



Bohrerauswahl | nach Werkstoffen und Bohrtiefe

| Familie | | Seite | |
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| 630.63 | | 10 | |

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|--|-------|--|-----------------|--|-------------------|
| | HSS | | mit Kühlkanalen | | ohne Beschichtung |
| | HSSCo | | Zylinderschaft | | TiN |
| | HM | | Kegelschaft | | TiAlN |

| N° | Werkstoff | Kaltleiter | Härte | 3 x D | | 5 x D | | 8 x D | | 10/12 x D | | 15 x D | | 20 x D | | 30 x D | | | | | |
|--------|---|------------|-------|---------|---|---------|-------|---------|-------|-----------|-------|---------|-------|---------|-------|---------|-------|--------|----|--------|----|
| | | | | Familie | Seite | Familie | Seite | Familie | Seite | Familie | Seite | Familie | Seite | Familie | Seite | Familie | Seite | | | | |
| 7 | Rostfreier Cr-Mo-Stahl, ferritisch und martensitisch. Säurebeständiger Stahl | ≤ 850 | | 630.63 | 9 | 640.63 | 11 | 650.63 | 12 | 660.63 | 13 | 670.63 | 14 | 680.63 | 15 | 690.63 | 16 | | | | |
| | | | | 610.63 | 8 | 620.63 | 10 | 250.30 | 65 | 184.43 | 29 | 124.40 | 33 | 125.40 | 34 | 126.40 | 35 | | | | |
| | | | | 100.60 | 17 | 105.60 | 18 | | | 184.44 | 31 | | | | | | | | | | |
| | | | | 185.43 | 19 | 183.43 | 23 | | | 182.40 | 51 | | | | | | | | | | |
| | | | | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | | | | | |
| | | | | 100.40 | 37 | 181.40 | 27 | | | | | | | | | | | | | | |
| | | | | | | 180.40 | 43 | | | | | | | | | | | | | | |
| | | | | | | 192.40 | 62 | | | | | | | | | | | | | | |
| | | | | 8 | Rostfreier, austenitischer Cr-Ni-Stahl hitzebeständig | ≤ 850 | | 630.63 | 9 | 640.63 | 11 | 650.63 | 12 | 660.63 | 13 | 670.63 | 14 | 680.63 | 15 | 690.63 | 16 |
| | | | | | | | | 610.63 | 8 | 620.63 | 10 | | | 184.43 | 29 | 124.40 | 33 | 125.40 | 34 | 126.40 | 35 |
| 100.60 | 17 | 105.60 | 18 | | | | | | | 184.44 | 31 | | | | | | | | | | |
| 185.43 | 19 | 183.43 | 23 | | | | | | | 182.40 | 51 | | | | | | | | | | |
| 185.44 | 21 | 183.44 | 25 | | | | | | | | | | | | | | | | | | |
| 100.40 | 37 | 181.40 | 27 | | | | | | | | | | | | | | | | | | |
| | | 180.40 | 43 | | | | | | | | | | | | | | | | | | |
| | | 192.40 | 62 | | | | | | | | | | | | | | | | | | |
| 9 | Rostfreier martensitisch Stähle. Gehärteter Stahl | 45-63 HRC | | | | | | 630.63 | 9 | 640.63 | 11 | 650.63 | 12 | 660.63 | 13 | 670.63 | 14 | 680.63 | 15 | 690.63 | 16 |
| | | | | | | | | 610.63 | 8 | 620.63 | 10 | | | | | | | | | | |
| 10 | Speziallegierungen: Nimonic, Hastelloy, Inconel, Monel usw. Titan und seine Legierungen | | | 630.63 | 9 | 640.63 | 11 | 650.63 | 12 | 660.63 | 13 | 670.63 | 14 | 680.63 | 15 | 690.63 | 16 | | | | |
| | | | | 610.63 | 8 | 620.63 | 10 | | | 184.43 | 29 | 124.40 | 33 | 125.40 | 34 | 126.40 | 35 | | | | |
| | | | | 100.60 | 17 | 105.60 | 18 | | | 184.44 | 31 | | | | | | | | | | |
