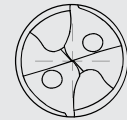
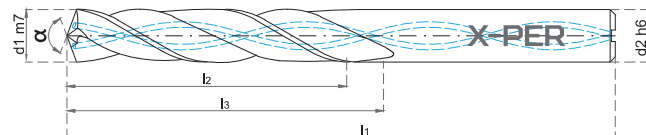


Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	70100	M5DF.2.0238.0680.A0140.0140.0000.0270.00.S03P1B03.01	2,38	3	68	14	27
*	70102	M5DF.2.0300.0660.A0138.0270.0000.0280.00.S06C1A05.01	3	6	66	27	28
*	70104	M5DF.2.0310.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,1	6	66	27	28
*	70106	M5DF.2.0320.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,2	6	66	27	28
*	70108	M5DF.2.0325.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,25	6	66	27	28
*	70110	M5DF.2.0330.0720.A0140.0290.0000.0320.00.S06A2B03.01	3,3	6	72	29	32
*	70112	M5DF.2.0330.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,3	6	66	27	28
*	70114	M5DF.2.0340.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,4	6	66	27	28
*	70116	M5DF.2.0350.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,5	6	66	27	28
*	70118	M5DF.2.0360.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,6	6	66	27	28
*	70120	M5DF.2.0370.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,7	6	66	27	28
*	70122	M5DF.2.0380.0740.A0138.0320.0000.0360.00.S06C1A05.01	3,8	6	74	32	36
*	70124	M5DF.2.0390.0740.A0138.0320.0000.0360.00.S06C1A05.01	3,9	6	74	32	36
*	70126	M5DF.2.0400.0740.A0138.0320.0000.0360.00.S06C1A05.01	4	6	74	32	36
*	70128	M5DF.2.0410.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,1	6	74	32	36
*	70130	M5DF.2.0420.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,2	6	74	32	36
*	70132	M5DF.2.0430.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,3	6	74	32	36
*	70134	M5DF.2.0440.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,4	6	74	32	36
*	70136	M5DF.2.0450.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,5	6	74	32	36
*	70138	M5DF.2.0460.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,6	6	74	32	36
*	70140	M5DF.2.0470.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,7	6	74	32	36
*	70142	M5DF.2.0480.0820.A0138.0410.0000.0440.00.S06A1A05.01	4,8	6	82	41	44
*	70144	M5DF.2.0490.0820.A0138.0410.0000.0440.00.S06A1A05.01	4,9	6	82	41	44
*	70146	M5DF.2.0500.0820.A0138.0410.0000.0440.00.S06A1A05.01	5	6	82	41	44
*	70148	M5DF.2.0510.0820.A0140.0430.0000.0440.00.S06A1B02.01	5,1	6	82	43	44
*	70150	M5DF.2.0510.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,1	6	82	41	44
*	70152	M5DF.2.0520.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,2	6	82	41	44
*	70154	M5DF.2.0530.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,3	6	82	41	44
*	70156	M5DF.2.0540.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,4	6	82	41	44
*	70158	M5DF.2.0550.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,5	6	82	41	44
*	70160	M5DF.2.0560.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,6	6	82	41	44
*	70162	M5DF.2.0570.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,7	6	82	41	44
*	70164	M5DF.2.0580.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,8	6	82	41	44
*	70166	M5DF.2.0590.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,9	6	82	41	44
*	70168	M5DF.2.0600.0820.A0138.0410.0000.0440.00.S06C2A05.01	6	6	82	41	44
*	70170	M5DF.2.0600.0820.A0138.0410.0000.0440.00.S06A1A05.01	6	6	82	41	44
*	70172	M5DF.2.0610.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,1	8	91	50	53
*	70174	M5DF.2.0620.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,2	8	91	50	53
*	70176	M5DF.2.0630.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,3	8	91	50	53
*	70178	M5DF.2.0640.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,4	8	91	50	53
*	70180	M5DF.2.0650.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,5	8	91	50	53
*	70182	M5DF.2.0660.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,6	8	91	50	53
*	70184	M5DF.2.0670.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,7	8	91	50	53
*	70186	M5DF.2.0680.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,8	8	91	50	53
*	70188	M5DF.2.0690.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,9	8	91	50	53
*	70190	M5DF.2.0700.0910.A0138.0500.0000.0530.00.S08A1A05.01	7	8	91	50	53
*	70192	M5DF.2.0710.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,1	8	91	50	53
*	70194	M5DF.2.0720.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,2	8	91	50	53
*	70196	M5DF.2.0730.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,3	8	91	50	53
*	70198	M5DF.2.0740.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,4	8	91	50	53

