SuperV70-NX

STOCK

Chip – by Chip – to the Top

SuperV drills

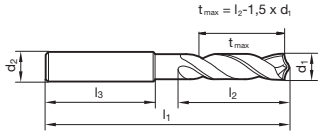
SuperV70-NX Solid carbide universal high-performance twist drill without internal cooling

Catalog no. 51783

SuperV-70-NX | 3xD | WN | VHM | TiSiN | 140° | HA

P	M	K	N	S	H
●	●	●	●		

- relieved cone
- 40° front helix angle
- innovative TiSiN-coating
- V70 geometry
- polished surface finish on functional surfaces, harder nano composite coating
- optimised point geometry and efficiant cutting edge preparation
- wide, open flutes for efficiant chip evacuation
- special cutting edge geometry for optimized short chip form



d1 mm	d2 h6 mm	l1 mm	l2 mm	Order no.	Price per item €
3,000	6,000	62,000	20,000		37,50
3,250	6,000	62,000	20,000	303183680	37,50
3,300	6,000	62,000	20,000		37,50
3,400	6,000	62,000	20,000		37,50
3,500	6,000	62,000	20,000		37,50
3,700	6,000	62,000	20,000		37,50
4,000	6,000	66,000	24,000		37,50
4,200	6,000	66,000	24,000	303123106	41,00
4,300	6,000	66,000	24,000		41,00
4,500	6,000	66,000	24,000		41,00
4,650	6,000	66,000	24,000		41,00
5,000	6,000	66,000	28,000	303186854	41,00
5,100	6,000	66,000	28,000	303186855	41,00
5,160	6,000	66,000	28,000	303123117	41,00
5,500	6,000	66,000	28,000		41,00
5,550	6,000	66,000	28,000		41,00
5,560	6,000	66,000	28,000		41,00
6,000	6,000	66,000	28,000		41,00
6,060	8,000	79,000	34,000	303130720	45,00
6,500	8,000	79,000	34,000		45,00
6,800	8,000	79,000	34,000		45,00
6,900	8,000	79,000	34,000		45,00
7,000	8,000	79,000	34,000		45,00
7,400	8,000	79,000	41,000	303123103	45,00
7,500	8,000	79,000	41,000		45,00
7,800	8,000	79,000	41,000	303132326	45,00
8,000	8,000	79,000	41,000	303123118	45,00
8,500	10,000	89,000	47,000		45,00
8,600	10,000	89,000	47,000		45,00
9,000	10,000	89,000	47,000		45,00
9,000	10,000	89,000	47,000	303108802	45,00
9,300	10,000	89,000	47,000		45,00
9,500	10,000	89,000	47,000		45,00
10,000	10,000	89,000	47,000		45,00
10,200	12,000	102,000	55,000		on request
10,300	12,000	102,000	55,000		on request
10,500	12,000	102,000	55,000		on request
11,000	12,000	102,000	55,000		on request
11,200	12,000	102,000	55,000		on request
11,500	12,000	102,000	55,000		on request
12,000	12,000	102,000	55,000		on request

Further dimensions possible on request.

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Catalog no. 51784

SuperV-70-IK-NX | 6xD | WN | VHM | TiSiN | 140° | HA

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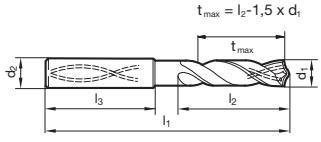