| | | | | 185.43 | 19 | 183.43 | 23 | | | 182.40 | 51 | | | | | | | | | | |
| | | | | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | | | | | |
| | | | | 100.40 | 37 | 181.40 | 27 | | | | | | | | | | | | | | |
| | | | | | | 180.40 | 43 | | | | | | | | | | | | | | |
| | | | | | | 192.40 | 62 | | | | | | | | | | | | | | |
| | | | | 11 | Federstahl | >1.300 | | 630.63 | 9 | 640.63 | 11 | 650.63 | 12 | 660.63 | 13 | 670.63 | 14 | 680.63 | 15 | 690.63 | 16 |
| | | | | | | | | 610.63 | 8 | 620.63 | 10 | | | | | | | | | | |
| 12 | Manganstahl | >1.300 | | 630.63 | 9 | 640.63 | 11 | 650.63 | 12 | 660.63 | 13 | 670.63 | 14 | 680.63 | 15 | 690.63 | 16 | | | | |
| | | | | 610.63 | 8 | 620.63 | 10 | | | | | | | | | | | | | | |
| 13.1 | Guss: Grauguss: GG Sphäroguss: GGG | < 250 HB | | 630.63 | 9 | 640.63 | 11 | 650.63 | 12 | 660.63 | 13 | 670.63 | 14 | 680.63 | 15 | 690.63 | 16 | | | | |
| | | | | 610.63 | 8 | 620.63 | 10 | 250.30* | 65 | 184.43 | 29 | 124.40 | 33 | 125.40 | 34 | 126.40 | 35 | | | | |
| | | | | 100.60 | 17 | 105.60 | 18 | 138.30 | 64 | 184.44 | 31 | 124.30 | 55 | 125.30 | 56 | 126.30 | 57 | | | | |
| | | | | 185.43 | 19 | 183.43 | 23 | 136.30 | 63 | 182.40 | 51 | 144.30 | 69 | 122.30 | 53 | 123.30 | 54 | | | | |
| | | | | 185.44 | 21 | 183.44 | 25 | | | | | 118.30 | 50 | 121.30 | 52 | | | | | | |
| | | | | 100.40 | 37 | 105.34 | 41 | | | | | 143.30 | 68 | 142.30 | 67 | | | | | | |
| | | | | | | 180.40 | 43 | | | | | 115.30 | 49 | | | | | | | | |
| | | | | | | 192.40 | 62 | | | | | 141.30 | 66 | | | | | | | | |
| | | | | | | 109.30 | 47 | | | | | | | | | | | | | | |
| | | | | | | 105.30 | 36 | | | | | | | | | | | | | | |
| 13.2 | Temperguss: GTW-GTS | < 350 HB | | 100.30 | 36 | 130.34 | 60 | | | | | | | | | | | | | | |
| | | | | | | 180.40 | 43 | | | | | | | | | | | | | | |
| 14 | Gehärteter Guss | > 350 HB | | 630.63 | 9 | 640.63 | 11 | 650.63 | 12 | 660.63 | 13 | 670.63 | 14 | 680.63 | 15 | 690.63 | 16 | | | | |
| | | | | 610.63 | 8 | 620.63 | 10 | | | | | | | | | | | | | | |
| 15 | Spröde Messig | | | 100.60 | 17 | 105.60 | 18 | | | | | | | | | | | | | | |
| | | | | | | 107.30 | 45 | | | | | | | | | | | | | | |
| | | | | 100.60 | 17 | 105.60 | 18 | | | | | | | | | | | | | | |
| | | | | 185.43 | 19 | 183.43 | 23 | | | | | | | | | | | | | | |
| 16 | Ääher Messig | | | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | | | | | |
| | | | | | | 105.34 | 41 | | | | | | | | | | | | | | |
| | | | | | | 130.34 | 60 | | | | | | | | | | | | | | |
| | | | | | | 181.40 | 27 | | | | | | | | | | | | | | |
| 17 | Hochfester Spezialmessing | | | 185.43 | 19 | 183.43 | 23 | | | 184.43 | 29 | 124.40 | 33 | 125.40 | 34 | 126.40 | 35 | | | | |
| | | | | 185.44 | 21 | 183.44 | 25 | | | 184.44 | 31 | | | | | | | | | | |
| | | | | | | 105.34 | 41 | | | | | | | | | | | | | | |
| | | | | | | 130.34 | 60 | | | | | | | | | | | | | | |

