



GÜHRING

BT 800

Interchangeable head drilling system
for quick head changes
and high economic efficiency

BT 800 – there's no better choice!

Your advantages

and how you
benefit from them



x Drill head with full carbide performance

Simple, fast handling combined with a long tool life and impressive performance. **This makes the BT 800 an economical alternative to solid carbide drills.**

x Greater economic efficiency

Big, bigger, expensive: Particularly when their diameters are large, solid carbide drills can be expensive to purchase and often their performance is not fully exploited. **Especially from $\varnothing > 14$ mm, the BT 800 modular system is more economically efficient.**

x Fast tool change cycle

Changing the BT 800 interchangeable head directly in the machine is faster than changing a monolithic drill. **This minimises your tool setup times and increases productivity.**

x High flexibility

The BT 800 enables different drill heads to be used on a single carrier. **This allows you to quickly adapt the tools to different materials or adjust processing requirements.**

x Greater cost savings

With the BT 800, only the drill head needs to be replaced in the event of wear and not the entire tool. **This reduces tool costs compared to monolithic solid carbide drills.**

x Reduced inventory

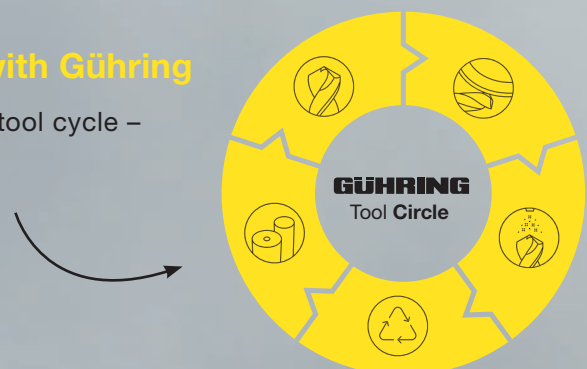
Modular systems reduce your tool inventory because, instead of multiple different tools, all you have to keep in stock are the drill heads you need. **This reduces the amount of tied-up capital, storage costs and logistical effort.**

x Bespoke solutions

In addition to the standard designs, BT 800 drill heads can also be flexibly adapted to your individual requirements. **As a result, you benefit from unlimited design freedom and maximum performance.**

x Regrind up to two times and recycle with Gühring

Gühring is the only manufacturer to offer a closed tool cycle – **for maximum resource conservation.**



BT 800 – there's no better choice!

Quick head changes and high economic efficiency

Up to 50 % longer tool life compared to conventional modular drills.

Flexibility & wear resistance: The BT 800 combines the properties of carbide with the advantages of modular tools.

At the heart of the BT 800 is the wear-resistant bayonet fixture, which ensures a precise and safe clamping mechanism and impresses with its easy handling, while also enabling quick head changes directly in the machine.

Simple, fast handling combined with a long tool life and high performance make the BT 800 the ideal choice for medium and large diameters. For shorter set-up times and more flexibility.





**Drill head with Persistum coating
for steel processing**
Ø range 10.0 – 26.0 mm



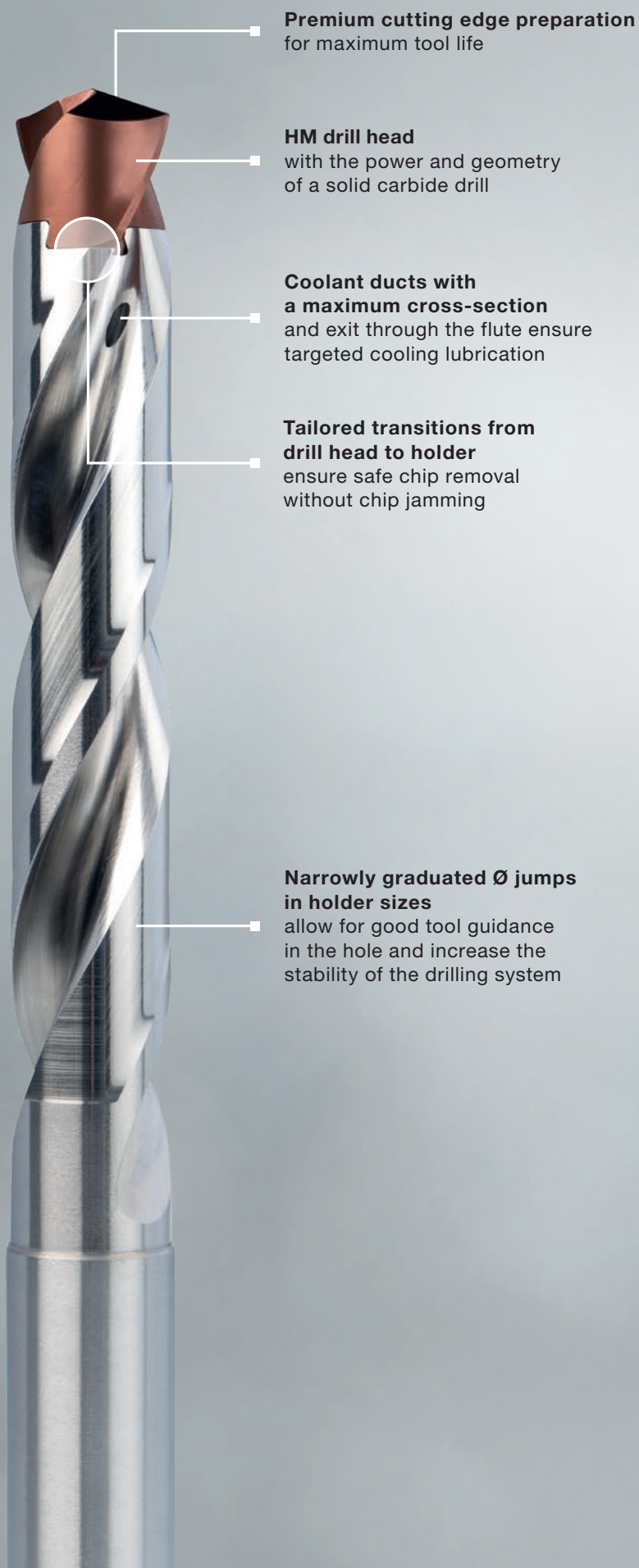
**Pilot drill head with
internal cooling for 4-way cooling**
Ø range 10.0 – 26.0 mm



**Precise and secure
clamping mechanism**
thanks to stable centring
and contact surfaces to
absorb cutting forces



**Holder for
the drill and pilot head**
1.5xD, 3xD, 5xD, 8xD, 12xD;
Ø range 10.0 – 26.0 mm



Premium cutting edge preparation
for maximum tool life

HM drill head
with the power and geometry
of a solid carbide drill

**Coolant ducts with
a maximum cross-section**
and exit through the flute ensure
targeted cooling lubrication

**Tailored transitions from
drill head to holder**
ensure safe chip removal
without chip jamming

**Narrowly graduated Ø jumps
in holder sizes**
allow for good tool guidance
in the hole and increase the
stability of the drilling system

Changing pays off!

Maximum economic efficiency:
The modular BT 800 interchangeable head drilling system

Longer tool life, shorter machining times:
With the BT 800 interchangeable head drilling system, the company Kurt Metallverarbeitung has found a new modular solution that not only impresses with simpler handling, but also with outstanding performance.

From individual parts and small series production to the finishing and reworking of metal parts: The company Kurt Metallverarbeitung from Remscheid in Germany manufactures various components for large-scale industry, such as spare parts for presses, cranes or excavators. To achieve this, it needs reliable tools that not only guarantee top machining results, but maximum economic efficiency, too. For this reason, the company has been relying on modular drilling systems that offer high savings potential for some time now.

Problems when changing the drill head

However, when it comes to using modular tools in practice, one important aspect cannot be neglected: the handling. Managing Director Samet

Kurt is well aware of this: “Before the BT 800 from Gühring, we used a competitor’s modular drilling system, which also enables the drill head to be changed without screws directly in the machine.” With this system, the drill head and carrier are connected to slotted engagement points with the help of mounting keys. However, the company Kurt Metallverarbeitung was not happy with this solution, as they often encountered problems when changing: “The drill head often got stuck in the cone interface. Because a lot of force was then needed to release it, it slipped off quickly and damaged the cutting edge,” recalls Samet Kurt.

“Some drill heads were unusable after the change.” But Gühring sales representative Ralf Hirschfeld knew how to help his long-standing customer – and introduced him to the BT 800 interchangeable head drilling system. The heart of the BT 800 is its wear-resistant bayonet fixture. Compared to the competitor’s system, the mounting key engages in the flute and enables quick and smooth drill head changes. The head is changed with a rotary move-

X Machining time halved
X Tool life increased by 65 %



We were able to increase tool life by 65 % and reduce machining time by more than half.

Samet Kurt, Managing Director,
Kurt Metallverarbeitung

ment, which clamps the head securely in the fixture without any play. The mounting key and clamping in the flute ensure secure changes without any damage to the cutting head. "This allows the customer to significantly reduce their set-up times and

downtimes," explains Hirschfeld. Samet Kurt tested the modular solution to produce a cog – a component made of quenched and tempered steel C45 (1.0503), which is then used in disc cutters. Several through-holes with a drilling depth of 10 mm need to be produced on each component using a Haas VF-1. And the BT 800 impressed: "The Gühring quick-change system is just better," says Samet Kurt. "When changing the drill heads, nothing gets stuck; it is very easy to handle."

Powerful & durable: 65 % longer tool life and reduced machining times

But the BT 800 doesn't just impress with its easy handling. In terms of performance, the tool also exceeds the customer's expectations and leaves the competitor's system in the dust: "We were able to increase tool life by 65 % and reduce machining time by more than half," reports Samet Kurt enthusiastically. Hirschfeld sums it up: "The simple handling combined with a long tool life and strong performance make the BT 800 an economical alternative to solid carbide drills."

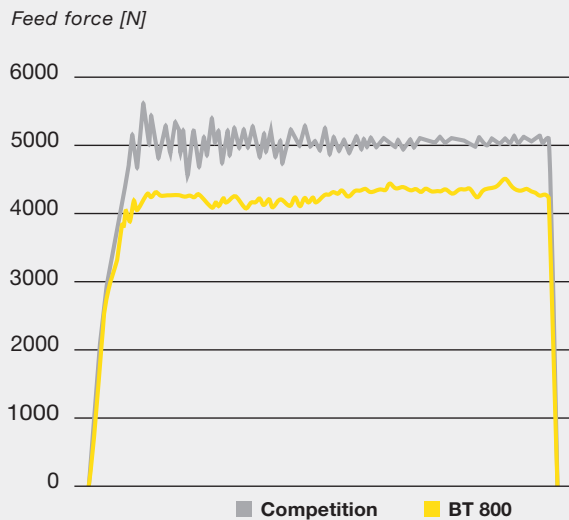
Tool Performance Report

Tool	Competition	Gühring
Diameter (Ø) [mm]	17.5	17.5
Component	Cog	Cog
Material	C45 (1.0503)	C45 (1.0503)
Cutting speed (v_c) [m/min]	54	94
Feed rate (f) [mm/rev]	0.24	0.32
Tool life (parts)	100	165

BT 800 – there's no better choice!

Comparison of the BT 800

Feed forces

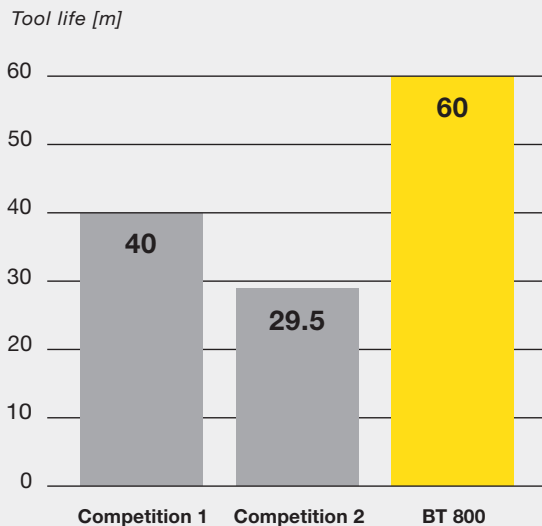


Reduced feed forces

Compared to conventional modular drilling systems, the BT 800 enables machining with reduced feed forces thanks to its large, easy-to-cut rake angles.

