

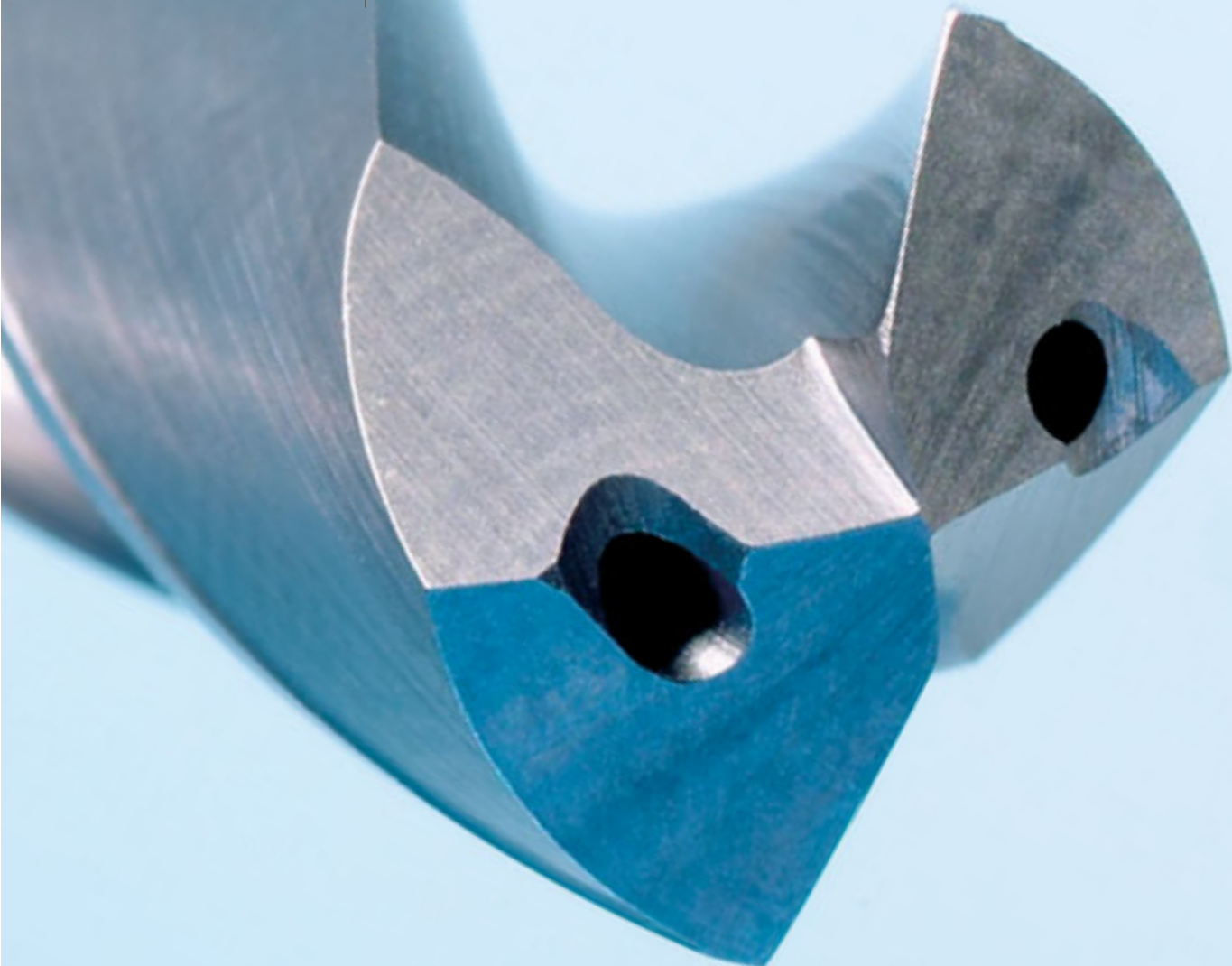
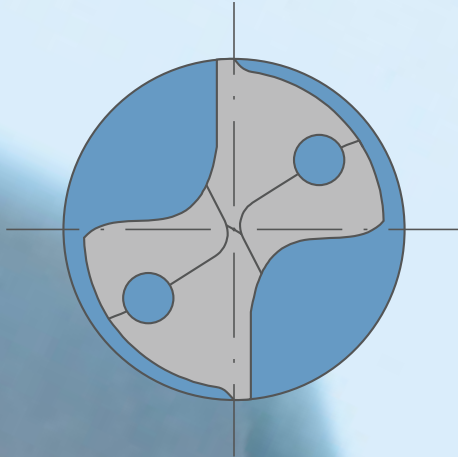
MEGA-Drill-Steel –

The best selection in carbon-based materials

The MEGA-Drill-Steel demonstrates its excellent efficiency in carbon-based materials with high cutting values and long tool life. In particular, the drill geometry excels in steels of various states and conditions.

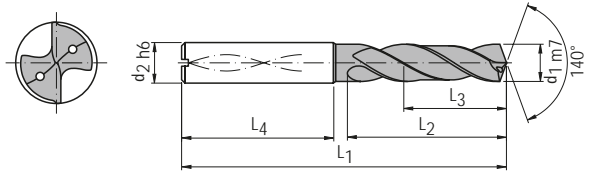
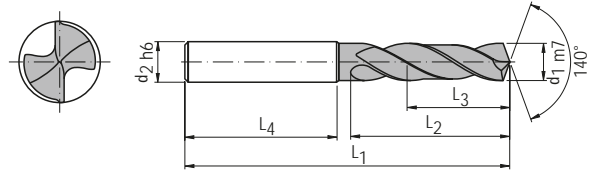
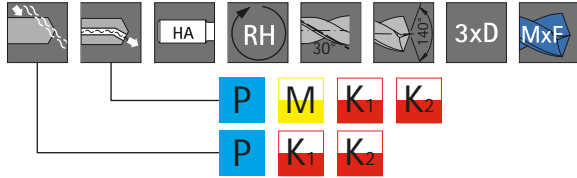
The special design of the cutting edge combined with the flute form allows the chip to curl and fracture effectively. Better chip control results in excellent chip clearance from the bore and improved drill performance.

Drilling depths of up to $5xD$ are achieved – and with internal coolant even up to $8xD$ with standard tools from stock.



MEGA-Drill-Steel

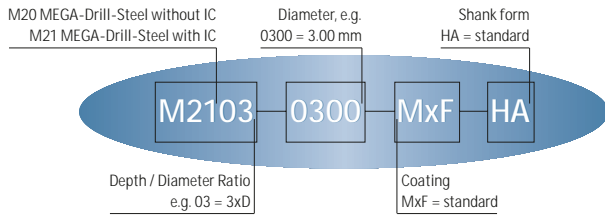
M2003 / M2103



Design:

Drill diameter: 3.00 – 20.00 mm
0.1181 – 0.7874 Inch
Bore tolerance: IT 9 (achievable)
No. of margins: 2

To order, use the code given in the table and supplement it with the required coating and shank form.
Complete order code:





