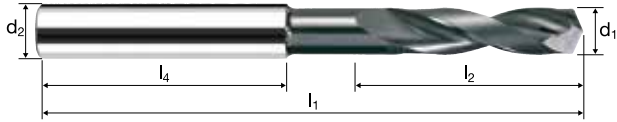
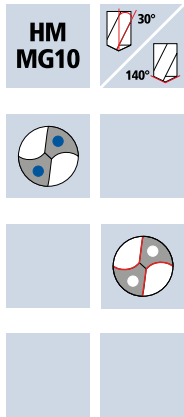


Spiral flute drills Supradrill® U

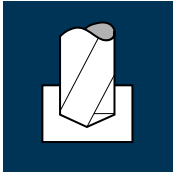
3xd



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless		GG(G) Aluminium
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Ø Code	d ₁ m7	d ₂ h5	l ₁	l ₂	l ₄	L _{max}	Article-N°. ø-Code		NANO-U ²
							Example: Order-N°.	B62011 0300	B62011 B63011
0300	3.00	6.0	62.0	20.0	36	16.2			●
0330	3.30	6.0	62.0	20.0	36	16.0			●
0340	3.40	6.0	62.0	20.0	36	15.8			●
0350	3.50	6.0	62.0	20.0	36	15.8			●
0370	3.70	6.0	62.0	20.0	36	15.6			●
0380	3.80	6.0	66.0	24.0	36	19.4			●
0400	4.00	6.0	66.0	24.0	36	18.9			●
0420	4.20	6.0	66.0	24.0	36	18.8			●
0450	4.50	6.0	66.0	24.0	36	18.6			●
0480	4.80	6.0	66.0	28.0	36	18.4			●
0500	5.00	6.0	66.0	28.0	36	18.8			●
0550	5.50	6.0	66.0	28.0	36	18.5			●
0580	5.80	6.0	66.0	28.0	36	18.4			●
0600	6.00	6.0	66.0	28.0	36	18.6			●
0650	6.50	8.0	79.0	34.0	36	29.1			●
0680	6.80	8.0	79.0	34.0	36	28.9			●
0700	7.00	8.0	79.0	34.0	36	28.8			●
0750	7.50	8.0	79.0	41.0	36	28.5			●
0780	7.80	8.0	79.0	41.0	36	28.4			●
0800	8.00	8.0	79.0	41.0	36	28.5			●
0850	8.50	10.0	89.0	47.0	40	32.1			●
0880	8.80	10.0	89.0	47.0	40	31.9			●
0900	9.00	10.0	89.0	47.0	40	31.7			●

Application



Material

Steel
< 500 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Steel
1300 - 1500 N/mm²



Stainless steel
[Cr-Ni/1.4301]



Cast iron
(lamellar / spheroidal)



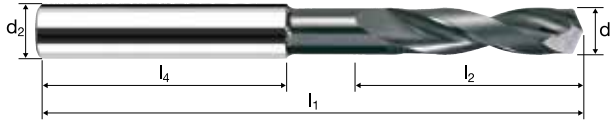
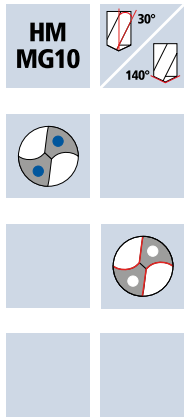
Wrought aluminium alloys
Si < 6%
hardened



