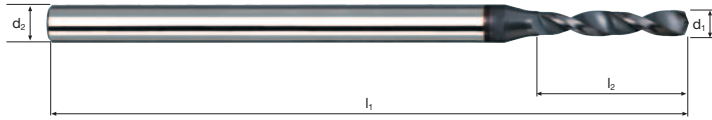
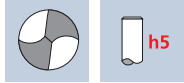
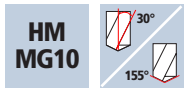


Mikrobohrer Microdrill NX

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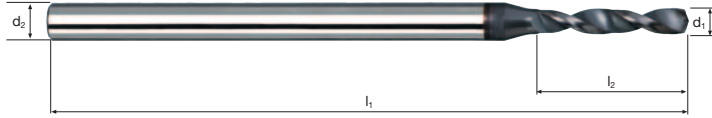
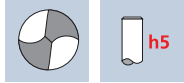
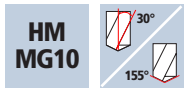


Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless		GG(G) Aluminium
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Beispiel: Bestell-Nr.							Artikel-Nr. B57014 α-Code .0020		DURO-SD
∅ Code	d1 m7	d2 h5	l1	l2	L _{max}				
.0020	0.20	3	42	1.3	1.0			●	
.0025	0.25	3	42	1.6	1.2			●	
.0030	0.30	3	42	2.0	1.6			●	
.0035	0.35	3	42	2.3	1.8			●	
.0040	0.40	3	42	2.6	2.0			●	
.0045	0.45	3	42	2.9	2.2			●	
.0050	0.50	3	42	3.3	2.6			●	
.0055	0.55	3	42	3.6	2.8			●	
.0060	0.60	3	42	3.9	3.0			●	
.0065	0.65	3	42	4.2	3.2			●	
.0070	0.70	3	42	4.6	3.6			●	
.0075	0.75	3	42	4.9	3.8			●	
.0080	0.80	3	42	5.2	4.0			●	
.0085	0.85	3	42	5.5	4.2			●	
.0087	0.87	3	42	5.7	4.4			●	
.0090	0.90	3	42	5.9	4.6			●	
.0095	0.95	3	42	6.2	4.8			●	
.0100	1.00	3	42	6.5	5.0			●	
.0105	1.05	3	42	6.8	5.2			●	
.0107	1.07	3	42	7.0	5.4			●	

Mikrobohrer Microdrill NX

5xd



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless		GG(G) Aluminium
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Beispiel: Bestell-Nr.							Artikel-Nr. B57014 α-Code .0110		DURO-SD
ø Code	d1 m7	d2 h5	l1	l2	L _{max}				
.0110	1.10	3	42	7.2	5.6			●	
.0115	1.15	3	42	7.5	5.8			●	
.0120	1.20	3	42	7.8	6.0			●	
.0125	1.25	3	42	8.1	6.2			●	
.0130	1.30	3	42	8.5	6.6			●	
.0135	1.35	3	42	8.8	6.8			●	
.0140	1.40	3	42	9.1	7.0			●	
.0142	1.42	3	42	9.2	7.1			●	
.0145	1.45	3	42	9.4	7.2			●	
.0150	1.50	3	42	9.8	7.6			●	
.0155	1.55	3	42	10.1	7.8			●	
.0160	1.60	3	42	10.4	8.0			●	
.0162	1.62	3	42	10.5	8.1			●	
.0165	1.65	3	42	10.7	8.2			●	
.0170	1.70	3	42	11.1	8.6			●	
.0175	1.75	3	42	11.4	8.8			●	
.0180	1.80	3	42	11.7	9.0			●	
.0185	1.85	3	50	12.0	9.2			●	
.0190	1.90	3	50	12.4	9.6			●	
.0195	1.95	3	50	12.7	9.8			●	

Anwendung



Werkstoff

Stahl
< 500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
1.10	100	0.022	28935	635	0.5	0.5
1.20	100	0.024	26525	635	0.5	0.6
1.30	100	0.026	24485	635	1.0	0.6
1.40	100	0.028	22735	635	1.0	0.7
1.50	100	0.030	21220	635	1.0	0.7
1.60	100	0.032	19895	635	1.5	0.8
1.70	100	0.034	18725	635	1.5	0.8
1.80	100	0.036	17685	635	1.5	0.9
1.90	100	0.038	16755	635	2.0	0.9