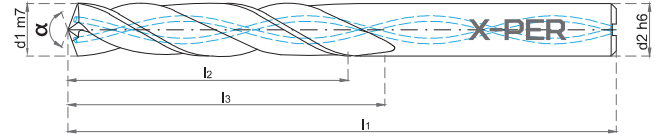
M5DF

5D Drill With
Coolant Holes



M5DF - 5D Drill With Coolant Holes

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	70200	M5DF.2.0750.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,5	8	91	50	53
*	70202	M5DF.2.0760.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,6	8	91	50	53
*	70204	M5DF.2.0770.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,7	8	91	50	53
*	70206	M5DF.2.0780.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,8	8	91	50	53
*	70208	M5DF.2.0790.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,9	8	91	50	53
*	70210	M5DF.2.0800.0910.A0138.0500.0000.0530.00.S08A1A05.01	8	8	91	50	53
*	70212	M5DF.2.0810.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,1	10	103	57	61
*	70214	M5DF.2.0820.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,2	10	103	57	61
*	70216	M5DF.2.0830.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,3	10	103	57	61
*	70218	M5DF.2.0840.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,4	10	103	57	61
*	70220	M5DF.2.0850.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,5	10	103	57	61
*	70222	M5DF.2.0860.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,6	10	103	57	61
*	70224	M5DF.2.0870.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,7	10	103	57	61
*	70226	M5DF.2.0880.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,8	10	103	57	61
*	70228	M5DF.2.0890.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,9	10	103	57	61
*	70230	M5DF.2.0900.1030.A0138.0570.0000.0610.00.S10A1A05.01	9	10	103	57	61
*	70232	M5DF.2.0910.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,1	10	103	57	61
*	70234	M5DF.2.0920.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,2	10	103	57	61
*	70236	M5DF.2.0930.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,3	10	103	57	61
*	70238	M5DF.2.0940.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,4	10	103	57	61
*	70240	M5DF.2.0950.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,5	10	103	57	61
*	70242	M5DF.2.0960.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,6	10	103	57	61
*	70244	M5DF.2.0970.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,7	10	103	57	61
*	70246	M5DF.2.0980.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,8	10	103	57	61
*	70248	M5DF.2.0990.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,9	10	103	57	61
*	70250	M5DF.2.1000.1030.A0138.0570.0000.0610.00.S10A1A05.01	10	10	103	57	61
*	70252	M5DF.2.1000.1100.A0140.0650.0000.0720.00.S10A1A05.01	10	10	110	65	72
*	70254	M5DF.2.1010.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,1	12	118	67	71
*	70256	M5DF.2.1020.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,2	12	118	67	71
*	70258	M5DF.2.1030.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,3	12	118	67	71
*	70260	M5DF.2.1040.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,4	12	118	67	71
*	70262	M5DF.2.1050.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,5	12	118	67	71
*	70264	M5DF.2.1060.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,6	12	118	67	71
*	70266	M5DF.2.1070.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,7	12	118	67	71
*	70268	M5DF.2.1080.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,8	12	118	67	71
*	70270	M5DF.2.1090.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,9	12	118	67	71
*	70272	M5DF.2.1100.1180.A0138.0670.0000.0710.00.S12A1A05.01	11	12	118	67	71
*	70274	M5DF.2.1110.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,1	12	118	67	71
*	70276	M5DF.2.1120.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,2	12	118	67	71
*	70278	M5DF.2.1130.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,3	12	118	67	71
*	70280	M5DF.2.1140.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,4	12	118	67	71
*	70282	M5DF.2.1150.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,5	12	118	67	71
*	70284	M5DF.2.1160.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,6	12	118	67	71
*	70286	M5DF.2.1170.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,7	12	118	67	71
*	70288	M5DF.2.1180.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,8	12	118	67	71
*	70290	M5DF.2.1190.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,9	12	118	67	71
*	70292	M5DF.2.1200.1180.A0138.0670.0000.0710.00.S12A1A05.01	12	12	118	67	71
*	70294	M5DF.2.1230.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,3	14	124	70	77
*	70296	M5DF.2.1250.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,5	14	124	70	77
*	70298	M5DF.2.1270.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,7	14	124	70	77
*	70300	M5DF.2.1280.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,8	14	124	70	77



