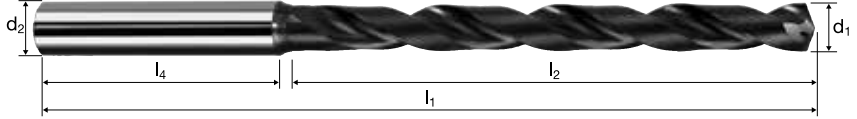
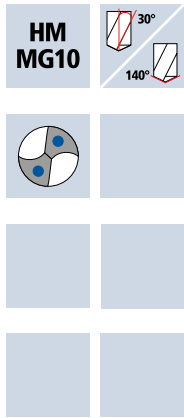


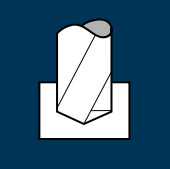








Spiral flute drills Supradrill® N

8xd

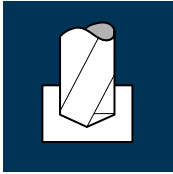


Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	GG(G) Aluminium
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Example: Order-N°.							DURO-SD	
Article-N°. ø-Code							B52020	
B52020 0400							B53020	
Ø Code	d ₁ m7	d ₂ h6	l ₁	l ₂	l ₄	L _{max}		
0400	4.00	6.0	82.0	44.0	36	34.9	●	
0420	4.20	6.0	82.0	44.0	36	34.8	●	
0450	4.50	6.0	82.0	44.0	36	34.6	●	
0480	4.80	6.0	82.0	44.0	36	34.4	●	
0500	5.00	6.0	95.0	57.0	36	47.7	●	
0550	5.50	6.0	95.0	57.0	36	47.5	●	
0580	5.80	6.0	95.0	57.0	36	47.3	●	
0600	6.00	6.0	95.0	57.0	36	47.4	●	
0650	6.50	8.0	115.0	76.0	36	65.0	●	
0680	6.80	8.0	115.0	76.0	36	64.8	●	
0700	7.00	8.0	115.0	76.0	36	64.7	●	
0750	7.50	8.0	115.0	76.0	36	64.4	●	
0780	7.80	8.0	115.0	76.0	36	64.3	●	
0800	8.00	8.0	115.0	76.0	36	64.3	●	
0850	8.50	10.0	138.0	95.0	40	81.0	●	
0900	9.00	10.0	138.0	95.0	40	80.7	●	
0950	9.50	10.0	138.0	95.0	40	80.4	●	
1000	10.00	10.0	138.0	95.0	40	80.2	●	
1050	10.50	12.0	162.0	114.0	45	97.0	●	
1100	11.00	12.0	162.0	114.0	45	96.6	●	
1150	11.50	12.0	162.0	114.0	45	96.4	●	
1200	12.00	12.0	162.0	114.0	45	96.2	●	

