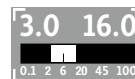
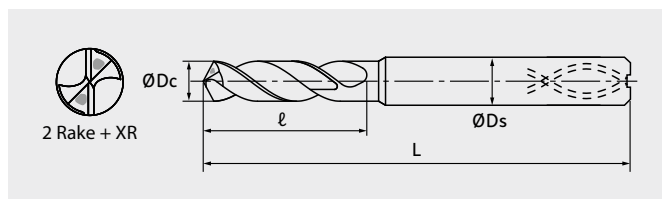


AQRVDOH8D

AquaREVO Drills
Oil-Hole (8D)



TOOL MATERIAL

POINT ANGLE HELIX ANGLE

List: 9868/9868D

unit: mm

Article number	Dc	ℓ	L	Ds	Stock
9198680300	3.0	34	81	3	●
9198680310	3.1	39	92	4	●
9198680320	3.2	39	92	4	●
9198680330	3.3	39	92	4	●
9198680340	3.4	39	92	4	●
9198680350	3.5	39	92	4	●
9198680360	3.6	45	92	4	●
9198680370	3.7	45	92	4	●
9198680380	3.8	45	92	4	●
9198680390	3.9	45	92	4	●
9198680400	4.0	45	92	4	●
9198680410	4.1	50	105	5	○
919868D0410	4.1	50	105	6	●
9198680420	4.2	50	105	5	○
919868D0420	4.2	50	105	6	●
9198680430	4.3	50	105	5	○
919868D0430	4.3	50	105	6	●
9198680440	4.4	50	105	5	○
919868D0440	4.4	50	105	6	●
9198680450	4.5	50	105	5	○
919868D0450	4.5	50	105	6	●
9198680460	4.6	56	105	5	○
919868D0460	4.6	56	105	6	●
9198680470	4.7	56	105	5	○
919868D0470	4.7	56	105	6	●
9198680480	4.8	56	105	5	○
919868D0480	4.8	56	105	6	●
9198680490	4.9	56	105	5	○
919868D0490	4.9	56	105	6	●
9198680500	5.0	56	105	5	○
919868D0500	5.0	56	105	6	●
9198680510	5.1	62	118	6	●
9198680520	5.2	62	118	6	●
9198680530	5.3	62	118	6	●
9198680540	5.4	62	118	6	●
9198680550	5.5	62	118	6	●
9198680560	5.6	68	118	6	●
9198680570	5.7	68	118	6	●
9198680580	5.8	68	118	6	●
9198680590	5.9	68	118	6	●
9198680600	6.0	68	118	6	●
9198680610	6.1	73	130	7	○
919868D0610	6.1	73	130	8	●
9198680620	6.2	73	130	7	○

Article number	Dc	ℓ	L	Ds	Stock
919868D0620	6.2	73	130	8	●
9198680630	6.3	73	130	7	○
919868D0630	6.3	73	130	8	●
9198680640	6.4	73	130	7	○
919868D0640	6.4	73	130	8	●
9198680650	6.5	73	130	7	○
919868D0650	6.5	73	130	8	●
9198680660	6.6	79	130	7	○
919868D0660	6.6	79	130	8	●
9198680670	6.7	79	130	7	○
919868D0670	6.7	79	130	8	●
9198680680	6.8	79	130	7	○
919868D0680	6.8	79	130	8	●
9198680690	6.9	79	130	7	○
919868D0690	6.9	79	130	8	●
9198680700	7.0	79	130	7	○
919868D0700	7.0	79	130	8	●
9198680710	7.1	84	142	8	●
9198680720	7.2	84	142	8	●
9198680730	7.3	84	142	8	●
9198680740	7.4	84	142	8	●
9198680750	7.5	84	142	8	●
9198680760	7.6	90	142	8	●
9198680770	7.7	90	142	8	●
9198680780	7.8	90	142	8	●
9198680790	7.9	90	142	8	●
9198680800	8.0	90	142	8	●
9198680810	8.1	95	154	9	○
919868D0810	8.1	95	154	10	●
9198680820	8.2	95	154	9	○
919868D0820	8.2	95	154	10	●
9198680830	8.3	95	154	9	○
919868D0830	8.3	95	154	10	●
9198680840	8.4	95	154	9	○
919868D0840	8.4	95	154	10	●
9198680850	8.5	95	154	9	○
919868D0850	8.5	95	154	10	●
9198680860	8.6	101	154	9	○
919868D0860	8.6	101	154	10	●
9198680870	8.7	101	154	9	○
919868D0870	8.7	101	154	10	●
9198680880	8.8	101	154	9	○
919868D0880	8.8	101	154	10	●
9198680890	8.9	101	154	9	○