d1 mm	d2 h6 mm	l1 mm	l2 mm	Order no.	Price per item €
3,000	6,000	62,000	24,000	303067303	48,00
3,100	6,000	66,000	28,000	303038910	48,00
3,300	6,000	66,000	28,000	303067306	48,00
3,400	6,000	66,000	28,000	302993226	48,00
3,500	6,000	66,000	28,000	303067236	48,00
3,700	6,000	68,000	30,000	303067238	48,00
4,000	6,000	70,000	32,000	303067330	51,00
4,200	6,000	72,000	34,000	303067329	51,00
4,300	6,000	72,000	34,000	303067326	51,00
4,500	6,000	74,000	36,000	303067322	51,00
4,650	6,000	75,000	37,000	303067323	51,00
5,000	6,000	79,000	41,000	303067223	51,00
5,100	6,000	79,000	41,000	303067220	51,00
5,200	6,000	80,000	42,000	303110864	51,00
5,500	6,000	82,000	44,000	303067214	51,00
5,550	6,000	82,000	44,000	302915146	51,00
5,900	6,000	86,000	48,000	303092941	51,00
6,000	6,000	86,000	48,000	303067209	51,00
6,200	8,000	88,000	50,000	303131136	61,50
6,500	8,000	90,000	52,000	303067189	61,50
6,800	8,000	93,000	55,000	302987118	61,50
6,900	8,000	93,000	55,000	303067204	61,50
7,000	8,000	94,000	56,000	303067180	61,50
7,400	8,000	97,000	59,000	303034105	61,50
7,500	8,000	98,000	60,000	303067185	61,50
7,800	8,000	101,000	63,000	303061283	61,50
7,900	8,000	102,000	64,000	303156008	61,50
8,000	8,000	102,000	64,000	303036093	61,50
8,200	10,000	108,000	66,000	303190896	79,00
8,500	10,000	110,000	68,000	302987336	79,00
8,600	10,000	111,000	69,000	303067133	79,00
8,800	10,000	114,000	72,000	303099395	79,00
9,000	10,000	114,000	72,000	303040499	79,00
9,300	10,000	116,000	74,000	303067135	79,00
9,500	10,000	118,000	76,000	303067139	79,00
10,000	10,000	122,000	80,000	303067142	79,00
10,200	12,000	129,000	82,000	302987424	102,00
10,300	12,000	129,000	82,000	302993209	102,00
10,500	12,000	131,000	84,000	303067113	102,00
11,000	12,000	135,000	88,000	303067118	102,00
11,200	12,000	137,000	90,000	303067122	102,00
11,500	12,000	139,000	92,000	303067128	102,00
12,000	12,000	143,000	96,000	303067129	102,00

Further dimensions possible on request.