Stahl
500 - 850 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
1.10	80	0.024	23150	555	0.5	0.6
1.20	80	0.027	21220	575	0.5	0.6
1.30	80	0.029	19590	570	1.0	0.7
1.40	80	0.031	18190	565	1.0	0.7
1.50	80	0.033	16975	560	1.0	0.8
1.60	80	0.036	15915	575	1.0	0.8
1.70	80	0.038	14980	570	1.5	0.9
1.80	80	0.040	14145	565	1.5	1.0
1.90	80	0.042	13405	565	1.5	1.0

Stahl
850 - 1100 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
1.10	40	0.017	11575	195	0.0	1.7
1.20	40	0.018	10610	190	0.0	1.9
1.30	40	0.020	9795	195	0.5	2.0
1.40	40	0.022	9095	200	0.5	2.1
1.50	40	0.023	8490	195	0.5	2.3
1.60	40	0.025	7960	200	0.5	2.4
1.70	40	0.026	7490	195	0.5	2.6
1.80	40	0.028	7075	200	0.5	2.7
1.90	40	0.029	6700	195	0.5	3.0

Nichtrostender Stahl
[Cr-Ni/1.4301]

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
1.10	30	0.017	8680	150	0.0	2.2
1.20	30	0.018	7960	145	0.0	2.5
1.30	30	0.020	7345	145	0.0	2.7
1.40	30	0.022	6820	150	0.0	2.8
1.50	30	0.023	6365	145	0.5	3.1
1.60	30	0.025	5970	150	0.5	3.2
1.70	30	0.026	5615	145	0.5	3.6
1.80	30	0.028	5305	150	0.5	3.6
1.90	30	0.029	5025	145	0.5	4.0

Werkstoff

Gusseisen
GG(G)

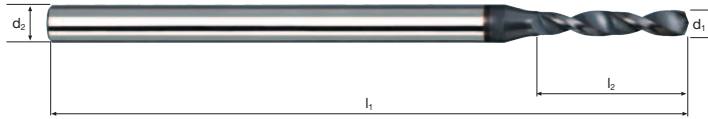
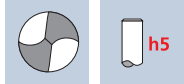
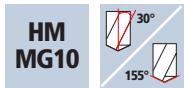
d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
1.10	130	0.024	37620	905	1.0	0.4
1.20	130	0.027	34485	930	1.0	0.4
1.30	130	0.029	31830	925	1.0	0.4
1.40	130	0.031	29555	915	1.5	0.5
1.50	130	0.033	27585	910	1.5	0.5
1.60	130	0.036	25865	930	2.0	0.5
1.70	130	0.038	24340	925	2.0	0.6
1.80	130	0.040	22990	920	2.5	0.6
1.90	130	0.042	21780	915	2.5	0.6

Al-Knetlegierung
Si < 6%

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
1.10	160	0.024	46300	1110	1.0	0.3
1.20	160	0.027	42440	1145	1.5	0.3
1.30	160	0.029	39175	1135	1.5	0.3
1.40	160	0.031	36380	1130	1.5	0.4
1.50	160	0.033	33955	1120	2.0	0.4
1.60	160	0.036	31830	1145	2.5	0.4
1.70	160	0.038	29960	1140	2.5	0.5
1.80	160	0.040	28295	1130	3.0	0.5
1.90	160	0.042	26805	1125	3.0	0.5