Drill diameter		Dimensions						M2003	M2103
mm	Inch / Wire / Letter	Dec. equiv. Inch	Shank diameter d ₂ h ₆ mm	Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm	Shank length L ₄ mm	Order code Form / Diameter	Order code Form / Diameter
3.00		0.1181	6	62	20	14	36	M2003-0300 ●	M2103-0300 ●
3.10		0.1220	6	62	20	14	36	M2003-0310 ●	M2103-0310 ●
3.18	1/8	0.1250	6	62	20	14	36	M2003-0318 ●	M2103-0318 ●
3.20		0.1260	6	62	20	14	36	M2003-0320 ○	M2103-0320 ●
3.30		0.1299	6	62	20	14	36	M2003-0330 ●	M2103-0330 ●
3.40		0.1339	6	62	20	14	36	M2003-0340 ○	M2103-0340 ○
3.45	#29	0.1358	6	62	20	14	36	M2003-0345 ●	M2103-0345 ●
3.50		0.1378	6	62	20	14	36	M2003-0350 ●	M2103-0350 ●
3.57	9/64	0.1406	6	62	20	14	36	M2003-0357 ●	M2103-0357 ●
3.60		0.1417	6	62	20	14	36	M2003-0360 ●	M2103-0360 ●
3.70		0.1457	6	62	20	14	36	M2003-0370 ●	M2103-0370 ●
3.80	#25	0.1496	6	66	24	17	36	M2003-0380 ●	M2103-0380 ●
3.86	#24	0.1520	6	66	24	17	36	M2003-0386 ●	M2103-0386 ●
3.90		0.1535	6	66	24	17	36	M2003-0390 ○	M2103-0390 ○
3.97	5/32	0.1562	6	66	24	17	36	M2003-0397 ●	M2103-0397 ●
4.00		0.1575	6	66	24	17	36	M2003-0400 ●	M2103-0400 ●
4.04	#21	0.1591	6	66	24	17	36	M2003-0404 ●	M2103-0404 ●
4.10		0.1614	6	66	24	17	36	M2003-0410 ●	M2103-0410 ○
4.20		0.1654	6	66	24	17	36	M2003-0420 ●	M2103-0420 ●
4.30	#18	0.1693	6	66	24	17	36	M2003-0430 ●	M2103-0430 ●
4.37	11/64	0.1719	6	66	24	17	36	M2003-0437 ●	M2103-0437 ●
4.40		0.1732	6	66	24	17	36	M2003-0440 ●	M2103-0440 ●
4.50	#16	0.1772	6	66	24	17	36	M2003-0450 ●	M2103-0450 ●
4.60		0.1811	6	66	24	17	36	M2003-0460 ●	M2103-0460 ●
4.62	#14	0.1819	6	66	24	17	36	M2003-0462 ●	M2103-0462 ●

For machining values see Page 28.

MEGA-Drill-Steel

M2003 / M2103

3xD

mm	Drill diameter d ₁ m7		Shank diameter d ₂ h6 mm	Dimensions				 M2003	 M2103		
	Inch / Wire / Letter	Dec. equiv. Inch		Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm	Shank length L ₄ mm			Order code Form / Diameter	Order code Form / Diameter
4.70	#13	0.1850	6	66	24	17	36	M2003-0470	●	M2103-0470	●
4.76	3/16	0.1875	6	66	28	20	36	M2003-0476	●	M2103-0476	●
4.80	#12	0.1890	6	66	28	20	36	M2003-0480	●	M2103-0480	●
4.90		0.1929	6	66	28	20	36	M2003-0490	○	M2103-0490	○
5.00		0.1969	6	66	28	20	36	M2003-0500	●	M2103-0500	●
5.10		0.2008	6	66	28	20	36	M2003-0510	●	M2103-0510	●
5.16	13/64	0.2031	6	66	28	20	36	M2003-0516	●	M2103-0516	●
5.20		0.2047	6	66	28	20	36	M2003-0520	●	M2103-0520	●
5.30		0.2087	6	66	28	20	36	M2003-0530	○	M2103-0530	○
5.40		0.2126	6	66	28	20	36	M2003-0540	○	M2103-0540	○
5.50		0.2165	6	66	28	20	36	M2003-0550	●	M2103-0550	●
5.56	7/32	0.2188	6	66	28	20	36	M2003-0556	●	M2103-0556	●
5.60		0.2205	6	66	28	20	36	M2003-0560	●	M2103-0560	●
5.70		0.2244	6	66	28	20	36	M2003-0570	●	M2103-0570	●
5.80		0.2283	6	66	28	20	36	M2003-0580	○	M2103-0580	○
5.90		0.2323	6	66	28	20	36	M2003-0590	●	M2103-0590	●
5.95	15/64	0.2344	6	66	28	20	36	M2003-0595	●	M2103-0595	●
6.00		0.2362	6	66	28	20	36	M2003-0600	●	M2103-0600	●
6.10		0.2402	8	79	34	24	36	M2003-0610	○	M2103-0610	○
6.15	C	0.2421	8	79	34	24	36	M2003-0615	●	M2103-0615	●
6.20		0.2441	8	79	34	24	36	M2003-0620	○	M2103-0620	○
6.30		0.2480	8	79	34	24	36	M2003-0630	○	M2103-0630	○
6.35	1/4	0.2500	8	79	34	24	36	M2003-0635	●	M2103-0635	●
6.40		0.2520	8	79	34	24	36	M2003-0640	○	M2103-0640	○
6.50		0.2559	8	79	34	24	36	M2003-0650	●	M2103-0650	●
6.53	F	0.2571	8	79	34	24	36	M2003-0653	●	M2103-0653	●
6.60		0.2598	8	79	34	24	36	M2003-0660	●	M2103-0660	●
6.63	G	0.2610	8	79	34	24	36	M2003-0663	●	M2103-0663	●
6.70		0.2638	8	79	34	24	36	M2003-0670	○	M2103-0670	○
6.75	17/64	0.2656	8	79	34	24	36	M2003-0675	●	M2103-0675	●
6.80		0.2677	8	79	34	24	36	M2003-0680	●	M2103-0680	●
6.90	I	0.2717	8	79	34	24	36	M2003-0690	●	M2103-0690	●
7.00		0.2756	8	79	34	24	36	M2003-0700	●	M2103-0700	●
7.10		0.2795	8	79	41	29	36	M2003-0710	○	M2103-0710	○
7.14	9/32	0.2812	8	79	41	29	36	M2003-0714	●	M2103-0714	●
7.20		0.2835	8	79	41	29	36	M2003-0720	●	M2103-0720	●
7.30		0.2874	8	79	41	29	36	M2003-0730	●	M2103-0730	●
7.40		0.2913	8	79	41	29	36	M2003-0740	●	M2103-0740	●
7.50		0.2953	8	79	41	29	36	M2003-0750	●	M2103-0750	●
7.54	19/64	0.2969	8	79	41	29	36	M2003-0754	●	M2103-0754	●
7.60		0.2992	8	79	41	29	36	M2003-0760	●	M2103-0760	●
7.70		0.3031	8	79	41	29	36	M2003-0770	●	M2103-0770	●
7.80		0.3071	8	79	41	29	36	M2003-0780	●	M2103-0780	●
7.90		0.3110	8	79	41	29	36	M2003-0790	○	M2103-0790	○
7.94	5/16	0.3125	8	79	41	29	36	M2003-0794	●	M2103-0794	●

For machining values see Page 28.

