



M20DF

20D Drill With
Coolant Holes

Stock	Order No	Code	d1h7	d2h6	l1	l2	l3
	76100	M20DF.2.0200.0920.A0135.0470.0000.0500.00.S04B2B03.01	2	4	92	47	50
	76102	M20DF.2.0220.0920.A0135.0470.0000.0500.00.S04B2B03.01	2,2	4	92	47	50
	76104	M20DF.2.0230.0920.A0135.0470.0000.0500.00.S04B2B03.01	2,3	4	92	47	50
	76106	M20DF.2.0240.1120.A0135.0660.0000.0700.00.S04B2B03.01	2,4	4	112	66	70
	76108	M20DF.2.0250.1120.A0135.0660.0000.0700.00.S04B2B03.01	2,5	4	112	66	70
	76110	M20DF.2.0270.1120.A0135.0660.0000.0700.00.S04B2B03.01	2,7	4	112	66	70
	76112	M20DF.2.0280.1120.A0135.0660.0000.0700.00.S04B2B03.01	2,8	4	112	66	70
	76114	M20DF.2.0300.1200.A0135.0750.0000.0800.00.S06B2B03.01	3	6	120	75	80
	76116	M20DF.2.0320.1200.A0135.0750.0000.0800.00.S06B2B03.01	3,2	6	120	75	80
	76118	M20DF.2.0330.1200.A0135.0750.0000.0800.00.S06B2B03.01	3,3	6	120	75	80
	76120	M20DF.2.0350.1200.A0135.0750.0000.0800.00.S06B2B03.01	3,5	6	120	75	80
	76122	M20DF.2.0380.1300.A0135.0840.0000.0900.00.S06B2B03.01	3,8	6	130	84	90
	76124	M20DF.2.0400.1300.A0135.0840.0000.0900.00.S06B2B03.01	4	6	130	84	90
	76126	M20DF.2.0420.1600.A0135.1030.0000.1100.00.S06B2B03.01	4,2	6	160	103	110
	76128	M20DF.2.0450.1600.A0135.1030.0000.1100.00.S06B2B03.01	4,5	6	160	103	110
	76130	M20DF.2.0480.1600.A0135.1130.0000.1200.00.S06B2B03.01	4,8	6	160	113	120
	76132	M20DF.2.0500.1600.A0135.1130.0000.1200.00.S06B2B03.01	5	6	160	113	120
	76134	M20DF.2.0550.1850.A0135.1310.0000.1400.00.S06B2B03.01	5,5	6	185	131	140
	76136	M20DF.2.0580.1850.A0135.1310.0000.1400.00.S06B2B03.01	5,8	6	185	131	140
	76138	M20DF.2.0600.1850.A0135.1310.0000.1400.00.S06B2B03.01	6	6	185	131	140
	76140	M20DF.2.0650.2100.A0135.1500.0000.1600.00.S08B2B03.01	6,5	8	210	150	160
	76142	M20DF.2.0680.2100.A0135.1500.0000.1600.00.S08B2B03.01	6,8	8	210	150	160
	76144	M20DF.2.0700.2100.A0135.1500.0000.1600.00.S08B2B03.01	7	8	210	150	160
	76146	M20DF.2.0750.2300.A0135.1680.0000.1800.00.S08B2B03.01	7,5	8	230	168	180
	76148	M20DF.2.0780.2300.A0135.1680.0000.1800.00.S08B2B03.01	7,8	8	230	168	180
	76150	M20DF.2.0800.2300.A0135.1680.0000.1800.00.S08B2B03.01	8	8	230	168	180
	76152	M20DF.2.0850.2600.A0135.1820.0000.1950.00.S10B2B03.01	8,5	10	260	182	195
	76154	M20DF.2.0880.2900.A0135.2160.0000.2300.00.S10B2B03.01	8,8	10	290	216	230
	76156	M20DF.2.0900.2900.A0135.2160.0000.2300.00.S10B2B03.01	9	10	290	216	230
	76158	M20DF.2.0980.2900.A0135.2160.0000.2300.00.S10B2B03.01	9,8	10	290	216	230
	76160	M20DF.2.1000.2900.A0135.2160.0000.2300.00.S10B2B03.01	10	10	290	216	230
	76162	M20DF.2.1020.3150.A0135.2510.0000.2680.00.S12B2B03.01	10,2	12	315	251	268
	76164	M20DF.2.1080.3150.A0135.2510.0000.2680.00.S12B2B03.01	10,8	12	315	251	268
	76166	M20DF.2.1180.3150.A0135.2510.0000.2680.00.S12B2B03.01	11,8	12	315	251	268
	76168	M20DF.2.1200.3150.A0135.2510.0000.2680.00.S12B2B03.01	12	12	315	251	268

Cutting Parameters Vc(m/min)

Unalloyed Steel	95	●
Steel	95	●
Tempered Steel	85	●
Hot Work Tool Steel	70	○
AISI 304 - 416 - 420	50	○
AISI 316 - 440	50	○
17-4 PH 15-5 PH	45	○
Chrome-Cobalt Alloy	45	○
Duplex F51	35	○
Super Duplex F55	35	○
Gray Cast	100	●
Alloyed Cast	95	●
Precision Cast	95	●

Feed Per Revolution (mm/rev)

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2-3	0,05-0,15
3-5	0,08-0,23
5-8	0,12-0,335
8-12	0,15-0,425