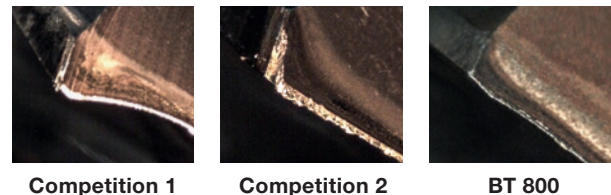
Diameter (Ø)	17.50 mm (5xD)
Material	42CrMo4
Cutting speed (v_c)	90 m/min
Feed (f)	0.3 mm/rev

Tool lives



Minimal wear and tear

Despite a longer tool life, the BT 800 exhibits significantly less corner wear compared to the competition.



Diameter (Ø)	17.50 mm (5xD)
Material	42CrMo4
Cutting speed (v_c)	90 m/min
Feed (f)	0.3 mm/rev

Contents



Drill head holder 1.5xD

Available from 09/2025 | high wear resistance | precise clamping mechanism



Drill head holder 3xD

Complete programme from 09/2025 | high wear resistance | precise clamping mechanism



Drill head holder 5xD

Complete programme from 09/2025 | high wear resistance | precise clamping mechanism



Drill head holder 8xD

Available from 09/2025 | high wear resistance | precise clamping mechanism



Drill head holder 12xD

Available from 09/2025 | high wear resistance | precise clamping mechanism



Drill head for steel machining

Complete programm from 09/2025 | with Persistum coating | Ø range 10.0 – 26.0 mm



Drill head for piloting

Available from 09/2025 | with internal cooling for 4-fold cooling | Ø range 10.0 – 26.0 mm



Mounting key

Enclosed with each tool holder | for easy change in the machine



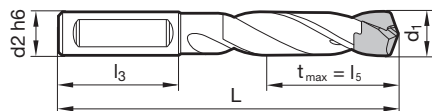
Modular drills with interchangeable head BT 800

Drill head holder BT 800

Article no. **8150**



especially high wear resistance • optimised coolant duct exit • mounting key art. no. 8170 included



Article no.

8150

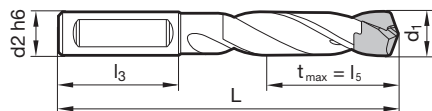
Holder size	d1	d2 h6 mm	L mm	l3 mm	l5 mm	Availability	Order no.
100	10.000-10.499	12.000	82.5	45.0	15.8	09/2025	8150 10.000
100	10.000-10.499	12.700	82.5	45.0	15.8	09/2025	8150 10.005
105	10.500-10.999	12.000	84.0	45.0	16.5	09/2025	8150 10.500
105	10.500-10.999	12.700	84.0	45.0	16.5	09/2025	8150 10.505
110	11.000-11.499	12.000	85.5	45.0	17.3	09/2025	8150 11.000
110	11.000-11.499	12.700	85.5	45.0	17.3	09/2025	8150 11.005
115	11.500-11.999	12.000	87.0	45.0	18.0	09/2025	8150 11.500
115	11.500-11.999	12.700	87.0	45.0	18.0	09/2025	8150 11.505
120	12.000-12.499	12.000	88.5	45.0	18.8	09/2025	8150 12.000
120	12.000-12.499	12.700	88.5	45.0	18.8	09/2025	8150 12.005
125	12.500-12.999	14.000	90.0	45.0	19.5	09/2025	8150 12.500
125	12.500-12.999	15.875	93.0	48.0	19.5	09/2025	8150 12.505
130	13.000-13.499	14.000	91.5	45.0	20.3	09/2025	8150 13.000
130	13.000-13.499	15.875	94.5	48.0	20.3	09/2025	8150 13.005
135	13.500-13.999	14.000	93.0	45.0	21.0	09/2025	8150 13.500
135	13.500-13.999	15.875	96.0	48.0	21.0	09/2025	8150 13.505
140	14.000-14.499	14.000	94.5	45.0	21.8	09/2025	8150 14.000
140	14.000-14.499	15.875	97.5	48.0	21.8	09/2025	8150 14.005
145	14.500-14.999	16.000	99.0	48.0	22.5	09/2025	8150 14.500
145	14.500-14.999	15.875	99.0	48.0	22.5	09/2025	8150 14.505
150	15.000-15.499	16.000	100.5	48.0	23.3	09/2025	8150 15.000
150	15.000-15.499	15.875	100.5	48.0	23.3	09/2025	8150 15.005
155	15.500-15.999	16.000	102.0	48.0	24.0	09/2025	8150 15.500
155	15.500-15.999	15.875	102.0	48.0	24.0	09/2025	8150 15.505
160	16.000-16.499	16.000	103.5	48.0	24.8	09/2025	8150 16.000
160	16.000-16.499	15.875	103.5	48.0	24.8	09/2025	8150 16.005
165	16.500-16.999	18.000	105.0	48.0	25.5	09/2025	8150 16.500
165	16.500-16.999	19.050	107.0	50.0	25.5	09/2025	8150 16.505
170	17.000-17.499	18.000	106.5	48.0	26.3	09/2025	8150 17.000
170	17.000-17.499	19.050	108.5	50.0	26.3	09/2025	8150 17.005
175	17.500-17.999	18.000	108.0	48.0	27.0	09/2025	8150 17.500
175	17.500-17.999	19.050	110.0	50.0	27.0	09/2025	8150 17.505
180	18.000-18.499	18.000	109.5	48.0	27.8	09/2025	8150 18.000
180	18.000-18.499	19.050	111.5	50.0	27.8	09/2025	8150 18.005
185	18.500-18.999	20.000	113.0	50.0	28.5	09/2025	8150 18.500
185	18.500-18.999	19.050	113.0	50.0	28.5	09/2025	8150 18.505
190	19.000-19.499	20.000	114.5	50.0	29.3	09/2025	8150 19.000
190	19.000-19.499	19.050	114.5	50.0	29.3	09/2025	8150 19.005
195	19.500-19.999	20.000	116.0	50.0	30.0	09/2025	8150 19.500
195	19.500-19.999	19.050	116.0	50.0	30.0	09/2025	8150 19.505
200	20.000-20.499	20.000	117.5	50.0	30.8	09/2025	8150 20.000
200	20.000-20.499	19.050	117.5	50.0	30.8	09/2025	8150 20.005
205	20.500-20.999	25.000	129.0	56.0	31.5	09/2025	8150 20.500
205	20.500-20.999	25.400	129.0	56.0	31.5	09/2025	8150 20.505
210	21.000-21.499	25.000	130.5	56.0	32.3	09/2025	8150 21.000
210	21.000-21.499	25.400	130.5	56.0	32.3	09/2025	8150 21.005
215	21.500-21.999	25.000	131.0	56.0	33.0	09/2025	8150 21.500
215	21.500-21.999	25.400	131.0	56.0	33.0	09/2025	8150 21.505
220	22.000-22.499	25.000	132.5	56.0	33.8	09/2025	8150 22.000
220	22.000-22.499	25.400	132.5	56.0	33.8	09/2025	8150 22.005
225	22.500-22.999	25.000	133.0	56.0	34.5	09/2025	8150 22.500
225	22.500-22.999	25.400	133.0	56.0	34.5	09/2025	8150 22.505
230	23.000-23.499	25.000	134.5	56.0	35.3	09/2025	8150 23.000
230	23.000-23.499	25.400	134.5	56.0	35.3	09/2025	8150 23.005
235	23.500-23.999	25.000	134.0	56.0	36.0	09/2025	8150 23.500
235	23.500-23.999	25.400	134.0	56.0	36.0	09/2025	8150 23.505
240	24.000-24.499	25.000	135.5	56.0	36.8	09/2025	8150 24.000
240	24.000-24.499	25.400	135.5	56.0	36.8	09/2025	8150 24.005
245	24.500-24.999	25.000	137.0	56.0	37.5	09/2025	8150 24.500
245	24.500-24.999	25.400	137.0	56.0	37.5	09/2025	8150 24.505
250	25.000-25.499	25.000	138.5	56.0	38.3	09/2025	8150 25.000
250	25.000-25.499	25.400	138.5	56.0	38.3	09/2025	8150 25.005
255	25.500-25.999	32.000	149.0	60.0	39.0	09/2025	8150 25.500
255	25.500-25.999	31.750	149.0	60.0	39.0	09/2025	8150 25.505
260	26.000-26.499	32.000	150.5	60.0	39.8	09/2025	8150 26.000
260	26.000-26.499	31.750	150.5	60.0	39.8	09/2025	8150 26.005



Drill head holder BT 800

Article no. **8151**

especially high wear resistance • optimised coolant duct exit • mounting key art. no. 8170 included



Article no.

8151

Holder size	d1	d2 h6 mm	L mm	l3 mm	l5 mm	Availability	Order no.
100	10.000-10.499	12.000	98.2	45.0	31.5	09/2025	8151 10.000
100	10.000-10.499	12.700	98.2	45.0	31.5	09/2025	8151 10.005
105	10.500-10.999	12.000	100.5	45.0	33.0	09/2025	8151 10.500
105	10.500-10.999	12.700	100.5	45.0	33.0	09/2025	8151 10.505
110	11.000-11.499	12.000	102.7	45.0	34.5	09/2025	8151 11.000
110	11.000-11.499	12.700	102.7	45.0	34.5	09/2025	8151 11.005
115	11.500-11.999	12.000	105.0	45.0	36.0	09/2025	8151 11.500
115	11.500-11.999	12.700	105.0	45.0	36.0	09/2025	8151 11.505
120	12.000-12.499	12.000	107.2	45.0	37.5	09/2025	8151 12.000
120	12.000-12.499	12.700	107.2	45.0	37.5	09/2025	8151 12.005
125	12.500-12.999	14.000	109.5	45.0	39.0	09/2025	8151 12.500
125	12.500-12.999	15.875	112.5	48.0	39.0	09/2025	8151 12.505
130	13.000-13.499	14.000	111.7	45.0	40.5	09/2025	8151 13.000
130	13.000-13.499	15.875	114.7	48.0	40.5	09/2025	8151 13.005
135	13.500-13.999	14.000	114.0	45.0	42.0	09/2025	8151 13.500
135	13.500-13.999	15.875	117.0	48.0	42.0	09/2025	8151 13.505
140	14.000-14.499	14.000	116.2	45.0	43.5	09/2025	8151 14.000
140	14.000-14.499	15.875	119.2	48.0	43.5	09/2025	8151 14.005
145	14.500-14.999	16.000	121.5	48.0	45.0	09/2025	8151 14.500
145	14.500-14.999	15.875	121.5	48.0	45.0	09/2025	8151 14.505
150	15.000-15.499	16.000	123.7	48.0	46.5	09/2025	8151 15.000
150	15.000-15.499	15.875	123.7	48.0	46.5	09/2025	8151 15.005
155	15.500-15.999	16.000	126.0	48.0	48.0	09/2025	8151 15.500
155	15.500-15.999	15.875	126.0	48.0	48.0	09/2025	8151 15.505
160	16.000-16.499	16.000	128.2	48.0	49.5	09/2025	8151 16.000
160	16.000-16.499	15.875	128.2	48.0	49.5	09/2025	8151 16.005
165	16.500-16.999	18.000	130.5	48.0	51.0	09/2025	8151 16.500
165	16.500-16.999	19.050	132.5	50.0	51.0	09/2025	8151 16.505
170	17.000-17.499	18.000	132.7	48.0	52.5	09/2025	8151 17.000
170	17.000-17.499	19.050	134.7	50.0	52.5	09/2025	8151 17.005
175	17.500-17.999	18.000	135.0	48.0	54.0	09/2025	8151 17.500
175	17.500-17.999	19.050	137.0	50.0	54.0	09/2025	8151 17.505
180	18.000-18.499	18.000	137.2	48.0	55.5	09/2025	8151 18.000
180	18.000-18.499	19.050	139.2	50.0	55.5	09/2025	8151 18.005
185	18.500-18.999	20.000	141.5	50.0	57.0	09/2025	8151 18.500
185	18.500-18.999	19.050	141.5	50.0	57.0	09/2025	8151 18.505
190	19.000-19.499	20.000	143.7	50.0	58.5	09/2025	8151 19.000
190	19.000-19.499	19.050	143.7	50.0	58.5	09/2025	8151 19.005
195	19.500-19.999	20.000	146.0	50.0	60.0	09/2025	8151 19.500
195	19.500-19.999	19.050	146.0	50.0	60.0	09/2025	8151 19.505
200	20.000-20.499	20.000	148.2	50.0	61.5	09/2025	8151 20.000
200	20.000-20.499	19.050	148.2	50.0	61.5	09/2025	8151 20.005
205	20.500-20.999	25.000	160.5	56.0	63.0	09/2025	8151 20.500
205	20.500-20.999	25.400	160.5	56.0	63.0	09/2025	8151 20.505
210	21.000-21.499	25.000	162.7	56.0	64.5	09/2025	8151 21.000
210	21.000-21.499	25.400	162.7	56.0	64.5	09/2025	8151 21.005
215	21.500-21.999	25.000	164.0	56.0	66.0	09/2025	8151 21.500
215	21.500-21.999	25.400	164.0	56.0	66.0	09/2025	8151 21.505
220	22.000-22.499	25.000	166.2	56.0	67.5	09/2025	8151 22.000
220	22.000-22.499	25.400	166.2	56.0	67.5	09/2025	8151 22.005
225	22.500-22.999	25.000	167.5	56.0	69.0	09/2025	8151 22.500
225	22.500-22.999	25.400	167.5	56.0	69.0	09/2025	8151 22.505
230	23.000-23.499	25.000	169.7	56.0	70.5	09/2025	8151 23.000
230	23.000-23.499	25.400	169.7	56.0	70.5	09/2025	8151 23.005
235	23.500-23.999	25.000	170.0	56.0	72.0	09/2025	8151 23.500
235	23.500-23.999	25.400	170.0	56.0	72.0	09/2025	8151 23.505
240	24.000-24.499	25.000	172.2	56.0	73.5	09/2025	8151 24.000
240	24.000-24.499	25.400	172.2	56.0	73.5	09/2025	8151 24.005
245	24.500-24.999	25.000	174.5	56.0	75.0	09/2025	8151 24.500
245	24.500-24.999	25.400	174.5	56.0	75.0	09/2025	8151 24.505
250	25.000-25.499	25.000	176.7	56.0	76.5	09/2025	8151 25.000
250	25.000-25.499	25.400	176.7	56.0	76.5	09/2025	8151 25.005
255	25.500-25.999	32.000	188.0	60.0	78.0	09/2025	8151 25.500
255	25.500-25.999	31.750	188.0	60.0	78.0	09/2025	8151 25.505
260	26.000-26.499	32.000	190.2	60.0	79.5	09/2025	8151 26.000
260	26.000-26.499	31.750	190.2	60.0	79.5	09/2025	8151 26.005



