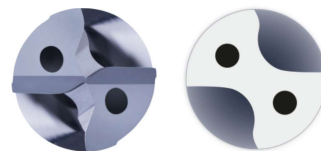


# Inovatoools **DEEPMAX**

**Mit dem Inovatoools DEEPMAX und seiner optimierten Schneidkantenpräparation, speziellen Nutform für sichere Spanabfuhr, definierten Spanraumgeometrie mit Kernverlauf und maximalen Standzeit, garantieren wir für eine Spitzenqualität! Die neu entwickelte Ausspitzung sorgt für idealen Spanbruch und erzielt niedrige Schnittkräfte und ruhigen Lauf.**

*With the Inovatoools DEEPMAX and its optimized cutting edge preparation, special flute design for safe chip removal, defined flute geometry with core profile and maximum tool life, we guarantee top quality! The newly developed drill tip ensures ideal chip breaking and achieves low cutting forces and a smooth run.*

*Avec le DEEPMAX Inovatoools et ses préparations d'arêtes de coupe optimisées, la forme spéciale des goujures pour une évacuation fiable des copeaux, une géométrie définie du logement de copeaux avec profil central et durée de vie maximale, nous garantissons une qualité de pointe ! L'amincissement nouvellement développé permet un bris du copeau optimal, obtient un faible besoin de puissance de coupe et une très bonne stabilité du foret.*



Querschnitt: Spanraum  
Cross section: chipping flute  
Coupe transversale :  
logement de copeaux



**TIEFLOCHBOHREN**

**DEEP HOLE DRILLING / PERCAGE TROUS PROFONDS**

**InoTV** 



**Tieflochbohren der neuen Generation**

*Deep hole drilling of a new generation*

*Perçage de trous profonds de la nouvelle génération*





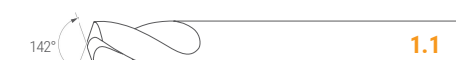
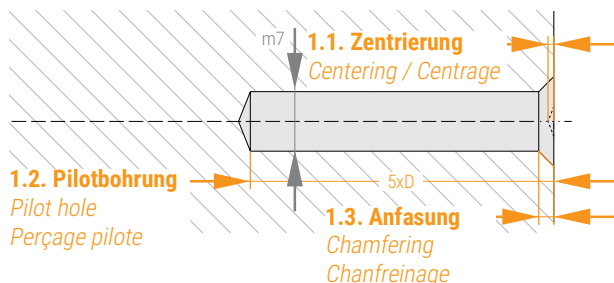
## Anleitung Tieflochbohren

Deep hole drilling instruction / Guide pour perçages profonds

### 1. Pilotbohrung (empfohlen ab 8xD, zwingend erforderlich ab 15xD)

Pilot hole (recommended from 8xD, mandatory from 15xD)

Perçage pilote (recommandé à partir de 8xD, obligatoire à partir de 15xD)



1.1

Art.-Nr.: 814



1.2

Art.-Nr.: 705/505/ 753



1.3

Art.-Nr.: 790/793/903

### 1.4 Die Pilotbohrung muss vor dem Tieflochbohren von Spänen komplett befreit werden

The pilot hole must be completely cleared of chips before deep hole drilling

Le perçage pilote doit être nettoyé de tout copeau avant le perçage profond

## 2. Tieflochbohrung

Deep hole / Perçage de trous profonds

Wir empfehlen den Prozess mit unseren INOCUT Schnittdaten ohne Entspannen (Lüften) durchzuführen.

Bis 30xD ist generell kein Rückzug notwendig. Falls das Entspannen trotzdem erforderlich ist, dann empfiehlt sich ein Rückzugsweg bis 3xD. Bei Kreuzbohrungen oder Austritten muss der Vorschub um 50% reduziert werden.

We recommend using our INOCUT cutting data to carry out the process without chip removing process (retreated).

