



Katalog-Nr. Cat.-No.		6944C							6944C				
P1	Stahl Steel < 500 N/mm ²	<input type="checkbox"/>	$v_c = 18-25$ m/min	<input type="checkbox"/>	$v_c = 18-25$ m/min	<input type="checkbox"/>	$v_c = 18-25$ m/min	<input type="checkbox"/>	$v_c = 18-25$ m/min	<input type="checkbox"/>	$v_c = 18-25$ m/min	<input type="checkbox"/>	$v_c = 18-25$ m/min
P2	Stahl Steel 500-1000 N/mm ²	<input checked="" type="checkbox"/>	$v_c = 18-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 18-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 18-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 18-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 18-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 18-25$ m/min
P3	Stahl Steel > 1000 N/mm ²	<input type="checkbox"/>	$v_c = 15-20$ m/min	<input type="checkbox"/>	$v_c = 15-20$ m/min	<input type="checkbox"/>	$v_c = 15-20$ m/min	<input type="checkbox"/>	$v_c = 15-20$ m/min	<input type="checkbox"/>	$v_c = 15-20$ m/min	<input type="checkbox"/>	$v_c = 15-20$ m/min
M1	Rostfreie austenitische Stähle Stainless steel austenitic	<input type="checkbox"/>	$v_c = 8-12$ m/min	<input type="checkbox"/>	$v_c = 8-12$ m/min	<input type="checkbox"/>	$v_c = 8-12$ m/min	<input type="checkbox"/>	$v_c = 8-12$ m/min	<input type="checkbox"/>	$v_c = 8-12$ m/min	<input type="checkbox"/>	$v_c = 8-12$ m/min
M2	Rostfreie martensitische Stähle Stainless steel martensitic												
K1	Grauguss Grey cast iron												
K2	Sphäroguss Nodular cast iron	<input type="checkbox"/>	$v_c = 20-25$ m/min	<input type="checkbox"/>	$v_c = 20-25$ m/min	<input type="checkbox"/>	$v_c = 20-25$ m/min	<input type="checkbox"/>	$v_c = 20-25$ m/min	<input type="checkbox"/>	$v_c = 20-25$ m/min	<input type="checkbox"/>	$v_c = 20-25$ m/min
N1	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si	<input type="checkbox"/>	$v_c = 25-30$ m/min	<input type="checkbox"/>	$v_c = 25-30$ m/min	<input type="checkbox"/>	$v_c = 25-30$ m/min	<input type="checkbox"/>	$v_c = 25-30$ m/min	<input type="checkbox"/>	$v_c = 25-30$ m/min	<input type="checkbox"/>	$v_c = 25-30$ m/min
N2	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5-10 % Si	<input checked="" type="checkbox"/>	$v_c = 20-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 20-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 20-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 20-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 20-25$ m/min	<input checked="" type="checkbox"/>	$v_c = 20-25$ 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	<input type="checkbox"/>	$v_c = 15-20$ m/min	<input type="checkbox"/>	$v_c = 15-20$ m/min	<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 ²												
S2	Titanlegierungen hochfest Titanium alloys high strength < 1300 N/mm ²												
H1	Hartguss und Harte Stähle Chilled steel and Hardened steel 45-55 HRC												
d ₁	P	l ₁	l ₂	d ₂	<input type="checkbox"/> h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code		
mit Überlaufschaft with standard straight shank													
MF 8	1	90	14	6	<input type="checkbox"/>	4,9	3	7	1402528	TC-CMF 08x1.00-6HX-V15-13	9127929	TC-CMF 08x1.00-6HX-V15-11	
MF 10	1	90	15	7	<input type="checkbox"/>	5,5	3	9	1402529	TC-CMF 10x1.00-6HX-V15-13	9127931	TC-CMF 10x1.00-6HX-V15-11	
MF 10	1,25	100	15	7	<input type="checkbox"/>	5,5	3	8,8	1402530	TC-CMF 10x1.25-6HX-V15-13	9127932	TC-CMF 10x1.25-6HX-V15-11	
MF 12	1	100	16	9	<input type="checkbox"/>	7	3	11	1402531	TC-CMF 12x1.00-6HX-V15-13	9127934	TC-CMF 12x1.00-6HX-V15-11	
MF 12	1,25	100	16	9	<input type="checkbox"/>	7	3	10,8	1402532	TC-CMF 12x1.25-6HX-V15-13	9127936	TC-CMF 12x1.25-6HX-V15-11	
MF 12	1,5	100	16	9	<input type="checkbox"/>	7	3	10,5	1402533	TC-CMF 12x1.50-6HX-V15-13	9127937	TC-CMF 12x1.50-6HX-V15-11	
MF 14	1,5	100	16	11	<input type="checkbox"/>	9	4	12,5	1402534	TC-CMF 14x1.50-6HX-V15-13	9127938	TC-CMF 14x1.50-6HX-V15-11	
MF 16	1,5	100	18	12	<input type="checkbox"/>	9	4	14,5	1402535	TC-CMF 16x1.50-6HX-V15-13	9127940	TC-CMF 16x1.50-6HX-V15-11	
MF 18	1,5	110	20	14	<input type="checkbox"/>	11	4	16,5	1402536	TC-CMF 18x1.50-6HX-V15-13	9127941	TC-CMF 18x1.50-6HX-V15-11	
MF 20	1,5	125	20	16	<input type="checkbox"/>	12	4	18,5	1402537	TC-CMF 20x1.50-6HX-V15-13	9127942	TC-CMF 20x1.50-6HX-V15-11	
MF 22	1,5	125	20	18	<input type="checkbox"/>	14,5	4	20,5	9127910	TC-CMF 22x1.50-6HX-V15-13	9127943	TC-CMF 22x1.50-6HX-V15-11	
MF 24	1,5	140	25	18	<input type="checkbox"/>	14,5	4	22,5	9127915	TC-CMF 24x1.50-6HX-V15-13	9127945	TC-CMF 24x1.50-6HX-V15-11	
MF 26	1,5	140	28	18	<input type="checkbox"/>	14,5	5	24,5	9127918	TC-CMF 26x1.50-6HX-V15-13	9127947	TC-CMF 26x1.50-6HX-V15-11	
MF 27	1,5	140	28	20	<input type="checkbox"/>	16	5	25,5	9127920	TC-CMF 27x1.50-6HX-V15-13	9127948	TC-CMF 27x1.50-6HX-V15-11	
MF 28	1,5	140	28	20	<input type="checkbox"/>	16	5	26,5	9127922	TC-CMF 28x1.50-6HX-V15-13	9127949	TC-CMF 28x1.50-6HX-V15-11	
MF 30	1,5	150	28	22	<input type="checkbox"/>	18	5	28,5	9127923	TC-CMF 30x1.50-6HX-V15-13	9127951	TC-CMF 30x1.50-6HX-V15-11	

Kernlochbohrer ab Seite 367
Pre-drills starting page 367

= Hauptanwendung First choice
 = Nebenanwendung Second choice