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The tool specialists for the trade.

THE ART OF
TOOLING

Standard product line MEGA-Speed-Drill

Available immediately as 5xD version:

MEGA-Speed-Drill-Inox
MEGA-Speed-Drill-Iron

MILLER
PRÄZISIONSWERKZEUGE



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The tool specialists for the trade.

MILLER GmbH, Präzisionswerkzeuge in Altenstadt is a member of the „tool-traders-partner“ association and utilises the benefits of this strong community to the benefit of its customers and the quality of its products.

For further information see the last pages in this catalogue or visit us on the Internet at www.tool-traders-partner.com.



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... is the art of bringing together
perfect products and services
for your success under one roof!

MEGA-Speed-Drill



The MEGA-Speed Drill has a completely new cutting edge geometry with unequal spacing and three guiding chamfers. This prevents vibration and reduces friction. The highly polished chip flutes guarantee optimal chip flow. These features, in conjunction with the particularly heat resistant cutting material Mx2, enable the MEGA-Speed-Drill to produce bores with more than twice the cutting speed and up to 30 % higher feeds than is possible with conventional drills. The standard product line covers the diameter range from 3 to 20 mm in drilling depths 3xD, 5xD and 8xD.

Advantages of the MEGA-Speed-Drill

- Up to three times the productivity with approximately the same tool costs
- Save up to half the production costs compared to standard solid carbide drills
- Reliable even with extreme cutting data
- One tool for wet and dry machining
- For universal applications with steel and cast iron

Faster, higher, further!
The high-performance tool for the
most demanding tasks!

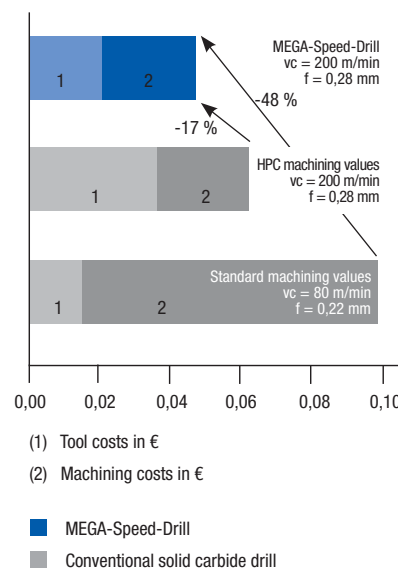
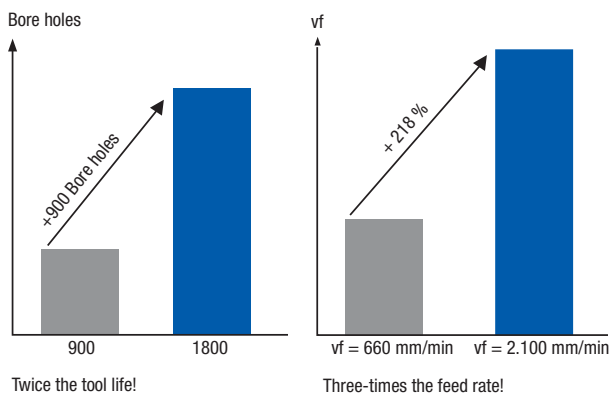
Machining of connecting rods

Machining results:
Material 42CrMo4
Bore 8.5 x 40 mm deep

Comparison:
Costs per bore
(8.5 x 40 mm deep)

With the same feed rate, the MEGA-Speed-Drill achieves twice the tool life. To achieve the tool life of the MEGA-Speed-Drill, the conventional drill must be moved 70 % slower.

Using the MEGA-Speed-Drill the costs compared to the conventional solid carbide drill can be reduced by 48 % (standard machining values) or 17 % (HPC machining values).



The MEGA-Speed-Drill features:
Lower tool costs,
machining time 68 % shorter!

MEGA-Speed-Drill-Inox



The high-performance drill for stainless steel machining from MILLER

Even in machining of rustproof and acid-resistant steels, which is not without its complications, MILLER has once again created the standard of things to come with its tools. The perfect combination of the special 4-facet geometry, high-quality carbide substrate with the latest coating and the patented MEGA-Speed geometry guarantee maximum cutting speeds and feeds with low machine load.

Advantages of the MEGA-Speed-Drill-Inox

- Specially designed for use with all rustproof and acid-resistant steels
- Use of premium carbide substrates and the latest coating for a durable and robust tool
- Special 4-facet geometry for low machine load
- Process reliability, even when maximum cutting data are reached

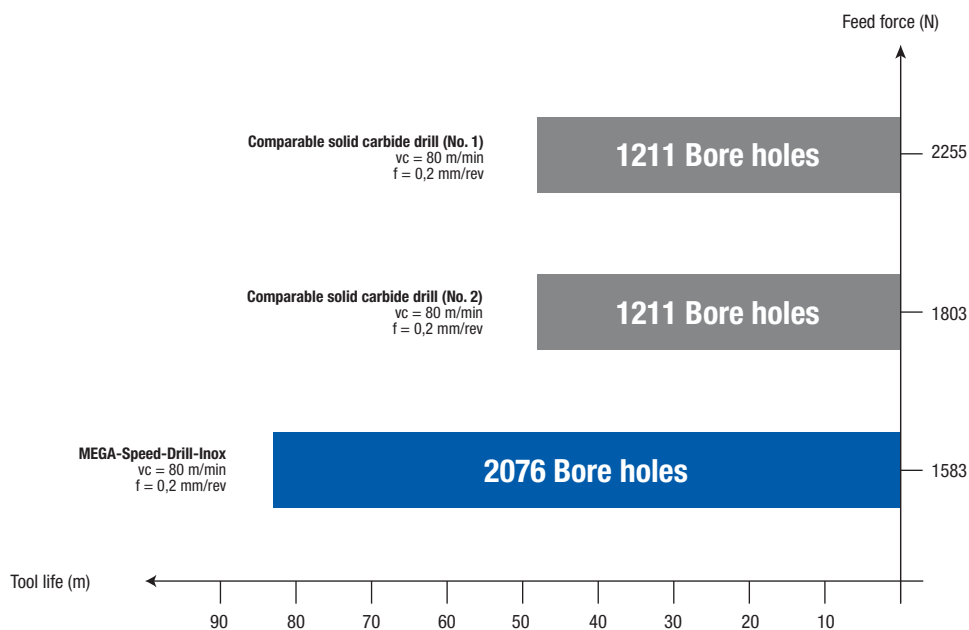
This drill brings out
the true performance capabilities
of your machine!

Stainless steel machining

Material 1.4571 (V4A)

Bore 8,5 x 40 mm

$vc = 80 \text{ m/min}$, $f = 0,2 \text{ mm/rev}$, $vf = 600 \text{ mm/min}$



Up to 30 % less load
ensures 73 % longer tool life!
Convincing arguments?!

MEGA-Speed-Drill-Iron



The high-performance drill for castings machining!

The MEGA-Speed-Drill-Iron is the specialist for castings machining in the new MILLER MEGA-Speed product line. The high-performance drill features an impressive geometry specially developed in-house with extremely stable cutting edges, the latest high-performance coating and the patented MEGA-Speed geometry with unequal spacing and three guiding chamfers. This high-performance combination allows for significantly higher cutting speeds and feed rates.

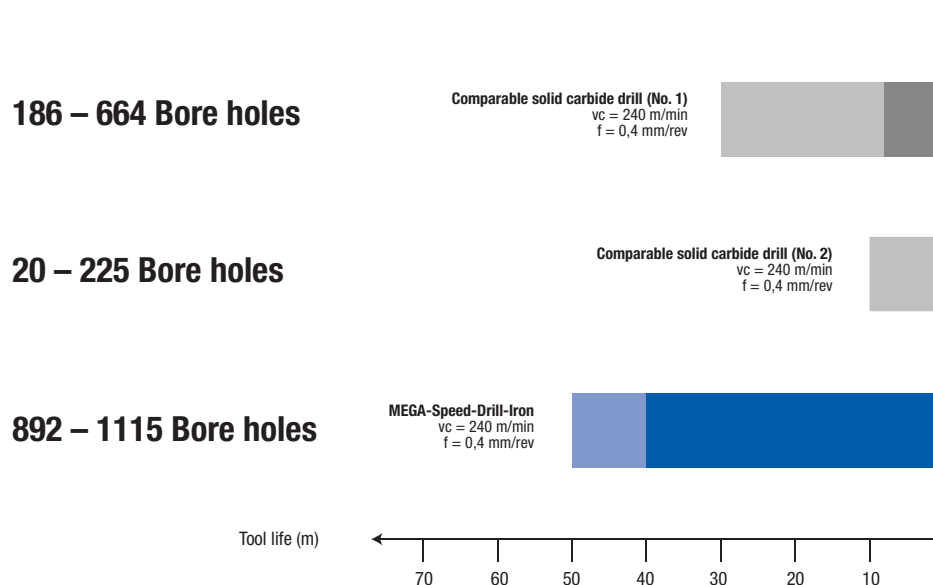
Advantages of the MEGA-Speed-Drill-Iron

- Geometry specially developed in-house with extremely stable cutting edges ensures high resistance
- Insensitive to heat build-up due to the latest high-performance coating
- Fewer vibrations and low friction with patented MEGA-Speed geometry
- Considerably higher feed rates and cutting speeds with reduced feed force

You are machining castings?
Pays for itself after just a short
time in serial production!