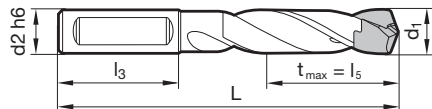
Modular drills with interchangeable head BT 800

Drill head holder BT 800

Article no. **8152**



especially high wear resistance • optimised coolant duct exit • mounting key art. no. 8170 included



Article no.

8152

Holder size	d1	d2 h6 mm	L mm	l3 mm	l5 mm	Availability	Order no.
100	10.000-10.499	12.000	119.2	45.0	52.5	09/2025	8152 10.000
100	10.000-10.499	12.700	119.2	45.0	52.5	09/2025	8152 10.005
105	10.500-10.999	12.000	122.5	45.0	55.0	09/2025	8152 10.500
105	10.500-10.999	12.700	122.5	45.0	55.0	09/2025	8152 10.505
110	11.000-11.499	12.000	125.7	45.0	57.5	09/2025	8152 11.000
110	11.000-11.499	12.700	125.7	45.0	57.5	09/2025	8152 11.005
115	11.500-11.999	12.000	129.0	45.0	60.0	09/2025	8152 11.500
115	11.500-11.999	12.700	129.0	45.0	60.0	09/2025	8152 11.505
120	12.000-12.499	12.000	132.2	45.0	62.5	09/2025	8152 12.000
120	12.000-12.499	12.700	132.2	45.0	62.5	09/2025	8152 12.005
125	12.500-12.999	14.000	135.5	45.0	65.0	09/2025	8152 12.500
125	12.500-12.999	15.875	138.5	48.0	65.0	09/2025	8152 12.505
130	13.000-13.499	14.000	138.7	45.0	67.5	09/2025	8152 13.000
130	13.000-13.499	15.875	141.7	48.0	67.5	09/2025	8152 13.005
135	13.500-13.999	14.000	142.0	45.0	70.0	09/2025	8152 13.500
135	13.500-13.999	15.875	145.0	48.0	70.0	09/2025	8152 13.505
140	14.000-14.499	14.000	145.2	45.0	72.5	09/2025	8152 14.000
140	14.000-14.499	15.875	148.2	48.0	72.5	09/2025	8152 14.005
145	14.500-14.999	16.000	151.5	48.0	75.0	09/2025	8152 14.500
145	14.500-14.999	15.875	151.5	48.0	75.0	09/2025	8152 14.505
150	15.000-15.499	16.000	154.7	48.0	77.5	09/2025	8152 15.000
150	15.000-15.499	15.875	154.7	48.0	77.5	09/2025	8152 15.005
155	15.500-15.999	16.000	158.0	48.0	80.0	09/2025	8152 15.500
155	15.500-15.999	15.875	158.0	48.0	80.0	09/2025	8152 15.505
160	16.000-16.499	16.000	161.2	48.0	82.5	09/2025	8152 16.000
160	16.000-16.499	15.875	161.2	48.0	82.5	09/2025	8152 16.005
165	16.500-16.999	18.000	164.5	48.0	85.0	09/2025	8152 16.500
165	16.500-16.999	19.050	166.5	50.0	85.0	09/2025	8152 16.505
170	17.000-17.499	18.000	167.7	48.0	87.5	09/2025	8152 17.000
170	17.000-17.499	19.050	169.7	50.0	87.5	09/2025	8152 17.005
175	17.500-17.999	18.000	171.0	48.0	90.0	09/2025	8152 17.500
175	17.500-17.999	19.050	173.0	50.0	90.0	09/2025	8152 17.505
180	18.000-18.499	18.000	174.2	48.0	92.5	09/2025	8152 18.000
180	18.000-18.499	19.050	176.2	50.0	92.5	09/2025	8152 18.005
185	18.500-18.999	20.000	179.5	50.0	95.0	09/2025	8152 18.500
185	18.500-18.999	19.050	179.5	50.0	95.0	09/2025	8152 18.505
190	19.000-19.499	20.000	182.7	50.0	97.5	09/2025	8152 19.000
190	19.000-19.499	19.050	182.7	50.0	97.5	09/2025	8152 19.005
195	19.500-19.999	20.000	186.0	50.0	100.0	09/2025	8152 19.500
195	19.500-19.999	19.050	186.0	50.0	100.0	09/2025	8152 19.505
200	20.000-20.499	20.000	189.2	50.0	102.5	09/2025	8152 20.000
200	20.000-20.499	19.050	189.2	50.0	102.5	09/2025	8152 20.005
205	20.500-20.999	25.000	202.5	56.0	105.0	09/2025	8152 20.500
205	20.500-20.999	25.400	202.5	56.0	105.0	09/2025	8152 20.505
210	21.000-21.499	25.000	205.7	56.0	107.5	09/2025	8152 21.000
210	21.000-21.499	25.400	205.7	56.0	107.5	09/2025	8152 21.005
215	21.500-21.999	25.000	208.0	56.0	110.0	09/2025	8152 21.500
215	21.500-21.999	25.400	208.0	56.0	110.0	09/2025	8152 21.505
220	22.000-22.499	25.000	211.2	56.0	112.5	09/2025	8152 22.000
220	22.000-22.499	25.400	211.2	56.0	112.5	09/2025	8152 22.005
225	22.500-22.999	25.000	213.5	56.0	115.0	09/2025	8152 22.500
225	22.500-22.999	25.400	213.5	56.0	115.0	09/2025	8152 22.505
230	23.000-23.499	25.000	216.7	56.0	117.5	09/2025	8152 23.000
230	23.000-23.499	25.400	216.7	56.0	117.5	09/2025	8152 23.005
235	23.500-23.999	25.000	218.0	56.0	120.0	09/2025	8152 23.500
235	23.500-23.999	25.400	218.0	56.0	120.0	09/2025	8152 23.505
240	24.000-24.499	25.000	221.2	56.0	122.5	09/2025	8152 24.000
240	24.000-24.499	25.400	221.2	56.0	122.5	09/2025	8152 24.005
245	24.500-24.999	25.000	224.5	56.0	125.0	09/2025	8152 24.500
245	24.500-24.999	25.400	224.5	56.0	125.0	09/2025	8152 24.505
250	25.000-25.499	25.000	227.7	56.0	127.5	09/2025	8152 25.000
250	25.000-25.499	25.400	227.7	56.0	127.5	09/2025	8152 25.005
255	25.500-25.999	32.000	240.0	60.0	130.0	09/2025	8152 25.500
255	25.500-25.999	31.750	240.0	60.0	130.0	09/2025	8152 25.505
260	26.000-26.499	32.000	243.2	60.0	132.5	09/2025	8152 26.000
260	26.000-26.499	31.750	243.2	60.0	132.5	09/2025	8152 26.005

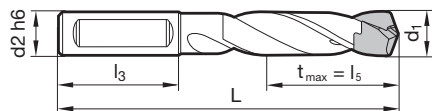


Drill head holder BT 800

Article no. 8153



especially high wear resistance • optimised coolant duct exit • mounting key art. no. 8170 included



Article no.

8153

Holder size	d1	d2 h6 mm	L mm	l3 mm	l5 mm	Availability	Order no.
100	10.000-10.499	12.000	150.7	45.0	84.0	09/2025	8153 10.000
100	10.000-10.499	12.700	150.7	45.0	84.0	09/2025	8153 10.005
105	10.500-10.999	12.000	155.5	45.0	88.0	09/2025	8153 10.500
105	10.500-10.999	12.700	155.5	45.0	88.0	09/2025	8153 10.505
110	11.000-11.499	12.000	160.2	45.0	92.0	09/2025	8153 11.000
110	11.000-11.499	12.700	160.2	45.0	92.0	09/2025	8153 11.005
115	11.500-11.999	12.000	165.0	45.0	96.0	09/2025	8153 11.500
115	11.500-11.999	12.700	165.0	45.0	96.0	09/2025	8153 11.505
120	12.000-12.499	12.000	169.7	45.0	100.0	09/2025	8153 12.000
120	12.000-12.499	12.700	169.7	45.0	100.0	09/2025	8153 12.005
125	12.500-12.999	14.000	174.5	45.0	104.0	09/2025	8153 12.500
125	12.500-12.999	15.875	177.5	48.0	104.0	09/2025	8153 12.505
130	13.000-13.499	14.000	179.2	45.0	108.0	09/2025	8153 13.000
130	13.000-13.499	15.875	182.2	48.0	108.0	09/2025	8153 13.005
135	13.500-13.999	14.000	184.0	45.0	112.0	09/2025	8153 13.500
135	13.500-13.999	15.875	187.0	48.0	112.0	09/2025	8153 13.505
140	14.000-14.499	14.000	188.7	45.0	116.0	09/2025	8153 14.000
140	14.000-14.499	15.875	191.7	48.0	116.0	09/2025	8153 14.005
145	14.500-14.999	16.000	196.5	48.0	120.0	09/2025	8153 14.500
145	14.500-14.999	15.875	196.5	48.0	120.0	09/2025	8153 14.505
150	15.000-15.499	16.000	201.2	48.0	124.0	09/2025	8153 15.000
150	15.000-15.499	15.875	201.2	48.0	124.0	09/2025	8153 15.005
155	15.500-15.999	16.000	206.0	48.0	128.0	09/2025	8153 15.500
155	15.500-15.999	15.875	206.0	48.0	128.0	09/2025	8153 15.505
160	16.000-16.499	16.000	210.7	48.0	132.0	09/2025	8153 16.000
160	16.000-16.499	15.875	210.7	48.0	132.0	09/2025	8153 16.005
165	16.500-16.999	18.000	215.5	48.0	136.0	09/2025	8153 16.500
165	16.500-16.999	19.050	217.5	50.0	136.0	09/2025	8153 16.505
170	17.000-17.499	18.000	220.2	48.0	140.0	09/2025	8153 17.000
170	17.000-17.499	19.050	222.2	50.0	140.0	09/2025	8153 17.005
175	17.500-17.999	18.000	225.0	48.0	144.0	09/2025	8153 17.500
175	17.500-17.999	19.050	227.0	50.0	144.0	09/2025	8153 17.505
180	18.000-18.499	18.000	229.7	48.0	148.0	09/2025	8153 18.000
180	18.000-18.499	19.050	231.7	50.0	148.0	09/2025	8153 18.005
185	18.500-18.999	20.000	236.5	50.0	152.0	09/2025	8153 18.500
185	18.500-18.999	19.050	236.5	50.0	152.0	09/2025	8153 18.505
190	19.000-19.499	20.000	241.2	50.0	156.0	09/2025	8153 19.000
190	19.000-19.499	19.050	241.2	50.0	156.0	09/2025	8153 19.005
195	19.500-19.999	20.000	246.0	50.0	160.0	09/2025	8153 19.500
195	19.500-19.999	19.050	246.0	50.0	160.0	09/2025	8153 19.505
200	20.000-20.499	20.000	250.7	50.0	164.0	09/2025	8153 20.000
200	20.000-20.499	19.050	250.7	50.0	164.0	09/2025	8153 20.005
205	20.500-20.999	25.000	265.5	56.0	168.0	09/2025	8153 20.500
205	20.500-20.999	25.400	265.5	56.0	168.0	09/2025	8153 20.505
210	21.000-21.499	25.000	270.2	56.0	172.0	09/2025	8153 21.000
210	21.000-21.499	25.400	270.2	56.0	172.0	09/2025	8153 21.005
215	21.500-21.999	25.000	274.0	56.0	176.0	09/2025	8153 21.500
215	21.500-21.999	25.400	274.0	56.0	176.0	09/2025	8153 21.505
220	22.000-22.499	25.000	278.7	56.0	180.0	09/2025	8153 22.000
220	22.000-22.499	25.400	278.7	56.0	180.0	09/2025	8153 22.005
225	22.500-22.999	25.000	282.5	56.0	184.0	09/2025	8153 22.500
225	22.500-22.999	25.400	282.5	56.0	184.0	09/2025	8153 22.505
230	23.000-23.499	25.000	287.2	56.0	188.0	09/2025	8153 23.000
230	23.000-23.499	25.400	287.2	56.0	188.0	09/2025	8153 23.005
235	23.500-23.999	25.000	290.0	56.0	192.0	09/2025	8153 23.500
235	23.500-23.999	25.400	290.0	56.0	192.0	09/2025	8153 23.505
240	24.000-24.499	25.000	294.7	56.0	196.0	09/2025	8153 24.000
240	24.000-24.499	25.400	294.7	56.0	196.0	09/2025	8153 24.005
245	24.500-24.999	25.000	299.5	56.0	200.0	09/2025	8153 24.500
245	24.500-24.999	25.400	299.5	56.0	200.0	09/2025	8153 24.505
250	25.000-25.499	25.000	304.2	56.0	204.0	09/2025	8153 25.000
250	25.000-25.499	25.400	304.2	56.0	204.0	09/2025	8153 25.005
255	25.500-25.999	32.000	318.0	60.0	208.0	09/2025	8153 25.500
255	25.500-25.999	31.750	318.0	60.0	208.0	09/2025	8153 25.505
260	26.000-26.499	32.000	322.7	60.0	212.0	09/2025	8153 26.000
260	26.000-26.499	31.750	322.7	60.0	212.0	09/2025	8153 26.005