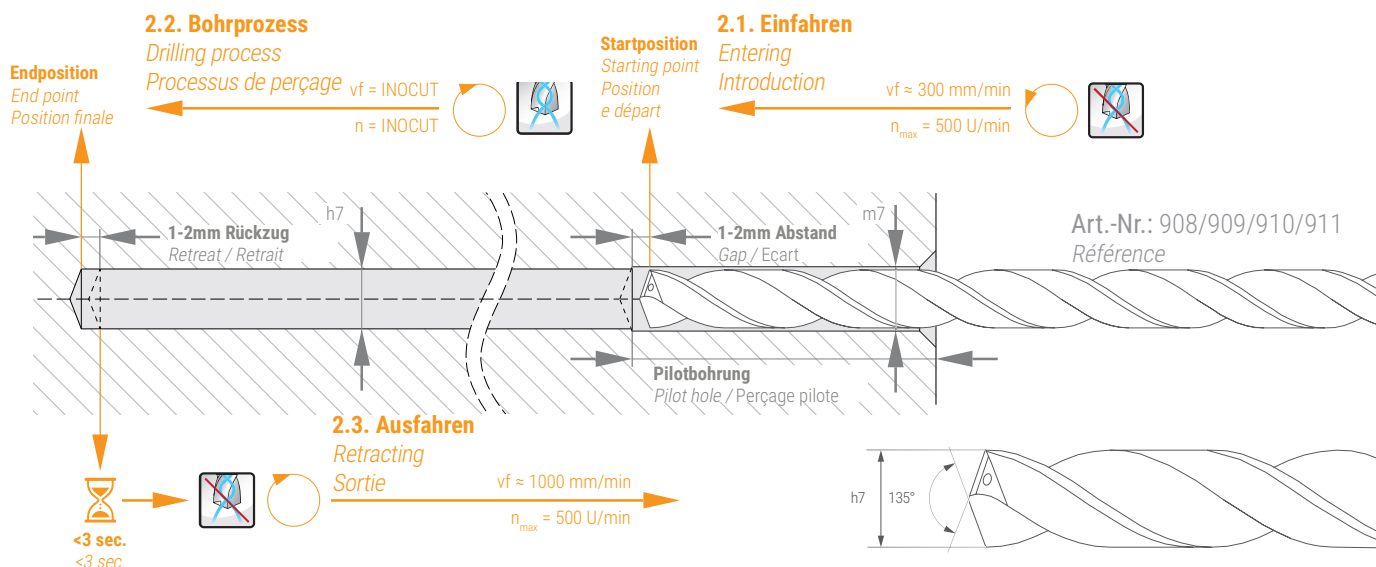
Up to 30xD, retreat is generally not necessary. If you still need to retreat, then we recommend up to 3xD.

In the case of cross holes or exits, the feed must be reduced by 50%.

Nous conseillons d'effectuer le process avec nos valeurs de coupe INOCUT sans débouillage (évacuation des copeaux).

En général, jusqu'à 30xD, un retrait n'est pas nécessaire. Si un débouillage devient nécessaire, un retrait jusqu'à 3xD est conseillé.

Lors de perçages en croix ou sorties, l'avance doit être réduite de 50%.

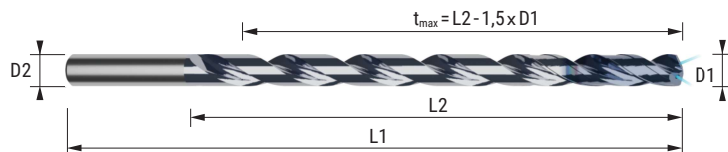


**DEEPMAX Tieflochbohrer**  
Deep hole drill  
Foret pour trous profonds

**HP VHM-Tieflochbohrer Deepmax 15xD mit IK**  
Solid carbide deep-hole drill Deepmax 15xD with IC  
Foret long carbure Deepmax 15xD à trous d'huile

