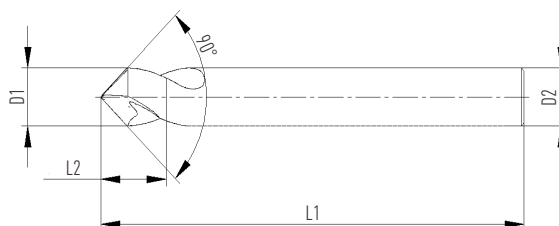


Spotting drill V3090



2 FLUTES

- angle of tip 90°
- helix angel 20°
- coating PVD
- chamfering by drilling



Cylindrical shank

| Order code | Dimensions (mm) | | | | |
|------------------------|-----------------|----|-----|----|---|
| | D1 | D2 | L1 | L2 | Z |
| V3090.6.V6.62.9.Z2 | 6 | 6 | 62 | 9 | 2 |
| V3090.8.V8.70.12.Z2 | 8 | 8 | 70 | 12 | 2 |
| V3090.10.V10.80.15.Z2 | 10 | 10 | 80 | 15 | 2 |
| V3090.12.V12.90.18.Z2 | 12 | 12 | 90 | 18 | 2 |
| V3090.16.V16.110.24.Z2 | 16 | 16 | 110 | 24 | 2 |
| V3090.20.V20.126.30.Z2 | 20 | 20 | 126 | 30 | 2 |

Recommended cutting conditions

| ISO | Strenght (N/mm ²) Material | Ap (mm) | Vc (m/min.) | Feed fz (mm/t) | | | | | |
|-----|---|------------|----------------|------------------|-------|-------|-------|-------|-------|
| | | | | by mill diameter | | | | | |
| | | | | 6 | 8 | 10 | 12 | 16 | 20 |
| P | < 800 N/mm ² | D - 0,3 mm | 90 | 0,020 | 0,025 | 0,030 | 0,030 | 0,040 | 0,040 |
| | < 1300 N/mm ² | D - 0,3 mm | 85 | 0,020 | 0,025 | 0,030 | 0,030 | 0,040 | 0,040 |
| M | Stainless steel | D - 0,3 mm | 65 | 0,020 | 0,025 | 0,030 | 0,030 | 0,040 | 0,040 |
| K | Grey cast iron < 1000 N/mm ² | D - 0,3 mm | 60 | 0,020 | 0,025 | 0,030 | 0,030 | 0,040 | 0,040 |
| H | Hihg alloyed steel | D - 0,3 mm | 80 | 0,020 | 0,025 | 0,030 | 0,030 | 0,040 | 0,040 |
| N | Aluminium and non ferrous | D - 0,3 mm | 120 | 0,020 | 0,025 | 0,030 | 0,030 | 0,040 | 0,040 |
| S | Titanium alloys | D - 0,3 mm | 40 | 0,020 | 0,025 | 0,030 | 0,030 | 0,040 | 0,040 |