	20,0	41	80	131	3	0,2	672,00

Andere diameters op aanvraag.
Other dimensions on request.

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm Ae 1xD Ap 1xD	ap mm	ae mm	fz mm Ae 0,6xD	drilling fz mm
N1.1	3,0	550	3	0.03	6	3	0.05	0.03
	4,0	550	3	0.035	8	4	0.06	0.035
	5,0	550	3	0.04	10	5	0.07	0.04
	6,0	550	3	0.05	12	6	0.09	0.05
	8,0	550	3	0.06	16	8	0.11	0.06
	10,0	550	3	0.07	20	10	0.13	0.07
	12,0	550	3	0.08	24	12	0.15	0.08
	16,0	550	3	0.12	32	16	0.16	0.12
Aluminium wrought alloys	20,0	550	3	0.18	40	20	0.22	0.18
	3,0	550	3	0.03	6	3	0.05	0.03
	4,0	550	3	0.035	8	4	0.06	0.035
	5,0	550	3	0.04	9	5	0.07	0.04
	6,0	550	3	0.05	12	6	0.09	0.05
	8,0	550	3	0.06	16	8	0.11	0.06
	10,0	550	3	0.07	20	10	0.13	0.07
	12,0	550	3	0.08	24	12	0.15	0.08
Aluminium cast alloys 6-12% Si	16,0	550	3	0.12	32	16	0.16	0.12
	20,0	550	3	0.18	40	20	0.22	0.18
	3,0	400	3	0.03	6	3	0.05	0.03
	4,0	400	3	0.035	8	4	0.06	0.035
	5,0	400	3	0.04	9	5	0.07	0.04
	6,0	400	3	0.05	12	6	0.09	0.05
	8,0	400	3	0.06	16	8	0.11	0.06
	10,0	400	3	0.07	20	10	0.13	0.07
Aluminium cast alloys <12%Si	12,0	400	3	0.08	24	12	0.15	0.08
	16,0	400	3	0.12	32	16	0.16	0.12
	20,0	400	3	0.18	40	20	0.22	0.18
	3,0	300	3	0.03	6	3	0.05	0.03
	4,0	300	3	0.035	8	4	0.06	0.035
	5,0	300	3	0.04	9	5	0.07	0.04
	6,0	300	3	0.05	12	6	0.09	0.05
	8,0	300	3	0.06	16	8	0.11	0.06
N2.1	10,0	300	3	0.07	20	10	0.13	0.07
	12,0	300	3	0.08	24	12	0.15	0.08
	16,0	300	3	0.12	32	16	0.16	0.12
	20,0	300	3	0.18	40	20	0.22	0.18
Copper	3,0	180	3	0.03	6	3	0.05	0.03
	4,0	180	3	0.035	8	4	0.06	0.035
	5,0	180	3	0.04	9	5	0.07	0.04
	6,0	180	3	0.05	12	6	0.09	0.05
	8,0	180	3	0.06	16	8	0.11	0.06
	10,0	180	3	0.07	20	10	0.13	0.07
	12,0	180	3	0.08	24	12	0.15	0.08
	16,0	180	3	0.12	32	16	0.16	0.12
N2.5	20,0	180	3	0.18	40	20	0.22	0.18
	3,0	180	3	0.03	6	3	0.05	0.03
	4,0	180	3	0.035	8	4	0.06	0.035
	5,0	180	3	0.04	9	5	0.07	0.04
	6,0	180	3	0.05	12	6	0.09	0.05
	8,0	180	3	0.06	16	8	0.11	0.06
	10,0	180	3	0.07	20	10	0.13	0.07
	12,0	180	3	0.08	24	12	0.15	0.08
Ampco	16,0	180	3	0.12	32	16	0.16	0.12
	20,0	180	3	0.18	40	20	0.22	0.18



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

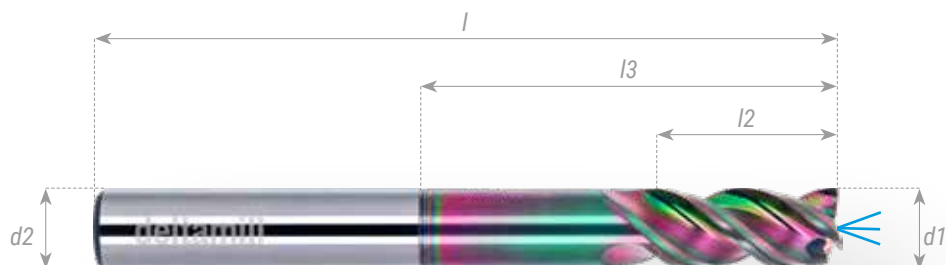


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Frees 5xD nek lengte, kopkoeling

SC UPC endmill 5xD neck relief, coolant



ALUMINATOR SMOOTHER



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3935-0300DLCI	3,0	6,0	6	15	62	3	0,2	78,00
D3935-0400DLCI	4,0	5,0	8	20	62	3	0,2	78,00
D3935-0500DLCI	5,0	5,0	9	25	70	3	0,2	82,00
D3935-0600DLCI	6,0	6,0	13	30	70	3	0,2	82,00
D3935-0800DLCI	8,0	8,0	21	40	80	3	0,2	124,00
D3935-1000DLCI	10,0	10,0	22	50	91	3	0,2	172,00
D3935-1010DLCI	10,0	10,0	22	50	91	3	1,0	172,00
D3935-1020dLCI	10,0	10,0	22	50	91	3	2,0	172,00
D3935-1200DLCI	12,0	12,0	26	60	106	3	0,2	232,00
D3935-1210DLCI	12,0	12,0	26	60	106	3	1,0	232,00
D3935-1220DLCI	12,0	12,0	26	60	106	3	2,0	232,00
D3935-1600DLCI	16,0	16,0	36	81	131	3	0,2	456,00
D3935-1610DLCI	16,0	16,0	36	81	131	3	1,0	456,00
D3935-1620DLCI	16,0	16,0	36	81	131	3	2,0	456,00
D3935-1650DLCI	16,0	16,0	36	81	131	3	5,0	456,00

Andere diameters op aanvraag.
Other dimensions on request.

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm Ae 1xD Ap 1xD	ap mm	ae mm	fz mm Ae 0,6xD	drilling fz mm
N1.1	3.0	450	3	0.015	6	3	0.03	0.015
	4.0	450	3	0.02	8	4	0.04	0.02
	5.0	450	3	0.025	10	5	0.06	0.025
	6.0	450	3	0.035	12	6	0.07	0.035
	8.0	450	3	0.04	16	8	0.08	0.04
	10.0	450	3	0.05	20	10	0.10	0.05
	12.0	450	3	0.06	24	12	0.11	0.06
	16.0	450	3	0.09	32	16	0.12	0.09
Aluminium wrought alloys	20.0	450	3	0.13	40	20	0.16	0.13
	3.0	400	3	0.015	3	3	0.03	0.015
	4.0	400	3	0.02	4	4	0.04	0.02
	5.0	400	3	0.025	5	5	0.06	0.025
	6.0	400	3	0.035	6	6	0.07	0.035
	8.0	400	3	0.04	8	8	0.08	0.04
	10.0	400	3	0.05	10	10	0.10	0.05
	12.0	400	3	0.06	12	12	0.11	0.06
Aluminium cast alloys 6-12% Si	16.0	400	3	0.09	16	16	0.12	0.09
	20.0	400	3	0.13	20	20	0.16	0.13
	3.0	300	3	0.015	3	3	0.03	0.015
	4.0	300	3	0.02	4	4	0.04	0.02
	5.0	300	3	0.025	5	5	0.06	0.025
	6.0	300	3	0.035	6	6	0.07	0.035
	8.0	300	3	0.04	8	8	0.08	0.04
	10.0	300	3	0.05	10	10	0.10	0.05
Aluminium cast alloys <12%Si	12.0	300	3	0.06	12	12	0.11	0.06
	16.0	300	3	0.09	16	16	0.12	0.09
	20.0	300	3	0.13	20	20	0.16	0.13
	3.0	200	3	0.015	3	3	0.03	0.015
	4.0	200	3	0.02	4	4	0.04	0.02
	5.0	200	3	0.025	5	5	0.06	0.025
	6.0	200	3	0.035	6	6	0.07	0.035
	8.0	200	3	0.04	8	8	0.08	0.04
N2.1	10.0	200	3	0.05	10	10	0.10	0.05
	12.0	200	3	0.06	12	12	0.11	0.06
	16.0	200	3	0.09	16	16	0.12	0.09
	20.0	200	3	0.13	20	20	0.16	0.13
Copper	3.0	100	3	0.015	3	3	0.03	0.015
	4.0	100	3	0.02	4	4	0.04	0.02
	5.0	100	3	0.025	5	5	0.06	0.025
	6.0	100	3	0.035	6	6	0.07	0.035
	8.0	100	3	0.04	8	8	0.08	0.04
	10.0	100	3	0.05	10	10	0.10	0.05
	12.0	100	3	0.06	12	12	0.11	0.06
	16.0	100	3	0.09	16	16	0.12	0.09
N2.5	20.0	100	3	0.13	20	20	0.16	0.13
	3.0	100	3	0.015	3	3	0.03	0.015
	4.0	100	3	0.02	4	4	0.04	0.02
	5.0	100	3	0.025	5	5	0.06	0.025
	6.0	100	3	0.035	6	6	0.07	0.035
	8.0	100	3	0.04	8	8	0.08	0.04
	10.0	100	3	0.05	10	10	0.10	0.05
	12.0	100	3	0.06	12	12	0.11	0.06
Ampco	16.0	100	3	0.09	16	16	0.12	0.09
	20.0	100	3	0.13	20	20	0.16	0.13



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

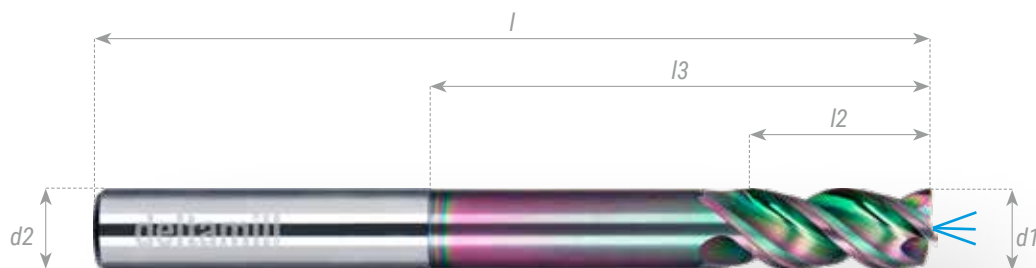


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Frees 6xD nek lengte, kopkoeling

SC UPC endmill 6xD neck relief, coolant



ALUMINATOR SMOOTHER



Code	Ød1	Ød2	L2	L3	L	z	r	€
D3936-0300DLCI	3,0	6,0	6	18	62	3	0,2	84,00
D3936-0400DLCI	4,0	6,0	8	24	70	3	0,2	92,00
D3936-0500DLCI	5,0	6,0	9	30	70	3	0,2	92,00
D3936-0600DLCI	6,0	6,0	13	36	75	3	0,2	100,00
D3936-0800DLCI	8,0	8,0	21	48	90	3	0,2	136,00
D3936-1000DLCI	10,0	10,0	22	60	100	3	0,2	196,00
D3936-1200DLCI	12,0	12,0	26	72	120	3	0,2	272,00
D3936-1600DLCI	16,0	16,0	36	96	145	3	0,2	616,00
D3936-2000DLCI	20,0	20,0	41	120	170	3	0,2	798,00

Andere diameters op aanvraag.
Other dimensions on request.

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm Ae 1xD Ap 1xD	ap mm	ae mm	fz mm Ae 0,6xD	drilling fz mm
N1.1	3.0	450	3	0.015	6	3	0.03	0.015
	4.0	450	3	0.02	8	4	0.04	0.02
	5.0	450	3	0.025	10	5	0.06	0.025
	6.0	450	3	0.035	12	6	0.07	0.035
	8.0	450	3	0.04	16	8	0.08	0.04
	10.0	450	3	0.05	20	10	0.10	0.05
	12.0	450	3	0.06	24	12	0.11	0.06
	16.0	450	3	0.09	32	16	0.12	0.09
Aluminium wrought alloys	20.0	450	3	0.13	40	20	0.16	0.13
	3.0	400	3	0.015	3	3	0.03	0.015
	4.0	400	3	0.02	4	4	0.04	0.02
	5.0	400	3	0.025	5	5	0.06	0.025
	6.0	400	3	0.035	6	6	0.07	0.035
	8.0	400	3	0.04	8	8	0.08	0.04
	10.0	400	3	0.05	10	10	0.10	0.05
	12.0	400	3	0.06	12	12	0.11	0.06
Aluminium cast alloys 6-12% Si	16.0	400	3	0.09	16	16	0.12	0.09
	20.0	400	3	0.13	20	20	0.16	0.13
	3.0	300	3	0.015	3	3	0.03	0.015
	4.0	300	3	0.02	4	4	0.04	0.02
	5.0	300	3	0.025	5	5	0.06	0.025
	6.0	300	3	0.035	6	6	0.07	0.035
	8.0	300	3	0.04	8	8	0.08	0.04
	10.0	300	3	0.05	10	10	0.10	0.05
Aluminium cast alloys <12%Si	12.0	300	3	0.06	12	12	0.11	0.06
	16.0	300	3	0.09	16	16	0.12	0.09
	20.0	300	3	0.13	20	20	0.16	0.13
	3.0	200	3	0.015	3	3	0.03	0.015
	4.0	200	3	0.02	4	4	0.04	0.02
	5.0	200	3	0.025	5	5	0.06	0.025
	6.0	200	3	0.035	6	6	0.07	0.035
	8.0	200	3	0.04	8	8	0.08	0.04
N2.1	10.0	200	3	0.05	10	10	0.10	0.05
	12.0	200	3	0.06	12	12	0.11	0.06
	16.0	200	3	0.09	16	16	0.12	0.09
	20.0	200	3	0.13	20	20	0.16	0.13
Copper	3.0	100	3	0.015	3	3	0.03	0.015
	4.0	100	3	0.02	4	4	0.04	0.02
	5.0	100	3	0.025	5	5	0.06	0.025
	6.0	100	3	0.035	6	6	0.07	0.035
	8.0	100	3	0.04	8	8	0.08	0.04
	10.0	100	3	0.05	10	10	0.10	0.05
	12.0	100	3	0.06	12	12	0.11	0.06
	16.0	100	3	0.09	16	16	0.12	0.09
N2.5	20.0	100	3	0.13	20	20	0.16	0.13
	3.0	100	3	0.015	3	3	0.03	0.015
	4.0	100	3	0.02	4	4	0.04	0.02
	5.0	100	3	0.025	5	5	0.06	0.025
	6.0	100	3	0.035	6	6	0.07	0.035
	8.0	100	3	0.04	8	8	0.08	0.04
	10.0	100	3	0.05	10	10	0.10	0.05
	12.0	100	3	0.06	12	12	0.11	0.06
Ampco	16.0	100	3	0.09	16	16	0.12	0.09
	20.0	100	3	0.13	20	20	0.16	0.13



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

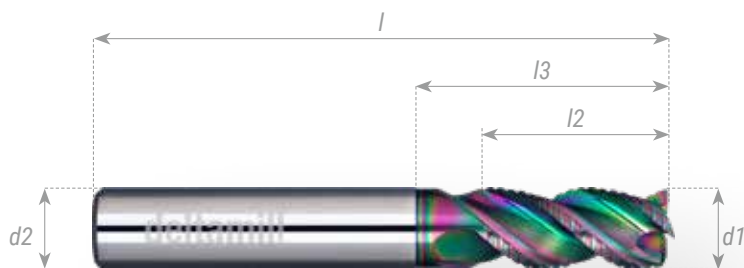


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Ruwrees Frees 3xD neklengte

SC UPC Roughing endmill 3xD neckrelief



ALUMINATOR ROUGHER

Speciale Ruwvertanding
Special Roughing profile



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3933R-0600DLC	6,0	6,0	13	18	58	3	0,2	57,00
D3933R-0800DLC	8,0	8,0	21	25	63	3	0,2	83,00
D3933R-1000DLC	10,0	10,0	22	30	72	3	0,3	122,00
D3933R-1200DLC	12,0	12,0	26	36	62	3	0,4	140,00
D3932R-1600DLC*	16,0	16,0	36	42	84	3	0,6	314,00
D3933R-1600DLC	16,0	16,0	36	48	84	3	0,6	366,00
D3932R-2000DLC*	20,0	20,0	41	52	100	3	0,6	419,00
D3933R-2000DLC	20,0	20,0	41	60	100	3	0,6	432,00

* 2xD uitvoering
2xD version

Mat.	ØD	Vc M/min	Z	ap mm	fz mm Ae 1xD	fz mm Ae 0,6xD	drilling fz mm
N1.1	6.0	550	3	12	0.05	0.09	0.05
	8.0	550	3	16	0.06	0.11	0.06
	10.0	550	3	20	0.07	0.13	0.07
	12.0	550	3	24	0.08	0.15	0.08
	16.0	550	3	32	0.12	0.16	0.12
	20.0	550	3	40	0.18	0.22	0.18
Aluminium wrought alloys							
N1.4	6.0	500	3	12	0.05	0.09	0.05
	8.0	500	3	16	0.06	0.11	0.06
	10.0	500	3	20	0.07	0.13	0.07
	12.0	500	3	24	0.08	0.15	0.08
	16.0	500	3	32	0.12	0.16	0.12
	20.0	500	3	40	0.18	0.22	0.18
Aluminium cast alloys 6-12% Si							
N1.5	6.0	400	3	12	0.05	0.09	0.05
	8.0	400	3	16	0.06	0.11	0.06
	10.0	400	3	20	0.07	0.13	0.07
	12.0	400	3	24	0.08	0.15	0.08
	16.0	400	3	32	0.12	0.16	0.12
	20.0	400	3	40	0.18	0.22	0.18
Aluminium cast alloys < 12% Si							
N2.1	6.0	300	3	12	0.05	0.09	0.05
	8.0	300	3	16	0.06	0.11	0.06
	10.0	300	3	20	0.07	0.13	0.07
	12.0	300	3	24	0.08	0.15	0.08
	16.0	300	3	32	0.12	0.16	0.12
	20.0	300	3	40	0.18	0.22	0.18
Copper							
N2.5	6.0	180	3	12	0.05	0.09	0.05
	8.0	180	3	16	0.06	0.11	0.06
	10.0	180	3	20	0.07	0.13	0.07
	12.0	180	3	24	0.08	0.15	0.08
	16.0	180	3	32	0.12	0.16	0.12
	20.0	180	3	40	0.18	0.22	0.18
Ampco							

Verspanings parameters *Cutting Data*



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

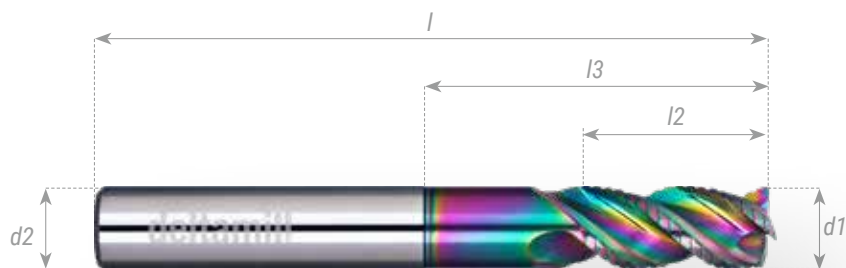


Contour Ap<1,5xD
en Ae<0,5xD



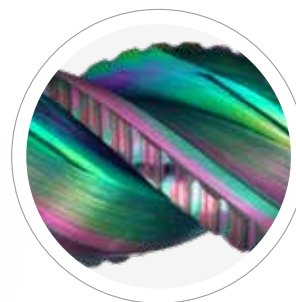
VHM UPC Ruwrees Frees 4xD neklengte

SC UPC Roughing endmill 4xD neckrelief



ALUMINATOR ROUGHER

Speciale Ruwvertanding
Special Roughing profile



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3934R-0800DLC	8,0	8,0	21	34	68	3	0,2	105,00
D3934R-1000DLC	10,0	10,0	22	40	80	3	0,3	144,00
D3934R-1200DLC	12,0	12,0	26	48	94	3	0,4	170,00
D3934R-1600DLC	16,0	16,0	36	64	113	3	0,6	410,00
D3934R-2000DLC	20,0	20,0	41	80	131	3	0,6	623,00

Mat.	ØD	Vc M/min	Z	ap mm	fz mm Ae 1xD	fz mm Ae 0,6xD	drilling fz mm
N1.1	6.0	550	3	12	0.05	0.09	0.05
	8.0	550	3	16	0.06	0.11	0.06
	10.0	550	3	20	0.07	0.13	0.07
	12.0	550	3	24	0.08	0.15	0.08
	16.0	550	3	32	0.12	0.16	0.12
	20.0	550	3	40	0.18	0.22	0.18
Aluminium wrought alloys							
N1.4	6.0	500	3	12	0.05	0.09	0.05
	8.0	500	3	16	0.06	0.11	0.06
	10.0	500	3	20	0.07	0.13	0.07
	12.0	500	3	24	0.08	0.15	0.08
	16.0	500	3	32	0.12	0.16	0.12
	20.0	500	3	40	0.18	0.22	0.18
Aluminium cast alloys 6-12% Si							
N1.5	6.0	400	3	12	0.05	0.09	0.05
	8.0	400	3	16	0.06	0.11	0.06
	10.0	400	3	20	0.07	0.13	0.07
	12.0	400	3	24	0.08	0.15	0.08
	16.0	400	3	32	0.12	0.16	0.12
	20.0	400	3	40	0.18	0.22	0.18
Aluminium cast alloys < 12% Si							
N2.1	6.0	300	3	12	0.05	0.09	0.05
	8.0	300	3	16	0.06	0.11	0.06
	10.0	300	3	20	0.07	0.13	0.07
	12.0	300	3	24	0.08	0.15	0.08
	16.0	300	3	32	0.12	0.16	0.12
	20.0	300	3	40	0.18	0.22	0.18
Copper							
N2.5	6.0	180	3	12	0.05	0.09	0.05
	8.0	180	3	16	0.06	0.11	0.06
	10.0	180	3	20	0.07	0.13	0.07
	12.0	180	3	24	0.08	0.15	0.08
	16.0	180	3	32	0.12	0.16	0.12
	20.0	180	3	40	0.18	0.22	0.18
Ampco							

Verspanings parameters *Cutting Data*



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

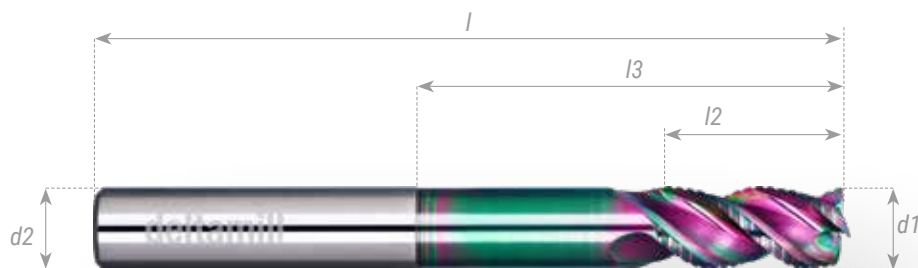


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Ruwfreees Frees 5xD

SC UPC Roughing endmill 5xD



ALUMINATOR ROUGHER

Speciale Ruwvertanding
Special Roughing profile



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3935R-0600DLC	6,0	6,0	13	18	58	3	0,2	76,00
D3935R-0800DLC	8,0	8,0	21	40	80	3	0,2	122,00
D3935R-1000DLC	10,0	10,0	22	50	91	3	0,3	166,00
D3935R-1200DLC	12,0	12,0	26	60	106	3	0,4	214,00
D3935R-1600DLC	16,0	16,0	36	81	131	3	0,6	432,00
D3935R-2000DLC	20,0	20,0	41	100	151	3	0,6	650,00

Mat.	ØD	Vc M/min	Z	ap mm	fz mm Ae 1xD	fz mm Ae 0,6xD	drilling fz mm
N1.1	6.0	450	3	6	0.035	0.07	0.035
	8.0	450	3	8	0.04	0.08	0.04
	10.0	450	3	10	0.05	0.10	0.05
	12.0	450	3	12	0.06	0.11	0.06
	16.0	450	3	16	0.09	0.12	0.09
	20.0	450	3	20	0.13	0.16	0.13
Aluminium wrought alloys							
N1.4	6.0	400	3	6	0.035	0.07	0.035
	8.0	400	3	8	0.04	0.08	0.04
	10.0	400	3	10	0.05	0.10	0.05
	12.0	400	3	12	0.06	0.11	0.06
	16.0	400	3	16	0.09	0.12	0.09
	20.0	400	3	20	0.13	0.16	0.13
Aluminium cast alloys 6-12% Si							
N1.5	6.0	300	3	6	0.035	0.07	0.035
	8.0	300	3	8	0.04	0.08	0.04
	10.0	300	3	10	0.05	0.10	0.05
	12.0	300	3	12	0.06	0.11	0.06
	16.0	300	3	16	0.09	0.12	0.09
	20.0	300	3	20	0.13	0.16	0.13
Aluminium cast alloys < 12% Si							
N2.1	6.0	200	3	6	0.035	0.07	0.035
	8.0	200	3	8	0.04	0.08	0.04
	10.0	200	3	10	0.05	0.10	0.05
	12.0	200	3	12	0.06	0.11	0.06
	16.0	200	3	16	0.09	0.12	0.09
	20.0	200	3	20	0.13	0.16	0.13
Copper							
N2.5	6.0	100	3	6	0.035	0.07	0.035
	8.0	100	3	8	0.04	0.08	0.04
	10.0	100	3	10	0.05	0.10	0.05
	12.0	100	3	12	0.06	0.11	0.06
	16.0	100	3	16	0.09	0.12	0.09
	20.0	100	3	20	0.13	0.16	0.13
Ampco							

Verspanings parameters *Cutting Data*



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

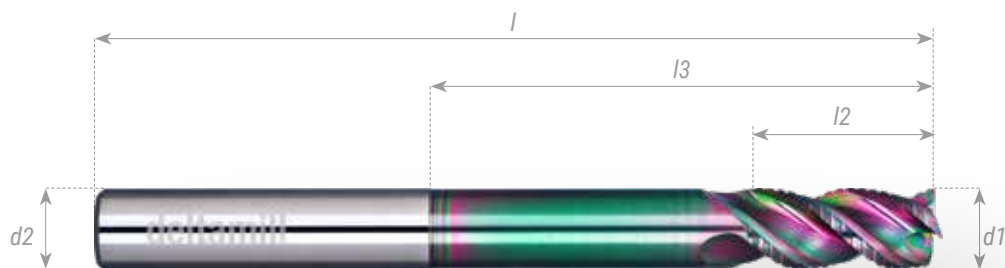


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Ruwfrees Frees 6xD

Solid carbide UPC Roughing endmill 6xD



ALUMINATOR ROUGHER

Speciale Ruwvertanding
Special Roughing profile



Code	Ød1	Ød2	l2	l3	l	z	r	€
D3936R-1000DLC	10,0	10,0	22	60	100	3	0,3	187,00
D3936R-1200DLC	12,0	12,0	26	72	120	3	0,4	257,00
D3936R-1600DLC	16,0	16,0	36	96	145	3	0,6	571,00
D3936R-2000DLC	20,0	20,0	41	120	170	3	0,6	799,00