Castings machining

Material GG25
Bore 8,5 x 45 mm
 $vc = 240 \text{ m/min}$, $f = 0,4 \text{ mm/rev}$, $vf = 3.600 \text{ mm/min}$



After 1000 bores with
the same drill,
we still deliver premium results!

Explanation of symbols

General symbols:



Cylindrical shank Form HA



Internal coolant supply

Suitability symbols:

Best suitable



Conditionally suitable



Non-alloy steels,
Cast steel, alloyed steels

Inox, stainless and acid-resistant steel (Cr-Ni alloy)

Grey cast iron, alloyed grey cast iron

Spheroidal cast iron, vermicular graphite cast iron, malleable cast iron

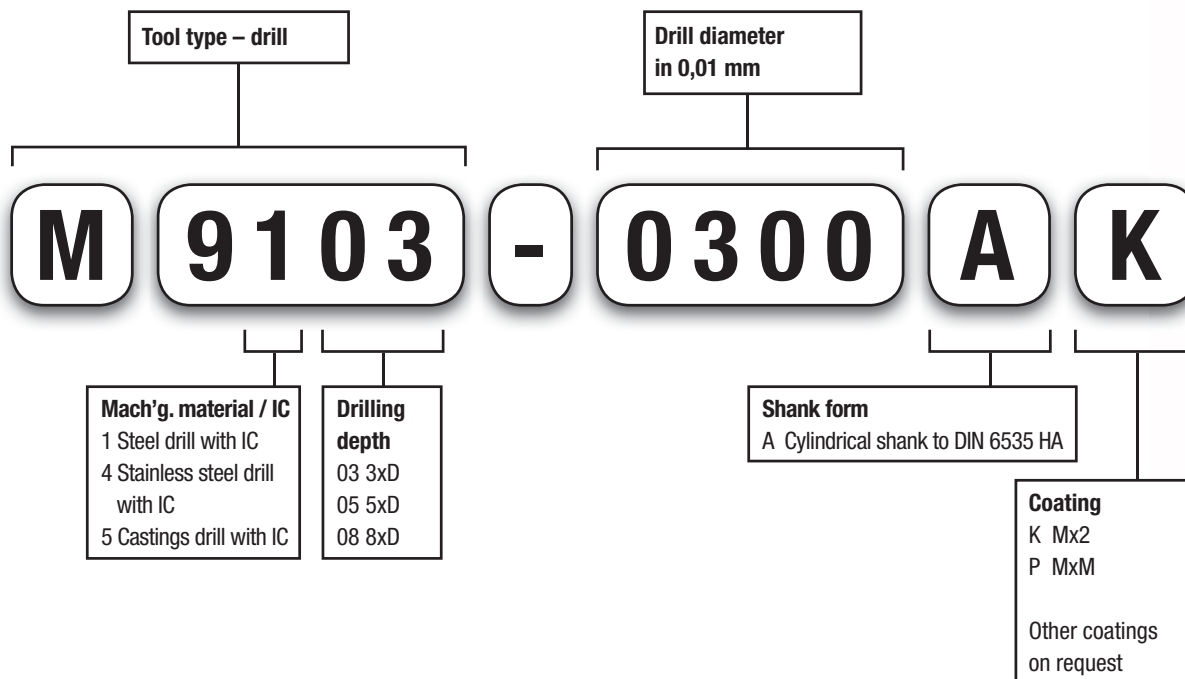
General information regarding the catalogue:

Technical data subject to change.

For corresponding prices surcharges please refer to our currently valid price list.

Our general terms and conditions of business apply.

Technical specification



Explanation of dimensions:

d_1 = Tool diameter

d_2 = Shank diameter

l_1 = Overall tool length

l_2 = Length of flute

l_3 = Maximum drilling depth

l_4 = Shank length

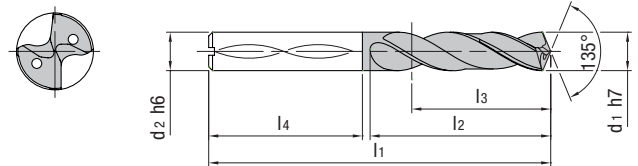
MEGA-Speed-Drill / M9103 (3xD)

Solid carbide twist drill, internal coolant supply



Design:

Drill diameter:	3,00 – 20,00 mm
Bore tolerance:	IT 10 (achievable)
Shank form:	HA
Coating:	Mx2
Number of cutting edges:	2
Number of margins:	3
Point geometry:	Specific point geometry
Point angle:	135°
Helix:	30°



Dimensions						Shank form HA		
d1 h7	d2 h6	l1	l2	l3	l4	Order designation	Order No.	Stock
3,00	6	62	20	14	36	M9103-0300AK	30265089	●
3,10	6	62	20	14	36	M9103-0310AK	30265090	○
3,20	6	62	20	14	36	M9103-0320AK	30265091	○
3,30	6	62	20	14	36	M9103-0330AK	30265092	●
3,40	6	62	20	14	36	M9103-0340AK	30265093	●
3,50	6	62	20	14	36	M9103-0350AK	30265094	●
3,60	6	62	20	14	36	M9103-0360AK	30265095	○
3,70	6	62	20	14	36	M9103-0370AK	30265096	●
3,80	6	66	24	17	36	M9103-0380AK	30265097	●
3,90	6	66	24	17	36	M9103-0390AK	30265098	●
4,00	6	66	24	17	36	M9103-0400AK	30265099	●
4,10	6	66	24	17	36	M9103-0410AK	30265100	○
4,20	6	66	24	17	36	M9103-0420AK	30265101	●
4,30	6	66	24	17	36	M9103-0430AK	30265102	○
4,40	6	66	24	17	36	M9103-0440AK	30265103	○
4,50	6	66	24	17	36	M9103-0450AK	30265104	●
4,60	6	66	24	17	36	M9103-0460AK	30265105	●
4,65	6	66	24	17	36	M9103-0465AK	30265106	○
4,70	6	66	24	17	36	M9103-0470AK	30265107	●
4,80	6	66	28	20	36	M9103-0480AK	30265108	○
4,90	6	66	28	20	36	M9103-0490AK	30265109	○
5,00	6	66	28	20	36	M9103-0500AK	30265110	●
5,10	6	66	28	20	36	M9103-0510AK	30265111	●
5,20	6	66	28	20	36	M9103-0520AK	30265112	○
5,30	6	66	28	20	36	M9103-0530AK	30265113	○
5,40	6	66	28	20	36	M9103-0540AK	30265114	●
5,50	6	66	28	20	36	M9103-0550AK	30265115	●
5,55	6	66	28	20	36	M9103-0555AK	30265116	●
5,60	6	66	28	20	36	M9103-0560AK	30265117	○
5,70	6	66	28	20	36	M9103-0570AK	30265118	○
5,80	6	66	28	20	36	M9103-0580AK	30265119	○
5,90	6	66	28	20	36	M9103-0590AK	30265120	○
6,00	6	66	28	20	36	M9103-0600AK	30265121	●
6,10	8	79	34	24	36	M9103-0610AK	30265122	○

Dimensions in mm.

For machining values see the end of the catalogue.

