

Эскиз инструмента	Серия	Вид охлаждения	Диаметры	Артикул	Область применения					
					P	M	K	N	S	H

Монолитные твердосплавные сверла 3xD										
	MD800F		d1 3-20	1001	•	•		•	•	
	MD800F		d1 3-20	C1001	•	•		•	•	
	MD800U		d1 3-20	1002	•	○	•	○	○	○
	MD800U		d1 3-20	C1002	•	○	•	○	○	○
	MD800H		d1 3-20	1003	•				○	•
	MD800H		d1 3-20	C1003	•				○	•
	MD800VA		d1 3-20	C1004		•			•	
	MS-KA		d1 3-20	1006					•	
	MS-KA		d1 3-20	C1006					•	

Монолитные твердосплавные сверла 5xD										
	MD800F		d1 3-25	1019	•	•		•	•	
	MD800F		d1 3-25	C1019	•	•		•	•	
	MD800U		d1 3-25	1021	•	○	•	○	○	○
	MD800U		d1 3-25	C1021	•	○	•	○	○	○
	MD800H		d1 3-25	C1022	•				○	•
	MD800VA		d1 3-25	C1020		•			•	
	MS-KA		d1 3-25	C1026					•	


Монолитные твердосплавные сверла 7xD										
	MD800U		d1 3-20	C1045	•	○	•	○	○	○
	MD800H		d1 3-20	C1046	•				○	•
	MS-KA		d1 3-20	C1047					•	

- - рекомендованное применение
- - возможное применение



	Серия	Вид охлаждения	Диаметры	Артикул	Область применения					
					P	M	K	N	S	H

Монолитные твердосплавные сверла с прямой канавкой 4xD										
	MD850AL		d1 3-20	C1082					•	
	MG-KA		d1 3-20	C1088					•	
	MD850G		d1 3-20	C1085			•			

Монолитные твердосплавные сверла с прямой канавкой 7xD										
	MD850AL		d1 3-20	C1083					•	
	MG-KA		d1 3-20	C1089					•	
	MD850G		d1 3-20	C1086			•			

Монолитные твердосплавные свёрла с прямой канавкой 10xD									
	MD850AL		d1 3-20	C1084				•	
	MG-KA		d1 3-20	C1090				•	
	MD850G		d1 3-20	C1087			•		

Спиральные твердосплавные свёрла с цилиндрическим хвостовиком 3xD									
	MSN		d1 3-16	1005	•	•	•	•	○

Спиральные твердосплавные свёрла с цилиндрическим хвостовиком 5xD									
	MSN		d1 3-14	1025	•	•	•	•	○

Центровочные твердосплавные сверла									
	MCN		90° d1 3-25	1077	•	•	•	•	•
	MCN		120° d1 3-25	1078	•	•	•	•	•
	MCN		118°/60° d1 1-12,5	1079	•	•	•	•	•

- - рекомендованное применение
- - возможное применение

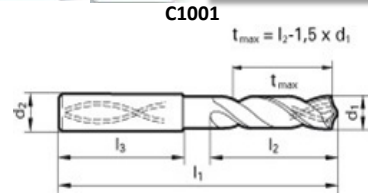
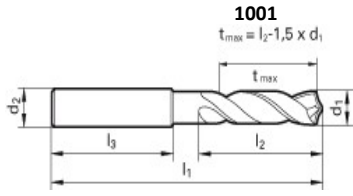
Сверла

Артикул	Серия
1001/C1001	MD800F
d1 = 3-20	

М **МЕТАЛЛЕКТ**



С покрытием



P	M	K	N	S	H
•	•	•	•	•	•

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	62,0	20,0	36,0
3,1	6,0	62,0	20,0	36,0
3,2	6,0	62,0	20,0	36,0
3,3	6,0	62,0	20,0	36,0
3,4	6,0	62,0	20,0	36,0
3,5	6,0	62,0	20,0	36,0
3,6	6,0	62,0	20,0	36,0
3,7	6,0	62,0	20,0	36,0
3,8	6,0	66,0	24,0	36,0
3,9	6,0	66,0	24,0	36,0
4,0	6,0	66,0	24,0	36,0
4,1	6,0	66,0	24,0	36,0
4,2	6,0	66,0	24,0	36,0
4,3	6,0	66,0	24,0	36,0
4,4	6,0	66,0	24,0	36,0
4,5	6,0	66,0	24,0	36,0
4,6	6,0	66,0	24,0	36,0
4,7	6,0	66,0	24,0	36,0
4,8	6,0	66,0	28,0	36,0
4,9	6,0	66,0	28,0	36,0
5,0	6,0	66,0	28,0	36,0
5,1	6,0	66,0	28,0	36,0
5,2	6,0	66,0	28,0	36,0
5,3	6,0	66,0	28,0	36,0
5,4	6,0	66,0	28,0	36,0
5,5	6,0	66,0	28,0	36,0
5,6	6,0	66,0	28,0	36,0
5,7	6,0	66,0	28,0	36,0
5,8	6,0	66,0	28,0	36,0
5,9	6,0	66,0	28,0	36,0
6,0	6,0	66,0	28,0	36,0
6,1	8,0	79,0	34,0	36,0
6,2	8,0	79,0	34,0	36,0
6,3	8,0	79,0	34,0	36,0
6,4	8,0	79,0	34,0	36,0
6,5	8,0	79,0	34,0	36,0
6,6	8,0	79,0	34,0	36,0
6,7	8,0	79,0	34,0	36,0
6,8	8,0	79,0	34,0	36,0
6,9	8,0	79,0	34,0	36,0
7,0	8,0	79,0	34,0	36,0
7,1	8,0	79,0	41,0	36,0
7,2	8,0	79,0	41,0	36,0
7,3	8,0	79,0	41,0	36,0
7,4	8,0	79,0	41,0	36,0
7,5	8,0	79,0	41,0	36,0
7,6	8,0	79,0	41,0	36,0
7,7	8,0	79,0	41,0	36,0
7,8	8,0	79,0	41,0	36,0
7,9	8,0	79,0	41,0	36,0
8,0	8,0	79,0	41,0	36,0
8,1	10,0	89,0	47,0	40,0
8,2	10,0	89,0	47,0	40,0
8,3	10,0	89,0	47,0	40,0
8,4	10,0	89,0	47,0	40,0
8,5	10,0	89,0	47,0	40,0
8,6	10,0	89,0	47,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	89,0	47,0	40,0
8,8	10,0	89,0	47,0	40,0
8,9	10,0	89,0	47,0	40,0
9,0	10,0	89,0	47,0	40,0
9,1	10,0	89,0	47,0	40,0
9,2	10,0	89,0	47,0	40,0
9,3	10,0	89,0	47,0	40,0
9,4	10,0	89,0	47,0	40,0
9,5	10,0	89,0	47,0	40,0
9,6	10,0	89,0	47,0	40,0
9,7	10,0	89,0	47,0	40,0
9,8	10,0	89,0	47,0	40,0
9,9	10,0	89,0	47,0	40,0
10,0	10,0	89,0	47,0	40,0
10,1	12,0	102,0	55,0	45,0
10,2	12,0	102,0	55,0	45,0
10,3	12,0	102,0	55,0	45,0
10,4	12,0	102,0	55,0	45,0
10,5	12,0	102,0	55,0	45,0
10,6	12,0	102,0	55,0	45,0
10,7	12,0	102,0	55,0	45,0
10,8	12,0	102,0	55,0	45,0
10,9	12,0	102,0	55,0	45,0
11,0	12,0	102,0	55,0	45,0
11,1	12,0	102,0	55,0	45,0
11,2	12,0	102,0	55,0	45,0
11,3	12,0	102,0	55,0	45,0
11,4	12,0	102,0	55,0	45,0
11,5	12,0	102,0	55,0	45,0
11,6	12,0	102,0	55,0	45,0
11,7	12,0	102,0	55,0	45,0
11,8	12,0	102,0	55,0	45,0
11,9	12,0	102,0	55,0	45,0
12,0	12,0	102,0	55,0	45,0
12,1	14,0	107,0	60,0	45,0
12,2	14,0	107,0	60,0	45,0
12,3	14,0	107,0	60,0	45,0
12,4	14,0	107,0	60,0	45,0
12,5	14,0	107,0	60,0	45,0
12,6	14,0	107,0	60,0	45,0
12,7	14,0	107,0	60,0	45,0
12,8	14,0	107,0	60,0	45,0
12,9	14,0	107,0	60,0	45,0
13,0	14,0	107,0	60,0	45,0
13,1	14,0	107,0	60,0	45,0
13,2	14,0	107,0	60,0	45,0
13,3	14,0	107,0	60,0	45,0
13,4	14,0	107,0	60,0	45,0
13,5	14,0	107,0	60,0	45,0
13,6	14,0	107,0	60,0	45,0
13,7	14,0	107,0	60,0	45,0
13,8	14,0	107,0	60,0	45,0
13,9	14,0	107,0	60,0	45,0
14,0	14,0	107,0	60,0	45,0
14,1	16,0	115,0	65,0	48,0
14,2	16,0	115,0	65,0	48,0
14,3	16,0	115,0	65,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	115,0	65,0	48,0
14,5	16,0	115,0	65,0	48,0
14,6	16,0	115,0	65,0	48,0
14,7	16,0	115,0	65,0	48,0
14,8	16,0	115,0	65,0	48,0
14,9	16,0	115,0	65,0	48,0
15,0	16,0	115,0	65,0	48,0
15,1	16,0	115,0	65,0	48,0
15,2	16,0	115,0	65,0	48,0
15,3	16,0	115,0	65,0	48,0
15,4	16,0	115,0	65,0	48,0
15,5	16,0	115,0	65,0	48,0
15,6	16,0	115,0	65,0	48,0
15,7	16,0	115,0	65,0	48,0
15,8	16,0	115,0	65,0	48,0
15,9	16,0	115,0	65,0	48,0
16,0	16,0	115,0	65,0	48,0
16,1	18,0	123,0	73,0	48,0
16,2	18,0	123,0	73,0	48,0
16,3	18,0	123,0	73,0	48,0
16,4	18,0	123,0	73,0	48,0
16,5	18,0	123,0	73,0	48,0
16,6	18,0	123,0	73,0	48,0
16,7	18,0	123,0	73,0	48,0
16,8	18,0	123,0	73,0	48,0
16,9	18,0	123,0	73,0	48,0
17,0	18,0	123,0	73,0	48,0
17,1	18,0	123,0	73,0	48,0
17,2	18,0	123,0	73,0	48,0
17,3	18,0	123,0	73,0	48,0
17,4	18,0	123,0	73,0	48,0
17,5	18,0	123,0	73,0	48,0
17,6	18,0	123,0	73,0	48,0
17,7	18,0	123,0	73,0	48,0
17,8	18,0	123,0	73,0	48,0
17,9	18,0	123,0	73,0	48,0
18,0	18,0	123,0	73,0	48,0
18,1	20,0	131,0	79,0	50,0
18,2	20,0	131,0	79,0	50,0
18,3	20,0	131,0	79,0	50,0
18,4	20,0	131,0	79,0	50,0
18,5	20,0	131,0	79,0	50,0
18,6	20,0	131,0	79,0	50,0
18,7	20,0	131,0	79,0	50,0
18,8	20,0	131,0	79,0	50,0
18,9	20,0	131,0	79,0	50,0
19,0	20,0	131,0	79,0	50,0
19,1	20,0	131,0	79,0	50,0
19,2	20,0	131,0	79,0	50,0
19,3	20,0	131,0	79,0	50,0
19,4	20,0	131,0	79,0	50,0
19,5	20,0	131,0	79,0	50,0
19,6	20,0	131,0	79,0	50,0
19,7	20,0	131,0	79,0	50,0
19,8	20,0	131,0	79,0	50,0
19,9	20,0	131,0	79,0	50,0
20,0	20,0	131,0	79,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: 1001-10,0-НА - сверло диаметром 10,0 без внутренних каналов охлаждения, форма хвостовика НА по DIN 6535

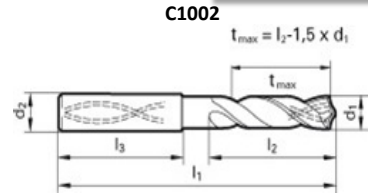
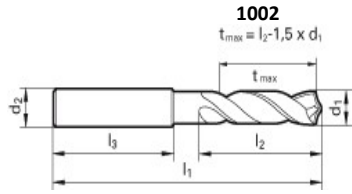
C1001-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности Н/мм ²	Твёрд.	V _c м/мин		Подача (№ в табл.)	
					1001	с1001	1001	с1001
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2)	≤500		130	145	7	7
		1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤1000		110	120	6	6
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36)	≤850		145	170	8	8
		1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤1000		110	145	7	8
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30)	≤700		120	130	7	8
		1.0503 C45, 1.1191 C45E (Ck45)	≤850		110	125	7	7
		1.0601 C60, 1.1221 C60E (Ck60)	≤1000		105	120	7	7
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4	≤1000		105	120	7	7
		1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1400		100	105	6	7
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		130	145	8	8
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		120	120	7	7
		1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1400		85	85	5	5
	Азотированные стали	1.8504 34CrAl6	≤850		100	110	6	7
		1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1400		90	105	5	5
Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9	≤850		65	80	6	6	
	1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤1400		55	65	5	5	
Быстрорежущие стали	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400			60	4	4	
Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	45	60	3	3	
M	Нерж. стали, с сод. Серы аустенитные мартенситные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		55	60	4	5
		1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		45	55	4	5
		1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		45	45	3	5
S	Специальные сплавы Титан и титановые сплавы	Нимоник, инконель, монель, хастеллой	≤2000		25	35	4	4
		3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		40	45	3	4
		3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		35	40	3	3
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		260	310	9	9
		3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		260	310	9	9
	Лит. ал. сплавы ≤ 10% Si > 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		220	260	9	9
		3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		180	220	8	9
	Магниеые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		260	280	8	8
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		105	125	7	7
		2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		270	325	8	8
		2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		180	220	7	7
		2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		105	125	6	7
		2.0790 CuNi18Zn19Pb	≤850		85	105	6	6
2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10		≤850		80	90	5	6	
Бронза, с короткой стружкой	2.0980 CuAl11Ni, 2.1247 CuBe2	≤1000		60	80	5	6	

Сверла

Артикул	Серия
1002/C1002	MD800U
d1 = 3-20	



P	M	K	N	S	H
●	○	●	○	○	○

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	62,0	20,0	36,0
3,1	6,0	62,0	20,0	36,0
3,2	6,0	62,0	20,0	36,0
3,3	6,0	62,0	20,0	36,0
3,4	6,0	62,0	20,0	36,0
3,5	6,0	62,0	20,0	36,0
3,6	6,0	62,0	20,0	36,0
3,7	6,0	62,0	20,0	36,0
3,8	6,0	66,0	24,0	36,0
3,9	6,0	66,0	24,0	36,0
4,0	6,0	66,0	24,0	36,0
4,1	6,0	66,0	24,0	36,0
4,2	6,0	66,0	24,0	36,0
4,3	6,0	66,0	24,0	36,0
4,4	6,0	66,0	24,0	36,0
4,5	6,0	66,0	24,0	36,0
4,6	6,0	66,0	24,0	36,0
4,7	6,0	66,0	24,0	36,0
4,8	6,0	66,0	28,0	36,0
4,9	6,0	66,0	28,0	36,0
5,0	6,0	66,0	28,0	36,0
5,1	6,0	66,0	28,0	36,0
5,2	6,0	66,0	28,0	36,0
5,3	6,0	66,0	28,0	36,0
5,4	6,0	66,0	28,0	36,0
5,5	6,0	66,0	28,0	36,0
5,6	6,0	66,0	28,0	36,0
5,7	6,0	66,0	28,0	36,0
5,8	6,0	66,0	28,0	36,0
5,9	6,0	66,0	28,0	36,0
6,0	6,0	66,0	28,0	36,0
6,1	8,0	79,0	34,0	36,0
6,2	8,0	79,0	34,0	36,0
6,3	8,0	79,0	34,0	36,0
6,4	8,0	79,0	34,0	36,0
6,5	8,0	79,0	34,0	36,0
6,6	8,0	79,0	34,0	36,0
6,7	8,0	79,0	34,0	36,0
6,8	8,0	79,0	34,0	36,0
6,9	8,0	79,0	34,0	36,0
7,0	8,0	79,0	34,0	36,0
7,1	8,0	79,0	41,0	36,0
7,2	8,0	79,0	41,0	36,0
7,3	8,0	79,0	41,0	36,0
7,4	8,0	79,0	41,0	36,0
7,5	8,0	79,0	41,0	36,0
7,6	8,0	79,0	41,0	36,0
7,7	8,0	79,0	41,0	36,0
7,8	8,0	79,0	41,0	36,0
7,9	8,0	79,0	41,0	36,0
8,0	8,0	79,0	41,0	36,0
8,1	10,0	89,0	47,0	40,0
8,2	10,0	89,0	47,0	40,0
8,3	10,0	89,0	47,0	40,0
8,4	10,0	89,0	47,0	40,0
8,5	10,0	89,0	47,0	40,0
8,6	10,0	89,0	47,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	89,0	47,0	40,0
8,8	10,0	89,0	47,0	40,0
8,9	10,0	89,0	47,0	40,0
9,0	10,0	89,0	47,0	40,0
9,1	10,0	89,0	47,0	40,0
9,2	10,0	89,0	47,0	40,0
9,3	10,0	89,0	47,0	40,0
9,4	10,0	89,0	47,0	40,0
9,5	10,0	89,0	47,0	40,0
9,6	10,0	89,0	47,0	40,0
9,7	10,0	89,0	47,0	40,0
9,8	10,0	89,0	47,0	40,0
9,9	10,0	89,0	47,0	40,0
10,0	10,0	89,0	47,0	40,0
10,1	12,0	102,0	55,0	45,0
10,2	12,0	102,0	55,0	45,0
10,3	12,0	102,0	55,0	45,0
10,4	12,0	102,0	55,0	45,0
10,5	12,0	102,0	55,0	45,0
10,6	12,0	102,0	55,0	45,0
10,7	12,0	102,0	55,0	45,0
10,8	12,0	102,0	55,0	45,0
10,9	12,0	102,0	55,0	45,0
11,0	12,0	102,0	55,0	45,0
11,1	12,0	102,0	55,0	45,0
11,2	12,0	102,0	55,0	45,0
11,3	12,0	102,0	55,0	45,0
11,4	12,0	102,0	55,0	45,0
11,5	12,0	102,0	55,0	45,0
11,6	12,0	102,0	55,0	45,0
11,7	12,0	102,0	55,0	45,0
11,8	12,0	102,0	55,0	45,0
11,9	12,0	102,0	55,0	45,0
12,0	12,0	102,0	55,0	45,0
12,1	14,0	107,0	60,0	45,0
12,2	14,0	107,0	60,0	45,0
12,3	14,0	107,0	60,0	45,0
12,4	14,0	107,0	60,0	45,0
12,5	14,0	107,0	60,0	45,0
12,6	14,0	107,0	60,0	45,0
12,7	14,0	107,0	60,0	45,0
12,8	14,0	107,0	60,0	45,0
12,9	14,0	107,0	60,0	45,0
13,0	14,0	107,0	60,0	45,0
13,1	14,0	107,0	60,0	45,0
13,2	14,0	107,0	60,0	45,0
13,3	14,0	107,0	60,0	45,0
13,4	14,0	107,0	60,0	45,0
13,5	14,0	107,0	60,0	45,0
13,6	14,0	107,0	60,0	45,0
13,7	14,0	107,0	60,0	45,0
13,8	14,0	107,0	60,0	45,0
13,9	14,0	107,0	60,0	45,0
14,0	14,0	107,0	60,0	45,0
14,1	16,0	115,0	65,0	48,0
14,2	16,0	115,0	65,0	48,0
14,3	16,0	115,0	65,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	115,0	65,0	48,0
14,5	16,0	115,0	65,0	48,0
14,6	16,0	115,0	65,0	48,0
14,7	16,0	115,0	65,0	48,0
14,8	16,0	115,0	65,0	48,0
14,9	16,0	115,0	65,0	48,0
15,0	16,0	115,0	65,0	48,0
15,1	16,0	115,0	65,0	48,0
15,2	16,0	115,0	65,0	48,0
15,3	16,0	115,0	65,0	48,0
15,4	16,0	115,0	65,0	48,0
15,5	16,0	115,0	65,0	48,0
15,6	16,0	115,0	65,0	48,0
15,7	16,0	115,0	65,0	48,0
15,8	16,0	115,0	65,0	48,0
15,9	16,0	115,0	65,0	48,0
16,0	16,0	115,0	65,0	48,0
16,1	18,0	123,0	73,0	48,0
16,2	18,0	123,0	73,0	48,0
16,3	18,0	123,0	73,0	48,0
16,4	18,0	123,0	73,0	48,0
16,5	18,0	123,0	73,0	48,0
16,6	18,0	123,0	73,0	48,0
16,7	18,0	123,0	73,0	48,0
16,8	18,0	123,0	73,0	48,0
16,9	18,0	123,0	73,0	48,0
17,0	18,0	123,0	73,0	48,0
17,1	18,0	123,0	73,0	48,0
17,2	18,0	123,0	73,0	48,0
17,3	18,0	123,0	73,0	48,0
17,4	18,0	123,0	73,0	48,0
17,5	18,0	123,0	73,0	48,0
17,6	18,0	123,0	73,0	48,0
17,7	18,0	123,0	73,0	48,0
17,8	18,0	123,0	73,0	48,0
17,9	18,0	123,0	73,0	48,0
18,0	18,0	123,0	73,0	48,0
18,1	20,0	131,0	79,0	50,0
18,2	20,0	131,0	79,0	50,0
18,3	20,0	131,0	79,0	50,0
18,4	20,0	131,0	79,0	50,0
18,5	20,0	131,0	79,0	50,0
18,6	20,0	131,0	79,0	50,0
18,7	20,0	131,0	79,0	50,0
18,8	20,0	131,0	79,0	50,0
18,9	20,0	131,0	79,0	50,0
19,0	20,0	131,0	79,0	50,0
19,1	20,0	131,0	79,0	50,0
19,2	20,0	131,0	79,0	50,0
19,3	20,0	131,0	79,0	50,0
19,4	20,0	131,0	79,0	50,0
19,5	20,0	131,0	79,0	50,0
19,6	20,0	131,0	79,0	50,0
19,7	20,0	131,0	79,0	50,0
19,8	20,0	131,0	79,0	50,0
19,9	20,0	131,0	79,0	50,0
20,0	20,0	131,0	79,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: 1002-10,0-НА - сверло диаметром 10,0 без внутренних каналов охлаждения, форма хвостовика НА по DIN 6535

C1002-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности Н/мм ²	Твёрд.	V _c м/мин		Подача (№ в табл.)		
				1002	с1002	1002	с1002	
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2) 1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		130 145 110 120	7 7 6 6	7 7 6 6	
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		145 170 110 145	8 8 7 8	8 8 7 8	
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		120 130 110 125 105 120	7 7 7 7 7 7	8 8 7 7 7 7	
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤1400		105 120 100 105	7 7 6 7	7 7 6 7	
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		130 145	8 8	8 8	
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1000 ≤1400		120 120 85 85	7 7 5 5	7 7 5 5	
	Азотированные стали	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤850 ≤1400		100 110 90 105	6 7 5 5	7 7 5 5	
	Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤1400		65 80 55 65	6 6 5 5	6 6 5 5	
	Быстрорежущие стали	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400				4 4	
	Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	45 60	3 3	3 3	
	M	Нерж. стали, с сод. Серы	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		55 60	4 5	5 5
		аустенитные	1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		45 55	4 5	5 5
		мартенситные	1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		45 45	3 5	5 5
	K	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤240 HB ≤350 HB	210 210 155 160	8 9 8 9	9 9 8 9
Высокопрочный и ковкий чугун		0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35) 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤240 HB ≤350 HB	155 140 125 130	7 9 7 8	9 9 8 8	
Отбеленный чугун		-		≤350 HB	35 40	3 3	3 3	
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		260 310	9 9	9 9	
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		260 310	9 9	9 9	
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		220 260	8 9	9 9	
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		180 220	8 9	9 9	
	Магниеые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		260 280	8 8	8 8	
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		105 125	7 7	7 7	
	Латунь с короткой струж с длинной стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600 ≤600		270 325 180 220	8 8 7 7	8 8 7 7	
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 ≤850		105 125 85 105	6 7 6 6	7 7 6 6	
	Бронза, с длинной стружкой	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		80 90 60 80	5 6 5 6	6 6 6 6	

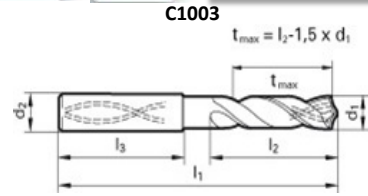
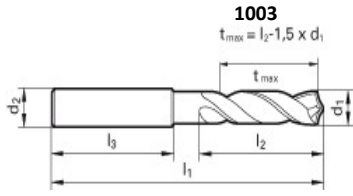
Сверла

Артикул	Серия
1003/С1003	MD800Н
d1 = 3-20	

М **МЕТАЛЛЕКТ**



С покрытием



P	M	K	N	S	H
●				○	●

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	62,0	20,0	36,0
3,1	6,0	62,0	20,0	36,0
3,2	6,0	62,0	20,0	36,0
3,3	6,0	62,0	20,0	36,0
3,4	6,0	62,0	20,0	36,0
3,5	6,0	62,0	20,0	36,0
3,6	6,0	62,0	20,0	36,0
3,7	6,0	62,0	20,0	36,0
3,8	6,0	66,0	24,0	36,0
3,9	6,0	66,0	24,0	36,0
4,0	6,0	66,0	24,0	36,0
4,1	6,0	66,0	24,0	36,0
4,2	6,0	66,0	24,0	36,0
4,3	6,0	66,0	24,0	36,0
4,4	6,0	66,0	24,0	36,0
4,5	6,0	66,0	24,0	36,0
4,6	6,0	66,0	24,0	36,0
4,7	6,0	66,0	24,0	36,0
4,8	6,0	66,0	28,0	36,0
4,9	6,0	66,0	28,0	36,0
5,0	6,0	66,0	28,0	36,0
5,1	6,0	66,0	28,0	36,0
5,2	6,0	66,0	28,0	36,0
5,3	6,0	66,0	28,0	36,0
5,4	6,0	66,0	28,0	36,0
5,5	6,0	66,0	28,0	36,0
5,6	6,0	66,0	28,0	36,0
5,7	6,0	66,0	28,0	36,0
5,8	6,0	66,0	28,0	36,0
5,9	6,0	66,0	28,0	36,0
6,0	6,0	66,0	28,0	36,0
6,1	8,0	79,0	34,0	36,0
6,2	8,0	79,0	34,0	36,0
6,3	8,0	79,0	34,0	36,0
6,4	8,0	79,0	34,0	36,0
6,5	8,0	79,0	34,0	36,0
6,6	8,0	79,0	34,0	36,0
6,7	8,0	79,0	34,0	36,0
6,8	8,0	79,0	34,0	36,0
6,9	8,0	79,0	34,0	36,0
7,0	8,0	79,0	34,0	36,0
7,1	8,0	79,0	41,0	36,0
7,2	8,0	79,0	41,0	36,0
7,3	8,0	79,0	41,0	36,0
7,4	8,0	79,0	41,0	36,0
7,5	8,0	79,0	41,0	36,0
7,6	8,0	79,0	41,0	36,0
7,7	8,0	79,0	41,0	36,0
7,8	8,0	79,0	41,0	36,0
7,9	8,0	79,0	41,0	36,0
8,0	8,0	79,0	41,0	36,0
8,1	10,0	89,0	47,0	40,0
8,2	10,0	89,0	47,0	40,0
8,3	10,0	89,0	47,0	40,0
8,4	10,0	89,0	47,0	40,0
8,5	10,0	89,0	47,0	40,0
8,6	10,0	89,0	47,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	89,0	47,0	40,0
8,8	10,0	89,0	47,0	40,0
8,9	10,0	89,0	47,0	40,0
9,0	10,0	89,0	47,0	40,0
9,1	10,0	89,0	47,0	40,0
9,2	10,0	89,0	47,0	40,0
9,3	10,0	89,0	47,0	40,0
9,4	10,0	89,0	47,0	40,0
9,5	10,0	89,0	47,0	40,0
9,6	10,0	89,0	47,0	40,0
9,7	10,0	89,0	47,0	40,0
9,8	10,0	89,0	47,0	40,0
9,9	10,0	89,0	47,0	40,0
10,0	10,0	89,0	47,0	40,0
10,1	12,0	102,0	55,0	45,0
10,2	12,0	102,0	55,0	45,0
10,3	12,0	102,0	55,0	45,0
10,4	12,0	102,0	55,0	45,0
10,5	12,0	102,0	55,0	45,0
10,6	12,0	102,0	55,0	45,0
10,7	12,0	102,0	55,0	45,0
10,8	12,0	102,0	55,0	45,0
10,9	12,0	102,0	55,0	45,0
11,0	12,0	102,0	55,0	45,0
11,1	12,0	102,0	55,0	45,0
11,2	12,0	102,0	55,0	45,0
11,3	12,0	102,0	55,0	45,0
11,4	12,0	102,0	55,0	45,0
11,5	12,0	102,0	55,0	45,0
11,6	12,0	102,0	55,0	45,0
11,7	12,0	102,0	55,0	45,0
11,8	12,0	102,0	55,0	45,0
11,9	12,0	102,0	55,0	45,0
12,0	12,0	102,0	55,0	45,0
12,1	14,0	107,0	60,0	45,0
12,2	14,0	107,0	60,0	45,0
12,3	14,0	107,0	60,0	45,0
12,4	14,0	107,0	60,0	45,0
12,5	14,0	107,0	60,0	45,0
12,6	14,0	107,0	60,0	45,0
12,7	14,0	107,0	60,0	45,0
12,8	14,0	107,0	60,0	45,0
12,9	14,0	107,0	60,0	45,0
13,0	14,0	107,0	60,0	45,0
13,1	14,0	107,0	60,0	45,0
13,2	14,0	107,0	60,0	45,0
13,3	14,0	107,0	60,0	45,0
13,4	14,0	107,0	60,0	45,0
13,5	14,0	107,0	60,0	45,0
13,6	14,0	107,0	60,0	45,0
13,7	14,0	107,0	60,0	45,0
13,8	14,0	107,0	60,0	45,0
13,9	14,0	107,0	60,0	45,0
14,0	14,0	107,0	60,0	45,0
14,1	16,0	115,0	65,0	48,0
14,2	16,0	115,0	65,0	48,0
14,3	16,0	115,0	65,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	115,0	65,0	48,0
14,5	16,0	115,0	65,0	48,0
14,6	16,0	115,0	65,0	48,0
14,7	16,0	115,0	65,0	48,0
14,8	16,0	115,0	65,0	48,0
14,9	16,0	115,0	65,0	48,0
15,0	16,0	115,0	65,0	48,0
15,1	16,0	115,0	65,0	48,0
15,2	16,0	115,0	65,0	48,0
15,3	16,0	115,0	65,0	48,0
15,4	16,0	115,0	65,0	48,0
15,5	16,0	115,0	65,0	48,0
15,6	16,0	115,0	65,0	48,0
15,7	16,0	115,0	65,0	48,0
15,8	16,0	115,0	65,0	48,0
15,9	16,0	115,0	65,0	48,0
16,0	16,0	115,0	65,0	48,0
16,1	18,0	123,0	73,0	48,0
16,2	18,0	123,0	73,0	48,0
16,3	18,0	123,0	73,0	48,0
16,4	18,0	123,0	73,0	48,0
16,5	18,0	123,0	73,0	48,0
16,6	18,0	123,0	73,0	48,0
16,7	18,0	123,0	73,0	48,0
16,8	18,0	123,0	73,0	48,0
16,9	18,0	123,0	73,0	48,0
17,0	18,0	123,0	73,0	48,0
17,1	18,0	123,0	73,0	48,0
17,2	18,0	123,0	73,0	48,0
17,3	18,0	123,0	73,0	48,0
17,4	18,0	123,0	73,0	48,0
17,5	18,0	123,0	73,0	48,0
17,6	18,0	123,0	73,0	48,0
17,7	18,0	123,0	73,0	48,0
17,8	18,0	123,0	73,0	48,0
17,9	18,0	123,0	73,0	48,0
18,0	18,0	123,0	73,0	48,0
18,1	20,0	131,0	79,0	50,0
18,2	20,0	131,0	79,0	50,0
18,3	20,0	131,0	79,0	50,0
18,4	20,0	131,0	79,0	50,0
18,5	20,0	131,0	79,0	50,0
18,6	20,0	131,0	79,0	50,0
18,7	20,0	131,0	79,0	50,0
18,8	20,0	131,0	79,0	50,0
18,9	20,0	131,0	79,0	50,0
19,0	20,0	131,0	79,0	50,0
19,1	20,0	131,0	79,0	50,0
19,2	20,0	131,0	79,0	50,0
19,3	20,0	131,0	79,0	50,0
19,4	20,0	131,0	79,0	50,0
19,5	20,0	131,0	79,0	50,0
19,6	20,0	131,0	79,0	50,0
19,7	20,0	131,0	79,0	50,0
19,8	20,0	131,0	79,0	50,0
19,9	20,0	131,0	79,0	50,0
20,0	20,0	131,0	79,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: 1003-10,0-НА - сверло диаметром 10,0 без внутренних каналов охлаждения, форма хвостовика НА по DIN 6536

