



# NACHREINER

spanabhebende Werkzeuge



spanabhebende Werkzeuge

## GEWINDESCHNEIDEN

Präzision bedeutet,  
nichts dem Zufall zu überlassen.

## BOHREN



## FRÄSEN

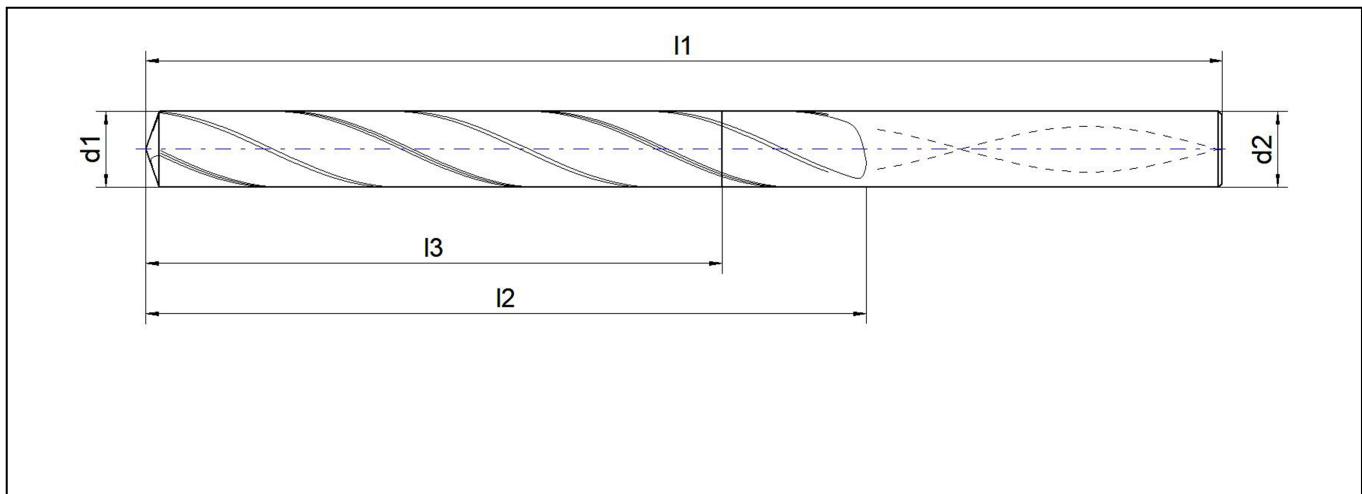
## REIBEN

## SENKEN



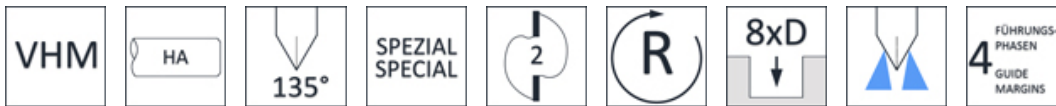
# Bohrer VHM Drills solid carbide





# VHM-Universal-Spiralbohrer 8xd mit 4-Führungsfasen

E.3666.1



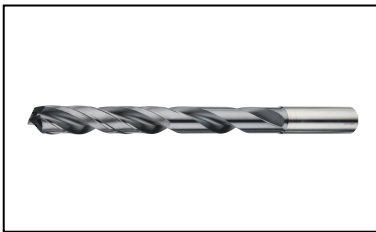
[Schnittdaten >](#)