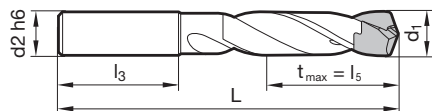


Drill head holder BT 800

Article no. **8154**



especially high wear resistance • optimised coolant duct exit • mounting key art. no. 8170 included



Article no.

8154

Holder size	d1	d2 h6 mm	L mm	l3 mm	l5 mm	Availability	Order no.
100	10.000-10.499	12.000	192.7	45.0	126.0	09/2025	8154 10.000
100	10.000-10.499	12.700	192.7	45.0	126.0	09/2025	8154 10.005
105	10.500-10.999	12.000	199.5	45.0	132.0	09/2025	8154 10.500
105	10.500-10.999	12.700	199.5	45.0	132.0	09/2025	8154 10.505
110	11.000-11.499	12.000	206.2	45.0	138.0	09/2025	8154 11.000
110	11.000-11.499	12.700	206.2	45.0	138.0	09/2025	8154 11.005
115	11.500-11.999	12.000	213.0	45.0	144.0	09/2025	8154 11.500
115	11.500-11.999	12.700	213.0	45.0	144.0	09/2025	8154 11.505
120	12.000-12.499	12.000	219.7	45.0	150.0	09/2025	8154 12.000
120	12.000-12.499	12.700	219.7	45.0	150.0	09/2025	8154 12.005
125	12.500-12.999	14.000	226.5	45.0	156.0	09/2025	8154 12.500
125	12.500-12.999	15.875	229.5	45.0	156.0	09/2025	8154 12.505
130	13.000-13.499	14.000	233.2	45.0	162.0	09/2025	8154 13.000
130	13.000-13.499	15.875	236.2	45.0	162.0	09/2025	8154 13.005
135	13.500-13.999	14.000	240.0	45.0	168.0	09/2025	8154 13.500
135	13.500-13.999	15.875	243.0	45.0	168.0	09/2025	8154 13.505
140	14.000-14.499	14.000	246.7	45.0	174.0	09/2025	8154 14.000
140	14.000-14.499	15.875	249.7	45.0	174.0	09/2025	8154 14.005
145	14.500-14.999	16.000	256.5	48.0	180.0	09/2025	8154 14.500
145	14.500-14.999	15.875	256.5	48.0	180.0	09/2025	8154 14.505
150	15.000-15.499	16.000	263.2	48.0	186.0	09/2025	8154 15.000
150	15.000-15.499	15.875	263.2	48.0	186.0	09/2025	8154 15.005
155	15.500-15.999	16.000	270.0	48.0	192.0	09/2025	8154 15.500
155	15.500-15.999	15.875	270.0	48.0	192.0	09/2025	8154 15.505
160	16.000-16.499	16.000	276.7	48.0	198.0	09/2025	8154 16.000
160	16.000-16.499	15.875	276.7	48.0	198.0	09/2025	8154 16.005
165	16.500-16.999	18.000	283.5	48.0	204.0	09/2025	8154 16.500
165	16.500-16.999	19.050	285.5	48.0	204.0	09/2025	8154 16.505
170	17.000-17.499	18.000	290.2	48.0	210.0	09/2025	8154 17.000
170	17.000-17.499	19.050	292.2	48.0	210.0	09/2025	8154 17.005
175	17.500-17.999	18.000	297.0	48.0	216.0	09/2025	8154 17.500
175	17.500-17.999	19.050	299.0	48.0	216.0	09/2025	8154 17.505
180	18.000-18.499	18.000	303.7	48.0	222.0	09/2025	8154 18.000
180	18.000-18.499	19.050	305.7	48.0	222.0	09/2025	8154 18.005
185	18.500-18.999	20.000	312.5	50.0	228.0	09/2025	8154 18.500
185	18.500-18.999	19.050	312.5	50.0	228.0	09/2025	8154 18.505
190	19.000-19.499	20.000	319.2	50.0	234.0	09/2025	8154 19.000
190	19.000-19.499	19.050	319.2	50.0	234.0	09/2025	8154 19.005
195	19.500-19.999	20.000	326.0	50.0	240.0	09/2025	8154 19.500
195	19.500-19.999	19.050	326.0	50.0	240.0	09/2025	8154 19.505
200	20.000-20.499	20.000	332.7	50.0	246.0	09/2025	8154 20.000
200	20.000-20.499	19.050	332.7	50.0	246.0	09/2025	8154 20.005
205	20.500-20.999	25.000	349.5	56.0	252.0	09/2025	8154 20.500
205	20.500-20.999	25.400	349.5	56.0	252.0	09/2025	8154 20.505
210	21.000-21.499	25.000	356.2	56.0	258.0	09/2025	8154 21.000
210	21.000-21.499	25.400	356.2	56.0	258.0	09/2025	8154 21.005
215	21.500-21.999	25.000	362.0	56.0	264.0	09/2025	8154 21.500
215	21.500-21.999	25.400	362.0	56.0	264.0	09/2025	8154 21.505
220	22.000-22.499	25.000	368.7	56.0	270.0	09/2025	8154 22.000
220	22.000-22.499	25.400	368.7	56.0	270.0	09/2025	8154 22.005
225	22.500-22.999	25.000	374.5	56.0	276.0	09/2025	8154 22.500
225	22.500-22.999	25.400	374.5	56.0	276.0	09/2025	8154 22.505
230	23.000-23.499	25.000	381.2	56.0	282.0	09/2025	8154 23.000
230	23.000-23.499	25.400	381.2	56.0	282.0	09/2025	8154 23.005
235	23.500-23.999	25.000	386.0	56.0	288.0	09/2025	8154 23.500
235	23.500-23.999	25.400	386.0	56.0	288.0	09/2025	8154 23.505
240	24.000-24.499	25.000	392.7	56.0	294.0	09/2025	8154 24.000
240	24.000-24.499	25.400	392.7	56.0	294.0	09/2025	8154 24.005
245	24.500-24.999	25.000	399.5	56.0	300.0	09/2025	8154 24.500
245	24.500-24.999	25.400	399.5	56.0	300.0	09/2025	8154 24.505
250	25.000-25.499	25.000	406.2	56.0	306.0	09/2025	8154 25.000
250	25.000-25.499	25.400	406.2	56.0	306.0	09/2025	8154 25.005
255	25.500-25.999	32.000	422.0	60.0	312.0	09/2025	8154 25.500
255	25.500-25.999	31.750	422.0	60.0	312.0	09/2025	8154 25.505
260	26.000-26.499	32.000	428.7	60.0	318.0	09/2025	8154 26.000
260	26.000-26.499	31.750	428.7	60.0	318.0	09/2025	8154 26.005



Drill head BT 800 for piloting

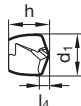
Article no. **8162**

cutting data see page 20



P	M	K	N	S	H
●	○	○	○	○	○

facet point grind • main cutting edge is slightly concave • exceptional hole quality • piloting in all materials • mounting
key art. no. 8170 included with drill head holder or order separately