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| HSS | mit Kühlkanalen | ohne Beschichtung |
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| N° | Werkstoff | 3 x D | | 5 x D | | 8 x D | | 10/12 x D | | 15 x D | | 20 x D | | 30 x D | |
|---|--|---------|--------|---------|--------|---------|--------|-----------|--------|---------|--------|---------|--------|---------|-------|
| | | Familie | Seite | Familie | Seite | Familie | Seite | Familie | Seite | Familie | Seite | Familie | Seite | Familie | Seite |
| NICHTEISENWERKSTOFFE | 18 Reines Kupfer | 100.60 | 17 | 105.60 | 18 | | | 184.43 | 29 | | | | | | |
| | | 185.43 | 19 | 183.43 | 23 | | | 184.44 | 31 | | | | | | |
| | | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | |
| | | | | 108.30 | 46 | | | | | | | | | | |
| | | | | 111.30 | 48 | | | | | | | | | | |
| | 19 Kupfer-Nickel, Kupfer-Zink, Kupfer-Magnesium, Kupfer-Siliziumlegierungen | 100.60 | 17 | 105.60 | 18 | | | 184.43 | 29 | | | | | | |
| | | 185.43 | 19 | 183.43 | 23 | | | 184.44 | 31 | | | | | | |
| | | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | |
| | | | | 105.34 | 41 | | | | | | | | | | |
| | | | | 130.34 | 60 | | | | | | | | | | |
| 20 Cu-Zn-Pb, Kupfer-Aluminium, Kupfer-Berylliumlegierungen | 100.60 | 17 | 105.60 | 18 | | | 184.43 | 29 | | | | | | | |
| | 185.43 | 19 | 183.43 | 23 | | | 184.44 | 31 | | | | | | | |
| | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | | |
| | | | 105.34 | 41 | | | | | | | | | | | |
| | | | 130.34 | 60 | | | | | | | | | | | |
| 21 Zinc und Zinklegierungen (Zamak) | 100.60 | 17 | 105.60 | 18 | | | 184.44 | 31 | | | | | | | |
| | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | | |
| | | | 107.30 | 45 | | | | | | | | | | | |
| | | | 108.30 | 46 | | | | | | | | | | | |
| | | | 111.30 | 48 | | | | | | | | | | | |
| 22 Magnesiumlegierungen | 100.60 | 17 | 105.60 | 18 | | | | | | | | | | | |
| | | | 107.30 | 45 | | | | | | | | | | | |
| | | | 108.30 | 46 | | | | | | | | | | | |
| | | | 111.30 | 48 | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| 23 Reines Aluminium und Aluminiumlegierungen | 100.60 | 17 | 105.60 | 18 | 138.30 | 64 | 118.30 | 50 | 124.30 | 55 | 125.30 | 56 | 126.30 | 57 | |
| | | | 108.30 | 46 | | | 143.30 | 68 | 144.30 | 69 | 122.30 | 53 | | | |
| | | | 111.30 | 48 | | | | | | | | | | | |
| | | | 109.30 | 47 | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| 24 24.1 Schmelzlegierungen AlSi <10%Si | 100.60 | 17 | 105.60 | 18 | | | 184.43 | 29 | | | | | | | |
| | 185.43 | 19 | 183.43 | 23 | | | 184.44 | 31 | | | | | | | |
| | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | | |
| | | | 108.30 | 46 | | | | | | | | | | | |
| | | | 111.30 | 48 | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| 24 24.2 Schmelzlegierungen AlSi 10-14%Si | 100.60 | 17 | 105.60 | 18 | | | 184.43 | 29 | | | | | | | |
| | 185.43 | 19 | 183.43 | 23 | | | 184.44 | 31 | | | | | | | |
| | 185.44 | 21 | 183.44 | 25 | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| 25 Thermoplaste (weiche Kunststoffe) wie PVC, Plexiglas, Zulluloid, Nylon, Polystyren | 185.44 | 21 | 183.44 | 25 | 138.30 | 64 | 184.44 | 31 | 124.30 | 55 | 125.30 | 56 | 126.30 | 57 | |
| | 100.60 | 17 | 105.60 | 18 | | | 118.30 | 50 | 144.30 | 69 | 122.30 | 53 | | | |
| | | | 109.30 | 47 | | | 143.30 | 68 | | | | | | | |
| | | | 107.30 | 45 | | | | | | | | | | | |
| | | | 108.30 | 46 | | | | | | | | | | | |
| | | | 111.30 | 48 | | | | | | | | | | | |
| NICHTMETALLISCHE WERKSTOFFE | 26 Kunststoffe mit organischer Füllung. Gepresste Platten, Pappe.. | 100.60 | 17 | 105.60 | 18 | 136.30 | 63 | 115.30 | 49 | | | | | | |
| | | 100.30 | 36 | 105.34 | 41 | | | | | | | | | | |
| | | | | 130.34 | 60 | | | | | | | | | | |
| | | | | 105.30 | 39 | | | | | | | | | | |
| | | | | 130.30 | 58 | | | | | | | | | | |
| | | | | 107.30 | 45 | | | | | | | | | | |
| | | | | 108.30 | 46 | | | | | | | | | | |
| | | | | 111.30 | 48 | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |
| 27 Hartkautschuk (Ebonit, Vulkanit). Kunstharze (Bakelit, Galalith, Erynoide-Kunstthorn) | 100.60 | 17 | 105.60 | 18 | | | | | | | | | | | |
| | | | 107.30 | 45 | | | | | | | | | | | |
| 28 Wärmebeständige | 100.60 | 17 | 105.60 | 18 | | | | | | | | | | | |
| 29 Graphit | | | 105.34 | 41 | | | | | | | | | | | |
| | | | 130.34 | 60 | | | | | | | | | | | |
| | | | 107.30 | 45 | | | | | | | | | | | |
| 30 Faserzement, Schiefer, Marmor | 100.60 | 17 | 105.60 | 18 | | | | | | | | | | | |