



## M25DF

25D Drill With  
Coolant Holes

| Stock | Order No     | Code                                                  | d1h7 | d2h6 | l1  | l2  | l3         |
|-------|--------------|-------------------------------------------------------|------|------|-----|-----|------------|
|       | <b>77100</b> | M25DF.2.0200.1040.A0135.0570.0000.0600.00.S04C1B03.01 | 2    | 4    | 104 | 57  | <b>60</b>  |
|       | <b>77102</b> | M25DF.2.0220.1040.A0135.0570.0000.0600.00.S04C1B03.01 | 2,2  | 4    | 104 | 57  | <b>60</b>  |
|       | <b>77104</b> | M25DF.2.0230.1040.A0135.0570.0000.0600.00.S04C1B03.01 | 2,3  | 4    | 104 | 57  | <b>60</b>  |
|       | <b>77106</b> | M25DF.2.0240.1250.A0135.0760.0000.0800.00.S04M1B03.01 | 2,4  | 4    | 125 | 76  | <b>80</b>  |
|       | <b>77108</b> | M25DF.2.0250.1250.A0135.0760.0000.0800.00.S04M1B03.01 | 2,5  | 4    | 125 | 76  | <b>80</b>  |
|       | <b>77110</b> | M25DF.2.0270.1250.A0135.0760.0000.0800.00.S04M1B03.01 | 2,7  | 4    | 125 | 76  | <b>80</b>  |
|       | <b>77112</b> | M25DF.2.0280.1250.A0135.0760.0000.0800.00.S04M1B03.01 | 2,8  | 4    | 125 | 76  | <b>80</b>  |
|       | <b>77114</b> | M25DF.2.0300.1350.A0135.0930.0000.0980.00.S06M1B03.01 | 3    | 6    | 135 | 93  | <b>98</b>  |
|       | <b>77116</b> | M25DF.2.0320.1350.A0135.0930.0000.0980.00.S06M1B03.01 | 3,2  | 6    | 135 | 93  | <b>98</b>  |
|       | <b>77118</b> | M25DF.2.0330.1500.A0135.1050.0000.1100.00.S06M1B03.01 | 3,3  | 6    | 150 | 105 | <b>110</b> |
|       | <b>77120</b> | M25DF.2.0350.1500.A0135.1050.0000.1100.00.S06M1B03.01 | 3,5  | 6    | 150 | 105 | <b>110</b> |
|       | <b>77122</b> | M25DF.2.0380.1600.A0135.1140.0000.1200.00.S06M1B03.01 | 3,8  | 6    | 160 | 114 | <b>120</b> |
|       | <b>77124</b> | M25DF.2.0400.1600.A0135.1140.0000.1200.00.S06M1B03.01 | 4    | 6    | 160 | 114 | <b>120</b> |
|       | <b>77126</b> | M25DF.2.0420.1600.A0135.1140.0000.1200.00.S06M1B03.01 | 4,2  | 6    | 160 | 114 | <b>120</b> |
|       | <b>77128</b> | M25DF.2.0450.1800.A0135.1280.0000.1350.00.S06C2B02.01 | 4,5  | 6    | 180 | 128 | <b>135</b> |
|       | <b>77130</b> | M25DF.2.0480.1800.A0135.1280.0000.1350.00.S06C2B02.01 | 4,8  | 6    | 180 | 128 | <b>135</b> |
|       | <b>77132</b> | M25DF.2.0500.1800.A0135.1280.0000.1350.00.S06C2B02.01 | 5    | 6    | 180 | 128 | <b>135</b> |
|       | <b>77134</b> | M25DF.2.0550.2050.A0135.1590.0000.1680.00.S06C2B02.01 | 5,5  | 6    | 205 | 159 | <b>168</b> |
|       | <b>77136</b> | M25DF.2.0580.2050.A0135.1590.0000.1680.00.S06C2B02.01 | 5,8  | 6    | 205 | 159 | <b>168</b> |