Information on special designs and other coatings available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill / M9103 (3xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
6,20	8	79	34	24	36	M9103-0620AK	30265123	○
6,30	8	79	34	24	36	M9103-0630AK	30265124	○
6,40	8	79	34	24	36	M9103-0640AK	30265125	○
6,50	8	79	34	24	36	M9103-0650AK	30265126	●
6,60	8	79	34	24	36	M9103-0660AK	30265127	●
6,70	8	79	34	24	36	M9103-0670AK	30265128	○
6,80	8	79	34	24	36	M9103-0680AK	30265129	●
6,90	8	79	34	24	36	M9103-0690AK	30265130	○
7,00	8	79	34	24	36	M9103-0700AK	30265131	●
7,10	8	79	41	29	36	M9103-0710AK	30265132	○
7,20	8	79	41	29	36	M9103-0720AK	30265133	○
7,30	8	79	41	29	36	M9103-0730AK	30265134	○
7,40	8	79	41	29	36	M9103-0740AK	30265135	●
7,50	8	79	41	29	36	M9103-0750AK	30265136	●
7,60	8	79	41	29	36	M9103-0760AK	30265137	○
7,70	8	79	41	29	36	M9103-0770AK	30265138	○
7,80	8	79	41	29	36	M9103-0780AK	30265139	○
7,90	8	79	41	29	36	M9103-0790AK	30265140	○
8,00	8	79	41	29	36	M9103-0800AK	30265141	●
8,10	10	89	47	35	40	M9103-0810AK	30265142	●
8,20	10	89	47	35	40	M9103-0820AK	30265143	○
8,30	10	89	47	35	40	M9103-0830AK	30265144	○
8,40	10	89	47	35	40	M9103-0840AK	30261134	○
8,50	10	89	47	35	40	M9103-0850AK	30265146	●
8,60	10	89	47	35	40	M9103-0860AK	30265147	●
8,70	10	89	47	35	40	M9103-0870AK	30265148	○
8,80	10	89	47	35	40	M9103-0880AK	30265149	●
8,90	10	89	47	35	40	M9103-0890AK	30265150	○
9,00	10	89	47	35	40	M9103-0900AK	30265151	●
9,10	10	89	47	35	40	M9103-0910AK	30265152	○
9,20	10	89	47	35	40	M9103-0920AK	30265153	○
9,30	10	89	47	35	40	M9103-0930AK	30265154	○
9,40	10	89	47	35	40	M9103-0940AK	30265155	○
9,50	10	89	47	35	40	M9103-0950AK	30265156	●
9,60	10	89	47	35	40	M9103-0960AK	30265157	○
9,70	10	89	47	35	40	M9103-0970AK	30265158	●
9,80	10	89	47	35	40	M9103-0980AK	30265159	○
9,90	10	89	47	35	40	M9103-0990AK	30265160	○
10,00	10	89	47	35	40	M9103-1000AK	30265161	●
10,10	12	102	55	40	45	M9103-1010AK	30265162	○
10,20	12	102	55	40	45	M9103-1020AK	30265163	●
10,30	12	102	55	40	45	M9103-1030AK	30265164	○
10,40	12	102	55	40	45	M9103-1040AK	30265165	○
10,50	12	102	55	40	45	M9103-1050AK	30265166	●
10,60	12	102	55	40	45	M9103-1060AK	30265167	○
10,70	12	102	55	40	45	M9103-1070AK	30265168	○
10,80	12	102	55	40	45	M9103-1080AK	30265169	○
10,90	12	102	55	40	45	M9103-1090AK	30265170	○
11,00	12	102	55	40	45	M9103-1100AK	30265171	●
11,10	12	102	55	40	45	M9103-1110AK	30265172	○

Dimensions in mm.

For machining values see the end of the catalogue.

 Information on special designs and other coatings
 available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill / M9103 (3xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order model	Order No.	Stock
11,20	12	102	55	40	45	M9103-1120AK	30265173	○
11,30	12	102	55	40	45	M9103-1130AK	30265174	○
11,40	12	102	55	40	45	M9103-1140AK	30265175	○
11,50	12	102	55	40	45	M9103-1150AK	30265176	●
11,60	12	102	55	40	45	M9103-1160AK	30265177	○
11,70	12	102	55	40	45	M9103-1170AK	30265178	○
11,80	12	102	55	40	45	M9103-1180AK	30265179	●
11,90	12	102	55	40	45	M9103-1190AK	30265180	○
12,00	12	102	55	40	45	M9103-1200AK	30265181	●
12,50	14	107	60	43	45	M9103-1250AK	30265182	●
12,80	14	107	60	43	45	M9103-1280AK	30265183	○
13,00	14	107	60	43	45	M9103-1300AK	30265184	●
13,50	14	107	60	43	45	M9103-1350AK	30265185	●
13,80	14	107	60	43	45	M9103-1380AK	30265186	○
14,00	14	107	60	43	45	M9103-1400AK	30265187	●
14,50	16	115	65	45	48	M9103-1450AK	30265188	●
14,80	16	115	65	45	48	M9103-1480AK	30265189	○
15,00	16	115	65	45	48	M9103-1500AK	30265190	●
15,50	16	115	65	45	48	M9103-1550AK	30265191	○
15,80	16	115	65	45	48	M9103-1580AK	30265192	○
16,00	16	115	65	45	48	M9103-1600AK	30265193	●
16,50	18	123	73	51	48	M9103-1650AK	30265194	○
16,80	18	123	73	51	48	M9103-1680AK	30265195	○
17,00	18	123	73	51	48	M9103-1700AK	30265196	●
17,50	18	123	73	51	48	M9103-1750AK	30265197	○
17,80	18	123	73	51	48	M9103-1780AK	30265198	○
18,00	18	123	73	51	48	M9103-1800AK	30265199	●
18,50	20	131	79	55	50	M9103-1850AK	30265200	○
18,80	20	131	79	55	50	M9103-1880AK	30265201	○
19,00	20	131	79	55	50	M9103-1900AK	30265202	●
19,50	20	131	79	55	50	M9103-1950AK	30265203	○
19,80	20	131	79	55	50	M9103-1980AK	30265204	○
20,00	20	131	79	55	50	M9103-2000AK	30265205	●

All dimensions in mm.

For machining values see the end of the catalogue.

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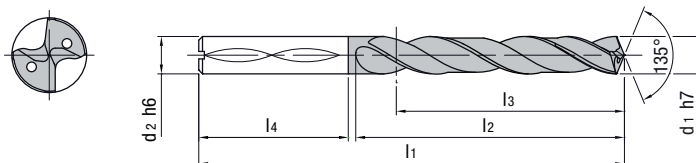
○ Not on stock (delivery time on request).

MEGA-Speed-Drill / M9105 (5xD)

Solid carbide twist drill, internal coolant supply


Design:

Bore diameter:	3,00 – 20,00 mm
Bore tolerance:	IT 10 (achievable)
Shank form:	HA
Coating:	Mx2
Number of cutting edges:	2
Number of margins:	3
Point geometry:	Specific point geometry
Point angle:	135°
Helix:	30°



Dimensions						Shank form HA		
d1 h7	d2 h6	l1	l2	l3	l4	Order designation	Order No.	Stock
3,00	6	66	28	23	36	M9105-0300AK	30260858	●
3,10	6	66	28	23	36	M9105-0310AK	30260859	○
3,20	6	66	28	23	36	M9105-0320AK	30260860	○
3,30	6	66	28	23	36	M9105-0330AK	30260861	●
3,40	6	66	28	23	36	M9105-0340AK	30260862	●
3,50	6	66	28	23	36	M9105-0350AK	30260863	●
3,60	6	66	28	23	36	M9105-0360AK	30260864	○
3,70	6	66	28	23	36	M9105-0370AK	30260865	●
3,80	6	74	36	29	36	M9105-0380AK	30260866	●
3,90	6	74	36	29	36	M9105-0390AK	30260867	●
4,00	6	74	36	29	36	M9105-0400AK	30260868	●
4,10	6	74	36	29	36	M9105-0410AK	30260869	○
4,20	6	74	36	29	36	M9105-0420AK	30260870	●
4,30	6	74	36	29	36	M9105-0430AK	30260871	○
4,40	6	74	36	29	36	M9105-0440AK	30260872	●
4,50	6	74	36	29	36	M9105-0450AK	30260873	●
4,60	6	74	36	29	36	M9105-0460AK	30260874	●
4,65	6	74	36	29	36	M9105-0465AK	30260875	○
4,70	6	74	36	29	36	M9105-0470AK	30260876	●
4,80	6	82	44	35	36	M9105-0480AK	30260877	●
4,90	6	82	44	35	36	M9105-0490AK	30260878	●
5,00	6	82	44	35	36	M9105-0500AK	30260879	●
5,10	6	82	44	35	36	M9105-0510AK	30260880	●
5,20	6	82	44	35	36	M9105-0520AK	30260881	●
5,30	6	82	44	35	36	M9105-0530AK	30260882	○
5,40	6	82	44	35	36	M9105-0540AK	30260883	●
5,50	6	82	44	35	36	M9105-0550AK	30260884	●
5,55	6	82	44	35	36	M9105-0555AK	30260885	●
5,60	6	82	44	35	36	M9105-0560AK	30260886	●
5,70	6	82	44	35	36	M9105-0570AK	30260887	○
5,80	6	82	44	35	36	M9105-0580AK	30260888	●
5,90	6	82	44	35	36	M9105-0590AK	30260889	○
6,00	6	82	44	35	36	M9105-0600AK	30260890	●
6,10	8	91	53	43	36	M9105-0610AK	30260891	●

Dimensions in mm.

For machining values see the end of the catalogue.

