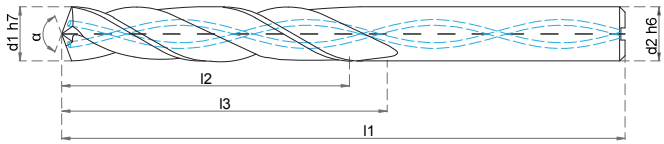
# M12DF

12D Drill With Coolant Holes




| Stock | Order No | Code | d1h7 | d2h6 | l1 | l2 | l3 |
|---|---|---|---|---|---|---|---|
| | **74100** | M12DF.2.0300.0920.A0135.0480.0000.0540.00.S06A2B03.01 | 3 | 6 | 92 | 48 | 54 |
| | **74102** | M12DF.2.0310.0920.A0135.0480.0000.0540.00.S06A2B03.01 | 3,1 | 6 | 92 | 48 | 54 |
| | **74104** | M12DF.2.0320.0920.A0135.0480.0000.0540.00.S06A2B03.01 | 3,2 | 6 | 92 | 48 | 54 |
| | **74106** | M12DF.2.0330.0920.A0135.0480.0000.0540.00.S06A2B03.01 | 3,3 | 6 | 92 | 48 | 54 |
| | **74108** | M12DF.2.0340.0920.A0135.0480.0000.0540.00.S06A2B03.01 | 3,4 | 6 | 92 | 48 | 54 |
| | **74110** | M12DF.2.0350.0920.A0135.0480.0000.0540.00.S06A2B03.01 | 3,5 | 6 | 92 | 48 | 54 |
| | **74112** | M12DF.2.0360.0920.A0135.0480.0000.0540.00.S06A2B03.01 | 3,6 | 6 | 92 | 48 | 54 |
| | **74114** | M12DF.2.0370.0920.A0135.0480.0000.0540.00.S06A2B03.01 | 3,7 | 6 | 92 | 48 | 54 |
| | **74116** | M12DF.2.0380.1020.A0135.0580.0000.0640.00.S06B2A05.01 | 3,8 | 6 | 102 | 58 | 64 |
| | **74118** | M12DF.2.0390.1020.A0135.0580.0000.0640.00.S06B2A05.01 | 3,9 | 6 | 102 | 58 | 64 |
| | **74120** | M12DF.2.0400.1020.A0140.0580.0000.0640.00.S06C2B02.01 | 4 | 6 | 102 | 58 | 64 |
| | **74122** | M12DF.2.0410.1020.A0140.0580.0000.0640.00.S06C2B02.01 | 4,1 | 6 | 102 | 58 | 64 |
| | **74124** | M12DF.2.0420.1020.A0140.0580.0000.0640.00.S06C2B02.01 | 4,2 | 6 | 102 | 58 | 64 |
| | **74126** | M12DF.2.0430.1020.A0140.0580.0000.0640.00.S06C2B02.01 | 4,3 | 6 | 102 | 58 | 64 |
| | **74128** | M12DF.2.0440.1020.A0140.0580.0000.0640.00.S06C2B02.01 | 4,4 | 6 | 102 | 58 | 64 |
| | **74130** | M12DF.2.0450.1020.A0140.0580.0000.0640.00.S06C2B02.01 | 4,5 | 6 | 102 | 58 | 64 |
| | **74132** | M12DF.2.0460.1020.A0140.0580.0000.0640.00.S06C2B02.01 | 4,6 | 6 | 102 | 58 | 64 |
| | **74134** | M12DF.2.0470.1020.A0140.0580.0000.0640.00.S06C2B02.01 | 4,7 | 6 | 102 | 58 | 64 |
| | **74136** | M12DF.2.0480.1160.A0135.0700.0000.0780.00.S06B2B03.01 | 4,8 | 6 | 116 | 70 | 78 |
| | **74138** | M12DF.2.0490.1160.A0135.0700.0000.0780.00.S06B2B03.01 | 4,9 | 6 | 116 | 70 | 78 |
| | **74140** | M12DF.2.0500.1160.A0135.0700.0000.0780.00.S06C2B02.01 | 5 | 6 | 116 | 70 | 78 |
| | **74142** | M12DF.2.0530.1260.A0140.0750.0000.0880.00.S06C2B02.01 | 5,3 | 6 | 126 | 75 | 88 |
| | **74144** | M12DF.2.0550.1160.A0135.0700.0000.0780.00.S06B2B03.01 | 5,5 | 6 | 116 | 70 | 78 |
| | **74146** | M12DF.2.0560.1220.A0140.0840.0000.0750.00.S06C2B02.01 | 5,6 | 6 | 122 | 84 | 75 |
| | **74148** | M12DF.2.0580.1160.A0135.0700.0000.0780.00.S06B2B03.01 | 5,8 | 6 | 116 | 70 | 78 |
| | **74150** | M12DF.2.0600.1160.A0135.0700.0000.0780.00.S06C2B02.01 | 6 | 6 | 116 | 70 | 78 |
| | **74152** | M12DF.2.0630.1460.A0135.0940.0000.1080.00.S08B2B02.01 | 6,3 | 8 | 146 | 94 | 108 |