С1003-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	Fo (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности Н/мм ²	Твёрд.	Vc м/мин		Подача (№ в табл.)		
					1003	с1003	1003	с1003	
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2) 1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		130 110	145 120	7 6	7 6	
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		145 110	170 145	8 7	8 8	
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		120 110 105	130 125 120	7 7 7	8 7 7	
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤1400		105 100	120 105	7 6	7 7	
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		130	145	8	8	
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1000 ≤1400		120 85	120 85	7 5	7 5	
	Азотированные стали	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤850 ≤1400		100 90	110 105	6 5	7 5	
	Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤1400		65 55	80 65	6 5	6 5	
	Быстрорежущие стали	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400		55	60	4	4	
	Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	45	60	3	3	
	H	Закаленные стали	–		≤48 HRC	45	55	3	3
					≤66 HRC	25	35	2	2
	S	Специальные сплавы	Нимоник, инконель, монель, хастеллой	≤2000		25	35	4	4
		Титан и титановые сплавы	3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		40	45	3	4
		3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		35	40	3	3	

Сверла

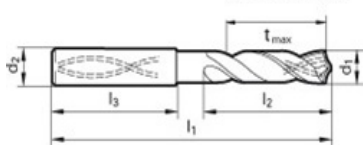
Артикул	Серия
C1004	MD800VA

d1 = 3-20



C1004

$$t_{max} = l_2 \cdot 1,5 \times d_1$$



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3
3,0	6,0	62,0	20,0	36,0	8,7	10,0	89,0	47,0	40,0	14,4	16,0	115,0	65,0	48,0
3,1	6,0	62,0	20,0	36,0	8,8	10,0	89,0	47,0	40,0	14,5	16,0	115,0	65,0	48,0
3,2	6,0	62,0	20,0	36,0	8,9	10,0	89,0	47,0	40,0	14,6	16,0	115,0	65,0	48,0
3,3	6,0	62,0	20,0	36,0	9,0	10,0	89,0	47,0	40,0	14,7	16,0	115,0	65,0	48,0
3,4	6,0	62,0	20,0	36,0	9,1	10,0	89,0	47,0	40,0	14,8	16,0	115,0	65,0	48,0
3,5	6,0	62,0	20,0	36,0	9,2	10,0	89,0	47,0	40,0	14,9	16,0	115,0	65,0	48,0
3,6	6,0	62,0	20,0	36,0	9,3	10,0	89,0	47,0	40,0	15,0	16,0	115,0	65,0	48,0
3,7	6,0	62,0	20,0	36,0	9,4	10,0	89,0	47,0	40,0	15,1	16,0	115,0	65,0	48,0
3,8	6,0	66,0	24,0	36,0	9,5	10,0	89,0	47,0	40,0	15,2	16,0	115,0	65,0	48,0
3,9	6,0	66,0	24,0	36,0	9,6	10,0	89,0	47,0	40,0	15,3	16,0	115,0	65,0	48,0
4,0	6,0	66,0	24,0	36,0	9,7	10,0	89,0	47,0	40,0	15,4	16,0	115,0	65,0	48,0
4,1	6,0	66,0	24,0	36,0	9,8	10,0	89,0	47,0	40,0	15,5	16,0	115,0	65,0	48,0
4,2	6,0	66,0	24,0	36,0	9,9	10,0	89,0	47,0	40,0	15,6	16,0	115,0	65,0	48,0
4,3	6,0	66,0	24,0	36,0	10,0	10,0	89,0	47,0	40,0	15,7	16,0	115,0	65,0	48,0
4,4	6,0	66,0	24,0	36,0	10,1	12,0	102,0	55,0	45,0	15,8	16,0	115,0	65,0	48,0
4,5	6,0	66,0	24,0	36,0	10,2	12,0	102,0	55,0	45,0	15,9	16,0	115,0	65,0	48,0
4,6	6,0	66,0	24,0	36,0	10,3	12,0	102,0	55,0	45,0	16,0	16,0	115,0	65,0	48,0
4,7	6,0	66,0	24,0	36,0	10,4	12,0	102,0	55,0	45,0	16,1	18,0	123,0	73,0	48,0
4,8	6,0	66,0	28,0	36,0	10,5	12,0	102,0	55,0	45,0	16,2	18,0	123,0	73,0	48,0
4,9	6,0	66,0	28,0	36,0	10,6	12,0	102,0	55,0	45,0	16,3	18,0	123,0	73,0	48,0
5,0	6,0	66,0	28,0	36,0	10,7	12,0	102,0	55,0	45,0	16,4	18,0	123,0	73,0	48,0
5,1	6,0	66,0	28,0	36,0	10,8	12,0	102,0	55,0	45,0	16,5	18,0	123,0	73,0	48,0
5,2	6,0	66,0	28,0	36,0	10,9	12,0	102,0	55,0	45,0	16,6	18,0	123,0	73,0	48,0
5,3	6,0	66,0	28,0	36,0	11,0	12,0	102,0	55,0	45,0	16,7	18,0	123,0	73,0	48,0
5,4	6,0	66,0	28,0	36,0	11,1	12,0	102,0	55,0	45,0	16,8	18,0	123,0	73,0	48,0
5,5	6,0	66,0	28,0	36,0	11,2	12,0	102,0	55,0	45,0	16,9	18,0	123,0	73,0	48,0
5,6	6,0	66,0	28,0	36,0	11,3	12,0	102,0	55,0	45,0	17,0	18,0	123,0	73,0	48,0
5,7	6,0	66,0	28,0	36,0	11,4	12,0	102,0	55,0	45,0	17,1	18,0	123,0	73,0	48,0
5,8	6,0	66,0	28,0	36,0	11,5	12,0	102,0	55,0	45,0	17,2	18,0	123,0	73,0	48,0
5,9	6,0	66,0	28,0	36,0	11,6	12,0	102,0	55,0	45,0	17,3	18,0	123,0	73,0	48,0
6,0	6,0	66,0	28,0	36,0	11,7	12,0	102,0	55,0	45,0	17,4	18,0	123,0	73,0	48,0
6,1	8,0	79,0	34,0	36,0	11,8	12,0	102,0	55,0	45,0	17,5	18,0	123,0	73,0	48,0
6,2	8,0	79,0	34,0	36,0	11,9	12,0	102,0	55,0	45,0	17,6	18,0	123,0	73,0	48,0
6,3	8,0	79,0	34,0	36,0	12,0	12,0	102,0	55,0	45,0	17,7	18,0	123,0	73,0	48,0
6,4	8,0	79,0	34,0	36,0	12,1	14,0	107,0	60,0	45,0	17,8	18,0	123,0	73,0	48,0
6,5	8,0	79,0	34,0	36,0	12,2	14,0	107,0	60,0	45,0	17,9	18,0	123,0	73,0	48,0
6,6	8,0	79,0	34,0	36,0	12,3	14,0	107,0	60,0	45,0	18,0	18,0	123,0	73,0	48,0
6,7	8,0	79,0	34,0	36,0	12,4	14,0	107,0	60,0	45,0	18,1	20,0	131,0	79,0	50,0
6,8	8,0	79,0	34,0	36,0	12,5	14,0	107,0	60,0	45,0	18,2	20,0	131,0	79,0	50,0
6,9	8,0	79,0	34,0	36,0	12,6	14,0	107,0	60,0	45,0	18,3	20,0	131,0	79,0	50,0
7,0	8,0	79,0	34,0	36,0	12,7	14,0	107,0	60,0	45,0	18,4	20,0	131,0	79,0	50,0
7,1	8,0	79,0	41,0	36,0	12,8	14,0	107,0	60,0	45,0	18,5	20,0	131,0	79,0	50,0
7,2	8,0	79,0	41,0	36,0	12,9	14,0	107,0	60,0	45,0	18,6	20,0	131,0	79,0	50,0
7,3	8,0	79,0	41,0	36,0	13,0	14,0	107,0	60,0	45,0	18,7	20,0	131,0	79,0	50,0
7,4	8,0	79,0	41,0	36,0	13,1	14,0	107,0	60,0	45,0	18,8	20,0	131,0	79,0	50,0
7,5	8,0	79,0	41,0	36,0	13,2	14,0	107,0	60,0	45,0	18,9	20,0	131,0	79,0	50,0
7,6	8,0	79,0	41,0	36,0	13,3	14,0	107,0	60,0	45,0	19,0	20,0	131,0	79,0	50,0
7,7	8,0	79,0	41,0	36,0	13,4	14,0	107,0	60,0	45,0	19,1	20,0	131,0	79,0	50,0
7,8	8,0	79,0	41,0	36,0	13,5	14,0	107,0	60,0	45,0	19,2	20,0	131,0	79,0	50,0
7,9	8,0	79,0	41,0	36,0	13,6	14,0	107,0	60,0	45,0	19,3	20,0	131,0	79,0	50,0
8,0	8,0	79,0	41,0	36,0	13,7	14,0	107,0	60,0	45,0	19,4	20,0	131,0	79,0	50,0
8,1	10,0	89,0	47,0	40,0	13,8	14,0	107,0	60,0	45,0	19,5	20,0	131,0	79,0	50,0
8,2	10,0	89,0	47,0	40,0	13,9	14,0	107,0	60,0	45,0	19,6	20,0	131,0	79,0	50,0
8,3	10,0	89,0	47,0	40,0	14,0	14,0	107,0	60,0	45,0	19,7	20,0	131,0	79,0	50,0
8,4	10,0	89,0	47,0	40,0	14,1	16,0	115,0	65,0	48,0	19,8	20,0	131,0	79,0	50,0
8,5	10,0	89,0	47,0	40,0	14,2	16,0	115,0	65,0	48,0	19,9	20,0	131,0	79,0	50,0
8,6	10,0	89,0	47,0	40,0	14,3	16,0	115,0	65,0	48,0	20,0	20,0	131,0	79,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1004-10,0-NA - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика NA по DIN 6535
 C1004-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Ус	Подача
			Н/мм ²		с1004	с1004
M	Нерж. стали, с сод. Серы аустенитные мартенситные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		80	5
		1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		60	2-3
		1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		80	5
S	Специальные сплавы	Нимоник, инконель, монель, хастеллой	≤2000		30	2
	Титан и титановые сплавы	3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		35	2
		3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400			

Сверла

Артикул	Серия
1005	MSN
d1 = 3-16	

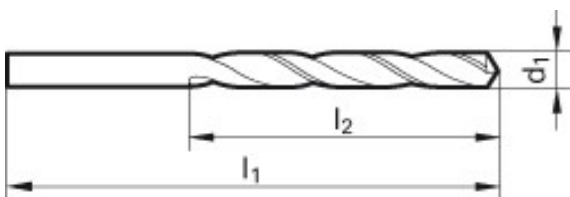
3×d₁

h7



С покрытием

M METALLEKT



P	M	K	N	S	H
•	•	•	•	•	○

Возможен заказ любых диаметров с ближайшими линейными параметрами
большого табличного значения

d1 h7	l1	l2	d1 h7	l1	l2	d1 h7	l1	l2
3,0	46,0	16,0	7,4	74,0	34,0	11,8	95,0	47,0
3,1	49,0	18,0	7,5	74,0	34,0	11,9	102,0	51,0
3,2	49,0	18,0	7,6	79,0	37,0	12,0	102,0	51,0
3,3	49,0	18,0	7,7	79,0	37,0	12,1	102,0	51,0
3,4	52,0	20,0	7,8	79,0	37,0	12,2	102,0	51,0
3,5	52,0	20,0	7,9	79,0	37,0	12,3	102,0	51,0
3,6	52,0	20,0	8,0	79,0	37,0	12,4	102,0	51,0
3,7	52,0	20,0	8,1	79,0	37,0	12,5	102,0	51,0
3,8	55,0	22,0	8,2	79,0	37,0	12,6	102,0	51,0
3,9	55,0	22,0	8,3	79,0	37,0	12,7	102,0	51,0
4,0	55,0	22,0	8,4	79,0	37,0	12,8	102,0	51,0
4,1	55,0	22,0	8,5	79,0	37,0	12,9	102,0	51,0
4,2	55,0	22,0	8,6	84,0	40,0	13,0	102,0	51,0
4,3	58,0	24,0	8,7	84,0	40,0	13,1	102,0	51,0
4,4	58,0	24,0	8,8	84,0	40,0	13,2	102,0	51,0
4,5	58,0	24,0	8,9	84,0	40,0	13,3	107,0	54,0
4,6	58,0	24,0	9,0	84,0	40,0	13,4	107,0	54,0
4,7	58,0	24,0	9,1	84,0	40,0	13,5	107,0	54,0
4,8	62,0	26,0	9,2	84,0	40,0	13,6	107,0	54,0
4,9	62,0	26,0	9,3	84,0	40,0	13,7	107,0	54,0
5,0	62,0	26,0	9,4	84,0	40,0	13,8	107,0	54,0
5,1	62,0	26,0	9,5	84,0	40,0	13,9	107,0	54,0
5,2	62,0	26,0	9,6	89,0	43,0	14,0	107,0	54,0
5,3	62,0	26,0	9,7	89,0	43,0	14,1	111,0	56,0
5,4	66,0	28,0	9,8	89,0	43,0	14,2	111,0	56,0
5,5	66,0	28,0	9,9	89,0	43,0	14,3	111,0	56,0
5,6	66,0	28,0	10,0	89,0	43,0	14,4	111,0	56,0
5,7	66,0	28,0	10,1	89,0	43,0	14,5	111,0	56,0
5,8	66,0	28,0	10,2	89,0	43,0	14,6	111,0	56,0
5,9	66,0	28,0	10,3	89,0	43,0	14,7	111,0	56,0
6,0	66,0	28,0	10,4	89,0	43,0	14,8	111,0	56,0
6,1	70,0	31,0	10,5	89,0	43,0	14,9	111,0	56,0
6,2	70,0	31,0	10,6	89,0	43,0	15,0	111,0	56,0
6,3	70,0	31,0	10,7	95,0	47,0	15,1	115,0	58,0
6,4	70,0	31,0	10,8	95,0	47,0	15,2	115,0	58,0
6,5	70,0	31,0	10,9	95,0	47,0	15,3	115,0	58,0
6,6	70,0	31,0	11,0	95,0	47,0	15,4	115,0	58,0
6,7	70,0	31,0	11,1	95,0	47,0	15,5	115,0	58,0
6,8	74,0	34,0	11,2	95,0	47,0	15,6	115,0	58,0
6,9	74,0	34,0	11,3	95,0	47,0	15,7	115,0	58,0
7,0	74,0	34,0	11,4	95,0	47,0	15,8	115,0	58,0
7,1	74,0	34,0	11,5	95,0	47,0	15,9	115,0	58,0
7,2	74,0	34,0	11,6	95,0	47,0	16,0	115,0	58,0
7,3	74,0	34,0	11,7	95,0	47,0			

При заказе указывать: артикул, диаметр d1.

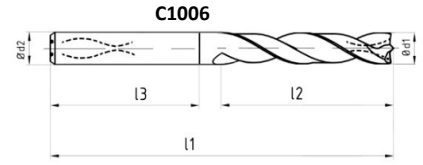
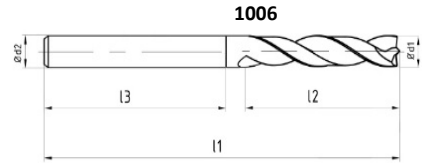
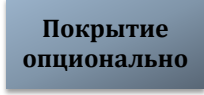
Пример: 1005-10,0 - сверло диаметром 10,0 без внутренних каналов охлаждения

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2)	≤500		104	5
		1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤1000		91	5
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36)	≤850		104	6
		1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤1000		91	5
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30)	≤700		104	5
		1.0503 C45, 1.1191 C45E (Ck45)	≤850		91	5
		1.0601 C60, 1.1221 C60E (Ck60)	≤1000		78	5
	Легируемые улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4	≤1000		78	5
		1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1400			
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		104	6
	Легируемые цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		78	5
		1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1400			
Азотируемые стали	1.8504 34CrAl6	≤850		65	5	
	1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1400				
Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9	≤850		65	4	
	1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤1400				
Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	32	3	
M	Нерж. стали, с сод. Серы аустенитные мартенситные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		32	5
		1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		32	4
		1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		32	4
H	Закаленные стали	–		≤48 HRC	26	4
				≤66 HRC		
S	Специальные сплавы	Нимоник, инконель, монель, хастеллой	≤2000		20	3
K	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20)		≤240 HB	117	5
		0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤350 HB	104	5
		0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35)		≤240 HB	91	5
S	Высокопрочный и ковкий чугун	0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤350 HB	104	5
S	Титан и титановые сплавы	3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		26	4
		3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		20	3
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		260	8
		3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		260	8
	Деформируемые сплавы	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		195	7
		3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		156	7
	Магниево-алюминиевые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		234	6
	Медь, низколегированная	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		104	6
	Латунь с короткой стружкой с длинной стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		234	6
		2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		234	6
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		156	6
		2.0790 CuNi18Zn19Pb	≤850		156	6
	Бронза, с длинной стружкой	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10	≤850		91	5
		2.0980 CuAl11Ni, 2.1247 CuBe2	≤1000		65	4
	Пласт, терморезистивные термопластичные	Бакелит, Ресопал, Пертинакс, Молтопрен	≤150		65	5
		Флексигласс, Хостален, Новодур, Макралон	≤100		52	4

Сверла

Артикул	Серия
1006/С1006	MS-KA
d1 = 3-20	



P	M	K	N	S	H
			•		

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	62,0	20,0	36,0
3,1	6,0	62,0	20,0	36,0
3,2	6,0	62,0	20,0	36,0
3,3	6,0	62,0	20,0	36,0
3,4	6,0	62,0	20,0	36,0
3,5	6,0	62,0	20,0	36,0
3,6	6,0	62,0	20,0	36,0
3,7	6,0	62,0	20,0	36,0
3,8	6,0	66,0	24,0	36,0
3,9	6,0	66,0	24,0	36,0
4,0	6,0	66,0	24,0	36,0
4,1	6,0	66,0	24,0	36,0
4,2	6,0	66,0	24,0	36,0
4,3	6,0	66,0	24,0	36,0
4,4	6,0	66,0	24,0	36,0
4,5	6,0	66,0	24,0	36,0
4,6	6,0	66,0	24,0	36,0
4,7	6,0	66,0	24,0	36,0
4,8	6,0	66,0	28,0	36,0
4,9	6,0	66,0	28,0	36,0
5,0	6,0	66,0	28,0	36,0
5,1	6,0	66,0	28,0	36,0
5,2	6,0	66,0	28,0	36,0
5,3	6,0	66,0	28,0	36,0
5,4	6,0	66,0	28,0	36,0
5,5	6,0	66,0	28,0	36,0
5,6	6,0	66,0	28,0	36,0
5,7	6,0	66,0	28,0	36,0
5,8	6,0	66,0	28,0	36,0
5,9	6,0	66,0	28,0	36,0
6,0	6,0	66,0	28,0	36,0
6,1	8,0	79,0	34,0	36,0
6,2	8,0	79,0	34,0	36,0
6,3	8,0	79,0	34,0	36,0
6,4	8,0	79,0	34,0	36,0
6,5	8,0	79,0	34,0	36,0
6,6	8,0	79,0	34,0	36,0
6,7	8,0	79,0	34,0	36,0
6,8	8,0	79,0	34,0	36,0
6,9	8,0	79,0	34,0	36,0
7,0	8,0	79,0	34,0	36,0
7,1	8,0	79,0	41,0	36,0
7,2	8,0	79,0	41,0	36,0
7,3	8,0	79,0	41,0	36,0
7,4	8,0	79,0	41,0	36,0
7,5	8,0	79,0	41,0	36,0
7,6	8,0	79,0	41,0	36,0
7,7	8,0	79,0	41,0	36,0
7,8	8,0	79,0	41,0	36,0
7,9	8,0	79,0	41,0	36,0
8,0	8,0	79,0	41,0	36,0
8,1	10,0	89,0	47,0	40,0
8,2	10,0	89,0	47,0	40,0
8,3	10,0	89,0	47,0	40,0
8,4	10,0	89,0	47,0	40,0
8,5	10,0	89,0	47,0	40,0
8,6	10,0	89,0	47,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	89,0	47,0	40,0
8,8	10,0	89,0	47,0	40,0
8,9	10,0	89,0	47,0	40,0
9,0	10,0	89,0	47,0	40,0
9,1	10,0	89,0	47,0	40,0
9,2	10,0	89,0	47,0	40,0
9,3	10,0	89,0	47,0	40,0
9,4	10,0	89,0	47,0	40,0
9,5	10,0	89,0	47,0	40,0
9,6	10,0	89,0	47,0	40,0
9,7	10,0	89,0	47,0	40,0
9,8	10,0	89,0	47,0	40,0
9,9	10,0	89,0	47,0	40,0
10,0	10,0	89,0	47,0	40,0
10,1	12,0	102,0	55,0	45,0
10,2	12,0	102,0	55,0	45,0
10,3	12,0	102,0	55,0	45,0
10,4	12,0	102,0	55,0	45,0
10,5	12,0	102,0	55,0	45,0
10,6	12,0	102,0	55,0	45,0
10,7	12,0	102,0	55,0	45,0
10,8	12,0	102,0	55,0	45,0
10,9	12,0	102,0	55,0	45,0
11,0	12,0	102,0	55,0	45,0
11,1	12,0	102,0	55,0	45,0
11,2	12,0	102,0	55,0	45,0
11,3	12,0	102,0	55,0	45,0
11,4	12,0	102,0	55,0	45,0
11,5	12,0	102,0	55,0	45,0
11,6	12,0	102,0	55,0	45,0
11,7	12,0	102,0	55,0	45,0
11,8	12,0	102,0	55,0	45,0
11,9	12,0	102,0	55,0	45,0
12,0	12,0	102,0	55,0	45,0
12,1	14,0	107,0	60,0	45,0
12,2	14,0	107,0	60,0	45,0
12,3	14,0	107,0	60,0	45,0
12,4	14,0	107,0	60,0	45,0
12,5	14,0	107,0	60,0	45,0
12,6	14,0	107,0	60,0	45,0
12,7	14,0	107,0	60,0	45,0
12,8	14,0	107,0	60,0	45,0
12,9	14,0	107,0	60,0	45,0
13,0	14,0	107,0	60,0	45,0
13,1	14,0	107,0	60,0	45,0
13,2	14,0	107,0	60,0	45,0
13,3	14,0	107,0	60,0	45,0
13,4	14,0	107,0	60,0	45,0
13,5	14,0	107,0	60,0	45,0
13,6	14,0	107,0	60,0	45,0
13,7	14,0	107,0	60,0	45,0
13,8	14,0	107,0	60,0	45,0
13,9	14,0	107,0	60,0	45,0
14,0	14,0	107,0	60,0	45,0
14,1	16,0	115,0	65,0	48,0
14,2	16,0	115,0	65,0	48,0
14,3	16,0	115,0	65,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	115,0	65,0	48,0
14,5	16,0	115,0	65,0	48,0
14,6	16,0	115,0	65,0	48,0
14,7	16,0	115,0	65,0	48,0
14,8	16,0	115,0	65,0	48,0
14,9	16,0	115,0	65,0	48,0
15,0	16,0	115,0	65,0	48,0
15,1	16,0	115,0	65,0	48,0
15,2	16,0	115,0	65,0	48,0
15,3	16,0	115,0	65,0	48,0
15,4	16,0	115,0	65,0	48,0
15,5	16,0	115,0	65,0	48,0
15,6	16,0	115,0	65,0	48,0
15,7	16,0	115,0	65,0	48,0
15,8	16,0	115,0	65,0	48,0
15,9	16,0	115,0	65,0	48,0
16,0	16,0	115,0	65,0	48,0
16,1	18,0	123,0	73,0	48,0
16,2	18,0	123,0	73,0	48,0
16,3	18,0	123,0	73,0	48,0
16,4	18,0	123,0	73,0	48,0
16,5	18,0	123,0	73,0	48,0
16,6	18,0	123,0	73,0	48,0
16,7	18,0	123,0	73,0	48,0
16,8	18,0	123,0	73,0	48,0
16,9	18,0	123,0	73,0	48,0
17,0	18,0	123,0	73,0	48,0
17,1	18,0	123,0	73,0	48,0
17,2	18,0	123,0	73,0	48,0
17,3	18,0	123,0	73,0	48,0
17,4	18,0	123,0	73,0	48,0
17,5	18,0	123,0	73,0	48,0
17,6	18,0	123,0	73,0	48,0
17,7	18,0	123,0	73,0	48,0
17,8	18,0	123,0	73,0	48,0
17,9	18,0	123,0	73,0	48,0
18,0	18,0	123,0	73,0	48,0
18,1	20,0	131,0	79,0	50,0
18,2	20,0	131,0	79,0	50,0
18,3	20,0	131,0	79,0	50,0
18,4	20,0	131,0	79,0	50,0
18,5	20,0	131,0	79,0	50,0
18,6	20,0	131,0	79,0	50,0
18,7	20,0	131,0	79,0	50,0
18,8	20,0	131,0	79,0	50,0
18,9	20,0	131,0	79,0	50,0
19,0	20,0	131,0	79,0	50,0
19,1	20,0	131,0	79,0	50,0
19,2	20,0	131,0	79,0	50,0
19,3	20,0	131,0	79,0	50,0
19,4	20,0	131,0	79,0	50,0
19,5	20,0	131,0	79,0	50,0
19,6	20,0	131,0	79,0	50,0
19,7	20,0	131,0	79,0	50,0
19,8	20,0	131,0	79,0	50,0
19,9	20,0	131,0	79,0	50,0
20,0	20,0	131,0	79,0	50,0

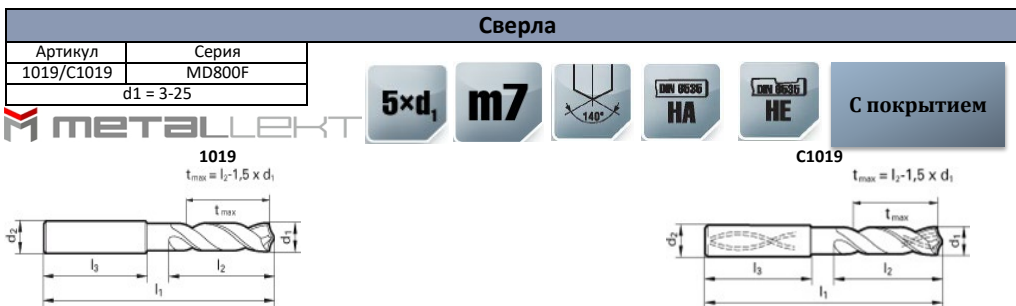
При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: 1006-10,0-НА - сверло диаметром 10,0 без внутренних каналов охлаждения, форма хвостовика НА по DIN 6535

C1006-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vс м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		180	9
	Деформируемые ал. сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		180	9
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		180	9
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		180	9
	Магниево-алюминиевые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		110	9
	Медь, низколегированная	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		110	9
	Латунь с короткой стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		110	9
с длинной стружкой	2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		120	9	