Mat.	ØD	Vc M/min	Z	ap mm	fz mm Ae 1xD	fz mm Ae 0,6xD	drilling fz mm
N1.1	6.0	450	3	6	0.035	0.07	0.035
	8.0	450	3	8	0.04	0.08	0.04
	10.0	450	3	10	0.05	0.10	0.05
	12.0	450	3	12	0.06	0.11	0.06
	16.0	450	3	16	0.09	0.12	0.09
	20.0	450	3	20	0.13	0.16	0.13
Aluminium wrought alloys							
N1.4	6.0	400	3	6	0.035	0.07	0.035
	8.0	400	3	8	0.04	0.08	0.04
	10.0	400	3	10	0.05	0.10	0.05
	12.0	400	3	12	0.06	0.11	0.06
	16.0	400	3	16	0.09	0.12	0.09
	20.0	400	3	20	0.13	0.16	0.13
Aluminium cast alloys 6-12% Si							
N1.5	6.0	300	3	6	0.035	0.07	0.035
	8.0	300	3	8	0.04	0.08	0.04
	10.0	300	3	10	0.05	0.10	0.05
	12.0	300	3	12	0.06	0.11	0.06
	16.0	300	3	16	0.09	0.12	0.09
	20.0	300	3	20	0.13	0.16	0.13
Aluminium cast alloys < 12% Si							
N2.1	6.0	200	3	6	0.035	0.07	0.035
	8.0	200	3	8	0.04	0.08	0.04
	10.0	200	3	10	0.05	0.10	0.05
	12.0	200	3	12	0.06	0.11	0.06
	16.0	200	3	16	0.09	0.12	0.09
	20.0	200	3	20	0.13	0.16	0.13
Copper							
N2.5	6.0	100	3	6	0.035	0.07	0.035
	8.0	100	3	8	0.04	0.08	0.04
	10.0	100	3	10	0.05	0.10	0.05
	12.0	100	3	12	0.06	0.11	0.06
	16.0	100	3	16	0.09	0.12	0.09
	20.0	100	3	20	0.13	0.16	0.13
Ampco							

Verspanings parameters *Cutting Data*



Drilling Ap1xD



Slotting Ap1xD
en Ae1xD

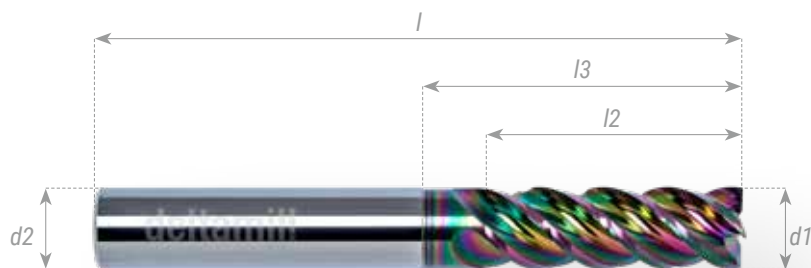


Contour Ap<1,5xD
en Ae<0,5xD



VHM UPC Trochiodaal Frees 3xD

SC UPC Trochiodal endmill 3xD



XTREMA UNI



Code	Ød1	Ød2	l2	l3	l	z	c	€
D4933-0300DLC	3,0	6,0	14	23	62	4	0,1	65,00
D4933-0400DLC	4,0	6,0	15	23	62	4	0,1	65,00
D4933-0500DLC	5,0	6,0	16	24	62	4	0,1	65,00
D4933-0600DLC	6,0	6,0	19	24	62	4	0,1	65,00
D4933-0800DLC	8,0	8,0	25	30	68	4	0,2	94,00
D4933-1000DLC	10,0	10,0	31	38	80	4	0,2	124,00
D4933-1200DLC	12,0	12,0	37	46	93	4	0,3	152,00
D4933-1600DLC	16,0	16,0	49	58	108	4	0,3	284,00
D4933-2000DLC	20,0	20,0	61	74	126	4	0,3	380,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 20% x D	hm* mm
N1.1	3.0	500	4	60°	14	0.224	0.158	0.112	0.050
	4.0	500	4	60°	15	0.358	0.253	0.179	0.080
	5.0	500	4	60°	16	0.447	0.316	0.224	0.100
	6.0	500	4	60°	19	0.581	0.411	0.291	0.130
	8.0	500	4	60°	25	0.626	0.442	0.313	0.140
	10.0	500	4	60°	31	0.671	0.474	0.335	0.140
	12.0	500	4	60°	37	0.716	0.506	0.358	0.160
	16.0	500	4	60°	49	0.894	0.632	0.447	0.200
	20.0	500	4	60°	61	1.073	0.759	0.537	0.240
Aluminium wrought alloys									
N1.4	3.0	500	4	60°	14	0.224	0.158	0.112	0.050
	4.0	500	4	60°	15	0.358	0.253	0.179	0.080
	5.0	500	4	60°	16	0.447	0.316	0.224	0.100
	6.0	500	4	60°	19	0.581	0.411	0.291	0.130
	8.0	500	4	60°	25	0.626	0.442	0.313	0.140
	10.0	500	4	60°	31	0.671	0.474	0.335	0.140
	12.0	500	4	60°	37	0.716	0.506	0.358	0.160
	16.0	500	4	60°	49	0.894	0.632	0.447	0.200
	20.0	500	4	60°	61	1.073	0.759	0.537	0.240
Aluminium cast alloys 6-12% Si									
N1.5	3.0	450	4	60°	14	0.224	0.158	0.112	0.050
	4.0	450	4	60°	15	0.358	0.253	0.179	0.080
	5.0	450	4	60°	16	0.447	0.316	0.224	0.100
	6.0	450	4	60°	19	0.581	0.411	0.291	0.130
	8.0	450	4	60°	25	0.626	0.442	0.313	0.140
	10.0	450	4	60°	31	0.671	0.474	0.335	0.140
	12.0	450	4	60°	37	0.716	0.506	0.358	0.160
	16.0	450	4	60°	49	0.894	0.632	0.447	0.200
	20.0	450	4	60°	61	1.073	0.759	0.537	0.240
Aluminium cast alloys <12% Si									
N2.1	3.0	300	4	60°	14	0.224	0.158	0.112	0.050
	4.0	300	4	60°	15	0.313	0.221	0.157	0.070
	5.0	300	4	60°	16	0.402	0.285	0.201	0.090
	6.0	300	4	60°	19	0.492	0.348	0.246	0.110
	8.0	300	4	60°	25	0.537	0.379	0.269	0.120
	10.0	300	4	60°	31	0.581	0.411	0.291	0.130
	12.0	300	4	60°	37	0.626	0.443	0.313	0.140
	16.0	300	4	60°	49	0.805	0.569	0.402	0.180
	20.0	300	4	60°	61	0.894	0.632	0.447	0.200
Copper									
N2.5	3.0	150	4	60°	14	0.188	0.133	0.094	0.042
	4.0	150	4	60°	15	0.246	0.174	0.123	0.055
	5.0	150	4	60°	16	0.313	0.221	0.157	0.070
	6.0	150	4	60°	19	0.380	0.269	0.190	0.085
	8.0	150	4	60°	25	0.537	0.379	0.268	0.120
	10.0	150	4	60°	31	0.626	0.443	0.313	0.140
	12.0	150	4	60°	37	0.738	0.522	0.369	0.165
	16.0	150	4	60°	49	0.859	0.429	0.429	0.192
	20.0	150	4	60°	61	1.073	0.759	0.537	0.240
Ampco									

*hm= gemiddelde spaandikte
*hm= average chip thickness

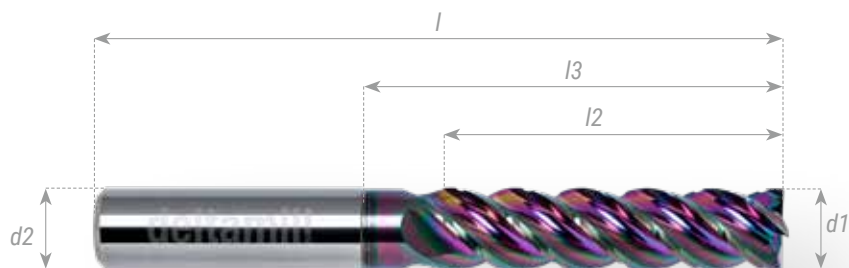


Trochiodal Max Ap
and Ae max 15%



VHM UPC Trochiodaal Frees 4xD

SC UPC Trochiodal Endmill 4xD



XTREMA UNI



Code	Ød1	Ød2	L2	L3	L	z	c	€
D4934-0600DLC	6,0	6,0	25	30	71	4	0,1	66,00
D4934-0800DLC	8,0	8,0	33	40	80	4	0,2	96,00
D4934-1000DLC	10,0	10,0	41	50	95	4	0,2	128,00
D4934-1200DLC	12,0	12,0	49	60	109	4	0,3	168,00
D4934-1600DLC	16,0	16,0	65	80	132	4	0,3	327,00
D4934-2000DLC	20,0	20,0	82	100	154	4	0,3	457,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 20% x D	hm* mm
N1.1	3.0	500	4	60°	14	0.224	0.158	0.112	0.050
	4.0	500	4	60°	15	0.358	0.253	0.179	0.080
	5.0	500	4	60°	16	0.447	0.316	0.224	0.100
	6.0	500	4	60°	19	0.581	0.411	0.291	0.130
	8.0	500	4	60°	25	0.626	0.442	0.313	0.140
	10.0	500	4	60°	31	0.671	0.474	0.335	0.140
	12.0	500	4	60°	37	0.716	0.506	0.358	0.160
	16.0	500	4	60°	49	0.894	0.632	0.447	0.200
	20.0	500	4	60°	61	1.073	0.759	0.537	0.240
Aluminium wrought alloys									
N1.4	3.0	500	4	60°	14	0.224	0.158	0.112	0.050
	4.0	500	4	60°	15	0.358	0.253	0.179	0.080
	5.0	500	4	60°	16	0.447	0.316	0.224	0.100
	6.0	500	4	60°	19	0.581	0.411	0.291	0.130
	8.0	500	4	60°	25	0.626	0.442	0.313	0.140
	10.0	500	4	60°	31	0.671	0.474	0.335	0.140
	12.0	500	4	60°	37	0.716	0.506	0.358	0.160
	16.0	500	4	60°	49	0.894	0.632	0.447	0.200
	20.0	500	4	60°	61	1.073	0.759	0.537	0.240
Aluminium cast alloys 6-12% Si									
N1.5	3.0	450	4	60°	14	0.224	0.158	0.112	0.050
	4.0	450	4	60°	15	0.358	0.253	0.179	0.080
	5.0	450	4	60°	16	0.447	0.316	0.224	0.100
	6.0	450	4	60°	19	0.581	0.411	0.291	0.130
	8.0	450	4	60°	25	0.626	0.442	0.313	0.140
	10.0	450	4	60°	31	0.671	0.474	0.335	0.140
	12.0	450	4	60°	37	0.716	0.506	0.358	0.160
	16.0	450	4	60°	49	0.894	0.632	0.447	0.200
	20.0	450	4	60°	61	1.073	0.759	0.537	0.240
Aluminium cast alloys < 12% Si									
N2.1	3.0	300	4	60°	14	0.224	0.158	0.112	0.050
	4.0	300	4	60°	15	0.313	0.221	0.157	0.070
	5.0	300	4	60°	16	0.402	0.285	0.201	0.090
	6.0	300	4	60°	19	0.492	0.348	0.246	0.110
	8.0	300	4	60°	25	0.537	0.379	0.269	0.120
	10.0	300	4	60°	31	0.581	0.411	0.291	0.130
	12.0	300	4	60°	37	0.626	0.443	0.313	0.140
	16.0	300	4	60°	49	0.805	0.569	0.402	0.180
	20.0	300	4	60°	61	0.894	0.632	0.447	0.200
Copper									
N2.5	3.0	150	4	60°	14	0.188	0.133	0.094	0.042
	4.0	150	4	60°	15	0.246	0.174	0.123	0.055
	5.0	150	4	60°	16	0.313	0.221	0.157	0.070
	6.0	150	4	60°	19	0.380	0.269	0.190	0.085
	8.0	150	4	60°	25	0.537	0.379	0.268	0.120
	10.0	150	4	60°	31	0.626	0.443	0.313	0.140
	12.0	150	4	60°	37	0.738	0.522	0.369	0.165
	16.0	150	4	60°	49	0.859	0.429	0.429	0.192
	20.0	150	4	60°	61	1.073	0.759	0.537	0.240
Ampco									

*hm= gemiddelde spaandikte
*hm= average chip thickness

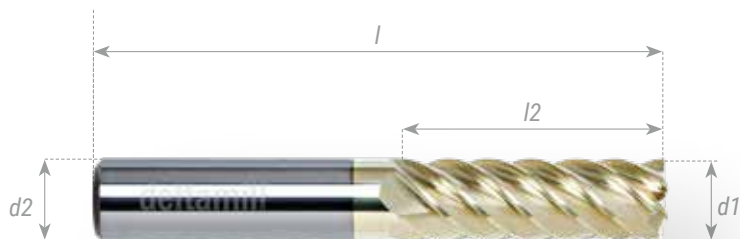


Trochiodal Max Ap
and Ae max 15%



VHM HPC Finish Frees 3xD

SC HPC endmill for finishing 3xD



AGRESSOR FINISHER

HPC

ALU



Code	Ød1	Ød2	l2	l3	l	z	c/r	€
D6933-0600AZOX	6,0	6,0	18	-	62	6	-	56,00
D6933-0800AZOX	8,0	8,0	24	-	68	6	-	77,00
D6933-1000AZOX	10,0	10,0	30	-	80	6	-	101,00
D6933-1200AZOX	12,0	12,0	36	-	93	6	-	130,00
D6933-1600AZOX	16,0	16,0	48	-	108	6	-	299,00
D6933-2000AZOX	20,0	20,0	60	-	126	6	-	356,00

Verspanings parameters *Cutting Data*

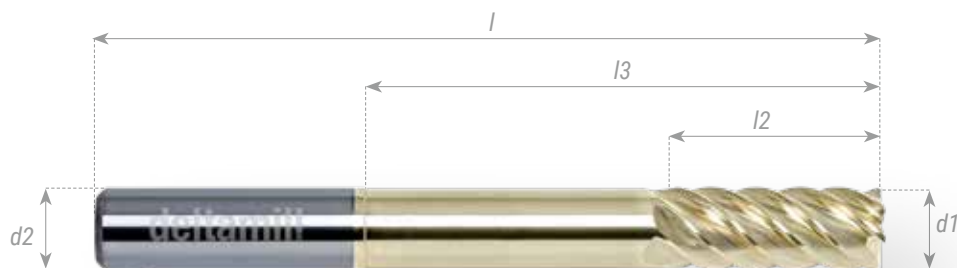
Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
N1.1 Aluminium wrought alloys	6.0	500	6	0.025	18	0.3
	8.0	500	6	0.035	24	0.4
	10.0	500	6	0.045	30	0.5
	12.0	500	6	0.050	36	0.6
	16.0	500	6	0.060	48	0.8
	20.0	500	6	0.070	60	1.0
N1.4 Aluminium cast alloys	6.0	300	6	0.015	6	0.3
	8.0	300	6	0.020	8	0.4
	10.0	300	6	0.025	10	0.5
	12.0	300	6	0.030	12	0.6
	16.0	300	6	0.050	16	0.8
	20.0	300	6	0.060	20	1.0
N1.5 Aluminium cast alloys	6.0	240	6	0.015	6	0.3
	8.0	240	6	0.020	8	0.4
	10.0	240	6	0.025	10	0.5
	12.0	240	6	0.030	12	0.6
	16.0	240	6	0.050	16	0.8
	20.0	240	6	0.060	20	1.0
N2.1 Copper	6.0	150	6	0.015	6	0.3
	8.0	150	6	0.020	8	0.4
	10.0	150	6	0.025	10	0.5
	12.0	150	6	0.030	12	0.6
	16.0	150	6	0.050	16	0.8
	20.0	150	6	0.060	20	1.0
N2.2 Brass	6.0	240	6	0.015	6	0.3
	8.0	240	6	0.020	8	0.4
	10.0	240	6	0.025	10	0.5
	12.0	240	6	0.030	12	0.6
	16.0	240	6	0.050	16	0.8
	20.0	240	6	0.060	20	1.0
N2.3 Bronze	6.0	150	6	0.015	6	0.3
	8.0	150	6	0.020	8	0.4
	10.0	150	6	0.025	10	0.5
	12.0	150	6	0.030	12	0.6
	16.0	150	6	0.050	16	0.8
	20.0	150	6	0.060	20	1.0
N2.5 Ampco	6.0	100	6	0.015	6	0.3
	8.0	100	6	0.020	8	0.4
	10.0	100	6	0.025	10	0.5
	12.0	100	6	0.030	12	0.6
	16.0	100	6	0.050	16	0.8
	20.0	100	6	0.060	20	1.0



Finish Ap<3xD
en Ae 0,05xD

VHM HPC Finiseer Frees lang 5xD

SC HPC endmill for finishing long 5xD



AGRESSOR FINISHER



Code	Ød1	Ød2	l2	l3	l	z	c/r	€
D6935-0600BZOX	6,0	6,0	16	42	80	6	-	63,00
D6935-0800BZOX	8,0	8,0	19	62	100	6	-	83,00
D6935-1000BZOX	10,0	10,0	25	58	100	6	-	135,00
D6935-1200BZOX	12,0	12,0	30	72	120	6	-	192,00
D6935-1600BZOX	16,0	16,0	40	100	150	6	-	376,00
D6935-2000BZOX	20,0	20,0	50	100	150	6	-	429,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
N1.1 Aluminium wrought alloys	6.0	500	6	0.020	16	0.3
	8.0	500	6	0.030	19	0.4
	10.0	500	6	0.040	25	0.5
	12.0	500	6	0.045	30	0.6
	16.0	500	6	0.055	40	0.8
	20.0	500	6	0.065	50	1.0
N1.4 Aluminium cast alloys	6.0	300	6	0.015	16	0.3
	8.0	300	6	0.020	19	0.4
	10.0	300	6	0.025	25	0.5
	12.0	300	6	0.030	30	0.6
	16.0	300	6	0.045	40	0.8
	20.0	300	6	0.055	50	1.0
N1.5 Aluminium cast alloys	6.0	240	6	0.015	16	0.3
	8.0	240	6	0.020	19	0.4
	10.0	240	6	0.025	25	0.5
	12.0	240	6	0.030	30	0.6
	16.0	240	6	0.045	40	0.8
	20.0	240	6	0.055	50	1.0
N2.1 Copper	6.0	150	6	0.015	16	0.3
	8.0	150	6	0.020	19	0.4
	10.0	150	6	0.025	25	0.5
	12.0	150	6	0.030	30	0.6
	16.0	150	6	0.045	40	0.8
	20.0	150	6	0.055	50	1.0
N2.2 Brass	6.0	240	6	0.015	16	0.3
	8.0	240	6	0.020	19	0.4
	10.0	240	6	0.025	25	0.5
	12.0	240	6	0.030	30	0.6
	16.0	240	6	0.045	40	0.8
	20.0	240	6	0.055	50	1.0
N2.3 Bronze	6.0	150	6	0.015	16	0.3
	8.0	150	6	0.020	19	0.4
	10.0	150	6	0.025	25	0.5
	12.0	150	6	0.030	30	0.6
	16.0	150	6	0.045	40	0.8
	20.0	150	6	0.055	50	1.0
N2.5 Ampco	6.0	100	6	0.015	16	0.3
	8.0	100	6	0.020	19	0.4
	10.0	100	6	0.025	25	0.5
	12.0	100	6	0.030	30	0.6
	16.0	100	6	0.045	40	0.8
	20.0	100	6	0.055	50	1.0

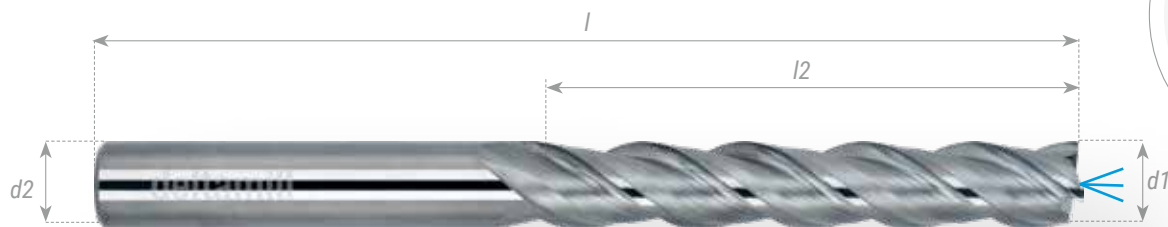


Finish Ap<2xD
en Ae 0,05xD



VHM HPC Frees ALU-Finisher Koelkanaal 6xD

SC HPC ALU Longflute Finisher Coolant hole 6xD


AGRESSOR ALU

HPC

ALU

POLISH
FLUTE

Code	Ød1	Ød2	l2	l3	l	z	r	€
D3936-1002ALF	10,0	10,0	62	-	115	3	0,1	218,00
D3936-1202ALF	12,0	12,0	74	-	134	3	0,1	340,00
D3936-1602ALF	16,0	16,0	98	-	166	3	0,1	719,00

Andere diameters op aanvraag.
Other dimensions on request.

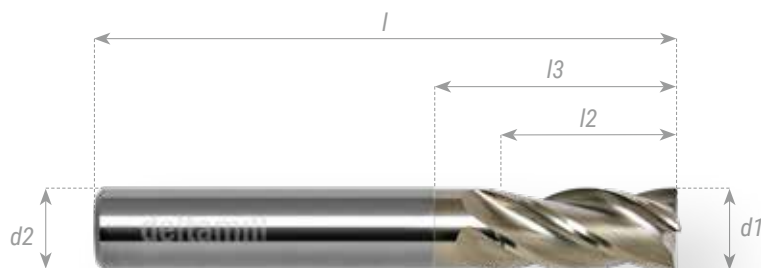
Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
N1.1	6.0	600	3	0.06	36	0,03
	8.0	600	3	0.06	48	0,04
	10.0	600	3	0.07	60	0,05
	12.0	600	3	0.08	72	0,06
	16.0	600	3	0.12	96	0,08
Aluminium wrought alloys						
N1.4	6.0	400	3	0.06	36	0,03
	8.0	400	3	0.06	48	0,04
	10.0	400	3	0.07	60	0,05
	12.0	400	3	0.08	72	0,06
	16.0	400	3	0.12	96	0,08
Aluminium cast alloys 6-12% Si						
N1.5	6.0	320	3	0.06	36	0,03
	8.0	320	3	0.06	48	0,04
	10.0	320	3	0.07	60	0,05
	12.0	320	3	0.08	72	0,06
	16.0	320	3	0.12	96	0,08
Aluminium cast alloys <12%Si						
N2.1	6.0	200	3	0.06	36	0,03
	8.0	200	3	0.06	48	0,04
	10.0	200	3	0.07	60	0,05
	12.0	200	3	0.08	72	0,06
	16.0	200	3	0.12	96	0,08
Copper						



Finish Ap<6xD
en Ae 0,005xD





AGRESSOR TITAN



Code	Ød1	Ød2	l2	l3	l	z	r	€
D4950-0400SI2	4,0	6,0	11	17	57	4	0,1	37,00
D4950-0500SI2	5,0	6,0	13	19	57	4	0,1	37,00
D4950-0600SI2	6,0	6,0	13	19	57	4	0,1	37,00
D4950-0800SI2	8,0	8,0	21	25	63	4	0,2	47,00
D4950-1000SI2	10,0	10,0	22	30	72	4	0,2	69,00
D4950-1200SI2	12,0	12,0	26	36	83	4	0,2	94,00
D4950-1600SI2	16,0	16,0	36	42	92	4	0,3	177,00
D4950-2000SI2	20,0	20,0	41	52	104	4	0,3	276,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
S1.1 Pure Titanium Ti99,5 / Ti Grade 1	3.0	100	4	0.015	3	3
	4.0	100	4	0.020	4	4
	5.0	100	4	0.025	5	5
	6.0	100	4	0.030	6	6
	8.0	100	4	0.035	8	8
	10.0	100	4	0.045	10	10
	12.0	100	4	0.055	12	12
	16.0	100	4	0.080	8	16
	20.0	100	4	0.095	10	20
S1.2 Titanium alloys Ti Grade 3 & 4	3.0	90	4	0.010	3	3
	4.0	90	4	0.015	4	4
	5.0	90	4	0.020	5	5
	6.0	90	4	0.025	6	6
	8.0	90	4	0.030	8	8
	10.0	90	4	0.040	10	10
	12.0	90	4	0.050	12	12
	16.0	90	4	0.065	8	16
	20.0	90	4	0.080	10	20
S1.3 Titanium alloys TiAl6V4 / Grade 5	3.0	70	4	0.007	3	3
	4.0	70	4	0.010	4	4
	5.0	70	4	0.015	5	5
	6.0	70	4	0.020	6	6
	8.0	70	4	0.025	8	8
	10.0	70	4	0.035	10	10
	12.0	70	4	0.040	12	12
	16.0	70	4	0.050	8	16
	20.0	70	4	0.065	10	20
S2.2 Inconel 625	3.0	50	4	0.010	1,5	3
	4.0	50	4	0.015	2	4
	5.0	50	4	0.020	2,5	5
	6.0	50	4	0.025	3	6
	8.0	50	4	0.030	4	8
	10.0	50	4	0.035	5	10
	12.0	50	4	0.040	6	12
	16.0	50	4	0.050	8	16
	20.0	50	4	0.060	10	20
S2.3 Inconel 718	3.0	40	4	0.005	1,5	3
	4.0	40	4	0.008	2	4
	5.0	40	4	0.012	2,5	5
	6.0	40	4	0.015	3	6
	8.0	40	4	0.020	4	8
	10.0	40	4	0.025	5	10
	12.0	40	4	0.030	6	12
	16.0	40	4	0.040	8	16
	20.0	40	4	0.060	10	20
M1.2 Stainless steel 303-304-316	3.0	100	5	0,012	1,5	1,5
	4.0	100	5	0,015	2	2
	5.0	100	5	0,020	2,5	2,5
	6.0	100	5	0,025	3	3
	8.0	100	5	0,030	4	4
	10.0	100	5	0,035	5	5
	12.0	100	5	0,040	6	6
	16.0	100	5	0,050	8	8
	20.0	100	5	0,07	10	10

Correctie *Correction*

Ae	Ap	Vc	fz
Ae= <0,4xD	1 x D	20%	20%
Ae= <0,4xD	1,5 x D	10%	10%
Ae= <0,05xD	2 x D	-	100%