List: 9868/9868D

unit: mm

Article number	Dc	ℓ	L	Ds	Stock
919868D0890	8.9	101	154	10	●
9198680900	9.0	101	154	9	○
919868D0900	9.0	101	154	10	●
9198680910	9.1	106	166	10	●
9198680920	9.2	106	166	10	●
9198680930	9.3	106	166	10	●
9198680940	9.4	106	166	10	●
9198680950	9.5	106	166	10	●
9198680960	9.6	112	166	10	●
9198680970	9.7	112	166	10	●
9198680980	9.8	112	166	10	●
9198680990	9.9	112	166	10	●
9198681000	10.0	112	166	10	●
9198681010	10.1	118	182	11	○
919868D1010	10.1	118	182	12	●
9198681020	10.2	118	182	11	○
919868D1020	10.2	118	182	12	●
9198681030	10.3	118	182	11	○
919868D1030	10.3	118	182	12	●
9198681040	10.4	118	182	11	○
919868D1040	10.4	118	182	12	●
9198681050	10.5	118	182	11	○
919868D1050	10.5	118	182	12	●
9198681060	10.6	124	182	11	○
919868D1060	10.6	124	182	12	●
9198681070	10.7	124	182	11	○
919868D1070	10.7	124	182	12	●
9198681080	10.8	124	182	11	○
919868D1080	10.8	124	182	12	●
9198681090	10.9	124	182	11	○
919868D1090	10.9	124	182	12	●
9198681100	11.0	124	182	11	○
919868D1100	11.0	124	182	12	●
9198681110	11.1	129	194	12	●
9198681120	11.2	129	194	12	●
9198681130	11.3	129	194	12	●
9198681140	11.4	129	194	12	●
9198681150	11.5	129	194	12	●
9198681160	11.6	135	194	12	●
9198681170	11.7	135	194	12	●
9198681180	11.8	135	194	12	●
9198681190	11.9	135	194	12	●
9198681200	12.0	135	194	12	●
9198681210	12.1	140	206	13	○
919868D1210	12.1	140	206	14	●
9198681220	12.2	140	206	13	○
919868D1220	12.2	140	206	14	●
9198681230	12.3	140	206	13	○
919868D1230	12.3	140	206	14	●
9198681240	12.4	140	206	13	○
919868D1240	12.4	140	206	14	●
9198681250	12.5	140	206	13	○
919868D1250	12.5	140	206	14	●