P	M	K	N	S	H
•	•	•	•	•	•

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3
3,0	6,0	66,0	28,0	36,0	10,3	12,0	118,0	71,0	45,0	17,6	18,0	143,0	93,0	48,0
3,1	6,0	66,0	28,0	36,0	10,4	12,0	118,0	71,0	45,0	17,7	18,0	143,0	93,0	48,0
3,2	6,0	66,0	28,0	36,0	10,5	12,0	118,0	71,0	45,0	17,8	18,0	143,0	93,0	48,0
3,3	6,0	66,0	28,0	36,0	10,6	12,0	118,0	71,0	45,0	17,9	18,0	143,0	93,0	48,0
3,4	6,0	66,0	28,0	36,0	10,7	12,0	118,0	71,0	45,0	18,0	18,0	143,0	93,0	48,0
3,5	6,0	66,0	28,0	36,0	10,8	12,0	118,0	71,0	45,0	18,1	20,0	153,0	101,0	50,0
3,6	6,0	66,0	28,0	36,0	10,9	12,0	118,0	71,0	45,0	18,2	20,0	153,0	101,0	50,0
3,7	6,0	66,0	28,0	36,0	11,0	12,0	118,0	71,0	45,0	18,3	20,0	153,0	101,0	50,0
3,8	6,0	74,0	36,0	36,0	11,1	12,0	118,0	71,0	45,0	18,4	20,0	153,0	101,0	50,0
3,9	6,0	74,0	36,0	36,0	11,2	12,0	118,0	71,0	45,0	18,5	20,0	153,0	101,0	50,0
4,0	6,0	74,0	36,0	36,0	11,3	12,0	118,0	71,0	45,0	18,6	20,0	153,0	101,0	50,0
4,1	6,0	74,0	36,0	36,0	11,4	12,0	118,0	71,0	45,0	18,7	20,0	153,0	101,0	50,0
4,2	6,0	74,0	36,0	36,0	11,5	12,0	118,0	71,0	45,0	18,8	20,0	153,0	101,0	50,0
4,3	6,0	74,0	36,0	36,0	11,6	12,0	118,0	71,0	45,0	18,9	20,0	153,0	101,0	50,0
4,4	6,0	74,0	36,0	36,0	11,7	12,0	118,0	71,0	45,0	19,0	20,0	153,0	101,0	50,0
4,5	6,0	74,0	36,0	36,0	11,8	12,0	118,0	71,0	45,0	19,1	20,0	153,0	101,0	50,0
4,6	6,0	74,0	36,0	36,0	11,9	12,0	118,0	71,0	45,0	19,2	20,0	153,0	101,0	50,0
4,7	6,0	74,0	36,0	36,0	12,0	12,0	118,0	71,0	45,0	19,3	20,0	153,0	101,0	50,0
4,8	6,0	82,0	44,0	36,0	12,1	14,0	124,0	77,0	45,0	19,4	20,0	153,0	101,0	50,0
4,9	6,0	82,0	44,0	36,0	12,2	14,0	124,0	77,0	45,0	19,5	20,0	153,0	101,0	50,0
5,0	6,0	82,0	44,0	36,0	12,3	14,0	124,0	77,0	45,0	19,6	20,0	153,0	101,0	50,0
5,1	6,0	82,0	44,0	36,0	12,4	14,0	124,0	77,0	45,0	19,7	20,0	153,0	101,0	50,0
5,2	6,0	82,0	44,0	36,0	12,5	14,0	124,0	77,0	45,0	19,8	20,0	153,0	101,0	50,0
5,3	6,0	82,0	44,0	36,0	12,6	14,0	124,0	77,0	45,0	19,9	20,0	153,0	101,0	50,0
5,4	6,0	82,0	44,0	36,0	12,7	14,0	124,0	77,0	45,0	20,0	20,0	153,0	101,0	50,0
5,5	6,0	82,0	44,0	36,0	12,8	14,0	124,0	77,0	45,0	20,1	25,0	165,0	105,0	56,0
5,6	6,0	82,0	44,0	36,0	12,9	14,0	124,0	77,0	45,0	20,2	25,0	165,0	105,0	56,0
5,7	6,0	82,0	44,0	36,0	13,0	14,0	124,0	77,0	45,0	20,3	25,0	165,0	105,0	56,0
5,8	6,0	82,0	44,0	36,0	13,1	14,0	124,0	77,0	45,0	20,4	25,0	165,0	105,0	56,0
5,9	6,0	82,0	44,0	36,0	13,2	14,0	124,0	77,0	45,0	20,5	25,0	165,0	105,0	56,0
6,0	6,0	82,0	44,0	36,0	13,3	14,0	124,0	77,0	45,0	20,6	25,0	165,0	105,0	56,0
6,1	8,0	91,0	53,0	36,0	13,4	14,0	124,0	77,0	45,0	20,7	25,0	165,0	105,0	56,0
6,2	8,0	91,0	53,0	36,0	13,5	14,0	124,0	77,0	45,0	20,8	25,0	165,0	105,0	56,0
6,3	8,0	91,0	53,0	36,0	13,6	14,0	124,0	77,0	45,0	20,9	25,0	165,0	105,0	56,0
6,4	8,0	91,0	53,0	36,0	13,7	14,0	124,0	77,0	45,0	21,0	25,0	165,0	105,0	56,0
6,5	8,0	91,0	53,0	36,0	13,8	14,0	124,0	77,0	45,0	21,1	25,0	165,0	105,0	56,0
6,6	8,0	91,0	53,0	36,0	13,9	14,0	124,0	77,0	45,0	21,2	25,0	165,0	105,0	56,0
6,7	8,0	91,0	53,0	36,0	14,0	14,0	124,0	77,0	45,0	21,3	25,0	165,0	105,0	56,0
6,8	8,0	91,0	53,0	36,0	14,1	16,0	133,0	83,0	48,0	21,4	25,0	165,0	105,0	56,0
6,9	8,0	91,0	53,0	36,0	14,2	16,0	133,0	83,0	48,0	21,5	25,0	165,0	105,0	56,0
7,0	8,0	91,0	53,0	36,0	14,3	16,0	133,0	83,0	48,0	21,6	25,0	165,0	105,0	56,0
7,1	8,0	91,0	53,0	36,0	14,4	16,0	133,0	83,0	48,0	21,7	25,0	165,0	105,0	56,0
7,2	8,0	91,0	53,0	36,0	14,5	16,0	133,0	83,0	48,0	21,8	25,0	165,0	105,0	56,0
7,3	8,0	91,0	53,0	36,0	14,6	16,0	133,0	83,0	48,0	21,9	25,0	165,0	105,0	56,0
7,4	8,0	91,0	53,0	36,0	14,7	16,0	133,0	83,0	48,0	22,0	25,0	165,0	105,0	56,0
7,5	8,0	91,0	53,0	36,0	14,8	16,0	133,0	83,0	48,0	22,1	25,0	180,0	117,0	56,0
7,6	8,0	91,0	53,0	36,0	14,9	16,0	133,0	83,0	48,0	22,2	25,0	180,0	117,0	56,0
7,7	8,0	91,0	53,0	36,0	15,0	16,0	133,0	83,0	48,0	22,3	25,0	180,0	117,0	56,0
7,8	8,0	91,0	53,0	36,0	15,1	16,0	133,0	83,0	48,0	22,4	25,0	180,0	117,0	56,0
7,9	8,0	91,0	53,0	36,0	15,2	16,0	133,0	83,0	48,0	22,5	25,0	180,0	117,0	56,0
8,0	8,0	91,0	53,0	36,0	15,3	16,0	133,0	83,0	48,0	22,6	25,0	180,0	117,0	56,0
8,1	10,0	103,0	61,0	40,0	15,4	16,0	133,0	83,0	48,0	22,7	25,0	180,0	117,0	56,0
8,2	10,0	103,0	61,0	40,0	15,5	16,0	133,0	83,0	48,0	22,8	25,0	180,0	117,0	56,0
8,3	10,0	103,0	61,0	40,0	15,6	16,0	133,0	83,0	48,0	22,9	25,0	180,0	117,0	56,0
8,4	10,0	103,0	61,0	40,0	15,7	16,0	133,0	83,0	48,0	23,0	25,0	180,0	117,0	56,0
8,5	10,0	103,0	61,0	40,0	15,8	16,0	133,0	83,0	48,0	23,1	25,0	180,0	117,0	56,0
8,6	10,0	103,0	61,0	40,0	15,9	16,0	133,0	83,0	48,0	23,2	25,0	180,0	117,0	56,0
8,7	10,0	103,0	61,0	40,0	16,0	16,0	133,0	83,0	48,0	23,3	25,0	180,0	117,0	56,0
8,8	10,0	103,0	61,0	40,0	16,1	18,0	143,0	93,0	48,0	23,4	25,0	180,0	117,0	56,0
8,9	10,0	103,0	61,0	40,0	16,2	18,0	143,0	93,0	48,0	23,5	25,0	180,0	117,0	56,0
9,0	10,0	103,0	61,0	40,0	16,3	18,0	143,0	93,0	48,0	23,6	25,0	180,0	117,0	56,0
9,1	10,0	103,0	61,0	40,0	16,4	18,0	143,0	93,0	48,0	23,7	25,0	180,0	117,0	56,0
9,2	10,0	103,0	61,0	40,0	16,5	18,0	143,0	93,0	48,0	23,8	25,0	180,0	117,0	56,0
9,3	10,0	103,0	61,0	40,0	16,6	18,0	143,0	93,0	48,0	23,9	25,0	180,0	117,0	56,0
9,4	10,0	103,0	61,0	40,0	16,7	18,0	143,0	93,0	48,0	24,0	25,0	180,0	117,0	56,0
9,5	10,0	103,0	61,0	40,0	16,8	18,0	143,0	93,0	48,0	24,1	25,0	180,0	117,0	56,0
9,6	10,0	103,0	61,0	40,0	16,9	18,0	143,0	93,0	48,0	24,2	25,0	180,0	117,0	56,0
9,7	10,0	103,0	61,0	40,0	17,0	18,0	143,0	93,0	48,0	24,3	25,0	180,0	117,0	56,0
9,8	10,0	103,0	61,0	40,0	17,1	18,0	143,0	93,0	48,0	24,4	25,0	180,0	117,0	56,0
9,9	10,0	103,0	61,0	40,0	17,2	18,0	143,0	93,0	48,0	24,5	25,0	180,0	117,0	56,0
10,0	10,0	103,0	61,0	40,0	17,3	18,0	143,0	93,0	48,0	24,6	25,0	180,0	117,0	56,0
10,1	12,0	118,0	71,0	45,0	17,4	18,0	143,0	93,0	48,0	24,7	25,0	180,0	117,0	56,0
10,2	12,0	118,0	71,0	45,0	17,5	18,0	143,0	93,0	48,0	24,8	25,0	180,0	117,0	56,0
										24,9	25,0	180,0	117,0	56,0
										25,0	25,0	180,0	117,0	56,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: 1019-10,0-НА - сверло диаметром 10,0 без внутренних каналов охлаждения, форма хвостовика НА по DIN 6535

C1019-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

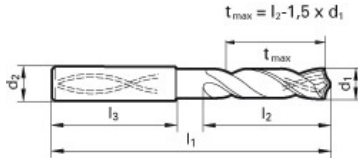
d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин		Подача (№ в табл.)	
			Н/мм ²		1019	1019	1019	1019
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2)	≤500		130	145	7	7
		1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤1000		110	120	6	6
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36)	≤850		145	170	8	8
		1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤1000		110	145	7	8
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30)	≤700		120	130	7	8
		1.0503 C45, 1.1191 C45E (Ck45)	≤850		110	125	7	7
		1.0601 C60, 1.1221 C60E (Ck60)	≤1000		105	120	7	7
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4	≤1000		105	120	7	7
		1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1400		100	105	6	7
	Углер. цементов. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		130	145	8	8
	Легированные цементованные стали	1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		120	120	7	7
		1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1400		85	85	5	5
	Азотированные стали	1.8504 34CrAl6	≤850		100	105	6	7
		1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1400		90	100	5	5
Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9	≤850		65	70	6	6	
	1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤1400		55	55	5	5	
Быстрорежущие стали	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400			60	4	5	
Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	45	60	3	3	
M	Нерж. стали, с сод. Серы аустенитные мартенситные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		55	60	4	5
		1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		45	55	4	5
		1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		45	50	3	5
S	Специальные сплавы Титан и титановые сплавы	Нимоник, инконель, монель, хастеллой	≤2000		25	35	4	4
		3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		40	45	3	4
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		260	310	9	9
		3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		260	310	9	9
	Деформир. ал. Сплавы	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		220	260	9	9
		3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		180	220	8	9
	Лит. ал. сплавы ≤ 10% Si > 10% Si	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		260	280	8	8
		Магниевые сплавы						
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		105	125	7	7
		2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		270	325	8	8
		2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		180	220	7	7
		2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		105	125	6	7
		2.0790 CuNi18Zn19Pb	≤850		85	105	6	6
		2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10	≤850		80	90	5	6
		2.0980 CuAl11Ni, 2.1247 CuBe2	≤1000		60	80	5	6
		Бронза, с длинной стружкой						

Сверла

Артикул	Серия
C1020	MD800VA

d1 = 3-25



P	M	K	N	S	H
•	•	•	•	•	•

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	66,0	28,0	36,0
3,1	6,0	66,0	28,0	36,0
3,2	6,0	66,0	28,0	36,0
3,3	6,0	66,0	28,0	36,0
3,4	6,0	66,0	28,0	36,0
3,5	6,0	66,0	28,0	36,0
3,6	6,0	66,0	28,0	36,0
3,7	6,0	66,0	28,0	36,0
3,8	6,0	74,0	36,0	36,0
3,9	6,0	74,0	36,0	36,0
4,0	6,0	74,0	36,0	36,0
4,1	6,0	74,0	36,0	36,0
4,2	6,0	74,0	36,0	36,0
4,3	6,0	74,0	36,0	36,0
4,4	6,0	74,0	36,0	36,0
4,5	6,0	74,0	36,0	36,0
4,6	6,0	74,0	36,0	36,0
4,7	6,0	74,0	36,0	36,0
4,8	6,0	82,0	44,0	36,0
4,9	6,0	82,0	44,0	36,0
5,0	6,0	82,0	44,0	36,0
5,1	6,0	82,0	44,0	36,0
5,2	6,0	82,0	44,0	36,0
5,3	6,0	82,0	44,0	36,0
5,4	6,0	82,0	44,0	36,0
5,5	6,0	82,0	44,0	36,0
5,6	6,0	82,0	44,0	36,0
5,7	6,0	82,0	44,0	36,0
5,8	6,0	82,0	44,0	36,0
5,9	6,0	82,0	44,0	36,0
6,0	6,0	82,0	44,0	36,0
6,1	8,0	91,0	53,0	36,0
6,2	8,0	91,0	53,0	36,0
6,3	8,0	91,0	53,0	36,0
6,4	8,0	91,0	53,0	36,0
6,5	8,0	91,0	53,0	36,0
6,6	8,0	91,0	53,0	36,0
6,7	8,0	91,0	53,0	36,0
6,8	8,0	91,0	53,0	36,0
6,9	8,0	91,0	53,0	36,0
7,0	8,0	91,0	53,0	36,0
7,1	8,0	91,0	53,0	36,0
7,2	8,0	91,0	53,0	36,0
7,3	8,0	91,0	53,0	36,0
7,4	8,0	91,0	53,0	36,0
7,5	8,0	91,0	53,0	36,0
7,6	8,0	91,0	53,0	36,0
7,7	8,0	91,0	53,0	36,0
7,8	8,0	91,0	53,0	36,0
7,9	8,0	91,0	53,0	36,0
8,0	8,0	91,0	53,0	36,0
8,1	10,0	103,0	61,0	40,0
8,2	10,0	103,0	61,0	40,0
8,3	10,0	103,0	61,0	40,0
8,4	10,0	103,0	61,0	40,0
8,5	10,0	103,0	61,0	40,0
8,6	10,0	103,0	61,0	40,0
8,7	10,0	103,0	61,0	40,0
8,8	10,0	103,0	61,0	40,0
8,9	10,0	103,0	61,0	40,0
9,0	10,0	103,0	61,0	40,0
9,1	10,0	103,0	61,0	40,0
9,2	10,0	103,0	61,0	40,0
9,3	10,0	103,0	61,0	40,0
9,4	10,0	103,0	61,0	40,0
9,5	10,0	103,0	61,0	40,0
9,6	10,0	103,0	61,0	40,0
9,7	10,0	103,0	61,0	40,0
9,8	10,0	103,0	61,0	40,0
9,9	10,0	103,0	61,0	40,0
10,0	10,0	103,0	61,0	40,0
10,1	12,0	118,0	71,0	45,0
10,2	12,0	118,0	71,0	45,0

d1 m7	d2 h6	l1	l2	l3
10,3	12,0	118,0	71,0	45,0
10,4	12,0	118,0	71,0	45,0
10,5	12,0	118,0	71,0	45,0
10,6	12,0	118,0	71,0	45,0
10,7	12,0	118,0	71,0	45,0
10,8	12,0	118,0	71,0	45,0
10,9	12,0	118,0	71,0	45,0
11,0	12,0	118,0	71,0	45,0
11,1	12,0	118,0	71,0	45,0
11,2	12,0	118,0	71,0	45,0
11,3	12,0	118,0	71,0	45,0
11,4	12,0	118,0	71,0	45,0
11,5	12,0	118,0	71,0	45,0
11,6	12,0	118,0	71,0	45,0
11,7	12,0	118,0	71,0	45,0
11,8	12,0	118,0	71,0	45,0
11,9	12,0	118,0	71,0	45,0
12,0	12,0	118,0	71,0	45,0
12,1	14,0	124,0	77,0	45,0
12,2	14,0	124,0	77,0	45,0
12,3	14,0	124,0	77,0	45,0
12,4	14,0	124,0	77,0	45,0
12,5	14,0	124,0	77,0	45,0
12,6	14,0	124,0	77,0	45,0
12,7	14,0	124,0	77,0	45,0
12,8	14,0	124,0	77,0	45,0
12,9	14,0	124,0	77,0	45,0
13,0	14,0	124,0	77,0	45,0
13,1	14,0	124,0	77,0	45,0
13,2	14,0	124,0	77,0	45,0
13,3	14,0	124,0	77,0	45,0
13,4	14,0	124,0	77,0	45,0
13,5	14,0	124,0	77,0	45,0
13,6	14,0	124,0	77,0	45,0
13,7	14,0	124,0	77,0	45,0
13,8	14,0	124,0	77,0	45,0
13,9	14,0	124,0	77,0	45,0
14,0	14,0	124,0	77,0	45,0
14,1	16,0	133,0	83,0	48,0
14,2	16,0	133,0	83,0	48,0
14,3	16,0	133,0	83,0	48,0
14,4	16,0	133,0	83,0	48,0
14,5	16,0	133,0	83,0	48,0
14,6	16,0	133,0	83,0	48,0
14,7	16,0	133,0	83,0	48,0
14,8	16,0	133,0	83,0	48,0
14,9	16,0	133,0	83,0	48,0
15,0	16,0	133,0	83,0	48,0
15,1	16,0	133,0	83,0	48,0
15,2	16,0	133,0	83,0	48,0
15,3	16,0	133,0	83,0	48,0
15,4	16,0	133,0	83,0	48,0
15,5	16,0	133,0	83,0	48,0
15,6	16,0	133,0	83,0	48,0
15,7	16,0	133,0	83,0	48,0
15,8	16,0	133,0	83,0	48,0
15,9	16,0	133,0	83,0	48,0
16,0	16,0	133,0	83,0	48,0
16,1	18,0	143,0	93,0	48,0
16,2	18,0	143,0	93,0	48,0
16,3	18,0	143,0	93,0	48,0
16,4	18,0	143,0	93,0	48,0
16,5	18,0	143,0	93,0	48,0
16,6	18,0	143,0	93,0	48,0
16,7	18,0	143,0	93,0	48,0
16,8	18,0	143,0	93,0	48,0
16,9	18,0	143,0	93,0	48,0
17,0	18,0	143,0	93,0	48,0
17,1	18,0	143,0	93,0	48,0
17,2	18,0	143,0	93,0	48,0
17,3	18,0	143,0	93,0	48,0
17,4	18,0	143,0	93,0	48,0
17,5	18,0	143,0	93,0	48,0

d1 m7	d2 h6	l1	l2	l3
17,6	18,0	143,0	93,0	48,0
17,7	18,0	143,0	93,0	48,0
17,8	18,0	143,0	93,0	48,0
17,9	18,0	143,0	93,0	48,0
18,0	18,0	143,0	93,0	48,0
18,1	20,0	153,0	101,0	50,0
18,2	20,0	153,0	101,0	50,0
18,3	20,0	153,0	101,0	50,0
18,4	20,0	153,0	101,0	50,0
18,5	20,0	153,0	101,0	50,0
18,6	20,0	153,0	101,0	50,0
18,7	20,0	153,0	101,0	50,0
18,8	20,0	153,0	101,0	50,0
18,9	20,0	153,0	101,0	50,0
19,0	20,0	153,0	101,0	50,0
19,1	20,0	153,0	101,0	50,0
19,2	20,0	153,0	101,0	50,0
19,3	20,0	153,0	101,0	50,0
19,4	20,0	153,0	101,0	50,0
19,5	20,0	153,0	101,0	50,0
19,6	20,0	153,0	101,0	50,0
19,7	20,0	153,0	101,0	50,0
19,8	20,0	153,0	101,0	50,0
19,9	20,0	153,0	101,0	50,0
20,0	20,0	153,0	101,0	50,0
20,1	25,0	165,0	105,0	56,0
20,2	25,0	165,0	105,0	56,0
20,3	25,0	165,0	105,0	56,0
20,4	25,0	165,0	105,0	56,0
20,5	25,0	165,0	105,0	56,0
20,6	25,0	165,0	105,0	56,0
20,7	25,0	165,0	105,0	56,0
20,8	25,0	165,0	105,0	56,0
20,9	25,0	165,0	105,0	56,0
21,0	25,0	165,0	105,0	56,0
21,1	25,0	165,0	105,0	56,0
21,2	25,0	165,0	105,0	56,0
21,3	25,0	165,0	105,0	56,0
21,4	25,0	165,0	105,0	56,0
21,5	25,0	165,0	105,0	56,0
21,6	25,0	165,0	105,0	56,0
21,7	25,0	165,0	105,0	56,0
21,8	25,0	165,0	105,0	56,0
21,9	25,0	165,0	105,0	56,0
22,0	25,0	165,0	105,0	56,0
22,1	25,0	180,0	117,0	56,0
22,2	25,0	180,0	117,0	56,0
22,3	25,0	180,0	117,0	56,0
22,4	25,0	180,0	117,0	56,0
22,5	25,0	180,0	117,0	56,0
22,6	25,0	180,0	117,0	56,0
22,7	25,0	180,0	117,0	56,0
22,8	25,0	180,0	117,0	56,0
22,9	25,0	180,0	117,0	56,0
23,0	25,0	180,0	117,0	56,0
23,1	25,0	180,0	117,0	56,0
23,2	25,0	180,0	117,0	56,0
23,3	25,0	180,0	117,0	56,0
23,4	25,0	180,0	117,0	56,0
23,5	25,0	180,0	117,0	56,0
23,6	25,0	180,0	117,0	56,0
23,7	25,0	180,0	117,0	56,0
23,8	25,0	180,0	117,0	56,0
23,9	25,0	180,0	117,0	56,0
24,0	25,0	180,0	117,0	56,0
24,1	25,0	180,0	117,0	56,0
24,2	25,0	180,0	117,0	56,0
24,3	25,0	180,0	117,0	56,0
24,4	25,0	180,0	117,0	56,0
24,5	25,0	180,0	117,0	56,0
24,6	25,0	180,0	117,0	56,0
24,7	25,0	180,0	117,0	56,0
24,8	25,0	180,0	117,0	56,0
24,9	25,0	180,0	117,0	56,0
25,0	25,0	180,0	117,0	56,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1020-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, с исполнением хвостовика НА
 C1020-10,0-HE - сверло диаметром 1

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (mm/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

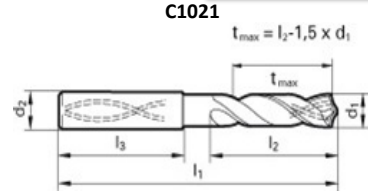
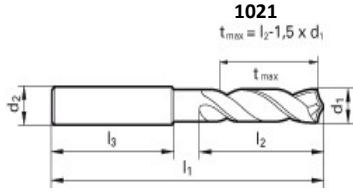
	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
M	Нерж. стали, с сод. Серы аустенитные мартенситные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		80	5
		1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		60	2-3
		1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		80	5
S	Титан и титановые сплавы	3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		35	2
		3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400			

Сверла

Артикул	Серия
1021/С1021	MD800U
d1 = 3-20	



С покрытием



P	M	K	N	S	H
●	○	●	○	○	○

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	66,0	28,0	36,0
3,1	6,0	66,0	28,0	36,0
3,2	6,0	66,0	28,0	36,0
3,3	6,0	66,0	28,0	36,0
3,4	6,0	66,0	28,0	36,0
3,5	6,0	66,0	28,0	36,0
3,6	6,0	66,0	28,0	36,0
3,7	6,0	66,0	28,0	36,0
3,8	6,0	74,0	36,0	36,0
3,9	6,0	74,0	36,0	36,0
4,0	6,0	74,0	36,0	36,0
4,1	6,0	74,0	36,0	36,0
4,2	6,0	74,0	36,0	36,0
4,3	6,0	74,0	36,0	36,0
4,4	6,0	74,0	36,0	36,0
4,5	6,0	74,0	36,0	36,0
4,6	6,0	74,0	36,0	36,0
4,7	6,0	74,0	36,0	36,0
4,8	6,0	82,0	44,0	36,0
4,9	6,0	82,0	44,0	36,0
5,0	6,0	82,0	44,0	36,0
5,1	6,0	82,0	44,0	36,0
5,2	6,0	82,0	44,0	36,0
5,3	6,0	82,0	44,0	36,0
5,4	6,0	82,0	44,0	36,0
5,5	6,0	82,0	44,0	36,0
5,6	6,0	82,0	44,0	36,0
5,7	6,0	82,0	44,0	36,0
5,8	6,0	82,0	44,0	36,0
5,9	6,0	82,0	44,0	36,0
6,0	6,0	82,0	44,0	36,0
6,1	8,0	91,0	53,0	36,0
6,2	8,0	91,0	53,0	36,0
6,3	8,0	91,0	53,0	36,0
6,4	8,0	91,0	53,0	36,0
6,5	8,0	91,0	53,0	36,0
6,6	8,0	91,0	53,0	36,0
6,7	8,0	91,0	53,0	36,0
6,8	8,0	91,0	53,0	36,0
6,9	8,0	91,0	53,0	36,0
7,0	8,0	91,0	53,0	36,0
7,1	8,0	91,0	53,0	36,0
7,2	8,0	91,0	53,0	36,0
7,3	8,0	91,0	53,0	36,0
7,4	8,0	91,0	53,0	36,0
7,5	8,0	91,0	53,0	36,0
7,6	8,0	91,0	53,0	36,0
7,7	8,0	91,0	53,0	36,0
7,8	8,0	91,0	53,0	36,0
7,9	8,0	91,0	53,0	36,0
8,0	8,0	91,0	53,0	36,0
8,1	10,0	103,0	61,0	40,0
8,2	10,0	103,0	61,0	40,0
8,3	10,0	103,0	61,0	40,0
8,4	10,0	103,0	61,0	40,0
8,5	10,0	103,0	61,0	40,0
8,6	10,0	103,0	61,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	103,0	61,0	40,0
8,8	10,0	103,0	61,0	40,0
8,9	10,0	103,0	61,0	40,0
9,0	10,0	103,0	61,0	40,0
9,1	10,0	103,0	61,0	40,0
9,2	10,0	103,0	61,0	40,0
9,3	10,0	103,0	61,0	40,0
9,4	10,0	103,0	61,0	40,0
9,5	10,0	103,0	61,0	40,0
9,6	10,0	103,0	61,0	40,0
9,7	10,0	103,0	61,0	40,0
9,8	10,0	103,0	61,0	40,0
9,9	10,0	103,0	61,0	40,0
10,0	10,0	103,0	61,0	40,0
10,1	12,0	118,0	71,0	45,0
10,2	12,0	118,0	71,0	45,0
10,3	12,0	118,0	71,0	45,0
10,4	12,0	118,0	71,0	45,0
10,5	12,0	118,0	71,0	45,0
10,6	12,0	118,0	71,0	45,0
10,7	12,0	118,0	71,0	45,0
10,8	12,0	118,0	71,0	45,0
10,9	12,0	118,0	71,0	45,0
11,0	12,0	118,0	71,0	45,0
11,1	12,0	118,0	71,0	45,0
11,2	12,0	118,0	71,0	45,0
11,3	12,0	118,0	71,0	45,0
11,4	12,0	118,0	71,0	45,0
11,5	12,0	118,0	71,0	45,0
11,6	12,0	118,0	71,0	45,0
11,7	12,0	118,0	71,0	45,0
11,8	12,0	118,0	71,0	45,0
11,9	12,0	118,0	71,0	45,0
12,0	12,0	118,0	71,0	45,0
12,1	14,0	124,0	77,0	45,0
12,2	14,0	124,0	77,0	45,0
12,3	14,0	124,0	77,0	45,0
12,4	14,0	124,0	77,0	45,0
12,5	14,0	124,0	77,0	45,0
12,6	14,0	124,0	77,0	45,0
12,7	14,0	124,0	77,0	45,0
12,8	14,0	124,0	77,0	45,0
12,9	14,0	124,0	77,0	45,0
13,0	14,0	124,0	77,0	45,0
13,1	14,0	124,0	77,0	45,0
13,2	14,0	124,0	77,0	45,0
13,3	14,0	124,0	77,0	45,0
13,4	14,0	124,0	77,0	45,0
13,5	14,0	124,0	77,0	45,0
13,6	14,0	124,0	77,0	45,0
13,7	14,0	124,0	77,0	45,0
13,8	14,0	124,0	77,0	45,0
13,9	14,0	124,0	77,0	45,0
14,0	14,0	124,0	77,0	45,0
14,1	16,0	124,0	83,0	48,0
14,2	16,0	133,0	83,0	48,0
14,3	16,0	133,0	83,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	133,0	83,0	48,0
14,5	16,0	133,0	83,0	48,0
14,6	16,0	133,0	83,0	48,0
14,7	16,0	133,0	83,0	48,0
14,8	16,0	133,0	83,0	48,0
14,9	16,0	133,0	83,0	48,0
15,0	16,0	133,0	83,0	48,0
15,1	16,0	133,0	83,0	48,0
15,2	16,0	133,0	83,0	48,0
15,3	16,0	133,0	83,0	48,0
15,4	16,0	133,0	83,0	48,0
15,5	16,0	133,0	83,0	48,0
15,6	16,0	133,0	83,0	48,0
15,7	16,0	133,0	83,0	48,0
15,8	16,0	133,0	83,0	48,0
15,9	16,0	133,0	83,0	48,0
16,0	16,0	133,0	83,0	48,0
16,1	18,0	143,0	93,0	48,0
16,2	18,0	143,0	93,0	48,0
16,3	18,0	143,0	93,0	48,0
16,4	18,0	143,0	93,0	48,0
16,5	18,0	143,0	93,0	48,0
16,6	18,0	143,0	93,0	48,0
16,7	18,0	143,0	93,0	48,0
16,8	18,0	143,0	93,0	48,0
16,9	18,0	143,0	93,0	48,0
17,0	18,0	143,0	93,0	48,0
17,1	18,0	143,0	93,0	48,0
17,2	18,0	143,0	93,0	48,0
17,3	18,0	143,0	93,0	48,0
17,4	18,0	143,0	93,0	48,0
17,5	18,0	143,0	93,0	48,0
17,6	18,0	143,0	93,0	48,0
17,7	18,0	143,0	93,0	48,0
17,8	18,0	143,0	93,0	48,0
17,9	18,0	143,0	93,0	48,0
18,0	18,0	143,0	93,0	48,0
18,1	20,0	153,0	101,0	50,0
18,2	20,0	153,0	101,0	50,0
18,3	20,0	153,0	101,0	50,0
18,4	20,0	153,0	101,0	50,0
18,5	20,0	153,0	101,0	50,0
18,6	20,0	153,0	101,0	50,0
18,7	20,0	153,0	101,0	50,0
18,8	20,0	153,0	101,0	50,0
18,9	20,0	153,0	101,0	50,0
19,0	20,0	153,0	101,0	50,0
19,1	20,0	153,0	101,0	50,0
19,2	20,0	153,0	101,0	50,0
19,3	20,0	153,0	101,0	50,0
19,4	20,0	153,0	101,0	50,0
19,5	20,0	153,0	101,0	50,0
19,6	20,0	153,0	101,0	50,0
19,7	20,0	153,0	101,0	50,0
19,8	20,0	153,0	101,0	50,0
19,9	20,0	153,0	101,0	50,0
20,0	20,0	153,0	101,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: 1021-10,0-НА - сверло диаметром 10,0 без внутренних каналов охлаждения, форма хвостовика НА по DIN 6535