|       | <b>77138</b> | M25DF.2.0600.2050.A0135.1590.0000.1680.00.S06C2B02.01 | 6    | 6    | 205 | 159 | <b>168</b> |
|       | <b>77140</b> | M25DF.2.0650.2400.A0135.1900.0000.2000.00.S08C2B02.01 | 6,5  | 8    | 240 | 190 | <b>200</b> |
|       | <b>77142</b> | M25DF.2.0680.2400.A0135.1900.0000.2000.00.S08C2B02.01 | 6,8  | 8    | 240 | 190 | <b>200</b> |
|       | <b>77144</b> | M25DF.2.0700.2400.A0135.1900.0000.2000.00.S08C2B02.01 | 7    | 8    | 240 | 190 | <b>200</b> |
|       | <b>77146</b> | M25DF.2.0750.2600.A0135.2080.0000.2200.00.S08C2B02.01 | 7,5  | 8    | 260 | 208 | <b>220</b> |
|       | <b>77148</b> | M25DF.2.0780.2600.A0135.2080.0000.2200.00.S08C2B02.01 | 7,8  | 8    | 260 | 208 | <b>220</b> |
|       | <b>77150</b> | M25DF.2.0800.2600.A0135.2080.0000.2200.00.S08C2B02.01 | 8    | 8    | 260 | 208 | <b>220</b> |
|       | <b>77152</b> | M25DF.2.0850.2850.A0135.2270.0000.2400.00.S10C2B02.01 | 8,5  | 10   | 285 | 227 | <b>240</b> |
|       | <b>77154</b> | M25DF.2.0880.3100.A0135.2540.0000.2680.00.S10C2B02.01 | 8,8  | 10   | 310 | 254 | <b>268</b> |
|       | <b>77156</b> | M25DF.2.0900.3100.A0135.2540.0000.2680.00.S10C2B02.01 | 9    | 10   | 310 | 254 | <b>268</b> |
|       | <b>77158</b> | M25DF.2.0980.3100.A0135.2540.0000.2680.00.S10C2B02.01 | 9,8  | 10   | 310 | 254 | <b>268</b> |
|       | <b>77160</b> | M25DF.2.1000.3100.A0135.2540.0000.2680.00.S10C2B02.01 | 10   | 10   | 310 | 254 | <b>268</b> |
|       | <b>77162</b> | M25DF.2.1020.3750.A0135.3080.0000.3250.00.S12C2B02.01 | 10,2 | 12   | 375 | 308 | <b>325</b> |
|       | <b>77164</b> | M25DF.2.1080.3750.A0135.3080.0000.3250.00.S12C2B02.01 | 10,8 | 12   | 375 | 308 | <b>325</b> |
|       | <b>77166</b> | M25DF.2.1180.3750.A0135.3080.0000.3250.00.S12C2B02.01 | 11,8 | 12   | 375 | 308 | <b>325</b> |
|       | <b>77168</b> | M25DF.2.1200.3750.A0135.3080.0000.3250.00.S12C2B02.01 | 12   | 12   | 375 | 308 | <b>325</b> |

## Cutting Parameters Vc(m/min)

|                      |    |   |
|----------------------|----|---|
| Non-Alloy Steel      | 85 | ● |
| Steel                | 85 | ● |
| Tempered Steel       | 75 | ● |
| Cold-Work Tool Steel | 65 | ○ |
| Hot-Work Tool Steel  | 45 | ○ |
| AISI 304 - 416 - 420 | 45 | ○ |
| AISI 316 - 440       | 40 | ○ |
| 17-4 PH 15-5 PH      | 40 | ○ |
| Chrome-Cobalt Alloy  | 30 | ○ |
| Duplex F51           | 30 | ○ |
| Grey Cast Iron       | 90 | ● |
| Alloy Cast Iron      | 85 | ● |
| Precision Cast       | 85 | ● |

## Feed Per Revolution (mm/rev)

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



● Recommended ○ Acceptable ○ Not Recommended

\*Marked products are available  
from stock to deliver fast.