d ₁ [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
3.00	170	0.0850	18040	1533	10.8
3.30	170	0.0950	16400	1560	13.3
3.50	170	0.1000	15460	1545	14.9
4.00	170	0.1150	13530	1555	19.5
4.20	170	0.1200	12885	1545	21.4
5.00	170	0.1450	10825	1570	30.8
6.00	170	0.1700	9020	1535	43.4
6.80	170	0.1950	7960	1550	56.3
8.50	170	0.2450	6365	1560	88.5
3.00	130	0.0850	13795	1173	8.3
3.30	130	0.0950	12540	1190	10.2
3.50	130	0.1000	11825	1185	11.4
4.00	130	0.1150	10345	1190	15.0
4.20	130	0.1200	9850	1180	16.3
5.00	130	0.1450	8275	1200	23.6
6.00	130	0.1700	6895	1170	33.1
6.80	130	0.1950	6085	1185	43.0
8.50	130	0.2450	4870	1195	67.8
3.00	110	0.0650	11670	759	5.4
3.30	110	0.0750	10610	795	6.8
3.50	110	0.0800	10005	800	7.7
4.00	110	0.0900	8755	790	9.9
4.20	110	0.0950	8335	790	10.9
5.00	110	0.1100	7005	770	15.1
6.00	110	0.1350	5835	790	22.3
6.80	110	0.1500	5150	775	28.1
8.50	110	0.1900	4120	785	44.5
3.00	70	0.0550	7425	408	2.9
3.30	70	0.0600	6750	405	3.5
3.50	70	0.0600	6365	380	3.7
4.00	70	0.0700	5570	390	4.9
4.20	70	0.0750	5305	400	5.5
5.00	70	0.0900	4455	400	7.9
6.00	70	0.1050	3715	390	11.0
6.80	70	0.1200	3275	395	14.3
8.50	70	0.1500	2620	395	22.4
3.00	40	0.0450	4245	191	1.4
3.30	40	0.0450	3860	175	1.5
3.50	40	0.0500	3640	180	1.7
4.00	40	0.0550	3185	175	2.2
4.20	40	0.0600	3030	180	2.5
5.00	40	0.0700	2545	180	3.5
6.00	40	0.0850	2120	180	5.1
6.80	40	0.0950	1870	180	6.5
8.50	40	0.1200	1500	180	10.2
3.00	60	0.0450	6365	286	2.0
3.30	60	0.0500	5785	290	2.5
3.50	60	0.0500	5455	275	2.6
4.00	60	0.0600	4775	285	3.6
4.20	60	0.0650	4545	295	4.1
5.00	60	0.0750	3820	285	5.6
6.00	60	0.0900	3185	285	8.1
6.80	60	0.1000	2810	280	10.2
8.50	60	0.1250	2245	280	15.9
3.00	220	0.0950	23345	2218	15.7
3.30	220	0.1050	21220	2230	19.1
3.50	220	0.1100	20010	2200	21.2
4.00	220	0.1250	17505	2190	27.5
4.20	220	0.1300	16675	2170	30.1
5.00	220	0.1550	14005	2170	42.6
6.00	220	0.1900	11670	2215	62.6
6.80	220	0.2150	10300	2215	80.4
8.50	220	0.2650	8240	2185	124.0
3.00	250	0.0850	26525	2255	15.9
3.30	250	0.0950	24115	2290	19.6
3.50	250	0.1000	22735	2275	21.9
4.00	250	0.1150	19895	2290	28.8
4.20	250	0.1200	18945	2275	31.5
5.00	250	0.1450	15915	2310	45.4
6.00	250	0.1700	13265	2255	63.8
6.80	250	0.1950	11705	2280	82.8
8.50	250	0.2450	9360	2295	130.2

Spiral flute drills Supradrill® U

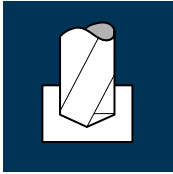
3xd



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless		GG(G) Aluminium
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Example: Order-N°.							Article-N°. ø-Code		NANO-U ²	
							B62011 0950		B62011	
									B63011	
Ø Code	d ₁ m7	d ₂ h5	l ₁	l ₂	l ₄	L _{max}				
0950	9.50	10.0	89.0	47.0	40	31.5	●			
0980	9.80	10.0	89.0	47.0	40	31.4	●			
1000	10.00	10.0	89.0	47.0	40	31.5	●			
1020	10.20	12.0	102.0	55.0	45	37.2	●			
1050	10.50	12.0	102.0	55.0	45	37.1	●			
1080	10.80	12.0	102.0	55.0	45	36.9	●			
1100	11.00	12.0	102.0	55.0	45	36.7	●			
1150	11.50	12.0	102.0	55.0	45	36.5	●			
1180	11.80	12.0	102.0	55.0	45	36.3	●			
1200	12.00	12.0	102.0	55.0	45	36.4	●			
1250	12.50	14.0	107.0	60.0	45	39.1	●			
1280	12.80	14.0	107.0	60.0	45	38.9	●			
1300	13.00	14.0	107.0	60.0	45	38.7	●			
1350	13.50	14.0	107.0	60.0	45	38.5	●			
1380	13.80	14.0	107.0	60.0	45	38.3	●			
1400	14.00	14.0	107.0	60.0	45	38.4	●			
1450	14.50	16.0	115.0	65.0	48	41.1	●			
1480	14.80	16.0	115.0	65.0	48	40.8	●			
1500	15.00	16.0	115.0	65.0	48	40.7	●			
1550	15.50	16.0	115.0	65.0	48	40.5	●			
1580	15.80	16.0	115.0	65.0	48	40.3	●			
1600	16.00	16.0	115.0	65.0	48	40.4	●			