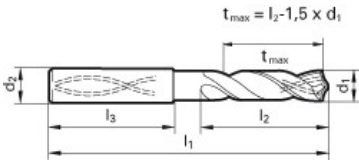
S1021-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности Н/мм ²	Твёрд.	Vc м/мин		Подача (№ в табл.)			
				1021	с1021	1021	с1021		
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2) 1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		130 110	145 120	7 6	7 6	
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		145 110	170 145	8 7	8 8	
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		120 110 105	130 125 120	7 7 7	8 7 7	
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤1400		105 100	120 105	7 6	7 7	
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		130	145	8	8	
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		120	120	7	7	
	Азотированные стали	1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5 1.8504 34CrAl6	≤1400 ≤850		85 100	85 105	5 6	5 7	
	Инструментальные стали	1.8519 31CrMoV9, 1.8550 34CrAlNi7 1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤1400		65 55	70 55	6 5	6 5	
	Быстрорежущие стали	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400			60		5	
	Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	45	60	3	3	
	M	Нерж. стали, с сод. Серы	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		55	60	4	5
		аустенитные	1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		45	55	4	5
		мартенситные	1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		45	50	3	5
	K	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤240 HB ≤350 HB	210 155	195 160	8 8	9 9
Высокопрочный и ковкий чугун		0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35) 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤240 HB ≤350 HB	145 125	140 130	7 7	9 8	
Отбеленный чугун		-		≤350 HB	35	40	3	3	
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		260	310	9	9	
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		260	310	9	9	
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		235	260	9	9	
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		170	220	8	9	
	Магниеые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		260	280	8	8	
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		105	125	7	7	
	Латунь с короткой струж с длинной стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600 ≤600		270 180	325 220	8 7	8 7	
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 ≤850		105 85	125 105	6 6	7 6	
	Бронза, с длинной стружкой	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		80 60	90 80	5 5	6 6	

Сверла

Артикул	Серия
C1022	MD800H
d1 = 3-25	



P	M	K	N	S	H
●	○	○	○	○	●

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3
3,0	6,0	66,0	28,0	36,0	10,3	12,0	118,0	71,0	45,0	17,6	18,0	143,0	93,0	48,0
3,1	6,0	66,0	28,0	36,0	10,4	12,0	118,0	71,0	45,0	17,7	18,0	143,0	93,0	48,0
3,2	6,0	66,0	28,0	36,0	10,5	12,0	118,0	71,0	45,0	17,8	18,0	143,0	93,0	48,0
3,3	6,0	66,0	28,0	36,0	10,6	12,0	118,0	71,0	45,0	17,9	18,0	143,0	93,0	48,0
3,4	6,0	66,0	28,0	36,0	10,7	12,0	118,0	71,0	45,0	18,0	18,0	143,0	93,0	48,0
3,5	6,0	66,0	28,0	36,0	10,8	12,0	118,0	71,0	45,0	18,1	20,0	153,0	101,0	50,0
3,6	6,0	66,0	28,0	36,0	10,9	12,0	118,0	71,0	45,0	18,2	20,0	153,0	101,0	50,0
3,7	6,0	66,0	28,0	36,0	11,0	12,0	118,0	71,0	45,0	18,3	20,0	153,0	101,0	50,0
3,8	6,0	74,0	36,0	36,0	11,1	12,0	118,0	71,0	45,0	18,4	20,0	153,0	101,0	50,0
3,9	6,0	74,0	36,0	36,0	11,2	12,0	118,0	71,0	45,0	18,5	20,0	153,0	101,0	50,0
4,0	6,0	74,0	36,0	36,0	11,3	12,0	118,0	71,0	45,0	18,6	20,0	153,0	101,0	50,0
4,1	6,0	74,0	36,0	36,0	11,4	12,0	118,0	71,0	45,0	18,7	20,0	153,0	101,0	50,0
4,2	6,0	74,0	36,0	36,0	11,5	12,0	118,0	71,0	45,0	18,8	20,0	153,0	101,0	50,0
4,3	6,0	74,0	36,0	36,0	11,6	12,0	118,0	71,0	45,0	18,9	20,0	153,0	101,0	50,0
4,4	6,0	74,0	36,0	36,0	11,7	12,0	118,0	71,0	45,0	19,0	20,0	153,0	101,0	50,0
4,5	6,0	74,0	36,0	36,0	11,8	12,0	118,0	71,0	45,0	19,1	20,0	153,0	101,0	50,0
4,6	6,0	74,0	36,0	36,0	11,9	12,0	118,0	71,0	45,0	19,2	20,0	153,0	101,0	50,0
4,7	6,0	74,0	36,0	36,0	12,0	12,0	118,0	71,0	45,0	19,3	20,0	153,0	101,0	50,0
4,8	6,0	82,0	44,0	36,0	12,1	14,0	124,0	77,0	45,0	19,4	20,0	153,0	101,0	50,0
4,9	6,0	82,0	44,0	36,0	12,2	14,0	124,0	77,0	45,0	19,5	20,0	153,0	101,0	50,0
5,0	6,0	82,0	44,0	36,0	12,3	14,0	124,0	77,0	45,0	19,6	20,0	153,0	101,0	50,0
5,1	6,0	82,0	44,0	36,0	12,4	14,0	124,0	77,0	45,0	19,7	20,0	153,0	101,0	50,0
5,2	6,0	82,0	44,0	36,0	12,5	14,0	124,0	77,0	45,0	19,8	20,0	153,0	101,0	50,0
5,3	6,0	82,0	44,0	36,0	12,6	14,0	124,0	77,0	45,0	19,9	20,0	153,0	101,0	50,0
5,4	6,0	82,0	44,0	36,0	12,7	14,0	124,0	77,0	45,0	20,0	20,0	153,0	101,0	50,0
5,5	6,0	82,0	44,0	36,0	12,8	14,0	124,0	77,0	45,0	20,1	25,0	165,0	105,0	56,0
5,6	6,0	82,0	44,0	36,0	12,9	14,0	124,0	77,0	45,0	20,2	25,0	165,0	105,0	56,0
5,7	6,0	82,0	44,0	36,0	13,0	14,0	124,0	77,0	45,0	20,3	25,0	165,0	105,0	56,0
5,8	6,0	82,0	44,0	36,0	13,1	14,0	124,0	77,0	45,0	20,4	25,0	165,0	105,0	56,0
5,9	6,0	82,0	44,0	36,0	13,2	14,0	124,0	77,0	45,0	20,5	25,0	165,0	105,0	56,0
6,0	6,0	82,0	44,0	36,0	13,3	14,0	124,0	77,0	45,0	20,6	25,0	165,0	105,0	56,0
6,1	8,0	91,0	53,0	36,0	13,4	14,0	124,0	77,0	45,0	20,7	25,0	165,0	105,0	56,0
6,2	8,0	91,0	53,0	36,0	13,5	14,0	124,0	77,0	45,0	20,8	25,0	165,0	105,0	56,0
6,3	8,0	91,0	53,0	36,0	13,6	14,0	124,0	77,0	45,0	20,9	25,0	165,0	105,0	56,0
6,4	8,0	91,0	53,0	36,0	13,7	14,0	124,0	77,0	45,0	21,0	25,0	165,0	105,0	56,0
6,5	8,0	91,0	53,0	36,0	13,8	14,0	124,0	77,0	45,0	21,1	25,0	165,0	105,0	56,0
6,6	8,0	91,0	53,0	36,0	13,9	14,0	124,0	77,0	45,0	21,2	25,0	165,0	105,0	56,0
6,7	8,0	91,0	53,0	36,0	14,0	14,0	124,0	77,0	45,0	21,3	25,0	165,0	105,0	56,0
6,8	8,0	91,0	53,0	36,0	14,1	16,0	133,0	83,0	48,0	21,4	25,0	165,0	105,0	56,0
6,9	8,0	91,0	53,0	36,0	14,2	16,0	133,0	83,0	48,0	21,5	25,0	165,0	105,0	56,0
7,0	8,0	91,0	53,0	36,0	14,3	16,0	133,0	83,0	48,0	21,6	25,0	165,0	105,0	56,0
7,1	8,0	91,0	53,0	36,0	14,4	16,0	133,0	83,0	48,0	21,7	25,0	165,0	105,0	56,0
7,2	8,0	91,0	53,0	36,0	14,5	16,0	133,0	83,0	48,0	21,8	25,0	165,0	105,0	56,0
7,3	8,0	91,0	53,0	36,0	14,6	16,0	133,0	83,0	48,0	21,9	25,0	165,0	105,0	56,0
7,4	8,0	91,0	53,0	36,0	14,7	16,0	133,0	83,0	48,0	22,0	25,0	165,0	105,0	56,0
7,5	8,0	91,0	53,0	36,0	14,8	16,0	133,0	83,0	48,0	22,1	25,0	180,0	117,0	56,0
7,6	8,0	91,0	53,0	36,0	14,9	16,0	133,0	83,0	48,0	22,2	25,0	180,0	117,0	56,0
7,7	8,0	91,0	53,0	36,0	15,0	16,0	133,0	83,0	48,0	22,3	25,0	180,0	117,0	56,0
7,8	8,0	91,0	53,0	36,0	15,1	16,0	133,0	83,0	48,0	22,4	25,0	180,0	117,0	56,0
7,9	8,0	91,0	53,0	36,0	15,2	16,0	133,0	83,0	48,0	22,5	25,0	180,0	117,0	56,0
8,0	8,0	91,0	53,0	36,0	15,3	16,0	133,0	83,0	48,0	22,6	25,0	180,0	117,0	56,0
8,1	10,0	103,0	61,0	40,0	15,4	16,0	133,0	83,0	48,0	22,7	25,0	180,0	117,0	56,0
8,2	10,0	103,0	61,0	40,0	15,5	16,0	133,0	83,0	48,0	22,8	25,0	180,0	117,0	56,0
8,3	10,0	103,0	61,0	40,0	15,6	16,0	133,0	83,0	48,0	22,9	25,0	180,0	117,0	56,0
8,4	10,0	103,0	61,0	40,0	15,7	16,0	133,0	83,0	48,0	23,0	25,0	180,0	117,0	56,0
8,5	10,0	103,0	61,0	40,0	15,8	16,0	133,0	83,0	48,0	23,1	25,0	180,0	117,0	56,0
8,6	10,0	103,0	61,0	40,0	15,9	16,0	133,0	83,0	48,0	23,2	25,0	180,0	117,0	56,0
8,7	10,0	103,0	61,0	40,0	16,0	16,0	133,0	83,0	48,0	23,3	25,0	180,0	117,0	56,0
8,8	10,0	103,0	61,0	40,0	16,1	18,0	143,0	93,0	48,0	23,4	25,0	180,0	117,0	56,0
8,9	10,0	103,0	61,0	40,0	16,2	18,0	143,0	93,0	48,0	23,5	25,0	180,0	117,0	56,0
9,0	10,0	103,0	61,0	40,0	16,3	18,0	143,0	93,0	48,0	23,6	25,0	180,0	117,0	56,0
9,1	10,0	103,0	61,0	40,0	16,4	18,0	143,0	93,0	48,0	23,7	25,0	180,0	117,0	56,0
9,2	10,0	103,0	61,0	40,0	16,5	18,0	143,0	93,0	48,0	23,8	25,0	180,0	117,0	56,0
9,3	10,0	103,0	61,0	40,0	16,6	18,0	143,0	93,0	48,0	23,9	25,0	180,0	117,0	56,0
9,4	10,0	103,0	61,0	40,0	16,7	18,0	143,0	93,0	48,0	24,0	25,0	180,0	117,0	56,0
9,5	10,0	103,0	61,0	40,0	16,8	18,0	143,0	93,0	48,0	24,1	25,0	180,0	117,0	56,0
9,6	10,0	103,0	61,0	40,0	16,9	18,0	143,0	93,0	48,0	24,2	25,0	180,0	117,0	56,0
9,7	10,0	103,0	61,0	40,0	17,0	18,0	143,0	93,0	48,0	24,3	25,0	180,0	117,0	56,0
9,8	10,0	103,0	61,0	40,0	17,1	18,0	143,0	93,0	48,0	24,4	25,0	180,0	117,0	56,0
9,9	10,0	103,0	61,0	40,0	17,2	18,0	143,0	93,0	48,0	24,5	25,0	180,0	117,0	56,0
10,0	10,0	103,0	61,0	40,0	17,3	18,0	143,0	93,0	48,0	24,6	25,0	180,0	117,0	56,0
10,1	12,0	118,0	71,0	45,0	17,4	18,0	143,0	93,0	48,0	24,7	25,0	180,0	117,0	56,0
10,2	12,0	118,0	71,0	45,0	17,5	18,0	143,0	93,0	48,0	24,8	25,0	180,0	117,0	56,0
										24,9	25,0	180,0	117,0	56,0
										25,0	25,0	180,0	117,0	56,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

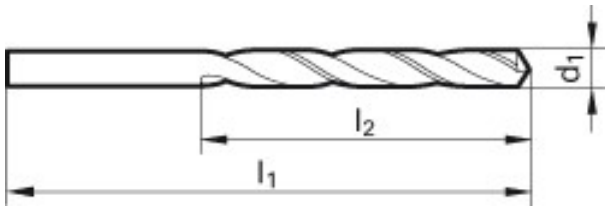
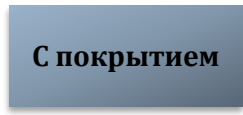
Пример: C1022-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6535
C1022-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	V _c м/мин	Подача (№ в табл.)
			Н/мм ²			
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2)	≤500		145	7
		1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤1000		120	6
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36)	≤850		170	8
		1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤1000		145	8
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30)	≤700		130	8
		1.0503 C45, 1.1191 C45E (Ck45)	≤850		125	7
		1.0601 C60, 1.1221 C60E (Ck60)	≤1000		120	7
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4	≤1000		120	7
		1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1400		105	7
	Углер. цементов. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		145	8
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		120	7
		1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1400		85	5
	Азотированные стали	1.8504 34CrAl6	≤850		110	7
		1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1400		105	5
	Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9	≤850		80	6
		1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤1400		65	5
Быстрорежущие стали	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400		60	4	
Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	60	3	
H	Закаленные стали	-		≤48 HRC	55	3
		-		≤66 HRC	35	2
S	Специальные сплавы	Нимоник, инконель, монель, хастеллой	≤2000		35	4
		3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		45	4
		3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		40	3

Сверла

Артикул	Серия
1025	MSN
d1 = 3-14	



P	M	K	N	S	H
•	•	•	•	•	○

Возможен заказ любых диаметров с ближайшими линейными параметрами
большого табличного значения

d1 h7	l1	l2	d1 h7	l1	l2	d1 h7	l1	l2
3,0	61,0	33,0	6,7	101,0	63,0	10,4	133,0	87,0
3,1	65,0	36,0	6,8	109,0	69,0	10,5	133,0	87,0
3,2	65,0	36,0	6,9	109,0	69,0	10,6	133,0	87,0
3,3	65,0	36,0	7,0	109,0	69,0	10,7	142,0	94,0
3,4	70,0	39,0	7,1	109,0	69,0	10,8	142,0	94,0
3,5	70,0	39,0	7,2	109,0	69,0	10,9	142,0	94,0
3,6	70,0	39,0	7,3	109,0	69,0	11,0	142,0	94,0
3,7	70,0	39,0	7,4	109,0	69,0	11,1	142,0	94,0
3,8	75,0	43,0	7,5	109,0	69,0	11,2	142,0	94,0
3,9	75,0	43,0	7,6	117,0	75,0	11,3	142,0	94,0
4,0	75,0	43,0	7,7	117,0	75,0	11,4	142,0	94,0
4,1	75,0	43,0	7,8	117,0	75,0	11,5	142,0	94,0
4,2	75,0	43,0	7,9	117,0	75,0	11,6	142,0	94,0
4,3	80,0	47,0	8,0	117,0	75,0	11,7	142,0	94,0
4,4	80,0	47,0	8,1	117,0	75,0	11,8	142,0	94,0
4,5	80,0	47,0	8,2	117,0	75,0	11,9	151,0	101,0
4,6	80,0	47,0	8,3	117,0	75,0	12,0	151,0	101,0
4,7	80,0	47,0	8,4	117,0	75,0	12,1	151,0	101,0
4,8	86,0	52,0	8,5	117,0	75,0	12,2	151,0	101,0
4,9	86,0	52,0	8,6	125,0	81,0	12,3	151,0	101,0
5,0	86,0	52,0	8,7	125,0	81,0	12,4	151,0	101,0
5,1	86,0	52,0	8,8	125,0	81,0	12,5	151,0	101,0
5,2	86,0	52,0	8,9	125,0	81,0	12,6	151,0	101,0
5,3	86,0	52,0	9,0	125,0	81,0	12,7	151,0	101,0
5,4	93,0	57,0	9,1	125,0	81,0	12,8	151,0	101,0
5,5	93,0	57,0	9,2	125,0	81,0	12,9	151,0	101,0
5,6	93,0	57,0	9,3	125,0	81,0	13,0	151,0	101,0
5,7	93,0	57,0	9,4	125,0	81,0	13,1	151,0	101,0
5,8	93,0	57,0	9,5	125,0	81,0	13,2	151,0	101,0
5,9	93,0	57,0	9,6	133,0	87,0	13,3	160,0	108,0
6,0	93,0	57,0	9,7	133,0	87,0	13,4	160,0	108,0
6,1	101,0	63,0	9,8	133,0	87,0	13,5	160,0	108,0
6,2	101,0	63,0	9,9	133,0	87,0	13,6	160,0	108,0
6,3	101,0	63,0	10,0	133,0	87,0	13,7	160,0	108,0
6,4	101,0	63,0	10,1	133,0	87,0	13,8	160,0	108,0
6,5	101,0	63,0	10,2	133,0	87,0	13,9	160,0	108,0
6,6	101,0	63,0	10,3	133,0	87,0	14,0	160,0	108,0

При заказе указывать: артикул, диаметр d1.

Пример: 1025-10,0 - сверло диаметром 10,0 без внутренних каналов охлаждения

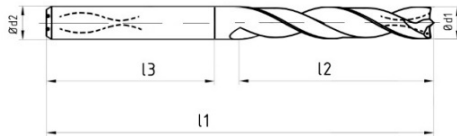
d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2)	≤500		100	5
		1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤1000		90	5
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36)	≤850		100	6
		1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤1000		90	4
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30)	≤700		100	5
		1.0503 C45, 1.1191 C45E (Ck45)	≤850		90	5
		1.0601 C60, 1.1221 C60E (Ck60)	≤1000		80	5
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4	≤1000		80	5
		1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1400			
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		100	6
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		80	5
	Азотированные стали	1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1400			
		1.8504 34CrAl6	≤850		65	5
	Инструментальные стали	1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1400			
1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9		≤850		65	3	
Быстрорежущие стали	1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤1400				
	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400				
Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	30	3	
M	Нерж. стали, с сод. Серы аустенитные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		30	5
		1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		30	4
	мартенситные	1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		30	4
H	Закаленные стали	-		≤48 HRC	25	3
S	Специальные сплавы	Нимоник, инконель, монель, хастеллой	≤2000		20	3
				≤66 HRC		
K	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20)		≤240 HB	115	5
		0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤350 HB	100	5
	Высокопрочный и ковкий чугун	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35)		≤240 HB	90	5
0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)			≤350 HB	80	5	
S	Титан и титановые сплавы	3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		25	4
		3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		20	3
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		260	8
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		260	8
	Лит. ал. сплавы ≤ 10% Si > 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		195	7
		3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		155	7
	Магниеые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		235	6
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		100	6
	Латунь с короткой струж с длинной стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		235	6
		2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		235	6
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		155	6
		2.0790 CuNi18Zn19Pb	≤850		155	6
	Бронза, с длинной стружкой	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10	≤850		90	5
		2.0980 CuAl11Ni, 2.1247 CuBe2	≤1000		65	4
	Пласт, терморезистивные термопластичные	Бакелит, Ресопал, Пертинакс, Молтопрен	≤150		50	5
		Флексигласс, Хостален, Новодур, Макралон	≤100		65	4

Сверла

Артикул С1026	Серия MS-КА
d1 = 3-25	

**Покрытие
опционально**



P	M	K	N	S	H															
						Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения														
d1 m7	d2 h6	l1	l2	l3		d1 m7	d2 h6	l1	l2	l3		d1 m7	d2 h6	l1	l2	l3				
3,0	6,0	66,0	28,0	36,0		10,3	12,0	118,0	71,0	45,0		17,6	18,0	143,0	93,0	48,0				
3,1	6,0	66,0	28,0	36,0		10,4	12,0	118,0	71,0	45,0		17,7	18,0	143,0	93,0	48,0				
3,2	6,0	66,0	28,0	36,0		10,5	12,0	118,0	71,0	45,0		17,8	18,0	143,0	93,0	48,0				
3,3	6,0	66,0	28,0	36,0		10,6	12,0	118,0	71,0	45,0		17,9	18,0	143,0	93,0	48,0				
3,4	6,0	66,0	28,0	36,0		10,7	12,0	118,0	71,0	45,0		18,0	18,0	143,0	93,0	48,0				
3,5	6,0	66,0	28,0	36,0		10,8	12,0	118,0	71,0	45,0		18,1	20,0	153,0	101,0	50,0				
3,6	6,0	66,0	28,0	36,0		10,9	12,0	118,0	71,0	45,0		18,2	20,0	153,0	101,0	50,0				
3,7	6,0	66,0	28,0	36,0		11,0	12,0	118,0	71,0	45,0		18,3	20,0	153,0	101,0	50,0				
3,8	6,0	74,0	36,0	36,0		11,1	12,0	118,0	71,0	45,0		18,4	20,0	153,0	101,0	50,0				
3,9	6,0	74,0	36,0	36,0		11,2	12,0	118,0	71,0	45,0		18,5	20,0	153,0	101,0	50,0				
4,0	6,0	74,0	36,0	36,0		11,3	12,0	118,0	71,0	45,0		18,6	20,0	153,0	101,0	50,0				
4,1	6,0	74,0	36,0	36,0		11,4	12,0	118,0	71,0	45,0		18,7	20,0	153,0	101,0	50,0				
4,2	6,0	74,0	36,0	36,0		11,5	12,0	118,0	71,0	45,0		18,8	20,0	153,0	101,0	50,0				
4,3	6,0	74,0	36,0	36,0		11,6	12,0	118,0	71,0	45,0		18,9	20,0	153,0	101,0	50,0				
4,4	6,0	74,0	36,0	36,0		11,7	12,0	118,0	71,0	45,0		19,0	20,0	153,0	101,0	50,0				
4,5	6,0	74,0	36,0	36,0		11,8	12,0	118,0	71,0	45,0		19,1	20,0	153,0	101,0	50,0				
4,6	6,0	74,0	36,0	36,0		11,9	12,0	118,0	71,0	45,0		19,2	20,0	153,0	101,0	50,0				
4,7	6,0	74,0	36,0	36,0		12,0	12,0	118,0	71,0	45,0		19,3	20,0	153,0	101,0	50,0				
4,8	6,0	82,0	44,0	36,0		12,1	14,0	124,0	77,0	45,0		19,4	20,0	153,0	101,0	50,0				
4,9	6,0	82,0	44,0	36,0		12,2	14,0	124,0	77,0	45,0		19,5	20,0	153,0	101,0	50,0				
5,0	6,0	82,0	44,0	36,0		12,3	14,0	124,0	77,0	45,0		19,6	20,0	153,0	101,0	50,0				
5,1	6,0	82,0	44,0	36,0		12,4	14,0	124,0	77,0	45,0		19,7	20,0	153,0	101,0	50,0				
5,2	6,0	82,0	44,0	36,0		12,5	14,0	124,0	77,0	45,0		19,8	20,0	153,0	101,0	50,0				
5,3	6,0	82,0	44,0	36,0		12,6	14,0	124,0	77,0	45,0		19,9	20,0	153,0	101,0	50,0				
5,4	6,0	82,0	44,0	36,0		12,7	14,0	124,0	77,0	45,0		20,0	20,0	153,0	101,0	50,0				
5,5	6,0	82,0	44,0	36,0		12,8	14,0	124,0	77,0	45,0		20,1	25,0	165,0	105,0	56,0				
5,6	6,0	82,0	44,0	36,0		12,9	14,0	124,0	77,0	45,0		20,2	25,0	165,0	105,0	56,0				
5,7	6,0	82,0	44,0	36,0		13,0	14,0	124,0	77,0	45,0		20,3	25,0	165,0	105,0	56,0				
5,8	6,0	82,0	44,0	36,0		13,1	14,0	124,0	77,0	45,0		20,4	25,0	165,0	105,0	56,0				
5,9	6,0	82,0	44,0	36,0		13,2	14,0	124,0	77,0	45,0		20,5	25,0	165,0	105,0	56,0				
6,0	6,0	82,0	44,0	36,0		13,3	14,0	124,0	77,0	45,0		20,6	25,0	165,0	105,0	56,0				
6,1	8,0	91,0	53,0	36,0		13,4	14,0	124,0	77,0	45,0		20,7	25,0	165,0	105,0	56,0				
6,2	8,0	91,0	53,0	36,0		13,5	14,0	124,0	77,0	45,0		20,8	25,0	165,0	105,0	56,0				
6,3	8,0	91,0	53,0	36,0		13,6	14,0	124,0	77,0	45,0		20,9	25,0	165,0	105,0	56,0				
6,4	8,0	91,0	53,0	36,0		13,7	14,0	124,0	77,0	45,0		21,0	25,0	165,0	105,0	56,0				
6,5	8,0	91,0	53,0	36,0		13,8	14,0	124,0	77,0	45,0		21,1	25,0	165,0	105,0	56,0				
6,6	8,0	91,0	53,0	36,0		13,9	14,0	124,0	77,0	45,0		21,2	25,0	165,0	105,0	56,0				
6,7	8,0	91,0	53,0	36,0		14,0	14,0	124,0	77,0	45,0		21,3	25,0	165,0	105,0	56,0				
6,8	8,0	91,0	53,0	36,0		14,1	16,0	133,0	83,0	48,0		21,4	25,0	165,0	105,0	56,0				
6,9	8,0	91,0	53,0	36,0		14,2	16,0	133,0	83,0	48,0		21,5	25,0	165,0	105,0	56,0				
7,0	8,0	91,0	53,0	36,0		14,3	16,0	133,0	83,0	48,0		21,6	25,0	165,0	105,0	56,0				
7,1	8,0	91,0	53,0	36,0		14,4	16,0	133,0	83,0	48,0		21,7	25,0	165,0	105,0	56,0				
7,2	8,0	91,0	53,0	36,0		14,5	16,0	133,0	83,0	48,0		21,8	25,0	165,0	105,0	56,0				
7,3	8,0	91,0	53,0	36,0		14,6	16,0	133,0	83,0	48,0		21,9	25,0	165,0	105,0	56,0				
7,4	8,0	91,0	53,0	36,0		14,7	16,0	133,0	83,0	48,0		22,0	25,0	165,0	105,0	56,0				
7,5	8,0	91,0	53,0	36,0		14,8	16,0	133,0	83,0	48,0		22,1	25,0	180,0	117,0	56,0				
7,6	8,0	91,0	53,0	36,0		14,9	16,0	133,0	83,0	48,0		22,2	25,0	180,0	117,0	56,0				
7,7	8,0	91,0	53,0	36,0		15,0	16,0	133,0	83,0	48,0		22,3	25,0	180,0	117,0	56,0				
7,8	8,0	91,0	53,0	36,0		15,1	16,0	133,0	83,0	48,0		22,4	25,0	180,0	117,0	56,0				
7,9	8,0	91,0	53,0	36,0		15,2	16,0	133,0	83,0	48,0		22,5	25,0	180,0	117,0	56,0				
8,0	8,0	91,0	53,0	36,0		15,3	16,0	133,0	83,0	48,0		22,6	25,0	180,0	117,0	56,0				
8,1	10,0	103,0	61,0	40,0		15,4	16,0	133,0	83,0	48,0		22,7	25,0	180,0	117,0	56,0				
8,2	10,0	103,0	61,0	40,0		15,5	16,0	133,0	83,0	48,0		22,8	25,0	180,0	117,0	56,0				
8,3	10,0	103,0	61,0	40,0		15,6	16,0	133,0	83,0	48,0		22,9	25,0	180,0	117,0	56,0				
8,4	10,0	103,0	61,0	40,0		15,7	16,0	133,0	83,0	48,0		23,0	25,0	180,0	117,0	56,0				
8,5	10,0	103,0	61,0	40,0		15,8	16,0	133,0	83,0	48,0		23,1	25,0	180,0	117,0	56,0				
8,6	10,0	103,0	61,0	40,0		15,9	16,0	133,0	83,0	48,0		23,2	25,0	180,0	117,0	56,0				
8,7	10,0	103,0	61,0	40,0		16,0	16,0	133,0	83,0	48,0		23,3	25,0	180,0	117,0	56,0				
8,8	10,0	103,0	61,0	40,0		16,1	18,0	143,0	93,0	48,0		23,4	25,0	180,0	117,0	56,0				
8,9	10,0	103,0	61,0	40,0		16,2	18,0	143,0	93,0	48,0		23,5	25,0	180,0	117,0	56,0				
9,0	10,0	103,0	61,0	40,0		16,3	18,0	143,0	93,0	48,0		23,6	25,0	180,0	117,0	56,0				
9,1	10,0	103,0	61,0	40,0		16,4	18,0	143,0	93,0	48,0		23,7	25,0	180,0	117,0	56,0				
9,2	10,0	103,0	61,0	40,0		16,5	18,0	143,0	93,0	48,0		23,8	25,0	180,0	117,0	56,0				
9,3	10,0	103,0	61,0	40,0		16,6	18,0	143,0	93,0	48,0		23,9	25,0	180,0	117,0	56,0				
9,4	10,0	103,0	61,0	40,0		16,7	18,0	143,0	93,0	48,0		24,0	25,0	180,0	117,0	56,0				
9,5	10,0	103,0	61,0	40,0		16,8	18,0	143,0	93,0	48,0		24,1	25,0	180,0	117,0	56,0				
9,6	10,0	103,0	61,0	40,0		16,9	18,0	143,0	93,0	48,0		24,2	25,0	180,0	117,0	56,0				
9,7	10,0	103,0	61,0	40,0		17,0	18,0	143,0	93,0	48,0		24,3	25,0	180,0	117,0	56,0				
9,8	10,0	103,0	61,0	40,0		17,1	18,0	143,0	93,0	48,0		24,4	25,0	180,0	117,0	56,0				
9,9	10,0	103,0	61,0	40,0		17,2	18,0	143,0	93,0	48,0		24,5	25,0	180,0	117,0	56,0				
10,0	10,0	103,0	61,0	40,0		17,3	18,0	143,0	93,0	48,0		24,6	25,0	180,0	117,0	56,0				
10,1	12,0	118,0	71,0	45,0		17,4	18,0	143,0	93,0	48,0		24,7	25,0	180,0	117,0	56,0				
10,2	12,0	118,0	71,0	45,0		17,5	18,0	143,0	93,0	48,0		24,8	25,0	180,0	117,0	56,0				
												24,9	25,0	180,0	117,0	56,0				
												25,0	25,0	180,0	117,0	56,0				