Article no.						8162	Article no.						8162
Size	d1 mm	inch	l4 mm	h mm	Avail.	Order no.	Size	d1 mm	inch	l4 mm	h mm	Avail.	Order no.
100	10.000		1.700	5.250	09/2025	8162 10.000	155	15.500		2.600	7.000	09/2025	8162 15.500
100	10.100		1.700	5.250	09/2025	8162 10.100	155	15.600		2.600	7.000	09/2025	8162 15.600
100	10.200		1.700	5.250	09/2025	8162 10.200	155	15.700		2.600	7.000	09/2025	8162 15.700
100	10.300		1.700	5.250	09/2025	8162 10.300	155	15.800		2.600	7.000	09/2025	8162 15.800
100	10.320	13/32	1.700	5.250	09/2025	8162 10.320	155	15.870	5/8	2.600	7.000	09/2025	8162 15.870
100	10.400		1.700	5.250	09/2025	8162 10.400	155	15.900		2.600	7.000	09/2025	8162 15.900
105	10.500		1.800	5.250	09/2025	8162 10.500	160	16.000		2.700	7.500	09/2025	8162 16.000
105	10.600		1.800	5.250	09/2025	8162 10.600	160	16.100		2.700	7.500	09/2025	8162 16.100
105	10.700		1.800	5.250	09/2025	8162 10.700	160	16.200		2.700	7.500	09/2025	8162 16.200
105	10.720	27/64	1.800	5.250	09/2025	8162 10.720	160	16.270	41/64	2.700	7.500	09/2025	8162 16.270
105	10.800		1.800	5.250	09/2025	8162 10.800	160	16.300		2.700	7.500	09/2025	8162 16.300
105	10.900		1.800	5.250	09/2025	8162 10.900	160	16.400		2.700	7.500	09/2025	8162 16.400
110	11.000		1.900	5.500	09/2025	8162 11.000	165	16.500		2.800	7.500	09/2025	8162 16.500
110	11.100		1.900	5.500	09/2025	8162 11.100	165	16.600		2.800	7.500	09/2025	8162 16.600
110	11.110	7/16	1.900	5.500	09/2025	8162 11.110	165	16.670	21/32	2.800	7.500	09/2025	8162 16.670
110	11.200		1.900	5.500	09/2025	8162 11.200	165	16.700		2.800	7.500	09/2025	8162 16.700
110	11.300		1.900	5.500	09/2025	8162 11.300	165	16.800		2.800	7.500	09/2025	8162 16.800
110	11.400		1.900	5.500	09/2025	8162 11.400	165	16.900		2.800	7.500	09/2025	8162 16.900
115	11.500		2.000	5.500	09/2025	8162 11.500	170	17.000		2.900	7.750	09/2025	8162 17.000
115	11.510	29/64	2.000	5.500	09/2025	8162 11.510	170	17.070	43/64	2.900	7.750	09/2025	8162 17.070
115	11.600		2.000	5.500	09/2025	8162 11.600	170	17.100		2.900	7.750	09/2025	8162 17.100
115	11.700		2.000	5.500	09/2025	8162 11.700	170	17.200		2.900	7.750	09/2025	8162 17.200
115	11.800		2.000	5.500	09/2025	8162 11.800	170	17.300		2.900	7.750	09/2025	8162 17.300
115	11.900		2.000	5.500	09/2025	8162 11.900	170	17.400		2.900	7.750	09/2025	8162 17.400
115	11.910	15/32	2.000	5.500	09/2025	8162 11.910	170	17.460	11/16	2.900	7.750	09/2025	8162 17.460
120	12.000		2.100	6.000	09/2025	8162 12.000	175	17.500		3.000	7.750	09/2025	8162 17.500
120	12.100		2.100	6.000	09/2025	8162 12.100	175	17.600		3.000	7.750	09/2025	8162 17.600
120	12.200		2.100	6.000	09/2025	8162 12.200	175	17.700		3.000	7.750	09/2025	8162 17.700
120	12.300	31/64	2.100	6.000	09/2025	8162 12.300	175	17.800		3.000	7.750	09/2025	8162 17.800
120	12.400		2.100	6.000	09/2025	8162 12.400	175	17.860	45/64	3.000	7.750	09/2025	8162 17.860
125	12.500		2.100	6.000	09/2025	8162 12.500	175	17.900		3.000	7.750	09/2025	8162 17.900
125	12.600		2.100	6.000	09/2025	8162 12.600	180	18.000		3.100	8.750	09/2025	8162 18.000
125	12.700	1/2	2.100	6.000	09/2025	8162 12.700	180	18.100		3.100	8.750	09/2025	8162 18.100
125	12.800		2.100	6.000	09/2025	8162 12.800	180	18.200		3.100	8.750	09/2025	8162 18.200
125	12.900		2.100	6.000	09/2025	8162 12.900	180	18.260	23/32	3.100	8.750	09/2025	8162 18.260
130	13.000		2.200	6.250	09/2025	8162 13.000	180	18.300		3.100	8.750	09/2025	8162 18.300
130	13.100	33/64	2.200	6.250	09/2025	8162 13.100	180	18.400		3.100	8.750	09/2025	8162 18.400
130	13.200		2.200	6.250	09/2025	8162 13.200	185	18.500		3.200	8.750	09/2025	8162 18.500
130	13.300		2.200	6.250	09/2025	8162 13.300	185	18.600		3.200	8.750	09/2025	8162 18.600
130	13.400		2.200	6.250	09/2025	8162 13.400	185	18.650	47/64	3.200	8.750	09/2025	8162 18.650
130	13.490	17/32	2.200	6.250	09/2025	8162 13.490	185	18.700		3.200	8.750	09/2025	8162 18.700
135	13.500		2.300	6.250	09/2025	8162 13.500	185	18.800		3.200	8.750	09/2025	8162 18.800
135	13.600		2.300	6.250	09/2025	8162 13.600	185	18.900		3.200	8.750	09/2025	8162 18.900
135	13.700		2.300	6.250	09/2025	8162 13.700	190	19.000		3.200	8.750	09/2025	8162 19.000
135	13.800		2.300	6.250	09/2025	8162 13.800	190	19.050	3/4	3.200	8.750	09/2025	8162 19.050
135	13.890	35/64	2.300	6.250	09/2025	8162 13.890	190	19.100		3.200	8.750	09/2025	8162 19.100
135	13.900		2.300	6.250	09/2025	8162 13.900	190	19.200		3.200	8.750	09/2025	8162 19.200
140	14.000		2.400	6.750	09/2025	8162 14.000	190	19.250		3.200	8.750	09/2025	8162 19.250
140	14.100		2.400	6.750	09/2025	8162 14.100	190	19.300		3.200	8.750	09/2025	8162 19.300
140	14.200		2.400	6.750	09/2025	8162 14.200	190	19.400		3.200	8.750	09/2025	8162 19.400
140	14.290	9/16	2.400	6.750	09/2025	8162 14.290	190	19.450	49/64	3.200	8.750	09/2025	8162 19.450
140	14.300		2.400	6.750	09/2025	8162 14.300	195	19.500		3.300	8.750	09/2025	8162 19.500
140	14.400		2.400	6.750	09/2025	8162 14.400	195	19.600		3.300	8.750	09/2025	8162 19.600
145	14.500		2.500	6.750	09/2025	8162 14.500	195	19.700		3.300	8.750	09/2025	8162 19.700
145	14.600		2.500	6.750	09/2025	8162 14.600	195	19.800		3.300	8.750	09/2025	8162 19.800
145	14.680	37/64	2.500	6.750	09/2025	8162 14.680	195	19.840	25/32	3.300	8.750	09/2025	8162 19.840
145	14.700		2.500	6.750	09/2025	8162 14.700	195	19.900		3.300	8.750	09/2025	8162 19.900
145	14.800		2.500	6.750	09/2025	8162 14.800	200	20.000		3.400	9.500	09/2025	8162 20.000
145	14.900		2.500	6.750	09/2025	8162 14.900	200	20.100		3.400	9.500	09/2025	8162 20.100
150	15.000		2.500	7.000	09/2025	8162 15.000	200	20.200		3.400	9.500	09/2025	8162 20.200
150	15.080	19/32	2.500	7.000	09/2025	8162 15.080	200	20.240	51/64	3.400	9.500	09/2025	8162 20.240
150	15.100		2.500	7.000	09/2025	8162 15.100	200	20.300		3.400	9.500	09/2025	8162 20.300
150	15.200		2.500	7.000	09/2025	8162 15.200	200	20.400		3.400	9.500	09/2025	8162 20.400
150	15.300		2.500	7.000	09/2025	8162 15.300	205	20.500		3.500	9.500	09/2025	8162 20.500
150	15.400		2.500	7.000	09/2025	8162 15.400	205	20.600		3.500	9.500	09/2025	8162 20.600
150	15.480	39/64	2.500	7.000	09/2025	8162 15.480	205	20.640	13/16	3.500	9.500	09/2025	8162 20.640



Modular drills with interchangeable head BT 800

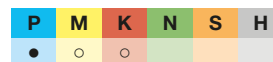
Article no.						8162	Article no.						8162
Size	d1 mm	inch	l4 mm	h mm	Avail.	Order no.	Size	d1 mm	inch	l4 mm	h mm	Avail.	Order no.
205	20.700		3.500	9.500	09/2025	8162 20.700	235	23.600		4.000	10.250	09/2025	8162 23.600
205	20.800		3.500	9.500	09/2025	8162 20.800	235	23.700		4.000	10.250	09/2025	8162 23.700
205	20.900		3.500	9.500	09/2025	8162 20.900	235	23.800		4.000	10.250	09/2025	8162 23.800
210	21.000		3.600	9.500	09/2025	8162 21.000	235	23.810	15/16	4.000	10.250	09/2025	8162 23.810
210	21.030	53/64	3.600	9.500	09/2025	8162 21.030	235	23.900		4.000	10.250	09/2025	8162 23.900
210	21.100		3.600	9.500	09/2025	8162 21.100	240	24.000		4.100	11.000	09/2025	8162 24.000
210	21.200		3.600	9.500	09/2025	8162 21.200	240	24.100		4.100	11.000	09/2025	8162 24.100
210	21.300		3.600	9.500	09/2025	8162 21.300	240	24.200		4.100	11.000	09/2025	8162 24.200
210	21.400		3.600	9.500	09/2025	8162 21.400	240	24.210	61/64	4.100	11.000	09/2025	8162 24.210
210	21.430	27/32	3.600	9.500	09/2025	8162 21.430	240	24.300		4.100	11.000	09/2025	8162 24.300
215	21.500		3.700	9.500	09/2025	8162 21.500	240	24.400		4.100	11.000	09/2025	8162 24.400
215	21.600		3.700	9.500	09/2025	8162 21.600	245	24.500		4.200	11.000	09/2025	8162 24.500
215	21.700		3.700	9.500	09/2025	8162 21.700	245	24.600		4.200	11.000	09/2025	8162 24.600
215	21.800		3.700	9.500	09/2025	8162 21.800	245	24.610	31/32	4.200	11.000	09/2025	8162 24.610
215	21.830	55/64	3.700	9.500	09/2025	8162 21.830	245	24.700		4.200	11.000	09/2025	8162 24.700
215	21.900		3.700	9.500	09/2025	8162 21.900	245	24.800		4.200	11.000	09/2025	8162 24.800
220	22.000		3.700	10.250	09/2025	8162 22.000	245	24.900		4.200	11.000	09/2025	8162 24.900
220	22.100		3.700	10.250	09/2025	8162 22.100	250	25.000	63/64	4.200	11.000	09/2025	8162 25.000
220	22.200		3.700	10.250	09/2025	8162 22.200	250	25.100		4.200	11.000	09/2025	8162 25.100
220	22.220	7/8	3.700	10.250	09/2025	8162 22.220	250	25.200		4.200	11.000	09/2025	8162 25.200
220	22.300		3.700	10.250	09/2025	8162 22.300	250	25.300		4.200	11.000	09/2025	8162 25.300
220	22.400		3.700	10.250	09/2025	8162 22.400	250	25.400	1	4.200	11.000	09/2025	8162 25.400
225	22.500		3.800	10.250	09/2025	8162 22.500	255	25.500		4.300	11.000	09/2025	8162 25.500
225	22.600		3.800	10.250	09/2025	8162 22.600	255	25.600		4.300	11.000	09/2025	8162 25.600
225	22.620	57/64	3.800	10.250	09/2025	8162 22.620	255	25.700		4.300	11.000	09/2025	8162 25.700
225	22.700		3.800	10.250	09/2025	8162 22.700	255	25.800	1 1/64	4.300	11.000	09/2025	8162 25.800
225	22.800		3.800	10.250	09/2025	8162 22.800	255	25.900		4.300	11.000	09/2025	8162 25.900
225	22.900		3.800	10.250	09/2025	8162 22.900	260	26.000		4.400	12.000	09/2025	8162 26.000
230	23.000		3.900	10.250	09/2025	8162 23.000							
230	23.020	29/32	3.900	10.250	09/2025	8162 23.020							
230	23.100		3.900	10.250	09/2025	8162 23.100							
230	23.200		3.900	10.250	09/2025	8162 23.200							
230	23.300		3.900	10.250	09/2025	8162 23.300							
230	23.400		3.900	10.250	09/2025	8162 23.400							
230	23.420	59/64	3.900	10.250	09/2025	8162 23.420							
235	23.500		4.000	10.250	09/2025	8162 23.500							



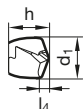
Drill head BT 800

Article no. **8163**

cutting data see page 21-23



facet point grind • main cutting edge is slightly concave • exceptional hole quality • mounting key art. no. 8170 included with drill head holder or order separately