**1<sup>st</sup>**  
**CHOICE**

**908...**



| Werkzeugdaten<br>Tool data / Données d'outils                                     |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   | Werkzeugempfehlung<br>Tool Recommendation / Conseils d'outil                      |                                                                                   |                                                                                   |                                                                                     | Einsatz<br>Capabilities / Utilisation                                               |  |
|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|--|
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| D1<br>h7                                                                          |                                                                                   | Inch                                                                              | D2<br>h6                                                                          |                                                                                   | L2                                                                                |                                                                                   | L1                                                                                |                                                                                   | Artikel-Nr.<br>Article-No.<br>Référence                                           |                                                                                   |                                                                                     |                                                                                     |  |
| 1,000                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 18,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.010.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,100                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 20,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.011.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,200                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 24,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.012.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,300                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 24,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.013.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,400                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 27,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.014.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,500                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 27,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.015.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,600                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 30,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.016.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,700                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 30,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.017.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,800                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 35,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.018.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 1,900                                                                             |                                                                                   | -                                                                                 | 3,00                                                                              |                                                                                   | 35,20                                                                             |                                                                                   | 75                                                                                |                                                                                   | 908.019.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,000                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 35,50                                                                             |                                                                                   | 80                                                                                |                                                                                   | 908.020.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,100                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 40,50                                                                             |                                                                                   | 80                                                                                |                                                                                   | 908.021.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,200                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 40,50                                                                             |                                                                                   | 80                                                                                |                                                                                   | 908.022.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,300                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 40,50                                                                             |                                                                                   | 80                                                                                |                                                                                   | 908.023.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,400                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 45,50                                                                             |                                                                                   | 90                                                                                |                                                                                   | 908.024.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,500                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 45,50                                                                             |                                                                                   | 90                                                                                |                                                                                   | 908.025.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,600                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 48,50                                                                             |                                                                                   | 90                                                                                |                                                                                   | 908.026.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,700                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 48,50                                                                             |                                                                                   | 90                                                                                |                                                                                   | 908.027.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,800                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 50,50                                                                             |                                                                                   | 90                                                                                |                                                                                   | 908.028.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 2,900                                                                             |                                                                                   | -                                                                                 | 4,00                                                                              |                                                                                   | 50,50                                                                             |                                                                                   | 90                                                                                |                                                                                   | 908.029.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,000                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 55,50                                                                             |                                                                                   | 100                                                                               |                                                                                   | 908.030.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,100                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 55,50                                                                             |                                                                                   | 100                                                                               |                                                                                   | 908.031.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,175                                                                             |                                                                                   | 1/8                                                                               | 6,00                                                                              |                                                                                   | 60,50                                                                             |                                                                                   | 100                                                                               |                                                                                   | 908.3175.00                                                                       |                                                                                   |                                                                                     |                                                                                     |  |
| 3,200                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 60,50                                                                             |                                                                                   | 100                                                                               |                                                                                   | 908.032.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,300                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 60,50                                                                             |                                                                                   | 100                                                                               |                                                                                   | 908.033.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,400                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 60,50                                                                             |                                                                                   | 100                                                                               |                                                                                   | 908.034.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,500                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 65,50                                                                             |                                                                                   | 108                                                                               |                                                                                   | 908.035.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,572                                                                             |                                                                                   | 9/64                                                                              | 6,00                                                                              |                                                                                   | 65,50                                                                             |                                                                                   | 100                                                                               |                                                                                   | 908.3572.00                                                                       |                                                                                   |                                                                                     |                                                                                     |  |
| 3,600                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 65,50                                                                             |                                                                                   | 108                                                                               |                                                                                   | 908.036.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,700                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 70,50                                                                             |                                                                                   | 108                                                                               |                                                                                   | 908.037.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,800                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 70,50                                                                             |                                                                                   | 108                                                                               |                                                                                   | 908.038.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,900                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 70,50                                                                             |                                                                                   | 108                                                                               |                                                                                   | 908.039.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 3,969                                                                             |                                                                                   | 5/32                                                                              | 6,00                                                                              |                                                                                   | 75,50                                                                             |                                                                                   | 115                                                                               |                                                                                   | 908.3969.00                                                                       |                                                                                   |                                                                                     |                                                                                     |  |
| 4,000                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 75,50                                                                             |                                                                                   | 120                                                                               |                                                                                   | 908.040.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,100                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 75,50                                                                             |                                                                                   | 120                                                                               |                                                                                   | 908.041.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,200                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 75,50                                                                             |                                                                                   | 120                                                                               |                                                                                   | 908.042.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,300                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 80,50                                                                             |                                                                                   | 120                                                                               |                                                                                   | 908.043.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,400                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 80,50                                                                             |                                                                                   | 120                                                                               |                                                                                   | 908.044.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,500                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 80,50                                                                             |                                                                                   | 120                                                                               |                                                                                   | 908.045.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,600                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 85,50                                                                             |                                                                                   | 125                                                                               |                                                                                   | 908.046.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,700                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 85,50                                                                             |                                                                                   | 125                                                                               |                                                                                   | 908.047.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,763                                                                             |                                                                                   | 3/16                                                                              | 6,00                                                                              |                                                                                   | 90,50                                                                             |                                                                                   | 130                                                                               |                                                                                   | 908.4763.00                                                                       |                                                                                   |                                                                                     |                                                                                     |  |
| 4,800                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 90,50                                                                             |                                                                                   | 140                                                                               |                                                                                   | 908.048.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 4,900                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 90,50                                                                             |                                                                                   | 140                                                                               |                                                                                   | 908.049.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 5,000                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 90,50                                                                             |                                                                                   | 140                                                                               |                                                                                   | 908.050.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 5,100                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 95,50                                                                             |                                                                                   | 140                                                                               |                                                                                   | 908.051.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 5,200                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 95,50                                                                             |                                                                                   | 140                                                                               |                                                                                   | 908.052.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 5,300                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 95,50                                                                             |                                                                                   | 140                                                                               |                                                                                   | 908.053.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 5,400                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 95,50                                                                             |                                                                                   | 140                                                                               |                                                                                   | 908.054.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |
| 5,500                                                                             |                                                                                   | -                                                                                 | 6,00                                                                              |                                                                                   | 100,50                                                                            |                                                                                   | 150                                                                               |                                                                                   | 908.055.00                                                                        |                                                                                   |                                                                                     |                                                                                     |  |



### VHM-Tieflochbohrer Deepmax 15xD mit IK

Solid carbide deep-hole drill Deepmax 15xD with IC

Foret long carbure Deepmax 15xD à trous d'huile



908...