Slotting Ap1xD
en Ae1xD

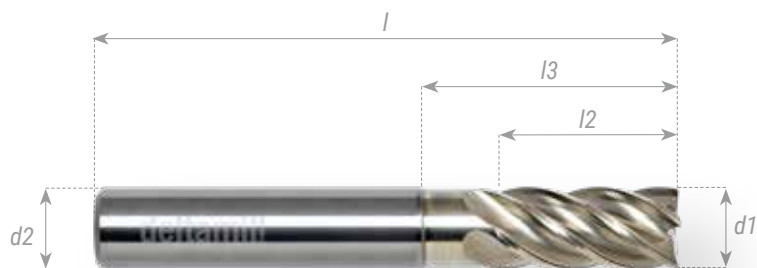


Contour Ap<1,5xD
en Ae<0,5xD



Finish Ap<2xD
en Ae 0,05xD





AGRESSOR TITAN



Code	Ød1	Ød2	l2	l3	l	z	r	€
D5950-0400SI2	4,0	6,0	11	17	57	5	0,1	39,00
D5950-0500SI2	5,0	6,0	13	19	57	5	0,1	39,00
D5950-0600SI2	6,0	6,0	13	19	57	5	0,1	39,00
D5950-0800SI2	8,0	8,0	21	25	63	5	0,2	49,00
D5950-1000SI2	10,0	10,0	22	30	72	5	0,2	72,00
D5950-1200SI2	12,0	12,0	26	36	83	5	0,2	99,00
D5950-1600SI2	16,0	16,0	36	42	92	5	0,3	186,00
D5950-2000SI2	20,0	20,0	41	52	104	5	0,3	289,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
S1.1 Pure Titanium Ti99,5 / Ti Grade 1	3.0	100	5	0,015	3	1,5
	4.0	100	5	0,030	4	2
	5.0	100	5	0,025	5	2,5
	6.0	100	5	0,030	6	3
	8.0	100	5	0,035	8	4
	10.0	100	5	0,045	10	5
	12.0	100	5	0,055	12	6
	16.0	100	5	0,080	8	8
	20.0	100	5	0,095	10	10
S1.2 Titanium alloys Ti Grade 3 & 4	3.0	90	5	0,007	3	1,5
	4.0	90	5	0,010	4	2
	5.0	90	5	0,015	5	2,5
	6.0	90	5	0,020	6	3
	8.0	90	5	0,025	8	4
	10.0	90	5	0,035	10	5
	12.0	90	5	0,040	12	6
	16.0	90	5	0,050	8	8
	20.0	90	5	0,065	10	10
S2.2 Inconel 625	3.0	50	5	0,010	3	1,5
	4.0	50	5	0,015	4	2
	5.0	50	5	0,020	5	2,5
	6.0	50	5	0,025	6	3
	8.0	50	5	0,030	8	4
	10.0	50	5	0,035	10	5
	12.0	50	5	0,040	12	6
	16.0	50	5	0,050	8	8
	20.0	50	5	0,060	10	10
S2.3 Inconel 718	3.0	40	5	0,005	1,5	1,5
	4.0	40	5	0,008	2	2
	5.0	40	5	0,012	2,5	2,5
	6.0	40	5	0,015	3	3
	8.0	40	5	0,020	4	4
	10.0	40	5	0,025	5	5
	12.0	40	5	0,030	6	6
	16.0	40	5	0,040	8	8
	20.0	40	5	0,050	10	10
M1.2 Stainless steel 303-304-316	3.0	100	5	0,012	1,5	1,5
	4.0	100	5	0,015	2	2
	5.0	100	5	0,020	2,5	2,5
	6.0	100	5	0,025	3	3
	8.0	100	5	0,030	4	4
	10.0	100	5	0,035	5	5
	12.0	100	5	0,040	6	6
	16.0	100	5	0,050	8	8
	20.0	100	5	0,07	10	10

Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1 x D	20%	20%
Ae= <0,4xD	1,5 x D	10%	10%
Ae= <0,05xD	2 x D	-	100%



Contour Ap<1,5xD
en Ae<0,5xD

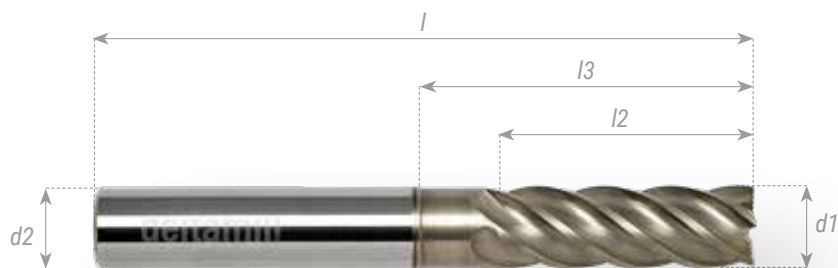


Finish Ap<2xD
en Ae 0,05xD



VHM HPC Trochiodaal Frees 3xD

SC UPC Trochiodal Endmill 3xD



AGRESSOR TITAN

HPC

TITAN



Code	Ød1	Ød2	l2	l3	l	z	r	€
D5953-0300SI2	3,0	6,0	14	23	62	5	0,1	56,00
D5953-0400SI2	4,0	6,0	15	23	62	5	0,1	56,00
D5953-0500SI2	5,0	6,0	16	24	62	5	0,1	56,00
D5953-0600SI2	6,0	6,0	19	24	62	5	0,1	56,00
D5953-0800SI2	8,0	8,0	25	30	68	5	0,2	81,00
D5953-1000SI2	10,0	10,0	31	38	80	5	0,2	106,00
D5953-1200SI2	12,0	12,0	37	46	93	5	0,3	130,00
D5953-1600SI2	16,0	16,0	49	58	108	5	0,3	234,00
D5953-2000SI2	20,0	20,0	61	74	126	5	0,3	330,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	Max. contacthoek Max. contactangle	ap mm	fz mm ae= 5% x D	fz mm ae= 10% x D	fz mm ae= 15% x D	hm* mm
S1.1 Pure Titanium Ti99,5 / Ti Grade 1	3.0	150	5	40°	14	0.030	0.010	0.005	0.002
	4.0	150	5	40°	15	0.040	0.020	0.010	0.003
	5.0	150	5	40°	16	0.050	0.030	0.020	0.005
	6.0	150	5	40°	19	0.060	0.040	0.030	0.010
	8.0	150	5	40°	25	0.070	0.050	0.040	0.015
	10.0	150	5	40°	31	0.090	0.060	0.040	0.015
	12.0	150	5	40°	37	0.110	0.080	0.070	0.025
	16.0	150	5	40°	49	0.157	0.111	0.090	0.035
	20.0	150	5	40°	61	0.220	0.150	0.130	0.049
S1.2 Titanium alloys Ti Grade 3 & 4	3.0	130	5	40°	14	0.030	0.010	0.005	0.002
	4.0	130	5	40°	15	0.040	0.020	0.010	0.003
	5.0	130	5	40°	16	0.050	0.030	0.020	0.005
	6.0	130	5	40°	19	0.060	0.040	0.030	0.010
	8.0	130	5	40°	25	0.070	0.050	0.040	0.015
	10.0	130	5	40°	31	0.090	0.060	0.040	0.015
	12.0	130	5	40°	37	0.110	0.080	0.070	0.025
	16.0	130	5	40°	49	0.157	0.111	0.090	0.035
	20.0	130	5	40°	61	0.220	0.150	0.130	0.049
S1.3 Titanium alloys TiAl6V4 / Grade 5	3.0	110	5	40°	14	0.010	0.005	0.005	0.004
	4.0	110	5	40°	15	0.020	0.010	0.010	0.006
	5.0	110	5	40°	16	0.030	0.020	0.020	0.008
	6.0	110	5	40°	19	0.040	0.030	0.030	0.010
	8.0	110	5	40°	25	0.050	0.040	0.030	0.012
	10.0	110	5	40°	31	0.070	0.050	0.040	0.015
	12.0	110	5	40°	37	0.080	0.060	0.050	0.019
	16.0	110	5	40°	49	0.117	0.083	0.070	0.026
	20.0	110	5	40°	61	0.160	0.120	0.090	0.036
S2.2 Inconel 625	3.0	90	5	40°	14	0.010	0.005	0.005	0.004
	4.0	90	5	40°	15	0.020	0.010	0.010	0.006
	5.0	90	5	40°	16	0.030	0.020	0.020	0.008
	6.0	90	5	40°	19	0.040	0.030	0.030	0.010
	8.0	90	5	40°	25	0.050	0.040	0.030	0.012
	10.0	90	5	40°	31	0.070	0.050	0.040	0.015
	12.0	90	5	40°	37	0.080	0.060	0.050	0.019
	16.0	90	5	40°	49	0.117	0.083	0.070	0.026
	20.0	90	5	40°	61	0.160	0.120	0.090	0.036
S2.3 Inconel 718	3.0	70	5	40°	14	0.010	0.005	0.005	0.004
	4.0	70	5	40°	15	0.020	0.010	0.010	0.006
	5.0	70	5	40°	16	0.030	0.020	0.020	0.008
	6.0	70	5	40°	19	0.040	0.030	0.030	0.010
	8.0	70	5	40°	25	0.050	0.040	0.030	0.012
	10.0	70	5	40°	31	0.070	0.050	0.040	0.015
	12.0	70	5	40°	37	0.080	0.060	0.050	0.019
	16.0	70	5	40°	49	0.117	0.083	0.070	0.026
	20.0	70	5	40°	61	0.160	0.090	0.090	0.036

*hm= gemiddelde spaandikte
*hm= average chip thickness

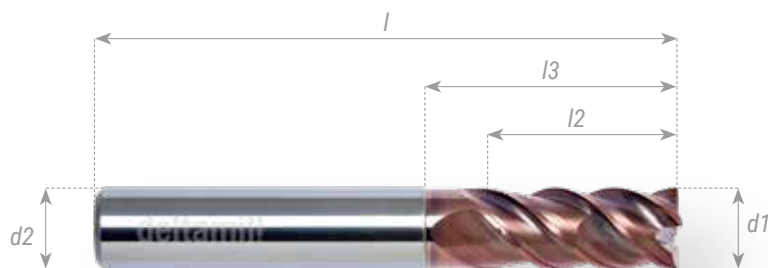


Trochiodal Max Ap
and Ae max 15%



VHM HPC Frees <60 HRC

Solid Carbide HPC endmill <60 HRC



AGRESSOR **HARD**

HPC

HRC
HARDCOATING
TiALN

Code	Ød1	Ød2	l2	l3	l	z	c	€
D4960-0300BT	3,0	6,0	8	-	57	4	0,1	36,00
D4960-0400BT	4,0	6,0	11	-	57	4	0,1	36,00
D4960-0500BT	5,0	6,0	13	18	57	4	0,1	36,00
D4960-0600BT	6,0	6,0	13	18	57	4	0,1	36,00
D4960-0800BT	8,0	8,0	21	25	64	4	0,2	45,00
D4960-1000BT	10,0	10,0	22	30	72	4	0,2	66,00
D4960-1200BT	12,0	12,0	26	36	83	4	0,3	92,00
D4560-1600BT	16,0	16,0	36	42	92	4	0,3	174,00
D4560-2000BT	20,0	20,0	41	52	104	4	0,3	276,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P3.2 High Alloy steels < 1600N/mm²	3.0	120	4	0.010	3	3
	4.0	120	4	0.015	4	4
	5.0	120	4	0.020	5	5
	6.0	120	4	0.025	6	6
	8.0	120	4	0.030	8	8
	10.0	120	4	0.035	10	10
	12.0	120	4	0.040	12	12
	16.0	120	4	0.050	8	16
	20.0	120	4	0.060	10	20
H1.1 Hardened steel < 52 HRC	3.0	75	4	0.008	3	3
	4.0	75	4	0.010	4	4
	5.0	75	4	0.012	5	5
	6.0	75	4	0.017	6	6
	8.0	75	4	0.020	8	8
	10.0	75	4	0.025	10	10
	12.0	75	4	0.030	12	12
	16.0	75	4	0.040	8	16
	20.0	75	4	0.050	10	20
H1.2 Hardened steel < 56 HRC	3.0	55	4	0.008	3	3
	4.0	55	4	0.010	4	4
	5.0	55	4	0.012	5	5
	6.0	55	4	0.017	6	6
	8.0	55	4	0.020	8	8
	10.0	55	4	0.025	10	10
	12.0	55	4	0.030	12	12
	16.0	55	4	0.040	8	16
	20.0	55	4	0.050	10	20
H1.3 Hardened steel < 60 HRC	3.0	30	4	0.004	1.5	3
	4.0	30	4	0.006	2	4
	5.0	30	4	0.007	2.5	5
	6.0	30	4	0.008	3	6
	8.0	30	4	0.010	4	8
	10.0	30	4	0.015	5	10
	12.0	30	4	0.020	6	12
	16.0	30	4	0.030	5	16
	20.0	30	4	0.040	6	20
H1.4 Hardened steel < 63 HRC	3.0	25	4	0.004	1.5	3
	4.0	25	4	0.006	2	4
	5.0	25	4	0.007	2.5	5
	6.0	25	4	0.008	3	6
	8.0	25	4	0.010	4	8
	10.0	25	4	0.015	5	10
	12.0	25	4	0.020	6	12
	16.0	25	4	0.030	5	16
	20.0	25	8	0.040	6	20

Correctie Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1 x D	+20%	+20%
Ae= <0,4xD	1,5 x D	+10%	+10%
Ae= <0,05xD	2 x D	-	+100%



Slotting Ap1xD
en Ae1xD



Contour Ap<1,5xD
en Ae<0,4xD

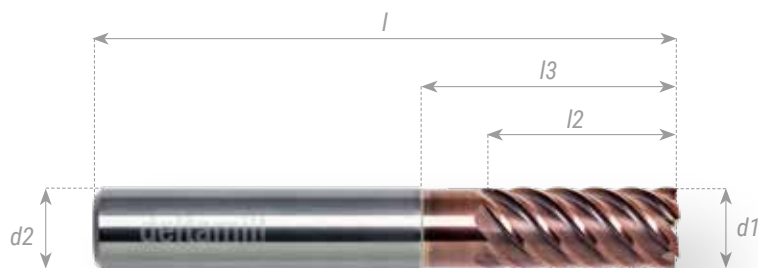


Finish Ap<2xD
en Ae 0,05xD



VHM HPC Finiseer Frees <63 HRC

Solid Carbide HPC endmill for finishing <63 HRC



AGRESSOR **HARD**

HPC

HRC
HARD



Code	Ød1	Ød2	l2	l3	l	z	r	€
D6560-0400BT	4,0	6,0	11	-	57	6	-	39,00
D6560-0405RBT	4,0	6,0	11	-	57	6	0,5	44,00
D6560-0500BT	5,0	6,0	13	18	57	6	-	39,00
D6560-0505RBT	5,0	6,0	13	18	57	6	0,5	44,00
D6560-0600BT	6,0	6,0	13	18	57	6	-	39,00
D6560-0605RBT	6,0	6,0	13	18	57	6	0,5	44,00
D6560-0800BT	8,0	8,0	21	25	64	6	-	53,00
D6560-0805RBT	8,0	8,0	21	25	64	6	0,5	60,00
D6560-0810RBT	8,0	8,0	21	25	64	6	1,0	60,00
D6560-1000BT	10,0	10,0	22	30	72	6	-	73,00
D6560-1005RBT	10,0	10,0	22	30	72	6	0,5	87,00
D6560-1010RBT	10,0	10,0	22	30	72	6	1,0	87,00
D6560-1200BT	12,0	12,0	26	36	83	6	-	96,00
D6560-1205RBT	12,0	12,0	26	36	83	6	0,5	110,00
D6560-1210RBT	12,0	12,0	26	36	83	6	1,0	110,00
D6560-1220RBT	12,0	12,0	26	36	83	6	2,0	110,00
D6560-1600BT	16,0	16,0	36	42	92	8	-	174,00
D6560-1605RBT	16,0	16,0	36	42	92	8	0,5	202,00
D6560-1610RBT	16,0	16,0	36	42	92	8	1,0	202,00
D6560-1620RBT	16,0	16,0	36	42	92	8	2,0	202,00
D6560-2000BT	20,0	20,0	41	52	104	8	-	247,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
H1.1 Hardened steel < 48 HRC	3.0	80	6	0.010	4.5	0.10
	4.0	80	6	0.015	6	0.11
	5.0	80	6	0.020	7.5	0.12
	6.0	80	6	0.025	9	0.13
	8.0	80	6	0.035	12	0.15
	10.0	80	6	0.040	15	0.15
	12.0	80	6	0.050	18	0.15
	16.0	80	8	0.070	24	0.20
	20.0	80	8	0.100	30	0.30
H1.2 Hardened steel < 52 HRC	3.0	75	6	0.010	4.5	0.10
	4.0	75	6	0.015	6	0.11
	5.0	75	6	0.020	7.5	0.12
	6.0	75	6	0.025	9	0.13
	8.0	75	6	0.035	12	0.15
	10.0	75	6	0.040	15	0.15
	12.0	75	6	0.050	18	0.15
	16.0	75	8	0.070	24	0.20
	20.0	75	8	0.100	30	0.30
H1.2 Hardened steel < 56 HRC	3.0	70	6	0.010	4.5	0.10
	4.0	70	6	0.015	6	0.11
	5.0	70	6	0.020	7.5	0.12
	6.0	70	6	0.025	9	0.13
	8.0	70	6	0.035	12	0.15
	10.0	70	6	0.040	15	0.15
	12.0	70	6	0.050	18	0.15
	16.0	70	8	0.070	24	0.20
	20.0	70	8	0.100	30	0.30
H1.3 Hardened steel < 60 HRC	3.0	60	6	0.010	4.5	0.10
	4.0	60	6	0.015	6	0.11
	5.0	60	6	0.020	7.5	0.12
	6.0	60	6	0.025	9	0.13
	8.0	60	6	0.035	12	0.15
	10.0	60	6	0.040	15	0.15
	12.0	60	6	0.050	18	0.15
	16.0	60	8	0.070	24	0.20
	20.0	60	8	0.100	30	0.30
H1.4 Hardened steel < 63 HRC	3.0	45	6	0.010	4.5	0.10
	4.0	45	6	0.015	6	0.11
	5.0	45	6	0.020	7.5	0.12
	6.0	45	6	0.025	9	0.13
	8.0	45	6	0.035	12	0.15
	10.0	45	6	0.040	15	0.15
	12.0	45	6	0.050	18	0.15
	16.0	45	8	0.070	24	0.20
	20.0	45	8	0.100	30	0.30

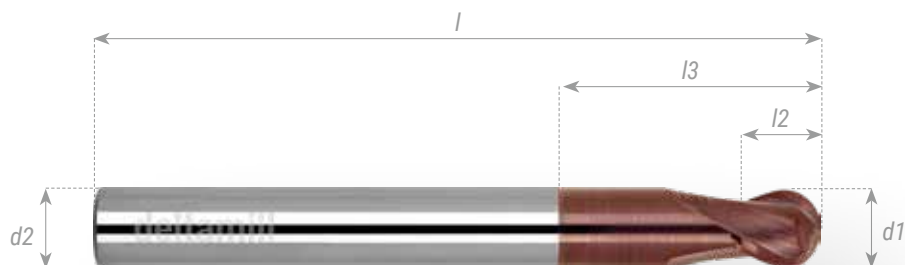


Finish $A_p < 1,5 \times D$



VHM HSC 3D Bolkop Frees <63 HRC

Solid Carbide HSC 3D Ball endmill <63 HRC



AGRESSOR HARD



Code	Ød1	Ød2	l2	l3	l	z	r	€
D2862-0300BT	3,0	6,0	3	9	51	2	1,5	69,00
D2862-0400BT	4,0	6,0	4	12	57	2	2,0	69,00
D2862-0500BT	5,0	6,0	5	15	57	2	2,5	69,00
D2862-0600BT	6,0	6,0	6	18	76	2	3,0	77,00
D2862-0800BT	8,0	8,0	8	24	76	2	4,0	108,00
D2862-1000BT	10,0	10,0	10	30	100	2	5,0	163,00
D2862-1200BT	12,0	12,0	12	36	100	2	6,0	167,00

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
H1.1	3.0	160	2	0.025	0.15	0.12
	4.0	160	2	0.035	0.20	0.16
	5.0	160	2	0.040	0.25	0.20
	6.0	160	2	0.050	0.30	0.24
	8.0	160	2	0.060	0.40	0.32
	10.0	160	2	0.065	0.50	0.40
	12.0	160	2	0.070	0.60	0.48
Hardened steel < 48 HRC						
H1.2	3.0	150	2	0.025	0.15	0.12
	4.0	150	2	0.035	0.20	0.16
	5.0	150	2	0.040	0.25	0.20
	6.0	150	2	0.050	0.30	0.24
	8.0	150	2	0.060	0.40	0.32
	10.0	150	2	0.065	0.50	0.40
	12.0	150	2	0.070	0.60	0.48
Hardened steel < 52 HRC						
H1.3	3.0	110	2	0.025	0.09	0.09
	4.0	110	2	0.035	0.12	0.12
	5.0	110	2	0.040	0.15	0.15
	6.0	110	2	0.050	0.18	0.18
	8.0	110	2	0.060	0.24	0.24
	10.0	110	2	0.065	0.30	0.30
	12.0	110	2	0.070	0.36	0.36
Hardened steel > 60 HRC						
H1.4	3.0	100	2	0.025	0.06	0.06
	4.0	100	2	0.035	0.08	0.08
	5.0	100	2	0.040	0.10	0.10
	6.0	100	2	0.050	0.12	0.12
	8.0	100	2	0.060	0.16	0.16
	10.0	100	2	0.065	0.20	0.20
	12.0	100	2	0.070	0.24	0.24
Hardened steel < 60 HRC						

Verspanings parameters *Cutting Data*

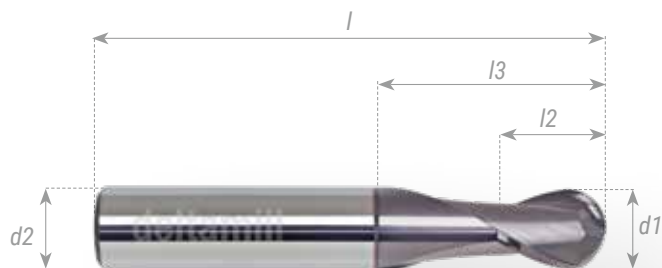


Finish $A_p < 1,5 \times D$



VHM Volradius frees

Solid carbide Fullradius endmill



UNILINE



Code	Ød1	Ød2	l2	l3	l	z	r	€
D2380-0100BT	1,0	6,0	4	8	54	2	0,5	32,00
D2380-0200BT	2,0	6,0	5	10	54	2	1,0	36,00
D2380-0300BT	3,0	6,0	5	15	54	2	1,5	36,00
D2380-0400BT	4,0	6,0	8	20	54	2	2,0	36,00
D2380-0500BT	5,0	6,0	9	20	54	2	2,5	36,00
D2380-0600BT	6,0	6,0	10	25	54	2	3,0	36,00
D2380-0800BT	8,0	8,0	12	25	58	2	4,0	44,00
D2380-1000BT	10,0	10,0	14	25	66	2	5,0	64,00
D2380-1200BT	12,0	12,0	16	30	73	2	6,0	90,00
D2380-1600BT	16,0	16,0	22	30	82	2	8,0	165,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm	d eff. mm
P1.1 Steel < 800N/mm²	1.0	180	2	0.005	0.03	0.06	0.34
	2.0	180	2	0.010	0.06	0.12	0.68
	3.0	180	2	0.015	0.09	0.18	1.02
	4.0	180	2	0.020	0.12	0.24	1.36
	5.0	180	2	0.025	0.15	0.30	1.71
	6.0	180	2	0.030	0.18	0.36	2.05
	8.0	180	2	0.040	0.24	0.48	2.73
	10.0	180	2	0.045	0.30	0.60	3.41
	12.0	180	2	0.050	0.36	0.72	4.09
P2.2 Heat Treatable steel < 1100N/mm²	1.0	120	2	0.004	0.03	0.06	0.34
	2.0	120	2	0.008	0.06	0.12	0.68
	3.0	120	2	0.012	0.09	0.18	1.02
	4.0	120	2	0.016	0.12	0.24	1.36
	5.0	120	2	0.020	0.15	0.30	1.71
	6.0	120	2	0.026	0.18	0.36	2.05
	8.0	120	2	0.030	0.24	0.48	2.73
	10.0	120	2	0.035	0.30	0.60	3.41
	12.0	120	2	0.040	0.36	0.72	4.09
P3.2 High Alloy steels < 1600N/mm²	1.0	100	2	0.004	0.03	0.06	0.34
	2.0	100	2	0.008	0.06	0.12	0.68
	3.0	100	2	0.012	0.09	0.18	1.02
	4.0	100	2	0.016	0.12	0.24	1.36
	5.0	100	2	0.020	0.15	0.30	1.71
	6.0	100	2	0.026	0.18	0.36	2.05
	8.0	100	2	0.030	0.24	0.48	2.73
	10.0	100	2	0.035	0.30	0.60	3.41
	12.0	100	2	0.040	0.36	0.72	4.09
M2.1 Stainless steel < 1600N/mm²	1.0	90	2	0.003	0.03	0.06	0.34
	2.0	90	2	0.005	0.06	0.12	0.68
	3.0	90	2	0.008	0.09	0.18	1.02
	4.0	90	2	0.010	0.12	0.24	1.36
	5.0	90	2	0.012	0.15	0.30	1.71
	6.0	90	2	0.016	0.18	0.36	2.05
	8.0	90	2	0.020	0.24	0.48	2.73
	10.0	90	2	0.025	0.30	0.60	3.41
	12.0	90	2	0.030	0.36	0.72	4.09
K1.2 Cast iron	1.0	200	2	0.010	0.03	0.06	0.34
	2.0	200	2	0.015	0.06	0.12	0.68
	3.0	200	2	0.020	0.09	0.18	1.02
	4.0	200	2	0.030	0.12	0.24	1.36
	5.0	200	2	0.035	0.15	0.30	1.71
	6.0	200	2	0.045	0.18	0.36	2.05
	8.0	200	2	0.055	0.24	0.48	2.73
	10.0	200	2	0.065	0.30	0.60	3.41
	12.0	200	2	0.070	0.36	0.72	4.09



Slotting Ap0,03xD
en Ae0,06xD

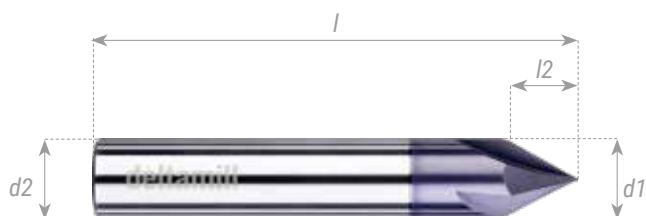


Contour Ap0,03xD
en Ae0,06xD



VHM 60° universeel afschuin frees

SC 60° universal chamfering endmill



UNILINE



Code	Ød1	Ød2	L2	L3	L	z	α	€
D4060-0600AT	6,0	6,0	3	-	57	4	60°	42,00
D4060-0800AT	8,0	8,0	4	-	60	4	60°	56,00
D4060-1000AT	10,0	10,0	5	-	70	4	60°	77,00
D4060-1200AT	12,0	12,0	6	-	70	4	60°	88,00
D4060-1600AT	16,0	16,0	8	-	80	4	60°	141,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	4.0	150	4	0.020	2	2
	6.0	150	4	0.030	3	3
	8.0	150	4	0.040	4	4
	10.0	150	4	0.050	5	5
	12.0	150	4	0.060	6	6
	16.0	150	4	0.080	8	8
P2.2 Heat Treatable steel < 1300N/mm²	4.0	120	4	0.020	2	2
	6.0	120	4	0.030	3	3
	8.0	120	4	0.040	4	4
	10.0	120	4	0.050	5	5
	12.0	120	4	0.060	6	6
	16.0	120	4	0.080	8	8
P3.2 High Alloy steels < 800N/mm²	4.0	80	4	0.020	2	2
	6.0	80	4	0.030	3	3
	8.0	80	4	0.040	4	4
	10.0	80	4	0.050	5	5
	12.0	80	4	0.060	6	6
	16.0	80	4	0.080	8	8
M2.1 Stainless steel < 1600N/mm²	4.0	40	4	0.010	2	2
	6.0	40	4	0.015	3	3
	8.0	40	4	0.018	4	4
	10.0	40	4	0.020	5	5
	12.0	40	4	0.025	6	6
	16.0	40	4	0.035	8	8
K1.2 Cast iron	4.0	150	4	0.015	2	2
	6.0	150	4	0.020	3	3
	8.0	150	4	0.025	4	4
	10.0	150	4	0.030	5	5
	12.0	150	4	0.035	6	6
	16.0	150	4	0.045	8	8



