

>> VHM-SPIRALBOHRER, KURZ, DIN 6539

Einsatzbereich:

Besonders geeignet zum Bohren von hochfesten Stählen, Cr-Ni-Stählen, Hartguss, Grauguss, Stahlguss, Mn-Hartstahl, Bronze, Aluminium mit hohem Siliziumanteil und anderen schwer zerspanbaren Werkstoffen.

SOLID CARBIDE STUB DRILLS, DIN 6539

Range of application:

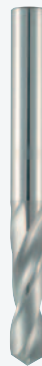
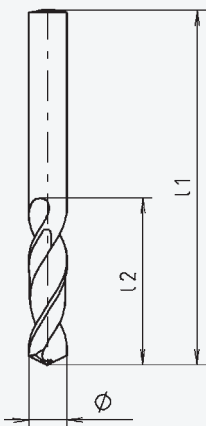
Especially suitable for drilling heat resistant steels, Cr-Ni steels, high carbon steel castings, grey cast iron, cast steels, manganese steels, bronze, aluminium with high percentage silicon and other difficult-to-machine materials.

PUNTE ELICOIDALI METALLO DURO INTEGRALE, SERIE CORTA, DIN 6539

Impiego:

Particolarmente adatte per foratura di acciai tenaci, acciai al Ni-Cr, ghisa conchigliata, ghisa grigia, acciaio fuso, acciai al manganese, bronzo, alluminio con elevato tenore di silicio, altri acciai di difficile lavorabilità.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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blank | bright | lucida



ALUNIT®

Ø _{h7} mm	L1 mm	L2 mm	Z	Code 6146 Art.-Nr.	€	Code 6147 Art.-Nr.	€
0,50	26	6	2	0 6146000501 00	8,78	0 6147000501 00	17,28
0,60	26	6	2	0 6146000601 00	8,78	0 6147000601 00	17,28
0,70	26	6	2	0 6146000701 00	8,78	0 6147000701 00	17,28
0,80	26	6	2	0 6146000801 00	6,58	0 6147000801 00	14,86
0,90	26	6	2	0 6146000901 00	6,58	0 6147000901 00	14,86
1,00	26	6	2	0 6146001001 00	4,39	0 6147001001 00	12,59
1,10	28	7	2	0 6146001101 00	5,53	0 6147001101 00	13,77
1,20	30	8	2	0 6146001201 00	5,53	0 6147001201 00	13,77
1,30	30	8	2	0 6146001301 00	5,53	0 6147001301 00	13,77
1,40	32	9	2	0 6146001401 00	5,53	0 6147001401 00	13,77
1,50	32	9	2	0 6146001501 00	5,53	0 6147001501 00	13,77
1,60	34	10	2	0 6146001601 00	6,06	0 6147001601 00	14,31
1,70	34	10	2	0 6146001701 00	6,06	0 6147001701 00	14,31
1,80	36	11	2	0 6146001801 00	6,06	0 6147001801 00	14,31
1,90	36	11	2	0 6146001901 00	6,06	0 6147001901 00	14,31
2,00	38	12	2	0 6146002001 00	5,53	0 6147002001 00	13,77
2,10	38	12	2	0 6146002101 00	6,06	0 6147002101 00	14,31
2,20	40	13	2	0 6146002201 00	6,58	0 6147002201 00	14,86
2,30	40	13	2	0 6146002301 00	6,58	0 6147002301 00	14,86
2,40	43	14	2	0 6146002401 00	7,10	0 6147002401 00	15,57
2,50	43	14	2	0 6146002501 00	6,58	0 6147002501 00	14,86
2,60	43	14	2	0 6146002601 00	8,25	0 6147002601 00	16,66
2,70	46	16	2	0 6146002701 00	9,93	0 6147002701 00	18,36
2,80	46	16	2	0 6146002801 00	9,93	0 6147002801 00	18,36
2,90	46	16	2	0 6146002901 00	9,93	0 6147002901 00	18,36

Hinweis:

Bis Ø 2,90 mm
4-Flächenanschliff,
ab Ø 3,00 mm
6-Flächenanschliff

Remark:

Up to Ø 2,90 mm
4-faced point shape,
beginning Ø 3,00 mm
6-faced point shape

Att:

Fino al Ø 2,90 mm
affilatura a 4 spoglie,
dal Ø 3,00 mm
affilatura a 6 spoglie



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>> VHM-SPIRALBOHRER, KURZ, DIN 6539

SOLID CARBIDE STUB DRILLS, DIN 6539

PUNTE ELICOIDALI METALLO DURO INTEGRALE, SERIE CORTA, DIN 6539

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Ø _{h7} mm	l1 mm	l2 mm	Z	blank bright lucida		ALUNIT®	
				Code 6146 Art.-Nr.	€	Code 6147 Art.-Nr.	€
3,00	46	16	2	0 6146003001 00	8,25	0 6147003001 00	16,66
3,10	49	18	2	0 6146003101 00	10,97	0 6147003101 00	19,52
3,20	49	18	2	0 6146003201 00	10,97	0 6147003201 00	19,52
3,30	49	18	2	0 6146003301 00	10,97	0 6147003301 00	19,52
3,40	52	20	2	0 6146003401 00	12,13	0 6147003401 00	20,61
3,50	52	20	2	0 6146003501 00	10,97	0 6147003501 00	19,52
3,60	52	20	2	0 6146003601 00	13,69	0 6147003601 00	22,33
3,70	52	20	2	0 6146003701 00	13,69	0 6147003701 00	22,33
3,80	55	22	2	0 6146003801 00	14,84	0 6147003801 00	23,51
3,90	55	22	2	0 6146003901 00	14,84	0 6147003901 00	23,51
4,00	55	22	2	0 6146004001 00	13,69	0 6147004001 00	22,33
4,10	55	22	2	0 6146004101 00	15,38	0 6147004101 00	24,06
4,20	55	22	2	0 6146004201 00	15,38	0 6147004201 00	24,06
4,30	58	24	2	0 6146004301 00	15,38	0 6147004301 00	24,06
4,40	58	24	2	0 6146004401 00	15,38	0 6147004401 00	24,06
4,50	58	24	2	0 6146004501 00	14,84	0 6147004501 00	23,51
4,60	58	24	2	0 6146004601 00	16,51	0 6147004601 00	25,24
4,70	58	24	2	0 6146004701 00	16,51	0 6147004701 00	25,24
4,80	62	26	2	0 6146004801 00	17,55	0 6147004801 00	28,08
4,90	62	26	2	0 6146004901 00	17,55	0 6147004901 00	28,08
5,00	62	26	2	0 6146005001 00	16,51	0 6147005001 00	27,02
5,10	62	26	2	0 6146005101 00	21,96	0 6147005101 00	32,70
5,20	62	26	2	0 6146005201 00	21,96	0 6147005201 00	32,70
5,30	62	26	2	0 6146005301 00	21,96	0 6147005301 00	32,70
5,40	66	28	2	0 6146005401 00	21,96	0 6147005401 00	32,70
5,50	66	28	2	0 6146005501 00	20,92	0 6147005501 00	31,53
5,60	66	28	2	0 6146005601 00	25,82	0 6147005601 00	36,74
5,70	66	28	2	0 6146005701 00	25,82	0 6147005701 00	36,74
5,80	66	28	2	0 6146005801 00	25,82	0 6147005801 00	36,74
5,90	66	28	2	0 6146005901 00	25,82	0 6147005901 00	36,74
6,00	66	28	2	0 6146006001 00	24,67	0 6147006001 00	35,48
6,10	70	31	2	0 6146006101 00	29,69	0 6147006101 00	44,14
6,20	70	31	2	0 6146006201 00	29,69	0 6147006201 00	44,14
6,30	70	31	2	0 6146006301 00	29,69	0 6147006301 00	44,14
6,40	70	31	2	0 6146006401 00	29,69	0 6147006401 00	44,14
6,50	70	31	2	0 6146006501 00	28,54	0 6147006501 00	42,96
6,60	70	31	2	0 6146006601 00	30,75	0 6147006601 00	45,21
6,70	70	31	2	0 6146006701 00	30,75	0 6147006701 00	45,21
6,80	74	34	2	0 6146006801 00	35,13	0 6147006801 00	49,89
6,90	74	34	2	0 6146006901 00	35,13	0 6147006901 00	49,89
7,00	74	34	2	0 6146007001 00	34,60	0 6147007001 00	49,36
7,10	74	34	2	0 6146007101 00	37,34	0 6147007101 00	52,15
7,20	74	34	2	0 6146007201 00	37,34	0 6147007201 00	52,15
7,30	74	34	2	0 6146007301 00	37,34	0 6147007301 00	52,15
7,40	74	34	2	0 6146007401 00	37,34	0 6147007401 00	52,15
7,50	74	34	2	0 6146007501 00	36,28	0 6147007501 00	51,01
7,60	79	36	2	0 6146007601 00	42,88	0 6147007601 00	59,06
7,70	79	36	2	0 6146007701 00	42,88	0 6147007701 00	59,06
7,80	79	36	2	0 6146007801 00	42,88	0 6147007801 00	59,06
7,90	79	36	2	0 6146007901 00	42,88	0 6147007901 00	59,06
8,00	79	36	2	0 6146008001 00	41,20	0 6147008001 00	57,35
8,10	79	36	2	0 6146008101 00	50,51	0 6147008101 00	68,24
8,20	79	36	2	0 6146008201 00	50,51	0 6147008201 00	68,24
8,30	79	36	2	0 6146008301 00	50,51	0 6147008301 00	68,24

Hinweis:

Bis Ø 2,90 mm
4-Flächenanschliff,
ab Ø 3,00 mm
6-Flächenanschliff

Remark:

Up to Ø 2,90 mm
4-faced point shape,
beginning Ø 3,00 mm
6-faced point shape

Att:

Fino al Ø 2,90 mm
affilatura a 4 spoglie,
dal Ø 3,00 mm
affilatura a 6 spoglie



Fortsetzung auf Seite I/6 | Continued on page I/6 | Segue a pagina I/6

>> VHM-SPIRALBOHRER, KURZ, DIN 6539

SOLID CARBIDE STUB DRILLS, DIN 6539

PUNTE ELICOIDALI METALLO DURO INTEGRALE, SERIE CORTA, DIN 6539

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Ø _{h7} mm	l1 mm	l2 mm	Z	blank bright lucida		ALUNIT®	
				Code 6146 Art.-Nr.	€	Code 6147 Art.-Nr.	€
8,40	79	36	2	0 6146008401 00	50,51	0 6147008401 00	68,24
8,50	79	36	2	0 6146008501 00	47,28	0 6147008501 00	64,76
8,60	84	40	2	0 6146008601 00	53,85	0 6147008601 00	71,57
8,70	84	40	2	0 6146008701 00	53,85	0 6147008701 00	71,57
8,80	84	40	2	0 6146008801 00	53,85	0 6147008801 00	71,57
8,90	84	40	2	0 6146008901 00	53,85	0 6147008901 00	71,57
9,00	84	40	2	0 6146009001 00	50,51	0 6147009001 00	68,24
9,10	84	40	2	0 6146009101 00	58,25	0 6147009101 00	76,18
9,20	84	40	2	0 6146009201 00	58,25	0 6147009201 00	76,18
9,30	84	40	2	0 6146009301 00	58,25	0 6147009301 00	76,18
9,40	84	40	2	0 6146009401 00	58,25	0 6147009401 00	76,18
9,50	84	40	2	0 6146009501 00	57,10	0 6147009501 00	74,99
9,60	89	43	2	0 6146009601 00	65,88	0 6147009601 00	84,18
9,70	89	43	2	0 6146009701 00	65,88	0 6147009701 00	84,18
9,80	89	43	2	0 6146009801 00	65,88	0 6147009801 00	84,18
9,90	89	43	2	0 6146009901 00	65,88	0 6147009901 00	84,18
10,00	89	43	2	0 6146010001 00	61,49	0 6147010001 00	79,68
10,20	89	43	2	0 6146010201 00	63,67	0 6147010201 00	83,65
10,50	89	43	2	0 6146010501 00	69,22	0 6147010501 00	89,40
10,80	95	47	2	0 6146010801 00	73,62	0 6147010801 00	93,91
11,00	95	47	2	0 6146011001 00	72,47	0 6147011001 00	92,84
11,50	95	47	2	0 6146011501 00	76,86	0 6147011501 00	97,46
12,00	102	51	2	0 6146012001 00	87,85	0 6147012001 00	111,20
12,50	102	51	2	0 6146012501 00	98,81	0 6147012501 00	124,90
13,00	102	51	2	0 6146013001 00	109,80	0 6147013001 00	136,40
13,50	107	54	2	0 6146013501 00	131,80	0 6147013501 00	159,40
14,00	107	54	2	0 6146014001 00	138,40	0 6147014001 00	166,20
14,50	111	56	2	0 6146014501 00	145,00		
15,00	111	56	2	0 6146015001 00	165,90		
15,50	115	58	2	0 6146015501 00	180,10		
16,00	115	58	2	0 6146016001 00	186,70		
16,50	119	60	2	0 6146016501 00	199,90		
17,00	119	60	2	0 6146017001 00	219,70		
17,50	123	62	2	0 6146017501 00	230,60		
18,00	123	62	2	0 6146018001 00	252,60		
18,50	127	64	2	0 6146018501 00	274,60		
19,00	127	64	2	0 6146019001 00	296,50		
19,50	131	66	2	0 6146019501 00	318,50		
20,00	131	66	2	0 6146020001 00	344,80		

Hinweis:

Bis Ø 2,90 mm
4-Flächenanschliff,
ab Ø 3,00 mm
6-Flächenanschliff

Remark:

Up to Ø 2,90 mm
4-faced point shape,
beginning Ø 3,00 mm
6-faced point shape

Att:

Fino al Ø 2,90 mm
affilatura a 4 spoglie,
dal Ø 3,00 mm
affilatura a 6 spoglie



>> VHM-SPIRALBOHRER, LANG, DIN 338

SOLID CARBIDE JOBBER DRILLS, DIN 338

PUNTE ELICOIDALI METALLO DURO INTEGRALE, SERIE LUNGA, DIN 338

Einsatzbereich:







Besonders geeignet zum Bohren von hochfesten Stählen, Cr-Ni-Stählen, Hartguss, Grauguss, Stahlguss, Mn-Hartstahl, Bronze, Aluminium mit hohem Siliziumanteil und anderen schwer zerspanbaren Werkstoffen.

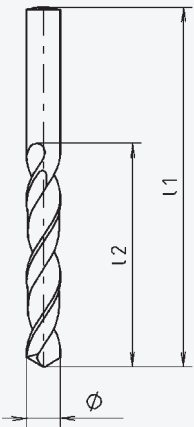
Range of application:

Especially suitable for drilling heat resistant steels, Cr-Ni steels, high carbon steel castings, grey cast iron, cast steels, manganese steels, bronze, aluminium with high percentage silicon and other difficult-to-machine materials.

Impiego:

Particolarmente adatte per foratura di acciai tenaci, acciai al Ni-Cr, ghisa conchigliata, ghisa grigia, acciaio fuso, acciai al manganese, bronzo, alluminio con elevato tenore di silicio, altri acciai di difficile lavorabilità.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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blank | bright | lucida



ALUNIT®

Ø _{h7} mm	L1 mm	L2 mm	Z	Code 6156 Art.-Nr.	€	Code 6157 Art.-Nr.	€
1,00	34	12	2	0 6156001001 00	5,53	0 6157001001 00	13,77
1,10	36	14	2	0 6156001101 00	6,06	0 6157001101 00	14,31
1,20	38	16	2	0 6156001201 00	6,58	0 6157001201 00	14,86
1,30	38	16	2	0 6156001301 00	6,58	0 6157001301 00	14,86
1,40	40	18	2	0 6156001401 00	6,58	0 6157001401 00	14,86
1,50	40	18	2	0 6156001501 00	6,06	0 6157001501 00	14,31
1,60	43	20	2	0 6156001601 00	7,74	0 6157001601 00	16,11
1,70	43	20	2	0 6156001701 00	7,74	0 6157001701 00	16,11
1,80	46	22	2	0 6156001801 00	7,74	0 6157001801 00	16,11
1,90	46	22	2	0 6156001901 00	7,74	0 6157001901 00	16,11
2,00	49	24	2	0 6156002001 00	8,25	0 6157002001 00	16,66
2,10	49	24	2	0 6156002101 00	8,78	0 6157002101 00	17,28
2,20	53	27	2	0 6156002201 00	9,93	0 6157002201 00	18,36
2,30	53	27	2	0 6156002301 00	9,93	0 6157002301 00	18,36
2,40	57	30	2	0 6156002401 00	9,93	0 6157002401 00	18,36
2,50	57	30	2	0 6156002501 00	10,97	0 6157002501 00	19,52
2,60	57	30	2	0 6156002601 00	12,65	0 6157002601 00	21,24
2,70	61	33	2	0 6156002701 00	14,84	0 6157002701 00	21,24
2,80	61	33	2	0 6156002801 00	14,84	0 6157002801 00	21,24
2,90	61	33	2	0 6156002901 00	14,84	0 6157002901 00	21,24
3,00	61	33	2	0 6156003001 00	12,65	0 6157003001 00	19,52
3,10	65	36	2	0 6156003101 00	14,84	0 6157003101 00	23,93
3,20	65	36	2	0 6156003201 00	14,84	0 6157003201 00	23,93
3,30	65	36	2	0 6156003301 00	14,84	0 6157003301 00	23,93
3,40	70	39	2	0 6156003401 00	16,51	0 6157003401 00	25,72

Hinweis:

Bis Ø 2,90 mm
4-Flächenanschliff,
ab Ø 3,00 mm
6-Flächenanschliff

Remark:

Up to Ø 2,90 mm
4-faced point shape,
beginning Ø 3,00 mm
6-faced point shape

Att:

Fino al Ø 2,90 mm
affilatura a 4 spoglie,
dal Ø 3,00 mm
affilatura a 6 spoglie



>> VHM-SPIRALBOHRER, LANG, DIN 338

SOLID CARBIDE JOBBER DRILLS, DIN 338

PUNTE ELICOIDALI METALLO DURO INTEGRALE, SERIE LUNGA, DIN 338

Fortsetzung von Seite I/7 | Continued from page I/7 |
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Ø _{h7} mm	l1 mm	l2 mm	Z	blank bright lucida		ALUNIT®	
				Code 6156 Art.-Nr.	€	Code 6157 Art.-Nr.	€
3,50	70	39	2	0 6156003501 00	14,84	0 6157003501 00	25,24
3,60	70	39	2	0 6156003601 00	18,09	0 6157003601 00	28,08
3,70	70	39	2	0 6156003701 00	18,09	0 6157003701 00	28,08
3,80	75	43	2	0 6156003801 00	19,23	0 6157003801 00	27,71
3,90	75	43	2	0 6156003901 00	19,23	0 6157003901 00	27,71
4,00	75	43	2	0 6156004001 00	18,09	0 6157004001 00	26,67
4,10	75	43	2	0 6156004101 00	23,11	0 6157004101 00	32,04
4,20	75	43	2	0 6156004201 00	23,11	0 6157004201 00	32,04
4,30	80	47	2	0 6156004301 00	23,11	0 6157004301 00	33,23
4,40	80	47	2	0 6156004401 00	23,11	0 6157004401 00	33,23
4,50	80	47	2	0 6156004501 00	20,92	0 6157004501 00	30,57
4,60	80	47	2	0 6156004601 00	24,67	0 6157004601 00	36,74
4,70	80	47	2	0 6156004701 00	24,67	0 6157004701 00	36,74
4,80	86	52	2	0 6156004801 00	26,35	0 6157004801 00	38,45
4,90	86	52	2	0 6156004901 00	26,35	0 6157004901 00	38,45
5,00	86	52	2	0 6156005001 00	24,67	0 6157005001 00	36,74
5,10	86	52	2	0 6156005101 00	30,75	0 6157005101 00	40,82
5,20	86	52	2	0 6156005201 00	30,75	0 6157005201 00	40,82
5,30	86	52	2	0 6156005301 00	30,75	0 6157005301 00	40,82
5,40	93	57	2	0 6156005401 00	32,93	0 6157005401 00	41,23
5,50	93	57	2	0 6156005501 00	31,26	0 6157005501 00	40,36
5,60	93	57	2	0 6156005601 00	35,67	0 6157005601 00	45,73
5,70	93	57	2	0 6156005701 00	35,67	0 6157005701 00	45,73
5,80	93	57	2	0 6156005801 00	35,67	0 6157005801 00	45,73
5,90	93	57	2	0 6156005901 00	35,67	0 6157005901 00	45,73
6,00	93	57	2	0 6156006001 00	34,60	0 6157006001 00	44,63
6,10	101	63	2	0 6156006101 00	41,20	0 6157006101 00	58,42
6,20	101	63	2	0 6156006201 00	41,20	0 6157006201 00	58,42
6,30	101	63	2	0 6156006301 00	41,20	0 6157006301 00	58,42
6,40	101	63	2	0 6156006401 00	41,20	0 6157006401 00	58,42
6,50	101	63	2	0 6156006501 00	39,52	0 6157006501 00	56,76
6,60	101	63	2	0 6156006601 00	43,92	0 6157006601 00	61,31
6,70	101	63	2	0 6156006701 00	43,92	0 6157006701 00	61,31
6,80	109	69	2	0 6156006801 00	49,46	0 6157006801 00	67,13
6,90	109	69	2	0 6156006901 00	49,46	0 6157006901 00	67,13
7,00	109	69	2	0 6156007001 00	48,30	0 6157007001 00	65,83
7,10	109	69	2	0 6156007101 00	56,04	0 6157007101 00	73,95
7,20	109	69	2	0 6156007201 00	56,04	0 6157007201 00	73,95
7,30	109	69	2	0 6156007301 00	56,04	0 6157007301 00	73,95
7,40	109	69	2	0 6156007401 00	56,04	0 6157007401 00	73,95
7,50	109	69	2	0 6156007501 00	54,36	0 6157007501 00	72,22
7,60	117	75	2	0 6156007601 00	64,21	0 6157007601 00	82,46
7,70	117	75	2	0 6156007701 00	64,21	0 6157007701 00	82,46
7,80	117	75	2	0 6156007801 00	64,21	0 6157007801 00	82,46
7,90	117	75	2	0 6156007901 00	64,21	0 6157007901 00	82,46
8,00	117	75	2	0 6156008001 00	60,44	0 6157008001 00	78,56
8,10	117	75	2	0 6156008101 00	75,82	0 6157008101 00	97,46
8,20	117	75	2	0 6156008201 00	75,82	0 6157008201 00	97,46
8,30	117	75	2	0 6156008301 00	75,82	0 6157008301 00	97,46
8,40	117	75	2	0 6156008401 00	75,82	0 6157008401 00	97,46
8,50	117	75	2	0 6156008501 00	70,79	0 6157008501 00	92,20
8,60	125	81	2	0 6156008601 00	79,59	0 6157008601 00	101,40
8,70	125	81	2	0 6156008701 00	79,59	0 6157008701 00	101,40
8,80	125	81	2	0 6156008801 00	79,59	0 6157008801 00	101,40

Fortsetzung auf Seite I/9 | Continued on page I/9 | Segue a pagina I/9



Hinweis:

Bis Ø 2,90 mm
4-Flächenanschliff,
ab Ø 3,00 mm
6-Flächenanschliff

Remark:

Up to Ø 2,90 mm
4-faced point shape,
beginning Ø 3,00 mm
6-faced point shape

Att:

Fino al Ø 2,90 mm
affilatura a 4 spoglie,
dal Ø 3,00 mm
affilatura a 6 spoglie

>> VHM-SPIRALBOHRER, LANG, DIN 338

SOLID CARBIDE JOBBER DRILLS, DIN 338

PUNTE ELICOIDALI METALLO DURO INTEGRALE, SERIE LUNGA, DIN 338

Fortsetzung von Seite I/8 | Continued from page I/8 |
Segue da pagina I/8

Ø _{h7} mm	l1 mm	l2 mm	Z	blank bright lucida		ALUNIT®	
				Code 6156 Art.-Nr.	€	Code 6157 Art.-Nr.	€
8,90	125	81	2	0 6156008901 00	79,59	0 6157008901 00	101,40
9,00	125	81	2	0 6156009001 00	75,82	0 6157009001 00	97,46
9,10	125	81	2	0 6156009101 00	87,32	0 6157009101 00	109,50
9,20	125	81	2	0 6156009201 00	87,32	0 6157009201 00	109,50
9,30	125	81	2	0 6156009301 00	87,32	0 6157009301 00	109,50
9,40	125	81	2	0 6156009401 00	87,32	0 6157009401 00	109,50
9,50	125	81	2	0 6156009501 00	85,65	0 6157009501 00	107,80
9,60	133	87	2	0 6156009601 00	98,81	0 6157009601 00	121,50
9,70	133	87	2	0 6156009701 00	98,81	0 6157009701 00	121,50
9,80	133	87	2	0 6156009801 00	98,81	0 6157009801 00	121,50
9,90	133	87	2	0 6156009901 00	98,81	0 6157009901 00	121,50
10,00	133	87	2	0 6156010001 00	92,24	0 6157010001 00	114,60
10,20	133	87	2	0 6156010201 00	95,58	0 6157010201 00	120,90
10,50	133	87	2	0 6156010501 00	103,80	0 6157010501 00	129,60
10,80	142	94	2	0 6156010801 00	110,40	0 6157010801 00	143,30
11,00	142	94	2	0 6156011001 00	107,70	0 6157011001 00	140,50
11,50	142	94	2	0 6156011501 00	115,40	0 6157011501 00	148,50
12,00	151	101	2	0 6156012001 00	131,80	0 6157012001 00	165,60
12,50	151	101	2	0 6156012501 00	148,30	0 6157012501 00	186,20
13,00	151	101	2	0 6156013001 00	164,70	0 6157013001 00	203,40
13,50	160	108	2	0 6156013501 00	197,70	0 6157013501 00	237,70
14,00	160	108	2	0 6156014001 00	208,70	0 6157014001 00	249,10
14,50	169	114	2	0 6156014501 00	234,00	0 6157014501 00	275,00
15,00	169	114	2	0 6156015001 00	248,70	0 6157015001 00	300,70
15,50	178	120	2	0 6156015501 00	270,20	0 6157015501 00	323,10
16,00	178	120	2	0 6156016001 00	280,10	0 6157016001 00	333,40

Hinweis:

Bis Ø 2,90 mm
4-Flächenanschliff,
ab Ø 3,00 mm
6-Flächenanschliff

Remark:

Up to Ø 2,90 mm
4-faced point shape,
beginning Ø 3,00 mm
6-faced point shape

Att:

Fino al Ø 2,90 mm
affilatura a 4 spoglie,
dal Ø 3,00 mm
affilatura a 6 spoglie



>> VHM-SPIRALBOHRER MIT 3 SCHNEIDEN, KURZ, DIN 6539

Einsatzbereich:

Besonders geeignet zum Bohren von Grauguss, kurzspanenden Metallen bis 1.300 N/mm² Festigkeit sowie Aluminium-Legierungen.

SOLID CARBIDE STUB DRILLS WITH 3 FLUTES, DIN 6539

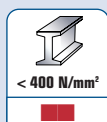

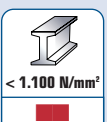
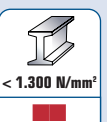
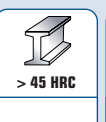
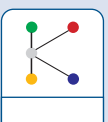
Range of application:

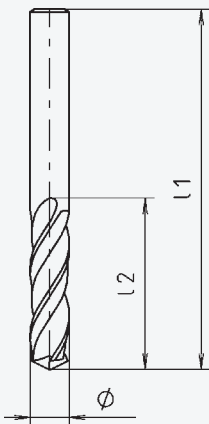
Especially suitable for drilling cast iron, short chipping metals up to 1.300 N/mm² tensile strength as well as aluminium-alloys.

PUNTE ELICOIDALI METALLO DURO INTEGRALE, 3 ELICHE, SERIE CORTA, DIN 6539

Impiego:

Particolarmente adatte per foratura di ghisa grigia, materiali a truciolo corto fino a 1.300 N/mm², leghe di alluminio.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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blank | bright | lucida



ALUNIT®

Ø _{h7} mm	L1 mm	L2 mm	Z	Code 6166 Art.-Nr.	€	Code 6167 Art.-Nr.	€
3,00	46	16	3	0 6166003001 00	12,65	0 6167003001 00	19,86
3,10	49	18	3	0 6166003101 00	14,84	0 6167003101 00	21,96
3,20	49	18	3	0 6166003201 00	14,84	0 6167003201 00	21,96
3,30	49	18	3	0 6166003301 00	14,84	0 6167003301 00	21,96
3,40	52	20	3	0 6166003401 00	16,51	0 6167003401 00	25,09
3,50	52	20	3	0 6166003501 00	14,84	0 6167003501 00	23,53
3,60	52	20	3	0 6166003601 00	18,09	0 6167003601 00	27,70
3,70	52	20	3	0 6166003701 00	18,09	0 6167003701 00	27,70
3,80	55	22	3	0 6166003801 00	19,23	0 6167003801 00	29,28
3,90	55	22	3	0 6166003901 00	19,23	0 6167003901 00	29,28
4,00	55	22	3	0 6166004001 00	20,92	0 6167004001 00	27,70
4,10	55	22	3	0 6166004101 00	23,11	0 6167004101 00	29,81
4,20	55	22	3	0 6166004201 00	23,11	0 6167004201 00	29,81
4,30	58	24	3	0 6166004301 00	23,11	0 6167004301 00	29,81
4,40	58	24	3	0 6166004401 00	23,11	0 6167004401 00	29,81
4,50	58	24	3	0 6166004501 00	22,47	0 6167004501 00	29,28
4,60	58	24	3	0 6166004601 00	24,67	0 6167004601 00	31,37
4,70	58	24	3	0 6166004701 00	24,67	0 6167004701 00	31,37
4,80	62	26	3	0 6166004801 00	26,35	0 6167004801 00	34,51
4,90	62	26	3	0 6166004901 00	26,35	0 6167004901 00	34,51
5,00	62	26	3	0 6166005001 00	24,67	0 6167005001 00	32,93
5,10	62	26	3	0 6166005101 00	30,75	0 6167005101 00	39,21
5,20	62	26	3	0 6166005201 00	30,75	0 6167005201 00	39,21
5,30	62	26	3	0 6166005301 00	30,75	0 6167005301 00	39,21
5,40	66	28	3	0 6166005401 00	30,75	0 6167005401 00	39,21



Hinweis:
6-Flächenanschliff

Remark:
6-faced point shape

Att:
6 spoglie

Fortsetzung auf Seite I/11 | Continued on page I/11 | Segue a pagina I/11

>> **VHM-SPIRALBOHRER MIT
3 SCHNEIDEN, KURZ,
DIN 6539**

**SOLID CARBIDE STUB
DRILLS WITH 3 FLUTES,
DIN 6539**

**PUNTE ELICOIDALI METALLO
DURO INTEGRALE, 3 ELICHE,
SERIE CORTA, DIN 6539**

Fortsetzung von Seite I/10 | Continued from page I/10 |
Segue da pagina I/10

Ø _{h7} mm	l1 mm	l2 mm	Z	blank bright lucida		ALUNIT®	
				Code 6166 Art.-Nr.	€	Code 6167 Art.-Nr.	€
5,50	66	28	3	0 6166005501 00	29,08	0 6167005501 00	37,65
5,60	66	28	3	0 6166005601 00	36,28	0 6167005601 00	43,92
5,70	66	28	3	0 6166005701 00	36,28	0 6167005701 00	43,92
5,80	66	28	3	0 6166005801 00	36,28	0 6167005801 00	43,92
5,90	66	28	3	0 6166005901 00	36,28	0 6167005901 00	43,92
6,00	66	28	3	0 6166006001 00	32,42	0 6167006001 00	40,78
6,10	70	31	3	0 6166006101 00	38,48	0 6167006101 00	49,67
6,20	70	31	3	0 6166006201 00	38,48	0 6167006201 00	49,67
6,30	70	31	3	0 6166006301 00	38,48	0 6167006301 00	49,67
6,40	70	31	3	0 6166006401 00	38,48	0 6167006401 00	49,67
6,50	70	31	3	0 6166006501 00	37,34	0 6167006501 00	48,64
6,60	70	31	3	0 6166006601 00	40,05	0 6167006601 00	51,23
6,70	70	31	3	0 6166006701 00	40,05	0 6167006701 00	51,23
6,80	74	34	3	0 6166006801 00	45,59	0 6167006801 00	56,45
6,90	74	34	3	0 6166006901 00	45,59	0 6167006901 00	56,45
7,00	74	34	3	0 6166007001 00	45,07	0 6167007001 00	55,95
7,10	74	34	3	0 6166007101 00	48,30	0 6167007101 00	59,60
7,20	74	34	3	0 6166007201 00	48,30	0 6167007201 00	59,60
7,30	74	34	3	0 6166007301 00	48,30	0 6167007301 00	59,60
7,40	74	34	3	0 6166007401 00	48,30	0 6167007401 00	59,60
7,50	74	34	3	0 6166007501 00	47,28	0 6167007501 00	58,04
7,60	79	37	3	0 6166007601 00	56,04	0 6167007601 00	67,44
7,70	79	37	3	0 6166007701 00	56,04	0 6167007701 00	67,44
7,80	79	37	3	0 6166007801 00	56,04	0 6167007801 00	67,44
7,90	79	37	3	0 6166007901 00	56,04	0 6167007901 00	67,44
8,00	79	37	3	0 6166008001 00	52,18	0 6167008001 00	63,80
8,10	79	37	3	0 6166008101 00	63,16	0 6167008101 00	75,82
8,20	79	37	3	0 6166008201 00	63,16	0 6167008201 00	75,82
8,30	79	37	3	0 6166008301 00	63,16	0 6167008301 00	75,82
8,40	79	37	3	0 6166008401 00	63,16	0 6167008401 00	75,82
8,50	79	37	3	0 6166008501 00	58,25	0 6167008501 00	71,10
8,60	84	40	3	0 6166008601 00	68,60	0 6167008601 00	81,04
8,70	84	40	3	0 6166008701 00	68,60	0 6167008701 00	81,04
8,80	84	40	3	0 6166008801 00	68,60	0 6167008801 00	81,04
8,90	84	40	3	0 6166008901 00	68,60	0 6167008901 00	81,04
9,00	84	40	3	0 6166009001 00	63,16	0 6167009001 00	75,82
9,10	84	40	3	0 6166009101 00	72,47	0 6167009101 00	84,72
9,20	84	40	3	0 6166009201 00	72,47	0 6167009201 00	84,72
9,30	84	40	3	0 6166009301 00	72,47	0 6167009301 00	84,72
9,40	84	40	3	0 6166009401 00	72,47	0 6167009401 00	84,72
9,50	84	40	3	0 6166009501 00	71,42	0 6167009501 00	83,66
9,60	89	43	3	0 6166009601 00	82,41	0 6167009601 00	94,12
9,70	89	43	3	0 6166009701 00	82,41	0 6167009701 00	94,12
9,80	89	43	3	0 6166009801 00	82,41	0 6167009801 00	94,12
9,90	89	43	3	0 6166009901 00	82,41	0 6167009901 00	94,12
10,00	89	43	3	0 6166010001 00	76,86	0 6167010001 00	88,89
10,20	89	43	3	0 6166010201 00	87,85	0 6167010201 00	101,50
10,50	89	43	3	0 6166010501 00	87,85	0 6167010501 00	101,50
10,80	95	47	3	0 6166010801 00	93,39	0 6167010801 00	106,70
11,00	95	47	3	0 6166011001 00	90,56	0 6167011001 00	104,10
11,50	95	47	3	0 6166011501 00	96,11	0 6167011501 00	109,30
12,00	102	51	3	0 6166012001 00	109,80	0 6167012001 00	125,00
12,50	102	51	3	0 6166012501 00	123,50	0 6167012501 00	140,20
13,00	102	51	3	0 6166013001 00	137,40	0 6167013001 00	153,20