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1026-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6535

C1026-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (мм/об.)								
3	0,08	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,1	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,1	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,125	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,16	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,2	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,2	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,25	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,315	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,4	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

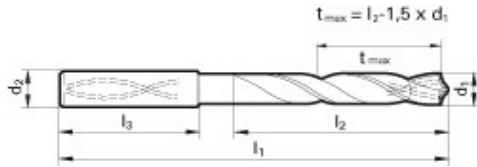
	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	V _c м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		180	9
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		180	9
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		180	9
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		180	9
	Магниеые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		110	9
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		110	9
	Латунь с короткой стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		110	9
	с длинной стружкой	2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		120	9

Сверла

Артикул	Серия
C1045	MD800U

d1 = 3-20

М **МЕТАЛЛЕКТ**



P	M	K	N	S	H
●	○	●	○	○	○

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3
3,0	6,0	70,0	30,0	36,0	8,7	10,0	131,0	87,0	40,0	14,4	16,0	204,0	152,0	48,0
3,1	6,0	70,0	30,0	36,0	8,8	10,0	131,0	87,0	40,0	14,5	16,0	204,0	152,0	48,0
3,2	6,0	70,0	30,0	36,0	8,9	10,0	131,0	87,0	40,0	14,6	16,0	204,0	152,0	48,0
3,3	6,0	70,0	30,0	36,0	9,0	10,0	131,0	87,0	40,0	14,7	16,0	204,0	152,0	48,0
3,4	6,0	75,0	35,5	36,0	9,1	10,0	139,0	95,0	40,0	14,8	16,0	204,0	152,0	48,0
3,5	6,0	75,0	35,5	36,0	9,2	10,0	139,0	95,0	40,0	14,9	16,0	204,0	152,0	48,0
3,6	6,0	75,0	35,5	36,0	9,3	10,0	139,0	95,0	40,0	15,0	16,0	204,0	152,0	48,0
3,7	6,0	75,0	35,5	36,0	9,4	10,0	139,0	95,0	40,0	15,1	16,0	204,0	152,0	48,0
3,8	6,0	75,0	37,5	36,0	9,5	10,0	139,0	95,0	40,0	15,2	16,0	204,0	152,0	48,0
3,9	6,0	75,0	37,5	36,0	9,6	10,0	139,0	95,0	40,0	15,3	16,0	204,0	152,0	48,0
4,0	6,0	75,0	37,5	36,0	9,7	10,0	139,0	95,0	40,0	15,4	16,0	204,0	152,0	48,0
4,1	6,0	75,0	37,5	36,0	9,8	10,0	139,0	95,0	40,0	15,5	16,0	204,0	152,0	48,0
4,2	6,0	75,0	37,5	36,0	9,9	10,0	139,0	95,0	40,0	15,6	16,0	204,0	152,0	48,0
4,3	6,0	85,0	45,0	36,0	10,0	10,0	139,0	95,0	40,0	15,7	16,0	204,0	152,0	48,0
4,4	6,0	85,0	45,0	36,0	10,1	12,0	155,0	106,0	45,0	15,8	16,0	204,0	152,0	48,0
4,5	6,0	85,0	45,0	36,0	10,2	12,0	155,0	106,0	45,0	15,9	16,0	204,0	152,0	48,0
4,6	6,0	85,0	45,0	36,0	10,3	12,0	155,0	106,0	45,0	16,0	16,0	204,0	152,0	48,0
4,7	6,0	85,0	45,0	36,0	10,4	12,0	155,0	106,0	45,0	16,1	18,0	223,0	171,0	48,0
4,8	6,0	90,0	50,0	36,0	10,5	12,0	155,0	106,0	45,0	16,2	18,0	223,0	171,0	48,0
4,9	6,0	90,0	50,0	36,0	10,6	12,0	155,0	106,0	45,0	16,3	18,0	223,0	171,0	48,0
5,0	6,0	90,0	50,0	36,0	10,7	12,0	155,0	106,0	45,0	16,4	18,0	223,0	171,0	48,0
5,1	6,0	90,0	50,0	36,0	10,8	12,0	155,0	106,0	45,0	16,5	18,0	223,0	171,0	48,0
5,2	6,0	90,0	50,0	36,0	10,9	12,0	155,0	106,0	45,0	16,6	18,0	223,0	171,0	48,0
5,3	6,0	90,0	50,0	36,0	11,0	12,0	155,0	106,0	45,0	16,7	18,0	223,0	171,0	48,0
5,4	6,0	97,0	57,0	36,0	11,1	12,0	163,0	114,0	45,0	16,8	18,0	223,0	171,0	48,0
5,5	6,0	97,0	57,0	36,0	11,2	12,0	163,0	114,0	45,0	16,9	18,0	223,0	171,0	48,0
5,6	6,0	97,0	57,0	36,0	11,3	12,0	163,0	114,0	45,0	17,0	18,0	223,0	171,0	48,0
5,7	6,0	97,0	57,0	36,0	11,4	12,0	163,0	114,0	45,0	17,1	18,0	223,0	171,0	48,0
5,8	6,0	97,0	57,0	36,0	11,5	12,0	163,0	114,0	45,0	17,2	18,0	223,0	171,0	48,0
5,9	6,0	97,0	57,0	36,0	11,6	12,0	163,0	114,0	45,0	17,3	18,0	223,0	171,0	48,0
6,0	6,0	97,0	57,0	36,0	11,7	12,0	163,0	114,0	45,0	17,4	18,0	223,0	171,0	48,0
6,1	8,0	106,0	66,0	36,0	11,8	12,0	163,0	114,0	45,0	17,5	18,0	223,0	171,0	48,0
6,2	8,0	106,0	66,0	36,0	11,9	12,0	163,0	114,0	45,0	17,6	18,0	223,0	171,0	48,0
6,3	8,0	106,0	66,0	36,0	12,0	12,0	163,0	114,0	45,0	17,7	18,0	223,0	171,0	48,0
6,4	8,0	106,0	66,0	36,0	12,1	14,0	182,0	133,0	45,0	17,8	18,0	223,0	171,0	48,0
6,5	8,0	106,0	66,0	36,0	12,2	14,0	182,0	133,0	45,0	17,9	18,0	223,0	171,0	48,0
6,6	8,0	106,0	66,0	36,0	12,3	14,0	182,0	133,0	45,0	18,0	18,0	223,0	171,0	48,0
6,7	8,0	106,0	66,0	36,0	12,4	14,0	182,0	133,0	45,0	18,1	20,0	244,0	190,0	50,0
6,8	8,0	106,0	66,0	36,0	12,5	14,0	182,0	133,0	45,0	18,2	20,0	244,0	190,0	50,0
6,9	8,0	116,0	76,0	36,0	12,6	14,0	182,0	133,0	45,0	18,3	20,0	244,0	190,0	50,0
7,0	8,0	116,0	76,0	36,0	12,7	14,0	182,0	133,0	45,0	18,4	20,0	244,0	190,0	50,0
7,1	8,0	116,0	76,0	36,0	12,8	14,0	182,0	133,0	45,0	18,5	20,0	244,0	190,0	50,0
7,2	8,0	116,0	76,0	36,0	12,9	14,0	182,0	133,0	45,0	18,6	20,0	244,0	190,0	50,0
7,3	8,0	116,0	76,0	36,0	13,0	14,0	182,0	133,0	45,0	18,7	20,0	244,0	190,0	50,0
7,4	8,0	116,0	76,0	36,0	13,1	14,0	182,0	133,0	45,0	18,8	20,0	244,0	190,0	50,0
7,5	8,0	116,0	76,0	36,0	13,2	14,0	182,0	133,0	45,0	18,9	20,0	244,0	190,0	50,0
7,6	8,0	116,0	76,0	36,0	13,3	14,0	182,0	133,0	45,0	19,0	20,0	244,0	190,0	50,0
7,7	8,0	116,0	76,0	36,0	13,4	14,0	182,0	133,0	45,0	19,1	20,0	244,0	190,0	50,0
7,8	8,0	116,0	76,0	36,0	13,5	14,0	182,0	133,0	45,0	19,2	20,0	244,0	190,0	50,0
7,9	8,0	116,0	76,0	36,0	13,6	14,0	182,0	133,0	45,0	19,3	20,0	244,0	190,0	50,0
8,0	8,0	116,0	76,0	36,0	13,7	14,0	182,0	133,0	45,0	19,4	20,0	244,0	190,0	50,0
8,1	10,0	131,0	87,0	40,0	13,8	14,0	182,0	133,0	45,0	19,5	20,0	244,0	190,0	50,0
8,2	10,0	131,0	87,0	40,0	13,9	14,0	182,0	133,0	45,0	19,6	20,0	244,0	190,0	50,0
8,3	10,0	131,0	87,0	40,0	14,0	14,0	182,0	133,0	45,0	19,7	20,0	244,0	190,0	50,0
8,4	10,0	131,0	87,0	40,0	14,1	16,0	204,0	152,0	48,0	19,8	20,0	244,0	190,0	50,0
8,5	10,0	131,0	87,0	40,0	14,2	16,0	204,0	152,0	48,0	19,9	20,0	244,0	190,0	50,0
8,6	10,0	131,0	87,0	40,0	14,3	16,0	204,0	152,0	48,0	20,0	20,0	244,0	190,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1045-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6535
 C1045-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	V _c м/мин	Подача (№ в табл.)	
			Н/мм ²				
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2)	≤500		145	6	
		1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤1000		120	5	
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36)	≤850		170	7	
		1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤1000		145	7	
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30)	≤700		130	7	
		1.0503 C45, 1.1191 C45E (Ck45)	≤850		125	6	
		1.0601 C60, 1.1221 C60E (Ck60)	≤1000		120	6	
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4	≤1000		120	6	
		1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1400		105	6	
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		145	7	
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		120	6	
		1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1400		85	4	
	Азотированные стали	1.8504 34CrAl6	≤850		110	6	
		1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1400		105	4	
	Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9	≤850		80	5	
1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4		≤1400		65	4		
Быстрорежущие стали	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400		60	4		
Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)			≤350 HB	60	2	
M	Нерж. стали, с сод. Серы аустенитные мартенситные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		60	4	
		1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		55	4	
		1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		45	4	
K	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20)			≤240 HB	195	8
		0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)			≤350 HB	160	8
	Высокопрочный и ковкий чугун	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35)			≤240 HB	140	8
		0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)			≤350 HB	130	7
	Отбеленный чугун	-			≤350 HB	40	2
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		310	8	
	Деформируе. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		310	8	
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		260	8	
		3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		220	8	
	Магниеые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		280	7	
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		125	6	
	Латунь с короткой струж с длинной стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		325	7	
		2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		220	6	
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		125	6	
		2.0790 CuNi18Zn19Pb	≤850		105	5	
Бронза, с длинной стружкой	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10	≤850		90	5		
	2.0980 CuAl11Ni, 2.1247 CuBe2	≤1000		80	5		

Сверла

Артикул	Серия
C1046	MD800H

d1 = 3-20

M METALLEKT

7x d₁

m7

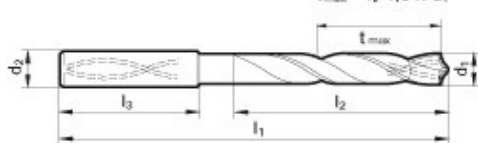


DIN 6536
HA

DIN 6536
HE

С покрытием

$$t_{\max} = l_2 - 1,5 \times d_1$$



P	M	K	N	S	H
●	○	○	○	○	●

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3
3,0	6,0	70,0	30,0	36,0	8,7	10,0	131,0	87,0	40,0	14,4	16,0	204,0	152,0	48,0
3,1	6,0	70,0	30,0	36,0	8,8	10,0	131,0	87,0	40,0	14,5	16,0	204,0	152,0	48,0
3,2	6,0	70,0	30,0	36,0	8,9	10,0	131,0	87,0	40,0	14,6	16,0	204,0	152,0	48,0
3,3	6,0	70,0	30,0	36,0	9,0	10,0	131,0	87,0	40,0	14,7	16,0	204,0	152,0	48,0
3,4	6,0	75,0	35,5	36,0	9,1	10,0	139,0	95,0	40,0	14,8	16,0	204,0	152,0	48,0
3,5	6,0	75,0	35,5	36,0	9,2	10,0	139,0	95,0	40,0	14,9	16,0	204,0	152,0	48,0
3,6	6,0	75,0	35,5	36,0	9,3	10,0	139,0	95,0	40,0	15,0	16,0	204,0	152,0	48,0
3,7	6,0	75,0	35,5	36,0	9,4	10,0	139,0	95,0	40,0	15,1	16,0	204,0	152,0	48,0
3,8	6,0	75,0	37,5	36,0	9,5	10,0	139,0	95,0	40,0	15,2	16,0	204,0	152,0	48,0
3,9	6,0	75,0	37,5	36,0	9,6	10,0	139,0	95,0	40,0	15,3	16,0	204,0	152,0	48,0
4,0	6,0	75,0	37,5	36,0	9,7	10,0	139,0	95,0	40,0	15,4	16,0	204,0	152,0	48,0
4,1	6,0	75,0	37,5	36,0	9,8	10,0	139,0	95,0	40,0	15,5	16,0	204,0	152,0	48,0
4,2	6,0	75,0	37,5	36,0	9,9	10,0	139,0	95,0	40,0	15,6	16,0	204,0	152,0	48,0
4,3	6,0	85,0	45,0	36,0	10,0	10,0	139,0	95,0	40,0	15,7	16,0	204,0	152,0	48,0
4,4	6,0	85,0	45,0	36,0	10,1	12,0	155,0	106,0	45,0	15,8	16,0	204,0	152,0	48,0
4,5	6,0	85,0	45,0	36,0	10,2	12,0	155,0	106,0	45,0	15,9	16,0	204,0	152,0	48,0
4,6	6,0	85,0	45,0	36,0	10,3	12,0	155,0	106,0	45,0	16,0	16,0	204,0	152,0	48,0
4,7	6,0	85,0	45,0	36,0	10,4	12,0	155,0	106,0	45,0	16,1	18,0	223,0	171,0	48,0
4,8	6,0	90,0	50,0	36,0	10,5	12,0	155,0	106,0	45,0	16,2	18,0	223,0	171,0	48,0
4,9	6,0	90,0	50,0	36,0	10,6	12,0	155,0	106,0	45,0	16,3	18,0	223,0	171,0	48,0
5,0	6,0	90,0	50,0	36,0	10,7	12,0	155,0	106,0	45,0	16,4	18,0	223,0	171,0	48,0
5,1	6,0	90,0	50,0	36,0	10,8	12,0	155,0	106,0	45,0	16,5	18,0	223,0	171,0	48,0
5,2	6,0	90,0	50,0	36,0	10,9	12,0	155,0	106,0	45,0	16,6	18,0	223,0	171,0	48,0
5,3	6,0	90,0	50,0	36,0	11,0	12,0	155,0	106,0	45,0	16,7	18,0	223,0	171,0	48,0
5,4	6,0	97,0	57,0	36,0	11,1	12,0	163,0	114,0	45,0	16,8	18,0	223,0	171,0	48,0
5,5	6,0	97,0	57,0	36,0	11,2	12,0	163,0	114,0	45,0	16,9	18,0	223,0	171,0	48,0
5,6	6,0	97,0	57,0	36,0	11,3	12,0	163,0	114,0	45,0	17,0	18,0	223,0	171,0	48,0
5,7	6,0	97,0	57,0	36,0	11,4	12,0	163,0	114,0	45,0	17,1	18,0	223,0	171,0	48,0
5,8	6,0	97,0	57,0	36,0	11,5	12,0	163,0	114,0	45,0	17,2	18,0	223,0	171,0	48,0
5,9	6,0	97,0	57,0	36,0	11,6	12,0	163,0	114,0	45,0	17,3	18,0	223,0	171,0	48,0
6,0	6,0	97,0	57,0	36,0	11,7	12,0	163,0	114,0	45,0	17,4	18,0	223,0	171,0	48,0
6,1	8,0	106,0	66,0	36,0	11,8	12,0	163,0	114,0	45,0	17,5	18,0	223,0	171,0	48,0
6,2	8,0	106,0	66,0	36,0	11,9	12,0	163,0	114,0	45,0	17,6	18,0	223,0	171,0	48,0
6,3	8,0	106,0	66,0	36,0	12,0	12,0	163,0	114,0	45,0	17,7	18,0	223,0	171,0	48,0
6,4	8,0	106,0	66,0	36,0	12,1	14,0	182,0	133,0	45,0	17,8	18,0	223,0	171,0	48,0
6,5	8,0	106,0	66,0	36,0	12,2	14,0	182,0	133,0	45,0	17,9	18,0	223,0	171,0	48,0
6,6	8,0	106,0	66,0	36,0	12,3	14,0	182,0	133,0	45,0	18,0	18,0	223,0	171,0	48,0
6,7	8,0	106,0	66,0	36,0	12,4	14,0	182,0	133,0	45,0	18,1	20,0	244,0	190,0	50,0
6,8	8,0	106,0	66,0	36,0	12,5	14,0	182,0	133,0	45,0	18,2	20,0	244,0	190,0	50,0
6,9	8,0	116,0	76,0	36,0	12,6	14,0	182,0	133,0	45,0	18,3	20,0	244,0	190,0	50,0
7,0	8,0	116,0	76,0	36,0	12,7	14,0	182,0	133,0	45,0	18,4	20,0	244,0	190,0	50,0
7,1	8,0	116,0	76,0	36,0	12,8	14,0	182,0	133,0	45,0	18,5	20,0	244,0	190,0	50,0
7,2	8,0	116,0	76,0	36,0	12,9	14,0	182,0	133,0	45,0	18,6	20,0	244,0	190,0	50,0
7,3	8,0	116,0	76,0	36,0	13,0	14,0	182,0	133,0	45,0	18,7	20,0	244,0	190,0	50,0
7,4	8,0	116,0	76,0	36,0	13,1	14,0	182,0	133,0	45,0	18,8	20,0	244,0	190,0	50,0
7,5	8,0	116,0	76,0	36,0	13,2	14,0	182,0	133,0	45,0	18,9	20,0	244,0	190,0	50,0
7,6	8,0	116,0	76,0	36,0	13,3	14,0	182,0	133,0	45,0	19,0	20,0	244,0	190,0	50,0
7,7	8,0	116,0	76,0	36,0	13,4	14,0	182,0	133,0	45,0	19,1	20,0	244,0	190,0	50,0
7,8	8,0	116,0	76,0	36,0	13,5	14,0	182,0	133,0	45,0	19,2	20,0	244,0	190,0	50,0
7,9	8,0	116,0	76,0	36,0	13,6	14,0	182,0	133,0	45,0	19,3	20,0	244,0	190,0	50,0
8,0	8,0	116,0	76,0	36,0	13,7	14,0	182,0	133,0	45,0	19,4	20,0	244,0	190,0	50,0
8,1	10,0	131,0	87,0	40,0	13,8	14,0	182,0	133,0	45,0	19,5	20,0	244,0	190,0	50,0
8,2	10,0	131,0	87,0	40,0	13,9	14,0	182,0	133,0	45,0	19,6	20,0	244,0	190,0	50,0
8,3	10,0	131,0	87,0	40,0	14,0	14,0	182,0	133,0	45,0	19,7	20,0	244,0	190,0	50,0
8,4	10,0	131,0	87,0	40,0	14,1	16,0	204,0	152,0	48,0	19,8	20,0	244,0	190,0	50,0
8,5	10,0	131,0	87,0	40,0	14,2	16,0	204,0	152,0	48,0	19,9	20,0	244,0	190,0	50,0
8,6	10,0	131,0	87,0	40,0	14,3	16,0	204,0	152,0	48,0	20,0	20,0	244,0	190,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1046-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6536
C1046-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F ₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	V _c м/мин	Подача (№ в табл.)
			Н/мм ²			
P	Углеродистые стали общего назначения	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2)	≤500		145	6
		1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤1000		120	5
	Автоматные стали (повыш. обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36)	≤850		170	7
		1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤1000		145	7
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30)	≤700		130	7
		1.0503 C45, 1.1191 C45E (Ck45)	≤850		125	6
		1.0601 C60, 1.1221 C60E (Ck60)	≤1000		120	6
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4	≤1000		120	6
		1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1400		105	6
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		145	7
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		120	6
		1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1400		85	4
	Азотированные стали	1.8504 34CrAl6	≤850		110	6
		1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1400		105	4
Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9	≤850		80	5	
	1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤1400		65	4	
Быстрорежущие стали	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400		60	3	
Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)			≤350 HB	60	2
H	Закаленные стали	-		≤48 HRC	55	2
				≤66 HRC	35	1
S	Специальные сплавы	Нимоник, инконель, монель, хастеллой	≤2000		35	3
		3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		45	3
		3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		40	4

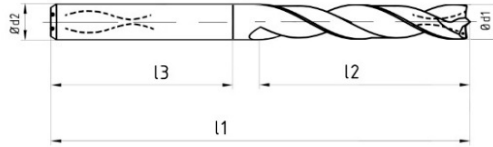
Сверла

Артикул	Серия
C1047	MS-KA

d1 = 3-20



Покрывтие
опционально



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	70,0	30,0	36,0
3,1	6,0	70,0	30,0	36,0
3,2	6,0	70,0	30,0	36,0
3,3	6,0	70,0	30,0	36,0
3,4	6,0	75,0	35,5	36,0
3,5	6,0	75,0	35,5	36,0
3,6	6,0	75,0	35,5	36,0
3,7	6,0	75,0	35,5	36,0
3,8	6,0	75,0	37,5	36,0
3,9	6,0	75,0	37,5	36,0
4,0	6,0	75,0	37,5	36,0
4,1	6,0	75,0	37,5	36,0
4,2	6,0	75,0	37,5	36,0
4,3	6,0	85,0	45,0	36,0
4,4	6,0	85,0	45,0	36,0
4,5	6,0	85,0	45,0	36,0
4,6	6,0	85,0	45,0	36,0
4,7	6,0	85,0	45,0	36,0
4,8	6,0	90,0	50,0	36,0
4,9	6,0	90,0	50,0	36,0
5,0	6,0	90,0	50,0	36,0
5,1	6,0	90,0	50,0	36,0
5,2	6,0	90,0	50,0	36,0
5,3	6,0	90,0	50,0	36,0
5,4	6,0	97,0	57,0	36,0
5,5	6,0	97,0	57,0	36,0
5,6	6,0	97,0	57,0	36,0
5,7	6,0	97,0	57,0	36,0
5,8	6,0	97,0	57,0	36,0
5,9	6,0	97,0	57,0	36,0
6,0	6,0	97,0	57,0	36,0
6,1	8,0	106,0	66,0	36,0
6,2	8,0	106,0	66,0	36,0
6,3	8,0	106,0	66,0	36,0
6,4	8,0	106,0	66,0	36,0
6,5	8,0	106,0	66,0	36,0
6,6	8,0	106,0	66,0	36,0
6,7	8,0	106,0	66,0	36,0
6,8	8,0	106,0	66,0	36,0
6,9	8,0	116,0	76,0	36,0
7,0	8,0	116,0	76,0	36,0
7,1	8,0	116,0	76,0	36,0
7,2	8,0	116,0	76,0	36,0
7,3	8,0	116,0	76,0	36,0
7,4	8,0	116,0	76,0	36,0
7,5	8,0	116,0	76,0	36,0
7,6	8,0	116,0	76,0	36,0
7,7	8,0	116,0	76,0	36,0
7,8	8,0	116,0	76,0	36,0
7,9	8,0	116,0	76,0	36,0
8,0	8,0	116,0	76,0	36,0
8,1	10,0	131,0	87,0	40,0
8,2	10,0	131,0	87,0	40,0
8,3	10,0	131,0	87,0	40,0
8,4	10,0	131,0	87,0	40,0
8,5	10,0	131,0	87,0	40,0
8,6	10,0	131,0	87,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	131,0	87,0	40,0
8,8	10,0	131,0	87,0	40,0
8,9	10,0	131,0	87,0	40,0
9,0	10,0	131,0	87,0	40,0
9,1	10,0	139,0	95,0	40,0
9,2	10,0	139,0	95,0	40,0
9,3	10,0	139,0	95,0	40,0
9,4	10,0	139,0	95,0	40,0
9,5	10,0	139,0	95,0	40,0
9,6	10,0	139,0	95,0	40,0
9,7	10,0	139,0	95,0	40,0
9,8	10,0	139,0	95,0	40,0
9,9	10,0	139,0	95,0	40,0
10,0	10,0	139,0	95,0	40,0
10,1	12,0	155,0	106,0	45,0
10,2	12,0	155,0	106,0	45,0
10,3	12,0	155,0	106,0	45,0
10,4	12,0	155,0	106,0	45,0
10,5	12,0	155,0	106,0	45,0
10,6	12,0	155,0	106,0	45,0
10,7	12,0	155,0	106,0	45,0
10,8	12,0	155,0	106,0	45,0
10,9	12,0	155,0	106,0	45,0
11,0	12,0	155,0	106,0	45,0
11,1	12,0	163,0	114,0	45,0
11,2	12,0	163,0	114,0	45,0
11,3	12,0	163,0	114,0	45,0
11,4	12,0	163,0	114,0	45,0
11,5	12,0	163,0	114,0	45,0
11,6	12,0	163,0	114,0	45,0
11,7	12,0	163,0	114,0	45,0
11,8	12,0	163,0	114,0	45,0
11,9	12,0	163,0	114,0	45,0
12,0	12,0	163,0	114,0	45,0
12,1	14,0	182,0	133,0	45,0
12,2	14,0	182,0	133,0	45,0
12,3	14,0	182,0	133,0	45,0
12,4	14,0	182,0	133,0	45,0
12,5	14,0	182,0	133,0	45,0
12,6	14,0	182,0	133,0	45,0
12,7	14,0	182,0	133,0	45,0
12,8	14,0	182,0	133,0	45,0
12,9	14,0	182,0	133,0	45,0
13,0	14,0	182,0	133,0	45,0
13,1	14,0	182,0	133,0	45,0
13,2	14,0	182,0	133,0	45,0
13,3	14,0	182,0	133,0	45,0
13,4	14,0	182,0	133,0	45,0
13,5	14,0	182,0	133,0	45,0
13,6	14,0	182,0	133,0	45,0
13,7	14,0	182,0	133,0	45,0
13,8	14,0	182,0	133,0	45,0
13,9	14,0	182,0	133,0	45,0
14,0	14,0	182,0	133,0	45,0
14,1	16,0	204,0	152,0	48,0
14,2	16,0	204,0	152,0	48,0
14,3	16,0	204,0	152,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	204,0	152,0	48,0
14,5	16,0	204,0	152,0	48,0
14,6	16,0	204,0	152,0	48,0
14,7	16,0	204,0	152,0	48,0
14,8	16,0	204,0	152,0	48,0
14,9	16,0	204,0	152,0	48,0
15,0	16,0	204,0	152,0	48,0
15,1	16,0	204,0	152,0	48,0
15,2	16,0	204,0	152,0	48,0
15,3	16,0	204,0	152,0	48,0
15,4	16,0	204,0	152,0	48,0
15,5	16,0	204,0	152,0	48,0
15,6	16,0	204,0	152,0	48,0
15,7	16,0	204,0	152,0	48,0
15,8	16,0	204,0	152,0	48,0
15,9	16,0	204,0	152,0	48,0
16,0	16,0	204,0	152,0	48,0
16,1	18,0	223,0	171,0	48,0
16,2	18,0	223,0	171,0	48,0
16,3	18,0	223,0	171,0	48,0
16,4	18,0	223,0	171,0	48,0
16,5	18,0	223,0	171,0	48,0
16,6	18,0	223,0	171,0	48,0
16,7	18,0	223,0	171,0	48,0
16,8	18,0	223,0	171,0	48,0
16,9	18,0	223,0	171,0	48,0
17,0	18,0	223,0	171,0	48,0
17,1	18,0	223,0	171,0	48,0
17,2	18,0	223,0	171,0	48,0
17,3	18,0	223,0	171,0	48,0
17,4	18,0	223,0	171,0	48,0
17,5	18,0	223,0	171,0	48,0
17,6	18,0	223,0	171,0	48,0
17,7	18,0	223,0	171,0	48,0
17,8	18,0	223,0	171,0	48,0
17,9	18,0	223,0	171,0	48,0
18,0	18,0	223,0	171,0	48,0
18,1	20,0	244,0	190,0	50,0
18,2	20,0	244,0	190,0	50,0
18,3	20,0	244,0	190,0	50,0
18,4	20,0	244,0	190,0	50,0
18,5	20,0	244,0	190,0	50,0
18,6	20,0	244,0	190,0	50,0
18,7	20,0	244,0	190,0	50,0
18,8	20,0	244,0	190,0	50,0
18,9	20,0	244,0	190,0	50,0
19,0	20,0	244,0	190,0	50,0
19,1	20,0	244,0	190,0	50,0
19,2	20,0	244,0	190,0	50,0
19,3	20,0	244,0	190,0	50,0
19,4	20,0	244,0	190,0	50,0
19,5	20,0	244,0	190,0	50,0
19,6	20,0	244,0	190,0	50,0
19,7	20,0	244,0	190,0	50,0
19,8	20,0	244,0	190,0	50,0
19,9	20,0	244,0	190,0	50,0
20,0	20,0	244,0	190,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1047-10,0-NA - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика NA по DIN 6535
C1047-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