Contour $A_p < 0,5 \times D$
en $A_e < 0,5 \times D$



D4090

P-SERIE

VHM 90° afschuin frees

SC 90° chamfering endmill

**UNILINE**

Code	Ød1	Ød2	l2	l3	l	z	α	€
D4090-0400AT	4,0	4,0	2	-	50	4	90°	42,00
D4090-0600AT	6,0	6,0	3	-	60	4	90°	42,00
D4090-0800AT	8,0	8,0	4	-	60	4	90°	56,00
D4090-1000AT	10,0	10,0	5	-	70	4	90°	77,00
D4090-1200AT	12,0	12,0	6	-	70	4	90°	88,00
D4090-1600AT	16,0	16,0	8	-	80	4	90°	141,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	4.0	150	4	0.020	2	2
	6.0	150	4	0.030	3	3
	8.0	150	4	0.040	4	4
	10.0	150	4	0.050	5	5
	12.0	150	4	0.060	6	6
	16.0	150	4	0.080	8	8
P2.2 Heat Treatable steel < 1300N/mm²	4.0	120	4	0.020	2	2
	6.0	120	4	0.030	3	3
	8.0	120	4	0.040	4	4
	10.0	120	4	0.050	5	5
	12.0	120	4	0.060	6	6
	16.0	120	4	0.080	8	8
P3.2 High Alloy steels < 800N/mm²	4.0	80	4	0.020	2	2
	6.0	80	4	0.030	3	3
	8.0	80	4	0.040	4	4
	10.0	80	4	0.050	5	5
	12.0	80	4	0.060	6	6
	16.0	80	4	0.080	8	8
M2.1 Stainless steel < 1600N/mm²	4.0	40	4	0.010	2	2
	6.0	40	4	0.015	3	3
	8.0	40	4	0.018	4	4
	10.0	40	4	0.020	5	5
	12.0	40	4	0.025	6	6
	16.0	40	4	0.035	8	8
K1.2 Cast iron	4.0	150	4	0.015	2	2
	6.0	150	4	0.020	3	3
	8.0	150	4	0.025	4	4
	10.0	150	4	0.030	5	5
	12.0	150	4	0.035	6	6
	16.0	150	4	0.045	8	8



Contour $A_p < 0,5 \times D$
en $A_e < 0,5 \times D$



VHM 120° afschuin frees SC 120° chamfering endmill



UNILINE



Code	Ød1	Ød2	l2	l3	l	z	α	€
D4120-0800AT	8,0	8,0	4	-	60	4	120	56,00
D4120-1000AT	10,0	10,0	5	-	70	4	120	77,00
D4120-1200AT	12,0	12,0	6	-	70	4	120	88,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel ≤ 800N/mm²	4.0	150	4	0.020	2	2
	6.0	150	4	0.030	3	3
	8.0	150	4	0.040	4	4
	10.0	150	4	0.050	5	5
	12.0	150	4	0.060	6	6
	16.0	150	4	0.080	8	8
P2.2 Heat Treatable steel ≤ 1300N/mm²	4.0	120	4	0.020	2	2
	6.0	120	4	0.030	3	3
	8.0	120	4	0.040	4	4
	10.0	120	4	0.050	5	5
	12.0	120	4	0.060	6	6
	16.0	120	4	0.080	8	8
P3.2 High Alloy steels ≤ 800N/mm²	4.0	80	4	0.020	2	2
	6.0	80	4	0.030	3	3
	8.0	80	4	0.040	4	4
	10.0	80	4	0.050	5	5
	12.0	80	4	0.060	6	6
	16.0	80	4	0.080	8	8
M2.1 Stainless steel ≤ 1600N/mm²	4.0	40	4	0.010	2	2
	6.0	40	4	0.015	3	3
	8.0	40	4	0.018	4	4
	10.0	40	4	0.020	5	5
	12.0	40	4	0.025	6	6
	16.0	40	4	0.035	8	8
K1.2 Cast iron	4.0	150	4	0.015	2	2
	6.0	150	4	0.020	3	3
	8.0	150	4	0.025	4	4
	10.0	150	4	0.030	5	5
	12.0	150	4	0.035	6	6
	16.0	150	4	0.045	8	8



Contour $A_p < 0,5 \times D$
en $A_e < 0,5 \times D$



VHM Multi-V frees

Solid carbide Multi-V endmill



UNILINE



Code	Ød1	Ød2	l2	l3	l	z	α	€
D2090-0300AB	3,0	6,0	8	-	57	2	90	50,00
D2090-0400AB	4,0	6,0	12	-	57	2	90	50,00
D2090-0600AB	6,0	6,0	13	-	57	2	90	50,00
D2090-0800AB	8,0	8,0	19	-	63	2	90	66,00
D2090-1000AB	10,0	10,0	22	-	72	2	90	86,00
D2090-1200AB	12,0	12,0	26	-	83	2	90	106,00
D2090-1600AB	16,0	16,0	32	-	92	2	90	298,00

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	70	2	0.010	1,5	1,5
	4.0	70	2	0.015	2,0	2,0
	6.0	70	2	0.020	3,0	3,0
	8.0	70	2	0.025	4,0	4,0
	10.0	70	2	0.030	5,0	5,0
	12.0	70	2	0.035	6,0	6,0
	16.0	70	2	0.045	8,0	8,0
P2.2 Heat Treatable steel < 1100N/mm²	3.0	60	2	0.010	1,5	1,5
	4.0	60	2	0.015	2,0	2,0
	6.0	60	2	0.020	3,0	3,0
	8.0	60	2	0.025	4,0	4,0
	10.0	60	2	0.030	5,0	5,0
	12.0	60	2	0.035	6,0	6,0
	16.0	60	2	0.045	8,0	8,0
M2.1 Stainless steel < 1600N/mm²	3.0	40	2	0.008	1,5	1,5
	4.0	40	2	0.010	2,0	2,0
	6.0	40	2	0.015	3,0	3,0
	8.0	40	2	0.018	4,0	4,0
	10.0	40	2	0.020	5,0	5,0
	12.0	40	2	0.025	6,0	6,0
	16.0	40	2	0.035	8,0	8,0
N1.1 Aluminium wrought alloys	3.0	175	2	0.010	1,5	1,5
	4.0	175	2	0.020	2,0	2,0
	6.0	175	2	0.030	3,0	3,0
	8.0	175	2	0.040	4,0	4,0
	10.0	175	2	0.050	5,0	5,0
	12.0	175	2	0.060	6,0	6,0
	16.0	175	2	0.080	8,0	8,0
N1.4 Aluminium cast alloys 6-12% Si	3.0	175	2	0.010	1,5	1,5
	4.0	175	2	0.020	2,0	2,0
	6.0	175	2	0.030	3,0	3,0
	8.0	175	2	0.040	4,0	4,0
	10.0	175	2	0.050	5,0	5,0
	12.0	175	2	0.060	6,0	6,0
	16.0	175	2	0.080	8,0	8,0
K1.2 Cast iron	3.0	70	2	0.010	1,5	1,5
	4.0	70	2	0.015	2,0	2,0
	6.0	70	2	0.020	3,0	3,0
	8.0	70	2	0.025	4,0	4,0
	10.0	70	2	0.030	5,0	5,0
	12.0	70	2	0.035	6,0	6,0
	16.0	70	2	0.045	8,0	8,0



Contour $A_p < 0,5 \times D$
en $A_e < 0,5 \times D$



VHM Holradius frees

Solid Carbide Corner rounding endmill



UNILINE



Code	Ød1	Ød2	l2	l3	l	z	r	€
D4080-0805AT	8,0	8,0	-	-	70	4	0,5	80,00
D4080-0810AT	8,0	8,0	-	-	70	4	1,0	80,00
D4080-1015AT	10,0	10,0	-	-	75	4	1,5	106,00
D4080-1020AT	10,0	10,0	-	-	75	4	2,0	106,00
D4080-1225AT	12,0	12,0	-	-	75	4	2,5	128,00
D4080-1230AT	12,0	12,0	-	-	75	4	3,0	128,00
D4080-1240AT	12,0	12,0	-	-	75	4	4,0	128,00
D4080-1650AT	16,0	16,0	-	-	80	4	5,0	213,00

Verspanings parameters *Cutting Data*

Mat.	ØD	R	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm ²	8.0	0.5	150	4	0.030	0.5	0.5
	8.0	1.0	150	4	0.030	1.0	1.0
	10.0	1.5	150	4	0.040	1.5	1.5
	10.0	2.0	150	4	0.040	2.0	2.0
	12.0	3.0	150	4	0.050	3.0	3.0
	12.0	4.0	150	4	0.050	4.0	4.0
	16.0	5.0	150	4	0.080	5.0	5.0
P2.2 Heat Treatable steel < 1100N/mm ²	8.0	0.5	120	4	0.030	0.5	0.5
	8.0	1.0	120	4	0.030	1.0	1.0
	10.0	1.5	120	4	0.040	1.5	1.5
	10.0	2.0	120	4	0.040	2.0	2.0
	12.0	3.0	120	4	0.050	3.0	3.0
	12.0	4.0	120	4	0.050	4.0	4.0
	16.0	5.0	120	4	0.080	5.0	5.0
P3.2 High Alloy steels < 1600N/mm ²	8.0	0.5	80	4	0.030	0.5	0.5
	8.0	1.0	80	4	0.030	1.0	1.0
	10.0	1.5	80	4	0.040	1.5	1.5
	10.0	2.0	80	4	0.040	2.0	2.0
	12.0	3.0	80	4	0.050	3.0	3.0
	12.0	4.0	80	4	0.050	4.0	4.0
	16.0	5.0	80	4	0.080	5.0	5.0
M2.1 Stainless steel < 1600N/mm ²	8.0	0.5	40	4	0.030	0.5	0.5
	8.0	1.0	40	4	0.030	1.0	1.0
	10.0	1.5	40	4	0.040	1.5	1.5
	10.0	2.0	40	4	0.040	2.0	2.0
	12.0	3.0	40	4	0.050	3.0	3.0
	12.0	4.0	40	4	0.050	4.0	4.0
	16.0	5.0	40	4	0.080	5.0	5.0
K1.2 Cast iron	8.0	0.5	150	4	0.030	0.5	0.5
	8.0	1.0	150	4	0.030	1.0	1.0
	10.0	1.5	150	4	0.040	1.5	1.5
	10.0	2.0	150	4	0.040	2.0	2.0
	12.0	3.0	150	4	0.050	3.0	3.0
	12.0	4.0	150	4	0.050	4.0	4.0
	16.0	5.0	150	4	0.080	5.0	5.0



Contour Ap = max. r
en Ae = max. r



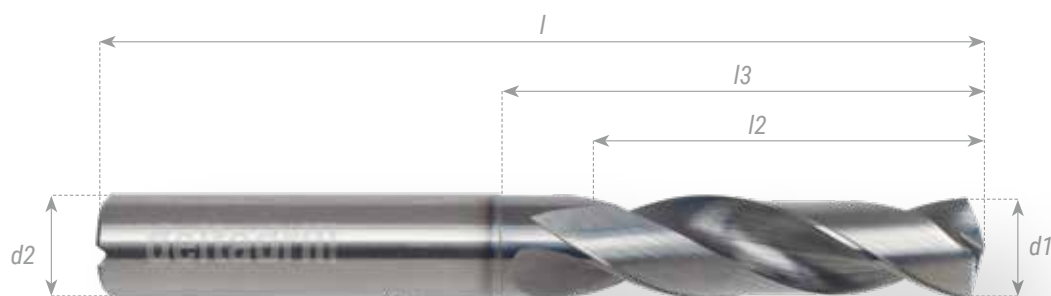


BOREN *DRILLS*

deltadrill
Drilling Technology

VHM Boren Staal 3xD

Solid carbide Drills Steel 3xD



SPEEDDRILL S2

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D20003-0300	3	6	62	20	14	31,36
D20003-0310	3,1	6	62	20	14	31,36
D20003-0320	3,2	6	62	20	14	31,36
D20003-0330	3,3	6	62	20	14	31,36
D20003-0340	3,4	6	62	20	14	31,36
D20003-0350	3,5	6	62	20	14	31,36
D20003-0360	3,6	6	62	20	14	31,36
D20003-0370	3,7	6	62	20	14	31,36
D20003-0380	3,8	6	66	24	17	31,36
D20003-0390	3,9	6	66	24	17	31,36
D20003-0400	4	6	66	24	17	31,36
D20003-0410	4,1	6	66	24	17	31,36
D20003-0420	4,2	6	66	24	17	31,36
D20003-0430	4,3	6	66	24	17	31,36
D20003-0440	4,4	6	66	24	17	31,36
D20003-0450	4,5	6	66	24	17	31,36
D20003-0460	4,6	6	66	24	17	31,36
D20003-0465	4,65	6	66	24	17	31,36
D20003-0470	4,7	6	66	24	17	31,36
D20003-0480	4,8	6	66	28	20	31,36
D20003-0490	4,9	6	66	28	20	31,36
D20003-0500	5	6	66	28	20	31,36
D20003-0510	5,1	6	66	28	20	31,36
D20003-0520	5,2	6	66	28	20	31,36
D20003-0530	5,3	6	66	28	20	31,36
D20003-0540	5,4	6	66	28	20	31,36
D20003-0550	5,5	6	66	28	20	31,36
D20003-0555	5,55	6	66	28	20	31,36
D20003-0560	5,6	6	66	28	20	31,36
D20003-0570	5,7	6	66	28	20	31,36
D20003-0580	5,8	6	66	28	20	31,36

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D20003-0590	5,9	6	66	28	20	31,36
D20003-0600	6	6	66	28	20	31,36
D20003-0610	6,1	8	79	34	24	40,32
D20003-0620	6,2	8	79	34	24	40,32
D20003-0630	6,3	8	79	34	24	40,32
D20003-0640	6,4	8	79	34	24	40,32
D20003-0650	6,5	8	79	34	24	40,32
D20003-0660	6,6	8	79	34	24	40,32
D20003-0670	6,7	8	79	34	24	40,32
D20003-0680	6,8	8	79	34	24	40,32
D20003-0690	6,9	8	79	34	24	40,32
D20003-0700	7	8	79	34	24	40,32
D20003-0710	7,1	8	79	41	29	40,32
D20003-0720	7,2	8	79	41	29	40,32
D20003-0730	7,3	8	79	41	29	40,32
D20003-0740	7,4	8	79	41	29	40,32
D20003-0750	7,5	8	79	41	29	40,32
D20003-0760	7,6	8	79	41	29	40,32
D20003-0770	7,7	8	79	41	29	40,32
D20003-0780	7,8	8	79	41	29	40,32
D20003-0790	7,9	8	79	41	29	40,32
D20003-0800	8	8	79	41	29	40,32
D20003-0810	8,1	10	89	47	35	53,76
D20003-0820	8,2	10	89	47	35	53,76
D20003-0830	8,3	10	89	47	35	53,76
D20003-0840	8,4	10	89	47	35	53,76
D20003-0850	8,5	10	89	47	35	53,76
D20003-0860	8,6	10	89	47	35	53,76
D20003-0870	8,7	10	89	47	35	53,76
D20003-0880	8,8	10	89	47	35	53,76
D20003-0890	8,9	10	89	47	35	53,76

Boorpunt - Drill point



Materiaal - Material



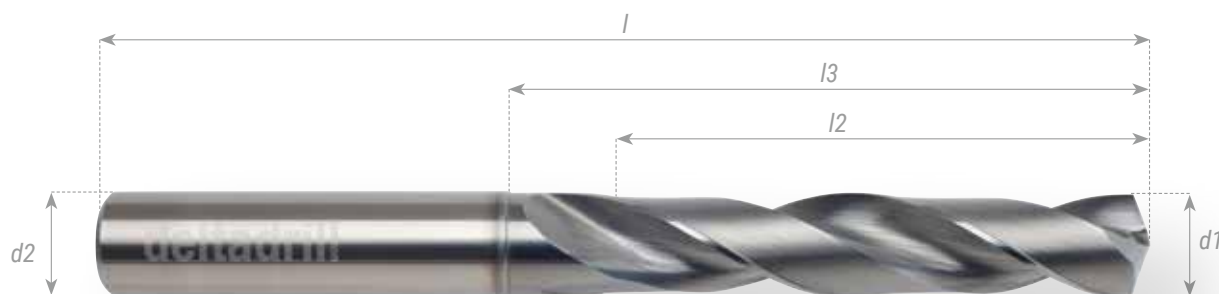
Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	Kegelmantel/releived cone
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Buiten / external
Schacht/shaft	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D20003-0900	9	10	89	47	35	53,76
D20003-0910	9,1	10	89	47	35	53,76
D20003-0920	9,2	10	89	47	35	53,76
D20003-0925	9,25	10	89	47	35	53,76
D20003-0930	9,3	10	89	47	35	53,76
D20003-0940	9,4	10	89	47	35	53,76
D20003-0950	9,5	10	89	47	35	53,76
D20003-0960	9,6	10	89	47	35	53,76
D20003-0970	9,7	10	89	47	35	53,76
D20003-0980	9,8	10	89	47	35	53,76
D20003-0990	9,9	10	89	47	35	53,76
D20003-1000	10	10	89	47	35	53,76
D20003-1020	10,2	12	102	55	40	75,04
D20003-1050	10,5	12	102	55	40	75,04
D20003-1080	10,8	12	102	55	40	75,04
D20003-1100	11	12	102	55	40	75,04
D20003-1150	11,5	12	102	55	40	75,04
D20003-1180	11,8	12	102	55	40	75,04
D20003-1200	12	12	102	55	40	75,04
D20003-1250	12,5	14	107	60	43	94,08
D20003-1280	12,8	14	107	60	43	94,08
D20003-1300	13	14	107	60	43	94,08
D20003-1350	13,5	14	107	60	43	94,08
D20003-1380	13,8	14	107	60	43	94,08
D20003-1400	14	14	107	60	43	94,08
D20003-1450	14,5	16	115	65	45	127,68
D20003-1480	14,8	16	115	65	45	127,68
D20003-1500	15	16	115	65	45	127,68
D20003-1550	15,5	16	115	65	45	127,68
D20003-1580	15,8	16	115	65	45	127,68
D20003-1600	16	16	115	65	45	127,68

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D20003-1650	16,5	18	123	73	51	192,64
D20003-1680	16,8	18	123	73	51	192,64
D20003-1700	17	18	123	73	51	192,64
D20003-1750	17,5	18	123	73	51	192,64
D20003-1780	17,8	18	123	73	51	192,64
D20003-1800	18	18	123	73	51	192,64
D20003-1850	18,5	20	131	79	55	209,44
D20003-1880	18,8	20	131	79	55	209,44
D20003-1900	19	20	131	79	55	209,44
D20003-1950	19,5	20	131	79	55	209,44
D20003-1980	19,8	20	131	79	55	209,44
D20003-2000	20	20	131	79	55	209,44

VHM Boren Staal 5xD

Solid carbide Drills Steel 5xD



SPEEDDRILL S2

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D20005-0300	3,0	6	66	28	23	38,08
D20005-0310	3,1	6	66	28	23	38,08
D20005-0320	3,2	6	66	28	23	38,08
D20005-0330	3,3	6	66	28	23	38,08
D20005-0340	3,4	6	66	28	23	38,08
D20005-0350	3,5	6	66	28	23	38,08
D20005-0360	3,6	6	66	28	23	38,08
D20005-0370	3,7	6	66	28	23	38,08
D20005-0380	3,8	6	74	36	29	38,08
D20005-0390	3,9	6	74	36	29	38,08
D20005-0400	4,0	6	74	36	29	38,08
D20005-0410	4,1	6	74	36	29	38,08
D20005-0420	4,2	6	74	36	29	38,08
D20005-0430	4,3	6	74	36	29	38,08
D20005-0440	4,4	6	74	36	29	38,08
D20005-0450	4,5	6	74	36	29	38,08
D20005-0460	4,6	6	74	36	29	38,08
D20005-0470	4,7	6	74	36	29	38,08
D20005-0480	4,8	6	82	44	35	38,08
D20005-0490	4,9	6	82	44	35	38,08
D20005-0500	5,0	6	82	44	35	38,08
D20005-0510	5,1	6	82	44	35	38,08
D20005-0520	5,2	6	82	44	35	38,08
D20005-0530	5,3	6	82	44	35	38,08
D20005-0540	5,4	6	82	44	35	38,08
D20005-0550	5,5	6	82	44	35	38,08
D20005-0560	5,6	6	82	44	35	38,08
D20005-0570	5,7	6	82	44	35	38,08
D20005-0580	5,8	6	82	44	35	38,08
D20005-0590	5,9	6	82	44	35	38,08
D20005-0600	6,0	6	82	44	35	38,08

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D20005-0610	6,1	8	91	53	43	45,92
D20005-0620	6,2	8	91	53	43	45,92
D20005-0630	6,3	8	91	53	43	45,92
D20005-0640	6,4	8	91	53	43	45,92
D20005-0650	6,5	8	91	53	43	45,92
D20005-0660	6,6	8	91	53	43	45,92
D20005-0670	6,7	8	91	53	43	45,92
D20005-0680	6,8	8	91	53	43	45,92
D20005-0690	6,9	8	91	53	43	45,92
D20005-0700	7,0	8	91	53	43	45,92
D20005-0710	7,1	8	91	53	43	45,92
D20005-0720	7,2	8	91	53	43	45,92
D20005-0730	7,3	8	91	53	43	45,92
D20005-0740	7,4	8	91	53	43	45,92
D20005-0750	7,5	8	91	53	43	45,92
D20005-0760	7,6	8	91	53	43	45,92
D20005-0770	7,7	8	91	53	43	45,92
D20005-0780	7,8	8	91	53	43	45,92
D20005-0790	7,9	8	91	53	43	45,92
D20005-0800	8,0	8	91	53	43	45,92
D20005-0810	8,1	10	103	61	49	56,00
D20005-0820	8,2	10	103	61	49	56,00
D20005-0830	8,3	10	103	61	49	56,00
D20005-0840	8,4	10	103	61	49	56,00
D20005-0850	8,5	10	103	61	49	56,00
D20005-0860	8,6	10	103	61	49	56,00
D20005-0870	8,7	10	103	61	49	56,00
D20005-0880	8,8	10	103	61	49	56,00
D20005-0890	8,9	10	103	61	49	56,00
D20005-0900	9,0	10	103	61	49	56,00
D20005-0910	9,1	10	103	61	49	56,00

Boorpunt - Drill point



Materiaal - Material



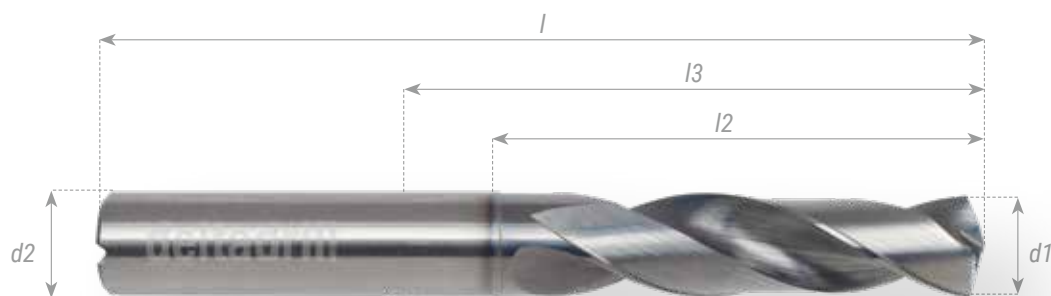
Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	Kegelmantel/releived cone
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Buiten / external
Schacht/shaft	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D20005-0920	9,2	10	103	61	49	56,00
D20005-0930	9,3	10	103	61	49	56,00
D20005-0940	9,4	10	103	61	49	56,00
D20005-0950	9,5	10	103	61	49	56,00
D20005-0960	9,6	10	103	61	49	56,00
D20005-0970	9,7	10	103	61	49	56,00
D20005-0980	9,8	10	103	61	49	56,00
D20005-0990	9,9	10	103	61	49	56,00
D20005-1000	10,0	10	103	61	49	56,00
D20005-1020	10,2	12	118	71	56	80,64
D20005-1050	10,5	12	118	71	56	80,64
D20005-1080	10,8	12	118	71	56	80,64
D20005-1100	11,0	12	118	71	56	80,64
D20005-1150	11,5	12	118	71	56	80,64
D20005-1180	11,8	12	118	71	56	80,64
D20005-1200	12,0	12	118	71	56	80,64
D20005-1250	12,5	14	124	77	60	104,16
D20005-1280	12,8	14	124	77	60	104,16
D20005-1300	13,0	14	124	77	60	104,16
D20005-1350	13,5	14	124	77	60	104,16
D20005-1380	13,8	14	124	77	60	104,16
D20005-1400	14,0	14	124	77	60	104,16
D20005-1450	14,5	16	133	83	63	142,24
D20005-1480	14,8	16	133	83	63	142,24
D20005-1500	15,0	16	133	83	63	142,24
D20005-1550	15,5	16	133	83	63	142,24
D20005-1580	15,8	16	133	83	63	142,24
D20005-1600	16,0	16	133	83	63	142,24
D20005-1650	16,5	18	143	93	71	211,68
D20005-1680	16,8	18	143	93	71	211,68
D20005-1700	17,0	18	143	93	71	211,68

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D20005-1750	17,5	18	143	93	71	211,68
D20005-1780	17,8	18	143	93	71	211,68
D20005-1800	18,0	18	143	93	71	211,68
D20005-1850	18,5	20	153	101	77	243,04
D20005-1880	18,8	20	153	101	77	243,04
D20005-1900	19,0	20	153	101	77	243,04
D20005-1950	19,5	20	153	101	77	243,04
D20005-1980	19,8	20	153	101	77	243,04
D20005-2000	20,0	20	153	101	77	243,04

VHM Boren Staal 3xD

Solid carbide Drills Steel 3xD



SPEEDDRILL S2

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21003-0300	3	6	62	20	14	43,68
D21003-0310	3,1	6	62	20	14	43,68
D21003-0320	3,2	6	62	20	14	43,68
D21003-0330	3,3	6	62	20	14	43,68
D21003-0340	3,4	6	62	20	14	43,68
D21003-0350	3,5	6	62	20	14	43,68
D21003-0360	3,6	6	62	20	14	43,68
D21003-0370	3,7	6	62	20	14	43,68
D21003-0380	3,8	6	66	24	17	43,68
D21003-0390	3,9	6	66	24	17	43,68
D21003-0400	4	6	66	24	17	43,68
D21003-0410	4,1	6	66	24	17	43,68
D21003-0420	4,2	6	66	24	17	43,68
D21003-0430	4,3	6	66	24	17	43,68
D21003-0440	4,4	6	66	24	17	43,68
D21003-0450	4,5	6	66	24	17	43,68
D21003-0460	4,6	6	66	24	17	43,68
D21003-0470	4,7	6	66	24	17	43,68
D21003-0480	4,8	6	66	28	20	43,68
D21003-0490	4,9	6	66	28	20	43,68
D21003-0500	5	6	66	28	20	43,68
D21003-0510	5,1	6	66	28	20	43,68
D21003-0520	5,2	6	66	28	20	43,68
D21003-0530	5,3	6	66	28	20	43,68
D21003-0540	5,4	6	66	28	20	43,68
D21003-0550	5,5	6	66	28	20	43,68
D21003-0560	5,6	6	66	28	20	43,68
D21003-0570	5,7	6	66	28	20	43,68
D21003-0580	5,8	6	66	28	20	43,68
D21003-0590	5,9	6	66	28	20	43,68
D21003-0600	6	6	66	28	20	43,68