Hinweis:
6-Flächenanschliff

Remark:
6-faced point shape

Att:
6 spoglie



>> VHM-SPIRALBOHRER MIT VERSTÄRKTEM SCHAFT NACH DIN 6535-HA, KURZ

Einsatzbereich:

Besonders geeignet zum Bohren von hochfesten Stählen, Cr-Ni-Stählen, Hartguss, Grauguss, Stahlguss, Mn-Hartstahl, Bronze, Aluminium mit hohem Siliziumanteil und anderen schwer zerspanbaren Werkstoffen.

SOLID CARBIDE STUB DRILLS WITH REINFORCED SHANK ACCORDING TO DIN 6535-HA






Range of application:

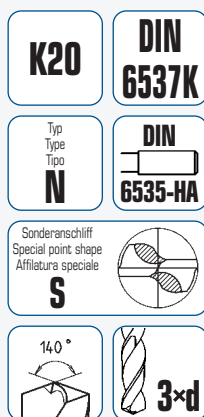
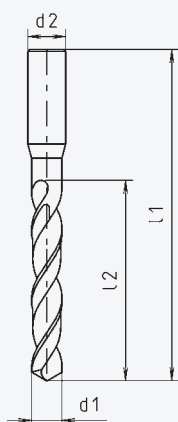
Especially suitable for drilling heat resistant steels, Cr-Ni steels, high carbon steel castings, grey cast iron, cast steels, manganese steels, bronze, aluminium with high percentage silicon and other difficult-to-machine materials.

PUNTE ELICOIDALI METALLO DURO INTEGRALE, CODOLO RINFORZATO, DIN 6535-HA, SERIE CORTA

Impiego:

Particolarmente adatte per foratura di acciai tenaci, acciai al Ni-Cr, ghisa conchigliata, ghisa grigia, acciaio fuso, acciai al manganese, bronzo, alluminio con elevato tenore di silicio, altri acciai di difficile lavorabilità.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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blank | bright | lucida



ALUNIT®

d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6285 Art.-Nr.	€	Code 6287 Art.-Nr.	€
3,00	6,00	62	20	2	0 6285003001 00	45,73	0 6287003001 00	50,80
3,10	6,00	62	20	2	0 6285003101 00	45,73	0 6287003101 00	50,80
3,20	6,00	62	20	2	0 6285003201 00	45,73	0 6287003201 00	50,80
3,30	6,00	62	20	2	0 6285003301 00	45,73	0 6287003301 00	50,80
3,40	6,00	62	20	2	0 6285003401 00	45,73	0 6287003401 00	50,80
3,50	6,00	62	20	2	0 6285003501 00	45,73	0 6287003501 00	50,80
3,60	6,00	62	20	2	0 6285003601 00	45,73	0 6287003601 00	50,80
3,70	6,00	62	20	2	0 6285003701 00	45,73	0 6287003701 00	50,80
3,80	6,00	66	24	2	0 6285003801 00	45,73	0 6287003801 00	50,80
3,90	6,00	66	24	2	0 6285003901 00	45,73	0 6287003901 00	50,80
4,00	6,00	66	24	2	0 6285004001 00	45,73	0 6287004001 00	50,80
4,10	6,00	66	24	2	0 6285004101 00	45,73	0 6287004101 00	50,80
4,20	6,00	66	24	2	0 6285004201 00	45,73	0 6287004201 00	50,80
4,30	6,00	66	24	2	0 6285004301 00	45,73	0 6287004301 00	50,80
4,40	6,00	66	24	2	0 6285004401 00	45,73	0 6287004401 00	50,80
4,50	6,00	66	24	2	0 6285004501 00	45,73	0 6287004501 00	50,80
4,60	6,00	66	24	2	0 6285004601 00	45,73	0 6287004601 00	50,80
4,70	6,00	66	28	2	0 6285004701 00	45,73	0 6287004701 00	50,80
4,80	6,00	66	28	2	0 6285004801 00	45,73	0 6287004801 00	50,80
4,90	6,00	66	28	2	0 6285004901 00	45,73	0 6287004901 00	50,80
5,00	6,00	66	28	2	0 6285005001 00	45,73	0 6287005001 00	50,80
5,10	6,00	66	28	2	0 6285005101 00	45,73	0 6287005101 00	50,80
5,20	6,00	66	28	2	0 6285005201 00	45,73	0 6287005201 00	50,80
5,30	6,00	66	28	2	0 6285005301 00	45,73	0 6287005301 00	50,80
5,40	6,00	66	28	2	0 6285005401 00	45,73	0 6287005401 00	50,80

Fortsetzung auf Seite I/13 | Continued on page I/13 | Segue a pagina I/13



>> **VHM-SPIRALBOHRER MIT VERSTÄRKTEM SCHAFT NACH DIN 6535-HA, KURZ**

SOLID CARBIDE STUB DRILLS WITH REINFORCED SHANK ACCORDING TO DIN 6535-HA

PUNTE ELICOIDALI METALLO DURO INTEGRALE, CODOLO RINFORZATO, DIN 6535-HA, SERIE CORTA

Fortsetzung von Seite I/12 | Continued from page I/12 |
Segue da pagina I/12

					blank bright lucida		ALUNIT®	
d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6285 Art.-Nr.	€	Code 6287 Art.-Nr.	€
5,50	6,00	66	28	2	0 6285005501 00	45,73	0 6287005501 00	50,80
5,60	6,00	66	28	2	0 6285005601 00	45,73	0 6287005601 00	50,80
5,70	6,00	66	28	2	0 6285005701 00	45,73	0 6287005701 00	50,80
5,80	6,00	66	28	2	0 6285005801 00	45,73	0 6287005801 00	50,80
5,90	6,00	66	28	2	0 6285005901 00	45,73	0 6287005901 00	50,80
6,00	6,00	66	28	2	0 6285006001 00	45,73	0 6287006001 00	50,80
6,10	8,00	79	34	2	0 6285006101 00	50,80	0 6287006101 00	55,88
6,20	8,00	79	34	2	0 6285006201 00	50,80	0 6287006201 00	55,88
6,30	8,00	79	34	2	0 6285006301 00	50,80	0 6287006301 00	55,88
6,40	8,00	79	34	2	0 6285006401 00	50,80	0 6287006401 00	55,88
6,50	8,00	79	34	2	0 6285006501 00	50,80	0 6287006501 00	55,88
6,60	8,00	79	34	2	0 6285006601 00	50,80	0 6287006601 00	55,88
6,70	8,00	79	34	2	0 6285006701 00	50,80	0 6287006701 00	55,88
6,80	8,00	79	34	2	0 6285006801 00	50,80	0 6287006801 00	55,88
6,90	8,00	79	34	2	0 6285006901 00	50,80	0 6287006901 00	55,88
7,00	8,00	79	34	2	0 6285007001 00	50,80	0 6287007001 00	55,88
7,10	8,00	79	41	2	0 6285007101 00	50,80	0 6287007101 00	55,88
7,20	8,00	79	41	2	0 6285007201 00	50,80	0 6287007201 00	55,88
7,30	8,00	79	41	2	0 6285007301 00	50,80	0 6287007301 00	55,88
7,40	8,00	79	41	2	0 6285007401 00	50,80	0 6287007401 00	55,88
7,50	8,00	79	41	2	0 6285007501 00	50,80	0 6287007501 00	55,88
7,60	8,00	79	41	2	0 6285007601 00	50,80	0 6287007601 00	55,88
7,70	8,00	79	41	2	0 6285007701 00	50,80	0 6287007701 00	55,88
7,80	8,00	79	41	2	0 6285007801 00	50,80	0 6287007801 00	55,88
7,90	8,00	79	41	2	0 6285007901 00	50,80	0 6287007901 00	55,88
8,00	8,00	79	41	2	0 6285008001 00	50,80	0 6287008001 00	55,88
8,10	10,00	89	47	2	0 6285008101 00	55,88	0 6287008101 00	60,96
8,20	10,00	89	47	2	0 6285008201 00	55,88	0 6287008201 00	60,96
8,30	10,00	89	47	2	0 6285008301 00	55,88	0 6287008301 00	60,96
8,40	10,00	89	47	2	0 6285008401 00	55,88	0 6287008401 00	60,96
8,50	10,00	89	47	2	0 6285008501 00	55,88	0 6287008501 00	60,96
8,60	10,00	89	47	2	0 6285008601 00	55,88	0 6287008601 00	60,96
8,70	10,00	89	47	2	0 6285008701 00	55,88	0 6287008701 00	60,96
8,80	10,00	89	47	2	0 6285008801 00	55,88	0 6287008801 00	60,96
8,90	10,00	89	47	2	0 6285008901 00	55,88	0 6287008901 00	60,96
9,00	10,00	89	47	2	0 6285009001 00	55,88	0 6287009001 00	60,96
9,10	10,00	89	47	2	0 6285009101 00	55,88	0 6287009101 00	60,96
9,20	10,00	89	47	2	0 6285009201 00	55,88	0 6287009201 00	60,96
9,30	10,00	89	47	2	0 6285009301 00	55,88	0 6287009301 00	60,96
9,40	10,00	89	47	2	0 6285009401 00	55,88	0 6287009401 00	60,96
9,50	10,00	89	47	2	0 6285009501 00	55,88	0 6287009501 00	60,96
9,60	10,00	89	47	2	0 6285009601 00	55,88	0 6287009601 00	60,96
9,70	10,00	89	47	2	0 6285009701 00	55,88	0 6287009701 00	60,96
9,80	10,00	89	47	2	0 6285009801 00	55,88	0 6287009801 00	60,96
9,90	10,00	89	47	2	0 6285009901 00	55,88	0 6287009901 00	60,96
10,00	10,00	89	47	2	0 6285010001 00	55,88	0 6287010001 00	60,96
10,20	12,00	102	55	2	0 6285010201 00	84,33	0 6287010201 00	91,44
10,50	12,00	102	55	2	0 6285010501 00	84,33	0 6287010501 00	91,44
10,80	12,00	102	55	2	0 6285010801 00	84,33	0 6287010801 00	91,44
11,00	12,00	102	55	2	0 6285011001 00	84,33	0 6287011001 00	91,44
11,50	12,00	102	55	2	0 6285011501 00	84,33	0 6287011501 00	91,44
12,00	12,00	102	55	2	0 6285012001 00	84,33	0 6287012001 00	91,44
12,50	14,00	107	60	2	0 6285012501 00	111,77	0 6287012501 00	121,93
13,00	14,00	107	60	2	0 6285013001 00	111,77	0 6287013001 00	121,93