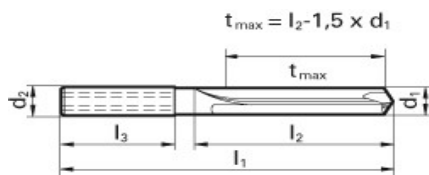
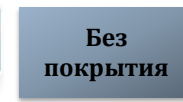
d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vс м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		180	9
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		180	9
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		180	9
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		180	9
	Магниеые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		110	9
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		110	9
	Латунь с короткой струж с длинной стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		110	9
		2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		120	9

Сверла

Артикул	Серия
C1082	MD850AL
d1 = 3-20	

М **МЕТАЛЛЕКТ**



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3
3,0	6,0	66,0	24,0	36,0	8,7	10,0	103,0	61,0	40,0	14,4	16,0	133,0	83,0	48,0
3,1	6,0	66,0	24,0	36,0	8,8	10,0	103,0	61,0	40,0	14,5	16,0	133,0	83,0	48,0
3,2	6,0	66,0	24,0	36,0	8,9	10,0	103,0	61,0	40,0	14,6	16,0	133,0	83,0	48,0
3,3	6,0	66,0	24,0	36,0	9,0	10,0	103,0	61,0	40,0	14,7	16,0	133,0	83,0	48,0
3,4	6,0	66,0	24,0	36,0	9,1	10,0	103,0	61,0	40,0	14,8	16,0	133,0	83,0	48,0
3,5	6,0	66,0	24,0	36,0	9,2	10,0	103,0	61,0	40,0	14,9	16,0	133,0	83,0	48,0
3,6	6,0	66,0	24,0	36,0	9,3	10,0	103,0	61,0	40,0	15,0	16,0	133,0	83,0	48,0
3,7	6,0	66,0	24,0	36,0	9,4	10,0	103,0	61,0	40,0	15,1	16,0	133,0	83,0	48,0
3,8	6,0	74,0	30,0	36,0	9,5	10,0	103,0	61,0	40,0	15,2	16,0	133,0	83,0	48,0
3,9	6,0	74,0	30,0	36,0	9,6	10,0	103,0	61,0	40,0	15,3	16,0	133,0	83,0	48,0
4,0	6,0	74,0	30,0	36,0	9,7	10,0	103,0	61,0	40,0	15,4	16,0	133,0	83,0	48,0
4,1	6,0	74,0	30,0	36,0	9,8	10,0	103,0	61,0	40,0	15,5	16,0	133,0	83,0	48,0
4,2	6,0	74,0	30,0	36,0	9,9	10,0	103,0	61,0	40,0	15,6	16,0	133,0	83,0	48,0
4,3	6,0	74,0	30,0	36,0	10,0	10,0	103,0	61,0	40,0	15,7	16,0	133,0	83,0	48,0
4,4	6,0	74,0	30,0	36,0	10,1	12,0	118,0	71,0	45,0	15,8	16,0	133,0	83,0	48,0
4,5	6,0	74,0	30,0	36,0	10,2	12,0	118,0	71,0	45,0	15,9	16,0	133,0	83,0	48,0
4,6	6,0	74,0	30,0	36,0	10,3	12,0	118,0	71,0	45,0	16,0	16,0	133,0	83,0	48,0
4,7	6,0	74,0	30,0	36,0	10,4	12,0	118,0	71,0	45,0	16,1	18,0	143,0	93,0	48,0
4,8	6,0	74,0	36,0	36,0	10,5	12,0	118,0	71,0	45,0	16,2	18,0	143,0	93,0	48,0
4,9	6,0	74,0	36,0	36,0	10,6	12,0	118,0	71,0	45,0	16,3	18,0	143,0	93,0	48,0
5,0	6,0	74,0	36,0	36,0	10,7	12,0	118,0	71,0	45,0	16,4	18,0	143,0	93,0	48,0
5,1	6,0	74,0	36,0	36,0	10,8	12,0	118,0	71,0	45,0	16,5	18,0	143,0	93,0	48,0
5,2	6,0	74,0	36,0	36,0	10,9	12,0	118,0	71,0	45,0	16,6	18,0	143,0	93,0	48,0
5,3	6,0	74,0	36,0	36,0	11,0	12,0	118,0	71,0	45,0	16,7	18,0	143,0	93,0	48,0
5,4	6,0	74,0	36,0	36,0	11,1	12,0	118,0	71,0	45,0	16,8	18,0	143,0	93,0	48,0
5,5	6,0	74,0	36,0	36,0	11,2	12,0	118,0	71,0	45,0	16,9	18,0	143,0	93,0	48,0
5,6	6,0	74,0	36,0	36,0	11,3	12,0	118,0	71,0	45,0	17,0	18,0	143,0	93,0	48,0
5,7	6,0	74,0	36,0	36,0	11,4	12,0	118,0	71,0	45,0	17,1	18,0	143,0	93,0	48,0
5,8	6,0	74,0	36,0	36,0	11,5	12,0	118,0	71,0	45,0	17,2	18,0	143,0	93,0	48,0
5,9	6,0	74,0	36,0	36,0	11,6	12,0	118,0	71,0	45,0	17,3	18,0	143,0	93,0	48,0
6,0	6,0	74,0	36,0	36,0	11,7	12,0	118,0	71,0	45,0	17,4	18,0	143,0	93,0	48,0
6,1	8,0	91,0	53,0	36,0	11,8	12,0	118,0	71,0	45,0	17,5	18,0	143,0	93,0	48,0
6,2	8,0	91,0	53,0	36,0	11,9	12,0	118,0	71,0	45,0	17,6	18,0	143,0	93,0	48,0
6,3	8,0	91,0	53,0	36,0	12,0	12,0	118,0	71,0	45,0	17,7	18,0	143,0	93,0	48,0
6,4	8,0	91,0	53,0	36,0	12,1	14,0	124,0	74,0	45,0	17,8	18,0	143,0	93,0	48,0
6,5	8,0	91,0	53,0	36,0	12,2	14,0	124,0	74,0	45,0	17,9	18,0	143,0	93,0	48,0
6,6	8,0	91,0	53,0	36,0	12,3	14,0	124,0	74,0	45,0	18,0	18,0	143,0	93,0	48,0
6,7	8,0	91,0	53,0	36,0	12,4	14,0	124,0	74,0	45,0	18,1	20,0	153,0	101,0	50,0
6,8	8,0	91,0	53,0	36,0	12,5	14,0	124,0	74,0	45,0	18,2	20,0	153,0	101,0	50,0
6,9	8,0	91,0	53,0	36,0	12,6	14,0	124,0	74,0	45,0	18,3	20,0	153,0	101,0	50,0
7,0	8,0	91,0	53,0	36,0	12,7	14,0	124,0	74,0	45,0	18,4	20,0	153,0	101,0	50,0
7,1	8,0	91,0	53,0	36,0	12,8	14,0	124,0	74,0	45,0	18,5	20,0	153,0	101,0	50,0
7,2	8,0	91,0	53,0	36,0	12,9	14,0	124,0	74,0	45,0	18,6	20,0	153,0	101,0	50,0
7,3	8,0	91,0	53,0	36,0	13,0	14,0	124,0	74,0	45,0	18,7	20,0	153,0	101,0	50,0
7,4	8,0	91,0	53,0	36,0	13,1	14,0	124,0	74,0	45,0	18,8	20,0	153,0	101,0	50,0
7,5	8,0	91,0	53,0	36,0	13,2	14,0	124,0	74,0	45,0	18,9	20,0	153,0	101,0	50,0
7,6	8,0	91,0	53,0	36,0	13,3	14,0	124,0	74,0	45,0	19,0	20,0	153,0	101,0	50,0
7,7	8,0	91,0	53,0	36,0	13,4	14,0	124,0	74,0	45,0	19,1	20,0	153,0	101,0	50,0
7,8	8,0	91,0	53,0	36,0	13,5	14,0	124,0	74,0	45,0	19,2	20,0	153,0	101,0	50,0
7,9	8,0	91,0	53,0	36,0	13,6	14,0	124,0	74,0	45,0	19,3	20,0	153,0	101,0	50,0
8,0	8,0	91,0	53,0	36,0	13,7	14,0	124,0	74,0	45,0	19,4	20,0	153,0	101,0	50,0
8,1	10,0	103,0	61,0	40,0	13,8	14,0	124,0	74,0	45,0	19,5	20,0	153,0	101,0	50,0
8,2	10,0	103,0	61,0	40,0	13,9	14,0	124,0	74,0	45,0	19,6	20,0	153,0	101,0	50,0
8,3	10,0	103,0	61,0	40,0	14,0	14,0	124,0	74,0	45,0	19,7	20,0	153,0	101,0	50,0
8,4	10,0	103,0	61,0	40,0	14,1	16,0	133,0	83,0	48,0	19,8	20,0	153,0	101,0	50,0
8,5	10,0	103,0	61,0	40,0	14,2	16,0	133,0	83,0	48,0	19,9	20,0	153,0	101,0	50,0
8,6	10,0	103,0	61,0	40,0	14,3	16,0	133,0	83,0	48,0	20,0	20,0	153,0	101,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1082-10,0-NA - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HA по DIN 6536
C1082-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

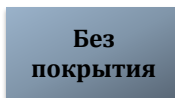
d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		410	9
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		410	9
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		380	9
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		330	9
	Магниеые сплавы	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		280	9
	Медь, низколегир.	2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600			
	Латунь с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		110	6
с длинной стружкой	2.0790 CuNi18Zn19Pb	≤850		80	5	

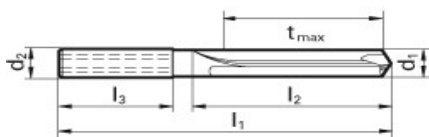
Сверла

Артикул	Серия
C1083	MD850AL
d1 = 3-20	

М METALLEKT



$$t_{\max} = l_2 - 1,5 \times d_1$$



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	74,0	32,0	36,0
3,1	6,0	74,0	32,0	36,0
3,2	6,0	74,0	32,0	36,0
3,3	6,0	74,0	32,0	36,0
3,4	6,0	74,0	34,0	36,0
3,5	6,0	74,0	34,0	36,0
3,6	6,0	74,0	34,0	36,0
3,7	6,0	74,0	34,0	36,0
3,8	6,0	97,0	45,0	36,0
3,9	6,0	97,0	45,0	36,0
4,0	6,0	97,0	45,0	36,0
4,1	6,0	97,0	45,0	36,0
4,2	6,0	97,0	45,0	36,0
4,3	6,0	97,0	45,0	36,0
4,4	6,0	97,0	45,0	36,0
4,5	6,0	97,0	45,0	36,0
4,6	6,0	97,0	45,0	36,0
4,7	6,0	97,0	45,0	36,0
4,8	6,0	97,0	57,0	36,0
4,9	6,0	97,0	57,0	36,0
5,0	6,0	97,0	57,0	36,0
5,1	6,0	97,0	57,0	36,0
5,2	6,0	97,0	57,0	36,0
5,3	6,0	97,0	57,0	36,0
5,4	6,0	97,0	57,0	36,0
5,5	6,0	97,0	57,0	36,0
5,6	6,0	97,0	57,0	36,0
5,7	6,0	97,0	57,0	36,0
5,8	6,0	97,0	57,0	36,0
5,9	6,0	97,0	57,0	36,0
6,0	6,0	97,0	57,0	36,0
6,1	8,0	116,0	76,0	36,0
6,2	8,0	116,0	76,0	36,0
6,3	8,0	116,0	76,0	36,0
6,4	8,0	116,0	76,0	36,0
6,5	8,0	116,0	76,0	36,0
6,6	8,0	116,0	76,0	36,0
6,7	8,0	116,0	76,0	36,0
6,8	8,0	116,0	76,0	36,0
6,9	8,0	116,0	76,0	36,0
7,0	8,0	116,0	76,0	36,0
7,1	8,0	116,0	76,0	36,0
7,2	8,0	116,0	76,0	36,0
7,3	8,0	116,0	76,0	36,0
7,4	8,0	116,0	76,0	36,0
7,5	8,0	116,0	76,0	36,0
7,6	8,0	116,0	76,0	36,0
7,7	8,0	116,0	76,0	36,0
7,8	8,0	116,0	76,0	36,0
7,9	8,0	116,0	76,0	36,0
8,0	8,0	116,0	76,0	36,0
8,1	10,0	139,0	95,0	40,0
8,2	10,0	139,0	95,0	40,0
8,3	10,0	139,0	95,0	40,0
8,4	10,0	139,0	95,0	40,0
8,5	10,0	139,0	95,0	40,0
8,6	10,0	139,0	95,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	139,0	95,0	40,0
8,8	10,0	139,0	95,0	40,0
8,9	10,0	139,0	95,0	40,0
9,0	10,0	139,0	95,0	40,0
9,1	10,0	139,0	95,0	40,0
9,2	10,0	139,0	95,0	40,0
9,3	10,0	139,0	95,0	40,0
9,4	10,0	139,0	95,0	40,0
9,5	10,0	139,0	95,0	40,0
9,6	10,0	139,0	95,0	40,0
9,7	10,0	139,0	95,0	40,0
9,8	10,0	139,0	95,0	40,0
9,9	10,0	139,0	95,0	40,0
10,0	10,0	139,0	95,0	40,0
10,1	12,0	163,0	114,0	45,0
10,2	12,0	163,0	114,0	45,0
10,3	12,0	163,0	114,0	45,0
10,4	12,0	163,0	114,0	45,0
10,5	12,0	163,0	114,0	45,0
10,6	12,0	163,0	114,0	45,0
10,7	12,0	163,0	114,0	45,0
10,8	12,0	163,0	114,0	45,0
10,9	12,0	163,0	114,0	45,0
11,0	12,0	163,0	114,0	45,0
11,1	12,0	163,0	114,0	45,0
11,2	12,0	163,0	114,0	45,0
11,3	12,0	163,0	114,0	45,0
11,4	12,0	163,0	114,0	45,0
11,5	12,0	163,0	114,0	45,0
11,6	12,0	163,0	114,0	45,0
11,7	12,0	163,0	114,0	45,0
11,8	12,0	163,0	114,0	45,0
11,9	12,0	163,0	114,0	45,0
12,0	12,0	163,0	114,0	45,0
12,1	14,0	182,0	133,0	45,0
12,2	14,0	182,0	133,0	45,0
12,3	14,0	182,0	133,0	45,0
12,4	14,0	182,0	133,0	45,0
12,5	14,0	182,0	133,0	45,0
12,6	14,0	182,0	133,0	45,0
12,7	14,0	182,0	133,0	45,0
12,8	14,0	182,0	133,0	45,0
12,9	14,0	182,0	133,0	45,0
13,0	14,0	182,0	133,0	45,0
13,1	14,0	182,0	133,0	45,0
13,2	14,0	182,0	133,0	45,0
13,3	14,0	182,0	133,0	45,0
13,4	14,0	182,0	133,0	45,0
13,5	14,0	182,0	133,0	45,0
13,6	14,0	182,0	133,0	45,0
13,7	14,0	182,0	133,0	45,0
13,8	14,0	182,0	133,0	45,0
13,9	14,0	182,0	133,0	45,0
14,0	14,0	182,0	133,0	45,0
14,1	16,0	204,0	152,0	48,0
14,2	16,0	204,0	152,0	48,0
14,3	16,0	204,0	152,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	204,0	152,0	48,0
14,5	16,0	204,0	152,0	48,0
14,6	16,0	204,0	152,0	48,0
14,7	16,0	204,0	152,0	48,0
14,8	16,0	204,0	152,0	48,0
14,9	16,0	204,0	152,0	48,0
15,0	16,0	204,0	152,0	48,0
15,1	16,0	204,0	152,0	48,0
15,2	16,0	204,0	152,0	48,0
15,3	16,0	204,0	152,0	48,0
15,4	16,0	204,0	152,0	48,0
15,5	16,0	204,0	152,0	48,0
15,6	16,0	204,0	152,0	48,0
15,7	16,0	204,0	152,0	48,0
15,8	16,0	204,0	152,0	48,0
15,9	16,0	204,0	152,0	48,0
16,0	16,0	204,0	152,0	48,0
16,1	18,0	223,0	171,0	48,0
16,2	18,0	223,0	171,0	48,0
16,3	18,0	223,0	171,0	48,0
16,4	18,0	223,0	171,0	48,0
16,5	18,0	223,0	171,0	48,0
16,6	18,0	223,0	171,0	48,0
16,7	18,0	223,0	171,0	48,0
16,8	18,0	223,0	171,0	48,0
16,9	18,0	223,0	171,0	48,0
17,0	18,0	223,0	171,0	48,0
17,1	18,0	223,0	171,0	48,0
17,2	18,0	223,0	171,0	48,0
17,3	18,0	223,0	171,0	48,0
17,4	18,0	223,0	171,0	48,0
17,5	18,0	223,0	171,0	48,0
17,6	18,0	223,0	171,0	48,0
17,7	18,0	223,0	171,0	48,0
17,8	18,0	223,0	171,0	48,0
17,9	18,0	223,0	171,0	48,0
18,0	18,0	223,0	171,0	48,0
18,1	20,0	244,0	190,0	50,0
18,2	20,0	244,0	190,0	50,0
18,3	20,0	244,0	190,0	50,0
18,4	20,0	244,0	190,0	50,0
18,5	20,0	244,0	190,0	50,0
18,6	20,0	244,0	190,0	50,0
18,7	20,0	244,0	190,0	50,0
18,8	20,0	244,0	190,0	50,0
18,9	20,0	244,0	190,0	50,0
19,0	20,0	244,0	190,0	50,0
19,1	20,0	244,0	190,0	50,0
19,2	20,0	244,0	190,0	50,0
19,3	20,0	244,0	190,0	50,0
19,4	20,0	244,0	190,0	50,0
19,5	20,0	244,0	190,0	50,0
19,6	20,0	244,0	190,0	50,0
19,7	20,0	244,0	190,0	50,0
19,8	20,0	244,0	190,0	50,0
19,9	20,0	244,0	190,0	50,0
20,0	20,0	244,0	190,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1083-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6535
 C1083-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6535

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

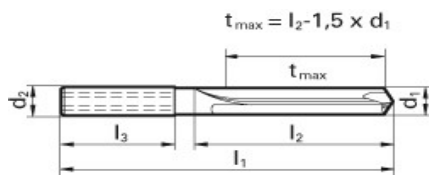
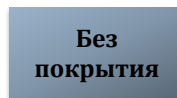
	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vс м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		410	8
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		410	8
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		380	8
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		330	8
	Латунь с короткой стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		280	7
	с длинной стружкой	2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600			
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		110	6
	2.0790 CuNi18Zn19Pb	≤850		80	5	

Сверла

Артикул	Серия
C1084	MD850AL

d1 = 3-20

М МЕТАЛЛЕКТ



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	91,0	42,0	36,0
3,1	6,0	91,0	42,0	36,0
3,2	6,0	91,0	42,0	36,0
3,3	6,0	91,0	42,0	36,0
3,4	6,0	91,0	48,0	36,0
3,5	6,0	91,0	48,0	36,0
3,6	6,0	91,0	48,0	36,0
3,7	6,0	91,0	48,0	36,0
3,8	6,0	121,0	77,0	36,0
3,9	6,0	121,0	77,0	36,0
4,0	6,0	121,0	77,0	36,0
4,1	6,0	121,0	77,0	36,0
4,2	6,0	121,0	77,0	36,0
4,3	6,0	121,0	77,0	36,0
4,4	6,0	121,0	77,0	36,0
4,5	6,0	121,0	77,0	36,0
4,6	6,0	121,0	77,0	36,0
4,7	6,0	121,0	77,0	36,0
4,8	6,0	121,0	82,0	36,0
4,9	6,0	121,0	82,0	36,0
5,0	6,0	121,0	82,0	36,0
5,1	6,0	121,0	82,0	36,0
5,2	6,0	121,0	82,0	36,0
5,3	6,0	121,0	82,0	36,0
5,4	6,0	121,0	82,0	36,0
5,5	6,0	121,0	82,0	36,0
5,6	6,0	121,0	82,0	36,0
5,7	6,0	121,0	82,0	36,0
5,8	6,0	121,0	82,0	36,0
5,9	6,0	121,0	82,0	36,0
6,0	6,0	121,0	82,0	36,0
6,1	8,0	146,0	106,0	36,0
6,2	8,0	146,0	106,0	36,0
6,3	8,0	146,0	106,0	36,0
6,4	8,0	146,0	106,0	36,0
6,5	8,0	146,0	106,0	36,0
6,6	8,0	146,0	106,0	36,0
6,7	8,0	146,0	106,0	36,0
6,8	8,0	146,0	106,0	36,0
6,9	8,0	146,0	106,0	36,0
7,0	8,0	146,0	106,0	36,0
7,1	8,0	146,0	106,0	36,0
7,2	8,0	146,0	106,0	36,0
7,3	8,0	146,0	106,0	36,0
7,4	8,0	146,0	106,0	36,0
7,5	8,0	146,0	106,0	36,0
7,6	8,0	146,0	106,0	36,0
7,7	8,0	146,0	106,0	36,0
7,8	8,0	146,0	106,0	36,0
7,9	8,0	146,0	106,0	36,0
8,0	8,0	146,0	106,0	36,0
8,1	10,0	175,0	130,0	40,0
8,2	10,0	175,0	130,0	40,0
8,3	10,0	175,0	130,0	40,0
8,4	10,0	175,0	130,0	40,0
8,5	10,0	175,0	130,0	40,0
8,6	10,0	175,0	130,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	175,0	130,0	40,0
8,8	10,0	175,0	130,0	40,0
8,9	10,0	175,0	130,0	40,0
9,0	10,0	175,0	130,0	40,0
9,1	10,0	175,0	130,0	40,0
9,2	10,0	175,0	130,0	40,0
9,3	10,0	175,0	130,0	40,0
9,4	10,0	175,0	130,0	40,0
9,5	10,0	175,0	130,0	40,0
9,6	10,0	175,0	130,0	40,0
9,7	10,0	175,0	130,0	40,0
9,8	10,0	175,0	130,0	40,0
9,9	10,0	175,0	130,0	40,0
10,0	10,0	175,0	130,0	40,0
10,1	12,0	209,0	159,0	45,0
10,2	12,0	209,0	159,0	45,0
10,3	12,0	209,0	159,0	45,0
10,4	12,0	209,0	159,0	45,0
10,5	12,0	209,0	159,0	45,0
10,6	12,0	209,0	159,0	45,0
10,7	12,0	209,0	159,0	45,0
10,8	12,0	209,0	159,0	45,0
10,9	12,0	209,0	159,0	45,0
11,0	12,0	209,0	159,0	45,0
11,1	12,0	209,0	159,0	45,0
11,2	12,0	209,0	159,0	45,0
11,3	12,0	209,0	159,0	45,0
11,4	12,0	209,0	159,0	45,0
11,5	12,0	209,0	159,0	45,0
11,6	12,0	209,0	159,0	45,0
11,7	12,0	209,0	159,0	45,0
11,8	12,0	209,0	159,0	45,0
11,9	12,0	209,0	159,0	45,0
12,0	12,0	209,0	159,0	45,0
12,1	14,0	233,0	183,0	45,0
12,2	14,0	233,0	183,0	45,0
12,3	14,0	233,0	183,0	45,0
12,4	14,0	233,0	183,0	45,0
12,5	14,0	233,0	183,0	45,0
12,6	14,0	233,0	183,0	45,0
12,7	14,0	233,0	183,0	45,0
12,8	14,0	233,0	183,0	45,0
12,9	14,0	233,0	183,0	45,0
13,0	14,0	233,0	183,0	45,0
13,1	14,0	233,0	183,0	45,0
13,2	14,0	233,0	183,0	45,0
13,3	14,0	233,0	183,0	45,0
13,4	14,0	233,0	183,0	45,0
13,5	14,0	233,0	183,0	45,0
13,6	14,0	233,0	183,0	45,0
13,7	14,0	233,0	183,0	45,0
13,8	14,0	233,0	183,0	45,0
13,9	14,0	233,0	183,0	45,0
14,0	14,0	233,0	183,0	45,0
14,1	16,0	260,0	207,0	48,0
14,2	16,0	260,0	207,0	48,0
14,3	16,0	260,0	207,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	260,0	207,0	48,0
14,5	16,0	260,0	207,0	48,0
14,6	16,0	260,0	207,0	48,0
14,7	16,0	260,0	207,0	48,0
14,8	16,0	260,0	207,0	48,0
14,9	16,0	260,0	207,0	48,0
15,0	16,0	260,0	207,0	48,0
15,1	16,0	260,0	207,0	48,0
15,2	16,0	260,0	207,0	48,0
15,3	16,0	260,0	207,0	48,0
15,4	16,0	260,0	207,0	48,0
15,5	16,0	260,0	207,0	48,0
15,6	16,0	260,0	207,0	48,0
15,7	16,0	260,0	207,0	48,0
15,8	16,0	260,0	207,0	48,0
15,9	16,0	260,0	207,0	48,0
16,0	16,0	260,0	207,0	48,0
16,1	18,0	284,0	231,0	48,0
16,2	18,0	284,0	231,0	48,0
16,3	18,0	284,0	231,0	48,0
16,4	18,0	284,0	231,0	48,0
16,5	18,0	284,0	231,0	48,0
16,6	18,0	284,0	231,0	48,0
16,7	18,0	284,0	231,0	48,0
16,8	18,0	284,0	231,0	48,0
16,9	18,0	284,0	231,0	48,0
17,0	18,0	284,0	231,0	48,0
17,1	18,0	284,0	231,0	48,0
17,2	18,0	284,0	231,0	48,0
17,3	18,0	284,0	231,0	48,0
17,4	18,0	284,0	231,0	48,0
17,5	18,0	284,0	231,0	48,0
17,6	18,0	284,0	231,0	48,0
17,7	18,0	284,0	231,0	48,0
17,8	18,0	284,0	231,0	48,0
17,9	18,0	284,0	231,0	48,0
18,0	18,0	284,0	231,0	48,0
18,1	20,0	308,0	255,0	50,0
18,2	20,0	308,0	255,0	50,0
18,3	20,0	308,0	255,0	50,0
18,4	20,0	308,0	255,0	50,0
18,5	20,0	308,0	255,0	50,0
18,6	20,0	308,0	255,0	50,0
18,7	20,0	308,0	255,0	50,0
18,8	20,0	308,0	255,0	50,0
18,9	20,0	308,0	255,0	50,0
19,0	20,0	308,0	255,0	50,0
19,1	20,0	308,0	255,0	50,0
19,2	20,0	308,0	255,0	50,0
19,3	20,0	308,0	255,0	50,0
19,4	20,0	308,0	255,0	50,0
19,5	20,0	308,0	255,0	50,0
19,6	20,0	308,0	255,0	50,0
19,7	20,0	308,0	255,0	50,0
19,8	20,0	308,0	255,0	50,0
19,9	20,0	308,0	255,0	50,0
20,0	20,0	308,0	255,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1084-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6536

C1084-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

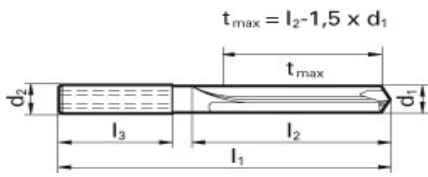
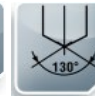
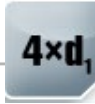
	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		410	8
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		410	8
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		380	8
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		330	8
	Латунь с короткой стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		280	7
	с длинной стружкой	2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600			
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		110	6
	2.0790 CuNi18Zn19Pb	≤850		80	5	