Article no.						8163	Article no.						8163
Size	d1 mm	inch	l4 mm	h mm	Avail.	Order no.	Size	d1 mm	inch	l4 mm	h mm	Avail.	Order no.
100	10.000	13/32	1.900	5.250	09/2025	8163 10.000	155	15.500	5/8	3.000	7.000	09/2025	8163 15.500
100	10.100		1.900	5.250	09/2025	8163 10.100	155	15.600		3.000	7.000	09/2025	8163 15.600
100	10.200		1.900	5.250	09/2025	8163 10.200	155	15.700		3.000	7.000	09/2025	8163 15.700
100	10.300		1.900	5.250	09/2025	8163 10.300	155	15.800		3.000	7.000	09/2025	8163 15.800
100	10.320		1.900	5.250	09/2025	8163 10.320	155	15.870		3.000	7.000	09/2025	8163 15.870
100	10.400	27/64	1.900	5.250	09/2025	8163 10.400	155	15.900	41/64	3.000	7.000	09/2025	8163 15.900
105	10.500		2.000	5.250	09/2025	8163 10.500	160	16.000		3.100	7.500		8163 16.000
105	10.600		2.000	5.250	09/2025	8163 10.600	160	16.100		3.100	7.500		8163 16.100
105	10.700		2.000	5.250	09/2025	8163 10.700	160	16.200		3.100	7.500		8163 16.200
105	10.720		2.000	5.250	09/2025	8163 10.720	160	16.270		3.100	7.500	09/2025	8163 16.270
105	10.800	7/16	2.000	5.250	09/2025	8163 10.800	160	16.300	21/32	3.100	7.500		8163 16.300
105	10.900		2.000	5.250	09/2025	8163 10.900	160	16.400		3.100	7.500		8163 16.400
110	11.000		2.100	5.500	09/2025	8163 11.000	165	16.500		3.200	7.500		8163 16.500
110	11.100		2.100	5.500	09/2025	8163 11.100	165	16.600		3.200	7.500		8163 16.600
110	11.110		2.100	5.500	09/2025	8163 11.110	165	16.670		3.200	7.500	09/2025	8163 16.670
110	11.200	15/32	2.100	5.500	09/2025	8163 11.200	165	16.700	11/16	3.200	7.500		8163 16.700
110	11.300		2.100	5.500	09/2025	8163 11.300	165	16.800		3.200	7.500		8163 16.800
110	11.400		2.100	5.500	09/2025	8163 11.400	165	16.900		3.200	7.500		8163 16.900
115	11.500		2.200	5.500	09/2025	8163 11.500	170	17.000		3.300	7.750		8163 17.000
115	11.510		2.200	5.500	09/2025	8163 11.510	170	17.070		3.300	7.750	09/2025	8163 17.070
115	11.600	15/32	2.200	5.500	09/2025	8163 11.600	170	17.100	43/64	3.300	7.750		8163 17.100
115	11.700		2.200	5.500	09/2025	8163 11.700	170	17.200		3.300	7.750		8163 17.200
115	11.800		2.200	5.500	09/2025	8163 11.800	170	17.300		3.300	7.750		8163 17.300
115	11.900		2.200	5.500	09/2025	8163 11.900	170	17.400		3.300	7.750		8163 17.400
115	11.910		2.200	5.500	09/2025	8163 11.910	170	17.460		3.300	7.750	09/2025	8163 17.460
120	12.000	31/64	2.300	6.000	09/2025	8163 12.000	175	17.500	45/64	3.400	7.750		8163 17.500
120	12.100		2.300	6.000	09/2025	8163 12.100	175	17.600		3.400	7.750		8163 17.600
120	12.200		2.300	6.000	09/2025	8163 12.200	175	17.700		3.400	7.750		8163 17.700
120	12.300		2.300	6.000	09/2025	8163 12.300	175	17.800		3.400	7.750	09/2025	8163 17.800
120	12.400		2.300	6.000	09/2025	8163 12.400	175	17.860		3.400	7.750		8163 17.860
125	12.500	1/2	2.400	6.000	09/2025	8163 12.500	175	17.900	23/32	3.400	7.750		8163 17.900
125	12.600		2.400	6.000	09/2025	8163 12.600	180	18.000		3.500	8.750		8163 18.000
125	12.700		2.400	6.000	09/2025	8163 12.700	180	18.100		3.500	8.750		8163 18.100
125	12.800		2.400	6.000	09/2025	8163 12.800	180	18.200		3.500	8.750		8163 18.200
125	12.900		2.400	6.000	09/2025	8163 12.900	180	18.260		3.500	8.750	09/2025	8163 18.260
130	13.000	33/64	2.500	6.250	09/2025	8163 13.000	180	18.300	47/64	3.500	8.750		8163 18.300
130	13.100		2.500	6.250	09/2025	8163 13.100	180	18.400		3.500	8.750		8163 18.400
130	13.200		2.500	6.250	09/2025	8163 13.200	185	18.500		3.600	8.750		8163 18.500
130	13.300		2.500	6.250	09/2025	8163 13.300	185	18.600		3.600	8.750		8163 18.600
130	13.400		2.500	6.250	09/2025	8163 13.400	185	18.650		3.600	8.750	09/2025	8163 18.650
130	13.490	17/32	2.500	6.250	09/2025	8163 13.490	185	18.700	3/4	3.600	8.750		8163 18.700
135	13.500		2.600	6.250	09/2025	8163 13.500	185	18.800		3.600	8.750		8163 18.800
135	13.600		2.600	6.250	09/2025	8163 13.600	185	18.900		3.600	8.750		8163 18.900
135	13.700		2.600	6.250	09/2025	8163 13.700	190	19.000		3.700	8.750		8163 19.000
135	13.800		2.600	6.250	09/2025	8163 13.800	190	19.050		3.700	8.750	09/2025	8163 19.050
135	13.890	35/64	2.600	6.250	09/2025	8163 13.890	190	19.100	51/64	3.700	8.750		8163 19.100
135	13.900		2.600	6.250	09/2025	8163 13.900	190	19.200		3.700	8.750		8163 19.200
140	14.000		2.700	6.750	09/2025	8163 14.000	190	19.250		3.700	8.750		8163 19.250
140	14.100		2.700	6.750	09/2025	8163 14.100	190	19.300		3.700	8.750		8163 19.300
140	14.200		2.700	6.750	09/2025	8163 14.200	190	19.400		3.700	8.750		8163 19.400
140	14.290	9/16	2.700	6.750	09/2025	8163 14.290	190	19.450	13/16	3.700	8.750	09/2025	8163 19.450
140	14.300		2.700	6.750	09/2025	8163 14.300	195	19.500		3.800	8.750		8163 19.500
140	14.400		2.700	6.750	09/2025	8163 14.400	195	19.600		3.800	8.750		8163 19.600
145	14.500		2.800	6.750	09/2025	8163 14.500	195	19.700		3.800	8.750		8163 19.700
145	14.600		2.800	6.750	09/2025	8163 14.600	195	19.800		3.800	8.750		8163 19.800
145	14.680	37/64	2.800	6.750	09/2025	8163 14.680	195	19.840	25/32	3.800	8.750	09/2025	8163 19.840
145	14.700		2.800	6.750	09/2025	8163 14.700	195	19.900		3.800	8.750		8163 19.900
145	14.800		2.800	6.750	09/2025	8163 14.800	200	20.000		3.900	9.500		8163 20.000
145	14.900		2.800	6.750	09/2025	8163 14.900	200	20.100		3.900	9.500		8163 20.100
150	15.000		2.900	7.000	09/2025	8163 15.000	200	20.200		3.900	9.500		8163 20.200
150	15.080	19/32	2.900	7.000	09/2025	8163 15.080	200	20.240	51/64	3.900	9.500	09/2025	8163 20.240
150	15.100		2.900	7.000	09/2025	8163 15.100	200	20.300		3.900	9.500		8163 20.300
150	15.200		2.900	7.000	09/2025	8163 15.200	200	20.400		3.900	9.500		8163 20.400
150	15.300		2.900	7.000	09/2025	8163 15.300	205	20.500		4.000	9.500		8163 20.500
150	15.400		2.900	7.000	09/2025	8163 15.400	205	20.600		4.000	9.500		8163 20.600
150	15.480	39/64	2.900	7.000	09/2025	8163 15.480	205	20.640	13/16	4.000	9.500	09/2025	8163 20.640



Modular drills with interchangeable head BT 800

Article no.						8163	Article no.						8163
Size	d1 mm	inch	l4 mm	h mm	Avail.	Order no.	Size	d1 mm	inch	l4 mm	h mm	Avail.	Order no.
205	20.700		4.000	9.500		8163 20.700	235	23.600		4.500	10.250		8163 23.600
205	20.800		4.000	9.500		8163 20.800	235	23.700		4.500	10.250		8163 23.700
205	20.900		4.000	9.500		8163 20.900	235	23.800		4.500	10.250		8163 23.800
210	21.000		4.100	9.500		8163 21.000	235	23.810	15/16	4.500	10.250	09/2025	8163 23.810
210	21.030	53/64	4.100	9.500	09/2025	8163 21.030	235	23.900		4.500	10.250		8163 23.900
210	21.100		4.100	9.500		8163 21.100	240	24.000		4.600	11.000		8163 24.000
210	21.200		4.100	9.500		8163 21.200	240	24.100		4.600	11.000		8163 24.100
210	21.300		4.100	9.500		8163 21.300	240	24.200		4.600	11.000		8163 24.200
210	21.400		4.100	9.500		8163 21.400	240	24.210	61/64	4.600	11.000	09/2025	8163 24.210
210	21.430	27/32	4.100	9.500	09/2025	8163 21.430	240	24.300		4.600	11.000		8163 24.300
215	21.500		4.200	9.500		8163 21.500	240	24.400		4.600	11.000		8163 24.400
215	21.600		4.200	9.500		8163 21.600	245	24.500		4.700	11.000		8163 24.500
215	21.700		4.200	9.500		8163 21.700	245	24.600		4.700	11.000		8163 24.600
215	21.800		4.200	9.500		8163 21.800	245	24.610	31/32	4.700	11.000	09/2025	8163 24.610
215	21.830	55/64	4.200	9.500	09/2025	8163 21.830	245	24.700		4.700	11.000		8163 24.700
215	21.900		4.200	9.500		8163 21.900	245	24.800		4.700	11.000		8163 24.800
220	22.000		4.300	10.250		8163 22.000	245	24.900		4.700	11.000		8163 24.900
220	22.100		4.300	10.250		8163 22.100	250	25.000	63/64	4.800	11.000		8163 25.000
220	22.200		4.300	10.250		8163 22.200	250	25.100		4.800	11.000		8163 25.100
220	22.220	7/8	4.300	10.250	09/2025	8163 22.220	250	25.200		4.800	11.000		8163 25.200
220	22.300		4.300	10.250		8163 22.300	250	25.300		4.800	11.000		8163 25.300
220	22.400		4.300	10.250		8163 22.400	250	25.400	1	4.800	11.000		8163 25.400
225	22.500		4.400	10.250		8163 22.500	255	25.500		4.900	11.000		8163 25.500
225	22.600		4.400	10.250		8163 22.600	255	25.600		4.900	11.000		8163 25.600
225	22.620	57/64	4.400	10.250	09/2025	8163 22.620	255	25.700		4.900	11.000		8163 25.700
225	22.700		4.400	10.250		8163 22.700	255	25.800	1 1/64	4.900	11.000		8163 25.800
225	22.800		4.400	10.250		8163 22.800	255	25.900		4.900	11.000		8163 25.900
225	22.900		4.400	10.250		8163 22.900	260	26.000		5.000	12.000		8163 26.000
230	23.000		4.500	10.250		8163 23.000							
230	23.020	29/32	4.500	10.250	09/2025	8163 23.020							
230	23.100		4.500	10.250		8163 23.100							
230	23.200		4.500	10.250		8163 23.200							
230	23.300		4.500	10.250		8163 23.300							
230	23.400		4.500	10.250		8163 23.400							
230	23.420	59/64	4.500	10.250	09/2025	8163 23.420							
235	23.500		4.500	10.250		8163 23.500							



Mounting key BT 800



Article no.

8170

Size	Order no.
10.0-10.99	8170 10.000
11.0-11.99	8170 11.000
12.0-12.99	8170 12.000
13.0-13.99	8170 13.000
14.0-14.99	8170 14.000
15.0-15.99	8170 15.000
16.0-16.99	8170 16.000
17.0-17.99	8170 17.000
18.0-18.99	8170 18.000
19.0-19.99	8170 19.000
20.0-20.99	8170 20.000
21.0-21.99	8170 21.000
22.0-22.99	8170 22.000
23.0-23.99	8170 23.000
24.0-24.99	8170 24.000
25.0-25.99	8170 25.000
26.0-26.99	8170 26.000