 Information on special designs and other coatings
 available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill / M9105 (5xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
6,20	8	91	53	43	36	M9105-0620AK	30260892	●
6,30	8	91	53	43	36	M9105-0630AK	30260893	○
6,40	8	91	53	43	36	M9105-0640AK	30260894	○
6,50	8	91	53	43	36	M9105-0650AK	30260895	●
6,60	8	91	53	43	36	M9105-0660AK	30260896	●
6,70	8	91	53	43	36	M9105-0670AK	30260897	○
6,80	8	91	53	43	36	M9105-0680AK	30260898	●
6,90	8	91	53	43	36	M9105-0690AK	30260899	●
7,00	8	91	53	43	36	M9105-0700AK	30260900	●
7,10	8	91	53	43	36	M9105-0710AK	30261186	○
7,20	8	91	53	43	36	M9105-0720AK	30260901	●
7,30	8	91	53	43	36	M9105-0730AK	30260902	○
7,40	8	91	53	43	36	M9105-0740AK	30260903	●
7,50	8	91	53	43	36	M9105-0750AK	30260904	●
7,60	8	91	53	43	36	M9105-0760AK	30261187	○
7,70	8	91	53	43	36	M9105-0770AK	30260905	●
7,80	8	91	53	43	36	M9105-0780AK	30260906	●
7,90	8	91	53	43	36	M9105-0790AK	30260907	○
8,00	8	91	53	43	36	M9105-0800AK	30260908	●
8,10	10	103	61	49	40	M9105-0810AK	30260909	●
8,20	10	103	61	49	40	M9105-0820AK	30260910	●
8,30	10	103	61	49	40	M9105-0830AK	30260911	○
8,40	10	103	61	49	40	M9105-0840AK	30260912	●
8,50	10	103	61	49	40	M9105-0850AK	30260913	●
8,60	10	103	61	49	40	M9105-0860AK	30260914	●
8,70	10	103	61	49	40	M9105-0870AK	30260915	●
8,80	10	103	61	49	40	M9105-0880AK	30260916	●
8,90	10	103	61	49	40	M9105-0890AK	30261188	○
9,00	10	103	61	49	40	M9105-0900AK	30260917	●
9,10	10	103	61	49	40	M9105-0910AK	30261190	○
9,20	10	103	61	49	40	M9105-0920AK	30261191	○
9,30	10	103	61	49	40	M9105-0930AK	30260918	●
9,40	10	103	61	49	40	M9105-0940AK	30260919	●
9,50	10	103	61	49	40	M9105-0950AK	30260920	○
9,60	10	103	61	49	40	M9105-0960AK	30260921	○
9,70	10	103	61	49	40	M9105-0970AK	30260922	●
9,80	10	103	61	49	40	M9105-0980AK	30260923	●
9,90	10	103	61	49	40	M9105-0990AK	30260924	○
10,00	10	103	61	49	40	M9105-1000AK	30260925	●
10,10	12	118	71	56	45	M9105-1010AK	30260926	●
10,20	12	118	71	56	45	M9105-1020AK	30260927	●
10,30	12	118	71	56	45	M9105-1030AK	30260928	●
10,40	12	118	71	56	45	M9105-1040AK	30260929	○
10,50	12	118	71	56	45	M9105-1050AK	30260930	●
10,60	12	118	71	56	45	M9105-1060AK	30260931	○
10,70	12	118	71	56	45	M9105-1070AK	30260968	●
10,80	12	118	71	56	45	M9105-1080AK	30260933	○
10,90	12	118	71	56	45	M9105-1090AK	30261192	○
11,00	12	118	71	56	45	M9105-1100AK	30260934	●
11,10	12	118	71	56	45	M9105-1110AK	30260969	○

Dimensions in mm.

For machining values see the end of the catalogue.

Information on special designs and other coatings
available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill / M9105 (5xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
11,20	12	118	71	56	45	M9105-1120AK	30260936	●
11,30	12	118	71	56	45	M9105-1130AK	30261193	○
11,40	12	118	71	56	45	M9105-1140AK	30261194	○
11,50	12	118	71	56	45	M9105-1150AK	30260937	○
11,60	12	118	71	56	45	M9105-1160AK	30260938	○
11,70	12	118	71	56	45	M9105-1170AK	30260939	○
11,80	12	118	71	56	45	M9105-1180AK	30260940	●
11,90	12	118	71	56	45	M9105-1190AK	30261195	○
12,00	12	118	71	56	45	M9105-1200AK	30260941	●
12,50	14	124	77	60	45	M9105-1250AK	30260942	●
12,80	14	124	77	60	45	M9105-1280AK	30260943	○
13,00	14	124	77	60	45	M9105-1300AK	30260944	●
13,50	14	124	77	60	45	M9105-1350AK	30260945	●
13,80	14	124	77	60	45	M9105-1380AK	30260946	○
14,00	14	124	77	60	45	M9105-1400AK	30260947	●
14,50	16	133	83	63	48	M9105-1450AK	30260948	●
14,80	16	133	83	63	48	M9105-1480AK	30260949	○
15,00	16	133	83	63	48	M9105-1500AK	30260950	○
15,50	16	133	83	63	48	M9105-1550AK	30260951	○
15,80	16	133	83	63	48	M9105-1580AK	30260952	○
16,00	16	133	83	63	48	M9105-1600AK	30260953	●
16,50	18	143	93	71	48	M9105-1650AK	30260954	○
16,80	18	143	93	71	48	M9105-1680AK	30261196	○
17,00	18	143	93	71	48	M9105-1700AK	30260955	●
17,50	18	143	93	71	48	M9105-1750AK	30260956	○
17,80	18	143	93	71	48	M9105-1780AK	30261197	○
18,00	18	143	93	71	48	M9105-1800AK	30260957	○
18,50	20	153	101	77	50	M9105-1850AK	30261198	○
18,80	20	153	101	77	50	M9105-1880AK	30261199	○
19,00	20	153	101	77	50	M9105-1900AK	30260958	○
19,50	20	153	101	77	50	M9105-1950AK	30261200	○
19,80	20	153	101	77	50	M9105-1980AK	30261201	○
20,00	20	153	101	77	50	M9105-2000AK	30260959	○

Dimensions in mm.

For machining values see the end of the catalogue.

Information on special designs and other coatings
available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

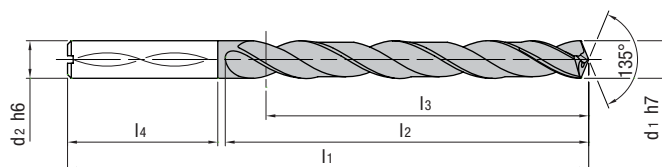
MEGA-Speed-Drill / M9108 (8xD)

Solid carbide twist drill, internal coolant supply



Design:

Drill diameter:	3,00 – 20,00 mm
bore tolerance:	IT 10 (Achievable)
Shank form:	HA
Coating:	Mx2
Number of cutting edges:	2
Number of margins:	3
Point geometry:	Specific point geometry
Point angle:	135°
Helix:	30°



Dimensions						Shank form HA		
d1 h7	d2 h6	l1	l2	l3	l4	Order designation	Order No.	Stock
3,00	6	72	34	29	36	M9108-0300AK	30265206	●
3,10	6	72	34	29	36	M9108-0310AK	30265207	○
3,20	6	72	34	29	36	M9108-0320AK	30265208	○
3,30	6	72	34	29	36	M9108-0330AK	30265209	○
3,40	6	72	34	29	36	M9108-0340AK	30265210	○
3,50	6	72	34	29	36	M9108-0350AK	30265211	●
3,60	6	72	34	29	36	M9108-0360AK	30265212	○
3,70	6	72	34	29	36	M9108-0370AK	30265213	●
3,80	6	81	43	36	36	M9108-0380AK	30265214	●
3,90	6	81	43	36	36	M9108-0390AK	30265215	●
4,00	6	81	43	36	36	M9108-0400AK	30265216	●
4,10	6	81	43	36	36	M9108-0410AK	30265217	○
4,20	6	81	43	36	36	M9108-0420AK	30265218	●
4,30	6	81	43	36	36	M9108-0430AK	30265219	○
4,40	6	81	43	36	36	M9108-0440AK	30265220	○
4,50	6	81	43	36	36	M9108-0450AK	30265221	●
4,60	6	81	43	36	36	M9108-0460AK	30265222	●
4,65	6	81	43	36	36	M9108-0465AK	30265223	○
4,70	6	81	43	36	36	M9108-0470AK	30265224	○
4,80	6	95	57	48	36	M9108-0480AK	30265225	○
4,90	6	95	57	48	36	M9108-0490AK	30265226	○
5,00	6	95	57	48	36	M9108-0500AK	30265227	●
5,10	6	95	57	48	36	M9108-0510AK	30265228	●
5,20	6	95	57	48	36	M9108-0520AK	30265229	○
5,30	6	95	57	48	36	M9108-0530AK	30265230	●
5,40	6	95	57	48	36	M9108-0540AK	30265231	●
5,50	6	95	57	48	36	M9108-0550AK	30265232	●
5,55	6	95	57	48	36	M9108-0555AK	30265233	●
5,60	6	95	57	48	36	M9108-0560AK	30265234	○
5,70	6	95	57	48	36	M9108-0570AK	30265235	●
5,80	6	95	57	48	36	M9108-0580AK	30265236	○
5,90	6	95	57	48	36	M9108-0590AK	30265237	●
6,00	6	95	57	48	36	M9108-0600AK	30265238	●
6,10	8	114	76	64	36	M9108-0610AK	30265239	○

Dimensions in mm.

For machining values see the end of the catalogue.