| Werkzeugdaten<br>Tool data / Données d'outils |       |          |        |     |                                         |  | Werkzeugempfehlung<br>Tool Recommendation / Conseils d'outil |  | Einsatz<br>Capabilities / Utilisation |  |
|-----------------------------------------------|-------|----------|--------|-----|-----------------------------------------|--|--------------------------------------------------------------|--|---------------------------------------|--|
| TYP N                                         |       | h7       |        |     |                                         |  |                                                              |  |                                       |  |
| D1<br>h7                                      | Inch  | D2<br>h6 | L2     | L1  | Artikel-Nr.<br>Article-No.<br>Référence |  |                                                              |  |                                       |  |
| 5,556                                         | 7/32  | 6,00     | 100,50 | 145 | 908.5556.00                             |  |                                                              |  |                                       |  |
| 5,600                                         | -     | 6,00     | 100,50 | 150 | 908.056.00                              |  |                                                              |  |                                       |  |
| 5,700                                         | -     | 6,00     | 100,50 | 150 | 908.057.00                              |  |                                                              |  |                                       |  |
| 5,800                                         | -     | 6,00     | 100,50 | 150 | 908.058.00                              |  |                                                              |  |                                       |  |
| 5,900                                         | -     | 6,00     | 100,50 | 150 | 908.059.00                              |  |                                                              |  |                                       |  |
| 6,000                                         | -     | 6,00     | 100,50 | 150 | 908.060.00                              |  |                                                              |  |                                       |  |
| 6,100                                         | -     | 8,00     | 108,00 | 148 | 908.061.00                              |  |                                                              |  |                                       |  |
| 6,200                                         | -     | 8,00     | 108,00 | 148 | 908.062.00                              |  |                                                              |  |                                       |  |
| 6,300                                         | -     | 8,00     | 108,00 | 148 | 908.063.00                              |  |                                                              |  |                                       |  |
| 6,350                                         | 1/4   | 8,00     | 108,00 | 148 | 908.6350.00                             |  |                                                              |  |                                       |  |
| 6,400                                         | -     | 8,00     | 108,00 | 148 | 908.064.00                              |  |                                                              |  |                                       |  |
| 6,500                                         | -     | 8,00     | 121,00 | 160 | 908.065.00                              |  |                                                              |  |                                       |  |
| 6,600                                         | -     | 8,00     | 121,00 | 160 | 908.066.00                              |  |                                                              |  |                                       |  |
| 6,700                                         | -     | 8,00     | 131,00 | 170 | 908.067.00                              |  |                                                              |  |                                       |  |
| 6,800                                         | -     | 8,00     | 131,00 | 170 | 908.068.00                              |  |                                                              |  |                                       |  |
| 6,900                                         | -     | 8,00     | 131,00 | 170 | 908.069.00                              |  |                                                              |  |                                       |  |
| 7,000                                         | -     | 8,00     | 131,00 | 170 | 908.070.00                              |  |                                                              |  |                                       |  |
| 7,144                                         | 9/32  | 8,00     | 131,00 | 170 | 908.7144.00                             |  |                                                              |  |                                       |  |
| 7,500                                         | -     | 8,00     | 131,00 | 170 | 908.075.00                              |  |                                                              |  |                                       |  |
| 7,800                                         | -     | 8,00     | 141,00 | 180 | 908.078.00                              |  |                                                              |  |                                       |  |
| 7,938                                         | 5/16  | 8,00     | 141,00 | 180 | 908.7938.00                             |  |                                                              |  |                                       |  |
| 8,000                                         | -     | 8,00     | 141,00 | 180 | 908.080.00                              |  |                                                              |  |                                       |  |
| 8,500                                         | -     | 10,00    | 155,00 | 198 | 908.085.00                              |  |                                                              |  |                                       |  |
| 8,731                                         | 11/32 | 10,00    | 165,00 | 208 | 908.8731.00                             |  |                                                              |  |                                       |  |
| 8,800                                         | -     | 10,00    | 165,00 | 208 | 908.088.00                              |  |                                                              |  |                                       |  |
| 9,000                                         | -     | 10,00    | 165,00 | 208 | 908.090.00                              |  |                                                              |  |                                       |  |
| 9,500                                         | -     | 10,00    | 165,00 | 208 | 908.095.00                              |  |                                                              |  |                                       |  |
| 9,525                                         | 3/8   | 10,00    | 165,00 | 208 | 908.9525.00                             |  |                                                              |  |                                       |  |
| 9,800                                         | -     | 10,00    | 165,00 | 208 | 908.098.00                              |  |                                                              |  |                                       |  |
| 10,000                                        | -     | 10,00    | 175,00 | 218 | 908.100.00                              |  |                                                              |  |                                       |  |
| 10,200                                        | -     | 12,00    | 187,00 | 235 | 908.102.00                              |  |                                                              |  |                                       |  |
| 10,319                                        | 13/32 | 12,00    | 187,00 | 235 | 908.10319.00                            |  |                                                              |  |                                       |  |
| 10,500                                        | -     | 12,00    | 197,00 | 245 | 908.105.00                              |  |                                                              |  |                                       |  |
| 10,800                                        | -     | 12,00    | 197,00 | 245 | 908.108.00                              |  |                                                              |  |                                       |  |
| 11,000                                        | -     | 12,00    | 197,00 | 245 | 908.110.00                              |  |                                                              |  |                                       |  |
| 11,113                                        | 7/16  | 12,00    | 197,00 | 245 | 908.11113.00                            |  |                                                              |  |                                       |  |
| 11,200                                        | -     | 12,00    | 197,00 | 245 | 908.112.00                              |  |                                                              |  |                                       |  |
| 11,500                                        | -     | 12,00    | 197,00 | 245 | 908.115.00                              |  |                                                              |  |                                       |  |
| 11,800                                        | -     | 12,00    | 207,00 | 255 | 908.118.00                              |  |                                                              |  |                                       |  |
| 11,906                                        | 15/32 | 12,00    | 207,00 | 255 | 908.11906.00                            |  |                                                              |  |                                       |  |
| 12,000                                        | -     | 12,00    | 207,00 | 255 | 908.120.00                              |  |                                                              |  |                                       |  |