Drill head BT 800 for piloting, with tool holder ≤ 3xD



Machining group		f (mm/rev) with nom. Ø							
	 v _c (m/min)	10	12	14	16	18	20	22	26
P1.1.1 Unalloyed steel, annealed, 0.15 % C, Rm 420 N/mm ² , 125 HB	130	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
P1.1.2 Unalloyed steel, heat-treated, 0.15 % C, Rm 420 N/mm ² , 125 HB	115	0.215	0.250	0.280	0.310	0.340	0.365	0.395	0.445
P1.1.3 Unalloyed steel, annealed, 0.45 % C, Rm 640 N/mm ² , 190 HB	115	0.215	0.250	0.280	0.310	0.340	0.365	0.395	0.445
P1.1.4 Unalloyed steel, heat-treated, 0.45 % C, Rm 640 N/mm ² , 190 HB	110	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
P1.1.5 Unalloyed steel, heat-treated, 0.45 % C, Rm 850 N/mm ² , 250 HB	110	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
P1.1.6 Unalloyed steel, annealed, 0.75 % C, Rm 915 N/mm ² , 270 HB	105	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
P1.1.7 Unalloyed steel, heat-treated, 0.75 % C, Rm 1020 N/mm ² , 300 HB	100	0.180	0.205	0.230	0.255	0.280	0.305	0.330	0.370
P2.1.1 Low-alloy steel, annealed, Rm 610 N/mm ² , 180 HB	110	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
P2.1.2 Low-alloy steel, heat-treated, Rm 930 N/mm ² , 275 HB	110	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
P2.1.3 Low-alloy steel, heat-treated, Rm 1020 N/mm ² , 300 HB	95	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
P2.1.4 Low-alloy steel, heat-treated, Rm 1190 N/mm ² , 350 HB	85	0.180	0.205	0.230	0.255	0.280	0.305	0.330	0.370
P3.1.1 High-alloy steel and tool steel, annealed, Rm 680 N/mm ² , 200 HB	60	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
P3.1.2 High-alloy steel and tool steel, hardened and tempered, Rm 1100 N/mm ² , 325 HB	50	0.165	0.185	0.210	0.235	0.255	0.275	0.295	0.335
M1.1.1 Stainless steel, ferritic/martensitic, with machining additives	55	0.155	0.175	0.200	0.220	0.240	0.260	0.280	0.315
M1.1.2 Stainless steel, ferritic/martensitic, annealed, Rm 680 N/mm ² , 200 HB	50	0.140	0.160	0.180	0.195	0.215	0.235	0.250	0.285
M1.1.3 Stainless steel, ferritic/martensitic, heat-treated, Rm 810 N/mm ² , 240 HB	45	0.130	0.150	0.170	0.185	0.205	0.220	0.235	0.270
M2.1.1 Stainless steel, austenitic, quenched, 180 HB	40	0.155	0.175	0.200	0.220	0.240	0.260	0.280	0.315
M2.2.1 Duplex steel, high-strength stainless steels	35	0.130	0.150	0.170	0.185	0.205	0.220	0.235	0.270
K1.1.1 Grey cast iron, pearlitic/ferritic, 180 HB	100	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
K1.1.2 Grey cast iron, pearlitic/martensitic, 260 HB	85	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
K1.2.1 Cast iron with spheroidal graphite, ferritic, 160 HB	85	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
K1.2.2 Cast iron with spheroidal graphite, pearlitic, 250 HB	80	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
K1.3.1 Malleable cast iron, ferritic, 130 HB	80	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
K1.3.2 Malleable cast iron, pearlitic, 230 HB	70	0.170	0.195	0.215	0.240	0.265	0.285	0.305	0.345
K2.1.1 Vermicular graphite cast iron (GJV)	80	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
K2.2.1 Austenitic-ferritic spheroidal graphite cast iron (ADI)	60	0.145	0.165	0.185	0.205	0.225	0.245	0.260	0.300
N1.1.1 Wrought aluminium alloys, non-hardened, 60 HB	200	0.305	0.355	0.395	0.440	0.480	0.520	0.560	0.635
N1.1.2 Wrought aluminium alloys, hardened, 100 HB	200	0.305	0.355	0.395	0.440	0.480	0.520	0.560	0.635
N2.1.1 Aluminium casting alloys, non-hardened, ≤ 12 % Si, 75 HB	180	0.305	0.355	0.395	0.440	0.480	0.520	0.560	0.635
N2.1.2 Aluminium casting alloys, hardened, ≤ 12 % Si, 90 HB	180	0.305	0.355	0.395	0.440	0.480	0.520	0.560	0.635
N2.1.3 Aluminium casting alloys, non-hardened, > 12 % Si, 130 HB	155	0.260	0.300	0.335	0.375	0.410	0.440	0.475	0.540
N3.1.1 Copper and copper alloys: Free-machining alloy, Pb > 1 %	140	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
N3.1.2 Copper and copper alloys: CuZn, CuSnZn	120	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
N3.1.3 Copper and copper alloys: CuSn, lead-free copper and copper electrolyte	110	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
N4.1.1 Non-metallic materials: Duroplastics, fibre-reinforced plastics									
N4.1.2 Non-metallic materials: Hard rubber, wood, etc.									
N4.1.3 Non-metallic materials: Graphite									
S1.1.1 Heat-resistant alloys, Fe-based, annealed, 200 HB	35	0.095	0.110	0.125	0.135	0.150	0.165	0.175	0.200
S1.1.2 Heat-resistant alloys, Fe-based, hardened, 280 HB	30	0.075	0.090	0.100	0.110	0.120	0.130	0.140	0.160
S1.1.3 Heat-resistant alloys, Ni- or Co-based, annealed, 250 HB	30	0.095	0.110	0.125	0.135	0.150	0.165	0.175	0.200
S1.1.4 Heat-resistant alloys, Ni- or Co-based, hardened, 350 HB	20	0.065	0.075	0.085	0.095	0.105	0.115	0.120	0.140
S1.1.5 Heat-resistant alloys, Ni- or Co-based, cast, 320 HB	20	0.065	0.075	0.085	0.095	0.105	0.115	0.120	0.140
S2.1.1 Titanium alloys, pure titanium, Rm 400 N/mm ²	40	0.120	0.140	0.155	0.175	0.190	0.205	0.220	0.250
S2.1.2 Titanium alloys, Alpha and Beta alloys, hardened, Rm 1050 N/mm ²	30	0.095	0.110	0.125	0.140	0.150	0.165	0.175	0.200
H1.1.1 Hardened steel, hardened and tempered, < 55 HRC	25	0.095	0.110	0.125	0.135	0.150	0.165	0.175	0.200
H1.1.2 Hardened steel, hardened and tempered, < 60 HRC									
H1.1.3 Hardened steel, hardened and tempered, > 60 HRC									
H2.1.1 Chilled cast iron, 400 HB	90	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
H2.1.2 Chilled cast iron, hardened and tempered, < 55 HRC	65	0.170	0.195	0.215	0.240	0.265	0.285	0.305	0.345



Drill head BT 800, with tool holder ≤ 5xD



Machining group		f (mm/rev) with nom. Ø							
	v _c (m/min)	10	12	14	16	18	20	22	26
P1.1.1 Unalloyed steel, annealed, 0.15 % C, Rm 420 N/mm ² , 125 HB	135	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
P1.1.2 Unalloyed steel, heat-treated, 0.15 % C, Rm 420 N/mm ² , 125 HB	120	0.215	0.250	0.280	0.310	0.340	0.365	0.395	0.445
P1.1.3 Unalloyed steel, annealed, 0.45 % C, Rm 640 N/mm ² , 190 HB	120	0.215	0.250	0.280	0.310	0.340	0.365	0.395	0.445
P1.1.4 Unalloyed steel, heat-treated, 0.45 % C, Rm 640 N/mm ² , 190 HB	115	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
P1.1.5 Unalloyed steel, heat-treated, 0.45 % C, Rm 850 N/mm ² , 250 HB	115	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
P1.1.6 Unalloyed steel, annealed, 0.75 % C, Rm 915 N/mm ² , 270 HB	110	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
P1.1.7 Unalloyed steel, heat-treated, 0.75 % C, Rm 1020 N/mm ² , 300 HB	100	0.180	0.205	0.230	0.255	0.280	0.305	0.330	0.370
P2.1.1 Low-alloy steel, annealed, Rm 610 N/mm ² , 180 HB	115	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
P2.1.2 Low-alloy steel, heat-treated, Rm 930 N/mm ² , 275 HB	115	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
P2.1.3 Low-alloy steel, heat-treated, Rm 1020 N/mm ² , 300 HB	100	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
P2.1.4 Low-alloy steel, heat-treated, Rm 1190 N/mm ² , 350 HB	85	0.180	0.205	0.230	0.255	0.280	0.305	0.330	0.370
P3.1.1 High-alloy steel and tool steel, annealed, Rm 680 N/mm ² , 200 HB	65	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
P3.1.2 High-alloy steel and tool steel, hardened and tempered, Rm 1100 N/mm ² , 325 HB	55	0.165	0.185	0.210	0.235	0.255	0.275	0.295	0.335
M1.1.1 Stainless steel, ferritic/martensitic, with machining additives	55	0.155	0.175	0.200	0.220	0.240	0.260	0.280	0.315
M1.1.2 Stainless steel, ferritic/martensitic, annealed, Rm 680 N/mm ² , 200 HB	50	0.140	0.160	0.180	0.195	0.215	0.235	0.250	0.285
M1.1.3 Stainless steel, ferritic/martensitic, heat-treated, Rm 810 N/mm ² , 240 HB	45	0.130	0.150	0.170	0.185	0.205	0.220	0.235	0.270
M2.1.1 Stainless steel, austenitic, quenched, 180 HB	40	0.155	0.175	0.200	0.220	0.240	0.260	0.280	0.315
M2.2.1 Duplex steel, high-strength stainless steels	35	0.130	0.150	0.170	0.185	0.205	0.220	0.235	0.270
K1.1.1 Grey cast iron, pearlitic/ferritic, 180 HB	100	0.240	0.275	0.310	0.345	0.375	0.405	0.435	0.495
K1.1.2 Grey cast iron, pearlitic/martensitic, 260 HB	85	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
K1.2.1 Cast iron with spheroidal graphite, ferritic, 160 HB	85	0.205	0.235	0.265	0.290	0.320	0.345	0.370	0.420
K1.2.2 Cast iron with spheroidal graphite, pearlitic, 250 HB	80	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
K1.3.1 Malleable cast iron, ferritic, 130 HB	80	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
K1.3.2 Malleable cast iron, pearlitic, 230 HB	70	0.170	0.195	0.215	0.240	0.265	0.285	0.305	0.345
K2.1.1 Vermicular graphite cast iron (GJV)	80	0.190	0.220	0.250	0.275	0.300	0.325	0.350	0.395
K2.2.1 Austenitic-ferritic spheroidal graphite cast iron (ADI)	60	0.145	0.165	0.185	0.205	0.225	0.245	0.260	0.300
N1.1.1 Wrought aluminium alloys, non-hardened, 60 HB									
N1.1.2 Wrought aluminium alloys, hardened, 100 HB									
N2.1.1 Aluminium casting alloys, non-hardened, ≤ 12 % Si, 75 HB									
N2.1.2 Aluminium casting alloys, hardened, ≤ 12 % Si, 90 HB									
N2.1.3 Aluminium casting alloys, non-hardened, > 12 % Si, 130 HB									
N3.1.1 Copper and copper alloys: Free-machining alloy, Pb > 1 %									
N3.1.2 Copper and copper alloys: CuZn, CuSnZn									
N3.1.3 Copper and copper alloys: CuSn, lead-free copper and copper electrolyte									
N4.1.1 Non-metallic materials: Duroplastics, fibre-reinforced plastics									
N4.1.2 Non-metallic materials: Hard rubber, wood, etc.									
N4.1.3 Non-metallic materials: Graphite									
S1.1.1 Heat-resistant alloys, Fe-based, annealed, 200 HB									
S1.1.2 Heat-resistant alloys, Fe-based, hardened, 280 HB									
S1.1.3 Heat-resistant alloys, Ni- or Co-based, annealed, 250 HB									
S1.1.4 Heat-resistant alloys, Ni- or Co-based, hardened, 350 HB									
S1.1.5 Heat-resistant alloys, Ni- or Co-based, cast, 320 HB									
S2.1.1 Titanium alloys, pure titanium, Rm 400 N/mm ²									
S2.1.2 Titanium alloys, Alpha and Beta alloys, hardened, Rm 1050 N/mm ²									
H1.1.1 Hardened steel, hardened and tempered, < 55 HRC									
H1.1.2 Hardened steel, hardened and tempered, < 60 HRC									
H1.1.3 Hardened steel, hardened and tempered, > 60 HRC									
H2.1.1 Chilled cast iron, 400 HB									
H2.1.2 Chilled cast iron, hardened and tempered, < 55 HRC									