Information on special designs and other coatings available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill / M9108 (8xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
6,20	8	114	76	64	36	M9108-0620AK	30265240	○
6,30	8	114	76	64	36	M9108-0630AK	30265241	○
6,40	8	114	76	64	36	M9108-0640AK	30265242	○
6,50	8	114	76	64	36	M9108-0650AK	30265243	●
6,60	8	114	76	64	36	M9108-0660AK	30265244	●
6,70	8	114	76	64	36	M9108-0670AK	30265245	○
6,80	8	114	76	64	36	M9108-0680AK	30265246	●
6,90	8	114	76	64	36	M9108-0690AK	30265247	○
7,00	8	114	76	64	36	M9108-0700AK	30265248	●
7,10	8	114	76	64	36	M9108-0710AK	30265249	○
7,20	8	114	76	64	36	M9108-0720AK	30265250	○
7,30	8	114	76	64	36	M9108-0730AK	30265251	○
7,40	8	114	76	64	36	M9108-0740AK	30265252	●
7,50	8	114	76	64	36	M9108-0750AK	30265253	●
7,60	8	114	76	64	36	M9108-0760AK	30265254	○
7,70	8	114	76	64	36	M9108-0770AK	30265255	●
7,80	8	114	76	64	36	M9108-0780AK	30265256	○
7,90	8	114	76	64	36	M9108-0790AK	30265257	○
8,00	8	114	76	64	36	M9108-0800AK	30265258	●
8,10	10	142	95	80	40	M9108-0810AK	30265259	●
8,20	10	142	95	80	40	M9108-0820AK	30265260	○
8,30	10	142	95	80	40	M9108-0830AK	30265261	○
8,40	10	142	95	80	40	M9108-0840AK	30265262	○
8,50	10	142	95	80	40	M9108-0850AK	30265263	●
8,60	10	142	95	80	40	M9108-0860AK	30265264	●
8,70	10	142	95	80	40	M9108-0870AK	30265265	○
8,80	10	142	95	80	40	M9108-0880AK	30265266	●
8,90	10	142	95	80	40	M9108-0890AK	30265267	○
9,00	10	142	95	80	40	M9108-0900AK	30265268	●
9,10	10	142	95	80	40	M9108-0910AK	30265269	○
9,20	10	142	95	80	40	M9108-0920AK	30265270	○
9,30	10	142	95	80	40	M9108-0930AK	30265271	○
9,40	10	142	95	80	40	M9108-0940AK	30265272	○
9,50	10	142	95	80	40	M9108-0950AK	30265273	○
9,60	10	142	95	80	40	M9108-0960AK	30265274	○
9,70	10	142	95	80	40	M9108-0970AK	30265275	●
9,80	10	142	95	80	40	M9108-0980AK	30265276	●
9,90	10	142	95	80	40	M9108-0990AK	30265277	○
10,00	10	142	95	80	40	M9108-1000AK	30265278	●
10,10	12	162	114	96	45	M9108-1010AK	30265279	○
10,20	12	162	114	96	45	M9108-1020AK	30265280	●
10,30	12	162	114	95	45	M9108-1030AK	30265281	○
10,40	12	162	114	96	45	M9108-1040AK	30265282	○
10,50	12	162	114	96	45	M9108-1050AK	30265283	●
10,60	12	162	114	96	45	M9108-1060AK	30265284	○
10,70	12	162	114	96	45	M9108-1070AK	30265285	●
10,80	12	162	114	96	45	M9108-1080AK	30265286	○
10,90	12	162	114	96	45	M9108-1090AK	30265287	○
11,00	12	162	114	96	45	M9108-1100AK	30265288	●
11,10	12	162	114	96	45	M9108-1110AK	30265289	○

All dimensions in mm.

For machining values see the end of the catalogue.

Information on special designs and other coatings
available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill / M9108 (8xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
11,20	12	162	114	96	45	M9108-1120AK	30265290	○
11,30	12	162	114	96	45	M9108-1130AK	30265291	●
11,40	12	162	114	96	45	M9108-1140AK	30265292	○
11,50	12	162	114	96	45	M9108-1150AK	30265293	○
11,60	12	162	114	96	45	M9108-1160AK	30265294	○
11,70	12	162	114	96	45	M9108-1170AK	30265295	○
11,80	12	162	114	96	45	M9108-1180AK	30265296	●
11,90	12	162	114	96	45	M9108-1190AK	30265297	○
12,00	12	162	114	96	45	M9108-1200AK	30265298	●
12,50	14	178	133	112	45	M9108-1250AK	30265299	●
12,80	14	178	133	112	45	M9108-1280AK	30265300	○
13,00	14	178	133	112	45	M9108-1300AK	30265301	●
13,50	14	178	133	112	45	M9108-1350AK	30265302	●
13,80	14	178	133	112	45	M9108-1380AK	30265303	○
14,00	14	178	133	112	45	M9108-1400AK	30265304	●
14,50	16	203	152	128	48	M9108-1450AK	30265305	○
14,80	16	203	152	128	48	M9108-1480AK	30265306	○
15,00	16	203	152	128	48	M9108-1500AK	30265307	●
15,50	16	203	152	128	48	M9108-1550AK	30265308	○
15,80	16	203	152	128	48	M9108-1580AK	30265309	○
16,00	16	203	152	128	48	M9108-1600AK	30265310	●
16,50	18	222	171	144	48	M9108-1650AK	30265311	○
16,80	18	222	171	144	48	M9108-1680AK	30265312	○
17,00	18	222	171	144	48	M9108-1700AK	30265313	●
17,50	18	222	171	144	48	M9108-1750AK	30265314	○
17,80	18	222	171	144	48	M9108-1780AK	30265315	○
18,00	18	222	171	144	48	M9108-1800AK	30265316	●
18,50	20	243	190	160	50	M9108-1850AK	30265317	○
18,80	20	243	190	160	50	M9108-1880AK	30265318	○
19,00	20	243	190	160	50	M9108-1900AK	30265319	●
19,50	20	243	190	160	50	M9108-1950AK	30265320	○
19,80	20	243	190	160	50	M9108-1980AK	30265321	○
20,00	20	243	190	160	50	M9108-2000AK	30265322	●

Dimensions in mm.

For machining values see the end of the catalogue.

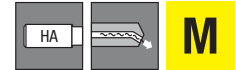
Information on special designs and other coatings
available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

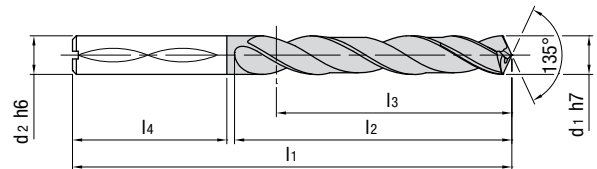
MEGA-Speed-Drill-Inox / M9405 (5xD)

Solid carbide twist drill, internal coolant supply



Design:

Drill diameter:	3,00 – 20,00 mm
Bore tolerance:	IT 10 (achievable)
Shank form:	HA
Coating:	Mx2
Number of cutting edges:	2
Number of margins:	3
Point geometry:	Specific point geometry
Point angle:	135°
Helix:	30°



Dimensions						Shank form HA		
d1 h7	d2 h6	l1	l2	l3	l4	Order designation	Order No.	Stock
3,00	6	66	28	23	36	M9405-0300AK	30484078	●
3,10	6	66	28	23	36	M9405-0310AK	30484079	○
3,20	6	66	28	23	36	M9405-0320AK	30484080	●
3,30	6	66	28	23	36	M9405-0330AK	30484081	●
3,40	6	66	28	23	36	M9405-0340AK	30484082	●
3,50	6	66	28	23	36	M9405-0350AK	30484083	●
3,60	6	66	28	23	36	M9405-0360AK	30484084	●
3,70	6	66	28	23	36	M9405-0370AK	30484085	●
3,80	6	74	36	29	36	M9405-0380AK	30484086	●
3,90	6	74	36	29	36	M9405-0390AK	30484087	●
4,00	6	74	36	29	36	M9405-0400AK	30484088	●
4,10	6	74	36	29	36	M9405-0410AK	30484089	●
4,20	6	74	36	29	36	M9405-0420AK	30484090	●
4,30	6	74	36	29	36	M9405-0430AK	30484091	●
4,40	6	74	36	29	36	M9405-0440AK	30484092	●
4,50	6	74	36	29	36	M9405-0450AK	30484093	●
4,60	6	74	36	29	36	M9405-0460AK	30484094	●
4,65	6	74	36	29	36	M9405-0465AK	30484095	●
4,70	6	74	36	29	36	M9405-0470AK	30484096	●
4,80	6	82	44	35	36	M9405-0480AK	30484097	●
4,90	6	82	44	35	36	M9405-0490AK	30484098	●
5,00	6	82	44	35	36	M9405-0500AK	30484099	●
5,10	6	82	44	35	36	M9405-0510AK	30484100	●
5,20	6	82	44	35	36	M9405-0520AK	30484101	●
5,30	6	82	44	35	36	M9405-0530AK	30484102	●
5,40	6	82	44	35	36	M9405-0540AK	30484103	○
5,50	6	82	44	35	36	M9405-0550AK	30484104	●
5,55	6	82	44	35	36	M9405-0555AK	30484105	○
5,60	6	82	44	35	36	M9405-0560AK	30484106	●
5,70	6	82	44	35	36	M9405-0570AK	30484107	○
5,80	6	82	44	35	36	M9405-0580AK	30484108	●
5,90	6	82	44	35	36	M9405-0590AK	30484110	●
6,00	6	82	44	35	36	M9405-0600AK	30484111	●
6,10	8	91	53	43	36	M9405-0610AK	30484112	●

Dimensions in mm.