Сверла

Артикул	Серия
C1085	MD850G

d1 = 3-20

М **МЕТАЛЛЕКТ**



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	66,0	24,0	36,0
3,1	6,0	66,0	24,0	36,0
3,2	6,0	66,0	24,0	36,0
3,3	6,0	66,0	24,0	36,0
3,4	6,0	66,0	24,0	36,0
3,5	6,0	66,0	24,0	36,0
3,6	6,0	66,0	24,0	36,0
3,7	6,0	66,0	24,0	36,0
3,8	6,0	74,0	30,0	36,0
3,9	6,0	74,0	30,0	36,0
4,0	6,0	74,0	30,0	36,0
4,1	6,0	74,0	30,0	36,0
4,2	6,0	74,0	30,0	36,0
4,3	6,0	74,0	30,0	36,0
4,4	6,0	74,0	30,0	36,0
4,5	6,0	74,0	30,0	36,0
4,6	6,0	74,0	30,0	36,0
4,7	6,0	74,0	30,0	36,0
4,8	6,0	74,0	36,0	36,0
4,9	6,0	74,0	36,0	36,0
5,0	6,0	74,0	36,0	36,0
5,1	6,0	74,0	36,0	36,0
5,2	6,0	74,0	36,0	36,0
5,3	6,0	74,0	36,0	36,0
5,4	6,0	74,0	36,0	36,0
5,5	6,0	74,0	36,0	36,0
5,6	6,0	74,0	36,0	36,0
5,7	6,0	74,0	36,0	36,0
5,8	6,0	74,0	36,0	36,0
5,9	6,0	74,0	36,0	36,0
6,0	6,0	74,0	36,0	36,0
6,1	8,0	91,0	53,0	36,0
6,2	8,0	91,0	53,0	36,0
6,3	8,0	91,0	53,0	36,0
6,4	8,0	91,0	53,0	36,0
6,5	8,0	91,0	53,0	36,0
6,6	8,0	91,0	53,0	36,0
6,7	8,0	91,0	53,0	36,0
6,8	8,0	91,0	53,0	36,0
6,9	8,0	91,0	53,0	36,0
7,0	8,0	91,0	53,0	36,0
7,1	8,0	91,0	53,0	36,0
7,2	8,0	91,0	53,0	36,0
7,3	8,0	91,0	53,0	36,0
7,4	8,0	91,0	53,0	36,0
7,5	8,0	91,0	53,0	36,0
7,6	8,0	91,0	53,0	36,0
7,7	8,0	91,0	53,0	36,0
7,8	8,0	91,0	53,0	36,0
7,9	8,0	91,0	53,0	36,0
8,0	8,0	91,0	53,0	36,0
8,1	10,0	103,0	61,0	40,0
8,2	10,0	103,0	61,0	40,0
8,3	10,0	103,0	61,0	40,0
8,4	10,0	103,0	61,0	40,0
8,5	10,0	103,0	61,0	40,0
8,6	10,0	103,0	61,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	103,0	61,0	40,0
8,8	10,0	103,0	61,0	40,0
8,9	10,0	103,0	61,0	40,0
9,0	10,0	103,0	61,0	40,0
9,1	10,0	103,0	61,0	40,0
9,2	10,0	103,0	61,0	40,0
9,3	10,0	103,0	61,0	40,0
9,4	10,0	103,0	61,0	40,0
9,5	10,0	103,0	61,0	40,0
9,6	10,0	103,0	61,0	40,0
9,7	10,0	103,0	61,0	40,0
9,8	10,0	103,0	61,0	40,0
9,9	10,0	103,0	61,0	40,0
10,0	10,0	103,0	61,0	40,0
10,1	12,0	118,0	71,0	45,0
10,2	12,0	118,0	71,0	45,0
10,3	12,0	118,0	71,0	45,0
10,4	12,0	118,0	71,0	45,0
10,5	12,0	118,0	71,0	45,0
10,6	12,0	118,0	71,0	45,0
10,7	12,0	118,0	71,0	45,0
10,8	12,0	118,0	71,0	45,0
10,9	12,0	118,0	71,0	45,0
11,0	12,0	118,0	71,0	45,0
11,1	12,0	118,0	71,0	45,0
11,2	12,0	118,0	71,0	45,0
11,3	12,0	118,0	71,0	45,0
11,4	12,0	118,0	71,0	45,0
11,5	12,0	118,0	71,0	45,0
11,6	12,0	118,0	71,0	45,0
11,7	12,0	118,0	71,0	45,0
11,8	12,0	118,0	71,0	45,0
11,9	12,0	118,0	71,0	45,0
12,0	12,0	118,0	71,0	45,0
12,1	14,0	124,0	74,0	45,0
12,2	14,0	124,0	74,0	45,0
12,3	14,0	124,0	74,0	45,0
12,4	14,0	124,0	74,0	45,0
12,5	14,0	124,0	74,0	45,0
12,6	14,0	124,0	74,0	45,0
12,7	14,0	124,0	74,0	45,0
12,8	14,0	124,0	74,0	45,0
12,9	14,0	124,0	74,0	45,0
13,0	14,0	124,0	74,0	45,0
13,1	14,0	124,0	74,0	45,0
13,2	14,0	124,0	74,0	45,0
13,3	14,0	124,0	74,0	45,0
13,4	14,0	124,0	74,0	45,0
13,5	14,0	124,0	74,0	45,0
13,6	14,0	124,0	74,0	45,0
13,7	14,0	124,0	74,0	45,0
13,8	14,0	124,0	74,0	45,0
13,9	14,0	124,0	74,0	45,0
14,0	14,0	124,0	74,0	45,0
14,1	16,0	133,0	83,0	48,0
14,2	16,0	133,0	83,0	48,0
14,3	16,0	133,0	83,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	133,0	83,0	48,0
14,5	16,0	133,0	83,0	48,0
14,6	16,0	133,0	83,0	48,0
14,7	16,0	133,0	83,0	48,0
14,8	16,0	133,0	83,0	48,0
14,9	16,0	133,0	83,0	48,0
15,0	16,0	133,0	83,0	48,0
15,1	16,0	133,0	83,0	48,0
15,2	16,0	133,0	83,0	48,0
15,3	16,0	133,0	83,0	48,0
15,4	16,0	133,0	83,0	48,0
15,5	16,0	133,0	83,0	48,0
15,6	16,0	133,0	83,0	48,0
15,7	16,0	133,0	83,0	48,0
15,8	16,0	133,0	83,0	48,0
15,9	16,0	133,0	83,0	48,0
16,0	16,0	133,0	83,0	48,0
16,1	18,0	143,0	93,0	48,0
16,2	18,0	143,0	93,0	48,0
16,3	18,0	143,0	93,0	48,0
16,4	18,0	143,0	93,0	48,0
16,5	18,0	143,0	93,0	48,0
16,6	18,0	143,0	93,0	48,0
16,7	18,0	143,0	93,0	48,0
16,8	18,0	143,0	93,0	48,0
16,9	18,0	143,0	93,0	48,0
17,0	18,0	143,0	93,0	48,0
17,1	18,0	143,0	93,0	48,0
17,2	18,0	143,0	93,0	48,0
17,3	18,0	143,0	93,0	48,0
17,4	18,0	143,0	93,0	48,0
17,5	18,0	143,0	93,0	48,0
17,6	18,0	143,0	93,0	48,0
17,7	18,0	143,0	93,0	48,0
17,8	18,0	143,0	93,0	48,0
17,9	18,0	143,0	93,0	48,0
18,0	18,0	143,0	93,0	48,0
18,1	20,0	153,0	101,0	50,0
18,2	20,0	153,0	101,0	50,0
18,3	20,0	153,0	101,0	50,0
18,4	20,0	153,0	101,0	50,0
18,5	20,0	153,0	101,0	50,0
18,6	20,0	153,0	101,0	50,0
18,7	20,0	153,0	101,0	50,0
18,8	20,0	153,0	101,0	50,0
18,9	20,0	153,0	101,0	50,0
19,0	20,0	153,0	101,0	50,0
19,1	20,0	153,0	101,0	50,0
19,2	20,0	153,0	101,0	50,0
19,3	20,0	153,0	101,0	50,0
19,4	20,0	153,0	101,0	50,0
19,5	20,0	153,0	101,0	50,0
19,6	20,0	153,0	101,0	50,0
19,7	20,0	153,0	101,0	50,0
19,8	20,0	153,0	101,0	50,0
19,9	20,0	153,0	101,0	50,0
20,0	20,0	153,0	101,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1085-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6536
 C1085-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
К	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20)		≤240 HB	120	7
		0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤350 HB	100	7
	Высокопрочный и ковкий чугун	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35)		≤240 HB	90	7
		0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤350 HB	80	7
	Отбеленный чугун	–		≤350 HB	40	2

Сверла

Артикул	Серия
C1086	MD850G

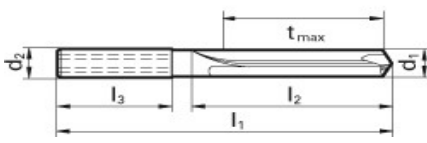
d1 = 3-20

М **МЕТАЛЛЕКТ**



С покрытием

$$t_{\max} = l_2 - 1,5 \times d_1$$



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	74,0	32,0	36,0
3,1	6,0	74,0	32,0	36,0
3,2	6,0	74,0	32,0	36,0
3,3	6,0	74,0	32,0	36,0
3,4	6,0	74,0	34,0	36,0
3,5	6,0	74,0	34,0	36,0
3,6	6,0	74,0	34,0	36,0
3,7	6,0	74,0	34,0	36,0
3,8	6,0	97,0	45,0	36,0
3,9	6,0	97,0	45,0	36,0
4,0	6,0	97,0	45,0	36,0
4,1	6,0	97,0	45,0	36,0
4,2	6,0	97,0	45,0	36,0
4,3	6,0	97,0	45,0	36,0
4,4	6,0	97,0	45,0	36,0
4,5	6,0	97,0	45,0	36,0
4,6	6,0	97,0	45,0	36,0
4,7	6,0	97,0	45,0	36,0
4,8	6,0	97,0	57,0	36,0
4,9	6,0	97,0	57,0	36,0
5,0	6,0	97,0	57,0	36,0
5,1	6,0	97,0	57,0	36,0
5,2	6,0	97,0	57,0	36,0
5,3	6,0	97,0	57,0	36,0
5,4	6,0	97,0	57,0	36,0
5,5	6,0	97,0	57,0	36,0
5,6	6,0	97,0	57,0	36,0
5,7	6,0	97,0	57,0	36,0
5,8	6,0	97,0	57,0	36,0
5,9	6,0	97,0	57,0	36,0
6,0	6,0	97,0	57,0	36,0
6,1	8,0	116,0	76,0	36,0
6,2	8,0	116,0	76,0	36,0
6,3	8,0	116,0	76,0	36,0
6,4	8,0	116,0	76,0	36,0
6,5	8,0	116,0	76,0	36,0
6,6	8,0	116,0	76,0	36,0
6,7	8,0	116,0	76,0	36,0
6,8	8,0	116,0	76,0	36,0
6,9	8,0	116,0	76,0	36,0
7,0	8,0	116,0	76,0	36,0
7,1	8,0	116,0	76,0	36,0
7,2	8,0	116,0	76,0	36,0
7,3	8,0	116,0	76,0	36,0
7,4	8,0	116,0	76,0	36,0
7,5	8,0	116,0	76,0	36,0
7,6	8,0	116,0	76,0	36,0
7,7	8,0	116,0	76,0	36,0
7,8	8,0	116,0	76,0	36,0
7,9	8,0	116,0	76,0	36,0
8,0	8,0	116,0	76,0	36,0
8,1	10,0	139,0	95,0	40,0
8,2	10,0	139,0	95,0	40,0
8,3	10,0	139,0	95,0	40,0
8,4	10,0	139,0	95,0	40,0
8,5	10,0	139,0	95,0	40,0
8,6	10,0	139,0	95,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	139,0	95,0	40,0
8,8	10,0	139,0	95,0	40,0
8,9	10,0	139,0	95,0	40,0
9,0	10,0	139,0	95,0	40,0
9,1	10,0	139,0	95,0	40,0
9,2	10,0	139,0	95,0	40,0
9,3	10,0	139,0	95,0	40,0
9,4	10,0	139,0	95,0	40,0
9,5	10,0	139,0	95,0	40,0
9,6	10,0	139,0	95,0	40,0
9,7	10,0	139,0	95,0	40,0
9,8	10,0	139,0	95,0	40,0
9,9	10,0	139,0	95,0	40,0
10,0	10,0	139,0	95,0	40,0
10,1	12,0	163,0	114,0	45,0
10,2	12,0	163,0	114,0	45,0
10,3	12,0	163,0	114,0	45,0
10,4	12,0	163,0	114,0	45,0
10,5	12,0	163,0	114,0	45,0
10,6	12,0	163,0	114,0	45,0
10,7	12,0	163,0	114,0	45,0
10,8	12,0	163,0	114,0	45,0
10,9	12,0	163,0	114,0	45,0
11,0	12,0	163,0	114,0	45,0
11,1	12,0	163,0	114,0	45,0
11,2	12,0	163,0	114,0	45,0
11,3	12,0	163,0	114,0	45,0
11,4	12,0	163,0	114,0	45,0
11,5	12,0	163,0	114,0	45,0
11,6	12,0	163,0	114,0	45,0
11,7	12,0	163,0	114,0	45,0
11,8	12,0	163,0	114,0	45,0
11,9	12,0	163,0	114,0	45,0
12,0	12,0	163,0	114,0	45,0
12,1	14,0	182,0	133,0	45,0
12,2	14,0	182,0	133,0	45,0
12,3	14,0	182,0	133,0	45,0
12,4	14,0	182,0	133,0	45,0
12,5	14,0	182,0	133,0	45,0
12,6	14,0	182,0	133,0	45,0
12,7	14,0	182,0	133,0	45,0
12,8	14,0	182,0	133,0	45,0
12,9	14,0	182,0	133,0	45,0
13,0	14,0	182,0	133,0	45,0
13,1	14,0	182,0	133,0	45,0
13,2	14,0	182,0	133,0	45,0
13,3	14,0	182,0	133,0	45,0
13,4	14,0	182,0	133,0	45,0
13,5	14,0	182,0	133,0	45,0
13,6	14,0	182,0	133,0	45,0
13,7	14,0	182,0	133,0	45,0
13,8	14,0	182,0	133,0	45,0
13,9	14,0	182,0	133,0	45,0
14,0	14,0	182,0	133,0	45,0
14,1	16,0	204,0	152,0	48,0
14,2	16,0	204,0	152,0	48,0
14,3	16,0	204,0	152,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	204,0	152,0	48,0
14,5	16,0	204,0	152,0	48,0
14,6	16,0	204,0	152,0	48,0
14,7	16,0	204,0	152,0	48,0
14,8	16,0	204,0	152,0	48,0
14,9	16,0	204,0	152,0	48,0
15,0	16,0	204,0	152,0	48,0
15,1	16,0	204,0	152,0	48,0
15,2	16,0	204,0	152,0	48,0
15,3	16,0	204,0	152,0	48,0
15,4	16,0	204,0	152,0	48,0
15,5	16,0	204,0	152,0	48,0
15,6	16,0	204,0	152,0	48,0
15,7	16,0	204,0	152,0	48,0
15,8	16,0	204,0	152,0	48,0
15,9	16,0	204,0	152,0	48,0
16,0	16,0	204,0	152,0	48,0
16,1	18,0	223,0	171,0	48,0
16,2	18,0	223,0	171,0	48,0
16,3	18,0	223,0	171,0	48,0
16,4	18,0	223,0	171,0	48,0
16,5	18,0	223,0	171,0	48,0
16,6	18,0	223,0	171,0	48,0
16,7	18,0	223,0	171,0	48,0
16,8	18,0	223,0	171,0	48,0
16,9	18,0	223,0	171,0	48,0
17,0	18,0	223,0	171,0	48,0
17,1	18,0	223,0	171,0	48,0
17,2	18,0	223,0	171,0	48,0
17,3	18,0	223,0	171,0	48,0
17,4	18,0	223,0	171,0	48,0
17,5	18,0	223,0	171,0	48,0
17,6	18,0	223,0	171,0	48,0
17,7	18,0	223,0	171,0	48,0
17,8	18,0	223,0	171,0	48,0
17,9	18,0	223,0	171,0	48,0
18,0	18,0	223,0	171,0	48,0
18,1	20,0	244,0	190,0	50,0
18,2	20,0	244,0	190,0	50,0
18,3	20,0	244,0	190,0	50,0
18,4	20,0	244,0	190,0	50,0
18,5	20,0	244,0	190,0	50,0
18,6	20,0	244,0	190,0	50,0
18,7	20,0	244,0	190,0	50,0
18,8	20,0	244,0	190,0	50,0
18,9	20,0	244,0	190,0	50,0
19,0	20,0	244,0	190,0	50,0
19,1	20,0	244,0	190,0	50,0
19,2	20,0	244,0	190,0	50,0
19,3	20,0	244,0	190,0	50,0
19,4	20,0	244,0	190,0	50,0
19,5	20,0	244,0	190,0	50,0
19,6	20,0	244,0	190,0	50,0
19,7	20,0	244,0	190,0	50,0
19,8	20,0	244,0	190,0	50,0
19,9	20,0	244,0	190,0	50,0
20,0	20,0	244,0	190,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1086-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6536

C1086-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
К	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20)		≤240 HB	120	7
		0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤350 HB	100	7
	Высокопрочный и ковкий чугун	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35)		≤240 HB	90	7
		0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤350 HB	80	7
	Отбеленный чугун	–		≤350 HB	40	2

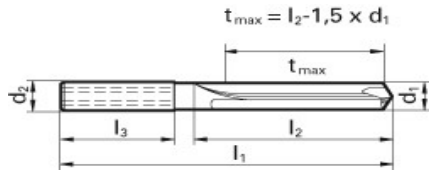
Сверла

Артикул	Серия
C1087	MD850G
d1 = 3-20	

М МЕТАЛЛЕКТ



С покрытием



P	M	K	N	S	H
		•			

Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	91,0	42,0	36,0
3,1	6,0	91,0	42,0	36,0
3,2	6,0	91,0	42,0	36,0
3,3	6,0	91,0	42,0	36,0
3,4	6,0	91,0	48,0	36,0
3,5	6,0	91,0	48,0	36,0
3,6	6,0	91,0	48,0	36,0
3,7	6,0	91,0	48,0	36,0
3,8	6,0	121,0	77,0	36,0
3,9	6,0	121,0	77,0	36,0
4,0	6,0	121,0	77,0	36,0
4,1	6,0	121,0	77,0	36,0
4,2	6,0	121,0	77,0	36,0
4,3	6,0	121,0	77,0	36,0
4,4	6,0	121,0	77,0	36,0
4,5	6,0	121,0	77,0	36,0
4,6	6,0	121,0	77,0	36,0
4,7	6,0	121,0	77,0	36,0
4,8	6,0	121,0	82,0	36,0
4,9	6,0	121,0	82,0	36,0
5,0	6,0	121,0	82,0	36,0
5,1	6,0	121,0	82,0	36,0
5,2	6,0	121,0	82,0	36,0
5,3	6,0	121,0	82,0	36,0
5,4	6,0	121,0	82,0	36,0
5,5	6,0	121,0	82,0	36,0
5,6	6,0	121,0	82,0	36,0
5,7	6,0	121,0	82,0	36,0
5,8	6,0	121,0	82,0	36,0
5,9	6,0	121,0	82,0	36,0
6,0	6,0	121,0	82,0	36,0
6,1	8,0	146,0	106,0	36,0
6,2	8,0	146,0	106,0	36,0
6,3	8,0	146,0	106,0	36,0
6,4	8,0	146,0	106,0	36,0
6,5	8,0	146,0	106,0	36,0
6,6	8,0	146,0	106,0	36,0
6,7	8,0	146,0	106,0	36,0
6,8	8,0	146,0	106,0	36,0
6,9	8,0	146,0	106,0	36,0
7,0	8,0	146,0	106,0	36,0
7,1	8,0	146,0	106,0	36,0
7,2	8,0	146,0	106,0	36,0
7,3	8,0	146,0	106,0	36,0
7,4	8,0	146,0	106,0	36,0
7,5	8,0	146,0	106,0	36,0
7,6	8,0	146,0	106,0	36,0
7,7	8,0	146,0	106,0	36,0
7,8	8,0	146,0	106,0	36,0
7,9	8,0	146,0	106,0	36,0
8,0	8,0	146,0	106,0	36,0
8,1	10,0	175,0	130,0	40,0
8,2	10,0	175,0	130,0	40,0
8,3	10,0	175,0	130,0	40,0
8,4	10,0	175,0	130,0	40,0
8,5	10,0	175,0	130,0	40,0
8,6	10,0	175,0	130,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	175,0	130,0	40,0
8,8	10,0	175,0	130,0	40,0
8,9	10,0	175,0	130,0	40,0
9,0	10,0	175,0	130,0	40,0
9,1	10,0	175,0	130,0	40,0
9,2	10,0	175,0	130,0	40,0
9,3	10,0	175,0	130,0	40,0
9,4	10,0	175,0	130,0	40,0
9,5	10,0	175,0	130,0	40,0
9,6	10,0	175,0	130,0	40,0
9,7	10,0	175,0	130,0	40,0
9,8	10,0	175,0	130,0	40,0
9,9	10,0	175,0	130,0	40,0
10,0	10,0	175,0	130,0	40,0
10,1	12,0	209,0	159,0	45,0
10,2	12,0	209,0	159,0	45,0
10,3	12,0	209,0	159,0	45,0
10,4	12,0	209,0	159,0	45,0
10,5	12,0	209,0	159,0	45,0
10,6	12,0	209,0	159,0	45,0
10,7	12,0	209,0	159,0	45,0
10,8	12,0	209,0	159,0	45,0
10,9	12,0	209,0	159,0	45,0
11,0	12,0	209,0	159,0	45,0
11,1	12,0	209,0	159,0	45,0
11,2	12,0	209,0	159,0	45,0
11,3	12,0	209,0	159,0	45,0
11,4	12,0	209,0	159,0	45,0
11,5	12,0	209,0	159,0	45,0
11,6	12,0	209,0	159,0	45,0
11,7	12,0	209,0	159,0	45,0
11,8	12,0	209,0	159,0	45,0
11,9	12,0	209,0	159,0	45,0
12,0	12,0	209,0	159,0	45,0
12,1	14,0	233,0	183,0	45,0
12,2	14,0	233,0	183,0	45,0
12,3	14,0	233,0	183,0	45,0
12,4	14,0	233,0	183,0	45,0
12,5	14,0	233,0	183,0	45,0
12,6	14,0	233,0	183,0	45,0
12,7	14,0	233,0	183,0	45,0
12,8	14,0	233,0	183,0	45,0
12,9	14,0	233,0	183,0	45,0
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13,1	14,0	233,0	183,0	45,0
13,2	14,0	233,0	183,0	45,0
13,3	14,0	233,0	183,0	45,0
13,4	14,0	233,0	183,0	45,0
13,5	14,0	233,0	183,0	45,0
13,6	14,0	233,0	183,0	45,0
13,7	14,0	233,0	183,0	45,0
13,8	14,0	233,0	183,0	45,0
13,9	14,0	233,0	183,0	45,0
14,0	14,0	233,0	183,0	45,0
14,1	16,0	260,0	207,0	48,0
14,2	16,0	260,0	207,0	48,0
14,3	16,0	260,0	207,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	260,0	207,0	48,0
14,5	16,0	260,0	207,0	48,0
14,6	16,0	260,0	207,0	48,0
14,7	16,0	260,0	207,0	48,0
14,8	16,0	260,0	207,0	48,0
14,9	16,0	260,0	207,0	48,0
15,0	16,0	260,0	207,0	48,0
15,1	16,0	260,0	207,0	48,0
15,2	16,0	260,0	207,0	48,0
15,3	16,0	260,0	207,0	48,0
15,4	16,0	260,0	207,0	48,0
15,5	16,0	260,0	207,0	48,0
15,6	16,0	260,0	207,0	48,0
15,7	16,0	260,0	207,0	48,0
15,8	16,0	260,0	207,0	48,0
15,9	16,0	260,0	207,0	48,0
16,0	16,0	260,0	207,0	48,0
16,1	18,0	284,0	231,0	48,0
16,2	18,0	284,0	231,0	48,0
16,3	18,0	284,0	231,0	48,0
16,4	18,0	284,0	231,0	48,0
16,5	18,0	284,0	231,0	48,0
16,6	18,0	284,0	231,0	48,0
16,7	18,0	284,0	231,0	48,0
16,8	18,0	284,0	231,0	48,0
16,9	18,0	284,0	231,0	48,0
17,0	18,0	284,0	231,0	48,0
17,1	18,0	284,0	231,0	48,0
17,2	18,0	284,0	231,0	48,0
17,3	18,0	284,0	231,0	48,0
17,4	18,0	284,0	231,0	48,0
17,5	18,0	284,0	231,0	48,0
17,6	18,0	284,0	231,0	48,0
17,7	18,0	284,0	231,0	48,0
17,8	18,0	284,0	231,0	48,0
17,9	18,0	284,0	231,0	48,0
18,0	18,0	284,0	231,0	48,0
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18,2	20,0	308,0	255,0	50,0
18,3	20,0	308,0	255,0	50,0
18,4	20,0	308,0	255,0	50,0
18,5	20,0	308,0	255,0	50,0
18,6	20,0	308,0	255,0	50,0
18,7	20,0	308,0	255,0	50,0
18,8	20,0	308,0	255,0	50,0
18,9	20,0	308,0	255,0	50,0
19,0	20,0	308,0	255,0	50,0
19,1	20,0	308,0	255,0	50,0
19,2	20,0	308,0	255,0	50,0
19,3	20,0	308,0	255,0	50,0
19,4	20,0	308,0	255,0	50,0
19,5	20,0	308,0	255,0	50,0
19,6	20,0	308,0	255,0	50,0
19,7	20,0	308,0	255,0	50,0
19,8	20,0	308,0	255,0	50,0
19,9	20,0	308,0	255,0	50,0
20,0	20,0	308,0	255,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1087-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6536

C1087-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

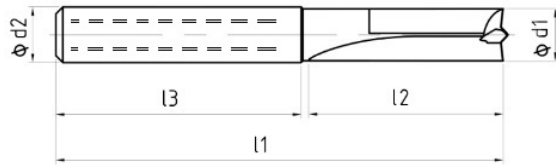
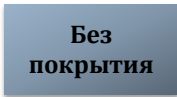
	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
К	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20)		≤240 HB	120	6
		0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤350 HB	100	6
	Высокопрочный и ковкий чугун	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35)		≤240 HB	90	6
		0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤350 HB	80	6
	Отбеленный чугун	–		≤350 HB	40	2

Сверла

Артикул	Серия
C1088	MG-KA

d1 = 3-20

МЕТАЛЛЕКТ



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3	d1 m7	d2 h6	l1	l2	l3
3,0	6,0	66,0	24,0	36,0	8,7	10,0	103,0	61,0	40,0	14,4	16,0	133,0	83,0	48,0
3,1	6,0	66,0	24,0	36,0	8,8	10,0	103,0	61,0	40,0	14,5	16,0	133,0	83,0	48,0
3,2	6,0	66,0	24,0	36,0	8,9	10,0	103,0	61,0	40,0	14,6	16,0	133,0	83,0	48,0
3,3	6,0	66,0	24,0	36,0	9,0	10,0	103,0	61,0	40,0	14,7	16,0	133,0	83,0	48,0
3,4	6,0	66,0	24,0	36,0	9,1	10,0	103,0	61,0	40,0	14,8	16,0	133,0	83,0	48,0
3,5	6,0	66,0	24,0	36,0	9,2	10,0	103,0	61,0	40,0	14,9	16,0	133,0	83,0	48,0
3,6	6,0	66,0	24,0	36,0	9,3	10,0	103,0	61,0	40,0	15,0	16,0	133,0	83,0	48,0
3,7	6,0	66,0	24,0	36,0	9,4	10,0	103,0	61,0	40,0	15,1	16,0	133,0	83,0	48,0
3,8	6,0	74,0	30,0	36,0	9,5	10,0	103,0	61,0	40,0	15,2	16,0	133,0	83,0	48,0
3,9	6,0	74,0	30,0	36,0	9,6	10,0	103,0	61,0	40,0	15,3	16,0	133,0	83,0	48,0
4,0	6,0	74,0	30,0	36,0	9,7	10,0	103,0	61,0	40,0	15,4	16,0	133,0	83,0	48,0
4,1	6,0	74,0	30,0	36,0	9,8	10,0	103,0	61,0	40,0	15,5	16,0	133,0	83,0	48,0
4,2	6,0	74,0	30,0	36,0	9,9	10,0	103,0	61,0	40,0	15,6	16,0	133,0	83,0	48,0
4,3	6,0	74,0	30,0	36,0	10,0	10,0	103,0	61,0	40,0	15,7	16,0	133,0	83,0	48,0
4,4	6,0	74,0	30,0	36,0	10,1	12,0	118,0	71,0	45,0	15,8	16,0	133,0	83,0	48,0
4,5	6,0	74,0	30,0	36,0	10,2	12,0	118,0	71,0	45,0	15,9	16,0	133,0	83,0	48,0
4,6	6,0	74,0	30,0	36,0	10,3	12,0	118,0	71,0	45,0	16,0	16,0	133,0	83,0	48,0
4,7	6,0	74,0	30,0	36,0	10,4	12,0	118,0	71,0	45,0	16,1	18,0	143,0	93,0	48,0
4,8	6,0	74,0	36,0	36,0	10,5	12,0	118,0	71,0	45,0	16,2	18,0	143,0	93,0	48,0
4,9	6,0	74,0	36,0	36,0	10,6	12,0	118,0	71,0	45,0	16,3	18,0	143,0	93,0	48,0
5,0	6,0	74,0	36,0	36,0	10,7	12,0	118,0	71,0	45,0	16,4	18,0	143,0	93,0	48,0
5,1	6,0	74,0	36,0	36,0	10,8	12,0	118,0	71,0	45,0	16,5	18,0	143,0	93,0	48,0
5,2	6,0	74,0	36,0	36,0	10,9	12,0	118,0	71,0	45,0	16,6	18,0	143,0	93,0	48,0
5,3	6,0	74,0	36,0	36,0	11,0	12,0	118,0	71,0	45,0	16,7	18,0	143,0	93,0	48,0
5,4	6,0	74,0	36,0	36,0	11,1	12,0	118,0	71,0	45,0	16,8	18,0	143,0	93,0	48,0
5,5	6,0	74,0	36,0	36,0	11,2	12,0	118,0	71,0	45,0	16,9	18,0	143,0	93,0	48,0
5,6	6,0	74,0	36,0	36,0	11,3	12,0	118,0	71,0	45,0	17,0	18,0	143,0	93,0	48,0
5,7	6,0	74,0	36,0	36,0	11,4	12,0	118,0	71,0	45,0	17,1	18,0	143,0	93,0	48,0
5,8	6,0	74,0	36,0	36,0	11,5	12,0	118,0	71,0	45,0	17,2	18,0	143,0	93,0	48,0
5,9	6,0	74,0	36,0	36,0	11,6	12,0	118,0	71,0	45,0	17,3	18,0	143,0	93,0	48,0
6,0	6,0	74,0	36,0	36,0	11,7	12,0	118,0	71,0	45,0	17,4	18,0	143,0	93,0	48,0
6,1	8,0	91,0	53,0	36,0	11,8	12,0	118,0	71,0	45,0	17,5	18,0	143,0	93,0	48,0
6,2	8,0	91,0	53,0	36,0	11,9	12,0	118,0	71,0	45,0	17,6	18,0	143,0	93,0	48,0
6,3	8,0	91,0	53,0	36,0	12,0	12,0	118,0	71,0	45,0	17,7	18,0	143,0	93,0	48,0
6,4	8,0	91,0	53,0	36,0	12,1	14,0	124,0	74,0	45,0	17,8	18,0	143,0	93,0	48,0
6,5	8,0	91,0	53,0	36,0	12,2	14,0	124,0	74,0	45,0	17,9	18,0	143,0	93,0	48,0
6,6	8,0	91,0	53,0	36,0	12,3	14,0	124,0	74,0	45,0	18,0	18,0	143,0	93,0	48,0
6,7	8,0	91,0	53,0	36,0	12,4	14,0	124,0	74,0	45,0	18,1	20,0	153,0	101,0	50,0
6,8	8,0	91,0	53,0	36,0	12,5	14,0	124,0	74,0	45,0	18,2	20,0	153,0	101,0	50,0
6,9	8,0	91,0	53,0	36,0	12,6	14,0	124,0	74,0	45,0	18,3	20,0	153,0	101,0	50,0
7,0	8,0	91,0	53,0	36,0	12,7	14,0	124,0	74,0	45,0	18,4	20,0	153,0	101,0	50,0
7,1	8,0	91,0	53,0	36,0	12,8	14,0	124,0	74,0	45,0	18,5	20,0	153,0	101,0	50,0
7,2	8,0	91,0	53,0	36,0	12,9	14,0	124,0	74,0	45,0	18,6	20,0	153,0	101,0	50,0
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7,4	8,0	91,0	53,0	36,0	13,1	14,0	124,0	74,0	45,0	18,8	20,0	153,0	101,0	50,0
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8,0	8,0	91,0	53,0	36,0	13,7	14,0	124,0	74,0	45,0	19,4	20,0	153,0	101,0	50,0
8,1	10,0	103,0	61,0	40,0	13,8	14,0	124,0	74,0	45,0	19,5	20,0	153,0	101,0	50,0
8,2	10,0	103,0	61,0	40,0	13,9	14,0	124,0	74,0	45,0	19,6	20,0	153,0	101,0	50,0
8,3	10,0	103,0	61,0	40,0	14,0	14,0	124,0	74,0	45,0	19,7	20,0	153,0	101,0	50,0
8,4	10,0	103,0	61,0	40,0	14,1	16,0	133,0	83,0	48,0	19,8	20,0	153,0	101,0	50,0
8,5	10,0	103,0	61,0	40,0	14,2	16,0	133,0	83,0	48,0	19,9	20,0	153,0	101,0	50,0
8,6	10,0	103,0	61,0	40,0	14,3	16,0	133,0	83,0	48,0	20,0	20,0	153,0	101,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1088-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6536