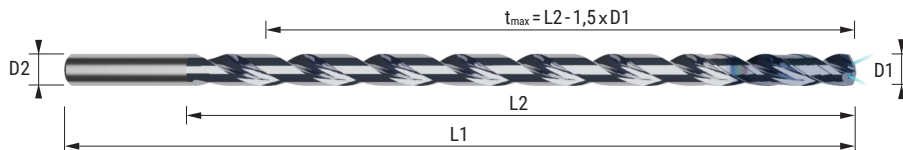
**HP VHM-Tieflochbohrer Deepmax 20xD mit IK**

Solid carbide deep-hole drill Deepmax 20xD with IC

Foret long carbure Deepmax 20xD à trous d'huile



909...



| Werkzeugdaten<br>Tool data / Données d'outils |       |          |        |     |                                         | Werkzeugempfehlung<br>Tool Recommendation / Conseils d'outil |  | Einsatz<br>Capabilities / Utilisation |  |
|-----------------------------------------------|-------|----------|--------|-----|-----------------------------------------|--------------------------------------------------------------|--|---------------------------------------|--|
| TYP N                                         |       | h7       |        |     |                                         |                                                              |  |                                       |  |
| D1<br>h7                                      | Inch  | D2<br>h6 | L2     | L1  | Artikel-Nr.<br>Article-No.<br>Référence |                                                              |  |                                       |  |
| 2,000                                         | -     | 4,00     | 45,50  | 95  | 909.020.00                              |                                                              |  |                                       |  |
| 2,100                                         | -     | 4,00     | 50,50  | 95  | 909.021.00                              |                                                              |  |                                       |  |
| 2,200                                         | -     | 4,00     | 50,50  | 95  | 909.022.00                              |                                                              |  |                                       |  |
| 2,300                                         | -     | 4,00     | 55,50  | 95  | 909.023.00                              |                                                              |  |                                       |  |
| 2,400                                         | -     | 4,00     | 55,50  | 95  | 909.024.00                              |                                                              |  |                                       |  |
| 2,500                                         | -     | 4,00     | 60,50  | 108 | 909.025.00                              |                                                              |  |                                       |  |
| 2,600                                         | -     | 4,00     | 60,50  | 108 | 909.026.00                              |                                                              |  |                                       |  |
| 2,700                                         | -     | 4,00     | 65,50  | 108 | 909.027.00                              |                                                              |  |                                       |  |
| 2,800                                         | -     | 4,00     | 65,50  | 108 | 909.028.00                              |                                                              |  |                                       |  |
| 2,900                                         | -     | 4,00     | 68,50  | 112 | 909.029.00                              |                                                              |  |                                       |  |
| 3,000                                         | -     | 6,00     | 68,50  | 112 | 909.030.00                              |                                                              |  |                                       |  |
| 3,175                                         | 1/8   | 6,00     | 75,50  | 120 | 909.3175.00                             |                                                              |  |                                       |  |
| 3,200                                         | -     | 6,00     | 75,50  | 120 | 909.032.00                              |                                                              |  |                                       |  |
| 3,300                                         | -     | 6,00     | 75,50  | 120 | 909.033.00                              |                                                              |  |                                       |  |
| 3,500                                         | -     | 6,00     | 80,50  | 130 | 909.035.00                              |                                                              |  |                                       |  |
| 3,572                                         | 9/64  | 6,00     | 80,50  | 130 | 909.3572.00                             |                                                              |  |                                       |  |
| 3,800                                         | -     | 6,00     | 90,50  | 140 | 909.038.00                              |                                                              |  |                                       |  |
| 3,969                                         | 5/32  | 6,00     | 95,50  | 140 | 909.3969.00                             |                                                              |  |                                       |  |
| 4,000                                         | -     | 6,00     | 95,50  | 140 | 909.040.00                              |                                                              |  |                                       |  |
| 4,200                                         | -     | 6,00     | 95,50  | 140 | 909.042.00                              |                                                              |  |                                       |  |
| 4,500                                         | -     | 6,00     | 110,50 | 160 | 909.045.00                              |                                                              |  |                                       |  |
| 4,600                                         | -     | 6,00     | 110,50 | 160 | 909.046.00                              |                                                              |  |                                       |  |
| 4,763                                         | 3/16  | 6,00     | 115,50 | 160 | 909.4763.00                             |                                                              |  |                                       |  |
| 4,800                                         | -     | 6,00     | 115,50 | 160 | 909.048.00                              |                                                              |  |                                       |  |
