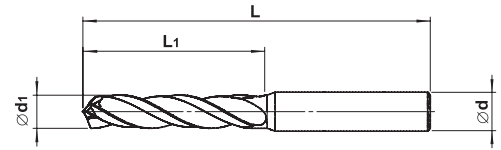
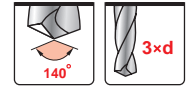


### UMT 8411 Z-3

Twist drills with reinforced shank



d <sub>1</sub> (m7)	L <sub>1</sub>	d (h6)	L	Stock	ART No	nano TEC1
5.0	28	6	66	o	84110500066-1	
5.1	28	6	66	o	84110510066-1	
5.2	28	6	66	o	84110520066-1	
5.3	28	6	66	o	84110530066-1	
5.4	28	6	66	o	84110540066-1	
5.5	28	6	66	o	84110550066-1	
5.6	28	6	66	o	84110560066-1	
5.7	28	6	66	o	84110570066-1	
5.8	28	6	66	o	84110580066-1	
5.9	28	6	66	o	84110590066-1	
6.0	28	6	66	o	84110600066-1	
6.1	34	8	79	o	84110610079-1	
6.2	34	8	79	o	84110620079-1	
6.3	34	8	79	o	84110630079-1	
6.4	34	8	79	o	84110640079-1	
6.5	34	8	79	o	84110650079-1	
6.6	34	8	79	o	84110660079-1	
6.7	34	8	79	o	84110670079-1	
6.8	34	8	79	o	84110680079-1	
6.9	34	8	79	o	84110690079-1	
7.0	34	8	79	o	84110700079-1	
7.1	41	8	79	o	84110710079-1	
7.2	41	8	79	o	84110720079-1	
7.3	41	8	79	o	84110730079-1	
7.4	41	8	79	o	84110740079-1	
7.5	41	8	79	o	84110750079-1	
7.6	41	8	79	o	84110760079-1	
7.7	41	8	79	o	84110770079-1	
7.8	41	8	79	o	84110780079-1	
7.9	41	8	79	o	84110790079-1	
8.0	41	8	79	o	84110800079-1	
8.1	47	10	89	o	84110810089-1	
8.2	47	10	89	o	84110820089-1	
8.3	47	10	89	o	84110830089-1	
8.4	47	10	89	o	84110840089-1	

d <sub>1</sub> (m7)	L <sub>1</sub>	d (h6)	L	Stock	ART No	nano TEC1
8.5	47	10	89	o	84110850089-1	
8.6	47	10	89	o	84110860089-1	
8.7	47	10	89	o	84110870089-1	
8.8	47	10	89	o	84110880089-1	
8.9	47	10	89	o	84110890089-1	
9.0	47	10	89	o	84110900089-1	
9.1	47	10	89	o	84110910089-1	
9.2	47	10	89	o	84110920089-1	
9.3	47	10	89	o	84110930089-1	
9.4	47	10	89	o	84110940089-1	
9.5	47	10	89	o	84110950089-1	
9.6	47	10	89	o	84110960089-1	
9.7	47	10	89	o	84110970089-1	
9.8	47	10	89	o	84110980089-1	
9.9	47	10	89	o	84110990089-1	
10.0	47	10	89	o	84111000089-1	
10.2	55	12	102	o	84111020102-1	
10.3	55	12	102	o	84111030102-1	
10.5	55	12	102	o	84111050102-1	
10.8	55	12	102	o	84111080102-1	
11.0	55	12	102	o	84111100102-1	
11.2	55	12	102	o	84111120102-1	
11.5	55	12	102	o	84111150102-1	
12.0	55	12	102	o	84111200102-1	
12.4	60	14	107	o	84111240107-1	
12.5	60	14	107	o	84111250107-1	
12.7	60	14	107	o	84111270107-1	
13.0	60	14	107	o	84111300107-1	
13.5	60	14	107	o	84111350107-1	
14.0	60	14	107	o	84111400107-1	
14.5	65	16	115	o	84111450115-1	
16.0	65	16	115	o	84111600115-1	

- In stock
- Produced to order only

#### Recommended cutting conditions for drills 8411

Work material	Cutting speed V <sub>c</sub> (m/min)	d <sub>1</sub> - diameter in mm				f - feed per revolution in mm/rev.	
		Ø5 - Ø6	Ø6 - Ø8	Ø8 - Ø10	Ø10 - Ø12	Ø12 - Ø14	Ø14 - Ø16
	nanoTEC1						
<b>P</b> Carbon steel and Alloy steel < 25 HRC	80-100	0.30-0.35	0.35-0.42	0.42-0.50	0.50-0.55	0.55-0.60	0.60-0.66
Alloy steel and Tool steel 25-45 HRC	55-70	0.24-0.29	0.29-0.34	0.34-0.40	0.40-0.44	0.44-0.48	0.48-0.52
<b>K</b> Cast iron GG	80-100	0.30-0.38	0.35-0.46	0.42-0.55	0.50-0.60	0.55-0.66	0.60-0.70
Nodular cast iron GGG	60-80	0.26-0.32	0.30-0.38	0.36-0.46	0.44-0.52	0.48-0.56	0.50-0.58
<b>N</b> Aluminium alloy	120-160	0.32-0.38	0.37-0.46	0.44-0.55	0.52-0.60	0.58-0.66	0.64-0.70