Article number	Dc	ℓ	L	Ds	Stock
9198681260	12.6	146	206	13	○
919868D1260	12.6	146	206	14	●
9198681270	12.7	146	206	13	○
919868D1270	12.7	146	206	14	●
9198681280	12.8	146	206	13	○
919868D1280	12.8	146	206	14	●
9198681290	12.9	146	206	13	○
919868D1290	12.9	146	206	14	●
9198681300	13.0	146	206	13	○
919868D1300	13.0	146	206	14	●
9198681310	13.1	151	218	14	●
9198681320	13.2	151	218	14	●
9198681330	13.3	151	218	14	●
9198681340	13.4	151	218	14	●
9198681350	13.5	151	218	14	●
9198681360	13.6	157	218	14	●
9198681370	13.7	157	218	14	●
9198681380	13.8	157	218	14	●
9198681390	13.9	157	218	14	●
9198681400	14.0	157	218	14	●
9198681410	14.1	163	230	15	○
919868D1410	14.1	163	230	16	●
9198681420	14.2	163	230	15	○
919868D1420	14.2	163	230	16	●
9198681430	14.3	163	230	15	○
919868D1430	14.3	163	230	16	●
9198681440	14.4	163	230	15	○
919868D1440	14.4	163	230	16	●
9198681450	14.5	163	230	15	○
919868D1450	14.5	163	230	16	●
9198681460	14.6	169	230	15	○
919868D1460	14.6	169	230	16	●
9198681470	14.7	169	230	15	○
919868D1470	14.7	169	230	16	●
9198681480	14.8	169	230	15	○
919868D1480	14.8	169	230	16	●
9198681490	14.9	169	230	15	○
919868D1490	14.9	169	230	16	●
9198681500	15.0	169	230	15	○
919868D1500	15.0	169	230	16	●
9198681510	15.1	174	242	16	●
9198681520	15.2	174	242	16	●
9198681530	15.3	174	242	16	●
9198681540	15.4	174	242	16	●
9198681550	15.5	174	242	16	●
9198681560	15.6	180	242	16	●
9198681570	15.7	180	242	16	●
9198681580	15.8	180	242	16	●
9198681590	15.9	180	242	16	●
9198681600	16.0	180	242	16	●

●: German Stock

AQRVDOH8D

AquaREVO Drills Oil-Hole (8D)

STANDARD CUTTING WET CONDITIONS																		
Work Material	Structural Steels, Carbon Steels, Cast Irons St37-2, C50E		Alloy Steels, Heat-treated Steels 42CrMo4		Mold Steels, Hardened Steels 1.2344		Hardened Steels		Ductile Cast Irons GG/GGG	Stainless Steels 1.4301 1.4000 1.4016		Stainless Steels 1.4542		Titanium Alloys TI-6Al-4V		Nickel Alloys Inconel 718		
	~200HB		20~30HRC		30~40HRC		40~50HRC			Rotation min ⁻¹ Feed mm/min		Rotation min ⁻¹ Feed mm/min		Rotation min ⁻¹ Feed mm/min		Rotation min ⁻¹ Feed mm/min		Rotation min ⁻¹ Feed mm/min
Drill Dia. mm	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min
3.0	12700	1020	10600	920	8500	630	4250	230	10600	800	8500	630	5300	360	4200	290	4200	170
4.0	9600	1020	8000	920	6400	630	3200	230	8000	800	6400	630	4000	360	3200	290	3200	170
6.0	6400	1020	5300	920	4200	600	2100	220	5300	740	4200	600	2600	360	2100	290	2100	170
8.0	4800	1020	4000	920	3200	590	1600	220	4000	740	3200	570	2000	360	1600	290	1600	170
10.0	3800	950	3200	860	2500	530	1300	210	3200	680	2500	530	1600	330	1300	260	1300	160
12.0	3200	890	2700	820	2100	480	1050	200	2700	630	2100	500	1300	320	1050	250	1050	150
16.0	2400	800	2000	800	1600	440	800	190	2000	550	1600	470	1000	290	800	230	800	140

STANDARD MQL CONDITIONS											
Work Material	Structural Steels, Carbon Steels, Cast Irons St37-2, C50E		Alloy Steels, Heat-treated Steels 42CrMo4		Mold Steels, Hardened Steels 1.2344		Hardened Steels		Ductile Cast Irons GG/GGG		
	~200HB		20~30HRC		30~40HRC		40~50HRC				
Drill Dia. mm	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	
3.0	8500	640	7400	510	6400	400	2550	120	7400	500	
4.0	6400	640	5600	510	4800	400	1900	120	5600	500	
6.0	4200	640	3700	510	3200	370	1300	120	3700	470	
8.0	3200	640	2800	510	2400	370	1000	120	2800	470	
10.0	2500	600	2200	480	1900	340	800	100	2200	440	
12.0	2100	560	1900	450	1600	340	650	100	1900	430	
16.0	1600	500	1400	450	1200	330	480	90	1400	360	

Pictogram overview



NACHI – high-quality solid carbide substrate



Revo-D coating ALTiCrXN Nanolayers



Point angle



Grinding tolerance



Helix angle



Shank tolerance