## Einsatzrichtwerte

| Material   | Nr. | Vc m/min |
|--|-----|----------|
| allg. Stähle -500 N/mm <sup>2</sup>                      | 1.1 | 90 - 120 |
| allg. Stähle -700 N/mm <sup>2</sup>                      | 1.2 | 80 - 100 |
| allg. Stähle - 850N/mm <sup>2</sup>                      | 1.3 | 80 - 100 |
| allg. Stähle -1000 N/mm <sup>2</sup>                     | 1.4 | 60 - 80  |
| allg. Stähle -1400 N/mm <sup>2</sup>                     | 1.5 | 30 - 45  |
| Einsatzstähle < 1000N/mm <sup>2</sup>                    | 1.6 | 60 - 80  |
| Nitrierstähle < 1000N/mm <sup>2</sup>                    | 1.7 | 60 - 80  |
| Vergütungsstähle < 850N/mm <sup>2</sup>                  | 1.8 | 60 - 80  |
| Werkzeugstähle (legiert und unlegiert)                   | 1.9 | 30 - 50  |
| Rost und säurebeständige Stähle bis 700N/mm <sup>2</sup> | 2.1 | 35 - 50  |
| Rost und säurebeständige Stähle ab 700N/mm <sup>2</sup>  | 2.2 | 30 - 45  |
| Gusseisen bis 180 HB                                     | 3.1 | 70 - 90  |

| Material                             | Nr. | Vc m/min  |
|--------------------------------------|-----|-----------|
| Temperguss                           | 3.2 | 70 - 90   |
| Gusseisen mit Kugelgraphit           | 3.3 | 65 - 85   |
| AL-und AL-Legierungen bis 6% Si      | 4.1 | 180 - 220 |
| AL-und AL-Legierungen (unter 12% Si) | 4.2 | 150 - 200 |
| AL-Legierung (über 12% Si)           | 4.3 | 100 - 150 |
| Messing, Kupfer, Bronze, Rotguss     | 4.4 |           |
| Duroplaste und Thermoplast           | 4.5 |           |
| Grafit, GFK, Kupfer                  | 4.6 |           |
| Titan und Titanlegierung             | 5.1 | 20 - 35   |
| Nickel                               | 5.2 |           |
| gehärtete Stähle 45-55 HRC           | 6.1 |           |
| gehärtete Stähle 55-60 HRC           | 6.2 |           |
| gehärtete Stähle 60-65 HRC           | 6.3 |           |

## Weitere Ansichten



## Verfügbare Varianten

| Artikel-Nr.   | d1 m7 | l1 | l2 | d2 h6 | Gewindebohrer | Gewindeforfräser |
|---------------|-------|----|----|-------|---------------|------------------|
| E.3666.1.0100 | 1     | 55 | 11 | 4,0   | M 1,1         | 9                |
| E.3666.1.0110 | 1.1   | 55 | 17 | 4,0   | M 1,4         | M 1,2<br>13.5    |
| E.3666.1.0120 | 1.2   | 55 | 17 | 4,0   |               | 13.5             |
| E.3666.1.0130 | 1.3   | 55 | 17 | 4,0   |               | 13.5             |
| E.3666.1.0140 | 1.4   | 55 | 17 | 4,0   |               | 13.5             |
| E.3666.1.0150 | 1.5   | 65 | 22 | 4,0   |               | 17.5             |
| E.3666.1.0160 | 1.6   | 65 | 22 | 4,0   | M 2           | 17.5             |
| E.3666.1.0170 | 1.7   | 65 | 22 | 4,0   |               | 17.5             |