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>> **VHM-SPIRALBOHRER MIT
VERSTÄRKTEM SCHAFT
NACH DIN 6535-HA, KURZ**

**SOLID CARBIDE STUB DRILLS
WITH REINFORCED SHANK
ACCORDING TO DIN 6535-HA**

**PUNTE ELICOIDALI METALLO
DURO INTEGRALE, CODOLO
RINFORZATO, DIN 6535-HA,
SERIE CORTA**

Fortsetzung von Seite I/13 | Continued from page I/13 |
Segue da pagina I/13

					blank bright lucida		ALUNIT®	
d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6285 Art.-Nr.	€	Code 6287 Art.-Nr.	€
13,50	14,00	107	60	2	0 6285013501 00	111,77	0 6287013501 00	121,93
14,00	14,00	107	60	2	0 6285014001 00	111,77	0 6287014001 00	121,93
14,50	16,00	115	65	2	0 6285014501 00	139,20	0 6287014501 00	152,41
15,00	16,00	115	65	2	0 6285015001 00	139,20	0 6287015001 00	152,41
15,50	16,00	115	65	2	0 6285015501 00	139,20	0 6287015501 00	152,41
16,00	16,00	115	65	2	0 6285016001 00	139,20	0 6287016001 00	152,41
16,50	18,00	123	73	2	0 6285016501 00	190,00	0 6287016501 00	203,21
17,00	18,00	123	73	2	0 6285017001 00	190,00	0 6287017001 00	203,21
17,50	18,00	123	73	2	0 6285017501 00	190,00	0 6287017501 00	203,21
18,00	18,00	123	73	2	0 6285018001 00	190,00	0 6287018001 00	203,21
18,50	20,00	131	79	2	0 6285018501 00	269,25	0 6287018501 00	304,82
19,00	20,00	131	79	2	0 6285019001 00	269,25	0 6287019001 00	304,82
19,50	20,00	131	79	2	0 6285019501 00	269,25	0 6287019501 00	350,54
20,00	20,00	131	79	2	0 6285020001 00	269,25	0 6287020001 00	304,82



>> VHM-SPIRALBOHRER MIT VERSTÄRKTEM SCHAFT NACH DIN 6535-HA, LANG

Einsatzbereich:

Besonders geeignet zum Bohren von hochfesten Stählen, Cr-Ni-Stählen, Hartguss, Grauguss, Stahlguss, Mn-Hartstahl, Bronze, Aluminium mit hohem Siliziumanteil und anderen schwer zerspanbaren Werkstoffen.

SOLID CARBIDE JOBBER DRILLS WITH REINFORCED SHANK ACCORDING TO DIN 6535-HA

Range of application:

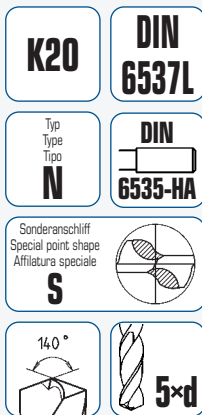
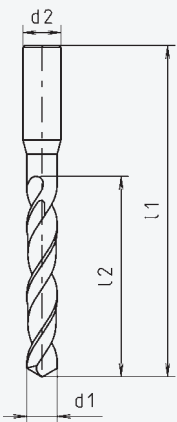
Especially suitable for drilling heat resistant steels, Cr-Ni steels, high carbon steel castings, grey cast iron, cast steels, manganese steels, bronze, aluminium with high percentage silicon and other difficult-to-machine materials.

PUNTE ELICOIDALI METALLO DURO INTEGRALE, CODOLO RINFORZATO, DIN 6535-HA, SERIE LUNGA

Impiego:

Particolarmente adatte per foratura di acciai tenaci, acciai al Ni-Cr, ghisa conchigliata, ghisa grigia, acciaio fuso, acciai al manganese, bronzo, alluminio con elevato tenore di silicio, altri acciai di difficile lavorabilità.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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blank | bright | lucida



ALUNIT®



d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6185 Art.-Nr.	€	Code 6187 Art.-Nr.	€
3,00	6,00	66	28	2	0 6185003001 00	53,85	0 6187003001 00	58,93
3,10	6,00	66	28	2	0 6185003101 00	53,85	0 6187003101 00	58,93
3,20	6,00	66	28	2	0 6185003201 00	53,85	0 6187003201 00	58,93
3,30	6,00	66	28	2	0 6185003301 00	53,85	0 6187003301 00	58,93
3,40	6,00	66	28	2	0 6185003401 00	53,85	0 6187003401 00	58,93
3,50	6,00	66	28	2	0 6185003501 00	53,85	0 6187003501 00	58,93
3,60	6,00	66	28	2	0 6185003601 00	53,85	0 6187003601 00	58,93
3,70	6,00	66	28	2	0 6185003701 00	53,85	0 6187003701 00	58,93
3,80	6,00	74	36	2	0 6185003801 00	53,85	0 6187003801 00	58,93
3,90	6,00	74	36	2	0 6185003901 00	53,85	0 6187003901 00	58,93
4,00	6,00	74	36	2	0 6185004001 00	53,85	0 6187004001 00	58,93
4,10	6,00	74	36	2	0 6185004101 00	53,85	0 6187004101 00	58,93
4,20	6,00	74	36	2	0 6185004201 00	53,85	0 6187004201 00	58,93
4,30	6,00	74	36	2	0 6185004301 00	53,85	0 6187004301 00	58,93
4,40	6,00	74	36	2	0 6185004401 00	53,85	0 6187004401 00	58,93
4,50	6,00	74	36	2	0 6185004501 00	53,85	0 6187004501 00	58,93
4,60	6,00	74	36	2	0 6185004601 00	53,85	0 6187004601 00	58,93
4,70	6,00	82	44	2	0 6185004701 00	53,85	0 6187004701 00	58,93
4,80	6,00	82	44	2	0 6185004801 00	53,85	0 6187004801 00	58,93
4,90	6,00	82	44	2	0 6185004901 00	53,85	0 6187004901 00	58,93
5,00	6,00	82	44	2	0 6185005001 00	53,85	0 6187005001 00	58,93
5,10	6,00	82	44	2	0 6185005101 00	53,85	0 6187005101 00	58,93
5,20	6,00	82	44	2	0 6185005201 00	53,85	0 6187005201 00	58,93
5,30	6,00	82	44	2	0 6185005301 00	53,85	0 6187005301 00	58,93
5,40	6,00	82	44	2	0 6185005401 00	53,85	0 6187005401 00	58,93

Fortsetzung auf Seite I/16 | Continued on page I/16 | Segue a pagina I/16

>> **VHM-SPIRALBOHRER MIT
VERSTÄRKTEM SCHAFT
NACH DIN 6535-HA, LANG**

**SOLID CARBIDE JOBBER
DRILLS WITH REINFORCED
SHANK ACCORDING TO
DIN 6535-HA**

**PUNTE ELICOIDALI METALLO
DURO INTEGRALE, CODOLO
RINFORZATO, DIN 6535-HA,
SERIE LUNGA**

Fortsetzung von Seite I/15 | Continued from page I/15 |
Segue da pagina I/15

d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	blank bright lucida		ALUNIT®	
					Code 6185 Art.-Nr.	€	Code 6187 Art.-Nr.	€
5,50	6,00	82	44	2	0 6185005501 00	53,85	0 6187005501 00	58,93
5,60	6,00	82	44	2	0 6185005601 00	53,85	0 6187005601 00	58,93
5,70	6,00	82	44	2	0 6185005701 00	53,85	0 6187005701 00	58,93
5,80	6,00	82	44	2	0 6185005801 00	53,85	0 6187005801 00	58,93
5,90	6,00	82	44	2	0 6185005901 00	53,85	0 6187005901 00	58,93
6,00	6,00	82	44	2	0 6185006001 00	53,85	0 6187006001 00	58,93
6,10	8,00	91	53	2	0 6185006101 00	55,88	0 6187006101 00	60,96
6,20	8,00	91	53	2	0 6185006201 00	55,88	0 6187006201 00	60,96
6,30	8,00	91	53	2	0 6185006301 00	55,88	0 6187006301 00	60,96
6,40	8,00	91	53	2	0 6185006401 00	55,88	0 6187006401 00	60,96
6,50	8,00	91	53	2	0 6185006501 00	55,88	0 6187006501 00	60,96
6,60	8,00	91	53	2	0 6185006601 00	55,88	0 6187006601 00	60,96
6,70	8,00	91	53	2	0 6185006701 00	55,88	0 6187006701 00	60,96
6,80	8,00	91	53	2	0 6185006801 00	55,88	0 6187006801 00	60,96
6,90	8,00	91	53	2	0 6185006901 00	55,88	0 6187006901 00	60,96
7,00	8,00	91	53	2	0 6185007001 00	55,88	0 6187007001 00	60,96
7,10	8,00	91	53	2	0 6185007101 00	55,88	0 6187007101 00	60,96
7,20	8,00	91	53	2	0 6185007201 00	55,88	0 6187007201 00	60,96
7,30	8,00	91	53	2	0 6185007301 00	55,88	0 6187007301 00	60,96
7,40	8,00	91	53	2	0 6185007401 00	55,88	0 6187007401 00	60,96
7,50	8,00	91	53	2	0 6185007501 00	55,88	0 6187007501 00	60,96
7,60	8,00	91	53	2	0 6185007601 00	55,88	0 6187007601 00	60,96
7,70	8,00	91	53	2	0 6185007701 00	55,88	0 6187007701 00	60,96
7,80	8,00	91	53	2	0 6185007801 00	55,88	0 6187007801 00	60,96
7,90	8,00	91	53	2	0 6185007901 00	55,88	0 6187007901 00	60,96
8,00	8,00	91	53	2	0 6185008001 00	55,88	0 6187008001 00	60,96
8,10	10,00	103	61	2	0 6185008101 00	60,96	0 6187008101 00	67,05
8,20	10,00	103	61	2	0 6185008201 00	60,96	0 6187008201 00	67,05
8,30	10,00	103	61	2	0 6185008301 00	60,96	0 6187008301 00	67,05
8,40	10,00	103	61	2	0 6185008401 00	60,96	0 6187008401 00	67,05
8,50	10,00	103	61	2	0 6185008501 00	60,96	0 6187008501 00	67,05
8,60	10,00	103	61	2	0 6185008601 00	60,96	0 6187008601 00	67,05
8,70	10,00	103	61	2	0 6185008701 00	60,96	0 6187008701 00	67,05
8,80	10,00	103	61	2	0 6185008801 00	60,96	0 6187008801 00	67,05
8,90	10,00	103	61	2	0 6185008901 00	60,96	0 6187008901 00	67,05
9,00	10,00	103	61	2	0 6185009001 00	60,96	0 6187009001 00	67,05
9,10	10,00	103	61	2	0 6185009101 00	60,96	0 6187009101 00	67,05
9,20	10,00	103	61	2	0 6185009201 00	60,96	0 6187009201 00	67,05
9,30	10,00	103	61	2	0 6185009301 00	60,96	0 6187009301 00	67,05
9,40	10,00	103	61	2	0 6185009401 00	60,96	0 6187009401 00	67,05
9,50	10,00	103	61	2	0 6185009501 00	60,96	0 6187009501 00	67,05
9,60	10,00	103	61	2	0 6185009601 00	60,96	0 6187009601 00	67,05
9,70	10,00	103	61	2	0 6185009701 00	60,96	0 6187009701 00	67,05
9,80	10,00	103	61	2	0 6185009801 00	60,96	0 6187009801 00	67,05
9,90	10,00	103	61	2	0 6185009901 00	60,96	0 6187009901 00	67,05
10,00	10,00	103	61	2	0 6185010001 00	60,96	0 6187010001 00	67,05
10,20	12,00	118	71	2	0 6185010201 00	91,44	0 6187010201 00	101,61
10,50	12,00	118	71	2	0 6185010501 00	91,44	0 6187010501 00	101,61
10,80	12,00	118	71	2	0 6185010801 00	91,44	0 6187010801 00	101,61
11,00	12,00	118	71	2	0 6185011001 00	91,44	0 6187011001 00	101,61
11,50	12,00	118	71	2	0 6185011501 00	91,44	0 6187011501 00	101,61
12,00	12,00	118	71	2	0 6185012001 00	91,44	0 6187012001 00	101,61
12,50	14,00	124	77	2	0 6185012501 00	123,96	0 6187012501 00	134,12
13,00	14,00	124	77	2	0 6185013001 00	123,96	0 6187013001 00	134,12