| | **74154** | M12DF.2.0650.1460.A0135.0940.0000.1080.00.S08B2B02.01 | 6,5 | 8 | 146 | 94 | 108 |
| | **74156** | M12DF.2.0660.1460.A0135.0940.0000.1080.00.S08B2B02.01 | 6,6 | 8 | 146 | 94 | 108 |
| | **74158** | M12DF.2.0680.1460.A0135.0940.0000.1080.00.S08B2B02.01 | 6,8 | 8 | 146 | 94 | 108 |
| | **74160** | M12DF.2.0700.1460.A0135.0940.0000.1080.00.S08B2B02.01 | 7 | 8 | 146 | 94 | 108 |
| | **74162** | M12DF.2.0750.1460.A0135.0940.0000.1080.00.S08B2B02.01 | 7,5 | 8 | 146 | 94 | 108 |
| | **74164** | M12DF.2.0780.1460.A0135.0940.0000.1080.00.S08B2B02.01 | 7,8 | 8 | 146 | 94 | 108 |
| | **74166** | M12DF.2.0800.1460.A0135.0940.0000.1080.00.S08B2B02.01 | 8 | 8 | 146 | 94 | 108 |
| | **74168** | M12DF.2.0820.1620.A0135.1100.0000.1200.00.S10C2B02.01 | 8,2 | 10 | 162 | 110 | 120 |
| | **74170** | M12DF.2.0850.1620.A0135.1100.0000.1200.00.S10C2B02.01 | 8,5 | 10 | 162 | 110 | 120 |
| | **74172** | M12DF.2.0900.1620.A0135.1100.0000.1200.00.S10C2B02.01 | 9 | 10 | 162 | 110 | 120 |
| | **74174** | M12DF.2.0950.1620.A0135.1100.0000.1200.00.S10B2B03.01 | 9,5 | 10 | 162 | 110 | 120 |
| | **74176** | M12DF.2.0980.1620.A0135.1100.0000.1200.00.S10B2B03.01 | 9,8 | 10 | 162 | 110 | 120 |
| | **74178** | M12DF.2.1000.1620.A0135.1100.0000.1200.00.S10B2B03.01 | 10 | 10 | 162 | 110 | 120 |
| | **74180** | M12DF.2.1050.2040.A0135.1420.0000.1560.00.S12B2B03.01 | 10,5 | 12 | 204 | 142 | 156 |
| | **74182** | M12DF.2.1100.2040.A0135.1420.0000.1560.00.S12B2B03.01 | 11 | 12 | 204 | 142 | 156 |
| | **74184** | M12DF.2.1150.2040.A0135.1420.0000.1560.00.S12B2B03.01 | 11,5 | 12 | 204 | 142 | 156 |
| | **74186** | M12DF.2.1200.2040.A0135.1420.0000.1560.00.S12B2B03.01 | 12 | 12 | 204 | 142 | 156 |
| | **74188** | M12DF.2.1300.2300.A0135.1660.0000.1820.00.S14B2B03.01 | 13 | 14 | 230 | 166 | 182 |
| | **74190** | M12DF.2.1400.2300.A0135.1660.0000.1820.00.S14B2B03.01 | 14 | 14 | 230 | 166 | 182 |
| | **74192** | M12DF.2.1500.2600.A0135.1920.0000.2080.00.S16B2B02.01 | 15 | 16 | 260 | 192 | 208 |
| | **74194** | M12DF.2.1600.2600.A0135.1920.0000.2080.00.S16B2B02.01 | 16 | 16 | 260 | 192 | 208 |
| | **74196** | M12DF.2.1800.2850.A0135.2160.0000.2340.00.S16B2B02.01 | 18 | 18 | 285 | 216 | 234 |

| Cutting Parameters Vc(m/min) | | |
|---|---|---|
| Non-Alloy Steel | 100 | ● |
| Steel | 80 | ● |
| Tempered Steel | 70 | ● |
| Cold-Work Tool Steel | 40 | ◑ |
| Hot-Work Tool Steel | 40 | ◑ |
| AISI 304 - 416 - 420 | 35 | ◑ |
| AISI 316 - 440 | 35 | ◑ |
| 17-4 PH 15-5 PH | 30 | ◑ |
| Chrome-Cobalt Alloy | 30 | ◑ |
| Duplex F51 | 25 | ◑ |
| Super Duplex F55 | 25 | ◑ |
| Grey Cast Iron | 70 | ● |
| Alloy Cast Iron | 60 | ● |
| Precision Cast | 50 | ● |

| Feed Per Revolution (mm/rev) | |
|---|---|
| Ø | |
| 3-5 | 0,05-0,19 |
| 5-8 | 0,08-0,25 |
| 8-12 | 0,1-0,32 |
| 12-16 | 0,12-0,38 |
| 16-18 | 0,13-0,42 |

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.