| 5,000                                         | -     | 6,00     | 115,50 | 160 | 909.050.00                              |                                                              |  |                                       |  |
| 5,500                                         | -     | 6,00     | 140,50 | 185 | 909.055.00                              |                                                              |  |                                       |  |
| 5,556                                         | 7/32  | 6,00     | 140,50 | 185 | 909.5556.00                             |                                                              |  |                                       |  |
| 5,800                                         | -     | 6,00     | 140,50 | 185 | 909.058.00                              |                                                              |  |                                       |  |
| 6,000                                         | -     | 6,00     | 140,50 | 185 | 909.060.00                              |                                                              |  |                                       |  |
| 6,350                                         | 1/4   | 8,00     | 150,00 | 190 | 909.6350.00                             |                                                              |  |                                       |  |
| 6,500                                         | -     | 8,00     | 150,00 | 190 | 909.065.00                              |                                                              |  |                                       |  |
| 6,800                                         | -     | 8,00     | 160,00 | 200 | 909.068.00                              |                                                              |  |                                       |  |
| 7,000                                         | -     | 8,00     | 170,00 | 210 | 909.070.00                              |                                                              |  |                                       |  |
| 7,144                                         | 9/32  | 8,00     | 170,00 | 210 | 909.7144.00                             |                                                              |  |                                       |  |
| 7,500                                         | -     | 8,00     | 170,00 | 210 | 909.075.00                              |                                                              |  |                                       |  |
| 7,800                                         | -     | 8,00     | 190,00 | 230 | 909.078.00                              |                                                              |  |                                       |  |
| 7,938                                         | 5/16  | 8,00     | 190,00 | 230 | 909.7938.00                             |                                                              |  |                                       |  |
| 8,000                                         | -     | 8,00     | 190,00 | 230 | 909.080.00                              |                                                              |  |                                       |  |
| 8,500                                         | -     | 10,00    | 196,00 | 240 | 909.085.00                              |                                                              |  |                                       |  |
| 8,731                                         | 11/32 | 10,00    | 216,00 | 260 | 909.8731.00                             |                                                              |  |                                       |  |
| 8,800                                         | -     | 10,00    | 216,00 | 260 | 909.088.00                              |                                                              |  |                                       |  |
| 9,000                                         | -     | 10,00    | 216,00 | 260 | 909.090.00                              |                                                              |  |                                       |  |
| 9,525                                         | 3/8   | 10,00    | 236,00 | 280 | 909.9525.00                             |                                                              |  |                                       |  |
| 9,800                                         | -     | 10,00    | 236,00 | 280 | 909.098.00                              |                                                              |  |                                       |  |
| 10,000                                        | -     | 10,00    | 236,00 | 280 | 909.100.00                              |                                                              |  |                                       |  |
| 10,200                                        | -     | 12,00    | 241,00 | 290 | 909.102.00                              |                                                              |  |                                       |  |
| 10,319                                        | 13/32 | 12,00    | 241,00 | 290 | 909.10319.00                            |                                                              |  |                                       |  |
| 10,800                                        | -     | 12,00    | 266,00 | 315 | 909.108.00                              |                                                              |  |                                       |  |
| 11,113                                        | 7/16  | 12,00    | 266,00 | 315 | 909.11113.00                            |                                                              |  |                                       |  |
| 11,800                                        | -     | 12,00    | 266,00 | 315 | 909.118.00                              |                                                              |  |                                       |  |
| 11,906                                        | 15/32 | 12,00    | 266,00 | 315 | 909.11906.00                            |                                                              |  |                                       |  |
| 12,000                                        | -     | 12,00    | 266,00 | 315 | 909.120.00                              |                                                              |  |                                       |  |

