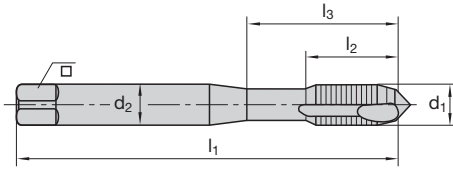




DIN 371

DIN 376

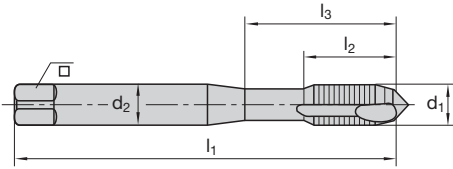


Katalog-Nr. Cat.-No.		6411C							6412C						
<b>P1</b>	Stahl Steel < 500 N/mm <sup>2</sup>	<input type="checkbox"/> v <sub>c</sub> = 20–25 m/min							<input type="checkbox"/> v <sub>c</sub> = 20–25 m/min						
<b>P2</b>	Stahl Steel 500–1000 N/mm <sup>2</sup>	<input checked="" type="checkbox"/> v <sub>c</sub> = 15–20 m/min							<input checked="" type="checkbox"/> v <sub>c</sub> = 15–20 m/min						
<b>P3</b>	Stahl Steel > 1000 N/mm <sup>2</sup>	<input type="checkbox"/> v <sub>c</sub> = 10–15 m/min							<input type="checkbox"/> v <sub>c</sub> = 10–15 m/min						
<b>M1</b>	Rostfreie austenitische Stähle Stainless steel austenitic	<input type="checkbox"/> v <sub>c</sub> = 5–10 m/min							<input type="checkbox"/> v <sub>c</sub> = 5–10 m/min						
<b>M2</b>	Rostfreie martensitische Stähle Stainless steel martensitic														
<b>K1</b>	Grauguss Grey cast iron														
<b>K2</b>	Sphäroguss Nodular cast iron	<input type="checkbox"/> v <sub>c</sub> = 15–20 m/min							<input type="checkbox"/> v <sub>c</sub> = 15–20 m/min						
<b>N1</b>	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si	<input type="checkbox"/> v <sub>c</sub> = 20–25 m/min							<input type="checkbox"/> v <sub>c</sub> = 20–25 m/min						
<b>N2</b>	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5–10 % Si	<input checked="" type="checkbox"/> v <sub>c</sub> = 15–20 m/min							<input checked="" type="checkbox"/> v <sub>c</sub> = 15–20 m/min						
<b>N3</b>	Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si	<input type="checkbox"/> v <sub>c</sub> = 15–20 m/min							<input type="checkbox"/> v <sub>c</sub> = 15–20 m/min						
<b>N4</b>	Graphit Graphite														
<b>S1</b>	Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm <sup>2</sup>														
<b>S2</b>	Titanlegierungen hochfest Titanium alloys high strength < 1300 N/mm <sup>2</sup>														
<b>H1</b>	Hartguss und Harte Stähle Chilled steel and Hardened steel 45–55 HRC														
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	□ h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code			
<b>mit verstärktem Zylinderschaft with reinforced straight shank</b>															
M 2	0,4	45	5	11	2,8	2,1	3	1,6	1393901	TC-BM 02x0.40-6H-V0-1	–	–			
M 2,2	0,45	45	5	12	2,8	2,1	3	1,75	1393902	TC-BM 2.2x0.45-6H-V0-1	–	–			
M 2,3	0,4	45	5	13	2,8	2,1	3	1,9	1393903	TC-BM 2.3x0.40-6H-V0-1	–	–			
M 2,5	0,45	50	5	15	2,8	2,1	3	2,05	1393904	TC-BM 2.5x0.45-6H-V0-1	–	–			
M 2,6	0,45	50	5	16	2,8	2,1	3	2,1	1393905	TC-BM 2.6x0.45-6H-V0-1	–	–			
M 3	0,5	56	5	18	3,5	2,7	3	2,5	1393906	TC-BM 03x0.50-6H-V0-1	–	–			
M 3,5	0,6	56	6	20	4	3	3	2,9	1393907	TC-BM 3.5x0.60-6H-V0-1	–	–			
M 4	0,7	63	7	21	4,5	3,4	3	3,3	1393915	TC-BM 04x0.70-6H-V0-1	–	–			
M 5	0,8	70	8	25	6	4,9	3	4,2	1393924	TC-BM 05x0.80-6H-V0-1	–	–			
M 6	1	80	10	30	6	4,9	3	5	1393933	TC-BM 06x1.00-6H-V0-1	–	–			
M 7	1	80	10	30	7	5,5	3	6	1393934	TC-BM 07x1.00-6H-V0-1	–	–			
M 8	1,25	90	13	35	8	6,2	3	6,8	1393942	TC-BM 08x1.25-6H-V0-1	–	–			
M 10	1,5	100	15	39	10	8	3	8,5	1393951	TC-BM 10x1.50-6H-V0-1	–	–			
<b>mit Überlaufschaft with standard straight shank</b>															
M 3	0,5	56	6	–	2,2	1,2	3	2,5	–	–	1393953	TC-BM 03x0.50-6H-V0-1			
M 4	0,7	63	7	–	2,8	2,1	3	3,3	–	–	1393955	TC-BM 04x0.70-6H-V0-1			
M 5	0,8	70	8	–	3,5	2,7	3	4,2	–	–	1393957	TC-BM 05x0.80-6H-V0-1			
M 6	1	80	10	–	4,5	3,4	3	5	–	–	1393959	TC-BM 06x1.00-6H-V0-1			
M 8	1,25	90	14	–	6	4,9	3	6,8	–	–	1393962	TC-BM 08x1.25-6H-V0-1			
M 10	1,5	100	16	–	7	5,5	3	8,5	–	–	1393964	TC-BM 10x1.50-6H-V0-1			
M 12	1,75	110	18	–	9	7	3	10,2	–	–	1393960	TC-BM 12x1.75-6H-V0-1			
M 14	2	110	20	–	11	9	3	12	–	–	1393785	TC-BM 14x2.00-6H-V0-1			
M 16	2	110	20	–	12	9	3	14	–	–	1393979	TC-BM 16x2.00-6H-V0-1			