|               |     |    |    |     |                |                |      |
|---------------|-----|----|----|-----|----------------|----------------|------|
| E.3666.1.0180 | 1.8 | 65 | 22 | 4,0 | M 2,2          | M 2            | 17.5 |
| E.3666.1.0190 | 1.9 | 65 | 22 | 4,0 | M 2,3          |                | 17.5 |
| E.3666.1.0200 | 2   | 74 | 28 | 4,0 |                |                | 22.5 |
| E.3666.1.0210 | 2.1 | 74 | 28 | 4,0 |                |                | 22.5 |
| E.3666.1.0220 | 2.2 | 74 | 28 | 4,0 |                |                | 22.5 |
| E.3666.1.0230 | 2.3 | 74 | 28 | 4,0 |                |                | 22.5 |
| E.3666.1.0240 | 2.4 | 74 | 28 | 4,0 |                |                | 22.5 |
| E.3666.1.0250 | 2.5 | 81 | 32 | 4,0 | M 3            |                | 22.5 |
| E.3666.1.0260 | 2.6 | 81 | 32 | 4,0 |                |                | 22.5 |
| E.3666.1.0270 | 2.7 | 81 | 32 | 4,0 |                |                | 22.5 |
| E.3666.1.0280 | 2.8 | 81 | 32 | 4,0 |                | M 3            | 22.5 |
| E.3666.1.0290 | 2.9 | 81 | 32 | 4,0 | M 3,5          | M 3 x<br>0,25  | 22.5 |
| E.3666.1.0300 | 3   | 72 | 34 | 6,0 |                |                | 27   |
| E.3666.1.0310 | 3.1 | 72 | 34 | 6,0 |                |                | 27   |
| E.3666.1.0320 | 3.2 | 72 | 34 | 6,0 |                |                | 27   |
| E.3666.1.0330 | 3.3 | 72 | 34 | 6,0 | M 4            | M 3,5 x<br>0,5 | 27   |
| E.3666.1.0340 | 3.4 | 72 | 34 | 6,0 |                |                | 27   |
| E.3666.1.0350 | 3.5 | 72 | 34 | 6,0 | M 4 x 0,5      |                | 27   |
| E.3666.1.0360 | 3.6 | 72 | 34 | 6,0 |                |                | 27   |
| E.3666.1.0370 | 3.7 | 72 | 34 | 6,0 | M 4,5          | M 4            | 27   |
| E.3666.1.0380 | 3.8 | 81 | 43 | 6,0 |                | M 4 x 0,5      | 35   |
| E.3666.1.0390 | 3.9 | 81 | 43 | 6,0 |                |                | 35   |
| E.3666.1.0400 | 4   | 81 | 43 | 6,0 | M 4,5 x<br>0,5 |                | 35   |
| E.3666.1.0410 | 4.1 | 81 | 43 | 6,0 |                |                | 35   |
| E.3666.1.0420 | 4.2 | 81 | 43 | 6,0 | M 5            | M 4,5          | 35   |
| E.3666.1.0430 | 4.3 | 81 | 43 | 6,0 |                | M 4,5 x<br>0,5 | 35   |



|               |     |     |    |     |                |           |    |
|---------------|-----|-----|----|-----|----------------|-----------|----|
| E.3666.1.0440 | 4.4 | 81  | 43 | 6,0 |                | 35        |    |
| E.3666.1.0450 | 4.5 | 81  | 43 | 6,0 | M 5 x 0,5      | 35        |    |
| E.3666.1.0460 | 4.6 | 81  | 43 | 6,0 | M 5,5          | 35        |    |
| E.3666.1.0470 | 4.7 | 81  | 43 | 6,0 | M 5 x 0,75     | 35        |    |
| E.3666.1.0480 | 4.8 | 95  | 57 | 6,0 | M 5 x 0,5      | 45        |    |
| E.3666.1.0490 | 4.9 | 95  | 57 | 6,0 |                | 45        |    |
| E.3666.1.0500 | 5   | 95  | 57 | 6,0 | M 6 / M5,5x0,5 | 45        |    |
| E.3666.1.0510 | 5.1 | 95  | 57 | 6,0 | M 5,5          | 45        |    |
| E.3666.1.0520 | 5.2 | 95  | 57 | 6,0 | M 6 x 0,75     | 45        |    |
| E.3666.1.0530 | 5.3 | 95  | 57 | 6,0 | M 5,5 x 0,5    | 45        |    |
| E.3666.1.0540 | 5.4 | 95  | 57 | 6,0 |                | 45        |    |
| E.3666.1.0550 | 5.5 | 95  | 57 | 6,0 | M 6 x 0,5      | 45        |    |
| E.3666.1.0560 | 5.6 | 95  | 57 | 6,0 | M 6            | 45        |    |
| E.3666.1.0570 | 5.7 | 95  | 57 | 6,0 | M 6 x 0,75     | 45        |    |
| E.3666.1.0580 | 5.8 | 95  | 57 | 6,0 | M 6 x 0,5      | 45        |    |
| E.3666.1.0590 | 5.9 | 95  | 57 | 6,0 |                | 45        |    |
| E.3666.1.0600 | 6   | 95  | 57 | 6,0 | M 7            | 45        |    |
| E.3666.1.0610 | 6.1 | 114 | 76 | 8,0 |                | 52        |    |
| E.3666.1.0620 | 6.2 | 114 | 76 | 8,0 | M 7 x 0,75     | 52        |    |
| E.3666.1.0630 | 6.3 | 114 | 76 | 8,0 |                | 52        |    |
| E.3666.1.0640 | 6.4 | 114 | 76 | 8,0 |                | 52        |    |
| E.3666.1.0650 | 6.5 | 114 | 76 | 8,0 |                | 52        |    |
| E.3666.1.0660 | 6.6 | 114 | 76 | 8,0 | M 7            | 52        |    |
| E.3666.1.0670 | 6.7 | 114 | 76 | 8,0 | M 7 x 0,75     | 52        |    |
| E.3666.1.0680 | 6.8 | 114 | 76 | 8,0 | M 8            | M 7 x 0,5 | 52 |