Application



Material

Steel
< 500 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Steel
1300 - 1500 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]
10.00	170	0.2850	5410	1540	121.0
10.20	170	0.2900	5305	1540	125.8
11.00	170	0.3150	4920	1550	147.3
12.00	170	0.3450	4510	1555	175.9
13.00	170	0.3700	4165	1540	204.4
14.00	170	0.4000	3865	1545	237.8
15.00	170	0.4300	3610	1550	273.9
15.50	170	0.4450	3490	1555	293.4
16.00	170	0.4550	3380	1540	309.6
10.00	130	0.2850	4140	1180	92.7
10.20	130	0.2900	4055	1175	96.0
11.00	130	0.3150	3760	1185	112.6
12.00	130	0.3450	3450	1190	134.6
13.00	130	0.3700	3185	1180	156.6
14.00	130	0.4000	2955	1180	181.6
15.00	130	0.4300	2760	1185	209.4
15.50	130	0.4450	2670	1190	224.5
16.00	130	0.4550	2585	1175	236.2
10.00	110	0.2200	3500	770	60.5
10.20	110	0.2250	3435	775	63.3
11.00	110	0.2450	3185	780	74.1
12.00	110	0.2650	2920	775	87.7
13.00	110	0.2900	2695	780	103.5
14.00	110	0.3100	2500	775	119.3
15.00	110	0.3350	2335	780	137.8
15.50	110	0.3450	2260	780	147.2
16.00	110	0.3550	2190	775	155.8
10.00	70	0.1750	2230	390	30.6
10.20	70	0.1800	2185	395	32.3
11.00	70	0.1950	2025	395	37.5
12.00	70	0.2100	1855	390	44.1
13.00	70	0.2300	1715	395	52.4
14.00	70	0.2450	1590	390	60.0
15.00	70	0.2650	1485	395	69.8
15.50	70	0.2700	1440	390	73.6
16.00	70	0.2800	1395	390	78.4
10.00	40	0.1450	1275	185	14.5
10.20	40	0.1450	1250	180	14.7
11.00	40	0.1550	1155	180	17.1
12.00	40	0.1700	1060	180	20.4
13.00	40	0.1850	980	180	23.9
14.00	40	0.2000	910	180	27.7
15.00	40	0.2150	850	185	32.7
15.50	40	0.2200	820	180	34.0
16.00	40	0.2300	795	185	37.2
10.00	60	0.1500	1910	285	22.4
10.20	60	0.1500	1870	280	22.9
11.00	60	0.1650	1735	285	27.1
12.00	60	0.1800	1590	285	32.2
13.00	60	0.1950	1470	285	37.8
14.00	60	0.2100	1365	285	43.9
15.00	60	0.2250	1275	285	50.4
15.50	60	0.2300	1230	285	53.8
16.00	60	0.2400	1195	285	57.3
10.00	220	0.3150	7005	2205	173.2
10.20	220	0.3200	6865	2195	179.4
11.00	220	0.3450	6365	2195	208.6
12.00	220	0.3750	5835	2190	247.7
13.00	220	0.4050	5385	2180	289.4
14.00	220	0.4400	5000	2200	338.7
15.00	220	0.4700	4670	2195	387.9
15.50	220	0.4850	4520	2190	413.2
16.00	220	0.5000	4375	2190	440.3
10.00	250	0.2850	7960	2270	178.3
10.20	250	0.2900	7800	2260	184.7
11.00	250	0.3150	7235	2280	216.7
12.00	250	0.3450	6630	2285	258.4
13.00	250	0.3700	6120	2265	300.6
14.00	250	0.4000	5685	2275	350.2
15.00	250	0.4300	5305	2280	402.9
15.50	250	0.4450	5135	2285	431.2
16.00	250	0.4550	4975	2265	455.4