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>> **VHM-SPIRALBOHRER MIT
VERSTÄRKTEM SCHAFT
NACH DIN 6535-HA, LANG**

**SOLID CARBIDE JOBBER
DRILLS WITH REINFORCED
SHANK ACCORDING TO
DIN 6535-HA**

**PUNTE ELICOIDALI METALLO
DURO INTEGRALE, CODOLO
RINFORZATO, DIN 6535-HA,
SERIE LUNGA**

Fortsetzung von Seite I/16 | Continued from page I/16 |
Segue da pagina I/16

					blank bright lucida		ALUNIT®	
d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6185 Art.-Nr.	€	Code 6187 Art.-Nr.	€
13,50	14,00	124	77	2	0 6185013501 00	123,96	0 6187013501 00	134,12
14,00	14,00	124	77	2	0 6185014001 00	123,96	0 6187014001 00	134,12
14,50	16,00	133	83	2	0 6185014501 00	157,49	0 6187014501 00	167,65
15,00	16,00	133	83	2	0 6185015001 00	157,49	0 6187015001 00	167,65
15,50	16,00	133	83	2	0 6185015501 00	157,49	0 6187015501 00	167,65
16,00	16,00	133	83	2	0 6185016001 00	157,49	0 6187016001 00	167,65
16,50	18,00	143	93	2	0 6185016501 00	213,37	0 6187016501 00	223,53
17,00	18,00	143	93	2	0 6185017001 00	213,37	0 6187017001 00	223,53
17,50	18,00	143	93	2	0 6185017501 00	213,37	0 6187017501 00	223,53
18,00	18,00	143	93	2	0 6185018001 00	213,37	0 6187018001 00	223,53
18,50	20,00	153	101	2	0 6185018501 00	304,82	0 6187018501 00	325,13
19,00	20,00	153	101	2	0 6185019001 00	304,82	0 6187019001 00	325,13
19,50	20,00	153	101	2	0 6185019501 00	304,82	0 6187019501 00	325,13
20,00	20,00	153	101	2	0 6185020001 00	304,82	0 6187020001 00	325,13



>> VHM-SPIRALBOHRER MIT INNENKÜHLUNG, KURZ, DIN 6537K

Einsatzbereich:

Besonders geeignet zum Bohren von hochfesten Stählen, Cr-Ni-Stählen, Hartguss, Grauguss, Stahlguss, Mn-Hartstahl, Bronze, Aluminium mit hohem Siliziumanteil und anderen schwer zerspanbaren Werkstoffen.

SOLID CARBIDE STUB DRILLS WITH INTERNAL COOLANT SUPPLY, DIN 6537K


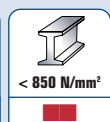
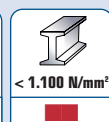
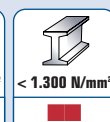
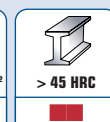
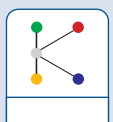
Range of application:

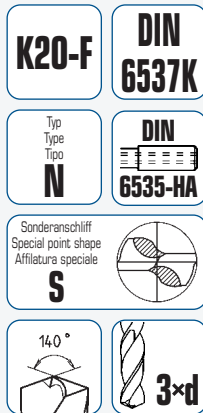
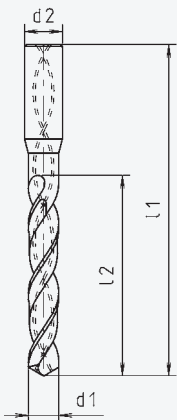
Especially suitable for drilling heat resistant steels, Cr-Ni steels, high carbon steel castings, grey cast iron, cast steels, manganese steels, bronze, aluminium with high percentage silicon and other difficult-to-machine materials.

PUNTE ELICOIDALI METALLO DURO INTEGRALE CON FORI LUBRIFICAZIONE, SERIE CORTA, DIN 6537K

Impiego:

Particolarmente adatte per foratura di acciai tenaci, acciai al Ni-Cr, ghisa conchigliata, ghisa grigia, acciaio fuso, acciai al manganese, bronzo, alluminio con elevato tenore di silicio, altri acciai di difficile lavorabilità.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
--	--	--	--	---	--	--	---------------------------------------	-----------	---------------	-----------	---



ALUNIT®

d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6207 Art.-Nr.	€
4,00	6,00	66	24	2	0 6207004001 00	59,60
4,10	6,00	66	24	2	0 6207004101 00	59,60
4,20	6,00	66	24	2	0 6207004201 00	59,60
4,30	6,00	66	24	2	0 6207004301 00	59,60
4,40	6,00	66	24	2	0 6207004401 00	59,60
4,50	6,00	66	24	2	0 6207004501 00	59,60
4,60	6,00	66	24	2	0 6207004601 00	59,60
4,70	6,00	66	24	2	0 6207004701 00	59,60
4,80	6,00	66	28	2	0 6207004801 00	59,60
4,90	6,00	66	28	2	0 6207004901 00	59,60
5,00	6,00	66	28	2	0 6207005001 00	59,60
5,10	6,00	66	28	2	0 6207005101 00	59,60
5,20	6,00	66	28	2	0 6207005201 00	59,60
5,30	6,00	66	28	2	0 6207005301 00	59,60
5,40	6,00	66	28	2	0 6207005401 00	59,60
5,50	6,00	66	28	2	0 6207005501 00	59,60
5,60	6,00	66	28	2	0 6207005601 00	59,60
5,70	6,00	66	28	2	0 6207005701 00	59,60
5,80	6,00	66	28	2	0 6207005801 00	59,60
5,90	6,00	66	28	2	0 6207005901 00	59,60
6,00	6,00	66	28	2	0 6207006001 00	59,60
6,10	8,00	79	34	2	0 6207006101 00	84,90
6,20	8,00	79	34	2	0 6207006201 00	84,90
6,30	8,00	79	34	2	0 6207006301 00	84,90
6,40	8,00	79	34	2	0 6207006401 00	84,90

Fortsetzung auf Seite I/19 | Continued on page I/19 | Segue a pagina I/19



>> **VHM-SPIRALBOHRER MIT
INNENKÜHLUNG, KURZ,
DIN 6537K**

**SOLID CARBIDE STUB DRILLS
WITH INTERNAL COOLANT
SUPPLY, DIN 6537K**

**PUNTE ELICOIDALI METALLO
DURO INTEGRALE CON FORI
LUBRIFICAZIONE, SERIE
CORTA, DIN 6537K**

Fortsetzung von Seite I/18 | Continued from page I/18 |
Segue da pagina I/18

					ALUNIT®	
d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6207 Art.-Nr.	€
6,50	8,00	79	34	2	0 6207006501 00	84,90
6,60	8,00	79	34	2	0 6207006601 00	84,90
6,70	8,00	79	34	2	0 6207006701 00	84,90
6,80	8,00	79	34	2	0 6207006801 00	84,90
6,90	8,00	79	34	2	0 6207006901 00	84,90
7,00	8,00	79	34	2	0 6207007001 00	84,90
7,10	8,00	79	41	2	0 6207007101 00	84,90
7,20	8,00	79	41	2	0 6207007201 00	84,90
7,30	8,00	79	41	2	0 6207007301 00	84,90
7,40	8,00	79	41	2	0 6207007401 00	84,90
7,50	8,00	79	41	2	0 6207007501 00	84,90
7,60	8,00	79	41	2	0 6207007601 00	84,90
7,70	8,00	79	41	2	0 6207007701 00	84,90
7,80	8,00	79	41	2	0 6207007801 00	84,90
7,90	8,00	79	41	2	0 6207007901 00	84,90
8,00	8,00	79	41	2	0 6207008001 00	84,90
8,10	10,00	89	47	2	0 6207008101 00	94,84
8,20	10,00	89	47	2	0 6207008201 00	94,84
8,30	10,00	89	47	2	0 6207008301 00	94,84
8,40	10,00	89	47	2	0 6207008401 00	94,84
8,50	10,00	89	47	2	0 6207008501 00	94,84
8,60	10,00	89	47	2	0 6207008601 00	94,84
8,70	10,00	89	47	2	0 6207008701 00	94,84
8,80	10,00	89	47	2	0 6207008801 00	94,84
8,90	10,00	89	47	2	0 6207008901 00	94,84
9,00	10,00	89	47	2	0 6207009001 00	94,84
9,10	10,00	89	47	2	0 6207009101 00	94,84
9,20	10,00	89	47	2	0 6207009201 00	94,84
9,30	10,00	89	47	2	0 6207009301 00	94,84
9,40	10,00	89	47	2	0 6207009401 00	94,84
9,50	10,00	89	47	2	0 6207009501 00	94,84
9,60	10,00	89	47	2	0 6207009601 00	94,84
9,70	10,00	89	47	2	0 6207009701 00	94,84
9,80	10,00	89	47	2	0 6207009801 00	94,84
9,90	10,00	89	47	2	0 6207009901 00	94,84
10,00	10,00	89	47	2	0 6207010001 00	94,84
10,20	12,00	102	55	2	0 6207010201 00	135,50
10,50	12,00	102	55	2	0 6207010501 00	135,50
10,80	12,00	102	55	2	0 6207010801 00	135,50
11,00	12,00	102	55	2	0 6207011001 00	135,50
11,50	12,00	102	55	2	0 6207011501 00	135,50
12,00	12,00	102	55	2	0 6207012001 00	135,50
12,50	14,00	107	60	2	0 6207012501 00	189,70
13,00	14,00	107	60	2	0 6207013001 00	189,70
13,50	14,00	107	60	2	0 6207013501 00	189,70
14,00	14,00	107	60	2	0 6207014001 00	189,70
14,50	16,00	115	65	2	0 6207014501 00	225,80
15,00	16,00	115	65	2	0 6207015001 00	225,80
15,50	16,00	115	65	2	0 6207015501 00	225,80
16,00	16,00	115	65	2	0 6207016001 00	225,80
16,50	18,00	123	73	2	0 6207016501 00	347,80
17,00	18,00	123	73	2	0 6207017001 00	347,80
17,50	18,00	123	73	2	0 6207017501 00	347,80
18,00	18,00	123	73	2	0 6207018001 00	347,80

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>> **VHM-SPIRALBOHRER MIT
INNENKÜHLUNG, KURZ,
DIN 6537K**

**SOLID CARBIDE STUB DRILLS
WITH INTERNAL COOLANT
SUPPLY, DIN 6537K**

**PUNTE ELICOIDALI METALLO
DURO INTEGRALE CON FORI
LUBRIFICAZIONE, SERIE
CORTA, DIN 6537K**

Fortsetzung von Seite I/19 | Continued from page I/19 |
Segue da pagina I/19

					ALUNIT®	
d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6207 Art.-Nr.	€
18,50	20,00	131	79	2	0 6207018501 00	397,40
19,00	20,00	131	79	2	0 6207019001 00	397,40
19,50	20,00	131	79	2	0 6207019501 00	397,40
20,00	20,00	131	79	2	0 6207020001 00	397,40



>> VHM-SPIRALBOHRER MIT INNENKÜHLUNG, LANG, DIN 6537L

Einsatzbereich:

Besonders geeignet zum Bohren von hochfesten Stählen, Cr-Ni-Stählen, Hartguss, Grauguss, Stahlguss, Mn-Hartstahl, Bronze, Aluminium mit hohem Siliziumanteil und anderen schwer zerspanbaren Werkstoffen.