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21003-0610	6,1	8	79	34	24	53,76
D21003-0620	6,2	8	79	34	24	53,76
D21003-0630	6,3	8	79	34	24	53,76
D21003-0640	6,4	8	79	34	24	53,76
D21003-0650	6,5	8	79	34	24	53,76
D21003-0660	6,6	8	79	34	24	53,76
D21003-0670	6,7	8	79	34	24	53,76
D21003-0680	6,8	8	79	34	24	53,76
D21003-0690	6,9	8	79	34	24	53,76
D21003-0700	7	8	79	34	24	53,76
D21003-0710	7,1	8	79	41	29	53,76
D21003-0720	7,2	8	79	41	29	53,76
D21003-0730	7,3	8	79	41	29	53,76
D21003-0740	7,4	8	79	41	29	53,76
D21003-0750	7,5	8	79	41	29	53,76
D21003-0760	7,6	8	79	41	29	53,76
D21003-0770	7,7	8	79	41	29	53,76
D21003-0780	7,8	8	79	41	29	53,76
D21003-0790	7,9	8	79	41	29	53,76
D21003-0800	8	8	79	41	29	53,76
D21003-0810	8,1	10	89	47	35	70,56
D21003-0820	8,2	10	89	47	35	70,56
D21003-0830	8,3	10	89	47	35	70,56
D21003-0840	8,4	10	89	47	35	70,56
D21003-0850	8,5	10	89	47	35	70,56
D21003-0860	8,6	10	89	47	35	70,56
D21003-0870	8,7	10	89	47	35	70,56
D21003-0880	8,8	10	89	47	35	70,56
D21003-0890	8,9	10	89	47	35	70,56
D21003-0900	9	10	89	47	35	70,56
D21003-0910	9,1	10	89	47	35	70,56

Boorpunt - Drill point



Materiaal - Material



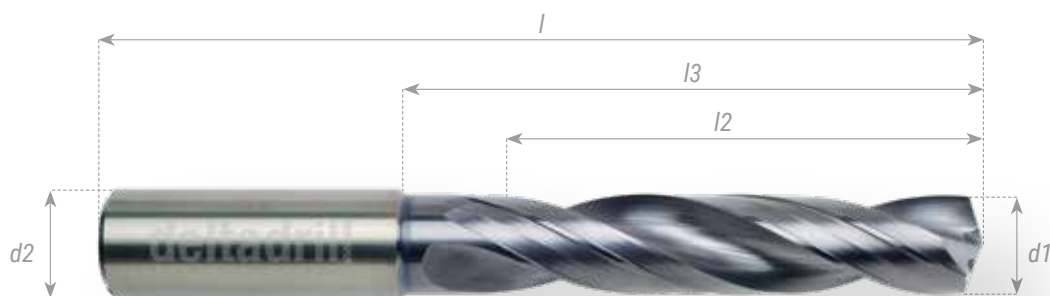
Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	Kegelmantel/releived cone
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Inwendig/internal
Schacht/shaft	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21003-0920	9,2	10	89	47	35	70,56
D21003-0930	9,3	10	89	47	35	70,56
D21003-0940	9,4	10	89	47	35	70,56
D21003-0950	9,5	10	89	47	35	70,56
D21003-0960	9,6	10	89	47	35	70,56
D21003-0970	9,7	10	89	47	35	70,56
D21003-0980	9,8	10	89	47	35	70,56
D21003-0990	9,9	10	89	47	35	70,56
D21003-1000	10	10	89	47	35	70,56
D21003-1020	10,2	12	102	55	40	94,08
D21003-1030	10,3	12	102	55	40	94,08
D21003-1050	10,5	12	102	55	40	94,08
D21003-1080	10,8	12	102	55	40	94,08
D21003-1100	11	12	102	55	40	94,08
D21003-1120	11,2	12	102	55	40	94,08
D21003-1140	11,4	12	102	55	40	94,08
D21003-1150	11,5	12	102	55	40	94,08
D21003-1170	11,7	12	102	55	40	94,08
D21003-1180	11,8	12	102	55	40	94,08
D21003-1200	12	12	102	55	40	94,08
D21003-1210	12,1	12	102	55	40	94,08
D21003-1220	12,2	12	102	55	40	94,08
D21003-1250	12,5	14	107	60	43	137,76
D21003-1280	12,8	14	107	60	43	137,76
D21003-1290	12,9	14	107	60	43	137,76
D21003-1300	13	14	107	60	43	137,76
D21003-1310	13,1	14	107	60	43	137,76
D21003-1320	13,2	14	107	60	43	137,76
D21003-1330	13,3	14	107	60	43	137,76
D21003-1350	13,5	14	107	60	43	137,76
D21003-1360	13,6	14	107	60	43	137,76

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21003-1380	13,8	14	107	60	43	137,76
D21003-1400	14	14	107	60	43	137,76
D21003-1450	14,5	16	115	65	45	171,36
D21003-1480	14,8	16	115	65	45	171,36
D21003-1500	15	16	115	65	45	171,36
D21003-1520	15,2	16	115	65	45	171,36
D21003-1530	15,3	16	115	65	45	171,36
D21003-1550	15,5	16	115	65	45	171,36
D21003-1580	15,8	16	115	65	45	171,36
D21003-1600	16	16	115	65	45	171,36
D21003-1650	16,5	18	123	73	51	241,92
D21003-1680	16,8	18	123	73	51	241,92
D21003-1700	17	18	123	73	51	241,92
D21003-1705	17,05	18	123	73	51	241,92
D21003-1730	17,3	18	123	73	51	241,92
D21003-1750	17,5	18	123	73	51	241,92
D21003-1755	17,55	18	123	73	51	241,92
D21003-1780	17,8	18	123	73	51	241,92
D21003-1800	18	18	123	73	51	241,92
D21003-1830	18,3	20	131	79	55	278,88
D21003-1850	18,5	20	131	79	55	278,88
D21003-1880	18,8	20	131	79	55	278,88
D21003-1900	19	20	131	79	55	278,88
D21003-1930	19,3	20	131	79	55	278,88
D21003-1950	19,5	20	131	79	55	278,88
D21003-1980	19,8	20	131	79	55	278,88
D21003-2000	20	20	131	79	55	278,88

VHM Boren Staal 5xD

Solid carbide Drills Steel 5xD



SPEEDDRILL S4

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21705-0300	3	6	66	28	23	60,48
D21705-0310	3,1	6	66	28	23	60,48
D21705-0320	3,2	6	66	28	23	60,48
D21705-0330	3,3	6	66	28	23	60,48
D21705-0340	3,4	6	66	28	23	60,48
D21705-0350	3,5	6	66	28	23	60,48
D21705-0360	3,6	6	66	28	23	60,48
D21705-0370	3,7	6	66	28	23	60,48
D21705-0380	3,8	6	74	36	29	60,48
D21705-0390	3,9	6	74	36	29	60,48
D21705-0400	4	6	74	36	29	60,48
D21705-0410	4,1	6	74	36	29	60,48
D21705-0420	4,2	6	74	36	29	60,48
D21705-0430	4,3	6	74	36	29	60,48
D21705-0440	4,4	6	74	36	29	60,48
D21705-0450	4,5	6	74	36	29	60,48
D21705-0460	4,6	6	74	36	29	60,48
D21705-0470	4,7	6	74	36	29	60,48
D21705-0480	4,8	6	82	44	35	60,48
D21705-0490	4,9	6	82	44	35	60,48
D21705-0500	5	6	82	44	35	60,48
D21705-0510	5,1	6	82	44	35	60,48
D21705-0520	5,2	6	82	44	35	60,48
D21705-0530	5,3	6	82	44	35	60,48
D21705-0540	5,4	6	82	44	35	60,48
D21705-0550	5,5	6	82	44	35	60,48
D21705-0560	5,6	6	82	44	35	60,48
D21705-0570	5,7	6	82	44	35	60,48
D21705-0580	5,8	6	82	44	35	60,48
D21705-0590	5,9	6	82	44	35	60,48
D21705-0600	6	6	82	44	35	60,48

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21705-0610	6,1	8	91	53	43	68,32
D21705-0620	6,2	8	91	53	43	68,32
D21705-0630	6,3	8	91	53	43	68,32
D21705-0640	6,4	8	91	53	43	68,32
D21705-0650	6,5	8	91	53	43	68,32
D21705-0660	6,6	8	91	53	43	68,32
D21705-0670	6,7	8	91	53	43	68,32
D21705-0680	6,8	8	91	53	43	68,32
D21705-0690	6,9	8	91	53	43	68,32
D21705-0700	7	8	91	53	43	68,32
D21705-0710	7,1	8	91	53	43	68,32
D21705-0720	7,2	8	91	53	43	68,32
D21705-0730	7,3	8	91	53	43	68,32
D21705-0740	7,4	8	91	53	43	68,32
D21705-0750	7,5	8	91	53	43	68,32
D21705-0760	7,6	8	91	53	43	68,32
D21705-0770	7,7	8	91	53	43	68,32
D21705-0780	7,8	8	91	53	43	68,32
D21705-0790	7,9	8	91	53	43	68,32
D21705-0800	8	8	91	53	43	68,32
D21705-0810	8,1	10	103	61	49	81,76
D21705-0820	8,2	10	103	61	49	81,76
D21705-0830	8,3	10	103	61	49	81,76
D21705-0840	8,4	10	103	61	49	81,76
D21705-0850	8,5	10	103	61	49	81,76
D21705-0860	8,6	10	103	61	49	81,76
D21705-0870	8,7	10	103	61	49	81,76
D21705-0880	8,8	10	103	61	49	81,76
D21705-0890	8,9	10	103	61	49	81,76
D21705-0900	9	10	103	61	49	81,76
D21705-0910	9,1	10	103	61	49	81,76

Boorpunt - Drill point



Materiaal - Material



Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	Kegelmantel/releived cone
Geleidefasen/Guide lands	4
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Inwendig/internal
Schacht/shaft	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21705-0920	9,2	10	103	61	49	81,76
D21705-0930	9,3	10	103	61	49	81,76
D21705-0940	9,4	10	103	61	49	81,76
D21705-0950	9,5	10	103	61	49	81,76
D21705-0960	9,6	10	103	61	49	81,76
D21705-0970	9,7	10	103	61	49	81,76
D21705-0980	9,8	10	103	61	49	81,76
D21705-0990	9,9	10	103	61	49	81,76
D21705-1000	10	10	103	61	49	81,76
D21705-1020	10,2	12	118	71	56	119,84
D21705-1050	10,5	12	118	71	56	119,84
D21705-1080	10,8	12	118	71	56	119,84
D21705-1100	11	12	118	71	56	119,84
D21705-1150	11,5	12	118	71	56	119,84
D21705-1180	11,8	12	118	71	56	119,84
D21705-1200	12	12	118	71	56	119,84
D21705-1250	12,5	14	124	77	60	159,04
D21705-1280	12,8	14	124	77	60	159,04
D21705-1300	13	14	124	77	60	159,04
D21705-1350	13,5	14	124	77	60	159,04
D21705-1380	13,8	14	124	77	60	159,04
D21705-1400	14	14	124	77	60	159,04
D21705-1450	14,5	16	133	83	63	192,64
D21705-1480	14,8	16	133	83	63	192,64
D21705-1500	15	16	133	83	63	192,64
D21705-1550	15,5	16	133	83	63	192,64
D21705-1580	15,8	16	133	83	63	192,64
D21705-1600	16	16	133	83	63	192,64
D21705-1650	16,5	18	143	93	71	259,84
D21705-1680	16,8	18	143	93	71	259,84
D21705-1700	17	18	143	93	71	259,84

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21705-1750	17,5	18	143	93	71	259,84
D21705-1780	17,8	18	143	93	71	259,84
D21705-1800	18	18	143	93	71	259,84
D21705-1850	18,5	20	153	101	77	327,04
D21705-1880	18,8	20	153	101	77	327,04
D21705-1900	19	20	153	101	77	327,04
D21705-1950	19,5	20	153	101	77	327,04
D21705-1980	19,8	20	153	101	77	327,04
D21705-2000	20	20	153	101	77	327,04

VHM Boren Staal 8xD

Solid carbide Drills Steel 8xD



SPEEDDRILL S4

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21708-0300	3	6	72	34	29	82,88
D21708-0310	3,1	6	72	34	29	82,88
D21708-0320	3,2	6	72	34	29	82,88
D21708-0330	3,3	6	72	34	29	82,88
D21708-0340	3,4	6	72	34	29	82,88
D21708-0350	3,5	6	72	34	29	82,88
D21708-0360	3,6	6	72	34	29	82,88
D21708-0370	3,7	6	72	34	29	82,88
D21708-0380	3,8	6	81	43	36	82,88
D21708-0390	3,9	6	81	43	36	82,88
D21708-0400	4	6	81	43	36	82,88
D21708-0410	4,1	6	81	43	36	82,88
D21708-0420	4,2	6	81	43	36	82,88
D21708-0430	4,3	6	81	43	36	82,88
D21708-0440	4,4	6	81	43	36	82,88
D21708-0450	4,5	6	81	43	36	82,88
D21708-0460	4,6	6	81	43	36	82,88
D21708-0470	4,7	6	81	43	36	82,88
D21708-0480	4,8	6	95	57	48	82,88
D21708-0490	4,9	6	95	57	48	82,88
D21708-0500	5	6	95	57	48	82,88
D21708-0510	5,1	6	95	57	48	82,88
D21708-0520	5,2	6	95	57	48	82,88
D21708-0530	5,3	6	95	57	48	82,88
D21708-0540	5,4	6	95	57	48	82,88
D21708-0550	5,5	6	95	57	48	82,88
D21708-0560	5,6	6	95	57	48	82,88
D21708-0570	5,7	6	95	57	48	82,88
D21708-0580	5,8	6	95	57	48	82,88
D21708-0590	5,9	6	95	57	48	82,88
D21708-0600	6	6	95	57	48	82,88

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21708-0610	6,1	8	114	76	64	112,00
D21708-0620	6,2	8	114	76	64	112,00
D21708-0630	6,3	8	114	76	64	112,00
D21708-0640	6,4	8	114	76	64	112,00
D21708-0650	6,5	8	114	76	64	112,00
D21708-0660	6,6	8	114	76	64	112,00
D21708-0670	6,7	8	114	76	64	112,00
D21708-0680	6,8	8	114	76	64	112,00
D21708-0690	6,9	8	114	76	64	112,00
D21708-0700	7	8	114	76	64	112,00
D21708-0710	7,1	8	114	76	64	112,00
D21708-0720	7,2	8	114	76	64	112,00
D21708-0730	7,3	8	114	76	64	112,00
D21708-0740	7,4	8	114	76	64	112,00
D21708-0750	7,5	8	114	76	64	112,00
D21708-0760	7,6	8	114	76	64	112,00
D21708-0770	7,7	8	114	76	64	112,00
D21708-0780	7,8	8	114	76	64	112,00
D21708-0790	7,9	8	114	76	64	112,00
D21708-0800	8	8	114	76	64	112,00
D21708-0810	8,1	10	142	95	80	155,68
D21708-0820	8,2	10	142	95	80	155,68
D21708-0830	8,3	10	142	95	80	155,68
D21708-0840	8,4	10	142	95	80	155,68
D21708-0850	8,5	10	142	95	80	155,68
D21708-0860	8,6	10	142	95	80	155,68
D21708-0870	8,7	10	142	95	80	155,68
D21708-0880	8,8	10	142	95	80	155,68
D21708-0890	8,9	10	142	95	80	155,68
D21708-0900	9	10	142	95	80	155,68
D21708-0910	9,1	10	142	95	80	155,68

Boorpunt - Drill point



Materiaal - Material



Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	Kegelmantel/releived cone
Geleidefasen/Guide lands	4
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Inwendig/internal
Schacht/shaft	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21708-0920	9,2	10	142	95	80	155,68
D21708-0930	9,3	10	142	95	80	155,68
D21708-0940	9,4	10	142	95	80	155,68
D21708-0950	9,5	10	142	95	80	155,68
D21708-0960	9,6	10	142	95	80	155,68
D21708-0970	9,7	10	142	95	80	155,68
D21708-0980	9,8	10	142	95	80	155,68
D21708-0990	9,9	10	142	95	80	155,68
D21708-1000	10	10	142	95	80	155,68
D21708-1020	10,2	12	162	114	96	198,24
D21708-1050	10,5	12	162	114	96	198,24
D21708-1080	10,8	12	162	114	96	198,24
D21708-1100	11	12	162	114	96	198,24
D21708-1150	11,5	12	162	114	96	198,24
D21708-1180	11,8	12	162	114	96	198,24
D21708-1200	12	12	162	114	96	198,24
D21708-1250	12,5	14	178	133	112	249,76
D21708-1280	12,8	14	178	133	112	249,76
D21708-1300	13	14	178	133	112	249,76
D21708-1350	13,5	14	178	133	112	249,76
D21708-1380	13,8	14	178	133	112	249,76
D21708-1400	14	14	178	133	112	249,76
D21708-1450	14,5	16	203	152	128	331,52
D21708-1480	14,8	16	203	152	128	331,52
D21708-1500	15	16	203	152	128	331,52
D21708-1550	15,5	16	203	152	128	331,52
D21708-1580	15,8	16	203	152	128	331,52
D21708-1600	16	16	203	152	128	331,52
D21708-1650	16,5	18	222	171	144	460,32
D21708-1680	16,8	18	222	171	144	460,32
D21708-1700	17	18	222	171	144	460,32

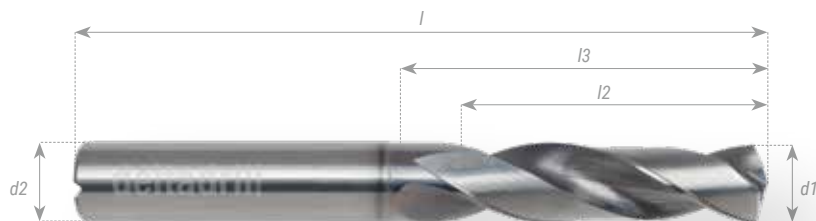
Art. nr.	Ød1	Ød2	l1	l3	l2	€
D21708-1750	17,5	18	222	171	144	460,32
D21708-1780	17,8	18	222	171	144	460,32
D21708-1800	18	18	222	171	144	460,32
D21708-1850	18,5	20	243	190	160	574,56
D21708-1880	18,8	20	243	190	160	574,56
D21708-1900	19	20	243	190	160	574,56
D21708-1950	19,5	20	243	190	160	574,56
D21708-1980	19,8	20	243	190	160	574,56
D21708-2000	20	20	243	190	160	574,56

VHM Boren universeel 3xD

Solid carbide Drills universal 3xD

De universeelboor voor alle materialen, zeer geschikt voor INOX.

The universal drill voor all materials, the best choice for INOX.



SPEEDDRILL U2

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18003-0300	3	6	62	20	14	43,68
D18003-0310	3,1	6	62	20	14	43,68
D18003-0320	3,2	6	62	20	14	43,68
D18003-0330	3,3	6	62	20	14	43,68
D18003-0340	3,4	6	62	20	14	43,68
D18003-0350	3,5	6	62	20	14	43,68
D18003-0360	3,6	6	62	20	14	43,68
D18003-0370	3,7	6	62	20	14	43,68
D18003-0380	3,8	6	66	24	17	43,68
D18003-0390	3,9	6	66	24	17	43,68
D18003-0400	4	6	66	24	17	43,68
D18003-0410	4,1	6	66	24	17	43,68
D18003-0420	4,2	6	66	24	17	43,68
D18003-0430	4,3	6	66	24	17	43,68
D18003-0440	4,4	6	66	24	17	43,68
D18003-0450	4,5	6	66	24	17	43,68
D18003-0460	4,6	6	66	24	17	43,68
D18003-0465	4,65	6	66	24	17	43,68
D18003-0470	4,7	6	66	24	17	43,68
D18003-0480	4,8	6	66	28	20	43,68
D18003-0490	4,9	6	66	28	20	43,68
D18003-0500	5	6	66	28	20	43,68
D18003-0510	5,1	6	66	28	20	43,68
D18003-0520	5,2	6	66	28	20	43,68
D18003-0530	5,3	6	66	28	20	43,68
D18003-0540	5,4	6	66	28	20	43,68
D18003-0550	5,5	6	66	28	20	43,68
D18003-0555	5,55	6	66	28	20	43,68
D18003-0560	5,6	6	66	28	20	43,68
D18003-0570	5,7	6	66	28	20	43,68
D18003-0580	5,8	6	66	28	20	43,68

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18003-0590	5,9	6	66	28	20	43,68
D18003-0600	6	6	66	28	20	43,68
D18003-0610	6,1	8	79	34	24	53,76
D18003-0620	6,2	8	79	34	24	53,76
D18003-0630	6,3	8	79	34	24	53,76
D18003-0640	6,4	8	79	34	24	53,76
D18003-0650	6,5	8	79	34	24	53,76
D18003-0660	6,6	8	79	34	24	53,76
D18003-0670	6,7	8	79	34	24	53,76
D18003-0680	6,8	8	79	34	24	53,76
D18003-0690	6,9	8	79	34	24	53,76
D18003-0700	7	8	79	34	24	53,76
D18003-0710	7,1	8	79	41	29	53,76
D18003-0720	7,2	8	79	41	29	53,76
D18003-0730	7,3	8	79	41	29	53,76
D18003-0740	7,4	8	79	41	29	53,76
D18003-0750	7,5	8	79	41	29	53,76
D18003-0760	7,6	8	79	41	29	53,76
D18003-0770	7,7	8	79	41	29	53,76
D18003-0780	7,8	8	79	41	29	53,76
D18003-0790	7,9	8	79	41	29	53,76
D18003-0800	8	8	79	41	29	53,76
D18003-0810	8,1	10	89	47	35	70,56
D18003-0820	8,2	10	89	47	35	70,56
D18003-0830	8,3	10	89	47	35	70,56
D18003-0840	8,4	10	89	47	35	70,56
D18003-0850	8,5	10	89	47	35	70,56
D18003-0860	8,6	10	89	47	35	70,56
D18003-0870	8,7	10	89	47	35	70,56
D18003-0880	8,8	10	89	47	35	70,56
D18003-0890	8,9	10	89	47	35	70,56

Boorpunt - Drill point



Materiaal - Material



Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	4-vlaks slijping/4-facet
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Inwendig/internal
Schacht/shaft	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18003-0900	9	10	89	47	35	70,56
D18003-0910	9,1	10	89	47	35	70,56
D18003-0920	9,2	10	89	47	35	70,56
D18003-0925	9,25	10	89	47	35	70,56
D18003-0930	9,3	10	89	47	35	70,56
D18003-0940	9,4	10	89	47	35	70,56
D18003-0950	9,5	10	89	47	35	70,56
D18003-0960	9,6	10	89	47	35	70,56
D18003-0970	9,7	10	89	47	35	70,56
D18003-0980	9,8	10	89	47	35	70,56
D18003-0990	9,9	10	89	47	35	70,56
D18003-1000	10	10	89	47	35	70,56
D18003-1020	10,2	12	102	55	40	94,08
D18003-1030	10,3	12	102	55	40	94,08
D18003-1050	10,5	12	102	55	40	94,08
D18003-1080	10,8	12	102	55	40	94,08
D18003-1100	11	12	102	55	40	94,08
D18003-1120	11,2	12	102	55	40	94,08
D18003-1130	11,3	12	102	55	40	94,08
D18003-1140	11,4	12	102	55	40	94,08
D18003-1150	11,5	12	102	55	40	94,08
D18003-1170	11,7	12	102	55	40	94,08
D18003-1180	11,8	12	102	55	40	94,08
D18003-1200	12	12	102	55	40	94,08
D18003-1210	12,1	14	107	60	43	137,76
D18003-1220	12,2	14	107	60	43	137,76
D18003-1250	12,5	14	107	60	43	137,76
D18003-1280	12,8	14	107	60	43	137,76
D18003-1290	12,9	14	107	60	43	137,76
D18003-1300	13	14	107	60	43	137,76
D18003-1310	13,1	14	107	60	43	137,76

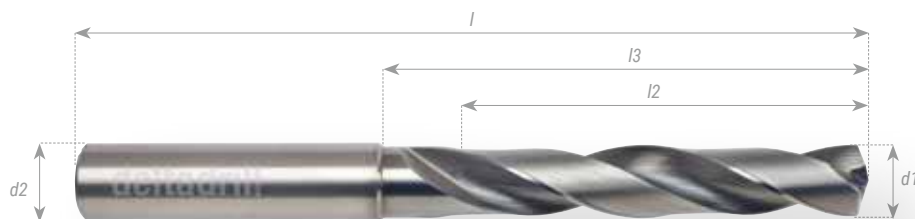
Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18003-1320	13,2	14	107	60	43	137,76
D18003-1330	13,3	14	107	60	43	137,76
D18003-1350	13,5	14	107	60	43	137,76
D18003-1360	13,5	14	107	60	43	137,76
D18003-1380	13,8	14	107	60	43	137,76
D18003-1400	14	14	107	60	43	137,76
D18003-1450	14,5	16	115	65	45	171,36
D18003-1480	14,8	16	115	65	45	171,36
D18003-1500	15	16	115	65	45	171,36
D18003-1550	15,5	16	115	65	45	171,36
D18003-1580	15,8	16	115	65	45	171,36
D18003-1600	16	16	115	65	45	171,36
D18003-1650	16,5	18	123	73	51	241,92
D18003-1680	16,8	18	123	73	51	241,92
D18003-1700	17	18	123	73	51	241,92
D18003-1750	17,5	18	123	73	51	241,92
D18003-1780	17,8	18	123	73	51	241,92
D18003-1800	18	18	123	73	51	241,92
D18003-1850	18,5	20	131	79	55	278,88
D18003-1880	18,8	20	131	79	55	278,88
D18003-1900	19	20	131	79	55	278,88
D18003-1950	19,5	20	131	79	55	278,88
D18003-1980	19,8	20	131	79	55	278,88
D18003-2000	20	20	131	79	55	278,88

VHM Boren universeel 5xD

Solid Carbide Drills universal 5xD

De universeelboor voor alle materialen, zeer geschikt voor INOX.

The universal drill voor all materials, the best choice for INOX.