|               |     |     |    |      |                |               |    |
|---------------|-----|-----|----|------|----------------|---------------|----|
| E.3666.1.0690 | 6.9 | 114 | 76 | 8,0  |                |               | 52 |
| E.3666.1.0700 | 7   | 114 | 76 | 8,0  | M 8 x 1        |               | 60 |
| E.3666.1.0710 | 7.1 | 114 | 76 | 8,0  |                |               | 60 |
| E.3666.1.0720 | 7.2 | 114 | 76 | 8,0  | M 8 x<br>0,75  |               | 60 |
| E.3666.1.0730 | 7.3 | 114 | 76 | 8,0  |                |               | 60 |
| E.3666.1.0740 | 7.4 | 114 | 76 | 8,0  |                | M 8           | 60 |
| E.3666.1.0750 | 7.5 | 114 | 76 | 8,0  | M 8 x 0,5      |               | 60 |
| E.3666.1.0760 | 7.6 | 114 | 76 | 8,0  |                | M 8 x 1       | 60 |
| E.3666.1.0770 | 7.7 | 114 | 76 | 8,0  |                | M 8 x<br>0,75 | 60 |
| E.3666.1.0780 | 7.8 | 114 | 76 | 8,0  | M 9            | M 8 x 0,5     | 60 |
| E.3666.1.0790 | 7.9 | 114 | 76 | 8,0  |                |               | 60 |
| E.3666.1.0800 | 8   | 114 | 76 | 8,0  | M 9 x 1        |               | 60 |
| E.3666.1.0810 | 8.1 | 142 | 95 | 10,0 |                |               | 68 |
| E.3666.1.0820 | 8.2 | 142 | 95 | 10,0 | M 9 x<br>0,75  |               | 68 |
| E.3666.1.0830 | 8.3 | 142 | 95 | 10,0 |                |               | 68 |
| E.3666.1.0840 | 8.4 | 142 | 95 | 10,0 |                | M 9           | 68 |
| E.3666.1.0850 | 8.5 | 142 | 95 | 10,0 | M 10           |               | 68 |
| E.3666.1.0860 | 8.6 | 142 | 95 | 10,0 |                | M 9 x 1       | 68 |
| E.3666.1.0870 | 8.7 | 142 | 95 | 10,0 |                | M 9 x<br>0,75 | 68 |
| E.3666.1.0880 | 8.8 | 142 | 95 | 10,0 | M 10 x<br>1,25 | M 9 x 0,5     | 68 |
| E.3666.1.0890 | 8.9 | 142 | 95 | 10,0 |                |               | 68 |
| E.3666.1.0900 | 9   | 142 | 95 | 10,0 | M 10 x 1       |               | 68 |
| E.3666.1.0910 | 9.1 | 142 | 95 | 10,0 |                |               | 76 |
| E.3666.1.0920 | 9.2 | 142 | 95 | 10,0 | M 10 x<br>0,75 |               | 76 |
| E.3666.1.0930 | 9.3 | 142 | 95 | 10,0 |                | M 10          | 76 |
| E.3666.1.0940 | 9.4 | 142 | 95 | 10,0 |                |               | 76 |

