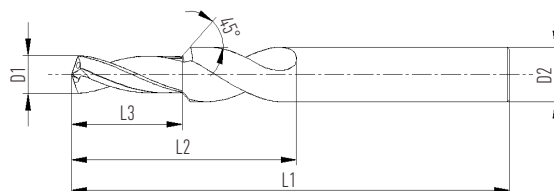


# Step drills for taps

## WITH INTERNAL COOLANT



- point angle 140°
- chamfer 45°
- depth of drilling 2,5xD
- cylindrical shank



## Drills for cutting taps

Order code	Dimensions (mm)						
	Thread	D1	D2	L1	L2	L3	Z
VS2050.M4.3.3.V6.60.10.Z2	M4	3,3	6	60	23	10	2
VS2050.M5.4.2.V6.60.13.Z2	M5	4,2	6	60	26	13	2
VS2050.M6.5.V8.75.15.Z2	M6	5	8	75	32	15	2
VS2050.M8.6.8.V10.90.20.Z2	M8	6,8	10	90	42	20	2
VS2050.M10.8.5.V12.110.25.Z2	M10	8,5	12	110	51	25	2
VS2050.M12.10.2.V14.110.30.Z2	M12	10,2	14	110	60	30	2

## Drills for forming taps

Order code	Dimensions (mm)						
	Thread	D1	D2	L1	L2	L3	Z
VST2050.M4.3.7.V6.60.10.Z2	M4	3,70	6	60	23	10	2
VST2050.M5.4.65.V6.60.13.Z2	M5	4,65	6	60	26	13	2
VST2050.M6.5.55.V8.75.15.Z2	M6	5,55	8	75	32	15	2
VST2050.M8.7.4.V10.90.20.Z2	M8	7,40	10	90	42	20	2
VST2050.M10.9.3.V12.110.25.Z2	M10	9,30	12	110	51	25	2
VST2050.M12.11.2.V14.110.30.Z2	M12	11,2	14	110	60	30	2

## Recommended cutting conditions

ISO	Strenght (N/mm <sup>2</sup> ) Material	Ap (mm)	Vc (m/min.)	Feed fz (mm/t) by mill diameter						
				3	4	5	6	8	10	12
				P	< 800 N/mm <sup>2</sup>	2,5 x D	90	0,040	0,050	0,060
< 1000 N/mm <sup>2</sup>	2,5 x D	70	0,040		0,050	0,060	0,080	0,100	0,120	0,140
< 1300 N/mm <sup>2</sup>	2,5 x D	45	0,030		0,040	0,050	0,060	0,080	0,100	0,110
K	Grey cast iron < 1000 N/mm <sup>2</sup>	2,5 x D	90	0,060	0,070	0,080	0,100	0,120	0,150	0,170