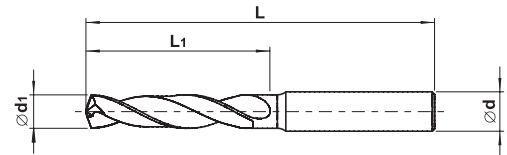


UMT 8311

Twist drills with reinforced shank for difficult to cut materials

DIN 6537K



nano
TEC2

d1 (m7)	L1	d (h6)	L	Stock	ART No
3.0	20	6	62	o	83110300062-2
3.1	20	6	62	o	83110310062-2
3.2	20	6	62	o	83110320062-2
3.3	20	6	62	o	83110330062-2
3.4	20	6	62	o	83110340062-2
3.5	20	6	62	o	83110350062-2
3.6	20	6	62	o	83110360062-2
3.7	20	6	62	o	83110370062-2
3.8	24	6	66	o	83110380066-2
3.9	24	6	66	o	83110390066-2
4.0	24	6	66	o	83110400066-2
4.1	24	6	66	o	83110410066-2
4.2	24	6	66	o	83110420066-2
4.3	24	6	66	o	83110430066-2
4.4	24	6	66	o	83110440066-2
4.5	24	6	66	o	83110450066-2
4.6	24	6	66	o	83110460066-2
4.7	24	6	66	o	83110470066-2
4.8	28	6	66	o	83110480066-2
4.9	28	6	66	o	83110490066-2
5.0	28	6	66	o	83110500066-2
5.1	28	6	66	o	83110510066-2
5.2	28	6	66	o	83110520066-2
5.3	28	6	66	o	83110530066-2
5.4	28	6	66	o	83110540066-2
5.5	28	6	66	o	83110550066-2
5.6	28	6	66	o	83110560066-2
5.7	28	6	66	o	83110570066-2
5.8	28	6	66	o	83110580066-2
5.9	28	6	66	o	83110590066-2
6.0	28	6	66	o	83110600066-2
6.1	34	8	79	o	83110610079-2
6.2	34	8	79	o	83110620079-2
6.3	34	8	79	o	83110630079-2
6.4	34	8	79	o	83110640079-2
6.5	34	8	79	o	83110650079-2
6.6	34	8	79	o	83110660079-2
6.7	34	8	79	o	83110670079-2
6.8	34	8	79	o	83110680079-2
6.9	34	8	79	o	83110690079-2
7.0	34	8	79	o	83110700079-2
7.1	41	8	79	o	83110710079-2
7.2	41	8	79	o	83110720079-2
7.3	41	8	79	o	83110730079-2

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d1 (m7)	L1	d (h6)	L	Stock	ART No
7.4	41	8	79	o	83110740079-2
7.5	41	8	79	o	83110750079-2
7.6	41	8	79	o	83110760079-2
7.7	41	8	79	o	83110770079-2
7.8	41	8	79	o	83110780079-2
7.9	41	8	79	o	83110790079-2
8.0	41	8	79	o	83110800079-2
8.1	47	10	89	o	83110810089-2
8.2	47	10	89	o	83110820089-2
8.3	47	10	89	o	83110830089-2
8.4	47	10	89	o	83110840089-2
8.5	47	10	89	o	83110850089-2
8.6	47	10	89	o	83110860089-2
8.7	47	10	89	o	83110870089-2
8.8	47	10	89	o	83110880089-2
8.9	47	10	89	o	83110890089-2
9.0	47	10	89	o	83110900089-2
9.1	47	10	89	o	83110910089-2
9.2	47	10	89	o	83110920089-2
9.3	47	10	89	o	83110930089-2
9.4	47	10	89	o	83110940089-2
9.5	47	10	89	o	83110950089-2
9.6	47	10	89	o	83110960089-2
9.7	47	10	89	o	83110970089-2
9.8	47	10	89	o	83110980089-2
9.9	47	10	89	o	83110990089-2
10.0	47	10	89	o	83111000089-2
10.2	55	12	102	o	83111020102-2
10.3	55	12	102	o	83111030102-2
10.5	55	12	102	o	83111050102-2
10.8	55	12	102	o	83111080102-2
11.0	55	12	102	o	83111100102-2
11.2	55	12	102	o	83111120102-2
11.5	55	12	102	o	83111150102-2
12.0	55	12	102	o	83111200102-2
12.4	60	14	107	o	83111240107-2
12.5	60	14	107	o	83111250107-2
12.7	60	14	107	o	83111270107-2
13.0	60	14	107	o	83111300107-2
13.5	60	14	107	o	83111350107-2
14.0	60	14	107	o	83111400107-2
14.5	65	16	115	o	83111450115-2
16.0	65	16	115	o	83111600115-2

o Produced to order only

Recommended cutting conditions for drills 8311

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
	nanoTEC2						
M Stainless steel Low alloy austenitic	30-50	0.04-0.10	0.08-0.12	0.09-0.14	0.12-0.20	0.16-0.22	0.18-0.24
Stainless steel High alloy austenitic	25-45	0.04-0.10	0.08-0.12	0.09-0.14	0.12-0.20	0.16-0.22	0.18-0.24
S Titanium alloy	25-40	0.033-0.07	0.07-0.10	0.084-0.12	0.094-0.13	0.10-0.14	0.12-0.14
Titanium	25-40	0.033-0.07	0.07-0.10	0.084-0.12	0.094-0.13	0.10-0.14	0.12-0.14
Heat resistant alloy	15-25	0.025-0.055	0.055-0.084	0.063-0.094	0.07-0.10	0.08-0.12	0.09-0.13