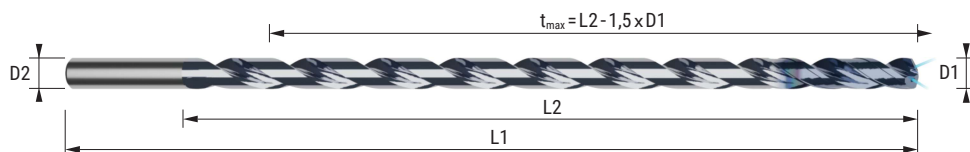
**VHM-Tieflochbohrer Deepmax 25xD mit IK**

Solid carbide deep-hole drill Deepmax 25xD with IC

Foret long carbure Deepmax 25xD à trous d'huile



910...



| Werkzeugdaten<br>Tool data / Données d'outils |       |          | Werkzeugempfehlung<br>Tool Recommendation / Conseils d'outil |     | Einsatz<br>Capabilities / Utilisation   |
|-----------------------------------------------|-------|----------|--------------------------------------------------------------|-----|-----------------------------------------|
| TYP N                                         |       |          |                                                              |     |                                         |
|                                               |       |          |                                                              |     |                                         |
| D1<br>h7                                      | Inch  | D2<br>h6 | L2                                                           | L1  | Artikel-Nr.<br>Article-No.<br>Référence |
| 3,000                                         | -     | 6,00     | 85,50                                                        | 130 | 910.030.00                              |
| 3,175                                         | 1/8   | 6,00     | 95,50                                                        | 140 | 910.3175.00                             |
| 3,200                                         | -     | 6,00     | 95,50                                                        | 140 | 910.032.00                              |
| 3,300                                         | -     | 6,00     | 95,50                                                        | 140 | 910.033.00                              |
| 3,500                                         | -     | 6,00     | 100,50                                                       | 150 | 910.035.00                              |
| 3,572                                         | 9/64  | 6,00     | 100,50                                                       | 150 | 910.3572.00                             |
| 3,800                                         | -     | 6,00     | 105,50                                                       | 150 | 910.038.00                              |
| 3,969                                         | 5/32  | 6,00     | 110,50                                                       | 160 | 910.3969.00                             |
| 4,000                                         | -     | 6,00     | 110,50                                                       | 160 | 910.040.00                              |
| 4,200                                         | -     | 6,00     | 120,50                                                       | 170 | 910.042.00                              |
| 4,500                                         | -     | 6,00     | 130,50                                                       | 180 | 910.045.00                              |
| 4,763                                         | 3/16  | 6,00     | 140,50                                                       | 190 | 910.4763.00                             |
| 4,800                                         | -     | 6,00     | 140,50                                                       | 190 | 910.048.00                              |
| 5,000                                         | -     | 6,00     | 140,50                                                       | 190 | 910.050.00                              |
| 5,500                                         | -     | 6,00     | 160,50                                                       | 210 | 910.055.00                              |
| 5,556                                         | 7/32  | 6,00     | 160,50                                                       | 210 | 910.5556.00                             |
| 5,800                                         | -     | 6,00     | 160,50                                                       | 210 | 910.058.00                              |
| 6,000                                         | -     | 6,00     | 170,50                                                       | 220 | 910.060.00                              |
| 6,350                                         | 1/4   | 8,00     | 191,00                                                       | 230 | 910.6350.00                             |
| 6,500                                         | -     | 8,00     | 191,00                                                       | 230 | 910.065.00                              |
| 6,800                                         | -     | 8,00     | 191,00                                                       | 230 | 910.068.00                              |
| 7,000                                         | -     | 8,00     | 201,00                                                       | 240 | 910.070.00                              |
| 7,144                                         | 9/32  | 8,00     | 201,00                                                       | 240 | 910.7144.00                             |
| 7,500                                         | -     | 8,00     | 214,00                                                       | 250 | 910.075.00                              |
| 7,800                                         | -     | 8,00     | 224,00                                                       | 260 | 910.078.00                              |
| 7,938                                         | 5/16  | 8,00     | 224,00                                                       | 260 | 910.7938.00                             |
| 8,000                                         | -     | 8,00     | 224,00                                                       | 260 | 910.080.00                              |
| 8,500                                         | -     | 10,00    | 237,00                                                       | 280 | 910.085.00                              |
| 8,731                                         | 11/32 | 10,00    | 247,00                                                       | 290 | 910.8731.00                             |
| 8,800                                         | -     | 10,00    | 247,00                                                       | 290 | 910.088.00                              |
| 9,000                                         | -     | 10,00    | 247,00                                                       | 290 | 910.090.00                              |
| 9,500                                         | -     | 10,00    | 267,00                                                       | 310 | 910.095.00                              |
| 9,525                                         | 3/8   | 10,00    | 267,00                                                       | 310 | 910.9525.00                             |
| 9,800                                         | -     | 10,00    | 267,00                                                       | 310 | 910.098.00                              |
| 10,000                                        | -     | 10,00    | 267,00                                                       | 310 | 910.100.00                              |
| 10,200                                        | -     | 12,00    | 292,00                                                       | 340 | 910.102.00                              |
| 10,319                                        | 13/32 | 12,00    | 292,00                                                       | 340 | 910.10319.00                            |
| 10,800                                        | -     | 12,00    | 302,00                                                       | 350 | 910.108.00                              |
| 11,113                                        | 7/16  | 12,00    | 302,00                                                       | 350 | 910.11113.00                            |
| 11,800                                        | -     | 12,00    | 327,00                                                       | 375 | 910.118.00                              |
| 11,906                                        | 15/32 | 12,00    | 327,00                                                       | 375 | 910.11906.00                            |
| 12,000                                        | -     | 12,00    | 327,00                                                       | 375 | 910.120.00                              |



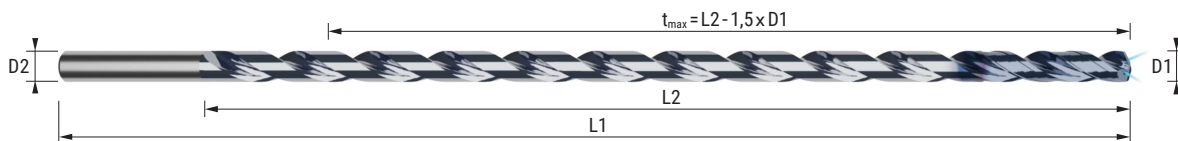
## VHM-Tieflochbohrer Deepmax 30xD mit IK

Solid carbide deep-hole drill Deepmax 30xD with IC

Foret long carbure Deepmax 30xD à trous d'huile



911...



