

PAGE 250

DIN
1897

118N - 218NVA (h8)

Ø mm	1~3	3.1~6	6.1~10	10.1~18	18.1~20
tol. D µ	0 / -14	0 / -18	0 / -22	0 / -27	0 / -33



d = D

N

HSS

OX +

118°

25-30°

NH

HSS/CO

HT

130°

30°

D(h8)	I	L		Stock	Stock
mm 1.00	6	26	10	●	●
1.10	7	28	10	●	○
1.20	8	30	10	●	●
1.25	8	30	10	●	○
1.30	8	30	10	●	○
1.40	9	32	10	●	○
1.50	9	32	10	●	●
1.60	10	34	10	●	○
1.70	10	34	10	●	○
1.75	11	36	10	●	○
1.80	11	36	10	●	○
1.90	11	36	10	●	○
2.00	12	38	10	●	●
2.10	12	38	10	●	●
2.20	13	40	10	●	○
2.25	13	40	10	●	○
2.30	13	40	10	●	○
2.40	14	43	10	●	●
2.50	14	43	10	●	●
2.60	14	43	10	●	○
2.70	16	46	10	●	○
2.75	16	46	10	●	○
2.80	16	46	10	●	○
2.90	16	46	10	●	○
3.00	16	46	10	●	●
3.10	18	49	10	●	○
3.20	18	49	10	●	●
3.25	18	49	10	●	●
3.30	18	49	10	●	●
3.40	20	52	10	●	●
3.50	20	52	10	●	●
3.60	20	52	10	●	○
3.70	20	52	10	●	○
3.75	20	52	10	●	○
3.80	22	55	10	●	●
3.90	22	55	10	●	○

* OX ≥ mm. 2

● stock standard ○ non-standard stock ■ stock exhaustion

n **Vf**
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tol. D µ	0 / -14	0 / -18	0 / -22	0 / -27	0 / -33



d = D

N

HSS

OX

118°

25-30°

NH

HSS/CO

HT

130°

30°

D(h8)	I	L		Stock	Stock
mm 4.00	22	55	10	●	●
4.10	22	55	10	●	●
4.20	22	55	10	●	●
4.25	22	55	10	●	●
4.30	24	58	10	●	●
4.40	24	58	10	○	○
4.50	24	58	10	●	●
4.60	24	58	10	●	●
4.70	24	58	10	●	○
4.75	24	58	10	●	○
4.80	26	62	10	●	●
4.90	26	62	10	●	○
5.00	26	62	10	●	●
5.10	26	62	10	●	●
5.20	26	62	10	●	●
5.25	26	62	10	●	○
5.30	26	62	10	●	○
5.40	28	66	10	●	○
5.50	28	66	10	●	●
5.60	28	66	10	●	○
5.70	28	66	10	●	○
5.75	28	66	10	●	○
5.80	28	66	10	●	○
5.90	28	66	10	○	○
6.00	28	66	10	●	●
6.10	31	70	10	●	○
6.20	31	70	10	●	○
6.25	31	70	10	●	○
6.30	31	70	10	●	○
6.40	31	70	10	●	○
6.50	31	70	10	●	●
6.60	31	70	5	○	○
6.70	31	70	5	●	●
6.75	34	74	5	●	●
6.80	34	74	5	●	●
6.90	34	74	5	●	○

● stock standard ○ non-standard stock ■ stock exhaustion

- TYPHOON
- C-SD-TA
- LFTA
- SUTA
- HSS-HSS/CO DRILLS
- UH RED
- MEX ORANGE
- HF EVO
- MEF ENDLESS
- ALU
- MDC
- G2
- MDTA
- ULTRA MILLS
- HSS/CO
- CARBIDE BURRS
- PARAMETERS

n **Vf**
PAGE 250

DIN
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118N - 218NVA (h8)

Ø mm	1~3	3.1~6	6.1~10	10.1~18	18.1~20
tol. D µ	0 / -14	0 / -18	0 / -22	0 / -27	0 / -33



d = D

N

NH

HSS
OX

HSS/CO
HT

118°

130°

25-30°

30°

D(h8)	I	L		Stock	Stock
mm 7.00	34	74	5	●	●
7.10	34	74	5	●	○
7.20	34	74	5	●	○
7.25	34	74	5	●	○
7.30	34	74	5	●	○
7.40	34	74	5	○	○
7.50	34	74	5	●	●
7.60	37	79	5	●	○
7.70	37	79	5	○	○
7.75	37	79	5	●	○
7.80	37	79	5	●	○
7.90	37	79	5	○	○
8.00	37	79	5	●	●
8.10	37	79	5	●	○
8.20	37	79	5	●	●
8.25	37	79	5	●	○
8.30	37	79	5	○	●
8.40	37	79	5	○	○
8.50	37	79	5	●	●
8.60	40	84	5	●	●
8.70	40	84	5	○	●
8.75	40	84	5	●	●
8.80	40	84	5	○	○
8.90	40	84	5	○	○
9.00	40	84	5	●	●
9.10	40	84	5	●	○
9.20	40	84	5	○	●
9.25	40	84	5	○	○
9.30	40	84	5	○	○
9.40	40	84	5	○	●
9.50	40	84	5	●	●
9.60	43	89	5	○	○
9.70	43	89	5	○	○
9.75	43	89	5	○	○
9.80	43	89	5	○	○
9.90	43	89	5	○	○

