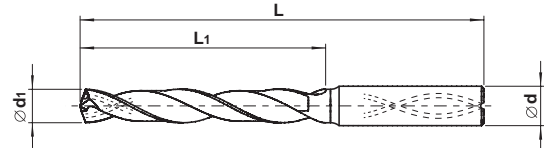


UMT 8322

Twist drills with reinforced shank and internal cooling for difficult to cut materials

DIN 6537L



nano TEC2

d1 (m7)	L1	d (h6)	L	Stock	ART No
3.0	28	6	66	●	83220300066-2
3.1	28	6	66	○	83220310066-2
3.2	28	6	66	○	83220320066-2
3.3	28	6	66	●	83220330066-2
3.4	28	6	66	○	83220340066-2
3.5	28	6	66	●	83220350066-2
3.6	28	6	66	○	83220360066-2
3.7	28	6	66	●	83220370066-2
3.8	36	6	74	○	83220380074-2
3.9	36	6	74	○	83220390074-2
4.0	36	6	74	●	83220400074-2
4.1	36	6	74	○	83220410074-2
4.2	36	6	74	●	83220420074-2
4.3	36	6	74	○	83220430074-2
4.4	36	6	74	○	83220440074-2
4.5	36	6	74	●	83220450074-2
4.6	36	6	74	●	83220460074-2
4.7	36	6	74	○	83220470074-2
4.8	44	6	82	○	83220480082-2
4.9	44	6	82	○	83220490082-2
5.0	44	6	82	●	83220500082-2
5.1	44	6	82	○	83220510082-2
5.2	44	6	82	●	83220520082-2
5.3	44	6	82	○	83220530082-2
5.4	44	6	82	○	83220540082-2
5.5	44	6	82	○	83220550082-2
5.6	44	6	82	●	83220560082-2
5.7	44	6	82	○	83220570082-2
5.8	44	6	82	○	83220580082-2
5.9	44	6	82	○	83220590082-2
6.0	44	6	82	●	83220600082-2
6.1	53	8	91	○	83220610091-2
6.2	53	8	91	○	83220620091-2
6.3	53	8	91	○	83220630091-2
6.4	53	8	91	○	83220640091-2
6.5	53	8	91	○	83220650091-2
6.6	53	8	91	○	83220660091-2
6.7	53	8	91	○	83220670091-2
6.8	53	8	91	●	83220680091-2
6.9	53	8	91	○	83220690091-2
7.0	53	8	91	○	83220700091-2
7.1	53	8	91	○	83220710091-2
7.2	53	8	91	○	83220720091-2
7.3	53	8	91	○	83220730091-2

nano TEC2

d1 (m7)	L1	d (h6)	L	Stock	ART No
7.4	53	8	91	●	83220740091-2
7.5	53	8	91	○	83220750091-2
7.6	53	8	91	○	83220760091-2
7.7	53	8	91	○	83220770091-2
7.8	53	8	91	●	83220780091-2
7.9	53	8	91	○	83220790091-2
8.0	53	8	91	●	83220800091-2
8.1	61	10	103	○	83220810103-2
8.2	61	10	103	○	83220820103-2
8.3	61	10	103	○	83220830103-2
8.4	61	10	103	○	83220840103-2
8.5	61	10	103	●	83220850103-2
8.6	61	10	103	○	83220860103-2
8.7	61	10	103	○	83220870103-2
8.8	61	10	103	●	83220880103-2
8.9	61	10	103	○	83220890103-2
9.0	61	10	103	●	83220900103-2
9.1	61	10	103	○	83220910103-2
9.2	61	10	103	○	83220920103-2
9.3	61	10	103	●	83220930103-2
9.4	61	10	103	○	83220940103-2
9.5	61	10	103	●	83220950103-2
9.6	61	10	103	○	83220960103-2
9.7	61	10	103	○	83220970103-2
9.8	61	10	103	○	83220980103-2
9.9	61	10	103	○	83220990103-2
10.0	61	10	103	●	83221000103-2
10.2	71	12	118	●	83221020118-2
10.5	71	12	118	●	83221050118-2
10.8	71	12	118	●	83221080118-2
11.0	71	12	118	●	83221100118-2
11.2	71	12	118	●	83221120118-2
11.7	71	12	118	○	83221170118-2
12.0	71	12	118	●	83221200118-2
12.5	77	14	124	○	83221250124-2
13.0	77	14	124	○	83221300124-2
14.0	77	14	124	○	83221400124-2
14.5	83	16	133	○	83221450133-2
15.0	83	16	133	○	83221500133-2
16.0	83	16	133	○	83221600133-2

● In stock
○ Produced to order only

Recommended cutting conditions for drills 8322

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 Low alloy austenitic	40-60	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	35-55	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	35-45	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	35-45	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	15-30	0.025-0.055	0.055-0.084	0.063-0.094	0.07-0.10	0.08-0.12	0.09-0.13