MEGA-Drill-Steel

M2003 / M2103

3xD

Drill diameter			Dimensions					M2003		M2103	
mm	d ₁ m7	Dec. equiv. Inch	Shank diameter d ₂ h6 mm	Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm	Shank length L ₄ mm	Order code Form / Diameter	Order code Form / Diameter		
	Inch / Wire / Letter										
8.00		0.3150	8	79	41	29	36	M2003-0800	●	M2103-0800	●
8.10		0.3189	10	89	47	35	40	M2003-0810	○	M2103-0810	○
8.20	P	0.3228	10	89	47	35	40	M2003-0820	○	M2103-0820	○
8.30		0.3268	10	89	47	35	40	M2003-0830	○	M2103-0830	○
8.33	21/64	0.3281	10	89	47	35	40	M2003-0833	●	M2103-0833	●
8.40		0.3307	10	89	47	35	40	M2003-0840	○	M2103-0840	○
8.43	Q	0.3319	10	89	47	35	40	M2003-0843	●	M2103-0843	●
8.50		0.3346	10	89	47	35	40	M2003-0850	●	M2103-0850	●
8.60		0.3386	10	89	47	35	40	M2003-0860	○	M2103-0860	○
8.70		0.3425	10	89	47	35	40	M2003-0870	○	M2103-0870	○
8.73	11/32	0.3438	10	89	47	35	40	M2003-0873	●	M2103-0873	●
8.80		0.3465	10	89	47	35	40	M2003-0880	●	M2103-0880	●
8.90		0.3504	10	89	47	35	40	M2003-0890	○	M2103-0890	○
9.00		0.3543	10	89	47	35	40	M2003-0900	●	M2103-0900	●
9.10		0.3583	10	89	47	35	40	M2003-0910	○	M2103-0910	○
9.13	23/64	0.3594	10	89	47	35	40	M2003-0913	●	M2103-0913	●
9.20		0.3622	10	89	47	35	40	M2003-0920	○	M2103-0920	○
9.30		0.3661	10	89	47	35	40	M2003-0930	●	M2103-0930	●
9.35	U	0.3681	10	89	47	35	40	M2003-0935	●	M2103-0935	●
9.40		0.3701	10	89	47	35	40	M2003-0940	●	M2103-0940	●
9.50		0.3740	10	89	47	35	40	M2003-0950	●	M2103-0950	●
9.53	3/8	0.3750	10	89	47	35	40	M2003-0953	●	M2103-0953	●
9.60		0.3780	10	89	47	35	40	M2003-0960	●	M2103-0960	●
9.70		0.3819	10	89	47	35	40	M2003-0970	○	M2103-0970	○
9.80	W	0.3858	10	89	47	35	40	M2003-0980	○	M2103-0980	○
9.90		0.3898	10	89	47	35	40	M2003-0990	●	M2103-0990	●
9.92	25/64	0.3906	10	89	47	35	40	M2003-0992	●	M2103-0992	●
10.00		0.3937	10	89	47	35	40	M2003-1000	●	M2103-1000	●
10.10		0.3976	12	102	55	40	45	M2003-1010	○	M2103-1010	○
10.20		0.4016	12	102	55	40	45	M2003-1020	●	M2103-1020	●
10.26	Y	0.4039	12	102	55	40	45	M2003-1026	●	M2103-1026	●
10.30		0.4055	12	102	55	40	45	M2003-1030	●	M2103-1030	●
10.32	13/32	0.4062	12	102	55	40	45	M2003-1032	●	M2103-1032	●
10.40		0.4094	12	102	55	40	45	M2003-1040	○	M2103-1040	○
10.50		0.4134	12	102	55	40	45	M2003-1050	●	M2103-1050	●
10.60		0.4173	12	102	55	40	45	M2003-1060	○	M2103-1060	○
10.70		0.4213	12	102	55	40	45	M2003-1070	●	M2103-1070	●
10.72	27/64	0.4219	12	102	55	40	45	M2003-1072	●	M2103-1072	●
10.80		0.4252	12	102	55	40	45	M2003-1080	○	M2103-1080	○
10.90		0.4291	12	102	55	40	45	M2003-1090	○	M2103-1090	○
11.00		0.4331	12	102	55	40	45	M2003-1100	●	M2103-1100	●
11.10		0.4370	12	102	55	40	45	M2003-1110	○	M2103-1110	○
11.11	7/16	0.4375	12	102	55	40	45	M2003-1111	●	M2103-1111	●
11.20		0.4409	12	102	55	40	45	M2003-1120	●	M2103-1120	●
11.30		0.4449	12	102	55	40	45	M2003-1130	●	M2103-1130	●

For machining values see Page 28.

MEGA-Drill-Steel

M2003 / M2103

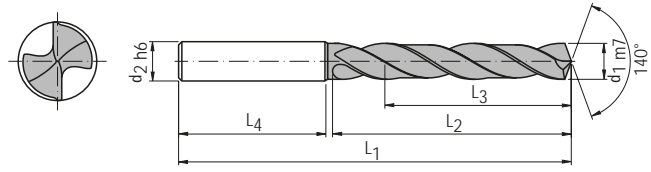
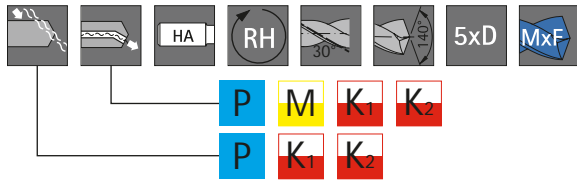
3xD

mm	Drill diameter d1 m7		Shank diameter d2 h6 mm	Dimensions				M2003		M2103	
	Inch / Wire / Letter	Dec. equiv. Inch		Total length L1 mm	Margin length L2 mm	Maximum drilling depth L3 mm	Shank length L4 mm	Order code Form / Diameter	Order code Form / Diameter		
11.40		0.4488	12	102	55	40	45	M2003-1140	●	M2103-1140	●
11.50	29/64	0.4528	12	102	55	40	45	M2003-1150	●	M2103-1150	●
11.60		0.4567	12	102	55	40	45	M2003-1160	○	M2103-1160	○
11.70		0.4606	12	102	55	40	45	M2003-1170	○	M2103-1170	○
11.80		0.4646	12	102	55	40	45	M2003-1180	●	M2103-1180	●
11.90	15/32	0.4685	12	102	55	40	45	M2003-1190	●	M2103-1190	●
12.00		0.4724	12	102	55	40	45	M2003-1200	●	M2103-1200	●
12.30	31/64	0.4843	14	107	60	43	45	M2003-1230	●	M2103-1230	●
12.50		0.4921	14	107	60	43	45	M2003-1250	●	M2103-1250	●
12.70	1/2	0.5000	14	107	60	43	45	M2003-1270	●	M2103-1270	●
12.80		0.5039	14	107	60	43	45	M2003-1280	●	M2103-1280	●
13.00		0.5118	14	107	60	43	45	M2003-1300	●	M2103-1300	●
13.10	33/64	0.5157	14	107	60	43	45	M2003-1310	●	M2103-1310	●
13.30		0.5236	14	107	60	43	45	M2003-1330	●	M2103-1330	●
13.50		0.5315	14	107	60	43	45	M2003-1350	●	M2103-1350	●
13.80		0.5433	14	107	60	43	45	M2003-1380	○	M2103-1380	○
14.00		0.5512	14	107	60	43	45	M2003-1400	●	M2103-1400	●
14.30	9/16	0.5630	16	115	65	45	48	M2003-1430	●	M2103-1430	●
14.50		0.5709	16	115	65	45	48	M2003-1450	●	M2103-1450	●
14.68	37/64	0.5780	16	115	65	45	48	M2003-1468	●	M2103-1468	●
14.80		0.5827	16	115	65	45	48	M2003-1480	●	M2103-1480	●
15.00		0.5906	16	115	65	45	48	M2003-1500	●	M2103-1500	●
15.08	19/32	0.5937	16	115	65	45	48	M2003-1508	●	M2103-1508	●
15.50		0.6102	16	115	65	45	48	M2003-1550	●	M2103-1550	●
15.80		0.6220	16	115	65	45	48	M2003-1580	○	M2103-1580	○
15.88	5/8	0.6250	16	115	65	45	48	M2003-1588	●	M2103-1588	●
16.00		0.6299	16	115	65	45	48	M2003-1600	●	M2103-1600	●
16.50		0.6496	18	123	73	51	48	M2003-1650	●	M2103-1650	●
16.67	21/32	0.6563	18	123	73	51	48	M2003-1667	●	M2103-1667	●
16.80		0.6614	18	123	73	51	48	M2003-1680	●	M2103-1680	●
17.00		0.6693	18	123	73	51	48	M2003-1700	●	M2103-1700	●
17.46	11/16	0.6874	18	123	73	51	48	M2003-1746	●	M2103-1746	●
17.50		0.6890	18	123	73	51	48	M2003-1750	●	M2103-1750	●
17.80		0.7008	18	123	73	51	48	M2003-1780	○	M2103-1780	○
17.86	45/64	0.7031	18	123	73	51	48	M2003-1786	●	M2103-1786	●
18.00		0.7087	18	123	73	51	48	M2003-1800	●	M2103-1800	●
18.26	23/32	0.7189	20	131	79	55	50	M2003-1826	●	M2103-1826	●
18.50		0.7283	20	131	79	55	50	M2003-1850	●	M2103-1850	●
18.80		0.7402	20	131	79	55	50	M2003-1880	○	M2103-1880	○
19.00		0.7480	20	131	79	55	50	M2003-1900	●	M2103-1900	●
19.05	3/4	0.7500	20	131	79	55	50	M2003-1905	●	M2103-1905	●
19.50		0.7677	20	131	79	55	50	M2003-1950	●	M2103-1950	●
19.80		0.7795	20	131	79	55	50	M2003-1980	○	M2103-1980	○
20.00		0.7874	20	131	79	55	50	M2003-2000	●	M2103-2000	●

