

| <div style="display: flex; justify-content: space-between; align-items: center;"> <div style="display: flex; gap: 5px;"> <span>M</span> <span>S</span> <span>DIN 2174</span> <span>h9</span> <span>3xD</span> <span>6HX</span> <span>HSS E-PM</span> <span>TiCN Plus</span> </div> <div style="display: flex; gap: 10px;"> </div> </div> |   |                |                |                |                |       |   |       |           |                        |           |                        |
|--|---|----------------|----------------|----------------|----------------|-------|---|-------|-----------|------------------------|-----------|------------------------|
|  |   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>Katalog-Nr. Cat.-No.</b>  |   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>6769C</b>   |   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>6391C</b>   |   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>P1</b>  | Stahl Steel < 500 N/mm <sup>2</sup> ■ v <sub>c</sub> = 20–40 m/min  |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>P2</b>  | Stahl Steel 500–1000 N/mm <sup>2</sup> ■ v <sub>c</sub> = 20–30 m/min   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>P3</b>  | Stahl Steel > 1000 N/mm <sup>2</sup> □ v <sub>c</sub> = 10–20 m/min   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>M1</b>  | Rostfreie austenitische Stähle Stainless steel austenitic ■ v <sub>c</sub> = 10–20 m/min                          |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>M2</b>  | Rostfreie martensitische Stähle Stainless steel martensitic □ v <sub>c</sub> = 10–15 m/min                        |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>K1</b>  | Grauguss Grey cast iron   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>K2</b>  | Sphäroguss Nodular cast iron □ v <sub>c</sub> = 20–30 m/min   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>N1</b>  | Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si ■ v <sub>c</sub> = 20–40 m/min      |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>N2</b>  | Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5–10 % Si ■ v <sub>c</sub> = 15–30 m/min     |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>N3</b>  | Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si                                   |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>N4</b>  | Graphit Graphite  |                |                |                |                |       |   |       |           |                        |           |                        |
| <b>S1</b>  | Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm <sup>2</sup> □ v <sub>c</sub> = 6–15 m/min |                |                |                |                |       |   |       |           |                        |           |                        |
| <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 5  | 0,8   | 70             | 8              | 25             | 6              | 4,9   | 4 | 4,65  | –         | –                      | 9128580   | TF-CM 05x0.80-6HX-N-13 |
| M 5  | 0,8   | 70             | 15             | 25             | 6              | 4,9   | 4 | 4,65  | 9128542   | TF-CM 05x0.80-6HX-S-13 | –         | –                      |
| M 6  | 1   | 80             | 16             | 30             | 6              | 4,9   | 4 | 5,55  | 9128543   | TF-CM 06x1.00-6HX-S-13 | 1410721   | TF-CM 06x1.00-6HX-N-13 |
| M 8  | 1,25  | 90             | 18             | 35             | 8              | 6,2   | 5 | 7,45  | 9128547   | TF-CM 08x1.25-6HX-S-13 | 1410722   | TF-CM 08x1.25-6HX-N-13 |
| M 10   | 1,5   | 100            | 20             | 39             | 10             | 8     | 4 | 9,3   | –         | –                      | 1410723   | TF-CM 10x1.50-6HX-N-13 |
| M 10   | 1,5   | 100            | 20             | 39             | 10             | 8     | 5 | 9,3   | 9128551   | TF-CM10x1.50-6HX-S-13  | –         | –                      |
| <b>mit Überlaufschaft with standard straight shank</b>   |   |                |                |                |                |       |   |       |           |                        |           |                        |
| M 12   | 1,75  | 110            | 24             | –              | 9              | 7     | 5 | 11,2  | 9128555   | TF-CM 12x1.75-6HX-S-13 | –         | –                      |
| M 14   | 2   | 110            | 26             | –              | 11             | 9     | 6 | 13,1  | 9128557   | TF-CM 14x2.00-6HX-S-13 | –         | –                      |
| M 16   | 2   | 110            | 28             | –              | 12             | 9     | 6 | 15,05 | 9128559   | TF-CM 16x2.00-6HX-S-13 | –         | –                      |

Kernlochbohrer ab Seite 367  
Pre-drills starting page 367

■ = Hauptanwendung First choice  
□ = Nebenanwendung Second choice