For machining values see the end of the catalogue.

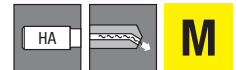
Information on special designs and other coatings
available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill-Inox / M9405 (5xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
6,20	8	91	53	43	36	M9405-0620AK	30484113	●
6,30	8	91	53	43	36	M9405-0630AK	30484114	●
6,40	8	91	53	43	36	M9405-0640AK	30484115	○
6,50	8	91	53	43	36	M9405-0650AK	30484116	●
6,60	8	91	53	43	36	M9405-0660AK	30484117	●
6,70	8	91	53	43	36	M9405-0670AK	30484118	○
6,80	8	91	53	43	36	M9405-0680AK	30484119	●
6,90	8	91	53	43	36	M9405-0690AK	30484120	●
7,00	8	91	53	43	36	M9405-0700AK	30484121	●
7,10	8	91	53	43	36	M9405-0710AK	30484122	○
7,20	8	91	53	43	36	M9405-0720AK	30484123	○
7,30	8	91	53	43	36	M9405-0730AK	30484124	○
7,40	8	91	53	43	36	M9405-0740AK	30484125	●
7,50	8	91	53	43	36	M9405-0750AK	30484126	●
7,60	8	91	53	43	36	M9405-0760AK	30484127	○
7,70	8	91	53	43	36	M9405-0770AK	30484128	○
7,80	8	91	53	43	36	M9405-0780AK	30484129	●
7,90	8	91	53	43	36	M9405-0790AK	30484130	○
8,00	8	91	53	43	36	M9405-0800AK	30484131	●
8,10	10	103	61	49	40	M9405-0810AK	30484132	●
8,20	10	103	61	49	40	M9405-0820AK	30484133	●
8,30	10	103	61	49	40	M9405-0830AK	30484134	○
8,40	10	103	61	49	40	M9405-0840AK	30484135	○
8,50	10	103	61	49	40	M9405-0850AK	30484136	●
8,60	10	103	61	49	40	M9405-0860AK	30484137	●
8,70	10	103	61	49	40	M9405-0870AK	30484138	○
8,80	10	103	61	49	40	M9405-0880AK	30484139	●
8,90	10	103	61	49	40	M9405-0890AK	30484140	○
9,00	10	103	61	49	40	M9405-0900AK	30484141	●
9,10	10	103	61	49	40	M9405-0910AK	30484142	○
9,20	10	103	61	49	40	M9405-0920AK	30484143	○
9,30	10	103	61	49	40	M9405-0930AK	30484144	●
9,40	10	103	61	49	40	M9405-0940AK	30484145	●
9,50	10	103	61	49	40	M9405-0950AK	30484146	●
9,60	10	103	61	49	40	M9405-0960AK	30484147	○
9,70	10	103	61	49	40	M9405-0970AK	30484148	○
9,80	10	103	61	49	40	M9405-0980AK	30484149	●
9,90	10	103	61	49	40	M9405-0990AK	30484150	○
10,00	10	103	61	49	40	M9405-1000AK	30484151	●
10,10	12	118	71	56	45	M9405-1010AK	30484152	●
10,20	12	118	71	56	45	M9405-1020AK	30484153	●
10,30	12	118	71	56	45	M9405-1030AK	30484154	●
10,40	12	118	71	56	45	M9405-1040AK	30484155	○
10,50	12	118	71	56	45	M9405-1050AK	30484156	●
10,60	12	118	71	56	45	M9405-1060AK	30484157	○
10,70	12	118	71	56	45	M9405-1070AK	30484158	○
10,80	12	118	71	56	45	M9405-1080AK	30484159	○
10,90	12	118	71	56	45	M9405-1090AK	30484160	○
11,00	12	118	71	56	45	M9405-1100AK	30484161	●
11,10	12	118	71	56	45	M9405-1110AK	30484162	○

Dimensions in mm.

For machining values see the end of the catalogue.

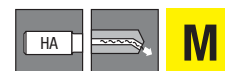
Information on special designs and other coatings
available on request.

● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill-Inox / M9405 (5xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
11,20	12	118	71	56	45	M9405-1120AK	30484163	○
11,30	12	118	71	56	45	M9405-1130AK	30484164	○
11,40	12	118	71	56	45	M9405-1140AK	30484165	○
11,50	12	118	71	56	45	M9405-1150AK	30484166	●
11,60	12	118	71	56	45	M9405-1160AK	30484167	○
11,70	12	118	71	56	45	M9405-1170AK	30484168	○
11,80	12	118	71	56	45	M9405-1180AK	30484169	●
11,90	12	118	71	56	45	M9405-1190AK	30484170	○
12,00	12	118	71	56	45	M9405-1200AK	30484171	●
12,50	14	124	77	60	45	M9405-1250AK	30484172	●
12,80	14	124	77	60	45	M9405-1280AK	30484173	○
13,00	14	124	77	60	45	M9405-1300AK	30484174	●
13,50	14	124	77	60	45	M9405-1350AK	30484175	●
13,80	14	124	77	60	45	M9405-1380AK	30484176	○
14,00	14	124	77	60	45	M9405-1400AK	30484177	●
14,50	16	133	83	63	48	M9405-1450AK	30484178	○
14,80	16	133	83	63	48	M9405-1480AK	30484179	○
15,00	16	133	83	63	48	M9405-1500AK	30484180	●
15,50	16	133	83	63	48	M9405-1550AK	30484181	○
15,80	16	133	83	63	48	M9405-1580AK	30484182	○
16,00	16	133	83	63	48	M9405-1600AK	30484183	○
16,50	18	143	93	71	48	M9405-1650AK	30484184	○
16,80	18	143	93	71	48	M9405-1680AK	30484185	○
17,00	18	143	93	71	48	M9405-1700AK	30484186	○
17,50	18	143	93	71	48	M9405-1750AK	30484187	○
17,80	18	143	93	71	48	M9405-1780AK	30484188	○
18,00	18	143	93	71	48	M9405-1800AK	30484189	○
18,50	20	153	101	77	50	M9405-1850AK	30484190	○
18,80	20	153	101	77	50	M9405-1880AK	30484191	○
19,00	20	153	101	77	50	M9405-1900AK	30484192	○
19,50	20	153	101	77	50	M9405-1950AK	30484193	○
19,80	20	153	101	77	50	M9405-1980AK	30484194	○
20,00	20	153	101	77	50	M9405-2000AK	30484195	○

Dimensions in mm.

For machining values see the end of the catalogue.

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○ Not on stock (delivery time on request).

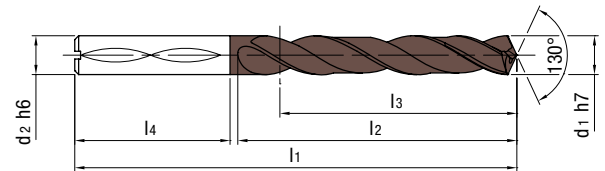
MEGA-Speed-Drill-Iron / M9505 (5xD)

Solid carbide twist drill, internal coolant supply



Design:

Drill diameter:	3,00 – 20,00 mm
Bore tolerance:	IT 10 (achievable)
Shank form:	HA
Coating:	MxM
Number of cutting edges:	2
Number of margins:	3
Point geometry:	Specific point geometry
Point angle:	130°
Helix:	30°



Dimensions						Shank form HA		
d1 h7	d2 h6	l1	l2	l3	l4	Order designation	Order No.	Stock
3,00	6	66	28	23	36	M9505-0300AP	30484196	●
3,10	6	66	28	23	36	M9505-0310AP	30484197	○
3,20	6	66	28	23	36	M9505-0320AP	30484198	●
3,30	6	66	28	23	36	M9505-0330AP	30484199	●
3,40	6	66	28	23	36	M9505-0340AP	30484200	●
3,50	6	66	28	23	36	M9505-0350AP	30484201	●
3,60	6	66	28	23	36	M9505-0360AP	30484202	○
3,70	6	66	28	23	36	M9505-0370AP	30484203	●
3,80	6	74	36	29	36	M9505-0380AP	30484204	●
3,90	6	74	36	29	36	M9505-0390AP	30484205	●
4,00	6	74	36	29	36	M9505-0400AP	30484206	●
4,10	6	74	36	29	36	M9505-0410AP	30484207	●
4,20	6	74	36	29	36	M9505-0420AP	30484208	●
4,30	6	74	36	29	36	M9505-0430AP	30484209	●
4,40	6	74	36	29	36	M9505-0440AP	30484210	●
4,50	6	74	36	29	36	M9505-0450AP	30484211	●
4,60	6	74	36	29	36	M9505-0460AP	30484212	●
4,65	6	74	36	29	36	M9505-0465AP	30484213	○
4,70	6	74	36	29	36	M9505-0470AP	30484214	○
4,80	6	82	44	35	36	M9505-0480AP	30484215	●
4,90	6	82	44	35	36	M9505-0490AP	30484216	●
5,00	6	82	44	35	36	M9505-0500AP	30484217	●
5,10	6	82	44	35	36	M9505-0510AP	30484218	●
5,20	6	82	44	35	36	M9505-0520AP	30484219	●
5,30	6	82	44	35	36	M9505-0530AP	30484220	○
5,40	6	82	44	35	36	M9505-0540AP	30484221	●
5,50	6	82	44	35	36	M9505-0550AP	30484222	●
5,55	6	82	44	35	36	M9505-0555AP	30484223	○
5,60	6	82	44	35	36	M9505-0560AP	30484224	●
5,70	6	82	44	35	36	M9505-0570AP	30484225	●
5,80	6	82	44	35	36	M9505-0580AP	30484226	●
5,90	6	82	44	35	36	M9505-0590AP	30484227	●
6,00	6	82	44	35	36	M9505-0600AP	30484228	●
6,10	8	91	53	43	36	M9505-0610AP	30484229	●

Dimensions in mm.