For machining values see Page 28.

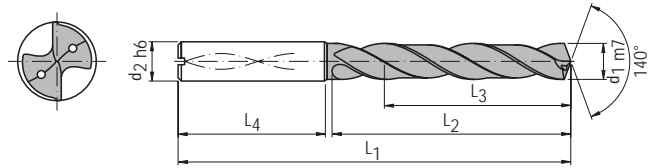
MEGA-Drill-Steel

M2005 / M2105

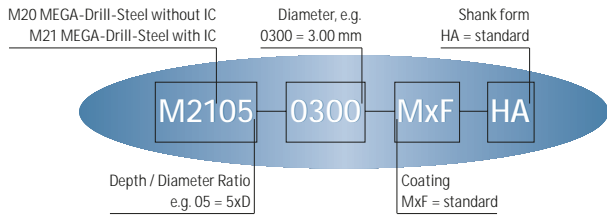


Design:

Drill diameter: 3.00 – 20.00 mm
0.1181 – 0.7874 Inch
Bore tolerance: IT 9 (achievable)
No. of margins: 2



To order, use the code given in the table and supplement it with the required coating and shank form.
Complete order code:



Drill diameter		Dimensions						M2005	M2105
mm	Inch / Wire / Letter	Dec. equiv. Inch	Shank diameter d ₂ h ₆ mm	Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm	Shank length L ₄ mm	Order code	Order code
								Form / Diameter	Form / Diameter
3.00		0.1181	6	66	28	23	36	M2005-0300 ●	M2105-0300 ●
3.10		0.1220	6	66	28	23	36	M2005-0310 ●	M2105-0310 ●
3.18	1/8	0.1250	6	66	28	23	36	M2005-0318 ●	M2105-0318 ●
3.20		0.1260	6	66	28	23	36	M2005-0320 ○	M2105-0320 ●
3.30		0.1299	6	66	28	23	36	M2005-0330 ●	M2105-0330 ●
3.40		0.1339	6	66	28	23	36	M2005-0340 ○	M2105-0340 ○
3.45	#29	0.1358	6	66	28	23	36	M2005-0345 ●	M2105-0345 ●
3.50		0.1378	6	66	28	23	36	M2005-0350 ●	M2105-0350 ●
3.57	9/64	0.1406	6	66	28	23	36	M2005-0357 ●	M2105-0357 ●
3.60		0.1417	6	66	28	23	36	M2005-0360 ●	M2105-0360 ●
3.70		0.1457	6	66	28	23	36	M2005-0370 ●	M2105-0370 ●
3.80	#25	0.1496	6	74	36	29	36	M2005-0380 ●	M2105-0380 ●
3.86	#24	0.1520	6	74	36	29	36	M2005-0386 ●	M2105-0386 ●
3.90		0.1535	6	74	36	29	36	M2005-0390 ○	M2105-0390 ○
3.97	5/32	0.1562	6	74	36	29	36	M2005-0397 ●	M2105-0397 ●
4.00		0.1575	6	74	36	29	36	M2005-0400 ●	M2105-0400 ●
4.04	#21	0.1591	6	74	36	29	36	M2005-0404 ●	M2105-0404 ●
4.10		0.1614	6	74	36	29	36	M2005-0410 ●	M2105-0410 ●
4.20		0.1654	6	74	36	29	36	M2005-0420 ●	M2105-0420 ●
4.30	#18	0.1693	6	74	36	29	36	M2005-0430 ●	M2105-0430 ●
4.37	11/64	0.1719	6	74	36	29	36	M2005-0437 ●	M2105-0437 ●
4.40		0.1732	6	74	36	29	36	M2005-0440 ●	M2105-0440 ●
4.50	#16	0.1772	6	74	36	29	36	M2005-0450 ●	M2105-0450 ●
4.60		0.1811	6	74	36	29	36	M2005-0460 ●	M2105-0460 ●
4.62	#14	0.1819	6	74	36	29	36	M2005-0462 ●	M2105-0462 ●

For machining values see Page 28.