SOLID CARBIDE JOBBER DRILLS WITH INTERNAL COOLANT SUPPLY, DIN 6537L







Range of application:

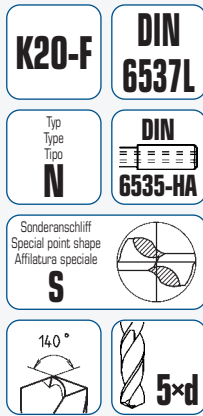
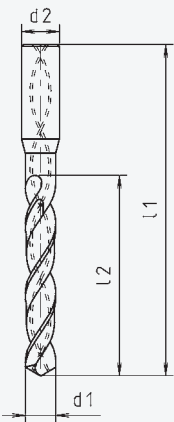
Especially suitable for drilling heat resistant steels, Cr-Ni steels, high carbon steel castings, grey cast iron, cast steels, manganese steels, bronze, aluminium with high percentage silicon and other difficult-to-machine materials.

PUNTE ELICOIDALI METALLO DURO INTEGRALE CON FORI LUBRIFICAZIONE, SERIE LUNGA, DIN 6537L

Impiego:

Particolarmente adatte per foratura di acciai tenaci, acciai al Ni-Cr, ghisa conchigliata, ghisa grigia, acciaio fuso, acciai al manganese, bronzo, alluminio con elevato tenore di silicio, altri acciai di difficile lavorabilità.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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ALUNIT®



d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6267 Art.-Nr.	€
4,00	6,00	74	36	2	0 6267004001 00	74,05
4,10	6,00	74	36	2	0 6267004101 00	74,05
4,20	6,00	74	36	2	0 6267004201 00	74,05
4,30	6,00	74	36	2	0 6267004301 00	74,05
4,40	6,00	74	36	2	0 6267004401 00	74,05
4,50	6,00	74	36	2	0 6267004501 00	74,05
4,60	6,00	74	36	2	0 6267004601 00	74,05
4,70	6,00	74	36	2	0 6267004701 00	74,05
4,80	6,00	82	44	2	0 6267004801 00	74,05
4,90	6,00	82	44	2	0 6267004901 00	74,05
5,00	6,00	82	44	2	0 6267005001 00	74,05
5,10	6,00	82	44	2	0 6267005101 00	74,05
5,20	6,00	82	44	2	0 6267005201 00	74,05
5,30	6,00	82	44	2	0 6267005301 00	74,05
5,40	6,00	82	44	2	0 6267005401 00	74,05
5,50	6,00	82	44	2	0 6267005501 00	74,05
5,60	6,00	82	44	2	0 6267005601 00	74,05
5,70	6,00	82	44	2	0 6267005701 00	74,05
5,80	6,00	82	44	2	0 6267005801 00	74,05
5,90	6,00	82	44	2	0 6267005901 00	74,05
6,00	6,00	82	44	2	0 6267006001 00	74,05
6,10	8,00	91	53	2	0 6267006101 00	89,42
6,20	8,00	91	53	2	0 6267006201 00	89,42
6,30	8,00	91	53	2	0 6267006301 00	89,42
6,40	8,00	91	53	2	0 6267006401 00	89,42

Fortsetzung auf Seite I/22 | Continued on page I/22 | Segue a pagina I/22

>> **VHM-SPIRALBOHRER MIT INNENKÜHLUNG, LANG, DIN 6537L**

SOLID CARBIDE JOBBER DRILLS WITH INTERNAL COOLANT SUPPLY, DIN 6537L

PUNTE ELICOIDALI METALLO DURO INTEGRALE CON FORI LUBRIFICAZIONE, SERIE LUNGA, DIN 6537L

Fortsetzung von Seite I/21 | Continued from page I/21 |
Segue da pagina I/21

					ALUNIT®	
d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6267 Art.-Nr.	€
6,50	8,00	91	53	2	0 6267006501 00	89,42
6,60	8,00	91	53	2	0 6267006601 00	89,42
6,70	8,00	91	53	2	0 6267006701 00	89,42
6,80	8,00	91	53	2	0 6267006801 00	89,42
6,90	8,00	91	53	2	0 6267006901 00	89,42
7,00	8,00	91	53	2	0 6267007001 00	89,42
7,10	8,00	91	53	2	0 6267007101 00	89,42
7,20	8,00	91	53	2	0 6267007201 00	89,42
7,30	8,00	91	53	2	0 6267007301 00	89,42
7,40	8,00	91	53	2	0 6267007401 00	89,42
7,50	8,00	91	53	2	0 6267007501 00	89,42
7,60	8,00	91	53	2	0 6267007601 00	89,42
7,70	8,00	91	53	2	0 6267007701 00	89,42
7,80	8,00	91	53	2	0 6267007801 00	89,42
7,90	8,00	91	53	2	0 6267007901 00	89,42
8,00	8,00	91	53	2	0 6267008001 00	89,42
8,10	10,00	103	61	2	0 6267008101 00	108,40
8,20	10,00	103	61	2	0 6267008201 00	108,40
8,30	10,00	103	61	2	0 6267008301 00	108,40
8,40	10,00	103	61	2	0 6267008401 00	108,40
8,50	10,00	103	61	2	0 6267008501 00	108,40
8,60	10,00	103	61	2	0 6267008601 00	108,40
8,70	10,00	103	61	2	0 6267008701 00	108,40
8,80	10,00	103	61	2	0 6267008801 00	108,40
8,90	10,00	103	61	2	0 6267008901 00	108,40
9,00	10,00	103	61	2	0 6267009001 00	108,40
9,10	10,00	103	61	2	0 6267009101 00	108,40
9,20	10,00	103	61	2	0 6267009201 00	108,40
9,30	10,00	103	61	2	0 6267009301 00	108,40
9,40	10,00	103	61	2	0 6267009401 00	108,40
9,50	10,00	103	61	2	0 6267009501 00	108,40
9,60	10,00	103	61	2	0 6267009601 00	108,40
9,70	10,00	103	61	2	0 6267009701 00	108,40
9,80	10,00	103	61	2	0 6267009801 00	108,40
9,90	10,00	103	61	2	0 6267009901 00	108,40
10,00	10,00	103	61	2	0 6267010001 00	108,40
10,20	12,00	118	71	2	0 6267010201 00	153,60
10,50	12,00	118	71	2	0 6267010501 00	153,60
10,80	12,00	118	71	2	0 6267010801 00	153,60
11,00	12,00	118	71	2	0 6267011001 00	153,60
11,50	12,00	118	71	2	0 6267011501 00	153,60
12,00	12,00	118	71	2	0 6267012001 00	153,60
12,50	14,00	124	77	2	0 6267012501 00	207,80
13,00	14,00	124	77	2	0 6267013001 00	207,80
13,50	14,00	124	77	2	0 6267013501 00	207,80
14,00	14,00	124	77	2	0 6267014001 00	207,80
14,50	16,00	133	83	2	0 6267014501 00	257,50
15,00	16,00	133	83	2	0 6267015001 00	257,50
15,50	16,00	133	83	2	0 6267015501 00	257,50
16,00	16,00	133	83	2	0 6267016001 00	257,50
16,50	18,00	143	93	2	0 6267016501 00	406,50
17,00	18,00	143	93	2	0 6267017001 00	406,50
17,50	18,00	143	93	2	0 6267017501 00	406,50
18,00	18,00	143	93	2	0 6267018001 00	406,50

Fortsetzung auf Seite I/23 | Continued on page I/23 | Segue a pagina I/23



>> **VHM-SPIRALBOHRER MIT
INNENKÜHLUNG, LANG,
DIN 6537L**

**SOLID CARBIDE JOBBER
DRILLS WITH INTERNAL
COOLANT SUPPLY, DIN 6537L**

**PUNTE ELICOIDALI METALLO
DURO INTEGRALE CON FORI
LUBRIFICAZIONE, SERIE
LUNGA, DIN 6537L**

Fortsetzung von Seite 1/22 | Continued from page 1/22 |
Segue da pagina 1/22

					ALUNIT®	
d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6267 Art.-Nr.	€
18,50	20,00	153	101	2	□ 6267018501 00	451,60
19,00	20,00	153	101	2	□ 6267019001 00	451,60
19,50	20,00	153	101	2	□ 6267019501 00	451,60
20,00	20,00	153	101	2	□ 6267020001 00	451,60



>> VHM-SPIRALBOHRER MIT INNENKÜHLUNG, EXTRA LANG

Einsatzbereich:

Besonders geeignet zum Bohren von hochfesten Stählen, Cr-Ni-Stählen, Hartguss, Grauguss, Stahlguss, Mn-Hartstahl, Bronze, Aluminium mit hohem Siliziumanteil und anderen schwer zerspanbaren Werkstoffen.

SOLID CARBIDE JOBBER DRILLS WITH INTERNAL COOLANT SUPPLY, EXTRA LONG SERIES


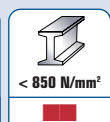
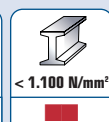
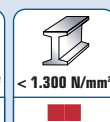
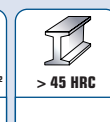
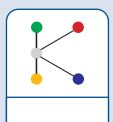
Range of application:

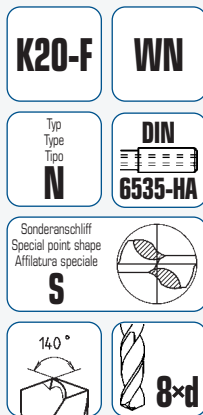
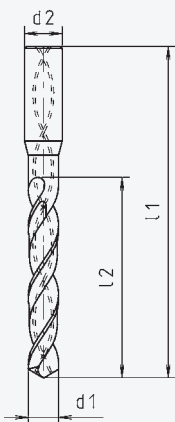
Especially suitable for drilling heat resistant steels, Cr-Ni steels, high carbon steel castings, grey cast iron, cast steels, manganese steels, bronze, aluminium with high percentage silicon and other difficult-to-machine materials.

PUNTE ELICOIDALI METALLO DURO INTEGRALE CON FORI LUBRIFICAZIONE, SERIE EXTRA LUNGA

Impiego:

Particolarmente adatte per foratura di acciai tenaci, acciai al Ni-Cr, ghisa conchigliata, ghisa grigia, acciaio fuso, acciai al manganese, bronzo, alluminio con elevato tenore di silicio, altri acciai di difficile lavorabilità.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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ALUNIT®



d1 _{h7} mm	d2 _{h6} mm	l1 mm	l2 mm	Z	Code 6917 Art.-Nr.	€
5,00	6,00	95	57	2	0 6917005001 00	135,50
5,50	6,00	95	57	2	0 6917005501 00	135,50
5,80	6,00	95	57	2	0 6917005801 00	135,50
6,00	6,00	95	57	2	0 6917006001 00	135,50
6,50	8,00	114	76	2	0 6917006501 00	162,60
6,80	8,00	114	76	2	0 6917006801 00	162,60
7,00	8,00	114	76	2	0 6917007001 00	162,60
7,50	8,00	114	76	2	0 6917007501 00	162,60
8,00	8,00	114	76	2	0 6917008001 00	162,60
8,50	10,00	142	95	2	0 6917008501 00	198,70
9,00	10,00	142	95	2	0 6917009001 00	198,70
9,50	10,00	142	95	2	0 6917009501 00	198,70
10,00	10,00	142	95	2	0 6917010001 00	198,70
10,20	12,00	162	114	2	0 6917010201 00	252,90
10,50	12,00	162	114	2	0 6917010501 00	252,90
10,80	12,00	162	114	2	0 6917010801 00	252,90
11,00	12,00	162	114	2	0 6917011001 00	252,90
11,50	12,00	162	114	2	0 6917011501 00	252,90
12,00	12,00	162	114	2	0 6917012001 00	252,90
12,50	14,00	178	133	2	0 6917012501 00	361,30
13,00	14,00	178	133	2	0 6917013001 00	361,30
13,50	14,00	178	133	2	0 6917013501 00	361,30
14,00	14,00	178	133	2	0 6917014001 00	361,30
15,00	16,00	203	152	2	0 6917015001 00	451,60
16,00	16,00	203	152	2	0 6917016001 00	451,60

>> VHM-STUFENBOHRER, 90° SENKWINKEL

Einsatzbereich:

Stufenbohrer mit Zylinderschaft zur Herstellung von Kernlochbohrungen nach DIN 336 Teil 1, wobei gleichzeitig Freisenkungen (90°) entsprechend den Durchgangslöchern – Ausführung mittel – nach ISO 273 erzeugt werden. Die Schnittgeschwindigkeit richtet sich nach dem großen Durchmesser, der Vorschub nach dem kleineren.