For machining values see the end of the catalogue.

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● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill-Iron / M9505 (5xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
6,20	8	91	53	43	36	M9505-0620AP	30484230	●
6,30	8	91	53	43	36	M9505-0630AP	30484231	●
6,40	8	91	53	43	36	M9505-0640AP	30484232	●
6,50	8	91	53	43	36	M9505-0650AP	30484233	●
6,60	8	91	53	43	36	M9505-0660AP	30484234	●
6,70	8	91	53	43	36	M9505-0670AP	30484235	○
6,80	8	91	53	43	36	M9505-0680AP	30484236	●
6,90	8	91	53	43	36	M9505-0690AP	30484237	●
7,00	8	91	53	43	36	M9505-0700AP	30484238	●
7,10	8	91	53	43	36	M9505-0710AP	30484239	●
7,20	8	91	53	43	36	M9505-0720AP	30484240	●
7,30	8	91	53	43	36	M9505-0730AP	30484241	○
7,40	8	91	53	43	36	M9505-0740AP	30484242	●
7,50	8	91	53	43	36	M9505-0750AP	30484243	●
7,60	8	91	53	43	36	M9505-0760AP	30484244	●
7,70	8	91	53	43	36	M9505-0770AP	30484245	○
7,80	8	91	53	43	36	M9505-0780AP	30484246	●
7,90	8	91	53	43	36	M9505-0790AP	30484247	○
8,00	8	91	53	43	36	M9505-0800AP	30484248	●
8,10	10	103	61	49	40	M9505-0810AP	30484249	●
8,20	10	103	61	49	40	M9505-0820AP	30484250	○
8,30	10	103	61	49	40	M9505-0830AP	30484251	○
8,40	10	103	61	49	40	M9505-0840AP	30484252	●
8,50	10	103	61	49	40	M9505-0850AP	30484253	●
8,60	10	103	61	49	40	M9505-0860AP	30484254	●
8,70	10	103	61	49	40	M9505-0870AP	30484255	●
8,80	10	103	61	49	40	M9505-0880AP	30484256	●
8,90	10	103	61	49	40	M9505-0890AP	30484257	●
9,00	10	103	61	49	40	M9505-0900AP	30484258	●
9,10	10	103	61	49	40	M9505-0910AP	30484259	●
9,20	10	103	61	49	40	M9505-0920AP	30484260	○
9,30	10	103	61	49	40	M9505-0930AP	30484261	●
9,40	10	103	61	49	40	M9505-0940AP	30484262	○
9,50	10	103	61	49	40	M9505-0950AP	30484263	●
9,60	10	103	61	49	40	M9505-0960AP	30484264	○
9,70	10	103	61	49	40	M9505-0970AP	30484265	○
9,80	10	103	61	49	40	M9505-0980AP	30484266	●
9,90	10	103	61	49	40	M9505-0990AP	30484267	○
10,00	10	103	61	49	40	M9505-1000AP	30484268	●
10,10	12	118	71	56	45	M9505-1010AP	30484269	○
10,20	12	118	71	56	45	M9505-1020AP	30484270	●
10,30	12	118	71	56	45	M9505-1030AP	30484271	○
10,40	12	118	71	56	45	M9505-1040AP	30484272	●
10,50	12	118	71	56	45	M9505-1050AP	30484273	●
10,60	12	118	71	56	45	M9505-1060AP	30484274	○
10,70	12	118	71	56	45	M9505-1070AP	30484275	○
10,80	12	118	71	56	45	M9505-1080AP	30484276	●
10,90	12	118	71	56	45	M9505-1090AP	30484277	○
11,00	12	118	71	56	45	M9505-1100AP	30484278	●
11,10	12	118	71	56	45	M9505-1110AP	30484279	○

Dimensions in mm.

For machining values see the end of the catalogue.

Information on special designs and other coatings
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● Available ex stock Germany.

○ Not on stock (delivery time on request).

MEGA-Speed-Drill-Iron / M9505 (5xD)

Solid carbide twist drill, internal coolant supply



Dimensions						Shank form HA		
d ₁ h7	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Order designation	Order No.	Stock
11,20	12	118	71	56	45	M9505-1120AP	30484280	●
11,30	12	118	71	56	45	M9505-1130AP	30484281	○
11,40	12	118	71	56	45	M9505-1140AP	30484282	○
11,50	12	118	71	56	45	M9505-1150AP	30484283	●
11,60	12	118	71	56	45	M9505-1160AP	30484284	○
11,70	12	118	71	56	45	M9505-1170AP	30484285	●
11,80	12	118	71	56	45	M9505-1180AP	30484286	●
11,90	12	118	71	56	45	M9505-1190AP	30484287	○
12,00	12	118	71	56	45	M9505-1200AP	30484288	●
12,50	14	124	77	60	45	M9505-1250AP	30484289	●
12,80	14	124	77	60	45	M9505-1280AP	30484290	○
13,00	14	124	77	60	45	M9505-1300AP	30484291	●
13,50	14	124	77	60	45	M9505-1350AP	30484292	○
13,80	14	124	77	60	45	M9505-1380AP	30484293	○
14,00	14	124	77	60	45	M9505-1400AP	30484294	●
14,50	16	133	83	63	48	M9505-1450AP	30484295	●
14,80	16	133	83	63	48	M9505-1480AP	30484296	○
15,00	16	133	83	63	48	M9505-1500AP	30484297	●
15,50	16	133	83	63	48	M9505-1550AP	30484298	○
15,80	16	133	83	63	48	M9505-1580AP	30484299	○
16,00	16	133	83	63	48	M9505-1600AP	30484300	●
16,50	18	143	93	71	48	M9505-1650AP	30484301	●
16,80	18	143	93	71	48	M9505-1680AP	30484302	○
17,00	18	143	93	71	48	M9505-1700AP	30484303	○
17,50	18	143	93	71	48	M9505-1750AP	30484304	○
17,80	18	143	93	71	48	M9505-1780AP	30484305	○
18,00	18	143	93	71	48	M9505-1800AP	30484306	○
18,50	20	153	101	77	50	M9505-1850AP	30484307	●
18,80	20	153	101	77	50	M9505-1880AP	30484308	○
19,00	20	153	101	77	50	M9505-1900AP	30484309	○
19,50	20	153	101	77	50	M9505-1950AP	30484310	○
19,80	20	153	101	77	50	M9505-1980AP	30484311	○
20,00	20	153	101	77	50	M9505-2000AP	30484312	●

Dimensions in mm.

For machining values see the end of the catalogue.

Information on special designs and other coatings
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● Available ex stock Germany.

○ Not on stock (delivery time on request).

Machining values

MEGA-Speed-Drill (M9103, M9105, M9108)

		Strength [N/mm²]	Examples	Cutting speed vc [m/min]		Recommended feed f [mm/rev] for diameter ranges					
		Hardness (HB)		IC	MQL	3–5 mm	5–8 mm	8–12 mm	12–16 mm	16–20 mm	
Material											
P	Non-alloyed steels, Cast steel	≤ 600 N/mm²	St37, St42, C22, GS38	180 - 220	130 - 180	0,10 - 0,18	0,15 - 0,25	0,22 - 0,35	0,30 - 0,45	0,35 - 0,50	P
		≤ 700 N/mm²	St50, St60, C45, GS62	160 - 200	120 - 160	0,10 - 0,18	0,15 - 0,25	0,22 - 0,35	0,30 - 0,45	0,35 - 0,50	
		> 700 N/mm²	St70, C70	140 -180	100 - 140	0,10 - 0,18	0,15 - 0,25	0,22 - 0,35	0,30 - 0,45	0,35 - 0,50	
	Alloyed steels	≤ 900 N/mm²	16MnCr5, 90MnCrV8	130 - 170	90 - 130	0,10 - 0,18	0,15 - 0,25	0,22 - 0,35	0,30 - 0,45	0,35 - 0,50	
		≤ 1000 N/mm²	100Cr6, 42CrMo4	120 - 160	80 - 120	0,08 - 0,16	0,14 - 0,22	0,20 - 0,32	0,26 - 0,40	0,30 - 0,45	
		> 1000 N/mm²	X210Cr13, 34CrAlNi7	80 - 120	60 - 80	0,08 - 0,14	0,12 - 0,20	0,18 - 0,28	0,24 - 0,35	0,26 - 0,40	
K ₁ *	Grey cast iron, alloyed grey cast iron	≤ 200 HB	GG10, GG15	110 - 150	120 - 160	0,16 - 0,24	0,20 - 0,35	0,25 - 0,40	0,35 - 0,50	0,40 - 0,63	K ₁ *
		≤ 250 HB	GG20, GG25, GTW40	120 - 160	80 - 120	0,14 - 0,22	0,18 - 0,28	0,22 - 0,35	0,30 - 0,45	0,35 - 0,56	
		> 250 HB	GG30, GG40, GTS70	80 - 120	60 - 80	0,12 - 0,20	0,16 - 0,25	0,20 - 0,30	0,28 - 0,40	0,30 - 0,45	
K ₂ *	Spheroidal cast iron,	≤ 600 N/mm²	GGG40, GGG50	140 - 180	100 - 140	0,16 - 0,24	0,20 - 0,35	0,25 - 0,40	0,35 - 0,50	0,40 - 0,70	K ₂ *
	Vermicular graphite cast iron, Malleable cast iron	> 600 N/mm²	GGG60, GGG70, GGV	100 - 150	75 - 100	0,14 - 0,22	0,18 - 0,28	0,22 - 0,35	0,30 - 0,45	0,35 - 0,60	

* For series production applications we recommend the MEGA-Speed-Drill-Iron.