MEGA-Drill-Steel

M2005 / M2105

5xD



mm	Drill diameter d ₁ m7		Shank diameter d ₂ h6 mm	Dimensions				Shank length L ₄ mm	M2005		M2105	
	Inch / Wire / Letter	Dec. equiv. Inch		Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm	Order code Form / Diameter		Order code Form / Diameter			
4.70	#13	0.1850	6	74	36	29	36	M2005-0470	●	M2105-0470	●	
4.76	3/16	0.1875	6	82	44	35	36	M2005-0476	●	M2105-0476	●	
4.80	#12	0.1890	6	82	44	35	36	M2005-0480	○	M2105-0480	●	
4.90		0.1929	6	82	44	35	36	M2005-0490	○	M2105-0490	○	
5.00		0.1969	6	82	44	35	36	M2005-0500	●	M2105-0500	●	
5.10		0.2008	6	82	44	35	36	M2005-0510	●	M2105-0510	●	
5.16	13/64	0.2031	6	82	44	35	36	M2005-0516	●	M2105-0516	●	
5.20		0.2047	6	82	44	35	36	M2005-0520	●	M2105-0520	●	
5.30		0.2087	6	82	44	35	36	M2005-0530	○	M2105-0530	○	
5.40		0.2126	6	82	44	35	36	M2005-0540	○	M2105-0540	○	
5.50		0.2165	6	82	44	35	36	M2005-0550	●	M2105-0550	●	
5.56	7/32	0.2188	6	82	44	35	36	M2005-0556	●	M2105-0556	●	
5.60		0.2205	6	82	44	35	36	M2005-0560	●	M2105-0560	●	
5.70		0.2244	6	82	44	35	36	M2005-0570	●	M2105-0570	●	
5.80		0.2283	6	82	44	35	36	M2005-0580	○	M2105-0580	○	
5.90		0.2323	6	82	44	35	36	M2005-0590	●	M2105-0590	●	
5.95	15/64	0.2344	6	82	44	35	36	M2005-0595	●	M2105-0595	●	
6.00		0.2362	6	82	44	35	36	M2005-0600	●	M2105-0600	●	
6.10		0.2402	8	91	53	43	36	M2005-0610	○	M2105-0610	○	
6.15	C	0.2421	8	91	53	43	36	M2005-0615	●	M2105-0615	●	
6.20		0.2441	8	91	53	43	36	M2005-0620	○	M2105-0620	○	
6.30		0.2480	8	91	53	43	36	M2005-0630	○	M2105-0630	○	
6.35	1/4	0.2500	8	91	53	43	36	M2005-0635	●	M2105-0635	●	
6.40		0.2520	8	91	53	43	36	M2005-0640	○	M2105-0640	○	
6.50		0.2559	8	91	53	43	36	M2005-0650	●	M2105-0650	●	
6.53	F	0.2571	8	91	53	43	36	M2005-0653	●	M2105-0653	●	
6.60		0.2598	8	91	53	43	36	M2005-0660	●	M2105-0660	●	
6.63	G	0.2610	8	91	53	43	36	M2005-0663	●	M2105-0663	●	
6.70		0.2638	8	91	53	43	36	M2005-0670	○	M2105-0670	○	
6.75	17/64	0.2656	8	91	53	43	36	M2005-0675	●	M2105-0675	●	
6.80		0.2677	8	91	53	43	36	M2005-0680	●	M2105-0680	●	
6.90	I	0.2717	8	91	53	43	36	M2005-0690	●	M2105-0690	●	
7.00		0.2756	8	91	53	43	36	M2005-0700	●	M2105-0700	●	
7.10		0.2795	8	91	53	43	36	M2005-0710	○	M2105-0710	○	
7.14	9/32	0.2812	8	91	53	43	36	M2005-0714	●	M2105-0714	●	
7.20		0.2835	8	91	53	43	36	M2005-0720	●	M2105-0720	●	
7.30		0.2874	8	91	53	43	36	M2005-0730	●	M2105-0730	●	
7.40		0.2913	8	91	53	43	36	M2005-0740	●	M2105-0740	●	
7.50		0.2953	8	91	53	43	36	M2005-0750	●	M2105-0750	●	
7.54	19/64	0.2969	8	91	53	43	36	M2005-0754	●	M2105-0754	●	
7.60		0.2992	8	91	53	43	36	M2005-0760	●	M2105-0760	○	
7.70		0.3031	8	91	53	43	36	M2005-0770	●	M2105-0770	●	
7.80		0.3071	8	91	53	43	36	M2005-0780	●	M2105-0780	●	
7.90		0.3110	8	91	53	43	36	M2005-0790	○	M2105-0790	○	
7.94	5/16	0.3125	8	91	53	43	36	M2005-0794	●	M2105-0794	●	

For machining values see Page 28.

MEGA-Drill-Steel

M2005 / M2105

5xD

Drill diameter			Dimensions					M2005		M2105	
mm	d ₁ m7	Dec. equiv. Inch	Shank diameter d ₂ h6 mm	Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm	Shank length L ₄ mm	 M2005	 M2105	Order code Form / Diameter	Order code Form / Diameter
	Inch / Wire / Letter										
8.00		0.3150	8	91	53	43	36	M2005-0800	●	M2105-0800	●
8.10		0.3189	10	103	61	49	40	M2005-0810	○	M2105-0810	○
8.20	P	0.3228	10	103	61	49	40	M2005-0820	○	M2105-0820	○
8.30		0.3268	10	103	61	49	40	M2005-0830	○	M2105-0830	○
8.33	21/64	0.3281	10	103	61	49	40	M2005-0833	●	M2105-0833	●
8.40		0.3307	10	103	61	49	40	M2005-0840	○	M2105-0840	○
8.43	Q	0.3319	10	103	61	49	40	M2005-0843	●	M2105-0843	●
8.50		0.3346	10	103	61	49	40	M2005-0850	●	M2105-0850	●
8.60		0.3386	10	103	61	49	40	M2005-0860	○	M2105-0860	○
8.70		0.3425	10	103	61	49	40	M2005-0870	○	M2105-0870	○
8.73	11/32	0.3438	10	103	61	49	40	M2005-0873	●	M2105-0873	●
8.80		0.3465	10	103	61	49	40	M2005-0880	●	M2105-0880	●
8.90		0.3504	10	103	61	49	40	M2005-0890	○	M2105-0890	○
9.00		0.3543	10	103	61	49	40	M2005-0900	●	M2105-0900	●
9.10		0.3583	10	103	61	49	40	M2005-0910	○	M2105-0910	○
9.13	23/64	0.3594	10	103	61	49	40	M2005-0913	●	M2105-0913	●
9.20		0.3622	10	103	61	49	40	M2005-0920	○	M2105-0920	○
9.30		0.3661	10	103	61	49	40	M2005-0930	●	M2105-0930	●
9.35	U	0.3681	10	103	61	49	40	M2005-0935	●	M2105-0935	●
9.40		0.3701	10	103	61	49	40	M2005-0940	●	M2105-0940	●
9.50		0.3740	10	103	61	49	40	M2005-0950	●	M2105-0950	●
9.53	3/8	0.3750	10	103	61	49	40	M2005-0953	●	M2105-0953	●
9.60		0.3780	10	103	61	49	40	M2005-0960	●	M2105-0960	●
9.70		0.3819	10	103	61	49	40	M2005-0970	○	M2105-0970	○
9.80	W	0.3858	10	103	61	49	40	M2005-0980	○	M2105-0980	○
9.90		0.3898	10	103	61	49	40	M2005-0990	●	M2105-0990	●
9.92	25/64	0.3906	10	103	61	49	40	M2005-0992	●	M2105-0992	●
10.00		0.3937	10	103	61	49	40	M2005-1000	●	M2105-1000	●
10.10		0.3976	12	118	71	56	45	M2005-1010	○	M2105-1010	○
10.20		0.4016	12	118	71	56	45	M2005-1020	●	M2105-1020	●
10.26	Y	0.4039	12	118	71	56	45	M2005-1026	●	M2105-1026	●
10.30		0.4055	12	118	71	56	45	M2005-1030	●	M2105-1030	●
10.32	13/32	0.4062	12	118	71	56	45	M2005-1032	●	M2105-1032	●
10.40		0.4094	12	118	71	56	45	M2005-1040	○	M2105-1040	○
10.50		0.4134	12	118	71	56	45	M2005-1050	●	M2105-1050	●
10.60		0.4173	12	118	71	56	45	M2005-1060	○	M2105-1060	○
10.70		0.4213	12	118	71	56	45	M2005-1070	●	M2105-1070	●
10.72	27/64	0.4219	12	118	71	56	45	M2005-1072	●	M2105-1072	●
10.80		0.4252	12	118	71	56	45	M2005-1080	○	M2105-1080	○
10.90		0.4291	12	118	71	56	45	M2005-1090	○	M2105-1090	○
11.00		0.4331	12	118	71	56	45	M2005-1100	●	M2105-1100	●
11.10		0.4370	12	118	71	56	45	M2005-1110	○	M2105-1110	○
11.11	7/16	0.4375	12	118	71	56	45	M2005-1111	●	M2105-1111	●
11.20		0.4409	12	118	71	56	45	M2005-1120	●	M2105-1120	●
11.30		0.4449	12	118	71	56	45	M2005-1130	●	M2105-1130	●

For machining values see Page 28.

