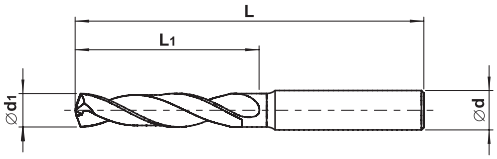
UMT 8211

Twist drills with reinforced shank

DIN 6537K | 140° | 3×d



nanoTEC1

d1 (m7)	L1	d (h6)	L	Stock	ART No
3.0	20	6	62	●	82110300062-1
3.1	20	6	62	○	82110310062-1
3.2	20	6	62	○	82110320062-1
3.3	20	6	62	●	82110330062-1
3.4	20	6	62	○	82110340062-1
3.5	20	6	62	●	82110350062-1
3.6	20	6	62	○	82110360062-1
3.7	20	6	62	●	82110370062-1
3.8	24	6	66	○	82110380066-1
3.9	24	6	66	○	82110390066-1
4.0	24	6	66	●	82110400066-1
4.1	24	6	66	○	82110410066-1
4.2	24	6	66	●	82110420066-1
4.3	24	6	66	○	82110430066-1
4.4	24	6	66	○	82110440066-1
4.5	24	6	66	●	82110450066-1
4.6	24	6	66	●	82110460066-1
4.7	24	6	66	○	82110470066-1
4.8	28	6	66	○	82110480066-1
4.9	28	6	66	○	82110490066-1
5.0	28	6	66	●	82110500066-1
5.1	28	6	66	○	82110510066-1
5.2	28	6	66	●	82110520066-1
5.3	28	6	66	○	82110530066-1
5.4	28	6	66	○	82110540066-1
5.5	28	6	66	○	82110550066-1
5.6	28	6	66	●	82110560066-1
5.7	28	6	66	○	82110570066-1
5.8	28	6	66	○	82110580066-1
5.9	28	6	66	○	82110590066-1
6.0	28	6	66	●	82110600066-1
6.1	34	8	79	○	82110610079-1
6.2	34	8	79	○	82110620079-1
6.3	34	8	79	○	82110630079-1
6.4	34	8	79	○	82110640079-1
6.5	34	8	79	○	82110650079-1
6.6	34	8	79	○	82110660079-1
6.7	34	8	79	○	82110670079-1
6.8	34	8	79	●	82110680079-1
6.9	34	8	79	○	82110690079-1
7.0	34	8	79	○	82110700079-1
7.1	41	8	79	○	82110710079-1
7.2	41	8	79	○	82110720079-1
7.3	41	8	79	○	82110730079-1

nanoTEC1

d1 (m7)	L1	d (h6)	L	Stock	ART No
7.4	41	8	79	●	82110740079-1
7.5	41	8	79	○	82110750079-1
7.6	41	8	79	○	82110760079-1
7.7	41	8	79	○	82110770079-1
7.8	41	8	79	●	82110780079-1
7.9	41	8	79	○	82110790079-1
8.0	41	8	79	●	82110800079-1
8.1	47	10	89	○	82110810089-1
8.2	47	10	89	○	82110820089-1
8.3	47	10	89	○	82110830089-1
8.4	47	10	89	○	82110840089-1
8.5	47	10	89	●	82110850089-1
8.6	47	10	89	○	82110860089-1
8.7	47	10	89	○	82110870089-1
8.8	47	10	89	●	82110880089-1
8.9	47	10	89	○	82110890089-1
9.0	47	10	89	●	82110900089-1
9.1	47	10	89	○	82110910089-1
9.2	47	10	89	○	82110920089-1
9.3	47	10	89	●	82110930089-1
9.4	47	10	89	○	82110940089-1
9.5	47	10	89	●	82110950089-1
9.6	47	10	89	○	82110960089-1
9.7	47	10	89	○	82110970089-1
9.8	47	10	89	○	82110980089-1
9.9	47	10	89	○	82110990089-1
10.0	47	10	89	●	82111000089-1
10.2	55	12	102	●	82111020102-1
10.3	55	12	102	○	82111030102-1
10.5	55	12	102	●	82111050102-1
10.8	55	12	102	●	82111080102-1
11.0	55	12	102	●	82111100102-1
11.2	55	12	102	●	82111120102-1
11.5	55	12	102	○	82111150102-1
12.0	55	12	102	●	82111200102-1
12.4	60	14	107	○	82111240107-1
12.5	60	14	107	●	82111250107-1
12.7	60	14	107	○	82111270107-1
13.0	60	14	107	●	82111300107-1
13.5	60	14	107	○	82111350107-1
14.0	60	14	107	●	82111400107-1
14.5	65	16	115	●	82111450115-1
16.0	65	16	115	●	82111600115-1

● In stock

○ Produced to order only

Recommended cutting conditions for drills 8211

Work material		Cutting speed V_c (m/min)	d1 - diameter in mm			f - feed per revolution in mm/rev.		
		nanoTEC1	∅3 - ∅6	∅6 - ∅8	∅8 - ∅10	∅10 - ∅12	∅12 - ∅14	∅14 - ∅16
P	Carbon steel and Alloy steel < 25 HRC	80-110	0.08-0.15	0.14-0.20	0.15-0.20	0.18-0.25	0.20-0.28	0.22-0.30
P	Alloy steel and Tool steel 25-45 HRC	60-90	0.07-0.14	0.12-0.18	0.14-0.19	0.16-0.23	0.18-0.26	0.20-0.28
K	Cast iron GG	90-130	0.10-0.18	0.17-0.24	0.20-0.30	0.22-0.35	0.26-0.40	0.28-0.42
K	Nodular cast iron GGG	60-90	0.08-0.16	0.15-0.22	0.18-0.26	0.20-0.30	0.22-0.35	0.24-0.38
N	Aluminium alloy	130-160	0.10-0.16	0.16-0.22	0.20-0.26	0.22-0.28	0.24-0.30	0.28-0.36