 Kernlochbohrer ab Seite 367  
 Pre-drills starting page 367

 ■ = Hauptanwendung First choice  
 □ = Nebenanwendung Second choice


M  V  h9  3xD  0°  B 3,5-5,1  ISO2 (6H)  HSS E-PM  TiCN Plus  DIN 371  DIN 376



Katalog-Nr. Cat.-No.		6411C				6412C							
P1	Stahl Steel < 500 N/mm <sup>2</sup>	<input type="checkbox"/>	$v_c = 20-25$ m/min	<input type="checkbox"/>	$v_c = 20-25$ m/min								
P2	Stahl Steel 500-1000 N/mm <sup>2</sup>	<input checked="" type="checkbox"/>	$v_c = 15-20$ m/min	<input checked="" type="checkbox"/>	$v_c = 15-20$ m/min								
P3	Stahl Steel > 1000 N/mm <sup>2</sup>	<input type="checkbox"/>	$v_c = 10-15$ m/min	<input type="checkbox"/>	$v_c = 10-15$ m/min								
M1	Rostfreie austenitische Stähle Stainless steel austenitic	<input type="checkbox"/>	$v_c = 5-10$ m/min	<input type="checkbox"/>	$v_c = 5-10$ m/min								
M2	Rostfreie martensitische Stähle Stainless steel martensitic												
K1	Grauguss Grey cast iron												
K2	Sphäroguss Nodular cast iron	<input type="checkbox"/>	$v_c = 15-20$ m/min	<input type="checkbox"/>	$v_c = 15-20$ m/min								
N1	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si	<input type="checkbox"/>	$v_c = 20-25$ m/min	<input type="checkbox"/>	$v_c = 20-25$ m/min								
N2	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5-10 % Si	<input checked="" type="checkbox"/>	$v_c = 15-20$ m/min	<input checked="" type="checkbox"/>	$v_c = 15-20$ m/min								
N3	Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si	<input type="checkbox"/>	$v_c = 15-20$ m/min	<input type="checkbox"/>	$v_c = 15-20$ m/min								
N4	Graphit Graphite												
S1	Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm <sup>2</sup>												
S2	Titanlegierungen hochfest Titanium alloys high strength < 1300 N/mm <sup>2</sup>												
H1	Hartguss und Harte Stähle Chilled steel and Hardened steel 45-55 HRC												
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	<input type="checkbox"/> h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code	
<b>mit Überlaufschaft with standard straight shank</b>													
M 18	2,5	125	25	-	14	<input type="checkbox"/>	11	3	15,5	-	-	1393809	TC-BM 18x2.50-6H-V0-1
M 20	2,5	140	25	-	16	<input type="checkbox"/>	12	3	17,5	-	-	1393818	TC-BM 20x2.50-6H-V0-1
M 22	2,5	140	25	-	18	<input type="checkbox"/>	14,5	3	19,5	-	-	1394593	TC-BM 22x2.50-6H-V0-1
M 24	3	160	30	-	18	<input type="checkbox"/>	14,5	4	21	-	-	1384594	TC-BM 24x3.00-6H-V0-1
M 27	3	160	30	-	20	<input type="checkbox"/>	16	4	24	-	-	1384596	TC-BM 27x3.00-6H-V0-1
M 30	3,5	180	35	-	22	<input type="checkbox"/>	18	4	26,5	-	-	1384598	TC-BM 30x3.50-6H-V0-1
M 36	4	200	40	-	28	<input type="checkbox"/>	22	4	32	-	-	1384600	TC-BM 36x4.00-6H-V0-1
M 42	4,5	220	45	-	32	<input type="checkbox"/>	24	4	37,5	-	-	1384602	TC-BM 42x4.50-6H-V0-1

Gewindebohrer für Nichtferrousmetalle  
Taps for nonferrous metals

Kernlochbohrer ab Seite 367  
Pre-drills starting page 367

= Hauptanwendung First choice  
 = Nebenanwendung Second choice