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M2005 / M2105

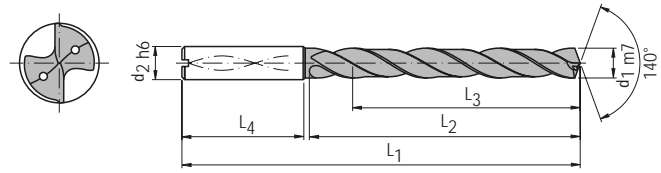
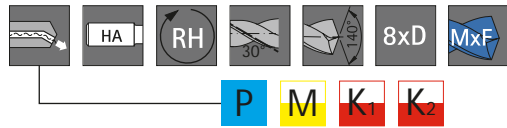
5xD

mm	Drill diameter d1 m7		Shank diameter d2 h6 mm	Dimensions				Shank length L4 mm	M2005		M2105	
	Inch / Wire / Letter	Dec. equiv. Inch		Total length L1 mm	Margin length L2 mm	Maximum drilling depth L3 mm	Order code Form / Diameter		Order code Form / Diameter			
11.40		0.4488	12	118	71	56	45	M2005-1140	●	M2105-1140	●	
11.50	29/64	0.4528	12	118	71	56	45	M2005-1150	●	M2105-1150	●	
11.60		0.4567	12	118	71	56	45	M2005-1160	○	M2105-1160	○	
11.70		0.4606	12	118	71	56	45	M2005-1170	○	M2105-1170	○	
11.80		0.4646	12	118	71	56	45	M2005-1180	●	M2105-1180	●	
11.90	15/32	0.4685	12	118	71	56	45	M2005-1190	●	M2105-1190	●	
12.00		0.4724	12	118	71	56	45	M2005-1200	●	M2105-1200	●	
12.30	31/64	0.4843	14	124	77	60	45	M2005-1230	●	M2105-1230	●	
12.50		0.4921	14	124	77	60	45	M2005-1250	●	M2105-1250	●	
12.70	1/2	0.5000	14	124	77	60	45	M2005-1270	●	M2105-1270	●	
12.80		0.5039	14	124	77	60	45	M2005-1280	●	M2105-1280	●	
13.00		0.5118	14	124	77	60	45	M2005-1300	●	M2105-1300	●	
13.10	33/64	0.5157	14	124	77	60	45	M2005-1310	●	M2105-1310	●	
13.30		0.5236	14	124	77	60	45	M2005-1330	●	M2105-1330	●	
13.50		0.5315	14	124	77	60	45	M2005-1350	●	M2105-1350	●	
13.80		0.5433	14	124	77	60	45	M2005-1380	○	M2105-1380	○	
14.00		0.5512	14	124	77	60	45	M2005-1400	●	M2105-1400	●	
14.30	9/16	0.5630	16	133	83	63	48	M2005-1430	●	M2105-1430	●	
14.50		0.5709	16	133	83	63	48	M2005-1450	●	M2105-1450	●	
14.68	37/64	0.5780	16	133	83	63	48	M2005-1468	●	M2105-1468	●	
14.80		0.5827	16	133	83	63	48	M2005-1480	●	M2105-1480	●	
15.00		0.5906	16	133	83	63	48	M2005-1500	●	M2105-1500	●	
15.08	19/32	0.5937	16	133	83	63	48	M2005-1508	●	M2105-1508	●	
15.50		0.6102	16	133	83	63	48	M2005-1550	●	M2105-1550	●	
15.80		0.6220	16	133	83	63	48	M2005-1580	○	M2105-1580	○	
15.88	5/8	0.6250	16	133	83	63	48	M2005-1588	●	M2105-1588	●	
16.00		0.6299	16	133	83	63	48	M2005-1600	●	M2105-1600	●	
16.50		0.6496	18	143	93	71	48	M2005-1650	●	M2105-1650	●	
16.67	21/32	0.6563	18	143	93	71	48	M2005-1667	●	M2105-1667	●	
16.80		0.6614	18	143	93	71	48	M2005-1680	●	M2105-1680	●	
17.00		0.6693	18	143	93	71	48	M2005-1700	●	M2105-1700	●	
17.46	11/16	0.6874	18	143	93	71	48	M2005-1746	●	M2105-1746	●	
17.50		0.6890	18	143	93	71	48	M2005-1750	●	M2105-1750	●	
17.80		0.7008	18	143	93	71	48	M2005-1780	○	M2105-1780	○	
17.86	45/64	0.7031	18	143	93	71	48	M2005-1786	●	M2105-1786	●	
18.00		0.7087	18	143	93	71	48	M2005-1800	●	M2105-1800	●	
18.26	23/32	0.7189	20	153	101	77	50	M2005-1826	●	M2105-1826	●	
18.50		0.7283	20	153	101	77	50	M2005-1850	●	M2105-1850	●	
18.80		0.7402	20	153	101	77	50	M2005-1880	○	M2105-1880	○	
19.00		0.7480	20	153	101	77	50	M2005-1900	●	M2105-1900	●	
19.05	3/4	0.7500	20	153	101	77	50	M2005-1905	●	M2105-1905	●	
19.50		0.7677	20	153	101	77	50	M2005-1950	●	M2105-1950	●	
19.80		0.7795	20	153	101	77	50	M2005-1980	○	M2105-1980	○	
20.00		0.7874	20	153	101	77	50	M2005-2000	●	M2105-2000	●	

For machining values see Page 28.

MEGA-Drill-Steel

M2108



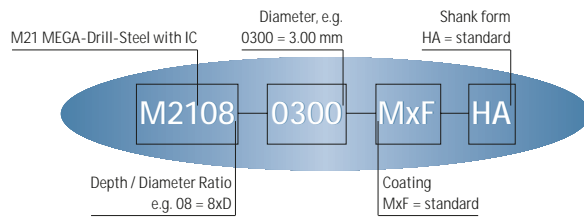
Design:

Drill diameter: 3.00 – 20.00 mm
0.1181 – 0.7874 Inch

Bore tolerance: IT 9 (achievable)

No. of margins: 2

To order, use the code given in the table and supplement it with the required coating and shank form.
Complete order code:




Drill diameter		Shank diameter		Total length		Margin length		Maximum drilling depth		Shank length		M2108 Order code Form / Diameter
mm	Inch / Wire / Letter	Dec. equivalent Inch	d ₂ h ₆ mm	L ₁ mm	L ₂ mm	L ₃ mm	L ₄ mm	d ₁ m7	L ₃ mm	L ₄ mm		
3.00		0.1181	6	72	34	29	36				M2108-0300	●
3.10		0.1220	6	72	34	29	36				M2108-0310	●
3.18	1/8	0.1250	6	72	34	29	36				M2108-0318	●
3.20		0.1260	6	72	34	29	36				M2108-0320	●
3.30		0.1299	6	72	34	29	36				M2108-0330	●
3.40		0.1339	6	72	34	29	36				M2108-0340	○
3.45	#29	0.1358	6	72	34	29	36				M2108-0345	●
3.50		0.1378	6	72	34	29	36				M2108-0350	●
3.57	9/64	0.1406	6	72	34	29	36				M2108-0357	●
3.60		0.1417	6	72	34	29	36				M2108-0360	●
3.70		0.1457	6	72	34	29	36				M2108-0370	●
3.80	#25	0.1496	6	81	43	36	36				M2108-0380	●
3.86	#24	0.1520	6	81	43	36	36				M2108-0386	●
3.90		0.1535	6	81	43	36	36				M2108-0390	○
3.97	5/32	0.1562	6	81	43	36	36				M2108-0397	●
4.00		0.1575	6	81	43	36	36				M2108-0400	●
4.04	#21	0.1591	6	81	43	36	36				M2108-0404	●
4.10		0.1614	6	81	43	36	36				M2108-0410	●
4.20		0.1654	6	81	43	36	36				M2108-0420	●
4.30	#18	0.1693	6	81	43	36	36				M2108-0430	●
4.37	11/64	0.1719	6	81	43	36	36				M2108-0437	●
4.40		0.1732	6	81	43	36	36				M2108-0440	●
4.50	#16	0.1772	6	81	43	36	36				M2108-0450	●
4.60		0.1811	6	81	43	36	36				M2108-0460	●
4.62	#14	0.1819	6	81	43	36	36				M2108-0462	●

For machining values see Page 28.

MEGA-Drill-Steel M2108

8xD


Drill diameter d ₁ m7		Dimensions						 M2108	Order code Form / Diameter	
mm	Inch / Wire / Letter	Dec. equivalent Inch	Shank diameter d ₂ h6 mm	Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm	Shank length L ₄ mm			
4.70	#13	0.1850	6	81	43	36	36	M2108-0470	●	
4.76	3/16	0.1875	6	95	57	48	36	M2108-0476	●	
4.80	#12	0.1890	6	95	57	48	36	M2108-0480	○	
4.90		0.1929	6	95	57	48	36	M2108-0490	○	
5.00		0.1969	6	95	57	48	36	M2108-0500	●	
5.10		0.2008	6	95	57	48	36	M2108-0510	●	
5.16	13/64	0.2031	6	95	57	48	36	M2108-0516	●	
5.20		0.2047	6	95	57	48	36	M2108-0520	●	
5.30		0.2087	6	95	57	48	36	M2108-0530	○	
5.40		0.2126	6	95	57	48	36	M2108-0540	○	
5.50		0.2165	6	95	57	48	36	M2108-0550	●	
5.56	7/32	0.2188	6	95	57	48	36	M2108-0556	●	
5.60		0.2205	6	95	57	48	36	M2108-0560	●	
5.70		0.2244	6	95	57	48	36	M2108-0570	●	
5.80		0.2283	6	95	57	48	36	M2108-0580	○	
5.90		0.2323	6	95	57	48	36	M2108-0590	●	
5.95	15/64	0.2344	6	95	57	48	36	M2108-0595	●	
6.00		0.2362	6	95	57	48	36	M2108-0600	●	
6.10		0.2402	8	114	76	64	36	M2108-0610	○	
6.15	C	0.2421	8	114	76	64	36	M2108-0615	●	
6.20		0.2441	8	114	76	64	36	M2108-0620	○	
6.30		0.2480	8	114	76	64	36	M2108-0630	○	
6.35	1/4	0.2500	8	114	76	64	36	M2108-0635	●	
6.40		0.2520	8	114	76	64	36	M2108-0640	○	
6.50		0.2559	8	114	76	64	36	M2108-0650	●	
6.53	F	0.2571	8	114	76	64	36	M2108-0653	●	
6.60		0.2598	8	114	76	64	36	M2108-0660	●	
6.63	G	0.2610	8	114	76	64	36	M2108-0663	●	
6.70		0.2638	8	114	76	64	36	M2108-0670	○	
6.75	17/64	0.2656	8	114	76	64	36	M2108-0675	●	
6.80		0.2677	8	114	76	64	36	M2108-0680	●	
6.90	I	0.2717	8	114	76	64	36	M2108-0690	●	
7.00		0.2756	8	114	76	64	36	M2108-0700	●	
7.10		0.2795	8	114	76	64	36	M2108-0710	○	
7.14	9/32	0.2812	8	114	76	64	36	M2108-0714	●	
7.20		0.2835	8	114	76	64	36	M2108-0720	●	
7.30		0.2874	8	114	76	64	36	M2108-0730	●	
7.40		0.2913	8	114	76	64	36	M2108-0740	●	
7.50		0.2953	8	114	76	64	36	M2108-0750	●	
7.54	19/64	0.2969	8	114	76	64	36	M2108-0754	●	
7.60		0.2992	8	114	76	64	36	M2108-0760	●	
7.70		0.3031	8	114	76	64	36	M2108-0770	●	
7.80		0.3071	8	114	76	64	36	M2108-0780	●	
7.90		0.3110	8	114	76	64	36	M2108-0790	○	
7.94	5/16	0.3125	8	114	76	64	36	M2108-0794	●	

For machining values see Page 28.

MEGA-Drill-Steel

M2108


8xD

Drill diameter		Dimensions						 M2108 Order code Form / Diameter	
mm	d ₁ m7 Inch / Wire / Letter	Dec. equivalent Inch	Shank diameter d ₂ h6 mm	Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm	Shank length L ₄ mm		
8.00		0.3150	8	114	76	64	36	M2108-0800	●
8.10		0.3189	10	142	95	80	40	M2108-0810	○
8.20	P	0.3228	10	142	95	80	40	M2108-0820	○
8.30		0.3268	10	142	95	80	40	M2108-0830	○
8.33	21/64	0.3281	10	142	95	80	40	M2108-0833	●
8.40		0.3307	10	142	95	80	40	M2108-0840	○
8.43	Q	0.3319	10	142	95	80	40	M2108-0843	●
8.50		0.3346	10	142	95	80	40	M2108-0850	●
8.60		0.3386	10	142	95	80	40	M2108-0860	○
8.70		0.3425	10	142	95	80	40	M2108-0870	○
8.73	11/32	0.3438	10	142	95	80	40	M2108-0873	●
8.80		0.3465	10	142	95	80	40	M2108-0880	●
8.90		0.3504	10	142	95	80	40	M2108-0890	○
9.00		0.3543	10	142	95	80	40	M2108-0900	●
9.10		0.3583	10	142	95	80	40	M2108-0910	○
9.13	23/64	0.3594	10	142	95	80	40	M2108-0913	●
9.20		0.3622	10	142	95	80	40	M2108-0920	○
9.30		0.3661	10	142	95	80	40	M2108-0930	●
9.35	U	0.3681	10	142	95	80	40	M2108-0935	●
9.40		0.3701	10	142	95	80	40	M2108-0940	●
9.50		0.3740	10	142	95	80	40	M2108-0950	●
9.53	3/8	0.3750	10	142	95	80	40	M2108-0953	●
9.60		0.3780	10	142	95	80	40	M2108-0960	●
9.70		0.3819	10	142	95	80	40	M2108-0970	○
9.80	W	0.3858	10	142	95	80	40	M2108-0980	○
9.90		0.3898	10	142	95	80	40	M2108-0990	●
9.92	25/64	0.3906	10	142	95	80	40	M2108-0992	●
10.00		0.3937	10	142	95	80	40	M2108-1000	●
10.10		0.3976	12	162	114	96	45	M2108-1010	○
10.20		0.4016	12	162	114	96	45	M2108-1020	●
10.26	Y	0.4039	12	162	114	96	45	M2108-1026	●
10.30		0.4055	12	162	114	96	45	M2108-1030	●
10.32	13/32	0.4062	12	162	114	96	45	M2108-1032	●
10.40		0.4094	12	162	114	96	45	M2108-1040	○
10.50		0.4134	12	162	114	96	45	M2108-1050	●
10.60		0.4173	12	162	114	96	45	M2108-1060	○
10.70		0.4213	12	162	114	96	45	M2108-1070	●
10.72	27/64	0.4219	12	162	114	96	45	M2108-1072	●
10.80		0.4252	12	162	114	96	45	M2108-1080	○
10.90		0.4291	12	162	114	96	45	M2108-1090	○
11.00		0.4331	12	162	114	96	45	M2108-1100	●
11.10		0.4370	12	162	114	96	45	M2108-1110	○
11.11	7/16	0.4375	12	162	114	96	45	M2108-1111	●
11.20		0.4409	12	162	114	96	45	M2108-1120	●
11.30		0.4449	12	162	114	96	45	M2108-1130	●

For machining values see Page 28.

