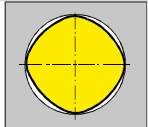


Thermdrill-Drill Selection & RPM

Thread	diameter	suggested max. material thickness				Shaft	Lenght	Length	RPM Range*			RPM Tapping
	[mm]	[mm]		[mm]		[mm]	[mm]	[mm]	min.	optimum	>	
		form-type		cut-type			working part	working part		Steel	Brass, Copper, Aluminium	
		short	long	short	long		short	long				
M3	2,7	1,5	2,0	1,5	3,0	6,0	6,4	7,6	2.600	3.000	4.000	1.350
M4	3,7	1,5	2,5	2,0	4,0	6,0	7,6	10,1	2.300	2.600	3.800	1.000
M5	4,5	2,0	3,0	3,0	4,5	6,0	9,1	12,0	2.200	2.500	3.700	800
M6	5,4	2,0	3,5	3,0	5,0	6,0	10,1	14,4	2.000	2.400	3.600	650
M8	7,3/7,4	2,5	4,0	4,0	6,0	8,0	13,5	18,2	1.600	2.200	3.200	500
M10	9,2/9,3	2,5	4,5	4,0	6,5	10,0	16,2	21,7	1.500	2.000	3.000	400
M12	10,9/11,0	3,0	5,0	4,5	7,0	12,0	19,3	25,8	1.400	1.800	2.800	350
M14	13,0/13,1	3,0	5,0	4,5	7,0	14,0	22,7	31,5	1.400	1.600	2.500	250
M16	14,8/14,9	3,5	6,0	5,0	8,0	16,0	26,2	35,7	1.200	1.400	2.200	250
M18	16,7/16,8	3,5	6,0	5,0	8,0	18,0	29,4	39,5	1.100	1.300	2.000	230
M20	18,7/18,8	4,0	8,0	6,0	10,0	20,0	33,1	43,4	1.000	1.200	1.900	200
1/8"	9,2/9,3	2,5	4,5	4,0	6,5	10,0	16,2	21,7	1.500	2.000	3.000	400
1/4"	12,4/12,5	2,5	5,0	4,0	7,0	14,0	21,3	26,4	1.400	1.600	2.600	350
3/8"	15,9/16,0	2,5	5,0	4,0	7,0	16,0	27,0	31,0	1.200	1.400	2.200	300
1/2"	19,9/20,0	2,5	5,0	4,0	7,0	18,0		36,3	1.000	1.200	1.800	250
3/4"	25,4/25,5	2,5	5,0	4,0	7,0	20,0		43,6	900	1.000	1.600	200
1"	32,0/32,1	2,5	5,0	4,0	7,0	20,0		52,3	900	1.000	1.500	150