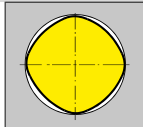


Thermdrill-Drill Selection & RPM

Thread	diameter [mm]	suggested max. material thickness				Shaft [mm]	Length		RPM Range*		
		[mm]		[mm]			working part	working part	min.	optimum	>
		form-type		cut-type			working part	working part		Steel	Brass, Copper, Aluminium
		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
M4	3,7	1,5	2,5	2,0	4,0	6,0	7,6	10,1	2.300	2.600	3.800
M5	4,5	2,0	3,0	3,0	4,5	6,0	9,1	12,0	2.200	2.500	3.700
M6	5,4	2,0	3,5	3,0	5,0	6,0	10,1	14,4	2.000	2.400	3.600
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
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
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
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
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
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
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
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
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
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
1/2"	19,9/20,0	2,5	5,0	4,0	7,0	18,0		36,3	1.000	1.200	1.800
3/4"	25,4/25,5	2,5	5,0	4,0	7,0	20,0		43,6	900	1.000	1.600
1"	32,0/32,1	2,5	5,0	4,0	7,0	20,0		52,3	900	1.000	1.500