Application	Material	d_1 [mm]	v_c [m/min]	f [mm]	n [min ⁻¹]	v_f [mm/min]	Q [cm ³ /min]	
	Steel < 500 N/mm ² 	4.00	130	0.0850	10345	879	11.0	
		5.00	130	0.1050	8275	869	17.1	
		6.00	130	0.1250	6895	862	24.4	
		7.00	130	0.1450	5910	857	33.0	
		8.00	130	0.1700	5175	880	44.2	
		9.00	130	0.1900	4600	874	55.6	
		10.00	130	0.2100	4140	869	68.3	
		11.00	130	0.2300	3760	865	82.2	
		12.00	130	0.2550	3450	880	99.5	
		Steel 500 - 850 N/mm ² 	4.00	100	0.0850	7960	677	8.5
			5.00	100	0.1050	6365	668	13.1
			6.00	100	0.1250	5305	663	18.7
			7.00	100	0.1450	4545	659	25.4
8.00	100		0.1700	3980	677	34.0		
9.00	100		0.1900	3535	672	42.7		
10.00	100		0.2100	3185	669	52.5		
11.00	100		0.2300	2895	666	63.3		
12.00	100		0.2550	2655	677	76.6		
Steel 850 - 1100 N/mm ² 	4.00		70	0.0650	5570	362	4.6	
	5.00		70	0.0800	4455	356	7.0	
	6.00		70	0.0950	3715	353	10.0	
	7.00		70	0.1100	3185	350	13.5	
	8.00	70	0.1300	2785	362	18.2		
	9.00	70	0.1450	2475	359	22.8		
	10.00	70	0.1600	2230	357	28.0		
	11.00	70	0.1750	2025	354	33.7		
	12.00	70	0.1900	1855	353	39.9		
	Steel 1100 - 1300 N/mm ² 	4.00	50	0.0550	3980	219	2.8	
		5.00	50	0.0650	3185	207	4.1	
		6.00	50	0.0800	2655	212	6.0	
		7.00	50	0.0950	2275	216	8.3	
8.00		50	0.1050	1990	209	10.5		
9.00		50	0.1200	1770	212	13.5		
10.00		50	0.1350	1590	215	16.9		
11.00		50	0.1450	1445	210	19.9		
12.00		50	0.1600	1325	212	24.0		
Stainless steel [Cr-Ni/1.4301] 		4.00	50	0.0450	3980	179	2.3	
		5.00	50	0.0550	3185	175	3.4	
		6.00	50	0.0700	2655	186	5.3	
		7.00	50	0.0800	2275	182	7.0	
	8.00	50	0.0900	1990	179	9.0		
	9.00	50	0.1050	1770	186	11.8		
	10.00	50	0.1150	1590	183	14.4		
	11.00	50	0.1250	1445	181	17.2		
	12.00	50	0.1350	1325	179	20.2		
	Cast iron (lamellar / spheroidal)  	4.00	150	0.0900	11935	1074	13.5	
		5.00	150	0.1150	9550	1098	21.6	
		6.00	150	0.1350	7960	1075	30.4	
		7.00	150	0.1600	6820	1091	42.0	
8.00		150	0.1850	5970	1105	55.5		
9.00		150	0.2050	5305	1088	69.2		
10.00		150	0.2300	4775	1098	86.3		
11.00		150	0.2500	4340	1085	103.1		
12.00		150	0.2750	3980	1095	123.8		
Wrought aluminium alloys Si < 6% hardened 		4.00	200	0.0800	15915	1273	16.0	
		5.00	200	0.1000	12730	1273	25.0	
		6.00	200	0.1200	10610	1273	36.0	
		7.00	200	0.1400	9095	1273	49.0	
	8.00	200	0.1600	7960	1274	64.0		
	9.00	200	0.1800	7075	1274	81.0		
	10.00	200	0.2000	6365	1273	100.0		
	11.00	200	0.2200	5785	1273	120.9		
	12.00	200	0.2400	5305	1273	144.0		

Application



Material

Steel
< 500 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Stainless steel
[Cr-Ni/1.4301]



Cast iron
(lamellar / spheroidal)



Wrought aluminium alloys
Si < 6%
hardened



d ₁ [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
12.50	130	0.2650	3310	877	107.6
13.00	130	0.2750	3185	876	116.3
13.50	130	0.2850	3065	874	125.0
14.00	130	0.2950	2955	872	134.2
14.50	130	0.3050	2855	871	143.8
15.00	130	0.3150	2760	869	153.6
16.00	130	0.3350	2585	866	174.1
12.50	100	0.2650	2545	674	82.8
13.00	100	0.2750	2450	674	89.4
13.50	100	0.2850	2360	673	96.3
14.00	100	0.2950	2275	671	103.3
14.50	100	0.3050	2195	670	110.6
15.00	100	0.3150	2120	668	118.0
16.00	100	0.3350	1990	667	134.0
12.50	70	0.2000	1785	357	43.8
13.00	70	0.2100	1715	360	47.8
13.50	70	0.2150	1650	355	50.8
14.00	70	0.2250	1590	358	55.1
14.50	70	0.2300	1535	353	58.3
15.00	70	0.2400	1485	356	63.0
16.00	70	0.2550	1395	356	71.5
12.50	50	0.1650	1275	210	25.8
13.00	50	0.1750	1225	214	28.5
13.50	50	0.1800	1180	212	30.4
14.00	50	0.1850	1135	210	32.3
14.50	50	0.1950	1100	215	35.4
15.00	50	0.2000	1060	212	37.5
16.00	50	0.2150	995	214	43.0
12.50	50	0.1450	1275	185	22.7
13.00	50	0.1500	1225	184	24.4
13.50	50	0.1550	1180	183	26.2
14.00	50	0.1600	1135	182	28.0
14.50	50	0.1650	1100	182	30.0
15.00	50	0.1700	1060	180	31.8
16.00	50	0.1850	995	184	37.0
12.50	150	0.2850	3820	1089	133.6
13.00	150	0.2950	3675	1084	143.9
13.50	150	0.3100	3535	1096	156.9
14.00	150	0.3200	3410	1091	168.0
14.50	150	0.3300	3295	1087	179.6
15.00	150	0.3450	3185	1099	194.2
16.00	150	0.3650	2985	1090	219.1
12.50	200	0.2500	5095	1274	156.3
13.00	200	0.2600	4895	1273	168.9
13.50	200	0.2700	4715	1273	182.2
14.00	200	0.2800	4545	1273	195.9
14.50	200	0.2900	4390	1273	210.2
15.00	200	0.3000	4245	1274	225.0
16.00	200	0.3200	3980	1274	256.1