SPEEDDRILL U2

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18005-0300	3	6	66	28	23	54,88
D18005-0310	3,1	6	66	28	23	54,88
D18005-0320	3,2	6	66	28	23	54,88
D18005-0330	3,3	6	66	28	23	54,88
D18005-0340	3,4	6	66	28	23	54,88
D18005-0350	3,5	6	66	28	23	54,88
D18005-0360	3,6	6	66	28	23	54,88
D18005-0370	3,7	6	66	28	23	54,88
D18005-0380	3,8	6	74	36	29	54,88
D18005-0390	3,9	6	74	36	29	54,88
D18005-0400	4	6	74	36	29	54,88
D18005-0410	4,1	6	74	36	29	54,88
D18005-0420	4,2	6	74	36	29	54,88
D18005-0430	4,3	6	74	36	29	54,88
D18005-0440	4,4	6	74	36	29	54,88
D18005-0450	4,5	6	74	36	29	54,88
D18005-0460	4,6	6	74	36	29	54,88
D18005-0470	4,7	6	74	36	29	54,88
D18005-0480	4,8	6	82	44	35	54,88
D18005-0490	4,9	6	82	44	35	54,88
D18005-0500	5	6	82	44	35	54,88
D18005-0510	5,1	6	82	44	35	54,88
D18005-0520	5,2	6	82	44	35	54,88
D18005-0530	5,3	6	82	44	35	54,88
D18005-0540	5,4	6	82	44	35	54,88
D18005-0550	5,5	6	82	44	35	54,88
D18005-0560	5,6	6	82	44	35	54,88
D18005-0570	5,7	6	82	44	35	54,88
D18005-0580	5,8	6	82	44	35	54,88
D18005-0590	5,9	6	82	44	35	54,88
D18005-0600	6	6	82	44	35	54,88

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18005-0610	6,1	8	91	53	43	61,60
D18005-0620	6,2	8	91	53	43	61,60
D18005-0630	6,3	8	91	53	43	61,60
D18005-0640	6,4	8	91	53	43	61,60
D18005-0650	6,5	8	91	53	43	61,60
D18005-0660	6,6	8	91	53	43	61,60
D18005-0670	6,7	8	91	53	43	61,60
D18005-0680	6,8	8	91	53	43	61,60
D18005-0690	6,9	8	91	53	43	61,60
D18005-0700	7	8	91	53	43	61,60
D18005-0710	7,1	8	91	53	43	61,60
D18005-0720	7,2	8	91	53	43	61,60
D18005-0730	7,3	8	91	53	43	61,60
D18005-0740	7,4	8	91	53	43	61,60
D18005-0750	7,5	8	91	53	43	61,60
D18005-0760	7,6	8	91	53	43	61,60
D18005-0770	7,7	8	91	53	43	61,60
D18005-0780	7,8	8	91	53	43	61,60
D18005-0790	7,9	8	91	53	43	61,60
D18005-0800	8	8	91	53	43	61,60
D18005-0810	8,1	10	103	61	49	73,92
D18005-0820	8,2	10	103	61	49	73,92
D18005-0830	8,3	10	103	61	49	73,92
D18005-0840	8,4	10	103	61	49	73,92
D18005-0850	8,5	10	103	61	49	73,92
D18005-0860	8,6	10	103	61	49	73,92
D18005-0870	8,7	10	103	61	49	73,92
D18005-0880	8,8	10	103	61	49	73,92
D18005-0890	8,9	10	103	61	49	73,92
D18005-0900	9	10	103	61	49	73,92
D18005-0910	9,1	10	103	61	49	73,92

Boorpunt - Drill point



Materiaal - Material



Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	4-vlaks slijping/4-facet
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Inwendig/internal
Schacht/shaft	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18005-0920	9,2	10	103	61	49	73,92
D18005-0930	9,3	10	103	61	49	73,92
D18005-0940	9,4	10	103	61	49	73,92
D18005-0950	9,5	10	103	61	49	73,92
D18005-0960	9,6	10	103	61	49	73,92
D18005-0970	9,7	10	103	61	49	73,92
D18005-0980	9,8	10	103	61	49	73,92
D18005-0990	9,9	10	103	61	49	73,92
D18005-1000	10	10	103	61	49	73,92
D18005-1010	10,1	12	118	71	56	107,52
D18005-1020	10,2	12	118	71	56	107,52
D18005-1030	10,3	12	118	71	56	107,52
D18005-1040	10,4	12	118	71	56	107,52
D18005-1050	10,5	12	118	71	56	107,52
D18005-1060	10,6	12	118	71	56	107,52
D18005-1070	10,7	12	118	71	56	107,52
D18005-1080	10,8	12	118	71	56	107,52
D18005-1090	10,9	12	118	71	56	107,52
D18005-1100	11	12	118	71	56	107,52
D18005-1110	11,1	12	118	71	56	107,52
D18005-1120	11,2	12	118	71	56	107,52
D18005-1130	11,3	12	118	71	56	107,52
D18005-1140	11,4	12	118	71	56	107,52
D18005-1150	11,5	12	118	71	56	107,52
D18005-1160	11,6	12	118	71	56	107,52
D18005-1170	11,7	12	118	71	56	107,52
D18005-1180	11,8	12	118	71	56	107,52
D18005-1190	11,9	12	118	71	56	107,52
D18005-1200	12	12	118	71	56	107,52
D18005-1250	12,5	14	124	77	60	143,36
D18005-1280	12,8	14	124	77	60	143,36

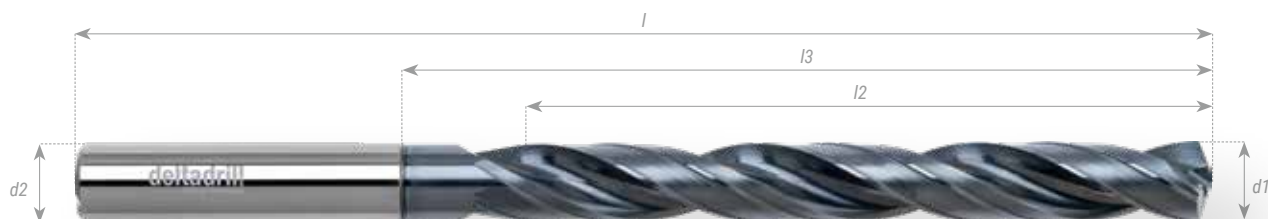
Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18005-1300	13	14	124	77	60	143,36
D18005-1350	13,5	14	124	77	60	143,36
D18005-1380	13,8	14	124	77	60	143,36
D18005-1400	14	14	124	77	60	143,36
D18005-1450	14,5	16	133	83	63	175,84
D18005-1480	14,8	16	133	83	63	175,84
D18005-1500	15	16	133	83	63	175,84
D18005-1550	15,5	16	133	83	63	175,84
D18005-1580	15,8	16	133	83	63	175,84
D18005-1600	16	16	133	83	63	175,84
D18005-1650	16,5	18	143	93	71	250,88
D18005-1680	16,8	18	143	93	71	250,88
D18005-1700	17	18	143	93	71	250,88
D18005-1750	17,5	18	143	93	71	250,88
D18005-1780	17,8	18	143	93	71	250,88
D18005-1800	18	18	143	93	71	250,88
D18005-1850	18,5	20	153	101	77	299,04
D18005-1880	18,8	20	153	101	77	299,04
D18005-1900	19	20	153	101	77	299,04
D18005-1950	19,5	20	153	101	77	299,04
D18005-1980	19,8	20	153	101	77	299,04
D18005-2000	20	20	153	101	77	299,04

VHM Boren universeel 8xD

Solid carbide Drills universal 8xD

De universeelboor voor alle materialen, zeer geschikt voor INOX.

The universal drill voor all materials, the best choice for INOX.



SPEEDDRILL U4

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18708-0300	3	6	72	34	29	82,88
D18708-0310	3,1	6	72	34	29	82,88
D18708-0320	3,2	6	72	34	29	82,88
D18708-0330	3,3	6	72	34	29	82,88
D18708-0340	3,4	6	72	34	29	82,88
D18708-0350	3,5	6	72	34	29	82,88
D18708-0360	3,6	6	72	34	29	82,88
D18708-0370	3,7	6	72	34	29	82,88
D18708-0380	3,8	6	81	43	36	82,88
D18708-0390	3,9	6	81	43	36	82,88
D18708-0400	4	6	81	43	36	82,88
D18708-0410	4,1	6	81	43	36	82,88
D18708-0420	4,2	6	81	43	36	82,88
D18708-0430	4,3	6	81	43	36	82,88
D18708-0440	4,4	6	81	43	36	82,88
D18708-0450	4,5	6	81	43	36	82,88
D18708-0460	4,6	6	81	43	36	82,88
D18708-0470	4,7	6	81	43	36	82,88
D18708-0480	4,8	6	95	57	48	82,88
D18708-0490	4,9	6	95	57	48	82,88
D18708-0500	5	6	95	57	48	82,88
D18708-0510	5,1	6	95	57	48	82,88
D18708-0520	5,2	6	95	57	48	82,88
D18708-0530	5,3	6	95	57	48	82,88
D18708-0540	5,4	6	95	57	48	82,88
D18708-0550	5,5	6	95	57	48	82,88
D18708-0560	5,6	6	95	57	48	82,88
D18708-0570	5,7	6	95	57	48	82,88
D18708-0580	5,8	6	95	57	48	82,88
D18708-0590	5,9	6	95	57	48	82,88
D18708-0600	6	6	95	57	48	82,88

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18708-0610	6,1	8	114	76	64	112,00
D18708-0620	6,2	8	114	76	64	112,00
D18708-0630	6,3	8	114	76	64	112,00
D18708-0640	6,4	8	114	76	64	112,00
D18708-0650	6,5	8	114	76	64	112,00
D18708-0660	6,6	8	114	76	64	112,00
D18708-0670	6,7	8	114	76	64	112,00
D18708-0680	6,8	8	114	76	64	112,00
D18708-0690	6,9	8	114	76	64	112,00
D18708-0700	7	8	114	76	64	112,00
D18708-0710	7,1	8	114	76	64	112,00
D18708-0720	7,2	8	114	76	64	112,00
D18708-0730	7,3	8	114	76	64	112,00
D18708-0740	7,4	8	114	76	64	112,00
D18708-0750	7,5	8	114	76	64	112,00
D18708-0760	7,6	8	114	76	64	112,00
D18708-0770	7,7	8	114	76	64	112,00
D18708-0780	7,8	8	114	76	64	112,00
D18708-0790	7,9	8	114	76	64	112,00
D18708-0800	8	8	114	76	64	112,00
D18708-0810	8,1	10	142	95	80	155,68
D18708-0820	8,2	10	142	95	80	155,68
D18708-0830	8,3	10	142	95	80	155,68
D18708-0840	8,4	10	142	95	80	155,68
D18708-0850	8,5	10	142	95	80	155,68
D18708-0860	8,6	10	142	95	80	155,68
D18708-0870	8,7	10	142	95	80	155,68
D18708-0880	8,8	10	142	95	80	155,68
D18708-0890	8,9	10	142	95	80	155,68
D18708-0900	9	10	142	95	80	155,68
D18708-0910	9,1	10	142	95	80	155,68

Boorpunt - Drill point



Materiaal - Material



Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	4-vlaks slijping/4-facet
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Inwendig/internal
Schacht/shaft	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18708-0920	10	142	95	80	49	155,68
D18708-0930	10	142	95	80	49	155,68
D18708-0940	10	142	95	80	49	155,68
D18708-0950	10	142	95	80	49	155,68
D18708-0960	10	142	95	80	49	155,68
D18708-0970	10	142	95	80	49	155,68
D18708-0980	10	142	95	80	49	155,68
D18708-0990	10	142	95	80	49	155,68
D18708-1000	10	142	95	80	49	155,68
D18708-1020	12	162	114	96	56	198,24
D18708-1050	12	162	114	96	56	198,24
D18708-1080	12	162	114	96	56	198,24
D18708-1100	12	162	114	96	56	198,24
D18708-1150	12	162	114	96	56	198,24
D18708-1180	12	162	114	96	56	198,24
D18708-1200	12	162	114	96	56	198,24
D18708-1250	14	178	133	112	60	249,76
D18708-1280	14	178	133	112	60	249,46
D18708-1300	14	178	133	112	60	198,24
D18708-1350	14	178	133	112	60	198,24
D18708-1380	14	178	133	112	60	198,24
D18708-1400	14	178	133	112	60	198,24
D18708-1450	16	203	152	128	63	331,52
D18708-1480	16	203	152	128	63	198,24
D18708-1500	16	203	152	128	63	198,24
D18708-1550	16	203	152	128	63	198,24
D18708-1580	16	203	152	128	63	198,24
D18708-1600	16	203	152	128	63	198,24
D18708-1650	18	222	171	144	71	460,32
D18708-1680	18	222	171	144	71	460,32
D18708-1700	18	222	171	144	71	460,32

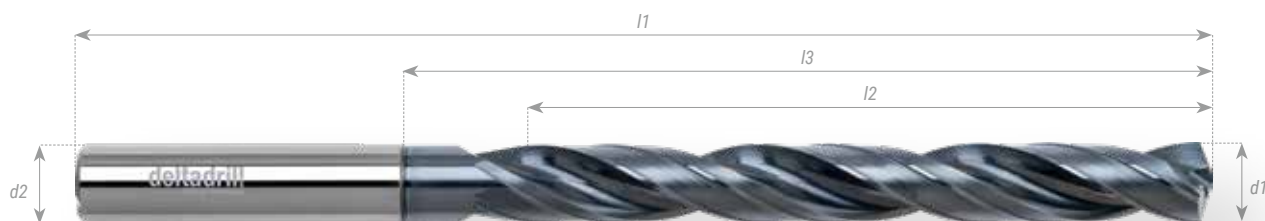
Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18708-1750	18	222	171	144	71	460,32
D18708-1780	18	222	171	144	71	460,32
D18708-1800	18	222	171	144	71	460,32
D18708-1850	20	243	190	160	77	574,56
D18708-1880	20	243	190	160	77	574,56
D18708-1900	20	243	190	160	77	574,56
D18708-1950	20	243	190	160	77	574,56
D18708-1980	20	243	190	160	77	574,56
D18708-2000	20	243	190	160	77	574,56

VHM Boren universeel 12xD

Solid carbide Drills universal 12xD

De universeelboor voor alle materialen, zeer geschikt voor INOX.

The universal drill voor all materials, the best choice for INOX.



SPEEDDRILL U4

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D18712-0300	3	6	92	54	48	120,96
D18712-0350	3,5	6	92	54	48	120,96
D18712-0400	4	6	102	64	58	120,96
D18712-0450	4,5	6	102	64	58	120,96
D18712-0500	5	6	116	78	70	120,96
D18712-0550	5,5	6	116	78	70	120,96
D18712-0600	6	6	116	78	70	120,96
D18712-0650	6,5	8	146	108	94	129,92
D18712-0700	7	8	146	108	94	129,92
D18712-0750	7,5	8	146	108	94	129,92
D18712-0800	8	8	146	108	94	129,92
D18712-0850	8,5	10	162	120	110	174,72
D18712-0900	9	10	162	120	110	174,72
D18712-0950	9,5	10	162	120	110	174,72
D18712-1000	10	10	162	120	110	174,72
D18712-1100	11	12	204	156	142	235,20
D18712-1200	12	12	204	156	142	235,20

Boorpunt - Drill point



Materiaal - Material

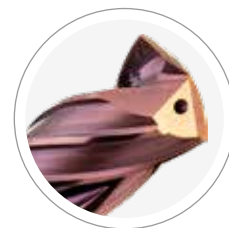
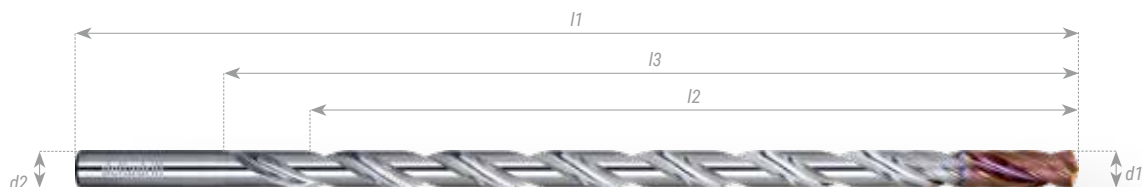


Spiraal/ Helix	30°
Tophoek/point angle	140°
Punt/point	4-vlaks slijping/4-facet
Hartmetaal/solid carbide	Fijnkorrel/ Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Inwendig/internal
Schacht/shaft	DIN 6535 HA

VHM diepgatboren universeel 20xD

Solid carbide deepdrills universal 20xD

De universeelboor voor alle materialen.
The universal drill voor all materials.



6-Fasen
6-Margins

DEEPDRILL US

Art. nr.	Ød1	Ød2	l2	l3	l1	€
D18720-0200	2,0	4	40	50	92	166,00
D18720-0220	2,2	4	40	50	92	166,00
D18720-0230	2,3	4	40	50	92	166,00
D18720-0240	2,4	4	40	50	92	166,00
D18720-0250	2,5	4	40	50	92	166,00
D18720-0270	2,7	4	40	50	92	166,00
D18720-0280	2,8	4	40	50	92	166,00
D18720-0300	3,0	6	60	80	120	252,00
D18720-0320	3,2	6	60	80	120	252,00
D18720-0330	3,3	6	60	80	120	252,00
D18720-0350	3,5	6	60	80	120	252,00
D18720-0380	3,8	6	60	80	120	259,00
D18720-0400	4,0	6	80	90	130	259,00
D18720-0420	4,2	6	80	90	130	307,00
D18720-0450	4,5	6	80	90	130	307,00
D18720-0480	4,8	6	80	90	130	307,00
D18720-0500	5,0	6	100	120	160	307,00
D18720-0550	5,5	6	100	120	160	318,00
D18720-0580	5,8	6	100	120	160	318,00
D18720-0600	6,0	6	120	140	185	318,00
D18720-0650	6,5	8	120	140	185	356,00
D18720-0680	6,8	8	120	140	185	356,00
D18720-0700	7,0	8	140	160	210	356,00
D18720-0750	7,5	8	140	160	210	400,00
D18720-0780	7,8	8	140	160	210	400,00
D18720-0800	8,0	8	160	180	230	400,00
D18720-0850	8,5	10	160	180	230	476,00
D18720-0880	8,8	10	160	180	230	493,00
D18720-0900	9,0	10	180	230	290	493,00
D18720-0950	9,5	10	180	230	290	493,00
D18720-0980	9,8	10	180	230	290	493,00

Art. nr.	Ød1	Ød2	l2	l3	l1	€
D18720-1000	10,0	10	200	230	290	493,00
D18720-1020	10,2	12	200	230	290	545,00
D18720-1050	10,5	12	200	230	290	545,00
D18720-1080	10,8	12	200	230	290	545,00
D18720-1100	11,0	12	220	268	315	545,00
D18720-1150	11,5	12	220	268	315	545,00
D18720-1180	11,8	12	220	268	315	545,00
D18720-1200	12,0	12	240	268	315	545,00

Boorpunt - Drill point



Materiaal - Material

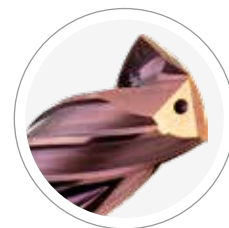
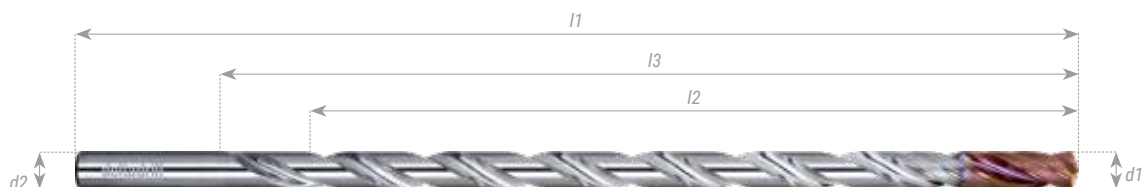


Spiraal/ Helix	30° Gepolijst / Polished
Tophoek/point angle	140°
Punt/point	4-vlaks / 4-facet
Geleidefasen / Guide lands	6
Hartmetaal/solid carbide	Fijnkorrel / Finegrain 8-10% Co
Coating/coating	HEX-Speed
Koeling/coolant	Inwendig / internal
Schacht/shaft	DIN 6535 HA

VHM diepgatboren universeel 30xD

Solid carbide deepdrills universal 30xD

De universeelboor voor alle materialen.
The universal drill voor all materials.



6-Fasen
Gepolijst groeven
6-Margins
Polished flutes

DEEPDRILL US

Art. nr.	Ød1	Ød2	l2	l3	l1	€
D18730-0200	2,0	4	60	70	115	243,00
D18730-0210	2,1	4	60	70	115	243,00
D18730-0220	2,2	4	60	70	115	243,00
D18730-0230	2,3	4	60	70	115	243,00
D18730-0240	2,4	4	72	90	138	265,00
D18730-0250	2,5	4	72	90	138	265,00
D18730-0270	2,7	4	72	90	138	265,00
D18730-0280	2,8	4	72	90	138	265,00
D18730-0300	3,0	6	90	105	150	371,00
D18730-0320	3,2	6	90	105	150	371,00
D18730-0330	3,3	6	99	135	185	383,00
D18730-0350	3,5	6	99	135	185	383,00
D18730-0380	3,8	6	99	135	185	383,00
D18730-0400	4,0	6	99	135	185	383,00
D18730-0420	4,2	6	99	135	185	383,00
D18730-0450	4,5	6	135	165	215	399,00
D18730-0480	4,8	6	135	165	215	399,00
D18730-0500	5,0	6	150	165	215	399,00
D18730-0550	5,5	6	150	165	215	406,00
D18730-0580	5,8	6	100	120	160	406,00
D18730-0600	6,0	6	120	140	185	406,00
D18730-0650	6,5	8	120	140	185	457,00
D18730-0680	6,8	8	120	140	185	476,00
D18730-0700	7,0	8	140	160	210	476,00
D18730-0750	7,5	8	140	160	210	476,00
D18730-0780	7,8	8	140	160	210	531,00
D18730-0800	8,0	8	160	180	230	531,00
D18730-0850	8,5	10	160	180	230	577,00
D18730-0880	8,8	10	160	180	230	648,00
D18730-0900	9,0	10	180	230	290	648,00

Art. nr.	Ød1	Ød2	l2	l3	l1	€
D18730-0950	9,5	10	180	230	290	648,00
D18730-0980	9,8	10	180	230	290	648,00
D18730-1000	10,0	10	200	230	290	648,00

Boorpunt - Drill point



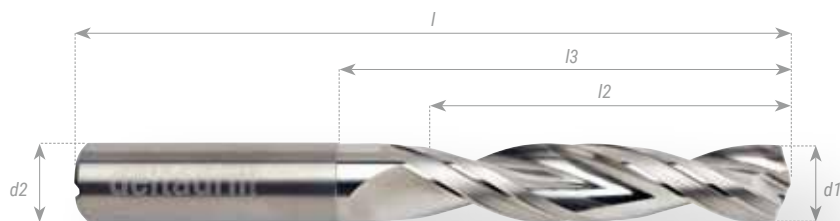
Materiaal - Material



Spiraal/ Helix	30° Gepolijst / Polished
Tophoek/point angle	140°
Punt/point	4-vlaks / 4-facet
Geleidefasen / Guide lands	6
Hartmetaal/solid carbide	Fijnkorrel / Finegrain 8-10% Co
Coating/coating	GTX-Speed
Koeling/coolant	Inwendig / internal
Schacht/shaft	DIN 6535 HA

VHM Boren Aluminium 5xD

Solid carbide Drills Aluminium 5xD



SPEEDDRILL A4

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D28705-0300	3	6	66	28	23	60,48
D28705-0310	3,1	6	66	28	23	60,48
D28705-0320	3,2	6	66	28	23	60,48
D28705-0330	3,3	6	66	28	23	60,48
D28705-0340	3,4	6	66	28	23	60,48
D28705-0350	3,5	6	66	28	23	60,48
D28705-0360	3,6	6	66	28	23	60,48
D28705-0370	3,7	6	66	28	23	60,48
D28705-0380	3,8	6	74	36	29	60,48
D28705-0390	3,9	6	74	36	29	60,48
D28705-0400	4	6	74	36	29	60,48
D28705-0410	4,1	6	74	36	29	60,48
D28705-0420	4,2	6	74	36	29	60,48
D28705-0430	4,3	6	74	36	29	60,48
D28705-0440	4,4	6	74	36	29	60,48
D28705-0450	4,5	6	74	36	29	60,48
D28705-0460	4,6	6	74	36	29	60,48
D28705-0470	4,7	6	74	36	29	60,48
D28705-0480	4,8	6	82	44	35	60,48
D28705-0490	4,9	6	82	44	35	60,48
D28705-0500	5	6	82	44	35	60,48
D28705-0510	5,1	6	82	44	35	60,48
D28705-0520	5,2	6	82	44	35	60,48
D28705-0530	5,3	6	82	44	35	60,48
D28705-0540	5,4	6	82	44	35	60,48
D28705-0550	5,5	6	82	44	35	60,48
D28705-0560	5,6	6	82	44	35	60,48
D28705-0570	5,7	6	82	44	35	60,48
D28705-0580	5,8	6	82	44	35	60,48
D28705-0590	5,9	6	82	44	35	60,48
D28705-0600	6	6	82	44	35	60,48

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D28705-0610	6,1	8	91	53	43	68,32
D28705-0620	6,2	8	91	53	43	68,32
D28705-0630	6,3	8	91	53	43	68,32
D28705-0640	6,4	8	91	53	43	68,32
D28705-0650	6,5	8	91	53	43	68,32
D28705-0660	6,6	8	91	53	43	68,32
D28705-0670	6,7	8	91	53	43	68,32
D28705-0680	6,8	8	91	53	43	68,32
D28705-0690	6,9	8	91	53	43	68,32
D28705-0700	7	8	91	53	43	68,32
D28705-0710	7,1	8	91	53	43	68,32
D28705-0720	7,2	8	91	53	43	68,32
D28705-0730	7,3	8	91	53	43	68,32
D28705-0740	7,4	8	91	53	43	68,32
D28705-0750	7,5	8	91	53	43	68,32
D28705-0760	7,6	8	91	53	43	68,32
D28705-0770	7,7	8	91	53	43	68,32
D28705-0780	7,8	8	91	53	43	68,32
D28705-0790	7,9	8	91	53	43	68,32
D28705-0800	8	8	91	53	43	68,32
D28705-0810	8,1	10	103	61	49	81,76
D28705-0820	8,2	10	103	61	49	81,76
D28705-0830	8,3	10	103	61	49	81,76
D28705-0840	8,4	10	103	61	49	81,76
D28705-0850	8,5	10	103	61	49	81,76
D28705-0860	8,6	10	103	61	49	81,76
D28705-0870	8,7	10	103	61	49	81,76
D28705-0880	8,8	10	103	61	49	81,76
D28705-0890	8,9	10	103	61	49	81,76
D28705-0900	9	10	103	61	49	81,76
D28705-0910	9,1	10	103	61	49	81,76