|               |      |     |     |      |               |    |
|---------------|------|-----|-----|------|---------------|----|
| E.3666.1.0950 | 9.5  | 142 | 95  | 10,0 | M 11          | 76 |
| E.3666.1.0960 | 9.6  | 142 | 95  | 10,0 | M 10 x 1      | 76 |
| E.3666.1.0970 | 9.7  | 142 | 95  | 10,0 | M 10 x 0,75   | 76 |
| E.3666.1.0980 | 9.8  | 142 | 95  | 10,0 | M 10 x 0,5    | 76 |
| E.3666.1.0990 | 9.9  | 142 | 95  | 10,0 |               | 76 |
| E.3666.1.1000 | 10   | 142 | 95  | 10,0 | M 11 x 1      | 76 |
| E.3666.1.1010 | 10.1 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1020 | 10.2 | 162 | 114 | 12,0 | M 12/M11x0,75 | 90 |
| E.3666.1.1030 | 10.3 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1040 | 10.4 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1050 | 10.5 | 162 | 114 | 12,0 | M 12 x 1,5    | 90 |
| E.3666.1.1060 | 10.6 | 162 | 114 | 12,0 | M 11 x 1      | 90 |
| E.3666.1.1070 | 10.7 | 162 | 114 | 12,0 | M 11 x 0,75   | 90 |
| E.3666.1.1080 | 10.8 | 162 | 114 | 12,0 | M 12 x 1,25   | 90 |
| E.3666.1.1090 | 10.9 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1100 | 11   | 162 | 114 | 12,0 | M 12 x 1      | 90 |
| E.3666.1.1110 | 11.1 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1120 | 11.2 | 162 | 114 | 12,0 | M 12          | 90 |
| E.3666.1.1130 | 11.3 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1140 | 11.4 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1150 | 11.5 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1160 | 11.6 | 162 | 114 | 12,0 | M 12 x 1      | 90 |
| E.3666.1.1170 | 11.7 | 162 | 114 | 12,0 | M 12 x 0,75   | 90 |
| E.3666.1.1180 | 11.8 | 162 | 114 | 12,0 |               | 90 |
| E.3666.1.1190 | 11.9 | 162 | 114 | 12,0 |               | 90 |



|               |      |     |     |      |                 |     |
|---------------|------|-----|-----|------|-----------------|-----|
| E.3666.1.1200 | 12   | 162 | 114 | 12,0 | M 14            | 90  |
| E.3666.1.1250 | 12.5 | 178 | 131 | 14,0 | M 14 x 1,5      | 106 |
| E.3666.1.1280 | 12.8 | 178 | 131 | 14,0 | M 14 x 1,25     | 106 |
| E.3666.1.1300 | 13   | 178 | 131 | 14,0 | M 14 x 1        | 106 |
| E.3666.1.1350 | 13.5 | 178 | 131 | 14,0 |                 | 106 |
| E.3666.1.1400 | 14   | 178 | 131 | 14,0 | M 16 / M 15 x 1 | 106 |
| E.3666.1.1450 | 14.5 | 203 | 152 | 16,0 | M 16 x 1,5      | 122 |
| E.3666.1.1500 | 15   | 203 | 152 | 16,0 | M 16 x 1        | 122 |
| E.3666.1.1550 | 15.5 | 203 | 152 | 16,0 | M 18            | 122 |
| E.3666.1.1600 | 16   | 203 | 152 | 16,0 | M 18 x 2        | 122 |
| E.3666.1.1780 | 17.8 | 222 | 171 | 18,0 |                 | 150 |
| E.3666.1.1880 | 18.8 | 243 | 190 | 20,0 |                 | 170 |

## Verfügbarkeit prüfen unter

<https://www.nachreiner-werkzeuge.de/sortiment/bohrer-vhm/hochleistungsbohrer-3xd-15xd-uni/8xd/898/vhm-universal-spiralbohrer-8xd-mit-4-fuehrungsfasen>.





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