SuperV70-NX

Cutting value recommendations

Material	Hardness/ tensile strength	Variant	Type of conditions	Cut v_c	Feed fu (mm/U) with nom. Ø							
					3	5	6	7	8	9	10	12
Struct. + free-cutting steels, unalloyed heat-treat. + case hard. steels 1.0035 S185, 1.0486 P275N, 1.0345 P235GH, 1.0050, 1.0070, 1.8937, 1.0718 11SMnPb30, 1.0736 11SMn37, 1.0402 C22, 1.1178 C30E, 1.0503 C45, 1.1191 C30E, 1.0301 C10, 1.1121 C10E, 1.1750 C75W, 1.2076 102Cr6, 1.2307 29CrMoV9	< 850 N/mm²	6xD	with IC	110	0,150	0,180	0,200	0,250	0,270	0,300	0,320	0,350
		3xD	without IC	100	0,150	0,180	0,200	0,250	0,270	0,300	0,320	0,350
Free-cutting steels, unalloyed case hardened steels, nitriding steels 1.0727 46 S20, 1.0728 60 S20, 1.0757 46SPb20, 1.0601 C60, 1.1221 C60E, 1.7043 38Cr4, 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5, 1.8504 34CrAl6, 1.8519 31CrMoV9, 1.8550 34CrAlNi7	850-1.200 N/mm²	6xD	with IC	90	0,120	0,140	0,160	0,190	0,210	0,240	0,250	0,270
		3xD	without IC	80	0,120	0,140	0,160	0,190	0,210	0,240	0,250	0,270
Alloyed heat-treatable, tool and high speed steels 1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4, 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4, 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.3344 S 6-5-3, 1.2379 X155CrVMo12-1, 1.3243 S 6-5-2-5, 1.3343 S 6-5-2, Spring steel = 1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4	850-1.400 N/mm²	6xD	with IC	70	0,100	0,120	0,140	0,150	0,170	0,185	0,200	0,250
		3xD	without IC	60	0,100	0,120	0,140	0,150	0,170	0,185	0,200	0,250
Hardened steel Tool steel, heat-treatable steel, spring steel, high-speed steel, case hardened steel, etc. e. g.: 1.2344 X40CrMoV5-1; 1.2767 X45NiCrMo4; 1.2379 X155CrVMo12-1; 1.2080 X210Cr12 1.3343 S 6-5-2	< 54 HRC	6xD	with IC	-	-	-	-	-	-	-	-	-
		3xD	without IC	-	-	-	-	-	-	-	-	-
Stainless steel 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X10CrNiS18-9 USA = 303, 410, 420F, 430, 430F	< 750 N/mm²	6xD	with IC	60	0,070	0,090	0,100	0,110	0,120	0,140	0,160	0,180
		3xD	without IC	45	0,070	0,090	0,100	0,110	0,120	0,140	0,160	0,180
Stainless steel 1.4301X5CrNi18-10, 1.4303 X5CrNi18-12 1.4310 XCrNi18-8 USA = 304, 304L, 420	750-850 N/mm²	6xD	with IC	50	0,060	0,070	0,080	0,090	0,100	0,125	0,145	0,175
		3xD	without IC	35	0,060	0,070	0,080	0,090	0,100	0,125	0,145	0,175
Stainless steel 1.4438 X2CrNiMo18-15-4, 1.4404 X2CrNiMo17-12-2, 1.4571 X6CrNiTi18-10 USA = 310, 316, 316B, 316L, 317	> 850 N/mm²	6xD	with IC	45	0,050	0,060	0,070	0,080	0,090	0,110	0,130	0,150
		3xD	without IC	30	0,050	0,060	0,070	0,080	0,090	0,110	0,130	0,150
Special alloys (nickel based "Ni") Nimonic, Inconel, Monel, Hastelloy	< 1.300 N/mm²	6xD	with IC	-	-	-	-	-	-	-	-	-
		3xD	without IC	-	-	-	-	-	-	-	-	-
Titanium alloys ("Ti") 3.7024 Ti99,5, 3.7114 TiAl5Sn2,5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7164 TiAl6V4, 3.7184 TiAl4Mo4Sn2,5	< 1.300 N/mm²	6xD	with IC	-	-	-	-	-	-	-	-	-
		3xD	without IC	-	-	-	-	-	-	-	-	-
Cast iron, grey cast iron, spheroidal graphite and malleable cast iron 0.6010 EN-GL100 (GG10), 0.6020 EN-GJL-200 (GG20), 0.7050 EN-GJS-500-7 (GGG50), 0.8535 EN-GJMW-350-4 (GTW35)	< 240 HB 30	6xD	with IC	120	0,120	0,140	0,160	0,190	0,230	0,260	0,280	0,350
		3xD	without IC	120	0,120	0,140	0,160	0,190	0,230	0,260	0,280	0,350
Cast iron, grey cast iron, spheroidal graphite and malleable cast iron 0.6025 EN-GL250 (GG25), 0.6035 EN-GJL-350 (GG35), 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)	> 240 HB 30	6xD	with IC	80	0,080	0,100	0,130	0,150	0,200	0,230	0,250	0,320
		3xD	without IC	80	0,080	0,100	0,130	0,150	0,200	0,230	0,250	0,320
Aluminium, Al-wrought alloys, Al-alloys 3.0255 Al99,5, 3.2315 AlMgSi1, 3.3515 AlMg1 3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1,5	< 3% Si	6xD	with IC	300	0,200	0,230	0,250	0,270	0,300	0,350	0,400	0,450
		3xD	without IC	250	0,200	0,230	0,250	0,270	0,300	0,350	0,400	0,450
Aluminium-cast alloys 3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9 3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	> 3% Si	6xD	with IC	250	0,175	0,200	0,220	0,240	0,270	0,310	0,350	0,400
		3xD	without IC	200	0,175	0,200	0,220	0,240	0,270	0,310	0,350	0,400
Magnesium-alloys MgMn2, G-MgAl8Zn1, G-MgAl6Zn3	-	6xD	with IC	200	0,150	0,180	0,200	0,220	0,250	0,275	0,300	0,350
		3xD	without IC	170	0,150	0,180	0,200	0,220	0,250	0,275	0,300	0,350
Non-ferrous metals (copper, short- or long-chipping brass) 2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb, 2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2, 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0,5, 2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn, 2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10	< 850 N/mm²	6xD	with IC	150	0,120	0,140	0,160	0,190	0,230	0,260	0,280	0,330
		3xD	without IC	135	0,120	0,140	0,160	0,190	0,230	0,260	0,280	0,330

- for steels up to approximately 1400 N/mm², stainless steels, cast materials, non-ferrous metals
- extensively polished flutes, with special TiSiN-coating
- best possible cutting edge preparation
- SuperV70 geometry, wide, open flutes for efficient chip evacuation
- with specially adapted cutting edge geometry for tough and long-chipping (incl. stainless) materials

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