Mikrobohrer Microdrill NX

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Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless		GG(G) Aluminium
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Beispiel: Bestell-Nr.							Artikel-Nr. B57014 ø-Code .0200		DURO-SD
ø Code	d1 m7	d2 h5	l1	l2	L _{max}				
.0200	2.00	3	50	13.0	10.0			●	
.0205	2.05	3	50	13.3	10.2			●	
.0210	2.10	3	50	13.7	10.6			●	
.0215	2.15	3	50	14.0	10.8			●	
.0220	2.20	3	50	14.3	11.0			●	
.0225	2.25	3	50	14.6	11.2			●	
.0230	2.30	3	50	15.0	11.6			●	
.0235	2.35	3	50	15.3	11.8			●	
.0240	2.40	3	50	15.6	12.0			●	
.0245	2.45	3	50	15.9	12.2			●	
.0250	2.50	3	50	16.3	12.6			●	
.0255	2.55	3	50	16.6	12.8			●	
.0260	2.60	3	50	16.9	13.0			●	
.0265	2.65	3	50	17.2	13.2			●	
.0270	2.70	3	50	17.6	13.6			●	
.0275	2.75	3	50	17.9	13.8			●	
.0280	2.80	3	50	18.2	14.0			●	
.0285	2.85	3	50	18.5	14.2			●	
.0290	2.90	3	50	18.9	14.6			●	
.0295	2.95	3	50	19.2	14.8			●	

Anwendung



Werkstoff

Stahl
< 500 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
2.00	100	0.040	15915	635	2.0	0.9
2.10	100	0.042	15160	635	2.0	1.0
2.20	100	0.044	14470	635	2.5	1.0
2.35	100	0.047	13545	635	3.0	1.1
2.50	100	0.050	12730	635	3.0	1.2
2.60	100	0.052	12245	635	3.5	1.2
2.75	100	0.055	11575	635	4.0	1.3
2.85	100	0.057	11170	635	4.0	1.3
2.95	100	0.059	10790	635	4.5	1.4

Stahl
500 - 850 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
2.00	80	0.044	12730	560	2.0	1.1
2.10	80	0.047	12125	570	2.0	1.1
2.20	80	0.049	11575	565	2.0	1.2
2.35	80	0.052	10835	565	2.5	1.3
2.50	80	0.056	10185	570	3.0	1.3
2.60	80	0.058	9795	570	3.0	1.4
2.75	80	0.061	9260	565	3.5	1.5
2.85	80	0.063	8935	565	3.5	1.5
2.95	80	0.066	8630	570	4.0	1.6

Stahl
850 - 1100 N/mm²

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
2.00	40	0.031	6365	195	0.5	3.1
2.10	40	0.032	6065	195	0.5	3.2
2.20	40	0.034	5785	195	0.5	3.4
2.35	40	0.036	5420	195	1.0	3.6
2.50	40	0.038	5095	195	1.0	3.9
2.60	40	0.040	4895	195	1.0	4.0
2.75	40	0.042	4630	195	1.0	4.2
2.85	40	0.044	4470	195	1.0	4.4
2.95	40	0.045	4315	195	1.5	4.6

Nichtrostender Stahl
[Cr-Ni/1.4301]

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
2.00	30	0.031	4775	150	0.5	4.0
2.10	30	0.032	4545	145	0.5	4.3
2.20	30	0.034	4340	150	0.5	4.4
2.35	30	0.036	4065	145	0.5	4.9
2.50	30	0.038	3820	145	0.5	5.2
2.60	30	0.040	3675	145	1.0	5.4
2.75	30	0.042	3470	145	1.0	5.7
2.85	30	0.044	3350	145	1.0	5.9
2.95	30	0.045	3235	145	1.0	6.1

Werkstoff

Gusseisen
GG(G)

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
2.00	130	0.044	20690	910	3.0	0.7
2.10	130	0.047	19705	925	3.0	0.7
2.20	130	0.049	18810	920	3.5	0.7
2.35	130	0.052	17610	915	4.0	0.8
2.50	130	0.056	16550	925	4.5	0.8
2.60	130	0.058	15915	925	5.0	0.8
2.75	130	0.061	15045	920	5.5	0.9
2.85	130	0.063	14520	915	6.0	0.9
2.95	130	0.066	14025	925	6.5	1.0

Al-Knetlegierung
Si < 6%

d1 [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]	T [sek]
2.00	160	0.044	25465	1120	3.5	0.5
2.10	160	0.047	24250	1140	4.0	0.6
2.20	160	0.049	23150	1135	4.5	0.6
2.35	160	0.052	21670	1125	5.0	0.6
2.50	160	0.056	20370	1140	5.5	0.7
2.60	160	0.058	19590	1135	6.0	0.7
2.75	160	0.061	18520	1130	6.5	0.7
2.85	160	0.063	17870	1125	7.0	0.8
2.95	160	0.066	17265	1140	8.0	0.8