MEGA-Drill-Steel M2108

8xD

Drill diameter d ₁ m7		Dec. equivalent Inch	Dimensions					Shank length L ₄ mm	 M2108	Order code Form / Diameter	
mm	Inch / Wire / Letter		Shank diameter d ₂ h6 mm	Total length L ₁ mm	Margin length L ₂ mm	Maximum drilling depth L ₃ mm					
11.40		0.4488	12	162	114	96	45	M2108-1140	●		
11.50	29/64	0.4528	12	162	114	96	45	M2108-1150	●		
11.60		0.4567	12	162	114	96	45	M2108-1160	○		
11.70		0.4606	12	162	114	96	45	M2108-1170	○		
11.80		0.4646	12	162	114	96	45	M2108-1180	○		
11.90	15/32	0.4685	12	162	114	96	45	M2108-1190	●		
12.00		0.4724	12	162	114	96	45	M2108-1200	●		
12.30	31/64	0.4843	14	178	133	112	45	M2108-1230	○		
12.50		0.4921	14	178	133	112	45	M2108-1250	●		
12.70	1/2	0.5000	14	178	133	112	45	M2108-1270	●		
12.80		0.5039	14	178	133	112	45	M2108-1280	●		
13.00		0.5118	14	178	133	112	45	M2108-1300	●		
13.10	33/64	0.5157	14	178	133	112	45	M2108-1310	○		
13.30		0.5236	14	178	133	112	45	M2108-1330	●		
13.50		0.5315	14	178	133	112	45	M2108-1350	●		
13.80		0.5433	14	178	133	112	45	M2108-1380	○		
14.00		0.5512	14	178	133	112	45	M2108-1400	●		
14.30	9/16	0.5630	16	203	152	128	48	M2108-1430	●		
14.50		0.5709	16	203	152	128	48	M2108-1450	●		
14.68	37/64	0.5780	16	203	152	128	48	M2108-1468	●		
14.80		0.5827	16	203	152	128	48	M2108-1480	●		
15.00		0.5906	16	203	152	128	48	M2108-1500	●		
15.08	19/32	0.5937	16	203	152	128	48	M2108-1508	●		
15.50		0.6102	16	203	152	128	48	M2108-1550	●		
15.80		0.6220	16	203	152	128	48	M2108-1580	○		
15.88	5/8	0.6250	16	203	152	128	48	M2108-1588	●		
16.00		0.6299	16	203	152	128	48	M2108-1600	●		
16.50		0.6496	18	222	171	144	48	M2108-1650	●		
16.67	21/32	0.6563	18	222	171	144	48	M2108-1667	●		
16.80		0.6614	18	222	171	144	48	M2108-1680	●		
17.00		0.6693	18	222	171	144	48	M2108-1700	●		
17.46	11/16	0.6874	18	222	171	144	48	M2108-1746	●		
17.50		0.6890	18	222	171	144	48	M2108-1750	●		
17.80		0.7008	18	222	171	144	48	M2108-1780	○		
17.86	45/64	0.7031	18	222	171	144	48	M2108-1786	●		
18.00		0.7087	18	222	171	144	48	M2108-1800	●		
18.26	23/32	0.7189	20	243	190	160	50	M2108-1826	●		
18.50		0.7283	20	243	190	160	50	M2108-1850	●		
18.80		0.7402	20	243	190	160	50	M2108-1880	○		
19.00		0.7480	20	243	190	160	50	M2108-1900	●		
19.05	3/4	0.7500	20	243	190	160	50	M2108-1905	●		
19.50		0.7677	20	243	190	160	50	M2108-1950	●		
19.80		0.7795	20	243	190	160	50	M2108-1980	○		
20.00		0.7874	20	243	190	160	50	M2108-2000	○		

For machining values see Page 28.

Machining values for MEGA-Drill-Steel



M2003, M2005



M2103, M2105, M2108



M2003, M2005

	Material	Hardness Rockwell (HRc) Hardness Brinell (BHN) Tensile strength (N/mm ²)			Cutting speed (v _c)				
		HRc	BHN	N/mm ²	M2003 M2005		M2103 M2105 M2108		
				SFM	m/min	SFM	m/min		
P	Non-alloyed steels, cast steels 1018, 1108-1161, 12L14, 1522-1572	up to 8	up to 178	up to 600	279-328	85-100	312-377	95-115	
		up to 15	up to 205	up to 700	246-295	75-90	279-344	85-105	
		over 15	over 205	over 700	213-262	65-80	246-295	75-90	
	Alloyed steels 5132, 4130, 8620, 4140, 4340, 5140, 6150	up to 27	up to 266	up to 900	180-246	55-75	197-279	60-85	
		up to 31	up to 297	up to 1000	147-197	45-60	164-230	50-70	
		over 31	over 297	over 1000	115-164	35-50	131-197	40-60	
M	Stainless steels Inox 17-4PH, 15-5PH					98-164	30-50		
	Stainless and acid resistant steels (Cr-Ni-Alloys) 304, 316, 17CrNi16-2					98-131	30-40		
K ₁	Grey cast iron, grey cast iron alloys GG10-GG40, A48	up to 14	up to 200	up to 680	230-361	70-110	262-427	80-130	
		up to 24	up to 250	up to 850	197-312	60-95	230-377	70-115	
		over 24	over 250	over 850	164-262	50-80	197-328	60-100	
K ₂	Spheroidal graphite cast iron, cast iron with vermicular graphite, malleable iron GGG40-GGG80	up to 8	up to 178	up to 600	213-279	65-85	246-295	75-90	
		over 8	over 178	over 600	180-230	55-70	213-262	65-80	
N	Alluminium (Si content > 10%) 6061, 2025, 208, 360								
	Aluminium (Si content < 10%) 413, 385, A390								
	Copper, brass, bronze Beryllium copper, naval brass, AMPCO								
S	Titanium alloys TiAl4V								
	Nickel alloys Inconel 718, Rene 41, Waspolloy								
H	Chilled cast iron	38-48	350-450	1173-1527	115-197	35-60	131-230	40-70	
	Hardened steel	50-55		1614-1870					
		56-60							
		61-65							

The guideline values for cutting speed v_c should be multiplied by the following correction factors K_{Fv} according to the drilling depth:

Depth / Diameter ratio	K _{Fv}
1 x D	1.3
2 x D	1.2
3 x D	1.0
4 x D	1.0
5 x D	0.8
8 x D	0.7