



Jongen Werkzeugtechnik

Special Offer

**Set consisting of 5 core hole drills for
M5, M6, M8, M10 and M12 threads**



**Set for only
179,-€**

Jongen Werkzeugtechnik GmbH

Siemensring 11 · 47877 Willich · Germany

Phone: +49 2154 / 9285-2900 · Fax: +49 2154 / 9285-92900

Email: export@jongen.de · Internet: www.jongen.de



SET COMPOSITION

Article	D	AL	N	L	d	Z	IK
VHB 55505*-0420 DR20	4,20	36	31	82	6	2	2
VHB 55505*-0500 DR20	5,00	44	36	82	6	2	2
VHB 55505*-0680 DR20	6,80	53	45	91	8	2	4
VHB 55505*-0850 DR20	8,50	61	52	103	10	2	4
VHB 55505*-1020 DR20	10,20	71	61	118	12	2	4

AL=Settle length / IK = No. of internal cooling channels

* = shank. The sets are available in two different variations:

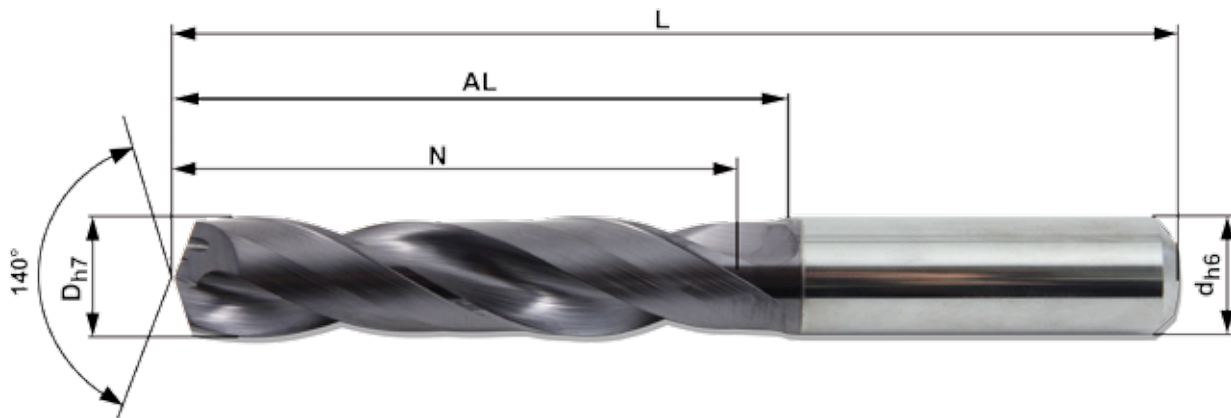
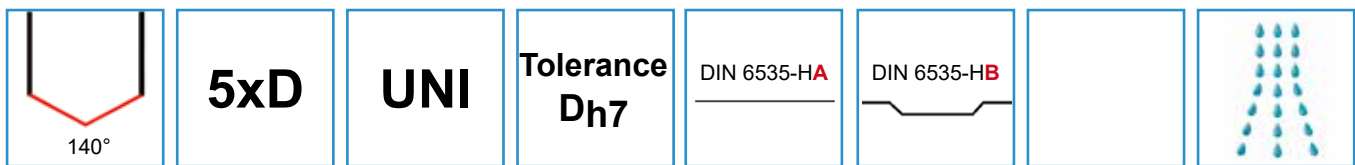
Shank made to DIN 6535-HA (cylindrical)

=> Order-No. of the set: **Set-VHB-5-A-010**

Shank made to DIN 6535-HB (Weldon)

=> Order-No. of the set: **Set-VHB-5-B-020**

TECHNICAL DATA VHB 55505 DR20



PARAMETERS RECOMMENDATION

Material	D [mm]	V _c [m/min]	f [mm/U]	n [min ⁻¹]	V _f [mm/min]
Structural steel Unalloyed steel <800 N/mm ²	4	120 (80 - 140)	0,130 (0,100 - 0,150)	9.550	1.240
	5	120 (80 - 140)	0,150 (0,120 - 0,170)	7.640	1.145
	6	120 (80 - 140)	0,160 (0,130 - 0,180)	6.370	1.020
	8	120 (80 - 140)	0,200 (0,170 - 0,220)	4.770	955
	10	120 (80 - 140)	0,240 (0,210 - 0,260)	3.820	915
Tool steel Heat-treatable steel Alloyed steel 800-1.200 N/mm ²	4	100 (80 - 120)	0,110 (0,080 - 0,130)	7.960	875
	5	100 (80 - 120)	0,130 (0,100 - 0,150)	6.370	830
	6	100 (80 - 120)	0,140 (0,110 - 0,160)	5.310	745
	8	100 (80 - 120)	0,180 (0,150 - 0,200)	3.980	715
	10	100 (80 - 120)	0,200 (0,170 - 0,220)	3.180	635
High grade steel High alloyed steel	4	55 (35 - 75)	0,080 (0,050 - 0,100)	4.380	350
	5	55 (35 - 75)	0,090 (0,060 - 0,110)	3.500	315
	6	55 (35 - 75)	0,100 (0,070 - 0,120)	2.920	290
	8	55 (35 - 75)	0,110 (0,080 - 0,130)	2.190	240
	10	55 (35 - 75)	0,130 (0,100 - 0,150)	1.750	230
Cast iron GG(G)	4	120 (100 - 140)	0,160 (0,130 - 0,180)	9.550	1.530
	5	120 (100 - 140)	0,200 (0,170 - 0,220)	7.640	1.530
	6	120 (100 - 140)	0,230 (0,200 - 0,250)	6.370	1.465
	8	120 (100 - 140)	0,270 (0,240 - 0,290)	4.770	1.290
	10	120 (100 - 140)	0,300 (0,270 - 0,320)	3.820	1.145

For the intermediate sizes the parameters are to be adjusted consequently.

The indicated cutting data are standard values that can change depending on type of processing, machine type and material.

The special offer is valid while stocks last and at market usual order quantities.

Errors, omissions and technical modifications are reserved.