M5DF - 5D Drill With Coolant Holes

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	70302	M5DF.2.1290.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,9	14	124	70	77
*	70304	M5DF.2.1300.1240.A0138.0700.0000.0770.00.S14A1A05.01	13	14	124	70	77
*	70306	M5DF.2.1330.1240.A0138.0700.0000.0770.00.S14A1A05.01	13,3	14	124	70	77
*	70308	M5DF.2.1350.1240.A0138.0700.0000.0770.00.S14A1A05.01	13,5	14	124	70	77
*	70310	M5DF.2.1370.1240.A0138.0700.0000.0770.00.S14A1A05.01	13,7	14	124	70	77
*	70312	M5DF.2.1380.1240.A0138.0700.0000.0770.00.S14A1A05.01	13,8	14	124	70	77
*	70314	M5DF.2.1400.1240.A0140.0700.0000.0770.00.S14A1A05.01	14	14	124	70	77
*	70316	M5DF.2.1420.1330.A0138.0740.0000.0830.00.S16A1A05.01	14,2	16	133	74	83
*	70318	M5DF.2.1450.1330.A0138.0740.0000.0830.00.S16A1A05.01	14,5	16	133	74	83
*	70320	M5DF.2.1470.1330.A0138.0740.0000.0830.00.S16A1A05.01	14,7	16	133	74	83
*	70322	M5DF.2.1480.1330.A0138.0740.0000.0830.00.S16A1A05.01	14,8	16	133	74	83
*	70324	M5DF.2.1500.1330.A0140.0740.0000.0830.00.S16A1A05.01	15	16	133	74	83
	70326	M5DF.2.1510.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,1	16	133	74	83
	70328	M5DF.2.1530.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,3	16	133	74	83
	70330	M5DF.2.1550.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,5	16	133	74	83
	70332	M5DF.2.1570.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,7	16	133	74	83
	70334	M5DF.2.1580.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,8	16	133	74	83
	70336	M5DF.2.1600.1330.A0138.0740.0000.0830.00.S16A1A05.01	16	16	133	74	83
	70338	M5DF.2.1650.1430.A0140.0860.0000.0930.00.S18A1A05.01	16,5	18	143	86	93
	70340	M5DF.2.1660.1430.A0140.0860.0000.0930.00.S18A1A05.01	16,6	18	143	86	93
	70342	M5DF.2.1680.1430.A0140.0860.0000.0930.00.S18A1A05.01	16,8	18	143	86	93
*	70344	M5DF.2.1700.1430.A0140.0860.0000.0930.00.S18A1A05.01	17	18	143	86	93
	70346	M5DF.2.1730.1430.A0140.0860.0000.0930.00.S18A1A05.01	17,3	18	143	86	93
	70348	M5DF.2.1750.1430.A0140.0860.0000.0930.00.S18A1A05.01	17,5	18	143	86	93
	70350	M5DF.2.1780.1430.A0140.0860.0000.0930.00.S18A1A05.01	17,8	18	143	86	93
	70352	M5DF.2.1800.1430.A0140.0860.0000.0930.00.S18A1A05.01	18	18	143	86	93
	70354	M5DF.2.1850.1530.A0140.0920.0000.1010.00.S20A1A05.01	18,5	20	153	92	101
	70356	M5DF.2.1880.1530.A0140.0920.0000.1010.00.S20A1A05.01	18,8	20	153	92	101
	70358	M5DF.2.1900.1530.A0140.0920.0000.1010.00.S20A1A05.01	19	20	153	92	101
	70360	M5DF.2.1950.1530.A0140.0920.0000.1010.00.S20A1A05.01	19,5	20	153	92	101
	70362	M5DF.2.1980.1530.A0140.0920.0000.1010.00.S20A1A05.01	19,8	20	153	92	101
	70364	M5DF.2.2000.1530.A0140.0920.0000.1010.00.S20A1A05.01	20	20	153	92	101

Cutting Parameters Vc(m/min)		
Blue	Non-Alloy Steel	100-130 ●
	Steel	90-120 ●
	Tempered Steel	90-120 ●
	Cold-Work Tool Steel	60-90 ◐
	Hot-Work Tool Steel	60-90 ◐
Yellow	AISI 304 - 416 - 420	50-55 ◐
	AISI 316 - 440	50-55 ◐
	17-4 PH 15-5 PH	40-50 ◐
	Chrome-Cobalt Alloy	40-50 ◐
	Duplex F51	30-40 ◐
Red	Super Duplex F55	30-40 ◐
	Grey Cast Iron	170-200 ●
	Alloy Cast Iron	150-180 ●
	Precision Cast	110-140 ●
	Titanium	30-40 ◐
Orange	Titanium Alloys	25-30 ◐
	≤ 54 HRC	60-80 ◐
	> 54 HRC	40-55 ◐

Feed Per Revolution (mm/rev)	
Ø	
3	0,045
4	0,07
5	0,1
6	0,170
7	0,187
8	0,204
9	0,230
10	0,255
12	0,281
14	0,306
16	0,332
18	0,357
20	0,383

*Marked products are available from stock to deliver fast.