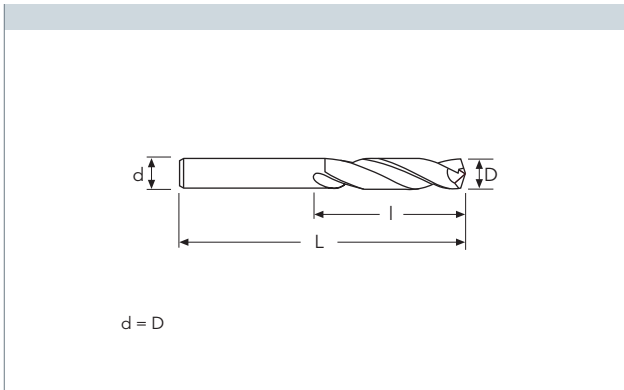
● stock standard ○ non-standard stock ■ stock exhaustion

n **Vf**
PAGE 250

DIN 1897

118N - 218NVA (h8)

Ø mm	1~3	3.1~6	6.1~10	10.1~18	18.1~20
tol. D µ	0 / -14	0 / -18	0 / -22	0 / -27	0 / -33



HSS OX	HSS/CO HT

D(h8)	I	L		Stock	Stock
mm 10.00	43	89	5	●	●
10.20	43	89	5	●	●
10.25	43	89	5	●	●
10.50	43	89	5	●	●
10.75	47	95	5	●	●
11.00	47	95	5	●	●
11.25	47	95	5	●	○
11.50	47	95	5	●	●
11.75	47	95	5	●	●
12.00	51	102	5	●	●
12.25	51	102	5	●	●
12.50	51	102	5	●	●
12.75	51	102	5	●	●
13.00	51	102	5	●	●
13.25	54	107	1	●	○
13.50	54	107	1	●	●
13.75	54	107	1	●	○
14.00	54	107	1	●	●
14.25	56	111	1	●	●
14.50	56	111	1	●	●
14.75	56	111	1	●	○
15.00	56	111	1	●	●
15.25	58	115	1	●	○
15.50	58	115	1	●	●
15.75	58	115	1	○	○
16.00	58	115	1	●	●
16.25	60	119	1		○
16.50	60	119	1		●
16.75	60	119	1		○
17.00	60	119	1		●
17.25	62	123	1		○
17.50	62	123	1		●
17.75	62	123	1		○
18.00	62	123	1		●
18.25	64	127	1		○
18.50	64	127	1		●

● stock standard ○ non-standard stock ■ stock exhaustion

- TYPHOON
- C-SD-TA
- LFTA
- SUTA
- HSS-HSS/CO DRILLS
- UH RED
- MEX ORANGE
- HF EVO
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- MDC
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Ø mm	1~3	3.1~6	6.1~10	10.1~18	18.1~20
tol. D µ	0 / -14	0 / -18	0 / -22	0 / -27	0 / -33



d = D

N

HSS

OX

118°

25-30°

NH

HSS/CO

HT

130°

30°

D(h8)	I	L		Stock	Stock
mm 18.75	64	127	1		○
19.00	64	127	1		●
19.25	66	131	1		○
19.50	66	131	1		●
19.75	66	131	1		●
20.00	66	131	1		●