Boorpunt - Drill point



Materiaal - Material



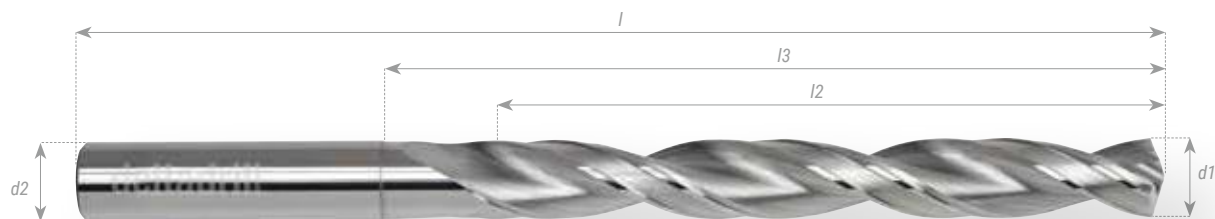
Spiraal	30° rechts
Tophoek	140°
Punt	4-vlaks slijping
Hartmetaal	Fijnkorrel 6-8% Co
Coating	Blank gepolijste spiraalgroeven
Koeling	Inwendig
Schacht	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D28705-0920	9,2	10	103	61	49	81,76
D28705-0930	9,3	10	103	61	49	81,76
D28705-0940	9,4	10	103	61	49	81,76
D28705-0950	9,5	10	103	61	49	81,76
D28705-0960	9,6	10	103	61	49	81,76
D28705-0970	9,7	10	103	61	49	81,76
D28705-0980	9,8	10	103	61	49	81,76
D28705-0990	9,9	10	103	61	49	81,76
D28705-1000	10	10	103	61	49	81,76
D28705-1020	10,2	12	118	71	56	119,84
D28705-1050	10,5	12	118	71	56	119,84
D28705-1080	10,8	12	118	71	56	119,84
D28705-1100	11	12	118	71	56	119,84
D28705-1150	11,5	12	118	71	56	119,84
D28705-1180	11,8	12	118	71	56	119,84
D28705-1200	12	12	118	71	56	119,84
D28705-1250	12,5	14	124	77	60	159,04
D28705-1280	12,8	14	124	77	60	159,04
D28705-1300	13	14	124	77	60	159,04
D28705-1350	13,5	14	124	77	60	159,04
D28705-1380	13,8	14	124	77	60	159,04
D28705-1400	14	14	124	77	60	159,04
D28705-1450	14,5	16	133	83	63	192,64
D28705-1480	14,8	16	133	83	63	192,64
D28705-1500	15	16	133	83	63	192,64
D28705-1550	15,5	16	133	83	63	192,64
D28705-1580	15,8	16	133	83	63	192,64
D28705-1600	16	16	133	83	63	192,64
D28705-1650	16,5	18	143	93	71	259,84
D28705-1680	16,8	18	143	93	71	259,84
D28705-1700	17	18	143	93	71	259,84

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D28705-1750	17,5	18	143	93	71	259,84
D28705-1780	17,8	18	143	93	71	259,84
D28705-1800	18	18	143	93	71	259,84
D28705-1850	18,5	20	153	101	77	327,04
D28705-1880	18,8	20	153	101	77	327,04
D28705-1900	19	20	153	101	77	327,04
D28705-1950	19,5	20	153	101	77	327,04
D28705-1980	19,8	20	153	101	77	327,04
D28705-2000	20	20	153	101	77	327,04

VHM Boren Aluminium 8xD

Solid carbide Drills Aluminium 8xD



SPEEDDRILL A4

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D28708-0300	3	6	72	34	29	82,88
D28708-0310	3,1	6	72	34	29	82,88
D28708-0320	3,2	6	72	34	29	82,88
D28708-0330	3,3	6	72	34	29	82,88
D28708-0340	3,4	6	72	34	29	82,88
D28708-0350	3,5	6	72	34	29	82,88
D28708-0360	3,6	6	72	34	29	82,88
D28708-0370	3,7	6	72	34	29	82,88
D28708-0380	3,8	6	81	43	36	82,88
D28708-0390	3,9	6	81	43	36	82,88
D28708-0400	4	6	81	43	36	82,88
D28708-0410	4,1	6	81	43	36	82,88
D28708-0420	4,2	6	81	43	36	82,88
D28708-0430	4,3	6	81	43	36	82,88
D28708-0440	4,4	6	81	43	36	82,88
D28708-0450	4,5	6	81	43	36	82,88
D28708-0460	4,6	6	81	43	36	82,88
D28708-0470	4,7	6	81	43	36	82,88
D28708-0480	4,8	6	95	57	48	82,88
D28708-0490	4,9	6	95	57	48	82,88
D28708-0500	5	6	95	57	48	82,88
D28708-0510	5,1	6	95	57	48	82,88
D28708-0520	5,2	6	95	57	48	82,88
D28708-0530	5,3	6	95	57	48	82,88
D28708-0540	5,4	6	95	57	48	82,88
D28708-0550	5,5	6	95	57	48	82,88
D28708-0560	5,6	6	95	57	48	82,88
D28708-0570	5,7	6	95	57	48	82,88
D28708-0580	5,8	6	95	57	48	82,88
D28708-0590	5,9	6	95	57	48	82,88
D28708-0600	6	6	95	57	48	82,88

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D28708-0610	6,1	8	114	76	64	112,00
D28708-0620	6,2	8	114	76	64	112,00
D28708-0630	6,3	8	114	76	64	112,00
D28708-0640	6,4	8	114	76	64	112,00
D28708-0650	6,5	8	114	76	64	112,00
D28708-0660	6,6	8	114	76	64	112,00
D28708-0670	6,7	8	114	76	64	112,00
D28708-0680	6,8	8	114	76	64	112,00
D28708-0690	6,9	8	114	76	64	112,00
D28708-0700	7	8	114	76	64	112,00
D28708-0710	7,1	8	114	76	64	112,00
D28708-0720	7,2	8	114	76	64	112,00
D28708-0730	7,3	8	114	76	64	112,00
D28708-0740	7,4	8	114	76	64	112,00
D28708-0750	7,5	8	114	76	64	112,00
D28708-0760	7,6	8	114	76	64	112,00
D28708-0770	7,7	8	114	76	64	112,00
D28708-0780	7,8	8	114	76	64	112,00
D28708-0790	7,9	8	114	76	64	112,00
D28708-0800	8	8	114	76	64	112,00
D28708-0810	8,1	10	142	95	80	155,68
D28708-0820	8,2	10	142	95	80	155,68
D28708-0830	8,3	10	142	95	80	155,68
D28708-0840	8,4	10	142	95	80	155,68
D28708-0850	8,5	10	142	95	80	155,68
D28708-0860	8,6	10	142	95	80	155,68
D28708-0870	8,7	10	142	95	80	155,68
D28708-0880	8,8	10	142	95	80	155,68
D28708-0890	8,9	10	142	95	80	155,68
D28708-0900	9	10	142	95	80	155,68
D28708-0910	9,1	10	142	95	80	155,68

Boorpunt - Drill point



Materiaal - Material



Spiraal	30° rechts
Tophoek	140°
Punt	4-vlaks slijping
Hartmetaal	Fijnkorrel 6-8% Co
Coating	Blank gepolijste spiraalgroeven
Koeling	Inwendig
Schacht	DIN 6535 HA

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D28708-0920	9,2	10	142	95	80	155,68
D28708-0930	9,3	10	142	95	80	155,68
D28708-0940	9,4	10	142	95	80	155,68
D28708-0950	9,5	10	142	95	80	155,68
D28708-0960	9,6	10	142	95	80	155,68
D28708-0970	9,7	10	142	95	80	155,68
D28708-0980	9,8	10	142	95	80	155,68
D28708-0990	9,9	10	142	95	80	155,68
D28708-1000	10	10	142	95	80	155,68
D28708-1020	10,2	12	162	114	96	198,24
D28708-1050	10,5	12	162	114	96	198,24
D28708-1080	10,8	12	162	114	96	198,24
D28708-1100	11	12	162	114	96	198,24
D28708-1150	11,5	12	162	114	96	198,24
D28708-1180	11,8	12	162	114	96	198,24
D28708-1200	12	12	162	114	96	198,24
D28708-1250	12,5	14	178	133	112	249,76
D28708-1280	12,8	14	178	133	112	249,76
D28708-1300	13	14	178	133	112	249,76
D28708-1350	13,5	14	178	133	112	249,76
D28708-1380	13,8	14	178	133	112	249,76
D28708-1400	14	14	178	133	112	249,76
D28708-1450	14,5	16	203	152	128	331,52
D28708-1480	14,8	16	203	152	128	331,52
D28708-1500	15	16	203	152	128	331,52
D28708-1550	15,5	16	203	152	128	331,52
D28708-1580	15,8	16	203	152	128	331,52
D28708-1600	16	16	203	152	128	331,52
D28708-1650	16,5	18	222	171	144	460,32
D28708-1680	16,8	18	222	171	144	460,32
D28708-1700	17	18	222	171	144	460,32

Art. nr.	Ød1	Ød2	l1	l3	l2	€
D28708-1750	17,5	18	222	171	144	460,32
D28708-1780	17,8	18	222	171	144	460,32
D28708-1800	18	18	222	171	144	460,32
D28708-1850	18,5	20	243	190	160	574,56
D28708-1880	18,8	20	243	190	160	574,56
D28708-1900	19	20	243	190	160	574,56
D28708-1950	19,5	20	243	190	160	574,56
D28708-1980	19,8	20	243	190	160	574,56
D28708-2000	20	20	243	190	160	574,56

Snijwaarden VHM boren

Cutting values SC drills

SPEEDDRILL S4

D20003 - D20005 - D21003 - 21705 - D21708

Mat.	Pull [N/mm²]	Bijvoorbeeld	Vc M/min	Voeding/Omw. f					
				Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Steel	< 600 N/mm²	St37, C22, GS38	100-120	0,15	0,20	0,25	0,30	0,36	0,40
	< 700 N/mm²	St52, C35, GS52	90-110	0,15	0,20	0,25	0,30	0,36	0,40
	< 700 N/mm²	St70, C45, GS62	80-100	0,15	0,20	0,25	0,30	0,36	0,40
	< 900 N/mm²	16MnCr5, 42CrMo4	80-95	0,15	0,20	0,25	0,30	0,36	0,40
	< 1000 N/mm²	90MnCrV8, 100Cr6	65-80	0,14	0,18	0,22	0,26	0,30	0,35
	> 1000 N/mm²	X210Cr12, 34CrAlNi7	45-65	0,12	0,16	0,2	0,24	0,30	0,35
Cast iron	< 200 HB	GG20, GG25, GTS45	100-130	0,22	0,28	0,34	0,38	0,44	0,50
	< 250 HB	GG30, GTW40	90-120	0,20	0,25	0,30	0,35	0,40	0,45
	>250 HB	GG40, GTS70	80-100	0,20	0,25	0,30	0,35	0,40	0,45
	< 600 N/mm²	GGG40, GGG50	90-120	0,20	0,25	0,30	0,35	0,40	0,45
	> 600 N/mm²	GGG60,GGV (CGI)	70-90	0,18	0,22	0,25	0,30	0,35	0,40

* Voor de S2 uitvoeringen (zonder binnenkoeling) de snijsnelheid met circa 25% reduceren.

* For de S2 Version (without internal coolant)) reduce the speed with 25%.

SPEEDDRILL A4

D28705 - D28708

Mat.	Pull [N/mm²]	Bijvoorbeeld	Vc M/min	Voeding/Omw. f					
				Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Aluminium / brass copper / bronze		AlCuMgPb, AlMgSi 0.5	200-350	0,3	0,4	0,5	0,55	0,7	0,8
		GD-AlSi9Cu3, AlSi7Mg0.6	200-350	0,3	0,4	0,5	0,55	0,7	0,8
		GB.AlSi12(Cu)	180-250	0,24	0,32	0,4	0,45	0,55	0,6
			120-200	0,18	0,24	0,3	0,35	0,4	0,5

SPEEDDRILL U2

D18003 - D18005

Mat.	Pull [N/mm²]	Bijvoorbeeld	Vc* M/min	Voeding/Omw. f					
				Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Steel	< 600 N/mm²	St37, C22, GS38	80-100	0,15	0,20	0,25	0,30	0,36	0,40
	< 700 N/mm²	St52, C35, GS52	70-90	0,15	0,20	0,25	0,30	0,36	0,40
	< 700 N/mm²	St70, C45, GS62	65-85	0,15	0,20	0,25	0,30	0,36	0,40
	< 900 N/mm²	16MnCr5, 42CrMo4	70-90	0,15	0,20	0,25	0,30	0,36	0,40
	< 1000 N/mm²	90MnCrV8, 100Cr6	65-80	0,14	0,18	0,22	0,26	0,30	0,35
	> 1000 N/mm²	X210Cr12, 34CrAlNi7	45-65	0,12	0,16	0,2	0,24	0,30	0,35
Stainless steel		X5 CrNi 18 9 (V2A)	30-60	0,10	0,12	0,14	0,16	0,20	0,28
		X10 CrNiMoTi 18 10							
Cast iron	< 200 HB	GG20, GG25, GTS45	80-100	0,22	0,28	0,34	0,38	0,44	0,50
	< 250 HB	GG30, GTW40	70-90	0,20	0,25	0,30	0,35	0,40	0,45
	>250 HB	GG40, GTS70	65-85	0,20	0,25	0,30	0,35	0,40	0,45
	< 600 N/mm²	GGG40, GGG50	70-90	0,20	0,25	0,30	0,35	0,40	0,45
	> 600 N/mm²	GGG60,GGV (CGI)	65-80	0,18	0,22	0,25	0,30	0,35	0,40
Aluminium / brass copper / bronze		AlCuMgPb, AlMgSi 0.5	180-250	0,18	0,24	0,30	0,35	0,40	0,50
		GD-AlSi9Cu3, AlSi7Mg0.6	180-250	0,18	0,24	0,30	0,35	0,40	0,50
		GB.AlSi12(Cu)	160-220	0,18	0,24	0,30	0,35	0,40	0,50
			120-200	0,18	0,24	0,30	0,35	0,40	0,50
Titanium / Inconel alloys		Ti6Al4V	20-50	0,10	0,12	0,14	0,16	0,20	0,25
		Inconel, Monel, Hasteloy	20-45	0,10	0,12	0,14	0,16	0,18	0,25

Snijwaarden VHM boren

Cutting values SC drills

SPEEDDRILL U4

D18708 - D18712

Mat.	Pull [N/mm²]	Bijvoorbeeld	Vc* M/min	Voeding/Omw. f					
				Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Steel	< 600 N/mm²	St37, C22, GS38	60-80	0,15	0,20	0,25	0,30	0,36	0,40
	< 700 N/mm²	St52, C35, GS52	60-80	0,15	0,20	0,25	0,30	0,36	0,40
	< 700 N/mm²	St70, C45, GS62	55-75	0,15	0,20	0,25	0,30	0,36	0,40
	< 900 N/mm²	16MnCr5, 42CrMo4	50-70	0,15	0,20	0,25	0,30	0,36	0,40
	< 1000 N/mm²	90MnCrV8, 100Cr6	50-70	0,14	0,18	0,22	0,26	0,30	0,35
	> 1000 N/mm²	X210Cr12, 34CrAlNi7	40-60	0,12	0,16	0,2	0,24	0,30	0,35
Stainless steel		X5 CrNi 18 9 (V2A)	25-50	0,10	0,12	0,14	0,16	0,20	0,28
		X10 CrNiMoTi 18 10							
Cast iron	< 200 HB	GG20, GG25, GTS45	70-90	0,22	0,28	0,34	0,38	0,44	0,50
	< 250 HB	GG30, GTW40	60-80	0,20	0,25	0,30	0,35	0,40	0,45
	>250 HB	GG40, GTS70	55-75	0,20	0,25	0,30	0,35	0,40	0,45
	< 600 N/mm²	GGG40, GGG50	60-75	0,20	0,25	0,30	0,35	0,40	0,45
	> 600 N/mm²	GGG60,GGV (CGI)	50-65	0,18	0,22	0,25	0,30	0,35	0,40
Aluminium / brass copper / bronze		AlCuMgPb, AlMgSi 0.5	120-200	0,18	0,24	0,30	0,35	0,40	0,50
		GD-AlSi9Cu3, AlSi7Mg0.6	120-200	0,18	0,24	0,30	0,35	0,40	0,50
		GB.AlSi12(Cu)	100-180	0,18	0,24	0,30	0,35	0,40	0,50
			80-150	0,18	0,24	0,30	0,35	0,40	0,50
Titanium / Inconel alloys		Ti6Al4V	20-35	0,08	0,12	0,14	0,16	0,20	0,25
		Inconel, Monel, Hasteloy	20-30	0,07	0,10	0,12	0,15	0,18	0,22

DEEPDRILL U6

D18720 - D18730

Mat.	Pull [N/mm²]	Bijvoorbeeld	Vc* M/min	Voeding/Omw. f					
				Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Steel	< 600 N/mm²	St37, C22, GS38	90-110	0,15	0,20	0,25	0,30	0,36	0,40
	< 700 N/mm²	St52, C35, GS52	90-110	0,15	0,20	0,25	0,30	0,36	0,40
	< 700 N/mm²	St70, C45, GS62	70-90	0,15	0,20	0,25	0,30	0,36	0,40
	< 900 N/mm²	16MnCr5, 42CrMo4	70-90	0,15	0,20	0,25	0,30	0,36	0,40
	< 1000 N/mm²	90MnCrV8, 100Cr6	60-75	0,14	0,18	0,22	0,26	0,30	0,35
	> 1000 N/mm²	X210Cr12, 34CrAlNi7	60-75	0,12	0,16	0,2	0,24	0,30	0,35
Stainless steel									
		X5 CrNi 18 9 (V2A)	50-70	0,10	0,12	0,14	0,16	0,20	0,28
		X10 CrNiMoTi 18 10	50-70						
Cast iron	< 200 HB	GG20, GG25, GTS45	75-90	0,22	0,28	0,34	0,38	0,44	0,50
	< 250 HB	GG30, GTW40	75-90	0,20	0,25	0,30	0,35	0,40	0,45
	>250 HB	GG40, GTS70	60-75	0,20	0,25	0,30	0,35	0,40	0,45
	< 600 N/mm²	GGG40, GGG50	60-75	0,20	0,25	0,30	0,35	0,40	0,45
	> 600 N/mm²	GGG60,GGV (CGI)	60-75	0,18	0,22	0,25	0,30	0,35	0,40





TECHNISCHE GEGEVENS

TECHNICAL DATA

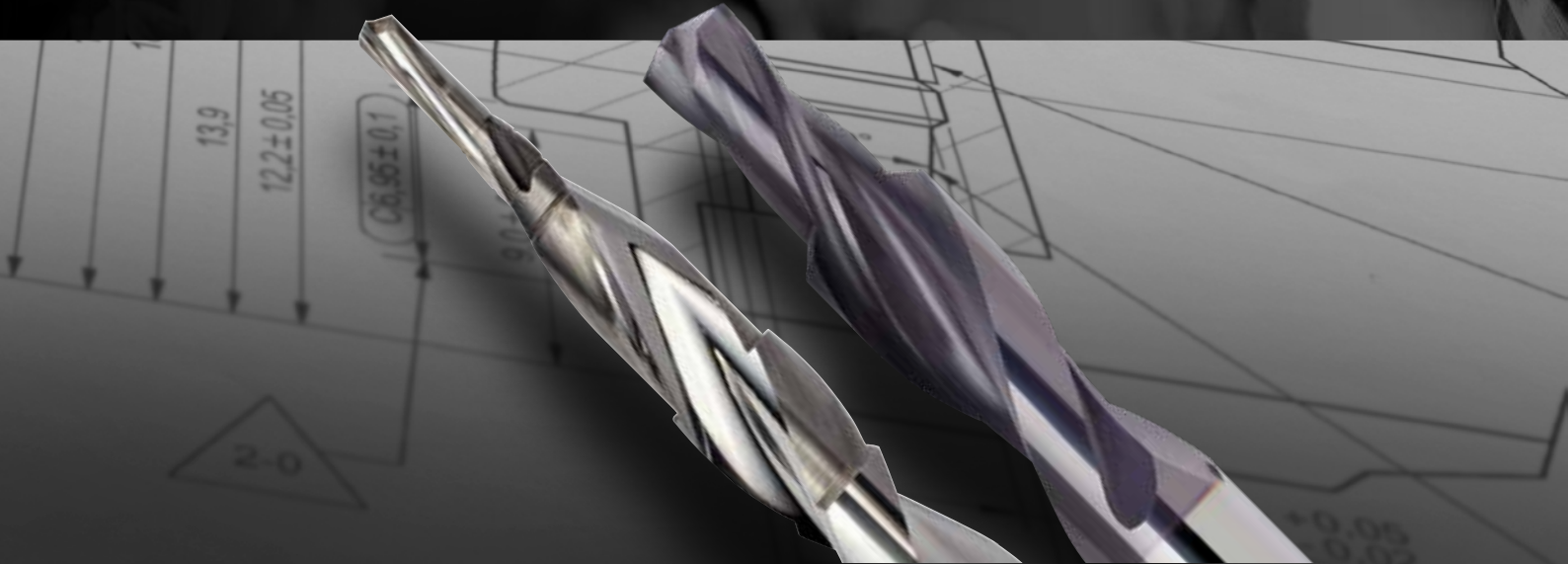
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Specials

Custom made



VHM special tools

Wij zijn uw juiste partner voor speciale boren en frezen, verzinken en ruimen. Wij produceren op zeer moderne CNC slijpcentra ieder type special voor uw toepassing.

Profiteer van onze jarenlange ervaring en zeer snelle levertijden tegen zeer aantrekkelijke prijzen. Wij slijpen de voor u beste geometrie, op het beste hardmetaal voorzien van de nieuwste generaties High-End coatings!

48-uur Special service

In overleg bieden wij als topservice een 48-uurs spoeddienst. Als de special voorzien moet worden van coating zijn we gebonden aan een extra levertijd van circa 3 werkdagen. Alle specials kunnen voorzien worden van een meet-rapport.

Project engineering

Naast het leveren van standaardgereedschappen leggen wij ons toe op project engineering. Dit houdt in dat wij samen met u onderzoeken of uw productieproces geoptimaliseerd kan worden door bijvoorbeeld het inzetten van veel snellere gereedschappen. Ook kunnen we uw beweringsstrategie onder de loep nemen om zo uw productie te optimaliseren.

Solid carbide custom made tools

We are your right partner for custom made tools. We produce every type of special for your custom application on the latest modern CNC grinders.

Benefit from our years of experience and very fast delivery times at attractive prices. We grind the best geometry, on the best carbide with the latest generations of High-end coatings. Also we can supply the endmills with the latest drag-finishing technology for edge preparation!

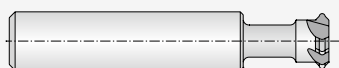
48-hours delivery!

In consultation, we offer a 48-hour emergency service as top service. If the special needs to be provided with a coating then the delivery is a few days later. We can also provide the custom made tool with a measuring report.

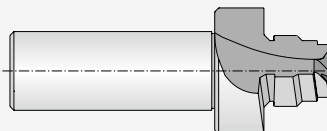
Project engineering

In addition to supplying standard endmills we also apply to project engineering. This means that together with you we will investigate whether a production process can be optimized by applying adapted endmills that have been specifically produced. We can also examine your machining strategy to optimize your production process

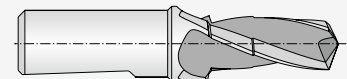
Voorbeeld 1 - Example 1



Voorbeeld 2 - Example 2



Voorbeeld 3 - Example 3



SAACKE

Herslijpen & hercoaten

Re-sharpening & re-coating

Herslijpen & hercoaten

Om zeker te zijn van een 100% goede frees/boor bieden wij u tegen zeer aantrekkelijke prijzen een herslijpservice aan. Middels een herslijpformulier kunt u uw gereedschappen naar ons sturen en kunt u uw tools in topconditie terugverwachten. Wij weten als geen ander volgens welke geometrie de tools moeten worden geslepen. Zo haalt u economisch het meeste voordeel uit onze tools. Vraag naar onze prijzen!

Re-sharpening & re-coating

In order to be sure of a 100% good endmill after resharping, we offer you a re-sharpening service. You can send us the endmills by packet service and you can expect a 100% good re-sharpened endmill. We know the geometry of the endmills like no other. This is how you get the most economic benefit from our endmill cutters.