Drill head BT 800, with tool holder 8xD



Machining group		f (mm/rev) with nom. Ø							
	v _c (m/min)	10	12	14	16	18	20	22	26
P1.1.1 Unalloyed steel, annealed, 0.15 % C, Rm 420 N/mm ² , 125 HB	120	0.205	0.235	0.265	0.295	0.325	0.350	0.375	0.425
P1.1.2 Unalloyed steel, heat-treated, 0.15 % C, Rm 420 N/mm ² , 125 HB	105	0.185	0.215	0.240	0.265	0.290	0.315	0.340	0.385
P1.1.3 Unalloyed steel, annealed, 0.45 % C, Rm 640 N/mm ² , 190 HB	105	0.185	0.215	0.240	0.265	0.290	0.315	0.340	0.385
P1.1.4 Unalloyed steel, heat-treated, 0.45 % C, Rm 640 N/mm ² , 190 HB	100	0.175	0.200	0.225	0.250	0.275	0.295	0.320	0.365
P1.1.5 Unalloyed steel, heat-treated, 0.45 % C, Rm 850 N/mm ² , 250 HB	100	0.175	0.200	0.225	0.250	0.275	0.295	0.320	0.365
P1.1.6 Unalloyed steel, annealed, 0.75 % C, Rm 915 N/mm ² , 270 HB	95	0.165	0.190	0.215	0.235	0.260	0.280	0.300	0.340
P1.1.7 Unalloyed steel, heat-treated, 0.75 % C, Rm 1020 N/mm ² , 300 HB	90	0.155	0.180	0.200	0.220	0.240	0.260	0.280	0.320
P2.1.1 Low-alloy steel, annealed, Rm 610 N/mm ² , 180 HB	100	0.205	0.235	0.265	0.295	0.325	0.350	0.375	0.425
P2.1.2 Low-alloy steel, heat-treated, Rm 930 N/mm ² , 275 HB	100	0.205	0.235	0.265	0.295	0.325	0.350	0.375	0.425
P2.1.3 Low-alloy steel, heat-treated, Rm 1020 N/mm ² , 300 HB	85	0.175	0.200	0.225	0.250	0.275	0.295	0.320	0.365
P2.1.4 Low-alloy steel, heat-treated, Rm 1190 N/mm ² , 350 HB	75	0.155	0.180	0.200	0.220	0.240	0.260	0.280	0.320
P3.1.1 High-alloy steel and tool steel, annealed, Rm 680 N/mm ² , 200 HB	55	0.165	0.190	0.215	0.235	0.260	0.280	0.300	0.340
P3.1.2 High-alloy steel and tool steel, hardened and tempered, Rm 1100 N/mm ² , 325 HB	50	0.140	0.160	0.180	0.200	0.220	0.240	0.255	0.290
M1.1.1 Stainless steel, ferritic/martensitic, with machining additives	50	0.130	0.150	0.170	0.190	0.205	0.225	0.240	0.270
M1.1.2 Stainless steel, ferritic/martensitic, annealed, Rm 680 N/mm ² , 200 HB	45	0.120	0.135	0.155	0.170	0.185	0.200	0.215	0.245
M1.1.3 Stainless steel, ferritic/martensitic, heat-treated, Rm 810 N/mm ² , 240 HB	40	0.110	0.130	0.145	0.160	0.175	0.190	0.205	0.230
M2.1.1 Stainless steel, austenitic, quenched, 180 HB	35	0.130	0.150	0.170	0.190	0.205	0.225	0.240	0.270
M2.2.1 Duplex steel, high-strength stainless steels	30	0.110	0.130	0.145	0.160	0.175	0.190	0.205	0.230
K1.1.1 Grey cast iron, pearlitic/ferritic, 180 HB	90	0.205	0.235	0.265	0.295	0.325	0.350	0.375	0.425
K1.1.2 Grey cast iron, pearlitic/martensitic, 260 HB	75	0.175	0.200	0.225	0.250	0.275	0.295	0.320	0.365
K1.2.1 Cast iron with spheroidal graphite, ferritic, 160 HB	75	0.175	0.200	0.225	0.250	0.275	0.295	0.320	0.365
K1.2.2 Cast iron with spheroidal graphite, pearlitic, 250 HB	70	0.165	0.190	0.215	0.235	0.260	0.280	0.300	0.340
K1.3.1 Malleable cast iron, ferritic, 130 HB	70	0.165	0.190	0.215	0.235	0.260	0.280	0.300	0.340
K1.3.2 Malleable cast iron, pearlitic, 230 HB	60	0.145	0.165	0.185	0.205	0.225	0.245	0.265	0.300
K2.1.1 Vermicular graphite cast iron (GJV)	70	0.165	0.190	0.215	0.235	0.260	0.280	0.300	0.340
K2.2.1 Austenitic-ferritic spheroidal graphite cast iron (ADI)	55	0.125	0.140	0.160	0.175	0.195	0.210	0.225	0.255
N1.1.1 Wrought aluminium alloys, non-hardened, 60 HB									
N1.1.2 Wrought aluminium alloys, hardened, 100 HB									
N2.1.1 Aluminium casting alloys, non-hardened, ≤ 12 % Si, 75 HB									
N2.1.2 Aluminium casting alloys, hardened, ≤ 12 % Si, 90 HB									
N2.1.3 Aluminium casting alloys, non-hardened, > 12 % Si, 130 HB									
N3.1.1 Copper and copper alloys: Free-machining alloy, Pb > 1 %									
N3.1.2 Copper and copper alloys: CuZn, CuSnZn									
N3.1.3 Copper and copper alloys: CuSn, lead-free copper and copper electrolyte									
N4.1.1 Non-metallic materials: Duroplastics, fibre-reinforced plastics									
N4.1.2 Non-metallic materials: Hard rubber, wood, etc.									
N4.1.3 Non-metallic materials: Graphite									
S1.1.1 Heat-resistant alloys, Fe-based, annealed, 200 HB									
S1.1.2 Heat-resistant alloys, Fe-based, hardened, 280 HB									
S1.1.3 Heat-resistant alloys, Ni- or Co-based, annealed, 250 HB									
S1.1.4 Heat-resistant alloys, Ni- or Co-based, hardened, 350 HB									
S1.1.5 Heat-resistant alloys, Ni- or Co-based, cast, 320 HB									
S2.1.1 Titanium alloys, pure titanium, Rm 400 N/mm ²									
S2.1.2 Titanium alloys, Alpha and Beta alloys, hardened, Rm 1050 N/mm ²									
H1.1.1 Hardened steel, hardened and tempered, < 55 HRC									
H1.1.2 Hardened steel, hardened and tempered, < 60 HRC									
H1.1.3 Hardened steel, hardened and tempered, > 60 HRC									
H2.1.1 Chilled cast iron, 400 HB									
H2.1.2 Chilled cast iron, hardened and tempered, < 55 HRC									



Drill head BT 800, with tool holder 12xD



Machining group		f (mm/rev) with nom. Ø							
	v _c (m/min)	10	12	14	16	18	20	22	26
P1.1.1 Unalloyed steel, annealed, 0.15 % C, Rm 420 N/mm ² , 125 HB	115	0.195	0.225	0.255	0.280	0.310	0.335	0.360	0.405
P1.1.2 Unalloyed steel, heat-treated, 0.15 % C, Rm 420 N/mm ² , 125 HB	100	0.175	0.205	0.230	0.255	0.275	0.300	0.320	0.365
P1.1.3 Unalloyed steel, annealed, 0.45 % C, Rm 640 N/mm ² , 190 HB	100	0.175	0.205	0.230	0.255	0.275	0.300	0.320	0.365
P1.1.4 Unalloyed steel, heat-treated, 0.45 % C, Rm 640 N/mm ² , 190 HB	95	0.165	0.190	0.215	0.240	0.260	0.285	0.305	0.345
P1.1.5 Unalloyed steel, heat-treated, 0.45 % C, Rm 850 N/mm ² , 250 HB	95	0.165	0.190	0.215	0.240	0.260	0.285	0.305	0.345
P1.1.6 Unalloyed steel, annealed, 0.75 % C, Rm 915 N/mm ² , 270 HB	90	0.155	0.180	0.205	0.225	0.245	0.265	0.285	0.325
P1.1.7 Unalloyed steel, heat-treated, 0.75 % C, Rm 1020 N/mm ² , 300 HB	85	0.150	0.170	0.190	0.210	0.230	0.250	0.270	0.305
P2.1.1 Low-alloy steel, annealed, Rm 610 N/mm ² , 180 HB	95	0.195	0.225	0.255	0.280	0.310	0.335	0.360	0.405
P2.1.2 Low-alloy steel, heat-treated, Rm 930 N/mm ² , 275 HB	95	0.195	0.225	0.255	0.280	0.310	0.335	0.360	0.405
P2.1.3 Low-alloy steel, heat-treated, Rm 1020 N/mm ² , 300 HB	80	0.165	0.190	0.215	0.240	0.260	0.285	0.305	0.345
P2.1.4 Low-alloy steel, heat-treated, Rm 1190 N/mm ² , 350 HB	70	0.150	0.170	0.190	0.210	0.230	0.250	0.270	0.305
P3.1.1 High-alloy steel and tool steel, annealed, Rm 680 N/mm ² , 200 HB	55	0.155	0.180	0.205	0.225	0.245	0.265	0.285	0.325
P3.1.2 High-alloy steel and tool steel, hardened and tempered, Rm 1100 N/mm ² , 325 HB	45	0.135	0.155	0.175	0.190	0.210	0.225	0.245	0.275
M1.1.1 Stainless steel, ferritic/martensitic, with machining additives	45	0.125	0.145	0.160	0.180	0.195	0.210	0.230	0.260
M1.1.2 Stainless steel, ferritic/martensitic, annealed, Rm 680 N/mm ² , 200 HB	40	0.115	0.130	0.145	0.160	0.175	0.190	0.205	0.235
M1.1.3 Stainless steel, ferritic/martensitic, heat-treated, Rm 810 N/mm ² , 240 HB	40	0.105	0.120	0.140	0.150	0.165	0.180	0.195	0.220
M2.1.1 Stainless steel, austenitic, quenched, 180 HB	35	0.125	0.145	0.160	0.180	0.195	0.210	0.230	0.260
M2.2.1 Duplex steel, high-strength stainless steels	30	0.105	0.120	0.140	0.150	0.165	0.180	0.195	0.220
K1.1.1 Grey cast iron, pearlitic/ferritic, 180 HB	85	0.195	0.225	0.255	0.280	0.310	0.335	0.360	0.405
K1.1.2 Grey cast iron, pearlitic/martensitic, 260 HB	70	0.165	0.190	0.215	0.240	0.260	0.285	0.305	0.345
K1.2.1 Cast iron with spheroidal graphite, ferritic, 160 HB	70	0.165	0.190	0.215	0.240	0.260	0.285	0.305	0.345
K1.2.2 Cast iron with spheroidal graphite, pearlitic, 250 HB	65	0.155	0.180	0.205	0.225	0.245	0.265	0.285	0.325
K1.3.1 Malleable cast iron, ferritic, 130 HB	65	0.155	0.180	0.205	0.225	0.245	0.265	0.285	0.325
K1.3.2 Malleable cast iron, pearlitic, 230 HB	60	0.140	0.160	0.180	0.195	0.215	0.235	0.250	0.285
K2.1.1 Vermicular graphite cast iron (GJV)	65	0.155	0.180	0.205	0.225	0.245	0.265	0.285	0.325
K2.2.1 Austenitic-ferritic spheroidal graphite cast iron (ADI)	50	0.120	0.135	0.150	0.170	0.185	0.200	0.215	0.245
N1.1.1 Wrought aluminium alloys, non-hardened, 60 HB									
N1.1.2 Wrought aluminium alloys, hardened, 100 HB									
N2.1.1 Aluminium casting alloys, non-hardened, ≤ 12 % Si, 75 HB									
N2.1.2 Aluminium casting alloys, hardened, ≤ 12 % Si, 90 HB									
N2.1.3 Aluminium casting alloys, non-hardened, > 12 % Si, 130 HB									
N3.1.1 Copper and copper alloys: Free-machining alloy, Pb > 1 %									
N3.1.2 Copper and copper alloys: CuZn, CuSnZn									
N3.1.3 Copper and copper alloys: CuSn, lead-free copper and copper electrolyte									
N4.1.1 Non-metallic materials: Duroplastics, fibre-reinforced plastics									
N4.1.2 Non-metallic materials: Hard rubber, wood, etc.									
N4.1.3 Non-metallic materials: Graphite									
S1.1.1 Heat-resistant alloys, Fe-based, annealed, 200 HB									
S1.1.2 Heat-resistant alloys, Fe-based, hardened, 280 HB									
S1.1.3 Heat-resistant alloys, Ni- or Co-based, annealed, 250 HB									
S1.1.4 Heat-resistant alloys, Ni- or Co-based, hardened, 350 HB									
S1.1.5 Heat-resistant alloys, Ni- or Co-based, cast, 320 HB									
S2.1.1 Titanium alloys, pure titanium, Rm 400 N/mm ²									
S2.1.2 Titanium alloys, Alpha and Beta alloys, hardened, Rm 1050 N/mm ²									
H1.1.1 Hardened steel, hardened and tempered, < 55 HRC									
H1.1.2 Hardened steel, hardened and tempered, < 60 HRC									
H1.1.3 Hardened steel, hardened and tempered, > 60 HRC									
H2.1.1 Chilled cast iron, 400 HB									
H2.1.2 Chilled cast iron, hardened and tempered, < 55 HRC									



BT 800 bayonet drilling system

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