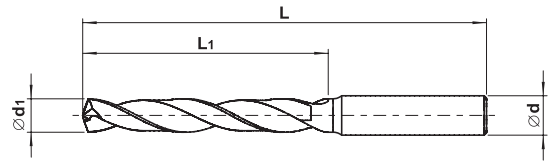


UMT 8221

Twist drills with reinforced shank



nano
TEC1

d1 (m7)	L1	d (h6)	L	Stock	ART No
3.0	28	6	66	●	82210300066-1
3.1	28	6	66	○	82210310066-1
3.2	28	6	66	○	82210320066-1
3.3	28	6	66	●	82210330066-1
3.4	28	6	66	○	82210340066-1
3.5	28	6	66	●	82210350066-1
3.6	28	6	66	○	82210360066-1
3.7	28	6	66	●	82210370066-1
3.8	36	6	74	○	82210380074-1
3.9	36	6	74	○	82210390074-1
4.0	36	6	74	●	82210400074-1
4.1	36	6	74	○	82210410074-1
4.2	36	6	74	●	82210420074-1
4.3	36	6	74	○	82210430074-1
4.4	36	6	74	○	82210440074-1
4.5	36	6	74	●	82210450074-1
4.6	36	6	74	●	82210460074-1
4.7	36	6	74	○	82210470074-1
4.8	44	6	82	○	82210480082-1
4.9	44	6	82	○	82210490082-1
5.0	44	6	82	●	82210500082-1
5.1	44	6	82	○	82210510082-1
5.2	44	6	82	●	82210520082-1
5.3	44	6	82	○	82210530082-1
5.4	44	6	82	○	82210540082-1
5.5	44	6	82	○	82210550082-1
5.6	44	6	82	●	82210560082-1
5.7	44	6	82	○	82210570082-1
5.8	44	6	82	○	82210580082-1
5.9	44	6	82	○	82210590082-1
6.0	44	6	82	●	82210600082-1
6.1	53	8	91	○	82210610091-1
6.2	53	8	91	○	82210620091-1
6.3	53	8	91	○	82210630091-1
6.4	53	8	91	○	82210640091-1
6.5	53	8	91	○	82210650091-1
6.6	53	8	91	○	82210660091-1
6.7	53	8	91	○	82210670091-1
6.8	53	8	91	●	82210680091-1
6.9	53	8	91	○	82210690091-1
7.0	53	8	91	○	82210700091-1
7.1	53	8	91	○	82210710091-1
7.2	53	8	91	○	82210720091-1
7.3	53	8	91	○	82210730091-1

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TEC1

d1 (m7)	L1	d (h6)	L	Stock	ART No
7.4	53	8	91	●	82210740091-1
7.5	53	8	91	○	82210750091-1
7.6	53	8	91	○	82210760091-1
7.7	53	8	91	○	82210770091-1
7.8	53	8	91	●	82210780091-1
7.9	53	8	91	○	82210790091-1
8.0	53	8	91	●	82210800091-1
8.1	61	10	103	○	82210810103-1
8.2	61	10	103	○	82210820103-1
8.3	61	10	103	○	82210830103-1
8.4	61	10	103	○	82210840103-1
8.5	61	10	103	●	82210850103-1
8.6	61	10	103	○	82210860103-1
8.7	61	10	103	○	82210870103-1
8.8	61	10	103	●	82210880103-1
8.9	61	10	103	○	82210890103-1
9.0	61	10	103	●	82210900103-1
9.1	61	10	103	○	82210910103-1
9.2	61	10	103	○	82210920103-1
9.3	61	10	103	●	82210930103-1
9.4	61	10	103	○	82210940103-1
9.5	61	10	103	○	82210950103-1
9.6	61	10	103	○	82210960103-1
9.7	61	10	103	○	82210970103-1
9.8	61	10	103	○	82210980103-1
9.9	61	10	103	○	82210990103-1
10.0	61	10	103	●	82211000103-1
10.2	71	12	118	●	82211020118-1
10.5	71	12	118	●	82211050118-1
10.8	71	12	118	●	82211080118-1
11.0	71	12	118	●	82211100118-1
11.2	71	12	118	●	82211120118-1
12.0	71	12	118	●	82211200118-1
12.5	77	14	124	●	82211250124-1
13.0	77	14	124	●	82211300124-1
14.0	77	14	124	●	82211400124-1
14.5	83	16	133	●	82211450133-1
16.0	83	16	133	●	82211600133-1

- In stock
- Produced to order only

Recommended cutting conditions for drills 8221

Work material	Cutting speed Vc (m/min)	d1 - diameter in mm				f - feed per revolution in mm/rev.	
		Ø3 - Ø6	Ø6 - Ø8	Ø8 - Ø10	Ø10 - Ø12	Ø12 - Ø14	Ø14 - Ø16
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
	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
	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