SOLID CARBIDE STEPPED TWIST DRILLS, 90° COUNTERSINK ANGLE







Range of application:

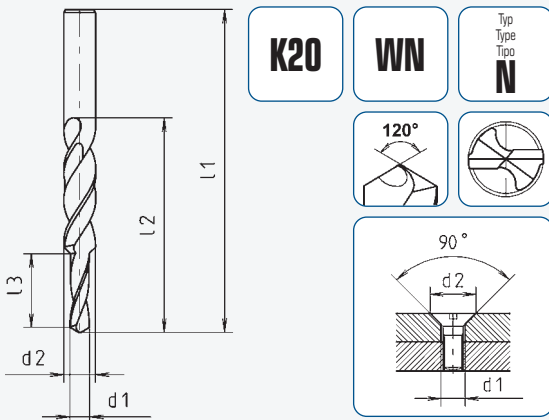
Stepped twist drills with straight shank for drilling the tapping hole according to DIN 336, Part 1, with the simultaneous counterboring (90°) of the corresponding clearance hole – accuracy class "medium" – according to ISO 273. The cutting speed is governed by the larger diameter but the feed must suit the smaller.

PUNTE ELICOIDALI A GRADINO METALLO DURO INTEGRALE, ANGOLO 90°

Impiego:



Punte a gradino codolo cilindrico, foratura degli avvanfori per maschiatura, secondo DIN 336 parte 1a. e contemporanea svasatura (90°), per fori passanti in esecuzione "media" secondo ISO 273. La velocità di taglio funzione del diametro maggiore, l'avanzamento funzione del diametro minore.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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ALUNIT®



	d _{1,h7} mm	d _{2,h7} mm	l ₁ mm	l ₂ mm	l ₃ mm		Z	Code 6277 Art.-Nr.	€
M 3	2,50	3,40	52	20	9	90°	2	0 6277002501 00	26,14
M 4	3,30	4,50	58	24	11	90°	2	0 6277003301 00	28,52
M 5	4,20	5,50	66	28	14	90°	2	0 6277004201 00	39,94
M 6	5,00	6,60	70	31	16	90°	2	0 6277005001 00	54,66
M 8	6,80	9,00	84	40	22	90°	2	0 6277006801 00	85,56
M10	8,50	11,00	95	47	28	90°	2	0 6277008501 00	110,30
M12	10,20	13,50	107	54	33	90°	2	0 6277010201 00	192,60
M14	12,00	15,50	115	58	38	90°	2	0 6277012001 00	258,60
M16	14,00	17,50	123	62	41	90°	2	0 6277014001 00	334,70

>> VHM-ZENTRIERBOHRER, ÄHNLICH DIN 333

Einsatzbereich:

Zentrierbohrer zum Herstellen von Zentrierbohrungen nach DIN 332 Blatt 1, Form A (ohne Schutzsenkung).

SOLID CARBIDE CENTRE DRILLS, SIMILAR TO DIN 333

Range of application:

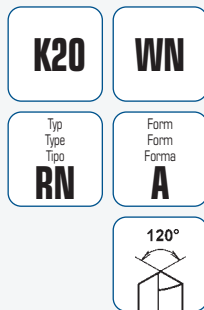
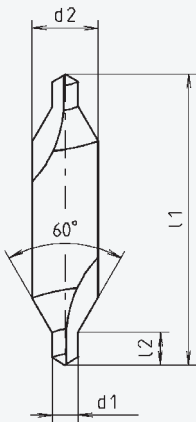
Centre-drills for the production of centre-holes according to DIN 332 sheet 1, form A (without protective chamfer).

PUNTE A CENTRARE METALLO DURO INTEGRALE, SIMILI DIN 333

Impiego:

Esecuzione fori di centraggio secondo DIN 332 part 1. Forma A (Senza smusso di protezione).

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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d _{h7} mm	d _{2h7} mm	l ₁ mm	l ₂ mm	Code 6525 Art.-Nr.	€
0,80	3,00	38	1,1	0 6525000801 00	20,93
1,00	3,00	38	1,3	0 6525001001 00	23,26
1,25	3,00	38	1,6	0 6525001201 00	24,42
1,60	4,00	40	2,0	0 6525001601 00	29,08
2,00	5,00	50	2,5	0 6525002001 00	34,89
2,50	6,00	50	3,1	0 6525002501 00	40,71
3,15	8,00	63	3,9	0 6525003101 00	52,33
4,00	10,00	66	5,0	0 6525004001 00	67,44
5,00	12,00	73	6,3	0 6525005001 00	93,02
6,30	16,00	75	8,0	0 6525006301 00	145,40



>> VHM-NC-ANBOHRER, 90°

SOLID CARBIDE NC-CENTRE DRILLS, 90°

PUNTE ELICOIDALI NC METALLO DURO INTEGRALE, ANGOLO 90°

Einsatzbereich:

Spezialbohrer für besonders genaues und schnelles Anbohren auf NC-Maschinen, Lehrenbohrwerken usw. Zum Zentrieren und Anfasen von Gewindebohrungen.

Achtung: Nicht geeignet für tiefe Bohrungen!

Range of application:







Special drills of highest efficiency for more precise and faster drilling-work on NC-machines, boring tools etc. Designed for centering and chamfering of center-holes.

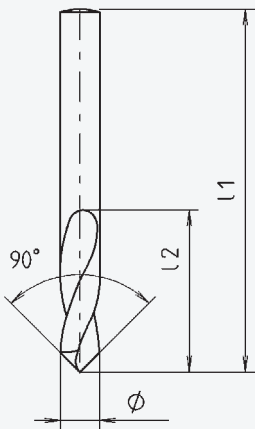
Attention: Not suitable for deeper holes!

Impiego:

Punte speciali per l'esecuzione di fori di centraggio particolarmente esatti su macchina NC, forature per calibri, ecc. Per centratura e smusso di fori per maschiatura.

Attenzione: non sono adatte per fori profondi.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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Ø _{hg} mm	l1 mm	l2 mm	Code 6225 Art.-Nr.	€	Code 6227 Art.-Nr.	€
4,00	40	10	0 6225004001 00	17,45	0 6227004001 00	24,42
5,00	50	10	0 6225005001 00	17,45	0 6227005001 00	24,42
6,00	50	16	0 6225006001 00	17,45	0 6227006001 00	24,42
8,00	63	20	0 6225008001 00	29,08	0 6227008001 00	38,37
10,00	72	22	0 6225010001 00	40,71	0 6227010001 00	52,33
12,00	73	22	0 6225012001 00	58,13	0 6227012001 00	67,44
16,00	82	25	0 6225016001 00	104,70	0 6227016001 00	122,20
20,00	104	30	0 6225020001 00	209,40	0 6227020001 00	232,60



>> VHM-KLEINSTBOHRER MIT ZYLINDRISCHEM SCHAFT, DIN 1899

Einsatzbereich:

Besonders geeignet zum Bohren von hochfesten Stählen, Cr-Ni-Stählen, Hartguss, Grauguss, Stahlguss, Mn-Hartstahl, Bronze, Aluminium mit hohem Siliziumanteil und anderen schwer zerspanbaren Werkstoffen.

SOLID CARBIDE MINI DRILLS WITH CYLINDRICAL SHANK, DIN 1899

Range of application:

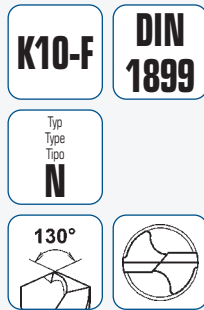
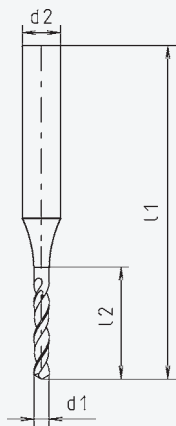
Especially suitable for drilling heat resistant steels, Cr-Ni steels, high carbon steel castings, grey cast iron, cast steels, manganese steels, bronze, aluminium with high percentage silicon and other difficult-to-machine materials.

MICROPUNTE METALLO DURO INTEGRALE, CODOLO CILINDRICO, DIN 1899

Impiego:

Particolarmente adatte per foratura di acciai tenaci, acciai al Ni-Cr, ghisa conchigliata, ghisa grigia, acciaio fuso, acciai al manganese, bronzo, alluminio con elevato tenore di silicio, altri acciai di difficile lavorabilità.

 < 400 N/mm ²	 < 850 N/mm ²	 < 1.100 N/mm ²	 < 1.300 N/mm ²	 > 45 HRC	INOX < 850 N/mm ²	INOX > 850 N/mm ²	GRAUGUSS CAST IRON GHISA GRIGIA	Ti	Cu, Ms	Al	
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d ₁ _{h7} mm	d ₂ _{h6} mm	l ₁ mm	l ₂ mm	Z	Code 6035 Art.-Nr.	€
0,30	1,00	25	2,2	2	0 6035000301 00	17,67
0,35	1,00	25	2,8	2	0 6035000351 00	22,56
0,40	1,00	25	3,6	2	0 6035000401 00	17,67
0,45	1,00	25	3,6	2	0 6035000451 00	22,56
0,50	1,00	25	4,0	2	0 6035000501 00	17,67
0,55	1,00	25	4,5	2	0 6035000551 00	24,42
0,60	1,00	25	4,5	2	0 6035000601 00	14,88
0,65	1,00	25	5,0	2	0 6035000651 00	24,42
0,70	1,00	25	5,6	2	0 6035000701 00	14,88
0,75	1,00	25	5,6	2	0 6035000751 00	24,42
0,80	1,50	25	6,3	2	0 6035000801 00	14,88
0,85	1,50	25	6,3	2	0 6035000851 00	24,42
0,90	1,50	25	7,1	2	0 6035000901 00	14,88
0,95	1,50	25	7,1	2	0 6035000951 00	25,57
1,00	1,50	25	8,0	2	0 6035001001 00	13,95
1,05	1,50	25	8,0	2	0 6035001051 00	25,57
1,10	1,50	25	9,0	2	0 6035001101 00	14,88
1,15	1,50	25	9,0	2	0 6035001151 00	25,57
1,20	1,50	25	10,0	2	0 6035001201 00	14,88
1,25	1,50	25	10,0	2	0 6035001251 00	25,57
1,30	1,50	25	10,0	2	0 6035001301 00	14,88
1,35	1,50	25	11,2	2	0 6035001351 00	25,57
1,40	1,50	25	11,2	2	0 6035001401 00	14,88

Hinweis: 4-Flächenanschliff
Remark: 4-faced point shape
Att: 4 spoglie