Materiaallijst

List of materials

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
P1.1	Free - machining steels					
	> 500	9			1.0711	9 S 20
	380 - 570	8			1.0715	9 SMn 28
	380 - 570	8			1.0718	9 SMnPb 28
	360 - 530	9			1.0721	10 S 20
	360 - 530	9			1.0722	10 SPb 20
	380 - 570	8			1.0723	15 S 20
	390 - 590	7			1.0736	9 SMn 36
	390 - 580	7			1.0737	9 SMnPb 36
	580 - 730	8			1.0726	35 S 20
	660 - 800	7			1.0727	45 S 20
	740 - 880	7			1.0728	60 S 20
P1.1	Alloyed structural steels					
	440 - 590	24			1.5415	15 Mo 3
	450 - 590	21			1.5423	16 Mo 5
	490 - 640	20			1.5622	14 Ni 6
	530 - 710	20			1.5680	12 Ni 19
	450 - 660	20			1.7335	13 CrMo 4 4
	540 - 690	20			1.7337	16 CrMo 4 4
	480 - 630	18			1.7380	10 CrMo 9 10
	700 - 850	16			1.7709	21 CrMoV 5 7
	490 - 640	20			1.7715	14 MoV 6 3
P1.1	Construction steels					
	> 500	25			1.0037	St 37 - 2
	410 - 560	21			1.0044	St 44 - 2
	340 - 470	25			1.0116	St 37 - 3
	410 - 560	21			1.0144	St 44 - 3
	470 - 610	19			1.0050	St 50 - 2
	490 - 630	21			1.0570	St 52 - 3
	570 - 710	15			1.0060	St 60 - 2
	340 - 470	25		< 82	1.0038	RSt37 - 2
P1.2	Steel castings					
	> 380	25			1.0420	GS - 38
	700 - 800				1.1118	GS - 24 Mn 6
	480 - 620	20			1.1120	GS - 20 Mn 5
	> 500	22			1.5419	GS - 22 Mo 4
	> 500				1.5633	GS - 24 Ni 8
	> 500				1.5681	GS - 10 Ni 19
	> 500				1.6309	GS - 20 Mn MoNi 5 5
	> 850	10			1.6582	GS - 34 CrNiMo 6
	> 800	11			1.6748	GS - 40 NiCrMo 6 5 6
	> 800				1.6750	GS - 20 NiCrMo 3 7
	> 800				1.6760	GS - 22 NiMoCr 5 6

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
P1.2	490 - 640	20			1.7357	GS - 17 CrMo 5 5
	> 500	18			1.7379	GS - 18 CrMo 9 10
P1.1	Case hardening steels					
	> 500	15		< 82	1.0301	C 10
	> 500	13		< 82	1.0401	C 15
	> 500	14		< 82	1.1121	CK 10
	> 500	13		< 82	1.1141	CK 15
	> 500	15		< 82	1.7012	13 Cr 2
	500 - 700	10		82 - 96	1.7015	15 Cr 3
	500 - 700	11		82 - 96	1.5732	14 NiCr 10
	700 - 850	10	< 24		1.5752	14 NiCr 14
	700 - 850	7	< 24		1.5860	14 NiCr 18
	700 - 850	9	< 24		1.5919	15 CrNi 6
	700 - 850	7	< 24		1.5920	18 NiCr 8
	700 - 850	10	< 24		1.6523	21 NiCrMo 2
	700 - 850	8	< 24		1.6587	17 CrNiMo 6
	700 - 850	10	< 24		1.7131	16 MnCr 5
	700 - 850	10	< 24		1.7139	16 MnCrS 5
	700 - 850	8	< 24		1.7147	20 MnCr 5
	700 - 850	8	< 24		1.7149	20 MnCrS 5
	700 - 850	10	< 24		1.7262	15 CrMo 5
	700 - 850	8	< 24		1.7264	20 CrMo 5
	700 - 850	8	< 24		1.7271	23 CrMoB 3 3
	500 - 700	10	< 24		1.7311	20 CrMo 2
	700 - 850	10	< 24		1.7321	20 MoCr 4
	700 - 850	10	< 24		1.7323	20 MoCrS 4
	700 - 850	8	< 24		1.7325	25 MoCr 4
	700 - 850	8	< 24		1.7326	25 MoCrS 4
	< 500	13		< 82	1.0402	C22
P2.1	Spring steels					
	< 850	6	< 24		1.0904	55 Si 7
	< 850	6	< 24		1.0961	60 SiCr 7
	< 850	6	< 24		1.1231	CK 67
	< 850	6	< 24		1.1248	CK 75
	< 850	6	< 24		1.1274	CK 101
	< 850	5	< 24		1.7103	67 SiCr 5
	< 850	6	< 24		1.7176	55 Cr 3
	< 850	10	< 24		1.8159	50 CrV 4
	< 850	6	< 24		1.5026	55 Si 7
P2.2	Alloyed heat - treatable steels					
	< 800	22	< 21		1.1133	20 Mn 5
	< 800	11	< 21		1.7735	14 CrMoV 6 9
	< 800		< 21		1.3505	100 Cr 6

Materiaallijst

List of materials

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
P2.2	< 800	12	< 21		1.5120	38 MnSi 4
	< 800	12	< 21		1.5121	46 MnSi 4
	< 800	12	< 21		1.5141	53 MnSi 4
	< 800	13	< 21		1.5710	36 NiCr 6
	< 800		< 21		1.6546	40 NiCrMo 2 2
	< 800		< 21		1.6565	40 NiCrMo 6
	< 800	14	< 21		1.7003	38 Cr 2
	< 800	12	< 21		1.7006	46 Cr 2
	< 800	15	< 21		1.7020	32 Cr 2
	< 800	14	< 21		1.7030	28 Cr 4
	< 800	14	< 21		1.7033	34 Cr 4
	< 800	14	< 21		1.7218	25 CrMo 4
	< 800	12	< 21		1.7220	34 CrMo 4
	< 800	10	< 21		1.7223	41 CrMo 4
	< 800	10	< 21		1.7225	42 CrMo 4
	< 800	9	< 21		1.7228	50 CrMo 4
	> 800 - 1000	12	> 21 -30		1.1157	40 Mn 4
	> 800 - 1000	14	> 21 -30		1.1165	30 Mn 5
	> 800 - 1000	10	> 21 -30		1.1167	36 Mn 5
	> 800 - 1000	13	> 21 -30		1.1170	28 Mn 5
	> 800 - 1000	12	> 21 -30		1.3561	44 Cr 2
	> 800 - 1000	12	> 21 -30		1.3563	43 CrMo 4
	> 800 - 1000	11	> 21 -30		1.3565	48 CrMo 4
	> 800 - 1000	12	> 21 -30		1.5120	38 MnSi 4
	> 800 - 1000	12	> 21 -30		1.5121	46 MnSi 4
	> 800 - 1000	12	> 21 -30		1.5122	37 MnSi 4
	> 800 - 1000	11	> 21 -30		1.5131	50 MnSi 4
	> 800 - 1000	12	> 21 -30		1.5141	53 MnSi 4
	> 800 - 1000	11	> 21 -30		1.5223	42 MnV 7
	> 800 - 1000	13	> 21 -30		1.5710	36 NiCr 6
	> 800 - 1000	12	> 21 -30		1.5736	36 NiCr 10
	> 800 - 1000	11	> 21 -30		1.5755	31 NiCr 14
	> 800 - 1000	11	> 21 -30		1.6511	36 CrNiMo 4
	> 800 - 1000	13	> 21 -30		1.6513	28 NiCrMo 4
	> 800 - 1000	14	> 21 -30		1.7003	38 Cr 2
	> 800 - 1000	13	> 21 -30		1.7006	46 Cr 2
	> 800 - 1000	12	> 21 -30		1.7030	28 Cr 4
	> 800 - 1000	14	> 21 -30		1.7033	34 Cr 4
	> 800 - 1000	13	> 21 -30		1.7034	37 Cr 4
	> 800 - 1000	12	> 21 -30		1.7035	41 Cr 4
	> 800 - 1000	14	> 21 -30		1.7218	25 CrMo 4
	> 800 - 1000	14	> 21 -30		1.7220	34 CrMo 4
	> 800 - 1000		> 21 -30		1.7223	41 CrMo 4
	> 800 - 1000	12	> 21 -30		1.7225	42 CrMo 4
	> 800 - 1000	13	> 21 -30		1.7228	50 CrMo 4
	> 800 - 1000	13	> 21 -30		1.7561	42 CrV 6

<i>Code</i>	<i>Rm N/mm²</i>	<i>A 5 %</i>	<i>HRC</i>	<i>HB</i>	<i>Mat. - Nr.</i>	<i>DIN</i>
P2.2	> 800 - 1000	11	> 21 -30		1.7735	14 CrMoV 6 9
	> 800 - 1000	10	> 24 -30		1.8159	50 CrV 4
P2.3	Alloyed heat - treatable steels					
	> 1000 - 1300	10	> 30 -40		1.3563	43 CrMo 4
	> 1000 - 1300	9	> 30 -40		1.3565	48 CrMo 4
	> 1000 - 1300	11	> 30 -40		1.5120	38 MnSi 4
	> 1000 - 1300	11	> 30 -40		1.5121	46 MnSi 4
	> 1000 - 1300	11	> 30 -40		1.5122	37 MnSi 4
	> 1000 - 1300	10	> 30 -40		1.5223	42 MnV 7
	> 1000 - 1300	11	> 30 -40		1.5710	36 NiCr 6
	> 1000 - 1300		> 30 -40		1.5736	36 NiCr 10
	> 1000 - 1300	7	> 30 -40		1.5864	35 NiCr 18
	> 1000 - 1300	10	> 30 -40		1.6511	36 CrNiMo 4
	> 1000 - 1300	9	> 30 -40		1.6580	30 CrNiMo 8
	> 1000 - 1300	9	> 30 -40		1.6582	34 CrNiMo 6
	> 1000 - 1300	12	> 30 -40		1.7033	34 Cr 4
	> 1000 - 1300	11	> 30 -40		1.7034	37 Cr 4
	> 1000 - 1300	11	> 30 -40		1.7035	41 Cr 4
	> 1000 - 1300		> 30 -40		1.7045	42 Cr 4
	> 1000 - 1300	12	> 30 -40		1.7218	25 CrMo 4
	> 1000 - 1300	11	> 30 -40		1.7220	34 CrMo 4
	> 1000 - 1300	11	> 30 -40		1.7223	41 CrMo 4
	> 1000 - 1300	10	> 30 -40		1.7225	42 CrMo 4
	> 1000 - 1300	9	> 30 -40		1.7228	50 CrMo 4
	> 1000 - 1300	9	> 30 -40		1.7361	32 CrMo 12
	> 1000 - 1300	10	> 30 -40		1.7561	42 CrV 6
	> 1000 - 1300	9	> 30 -40		1.7707	30 CrMoV 9
	> 1000 - 1300	10	> 30 -40		1.7735	14 CrMoV 6 9
	> 1000 - 1300	9	> 30 -40		1.8159	50 CrV 4
	> 1000 - 1300	8	> 30 -40		1.8161	58 CrV 4
P2.2	Unalloyed heat - treatable steels					
	< 800	20	< 21		1.0402	C 22
	< 800	19	< 21		1.0406	C 25
	< 800	17	< 21		1.0501	C 35
	< 800	14	< 21		1.0503	C 45
	< 800	16	< 21		1.0511	C 40
	< 800	18	< 21		1.0528	C 30
	< 800	20	< 21		1.1151	Ck 22
	< 800	19	< 21		1.1158	Ck 25
	< 800	18	< 21		1.1178	Ck 30
	< 800	17	< 21		1.1181	Ck 35
	< 800	16	< 21		1.1186	Ck 40
	< 800	14	< 21		1.1191	Ck 45
	> 800 - 1000	12	> 21 -30		1.0535	C 55

Materiaallijst

List of materials

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
P2.2	> 800 - 1000	13	> 21 -30		1.0540	C 50
	> 800 - 1000	11	> 21 -30		1.0601	C 60
	> 800 - 1000	12	> 21 -30		1.1203	Ck 55
	> 800 - 1000	13	> 21 -30		1.1206	Ck 50
	> 800 - 1000	11	> 21 -30		1.1221	Ck 60
P4.2	Cold work tool steels					
	760		19		1.2067	100 Cr 6
	750		99	99	1.2101	62 SiMnCr 4
	760		19		1.2103	58 SiCr 8
	760		19		1.2108	90 CrSi 5
	720			97	1.2162	21 MnCr 5
	730			98	1.2210	115 CRV 3
	730			98	1.2330	35 CrMo 4
	750			99	1.2332	47 CrMo 4
	760		19		1.2419	105 WCr 6
	720			97	1.2510	100 MnCrW 4
	730			98	1.2516	120 W 4
	750			99	1.2542	45 WCrV 7
	750			99	1.2550	60 WCrV 7
	830		23		1.2721	50 NiCr 13
	670			95	1.2735	15 NiCr 14
	710			97	1.2762	75 CrMoNiW 6 7
	750			99	1.2826	60 MnSiCr 4
	760		19		1.2833	100 V 1
	730			98	1.2842	90 MnCrV 8
	830		23		1.2080	X 210 Cr 12
	380			63	1.2341	X 6 CrMo 4
	760		19		1.2363	X 100 CrMoV 5 1
	640 - 840	18			1.5662	X 8 Ni9
	760		19		1.2379	X 155 CrVMo12 1
	760		19		1.2436	X 210 CrW 12
	760		19		1.2601	X 165 CrMoV 12
P4.1	Unalloyed tool steels					
	640			93	1.1520	C 70 W 1
	640			93	1.1525	C 80 W 1
	640			93	1.1545	C 105 W 1
	640			93	1.1620	C 70 W 2
	640			93	1.1625	C 80 W 2
	640			93	1.1645	C 105 W 2
	660			94	1.1654	C 110 W
	710			97	1.1663	C 125 W
	760		19		1.1673	C 135 W
	640			93	1.1730	C 45 W
	760		19		1.1740	C 60 W

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
	730			98	1.1744	C 67 W
	730			98	1.1750	C 75 W
	570			88	1.1820	C 55 W
	750			99	1.1830	C 85 W
P3.1	Hot work tool steels					
	< 770				1.2311	40 CrMnMo 7
	< 770				1.2312	40 CrMnMoS 8 6
	< 770				1.2711	54 NiCrMoV 6
	< 800				1.2713	55 NiCrMoV 6
	< 800				1.2738	40 CrMnNiMo 8
	< 840				1.2744	57 NiCrMoV 77
	< 860				1.2764	X 19 NiCrMo 4
	< 870				1.2767	X 45 NiCrMo 4
	< 770				1.2083	X 42 Cr 13
	< 800				1.2343	X 38 CrMoV 5 1
	< 800				1.2344	X 40 CrMoV 5 1
	< 800				1.2365	X 32 CrMoV 3 3
	< 800				1.2567	X 30 WCrV 5 3
	< 800				1.2581	X 30 WCrV 9 3
	< 770				1.2885	X 32 CrMoV 3 3 3
	< 840				1.2316	X 36 CrMo 17
	1080	16	> 29		Toolox 33	
	1250	10	43		Hardox 400	
	1450	13	45		Toolox 44	
P3.2	Nitriding steels					
	< 1000	14	< 30		1.8504	34 CrAl 6
	< 1000	12	< 30		1.8506	34 CrAlS 5
	< 1000	14	< 30		1.8507	34 CrAlMo 5
	< 1000	12	< 30		1.8509	41 CrAlMo 7
	> 1000	10	> 30		1.8515	31 CrMo 12
	> 1000	9	> 30		1.8519	31 CrMoV 9
	> 1000	10	> 30		1.8521	15 CrMoV 5 9
	> 1000	8	> 30		1.8523	39 CrMoV 13 9
	> 1000	12	> 30		1.8550	34 CrAlNi 7
M1.1	Stainless steels - ferritic					
	400 - 600	17			1.4002	X 6 CrAl 13
	380 - 560	25			1.4512	X 5 CrTi 12
	400 - 600	19			1.4000	X 6 Cr 13
	450 - 600	18			1.4016	X 6 Cr 17
	500 - 700	12			1.4742	X 10 CrAlSi 18
	450 - 630	18			1.4113	X 6 CrMo 17
	420 - 600	23			1.4510	X 3 CrTi 17
	400 - 600	20			1.4521	X 2 CrMoTi 18-2

Materiaallijst

List of materials

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
M1.1	450 - 650	15			1.4724	X 10 CrAlSi 13
	520 - 720	15			1.4762	X 10 CrAl 24
M2.1	Stainless steels - austenitic					
	750 - 950	40			1.4372	X 12 CrMnNiN 17 - 7 - 5
	680 - 880	35			1.4373	X 12 CrMnNiN 18 - 9 - 5
	600 - 950	40			1.4310	X 10 CrNi 18 - 8; X 12 CrNi 17 7
	630 - 850	35			1.4318	X 2 CrNiN 18 - 7
	500 - 700	35			1.4305	X 10 CrNiS 18 9
	600 - 951	36			1.4350	X 5 CrNi 18 9
	520 - 720	45			1.4301	X 5 CrNi 18 9
	460 - 680	45			1.4306	X 2 CrNi 19 11
	550 - 750	40			1.4311	X 2 CrNiN 18 10
	510 - 710	45			1.4948	X 6 CrNi 18 - 11
	520 - 700	45			1.4307	X 2 CrNi 18 - 9
	500 - 750	40			1.4315	X 5 CrNiN 19 - 9
	500 - 650	45			1.4303	X 5 CrNi 18 - 12
	500 - 700	33			1.4833	X 12 CrNi 23 - 13
	500 - 700	33			1.4845	X 8 CrNi 25 - 21
	550 - 750	30			1.4841	X 15 CrNiSi 25 - 21
	520 - 680	40			1.4401	X 5 CrNiMo 18 10
	530 - 730	40			1.4436	X 5 CrNiMo 17 13 3
	520 - 680	40			1.4404	X 2 CrNiMo 17 13 2
	520 - 700	40			1.4435	X 2 CrNiMo 18 14 3
	520 - 700	40			1.4432	X 2 CrNiMo 17 - 12 - 3
	580 - 780	40			1.4406	X 2 CrNiMoN 17 12 2
	580 - 780	35			1.4429	X 2 CrNiMoN 17 13 3
	490 - 740	40			1.4573	X 10 CrNiMoTi 18 12
	520 - 690	40			1.4571	X 6 CrNiMoTi 17 12 2
	520 - 720	40			1.4580	X 6 CrNiMoNb 17 12 2
	550 - 700	35			1.4438	X 2 CrNiMo 18 16 4
	580 - 780	35			1.4439	X 2 CrNiMoN 17 - 13 - 5
	490 - 740	40			1.4583	X 10 CrNiMoNb 18 12
	500 - 720	40			1.4541	X 6 CrNiTi 18 10
	500 - 720	40			1.4878	X 8 CrNiTi 18 - 10
	500 - 720	40			1.4550	X 6 CrNiNb 18 10
	500 - 700	40			1.4563	X 1 NiCrMoCu 31 - 27 - 4
	520 - 730	35			1.4539	X 1 NiCrMoCu 25 - 20 - 5
	550 - 750	30			1.4864	X 12 NiCrSi 35 - 16
	620 - 880	20			1.4460	X 8 CrNiMo 27 5
	500 - 740	30			1.4546	X 5 CrNiNb 18 10
M3.1	Stainless steels - duplex					
	340 - 950	20			1.4462	X 2 CrNiMoN 22 - 5 - 3
	630 - 850	20			1.4362	X 2 CrNiN 23-4
	730 - 1000	15			1.4410	X 2 CrNiMoN 25 - 7 - 4

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
M3.1	730 - 1000	17			1.4507	X 2 CrNiMoCuN 25-6-3
	730 - 1000	17			1.4507	X 2 CrNiMoCuN 25-6-3
M1.2	Stainless steels - martensitic					
	> 600	20			1.4006	X 10 Cr 13
	650 - 850	12			1.4005	X 12 CrS 13
	> 700	15			1.4021	X 20 Cr 13
	> 740	15			1.4028	X 30 Cr 13
	> 760	12			1.4031	X 38 Cr 13
	> 780	12			1.4034	X 46 Cr 13
	> 850	12			1.4116	X 50 CrMoV 15
	> 900	12			1.4122	X 39 CrMo 17-1
	780 - 1100	11			1.4313	X 5 CrNi 13 4
	840 - 1100	14			1.4418	X 4 CrNiMo 6-5-1
	> 650	14			1.4024	X15Cr13
	640 - 840	11			1.4104	X 14 CrMoS 17
	750 - 950	14			1.4057	X 17 CrNi 16 2
					1.4747	X 80 CrNiSi 20
	< 900				1.4125	X 105 CrMo 17
M1.3	Stainless steels - hardened					
	> 1275	5			1.4542	X 5 CrNiCuNb 16 - 4
	> 1030	19			1.4568	X7CrNiAl 17 - 7
S2.1	Nickel-/Cobalt - alloys					
	900 - 1100	14			1.4718	X 45 CrSi 9 3
	500 - 750	30			1.4828	X 15 CrNiSi 20 12
	550 - 800	30			1.4841	X15 CrNiSi 25 20
	500 - 750	35			1.4845	X 12 CrNi 25 21
	550 - 800	30			1.4864	X 12 NiCrSi 36 16
	950 - 1200	8			1.4871	X 53 CrMnNiN 21 9
	500 - 750	30			1.4876	X 10 NiCrAlTi 33 20
	500 - 750	40			1.4878	X 12 CrNiTi 18 9
	500 - 700	35			2.4360	NiCu30Fe
	620 - 850	17			2.4375	NiCu30Al
	> 690	40			2.4685	G-NiMo28
	> 740	42			2.4610	NiMo16Cr16Ti
	> 760	40			2.4617	G-NiMo30
	700 - 800	26			2.4630; 2.4951	NiCr20Ti
	800 - 1000	12			2.4631	NiCr20TiAl
S2.2	Nickel-/Cobalt - alloys					
	1200	17			2.4632	NiCr20Co 1 8 Ti
	1180	25			2.4634	NiCo20Cr15MoAlTi
	< 770	15			2.4662	NiCr13Mo6Ti3

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List of materials

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
S2.2	900 - 1200				2.4670	
	900 - 1200				2.4674	
	1270	23			2.6554	
	890	50			2.4856	NiCr22Mo9Nb
S2.3	< 1400	25			2.4668	NiCr19FeNbMo
S1.1	Pure titanium, Titanium					
	290 - 410	30			3.7025	Ti99.5 / Ti Gr. 1
S1.2	380 - 540	20			3.7035	Ti99.4 / Ti Gr. 2
	460 - 590	18			3.7055	Ti99.3 / Ti Gr. 3
	540 - 740	16			3.7065	Ti99.2 / Ti Gr. 4
	390 - 540	20			3.7235	Ti 2 Pd / Ti Gr.2 Pd
S1.3	> 890	> 10			3.7165	TiAl6V482 / Ti Gr. 5
	> 1000	9			3.7185	TiAl 4 Mo 4 Sn 2
K1.1	Cast iron - lamellar graphite					
	100 - 200				0.6010	EN - JL 100 (GG - 10)
	150 - 250				0.6015	EN - JL 150 (GG - 15)
	200 - 300				0.6020	EN - JL 200 (GG - 20)
	250 - 350				0.6025	EN - JL 250 (GG - 25)
	300 - 400				0.6030	EN - JL 300 (GG - 30)
	350 - 450				0.6035	EN - JL 350 (GG - 35)
	400 - 500				0.6040	EN - JL Z (GG - 40)
	> 170				0.6655	GGL - NiCuCr 15 6 2
	> 170	2			0.6660	GGL - NiCr 20 - 2
	> 190	1			0.6676	GGL - NiCr 30 - 3
	> 170				0.6680	GGL - NiSiCr 30 - 5 - 5
K1.2	Cast iron - nodular graphite					
	370 - 400	14			0.7040	EN (-GJS - 400) 15
	420 - 500	7			0.7050	EN (-GJS - 500) 7
	550 - 600	3			0.7060	EN (-GJS - 600) 3
	660 - 700	2			0.7070	EN - GJS - 700 - 2 (GGG - 70)
	800	2			0.7080	EN - GJS - 800 - 2 (GGG - 80)
	370 - 480	7			0.7660	GGG - NiCr 20 2
	> 390	7			0.7661	GGG - NiCr 20 3
	370 - 450	20			0.7670	EN - GJSA - XNi22
	440 - 480	25			0.7673	EN - GJSA - XNiMn23 - 4
	370 - 480	7			0.7676	EN - GJSA - XNiCr30 - 3
	> 370	13			0.7677	GGG - NiCr 30 1
	390 - 500	1			0.7680	EN - GJSA - XNiSiCr 30 - 5 - 5
	370 - 420	20			0.7683	EN - GJSA - XNi35
	370 - 450	7			0.7685	EN - GJSA - XNiCr35 - 3

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
K1.3	Cast iron - vermicular graphite					
	300 - 375	1.5				EN - GJV 300
	350 - 425	1.5				EN - GJV 350
	400 - 475	1.0				EN - GJV 400
	450 - 525	1.0				EN - GJV 450
	500 - 575	0.5				EN - GJV 500
K2.1	Malleable cast iron					
	> 350	10			0.8135	EN - GJBM 350 - 10
	> 450	6			0.8145	EN - GJMB 450 - 6
	> 550	4			0.8155	EN - GJMB 550 - 4
	> 650	2			0.8165	EN - GJMB 650 - 2
	> 700	2			0.8170	EN - GJMB 700 - 2
	270 - 360	3			0.8035	EN - GJMW - 350 - 4
	300 - 420	4			0.8040	EN - GJMW - 400 - 5
	330 - 480	4			0.8045	EN - GJMW - 450 - 7
	490 - 570	3			0.8055	EN - GJMW - 550 - 4
K3.1	Hard casting					
	< 1400		< 45		0.9620	GJH - X 260 NiCr 4 - 2
	< 1400		< 45		0.9625	GJH - X 330 NiCr 4 - 2
	< 1400		< 45		0.9630	GJH - X 300 CrNiSi 9 - 5 - 2
	< 1400		< 45		0.9635	GJH - X 300 CrMo 15 - 3
	1000	5				GJS - 1000 - 5
	1200	2				GJS - 1200 - 2
	1400	1				GJS - 1400 - 1
H1.1	Hardened steels					
	1250 - 1550	8	< 50		Weldox 1100	
H1.2	1600 - 1800		< 55		Hardox 500	
	1820 - 1900		< 55		Hardox 550	
	~ 1850		< 55		1.2713	55 NiCrMoV 6
H1.3	1995 - 2300		< 60		Armox 600T	
	~ 2100		< 60		1.2542	45 WCrV 7
H1.4			< 63		Ferro - Titanit	
			< 63		1.2379	X 155 CrVMo12 1
			< 66		HSSE	
			< 66		1.2436	X 210 CrW 12
N1.1	Aluminium unalloyed					
	65 - 150	< 40			3.0225	Al99.5
	40 - 100	< 33			3.0305	Al99.9

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List of materials

Code	Rm N/mm ²	A 5 %	HRC	HB	Mat. - Nr.	DIN
N1.1	Aluminium wrought alloys - not hardened					
	100 - 125	> 1			3.0505	AlMn0.5Mg0.5
	80 - 230	> 2			3.0515	AlMn 1
	115 - 290	4			3.0525	AlMn1Mg0.5
	100 - 205	> 4			3.3315	AlMg 1
	180 - 310	> 3			3.3535	AlMg 3
N1.2	Aluminium wrought alloys - hardened					
	150 - 400	> 2			3.1325	AlCuMg 1
	180 - 460	> 3			3.1355	AlCuMg 2
	130 - 360	> 2			3.2315	AlMgSi 1
	130 - 270	> 8			3.3206	AlMgSi 0.5
	120 - 300	> 2			3.3211	AlMg 1 SiCu
	410 - 490	> 3			3.4345	AlZnMgCu 0.5
	180 - 560	> 1			3.4365	AlZnMgCu 1.5
N1.2	Aluminium cast alloys Si < 5%					
	280 - 300	< 1			3.2134	G - AlSiCu 1 Mg
	140 - 300	> 2			3.3241	G - AlMg3Si
	200	1			3.3292	GD - AlMg9
	140 - 210	> 4			3.3541	GD - AlMg3
N1.4	Aluminium cast alloys Si < 5 - 12%					
	160 - 200	1			3.2161	G - AlSi8Cu3
	230 - 360	> 2			3.2373	G - AlSi9Mg
	240 - 350	< 3			3.2163	G - AlSi9Cu3
	150 - 340	> 1			3.2381	G - AlSi10Mg
	160	1			3.2383	G - AlSi10Mg (Cu)
	150 - 170	5			3.2581	G - AlSi 1 2
	150 - 290	> 1			3.2583	G - AlSi 1 2 (Cu)
N1.5	Aluminium cast alloys Si > 12%					
	165 - 370	< 1				G - AlSi 17 Cu 4 Mg
	180 - 220	< 1				G - AlSi 18 CuNiMg
	200 - 240	< 1				G - AlSi 21 CuNiMg
	230 - 300	< 1.5				G - AlSi 25 CuNiMg
N2.1	Pure copper, low alloyed copper					
	< 600	> 10			2.0240	CuZn15
	< 800	> 10			2.0265	CuZn30
N2.2	Copper-zinc alloys (brass) (long chipping)					
	< 800	> 10			2.0321	CuZn37
	< 800	> 12			2.0335	CuZn36
	340 - 480	25			2.0360	CuZn40

<i>Code</i>	<i>Rm N/mm²</i>	<i>A 5 %</i>	<i>HRC</i>	<i>HB</i>	<i>Mat. - Nr.</i>	<i>DIN</i>
N2.2	Copper-zinc alloys (brass) (short chipping)					
	340 - 570	> 11			2.0401	CuZn39Pb3
N2.4	Copper-tin alloys (bronze) (long-chipping)					
	< 900	50			2.1016	CuSn4
	390 - 620	> 15			2.1030	CuSn8P
N2.3	Copper-zinc alloys (bronze) (short-chipping)					
	200 - 250	6			2.1097	G - CuSn5ZnPb
	230 - 320	12			2.1090.01	G - CuSn7ZnPb
	280	18			2.1086.01	G - CuSn10Zn
	600 - 650	7			2.0975	G - CuAl10Ni
N2.5	Copper-Aluminium alloys					
	> 550	40			Ampco 8	
	> 750	1			Ampco 21	
	> 500	0			Ampco 25	
	> 810	15			Ampco 45	
	> 1000	8			Ampco M-4	
N3.1	Magnesium, wrought alloys					
	> 270	6			3.5612	MgAl 6 Zn
	> 240	2			3.5912	G - MgAl9Zn 1
N4.1	Synthetics					
					Bakelit	
					Pertinax	
N4.2					PMMA	
					POM	
					PVC	
N4.3	Fibre - reinforced synthetics					
	155 - 365				GFK	Fibreglass
	190 - 210				CFK uni.	Carbon fibre
	190 - 210				CFK multi.	Carbon fibre
					AFK	Aramide fibre
					BFK	Bore fibre
					MFK	Metal fibre
					SFK	Synthetic fibre
N4.5	Sandwich					
					P - M - H	Plastic-Metal-Wood
					Honeycomb	
					Metal	

Notes

Notes

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