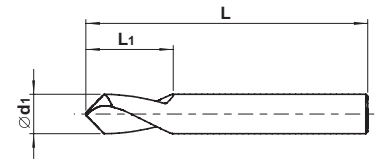




**UMT 8101**  
NC center drills



nano  
TEC1

d1 (h7)	L1	L	Stock	ART No
3	9	38	●	81010300038-1
4	10	50	●	81010400050-1
5	13	50	●	81010500050-1
6	13	57	●	81010600057-1
8	20	63	●	81010800063-1
10	22	72	●	81011000072-1
12	22	83	●	81011200083-1

● In stock

Recommended cutting conditions for drills 8101

Work material	Cutting speed V <sub>c</sub> (m/min)	d1 - diameter in mm						f - feed per revolution in mm/rev.	
		ø3 - ø4	ø4 - ø5	ø5 - ø6	ø6 - ø8	ø8 - ø10	ø10 - ø12		
	nanoTEC1								
<b>P</b> Carbon steel and Alloy steel < 25 HRC	50-70	0.05-0.08	0.06-0.10	0.08-0.12	0.09-0.14	0.12-0.20	0.16-0.26		
Alloy steel and Tool steel 25-45 HRC	30-50	0.04-0.07	0.05-0.09	0.07-0.11	0.07-0.12	0.10-0.16	0.13-0.20		
<b>M</b> Stainless steel	30-40	0.03-0.07	0.04-0.09	0.06-0.11	0.06-0.12	0.09-0.12	0.12-0.18		
<b>K</b> Cast iron GG	60-80	0.04-0.07	0.05-0.09	0.07-0.11	0.07-0.12	0.10-0.16	0.13-0.20		
Nodular cast iron GGG	40-60	0.03-0.07	0.04-0.09	0.06-0.11	0.06-0.12	0.09-0.12	0.12-0.18		
<b>N</b> Aluminium alloy	100-140	0.06-0.10	0.08-0.12	0.09-0.14	0.10-0.18	0.14-0.26	0.18-0.32		
Copper alloy	70-100	0.06-0.09	0.08-0.11	0.09-0.13	0.10-0.16	0.12-0.20	0.15-0.26		
<b>S</b> Titanium alloy	20-30	0.017-0.04	0.027-0.05	0.033-0.055	0.037-0.063	0.042-0.07	0.047-0.08		