MEGA-Speed-Drill-Inox (M9405) MEGA-Speed-Drill-Iron (M9505)

		Strength [N/mm²]	Examples	Cutting speed vc [m/min]		Recommended feed f [mm/rev] for diameter ranges					
		Hardness (HB)		IC	MQL	3–5 mm	5–8 mm	8–12 mm	12–16 mm	16–20 mm	
Material											
M	Stainless steel (ferrit./mart.)	≤ 600 N/mm² ≤ 200 HB	X5 CrNi 18 9 (V2A)	60-70	50-60	0,09-0,14	0,12-0,18	0,15-0,24	0,20-0,28	0,23-0,30	M
	Stainless steel (martensitic)	≤ 810 N/mm² ≤ 240 HB	X10 CrNiMoTi 18 10	50-60	45-55	0,07-0,11	0,09-0,14	0,12-0,18	0,15-0,22	0,18-0,24	
	Stainless steel (austenitic)	≤ 610 N/mm² ≤ 180 HB	G-X40 CrNi 27 4	60-80	50-65	0,07-0,11	0,09-0,14	0,12-0,18	0,15-0,22	0,18-0,24	
	rustpr. steel (austn./ ferrit.) DUPLEX	≥ 880 N/mm² ≥ 260 HB	X2 CrNiMoN 22 5 3	60-80	50-60	0,08-0,12	0,10-0,16	0,13-0,20	0,17-0,24	0,20-0,28	
K ₁	Grey cast iron	≤ 200 N/mm² ≤ 180 HB	GG10, GG15	170-210	120-160	0,19-0,31	0,25-0,40	0,32-0,50	0,40-0,57	0,46-0,70	K ₁
		≤ 250 N/mm² ≤ 220 HB	GG20, GG25, GTW 40	140-180	100-130	0,17-0,27	0,22-0,35	0,28-0,43	0,34-0,51	0,41-0,60	
		≥ 300 N/mm² ≥ 260 HB	GG30, GG40, GTS 70	100-135	80-105	0,14-0,24	0,19-0,31	0,25-0,39	0,31-0,45	0,31-0,49	
K ₂	Spheroidal cast iron	≤ 400 N/mm² ≤ 160 HB	GGG40, GGG50	180-240	140-180	0,19-0,31	0,25-0,40	0,32-0,50	0,40-0,57	0,46-0,63	K ₂
		≤ 500 N/mm² ≤ 200 HB	GGG60, GGG70	140-180	100-135	0,17-0,27	0,22-0,35	0,28-0,43	0,34-0,51	0,41-0,56	
		≥ 600 N/mm² ≥ 250 HB	GGG80, GTS 65	120-150	90-115	0,14-0,24	0,19-0,31	0,25-0,39	0,31-0,45	0,36-0,49	
	Vermicular graphite cast iron	≤ 400 N/mm²	GGV Ti	100-135	90-120	0,19-0,31	0,25-0,40	0,32-0,50	0,40-0,57	0,46-0,63	
		≥ 500 N/mm²	GGV Ti	90-120	80-105	0,17-0,27	0,22-0,35	0,28-0,43	0,34-0,51	0,41-0,56	
	ADI cast iron	≤ 800 N/mm²	ADI 800	70-95	60-75	0,14-0,24	0,19-0,31	0,25-0,39	0,31-0,45	0,36-0,49	
≥ 1200 N/mm²		ADI 1200	60-75	50-65	0,14-0,24	0,19-0,31	0,25-0,39	0,31-0,45	0,36-0,49		

MILLER News

NEW: Tool product line for machining modern materials and high-performance materials

MILLER GmbH, Präzisionswerkzeuge has developed a new product line of tools for drilling and milling titanium, high-temperature super alloys and composite materials. The tool design focuses on preventing delamination, burr formation or fibre projections on the component. Special diamond coatings and tools equipped with PCD ensure long tool lives. The user-friendly product line includes tools for drilling and milling CFRP, GFRP, titanium, nickel-based alloys, aramide and plastics.



NEW: OptiMill®-Silent – An HPC milling cutter with the „satin glove touch“

This product, recently developed by MILLER, is specially designed for roughing and finishing structural steel, case hardened steel, tool steel, cast steel and cast iron, as well as chromium and nickel materials and highly heat resisting materials. This milling cutter's impressive features include its geometrical shape, innovative coating and the specially developed geometry for long tool life, outstanding feed rates and incredibly low noise produced during milling of solid materials.

For further information,
please visit our Internet site at
www.miller-tools.de!

Available from our partners

VR reamers: More blades for more performance!

A crucial criterion for the performance of multi-bladed reamers is the number of blades. To allow more room for blades, chip spaces are eliminated in the VR 01 multi-blade reamer from BECK. Despite this, an effective coolant supply directly to the blades is still assured. This produces several positive effects: The machining time is drastically reduced, the tool lives are increased and the bore quality, in particular the circularity of the bore, is improved. For example, honing during fine machining of bores is often no longer required. VR reamers from BECK are available with different cutting edge materials including Cermet, carbide, coated cutting edges as well as PCD or PcBN, depending on the machining task.

BECK 
PRÄZISIONSWERKZEUGE



 **WTE**
PRÄZISIONSTECHNIK

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The ideal clamping system for milling applications.

HPHs (High Performance Holders) from WTE Präzisionstechnik GmbH are a unique class based on an advanced development of conventional expanding technology. The chuck combines maximum holding forces with outstanding damping properties and high bending resistance while ensuring the customary radial-run-out accuracy, setting it apart in the top class of clamping tools and guaranteeing especially high surface quality in practical applications.

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August Beck GmbH & Co. KG
in Winterlingen

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The competence and experience from more than 100 years make BECK a dependable partner in demand for bore machining. The comprehensive standard programme includes reaming and countersinking tools and covers the complete cutting material spectrum from HSS to PCD and PCBN.

This programme is supplemented by high performance reamers and custom tools that offer users that crucial performance plus.



MILLER GmbH, Präzisionswerkzeuge
in Altenstadt

► **Innovative drilling and milling**

One of the largest and most modern factories for solid carbide tools in Europe produces drills and milling cutters that have yet to find their equal. Because when it comes to high-precision standard solutions for drilling and milling, MILLER is the acknowledged specialist. The diverse program line consists of solid carbide tools for almost any application. Know-how, quality and focus on retail business are the features that best describe our company and our products.



WTE Präzisionstechnik GmbH
in Kempten

► **Reliable clamping technology**

WTE is the specialist in innovative tool adapters. The extensive product line of precision drill chucks, hydraulic chucks, shrink chucks, HPH universal chucks and micro chucks fills every need for modern, high-precision machining.

WTE stands for precision and quality combined with high competence as a reliable clamping systems partner for your retail business.

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Three specialists deliver the perfect tools for success in your retail business.

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We are convinced that the high demands of precision-dependent industries are met only by products developed and manufactured in Germany. The most modern manufacturing processes, production systems and infrastructure as well as qualified and dedicated employees make it possible to achieve very high performance standards. That means the highest quality features in the μ range for our products, combined with an attractive price-to-performance ratio. All companies in „tool-traders-partner“ have active quality management systems and are certified in accordance with ISO 9001.



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All the companies in „tool-traders-partner“ are technology leaders and their brands enjoy a high level of familiarity internationally and an excellent image. With our practically oriented tool specialists, we have access to a pool of information from decades of experience and collective specialist knowledge. We stand for continuity, technological competence and innovative strength. For retail business this means: Always being in touch with the latest in tool technology and know-how.



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MILLER GmbH, Präzisionswerkzeuge:
The specialist for solid carbide drills and
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- ▶ High performance drills with more cutting edges and additional guiding chamfers
- ▶ TTD replaceable head drills
- ▶ Solid carbide milling range for steel, aluminium, stainless steel, plastics and hardened materials
- ▶ High performance milling cutters for high machining volumes



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