C1088-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

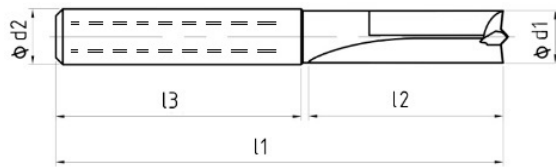
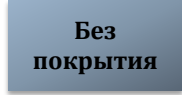
d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vс м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		410	9
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		410	9
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		380	9
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		330	9
	Латунь с короткой стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		280	9
	с длинной стружкой	2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600			
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		110	6
	2.0790 CuNi18Zn19Pb	≤850		80	5	

Сверла

Артикул	Серия
C1089	MG-KA
d1 = 3-20	

M METALLEKT



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	74,0	32,0	36,0
3,1	6,0	74,0	32,0	36,0
3,2	6,0	74,0	32,0	36,0
3,3	6,0	74,0	32,0	36,0
3,4	6,0	74,0	34,0	36,0
3,5	6,0	74,0	34,0	36,0
3,6	6,0	74,0	34,0	36,0
3,7	6,0	74,0	34,0	36,0
3,8	6,0	97,0	45,0	36,0
3,9	6,0	97,0	45,0	36,0
4,0	6,0	97,0	45,0	36,0
4,1	6,0	97,0	45,0	36,0
4,2	6,0	97,0	45,0	36,0
4,3	6,0	97,0	45,0	36,0
4,4	6,0	97,0	45,0	36,0
4,5	6,0	97,0	45,0	36,0
4,6	6,0	97,0	45,0	36,0
4,7	6,0	97,0	45,0	36,0
4,8	6,0	97,0	57,0	36,0
4,9	6,0	97,0	57,0	36,0
5,0	6,0	97,0	57,0	36,0
5,1	6,0	97,0	57,0	36,0
5,2	6,0	97,0	57,0	36,0
5,3	6,0	97,0	57,0	36,0
5,4	6,0	97,0	57,0	36,0
5,5	6,0	97,0	57,0	36,0
5,6	6,0	97,0	57,0	36,0
5,7	6,0	97,0	57,0	36,0
5,8	6,0	97,0	57,0	36,0
5,9	6,0	97,0	57,0	36,0
6,0	6,0	97,0	57,0	36,0
6,1	8,0	116,0	76,0	36,0
6,2	8,0	116,0	76,0	36,0
6,3	8,0	116,0	76,0	36,0
6,4	8,0	116,0	76,0	36,0
6,5	8,0	116,0	76,0	36,0
6,6	8,0	116,0	76,0	36,0
6,7	8,0	116,0	76,0	36,0
6,8	8,0	116,0	76,0	36,0
6,9	8,0	116,0	76,0	36,0
7,0	8,0	116,0	76,0	36,0
7,1	8,0	116,0	76,0	36,0
7,2	8,0	116,0	76,0	36,0
7,3	8,0	116,0	76,0	36,0
7,4	8,0	116,0	76,0	36,0
7,5	8,0	116,0	76,0	36,0
7,6	8,0	116,0	76,0	36,0
7,7	8,0	116,0	76,0	36,0
7,8	8,0	116,0	76,0	36,0
7,9	8,0	116,0	76,0	36,0
8,0	8,0	116,0	76,0	36,0
8,1	10,0	139,0	95,0	40,0
8,2	10,0	139,0	95,0	40,0
8,3	10,0	139,0	95,0	40,0
8,4	10,0	139,0	95,0	40,0
8,5	10,0	139,0	95,0	40,0
8,6	10,0	139,0	95,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	139,0	95,0	40,0
8,8	10,0	139,0	95,0	40,0
8,9	10,0	139,0	95,0	40,0
9,0	10,0	139,0	95,0	40,0
9,1	10,0	139,0	95,0	40,0
9,2	10,0	139,0	95,0	40,0
9,3	10,0	139,0	95,0	40,0
9,4	10,0	139,0	95,0	40,0
9,5	10,0	139,0	95,0	40,0
9,6	10,0	139,0	95,0	40,0
9,7	10,0	139,0	95,0	40,0
9,8	10,0	139,0	95,0	40,0
9,9	10,0	139,0	95,0	40,0
10,0	10,0	139,0	95,0	40,0
10,1	12,0	163,0	114,0	45,0
10,2	12,0	163,0	114,0	45,0
10,3	12,0	163,0	114,0	45,0
10,4	12,0	163,0	114,0	45,0
10,5	12,0	163,0	114,0	45,0
10,6	12,0	163,0	114,0	45,0
10,7	12,0	163,0	114,0	45,0
10,8	12,0	163,0	114,0	45,0
10,9	12,0	163,0	114,0	45,0
11,0	12,0	163,0	114,0	45,0
11,1	12,0	163,0	114,0	45,0
11,2	12,0	163,0	114,0	45,0
11,3	12,0	163,0	114,0	45,0
11,4	12,0	163,0	114,0	45,0
11,5	12,0	163,0	114,0	45,0
11,6	12,0	163,0	114,0	45,0
11,7	12,0	163,0	114,0	45,0
11,8	12,0	163,0	114,0	45,0
11,9	12,0	163,0	114,0	45,0
12,0	12,0	163,0	114,0	45,0
12,1	14,0	182,0	133,0	45,0
12,2	14,0	182,0	133,0	45,0
12,3	14,0	182,0	133,0	45,0
12,4	14,0	182,0	133,0	45,0
12,5	14,0	182,0	133,0	45,0
12,6	14,0	182,0	133,0	45,0
12,7	14,0	182,0	133,0	45,0
12,8	14,0	182,0	133,0	45,0
12,9	14,0	182,0	133,0	45,0
13,0	14,0	182,0	133,0	45,0
13,1	14,0	182,0	133,0	45,0
13,2	14,0	182,0	133,0	45,0
13,3	14,0	182,0	133,0	45,0
13,4	14,0	182,0	133,0	45,0
13,5	14,0	182,0	133,0	45,0
13,6	14,0	182,0	133,0	45,0
13,7	14,0	182,0	133,0	45,0
13,8	14,0	182,0	133,0	45,0
13,9	14,0	182,0	133,0	45,0
14,0	14,0	182,0	133,0	45,0
14,1	16,0	204,0	152,0	48,0
14,2	16,0	204,0	152,0	48,0
14,3	16,0	204,0	152,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	204,0	152,0	48,0
14,5	16,0	204,0	152,0	48,0
14,6	16,0	204,0	152,0	48,0
14,7	16,0	204,0	152,0	48,0
14,8	16,0	204,0	152,0	48,0
14,9	16,0	204,0	152,0	48,0
15,0	16,0	204,0	152,0	48,0
15,1	16,0	204,0	152,0	48,0
15,2	16,0	204,0	152,0	48,0
15,3	16,0	204,0	152,0	48,0
15,4	16,0	204,0	152,0	48,0
15,5	16,0	204,0	152,0	48,0
15,6	16,0	204,0	152,0	48,0
15,7	16,0	204,0	152,0	48,0
15,8	16,0	204,0	152,0	48,0
15,9	16,0	204,0	152,0	48,0
16,0	16,0	204,0	152,0	48,0
16,1	18,0	223,0	171,0	48,0
16,2	18,0	223,0	171,0	48,0
16,3	18,0	223,0	171,0	48,0
16,4	18,0	223,0	171,0	48,0
16,5	18,0	223,0	171,0	48,0
16,6	18,0	223,0	171,0	48,0
16,7	18,0	223,0	171,0	48,0
16,8	18,0	223,0	171,0	48,0
16,9	18,0	223,0	171,0	48,0
17,0	18,0	223,0	171,0	48,0
17,1	18,0	223,0	171,0	48,0
17,2	18,0	223,0	171,0	48,0
17,3	18,0	223,0	171,0	48,0
17,4	18,0	223,0	171,0	48,0
17,5	18,0	223,0	171,0	48,0
17,6	18,0	223,0	171,0	48,0
17,7	18,0	223,0	171,0	48,0
17,8	18,0	223,0	171,0	48,0
17,9	18,0	223,0	171,0	48,0
18,0	18,0	223,0	171,0	48,0
18,1	20,0	244,0	190,0	50,0
18,2	20,0	244,0	190,0	50,0
18,3	20,0	244,0	190,0	50,0
18,4	20,0	244,0	190,0	50,0
18,5	20,0	244,0	190,0	50,0
18,6	20,0	244,0	190,0	50,0
18,7	20,0	244,0	190,0	50,0
18,8	20,0	244,0	190,0	50,0
18,9	20,0	244,0	190,0	50,0
19,0	20,0	244,0	190,0	50,0
19,1	20,0	244,0	190,0	50,0
19,2	20,0	244,0	190,0	50,0
19,3	20,0	244,0	190,0	50,0
19,4	20,0	244,0	190,0	50,0
19,5	20,0	244,0	190,0	50,0
19,6	20,0	244,0	190,0	50,0
19,7	20,0	244,0	190,0	50,0
19,8	20,0	244,0	190,0	50,0
19,9	20,0	244,0	190,0	50,0
20,0	20,0	244,0	190,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1089-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6536

C1089-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

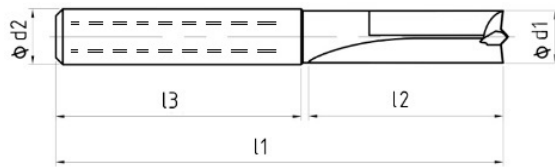
d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vс м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		410	8
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		410	8
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		380	8
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		330	8
	Латунь с короткой стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		280	7
	с длинной стружкой	2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600			
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		110	6
	2.0790 CuNi18Zn19Pb	≤850		80	5	

Сверла

Артикул	Серия
C1090	MG-KA
d1 = 3-20	

М METALLEKT



P	M	K	N	S	H
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Возможен заказ любых диаметров с ближайшими линейными параметрами большего табличного значения

d1 m7	d2 h6	l1	l2	l3
3,0	6,0	91,0	42,0	36,0
3,1	6,0	91,0	42,0	36,0
3,2	6,0	91,0	42,0	36,0
3,3	6,0	91,0	42,0	36,0
3,4	6,0	91,0	48,0	36,0
3,5	6,0	91,0	48,0	36,0
3,6	6,0	91,0	48,0	36,0
3,7	6,0	91,0	48,0	36,0
3,8	6,0	121,0	77,0	36,0
3,9	6,0	121,0	77,0	36,0
4,0	6,0	121,0	77,0	36,0
4,1	6,0	121,0	77,0	36,0
4,2	6,0	121,0	77,0	36,0
4,3	6,0	121,0	77,0	36,0
4,4	6,0	121,0	77,0	36,0
4,5	6,0	121,0	77,0	36,0
4,6	6,0	121,0	77,0	36,0
4,7	6,0	121,0	77,0	36,0
4,8	6,0	121,0	82,0	36,0
4,9	6,0	121,0	82,0	36,0
5,0	6,0	121,0	82,0	36,0
5,1	6,0	121,0	82,0	36,0
5,2	6,0	121,0	82,0	36,0
5,3	6,0	121,0	82,0	36,0
5,4	6,0	121,0	82,0	36,0
5,5	6,0	121,0	82,0	36,0
5,6	6,0	121,0	82,0	36,0
5,7	6,0	121,0	82,0	36,0
5,8	6,0	121,0	82,0	36,0
5,9	6,0	121,0	82,0	36,0
6,0	6,0	121,0	82,0	36,0
6,1	8,0	146,0	106,0	36,0
6,2	8,0	146,0	106,0	36,0
6,3	8,0	146,0	106,0	36,0
6,4	8,0	146,0	106,0	36,0
6,5	8,0	146,0	106,0	36,0
6,6	8,0	146,0	106,0	36,0
6,7	8,0	146,0	106,0	36,0
6,8	8,0	146,0	106,0	36,0
6,9	8,0	146,0	106,0	36,0
7,0	8,0	146,0	106,0	36,0
7,1	8,0	146,0	106,0	36,0
7,2	8,0	146,0	106,0	36,0
7,3	8,0	146,0	106,0	36,0
7,4	8,0	146,0	106,0	36,0
7,5	8,0	146,0	106,0	36,0
7,6	8,0	146,0	106,0	36,0
7,7	8,0	146,0	106,0	36,0
7,8	8,0	146,0	106,0	36,0
7,9	8,0	146,0	106,0	36,0
8,0	8,0	146,0	106,0	36,0
8,1	10,0	175,0	130,0	40,0
8,2	10,0	175,0	130,0	40,0
8,3	10,0	175,0	130,0	40,0
8,4	10,0	175,0	130,0	40,0
8,5	10,0	175,0	130,0	40,0
8,6	10,0	175,0	130,0	40,0

d1 m7	d2 h6	l1	l2	l3
8,7	10,0	175,0	130,0	40,0
8,8	10,0	175,0	130,0	40,0
8,9	10,0	175,0	130,0	40,0
9,0	10,0	175,0	130,0	40,0
9,1	10,0	175,0	130,0	40,0
9,2	10,0	175,0	130,0	40,0
9,3	10,0	175,0	130,0	40,0
9,4	10,0	175,0	130,0	40,0
9,5	10,0	175,0	130,0	40,0
9,6	10,0	175,0	130,0	40,0
9,7	10,0	175,0	130,0	40,0
9,8	10,0	175,0	130,0	40,0
9,9	10,0	175,0	130,0	40,0
10,0	10,0	175,0	130,0	40,0
10,1	12,0	209,0	159,0	45,0
10,2	12,0	209,0	159,0	45,0
10,3	12,0	209,0	159,0	45,0
10,4	12,0	209,0	159,0	45,0
10,5	12,0	209,0	159,0	45,0
10,6	12,0	209,0	159,0	45,0
10,7	12,0	209,0	159,0	45,0
10,8	12,0	209,0	159,0	45,0
10,9	12,0	209,0	159,0	45,0
11,0	12,0	209,0	159,0	45,0
11,1	12,0	209,0	159,0	45,0
11,2	12,0	209,0	159,0	45,0
11,3	12,0	209,0	159,0	45,0
11,4	12,0	209,0	159,0	45,0
11,5	12,0	209,0	159,0	45,0
11,6	12,0	209,0	159,0	45,0
11,7	12,0	209,0	159,0	45,0
11,8	12,0	209,0	159,0	45,0
11,9	12,0	209,0	159,0	45,0
12,0	12,0	209,0	159,0	45,0
12,1	14,0	233,0	183,0	45,0
12,2	14,0	233,0	183,0	45,0
12,3	14,0	233,0	183,0	45,0
12,4	14,0	233,0	183,0	45,0
12,5	14,0	233,0	183,0	45,0
12,6	14,0	233,0	183,0	45,0
12,7	14,0	233,0	183,0	45,0
12,8	14,0	233,0	183,0	45,0
12,9	14,0	233,0	183,0	45,0
13,0	14,0	233,0	183,0	45,0
13,1	14,0	233,0	183,0	45,0
13,2	14,0	233,0	183,0	45,0
13,3	14,0	233,0	183,0	45,0
13,4	14,0	233,0	183,0	45,0
13,5	14,0	233,0	183,0	45,0
13,6	14,0	233,0	183,0	45,0
13,7	14,0	233,0	183,0	45,0
13,8	14,0	233,0	183,0	45,0
13,9	14,0	233,0	183,0	45,0
14,0	14,0	233,0	183,0	45,0
14,1	16,0	260,0	207,0	48,0
14,2	16,0	260,0	207,0	48,0
14,3	16,0	260,0	207,0	48,0

d1 m7	d2 h6	l1	l2	l3
14,4	16,0	260,0	207,0	48,0
14,5	16,0	260,0	207,0	48,0
14,6	16,0	260,0	207,0	48,0
14,7	16,0	260,0	207,0	48,0
14,8	16,0	260,0	207,0	48,0
14,9	16,0	260,0	207,0	48,0
15,0	16,0	260,0	207,0	48,0
15,1	16,0	260,0	207,0	48,0
15,2	16,0	260,0	207,0	48,0
15,3	16,0	260,0	207,0	48,0
15,4	16,0	260,0	207,0	48,0
15,5	16,0	260,0	207,0	48,0
15,6	16,0	260,0	207,0	48,0
15,7	16,0	260,0	207,0	48,0
15,8	16,0	260,0	207,0	48,0
15,9	16,0	260,0	207,0	48,0
16,0	16,0	260,0	207,0	48,0
16,1	18,0	284,0	231,0	48,0
16,2	18,0	284,0	231,0	48,0
16,3	18,0	284,0	231,0	48,0
16,4	18,0	284,0	231,0	48,0
16,5	18,0	284,0	231,0	48,0
16,6	18,0	284,0	231,0	48,0
16,7	18,0	284,0	231,0	48,0
16,8	18,0	284,0	231,0	48,0
16,9	18,0	284,0	231,0	48,0
17,0	18,0	284,0	231,0	48,0
17,1	18,0	284,0	231,0	48,0
17,2	18,0	284,0	231,0	48,0
17,3	18,0	284,0	231,0	48,0
17,4	18,0	284,0	231,0	48,0
17,5	18,0	284,0	231,0	48,0
17,6	18,0	284,0	231,0	48,0
17,7	18,0	284,0	231,0	48,0
17,8	18,0	284,0	231,0	48,0
17,9	18,0	284,0	231,0	48,0
18,0	18,0	284,0	231,0	48,0
18,1	20,0	308,0	255,0	50,0
18,2	20,0	308,0	255,0	50,0
18,3	20,0	308,0	255,0	50,0
18,4	20,0	308,0	255,0	50,0
18,5	20,0	308,0	255,0	50,0
18,6	20,0	308,0	255,0	50,0
18,7	20,0	308,0	255,0	50,0
18,8	20,0	308,0	255,0	50,0
18,9	20,0	308,0	255,0	50,0
19,0	20,0	308,0	255,0	50,0
19,1	20,0	308,0	255,0	50,0
19,2	20,0	308,0	255,0	50,0
19,3	20,0	308,0	255,0	50,0
19,4	20,0	308,0	255,0	50,0
19,5	20,0	308,0	255,0	50,0
19,6	20,0	308,0	255,0	50,0
19,7	20,0	308,0	255,0	50,0
19,8	20,0	308,0	255,0	50,0
19,9	20,0	308,0	255,0	50,0
20,0	20,0	308,0	255,0	50,0

При заказе указывать: артикул, диаметр d1, тип хвостовика.

Пример: C1090-10,0-НА - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика НА по DIN 6536
 C1090-10,0-HE - сверло диаметром 10,0 с внутренними каналами охлаждения, форма хвостовика HE по DIN 6536

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	F₀ (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vс м/мин	Подача (№ в табл.)
			Н/мм ²			
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		410	6
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		410	6
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		380	6
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		330	6
	Латунь с короткой стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		280	7
	с длинной стружкой	2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600			
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		110	6
	2.0790 CuNi18Zn19Pb	≤850		80	5	

Сверла

Артикул	Серия
1077	MCN

d1 = 3-25

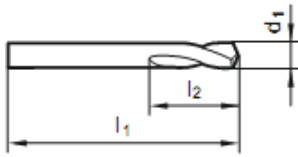
М METALLEKT

h6



Без покрытия

d1 h6	l1	l2
3,0	46,0	12,0
4,0	55,0	12,0
5,0	62,0	14,0
6,0	66,0	16,0
7,0	70,0	17,0
8,0	79,0	21,0
9,0	84,0	22,0
10,0	89,0	25,0
12,0	102,0	30,0
13,0	102,0	32,0
14,0	107,0	34,0
16,0	115,0	38,0
18,0	127,0	40,0
20,0	131,0	45,0
25,0	151,0	53,0



P	M	K	N	S	H
•	•	•	•	•	•

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	Fo (мм/об.)								
3	0,008	0,017	0,025	0,033	0,042	0,05	0,058	0,067	0,075
4	0,013	0,027	0,04	0,053	0,067	0,08	0,093	0,11	0,12
5	0,017	0,033	0,05	0,067	0,083	0,1	0,12	0,13	0,15
6	0,018	0,037	0,055	0,073	0,091	0,11	0,13	0,15	0,16
8	0,021	0,042	0,063	0,084	0,11	0,13	0,15	0,17	0,19
10	0,024	0,047	0,071	0,094	0,12	0,14	0,16	0,19	0,21
12	0,026	0,052	0,077	0,1	0,13	0,15	0,18	0,21	0,23
16	0,029	0,058	0,087	0,12	0,14	0,17	0,2	0,23	0,26
20	0,033	0,067	0,1	0,13	0,17	0,2	0,23	0,27	0,3
25	0,037	0,075	0,11	0,15	0,19	0,22	0,26	0,3	0,34

При заказе указывать: артикул, диаметр d1.

Пример: 1077-10,0 - центровочное сверло диаметром 10,0 без внутренних каналов охлаждения

Сверла

Артикул	Серия
1078	MCN

d1 = 3-25

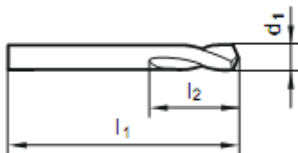
М METALLEKT

h6



Без покрытия

d1 h6	l1	l2
3,0	46,0	12,0
4,0	55,0	12,0
5,0	62,0	14,0
6,0	66,0	16,0
7,0	70,0	17,0
8,0	79,0	21,0
9,0	84,0	22,0
10,0	89,0	25,0
12,0	102,0	30,0
13,0	102,0	32,0
14,0	107,0	34,0
16,0	115,0	38,0
18,0	127,0	40,0
20,0	131,0	45,0
25,0	151,0	53,0



P	M	K	N	S	H
•	•	•	•	•	•

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	Fo (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5
16	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63
20	0,125	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,63
25	0,16	0,2	0,25	0,315	0,4	0,5	0,63	0,8	0,8

При заказе указывать: артикул, диаметр d1.

Пример: 1078-10,0 - центровочное сверло диаметром 10,0 без внутренних каналов охлаждения

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин		Подача (№ в табл.)		
			Н/мм ²		1077	1078	1077	1078	
P	Углеродистые стали общего назначения	1.0035 S185 (St33), 1.0486 P275N (StE285), 1.0345 P235GH (H1), 1.0425 P265GH (H2) 1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		104 91		5 5		
	Автоматные стали (повыш.обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		104 91		6 5		
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		104 91 78		5 5 5		
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤1400		78		5		
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		104		6		
	Легированные цементированные стали	1.7276 10CrMo11, 1.5125 11MnSi6 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1000 ≤1400		78		5		
	Азотированные стали	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤850 ≤1400		65		5		
	Инструментальные стали	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤1400		65		4		
	Рессорно-пружинные	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	32		3		
	M	Нерж. стали, с сод. Серы аустенитные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9 1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi17-12-2 (V4A)	≤900 ≤1100		32 32		5 4	
		мартенситные	1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		32		4	
		Закаленные стали	-		≤48 HRC ≤66 HRC	26		4	
	S	Специальные сплавы	Нимоник, инконель, монель, хастеллой	≤2000		20		3	
	K	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤240 HB ≤350 HB	117 104		5 5	
Высокопрочный и ковкий чугун		0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35) 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤240 HB ≤350 HB	91 104		5 5		
Титан и титановые сплавы		3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤850 ≤1400		26 20		4 3		
N	Алюминий и сплавы	3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		260		8		
	Деформир. ал. Сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		260		8		
	Лит. ал. сплавы ≤ 10% Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		195		7		
	> 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		156		7		
	Магниеые сплавы	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		234		6		
	Медь, низколегир.	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		104		6		
	Латунь с короткой струж с длинной стружкой	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600 ≤600		234 234		6 6		
	Бронза, с короткой стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 ≤850		156 156		6 6		
	Бронза, с длинной стружкой	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		91 65		5 4		
	Пласт, терморреактивные термопластичные	Бакелит, Ресопал, Пертинакс, Молтопрен	≤150		65		5		
	армированные	Флексигласс, Хостален, Новодур, Макралон	≤100		52		4		
	армированные	Кевлар	≤1000						
	стекло- и углепластики	GFK/CFK	≤1000		104		4		

Сверла

Артикул	Серия
1079	MCN

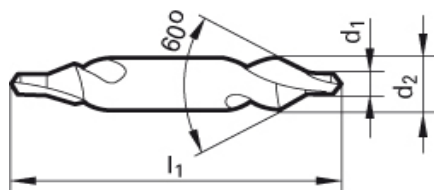
d1 = 1-12,5

K12



Без покрытия

М МЕТАЛЛЕКТ



P	M	K	N	S	H
•	•	•	•	•	•

d1 k12	d2 h6	l1
1,0	3,15	35,0
1,25	3,15	35,0
1,6	4,0	35,0
2,0	5,0	40,0
2,5	6,0	45,0
3,15	8,0	50,0
4,0	10,0	56,0
5,0	12,5	63,0
6,3	16,0	71,0
8,0	20,0	80,0
10,0	25,0	100,0
12,5	31,5	125,0

d1 mm	Подача (№ в табл.)								
	1	2	3	4	5	6	7	8	9
	Fo (мм/об.)								
3	0,032	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,16
4	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,2
5	0,04	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25
6	0,05	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315
8	0,063	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,315
10	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,4
12	0,08	0,1	0,125	0,16	0,2	0,25	0,315	0,4	0,5

При заказе указывать: артикул, диаметр d1.

Пример: 1079-10,0 - центровочное сверло диаметром 10,0 без внутренних каналов охлаждения

	Группа материалов	Примеры материалов жирным шрифтом выделено обозначение по DIN EN	Предел прочности	Твёрд.	Vc м/мин	Подача (№ в табл.)
			Н/мм ²			
P	Углеродистые стали общего назначения	1.0035 S185 (St33), 1.0486 P275N (StE285), 1.0345 P235GH (H1), 1.0425 P265GH (H2)	≤500		104	5
		1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤1000		91	5
	Автоматные стали (повыш.обраб.резанием)	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36)	≤850		104	6
		1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤1000		91	5
	Углеродистые улучшенные стали	1.0402 C22, 1.1178 C30E (Ck30)	≤700		104	5
		1.0503 C45, 1.1191 C45E (Ck45)	≤850		91	5
		1.0601 C60, 1.1221 C60E (Ck60)	≤1000		78	5
	Легированные улучшенные стали	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4	≤1000		78	5
		1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1400			
	Углер. цементиров. стали	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		104	6
		1.7276 10CrMo11, 1.5125 11MnSi6	≤1000		78	5
	Легированные цементированные стали	1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1400			
		1.8504 34CrAl6	≤850		65	5
	Азотированные стали	1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1400			
1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9		≤850		65	4	
Инструментальные стали	1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤1400				
	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	32	3	
M	Нерж. стали, с сод. Серы аустенитные мартенситные	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		32	5
		1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi17-12-2 (V4A)	≤1100		32	4
		1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		32	4
H	Закаленные стали	-		≤48 HRC	26	4
				≤66 HRC		
S	Специальные сплавы	Нимоник, инконель, монель, хастеллой	≤2000		20	3
K	Серый чугун	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20)		≤240 HB	117	5
		0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤350 HB	104	5
		0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35)		≤240 HB	91	5
S	Высокопрочный и ковкий чугун	0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤350 HB	104	5
		3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2	≤850		26	4
N	Титан и титановые сплавы	3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		20	3
		3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		260	8
	Алюминий и сплавы	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	≤650		260	8
		3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9	≤600		195	7
	Лит. ал. сплавы ≤ 10% Si > 10% Si	3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		156	7
		3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		234	6
	Магниеые сплавы	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		104	6
	Медь, низколегир.	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2	≤600		234	6
		2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5	≤600		234	6
	Латунь с короткой струж с длинной стружкой	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn	≤600		156	6
		2.0790 CuNi18Zn19Pb	≤850		156	6
	Бронза, с короткой стружкой	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10	≤850		91	5
		2.0980 CuAl11Ni, 2.1247 CuBe2	≤1000		65	4
	Бронза, с длинной стружкой	Бакелит, Ресопал, Пертинакс, Молтопрен	≤150		65	5
		Флексигласс, Хостален, Новодур, Макралон	≤100		52	4
	Пласт, терморреактивные термомластичные	Кевлар	≤1000			
	армированные	GFK/CFK	≤1000		104	4
	стекло- и углепластики					