| Werkzeugdaten<br>Tool data / Données d'outils |       |          |        | Werkzeugempfehlung<br>Tool Recommendation / Conseils d'outil |                                         | Einsatz<br>Capabilities / Utilisation |
|-----------------------------------------------|-------|----------|--------|--------------------------------------------------------------|-----------------------------------------|---------------------------------------|
| TYP N                                         |       |          |        |                                                              |                                         |                                       |
| D1<br>h7                                      | Inch  | D2<br>h6 | L2     | L1                                                           | Artikel-Nr.<br>Article-No.<br>Référence |                                       |
| 2,000                                         | -     | 4,00     | 65,50  | 105                                                          | 911.020.00                              |                                       |
| 2,200                                         | -     | 4,00     | 75,50  | 115                                                          | 911.022.00                              |                                       |
| 2,300                                         | -     | 4,00     | 75,50  | 115                                                          | 911.023.00                              |                                       |
| 2,400                                         | -     | 4,00     | 85,50  | 130                                                          | 911.024.00                              |                                       |
| 2,500                                         | -     | 4,00     | 85,50  | 130                                                          | 911.025.00                              |                                       |
| 2,700                                         | -     | 4,00     | 95,50  | 140                                                          | 911.027.00                              |                                       |
| 2,800                                         | -     | 4,00     | 95,50  | 140                                                          | 911.028.00                              |                                       |
| 2,900                                         | -     | 4,00     | 95,50  | 140                                                          | 911.029.00                              |                                       |
| 3,000                                         | -     | 6,00     | 105,50 | 150                                                          | 911.030.00                              |                                       |
| 3,175                                         | 1/8   | 6,00     | 105,50 | 150                                                          | 911.3175.00                             |                                       |
| 3,200                                         | -     | 6,00     | 105,50 | 150                                                          | 911.032.00                              |                                       |
| 3,300                                         | -     | 6,00     | 115,50 | 160                                                          | 911.033.00                              |                                       |
| 3,500                                         | -     | 6,00     | 115,50 | 160                                                          | 911.035.00                              |                                       |
| 3,572                                         | 9/64  | 6,00     | 115,50 | 160                                                          | 911.3572.00                             |                                       |
| 3,800                                         | -     | 6,00     | 125,50 | 175                                                          | 911.038.00                              |                                       |
| 3,969                                         | 5/32  | 6,00     | 135,50 | 185                                                          | 911.3969.00                             |                                       |
| 4,000                                         | -     | 6,00     | 135,50 | 185                                                          | 911.040.00                              |                                       |
| 4,200                                         | -     | 6,00     | 135,50 | 185                                                          | 911.042.00                              |                                       |
| 4,500                                         | -     | 6,00     | 145,50 | 195                                                          | 911.045.00                              |                                       |
| 4,600                                         | -     | 6,00     | 155,50 | 205                                                          | 911.046.00                              |                                       |
| 4,763                                         | 3/16  | 6,00     | 165,50 | 210                                                          | 911.4763.00                             |                                       |
| 4,800                                         | -     | 6,00     | 165,50 | 210                                                          | 911.048.00                              |                                       |
| 5,000                                         | -     | 6,00     | 165,50 | 210                                                          | 911.050.00                              |                                       |
| 5,500                                         | -     | 6,00     | 180,50 | 240                                                          | 911.055.00                              |                                       |
| 5,556                                         | 7/32  | 6,00     | 180,50 | 240                                                          | 911.5556.00                             |                                       |
| 5,800                                         | -     | 6,00     | 190,50 | 240                                                          | 911.058.00                              |                                       |
| 6,000                                         | -     | 6,00     | 190,50 | 240                                                          | 911.060.00                              |                                       |
| 6,350                                         | 1/4   | 8,00     | 222,00 | 260                                                          | 911.6350.00                             |                                       |
| 6,500                                         | -     | 8,00     | 222,00 | 260                                                          | 911.065.00                              |                                       |
| 6,800                                         | -     | 8,00     | 222,00 | 260                                                          | 911.068.00                              |                                       |
| 7,000                                         | -     | 8,00     | 232,00 | 270                                                          | 911.070.00                              |                                       |
| 7,144                                         | 9/32  | 8,00     | 232,00 | 270                                                          | 911.7144.00                             |                                       |
| 7,500                                         | -     | 8,00     | 252,00 | 290                                                          | 911.075.00                              |                                       |
| 7,800                                         | -     | 8,00     | 262,00 | 300                                                          | 911.078.00                              |                                       |
| 7,938                                         | 5/16  | 8,00     | 267,00 | 305                                                          | 911.7938.00                             |                                       |
| 8,000                                         | -     | 8,00     | 267,00 | 305                                                          | 911.080.00                              |                                       |
| 8,500                                         | -     | 10,00    | 278,00 | 320                                                          | 911.085.00                              |                                       |
| 8,731                                         | 11/32 | 10,00    | 298,00 | 340                                                          | 911.8731.00                             |                                       |
| 8,800                                         | -     | 10,00    | 298,00 | 340                                                          | 911.088.00                              |                                       |
| 9,000                                         | -     | 10,00    | 298,00 | 340                                                          | 911.090.00                              |                                       |
| 9,500                                         | -     | 10,00    | 318,00 | 360                                                          | 911.095.00                              |                                       |
| 9,525                                         | 3/8   | 10,00    | 318,00 | 360                                                          | 911.9525.00                             |                                       |
| 9,800                                         | -     | 10,00    | 338,00 | 380                                                          | 911.098.00                              |                                       |
| 10,000                                        | -     | 10,00    | 338,00 | 380                                                          | 911.100.00                              |                                       |