● stock standard ○ non-standard stock ■ stock exhaustion

118N - 218NVA* - 138N - 238NVA - 234NVA* - 145N - 245N - 138NTI** - 145NTI														
MATERIAL GROUPS	1 2		2 3 4		4 5		5 6		6		9		26	
HRC			~23		23~28		23~34		34~38					
N/mm ²	~570		570~830		830~950		830~1110		1110~1260					
Vc [m/min]	24~28		18~22		14~18		16~20		10~12		18~22		10~12	
Ø mm.	n	fn	n	fn	n	fn	n	fn	n	fn	n	fn	n	fn
2	4250	0.025	3200	0.025	2400	0.015	3000	0.020	1750	0.015	3200	0.025	1750	0.020
2.5	3400	0.025	2600	0.025	1900	0.015	2400	0.020	1400	0.015	2600	0.025	1400	0.020
3	2700	0.050	2000	0.050	1500	0.025	1900	0.050	1100	0.020	2000	0.050	1100	0.025
4	2200	0.060	1650	0.060	1250	0.030	1600	0.060	900	0.020	1700	0.060	900	0.030
5	1700	0.065	1300	0.065	950	0.038	1200	0.063	700	0.025	1300	0.063	700	0.038
6	1500	0.090	1100	0.090	850	0.050	1100	0.090	600	0.030	1100	0.090	600	0.050
7	1250	0.110	950	0.110	700	0.060	900	0.110	520	0.030	950	0.110	520	0.060
8	1100	0.130	780	0.130	600	0.076	750	0.130	430	0.038	780	0.130	430	0.076
9	950	0.140	710	0.140	540	0.080	860	0.150	390	0.040	710	0.140	430	0.080
10	850	0.140	650	0.140	460	0.080	590	0.160	350	0.050	650	0.140	430	0.080
11	750	0.150	550	0.150	430	0.076	520	0.180	300	0.050	550	0.150	430	0.080
12	710	0.160	530	0.160	410	0.080	500	0.190	290	0.050	530	0.160	400	0.080
13	680	0.170	510	0.170	390	0.090	470	0.190	280	0.050	510	0.170	370	0.090
14	640	0.180	480	0.180	350	0.110	440	0.200	260	0.050	480	0.180	340	0.100
16	590	0.190	440	0.190	320	0.110	410	0.210	240	0.050	440	0.190	300	0.100
18	550	0.200	410	0.200	280	0.120	350	0.210	210	0.050	410	0.200	270	0.110
19	450	0.230	330	0.230	270	0.130	300	0.230	180	0.050	330	0.230	200	0.130
20	430	0.230	320	0.230	250	0.130	290	0.230	170	0.060	320	0.230	180	0.130
22	400	0.240	300	0.240	230	0.140	270	0.230	160	0.060	300	0.240	170	0.140
24	370	0.250	280	0.250	220	0.150	260	0.240	150	0.060	280	0.250	150	0.150
26	350	0.260	260	0.260	200	0.160	240	0.240	140	0.070	260	0.260	140	0.160
28	320	0.260	240	0.260	180	0.160	220	0.240	130	0.070	240	0.260	130	0.160
30	290	0.270	220	0.270	160	0.170	200	0.250	120	0.080	220	0.270	120	0.170
32	250	0.280	200	0.280	150	0.180	180	0.250	110	0.080	200	0.280	110	0.180
35	250	0.320	190	0.320	140	0.200	170	0.270	100	0.080	190	0.320	100	0.200
40	220	0.330	170	0.330	120	0.200	150	0.280	90	0.080	170	0.330	90	0.200
45	190	0.330	150	0.330	110	0.200	140	0.290	80	0.080	150	0.330	80	0.200
50	170	0.330	130	0.330	95	0.200	120	0.300	70	0.080	130	0.330	70	0.200

**n & fn = +30%~-+15%

* DIN1897 - DIN340 - DIN1869 - DIN341 - DIN1870 : n= n x Q (page 251)
 DIN1897 - DIN340 - DIN1869 - DIN341 - DIN1870 : fn= fn x R (page 251)

LS DIN338*														
MATERIAL GROUPS	3 4		5 6		13 14		13 14							
HRC	~30		20~40											
N/mm ²	700~1000		800~1200		~250 (HB)		~300 (HB)							
Vc [m/min]	15~18		12~14		24~28		10~12							
Ø mm.	n	fn	n	fn	n	fn	n	fn						
2	2650	0.030	2100	0.025	4200	0.060	1700	0.050						
2.5	2100	0.040	1700	0.030	3300	0.080	1300	0.060						
3	1700	0.050	1300	0.040	2650	0.100	1050	0.080						
4	1300	0.080	1050	0.050	2100	0.130	850	0.100						
5	1050	0.060	850	0.050	1700	0.130	660	0.100						
6	850	0.080	660	0.060	1300	0.180	530	0.130						
8	650	0.100	530	0.080	1050	0.200	420	0.170						
10	530	0.130	420	0.100	850	0.250	330	0.210						
13	420	0.130	330	0.100	650	0.250	260	0.210						
16	330	0.150	260	0.130	530	0.300	210	0.250						
20	260	0.200	210	0.150	420	0.400	170	0.300						
25	210	0.250	170	0.200	330	0.500	130	0.500						
30	170	0.250	130	0.200	260	0.500	110	0.500						

* DIN340 - DIN1869 - DIN341 - DIN1870 : n= n x Q (page 251)
 DIN340 - DIN1869 - DIN341 - DIN1870 : fn= fn x R (page 251)