THERMDRILL-Selection Table & Speeds for FORM and CUT-type thermal drills, short and long version

THERMDRILL®
Fastening Technology – Made in Germany

Form
without cutting edges

Additional thread in the collar provides a more stable connection

wirh collar

Thread	Short Version: Maximum material thickness [mm]	Short Version: Lenght working part [mm]	Short Version: Art.no.	Long Version: Maximum material thickness [mm]	Long Version: Lenght working part [mm]	Long Version: Art.no.	Shaft Ø [mm]	Speeds: Thermal Drilling min. [U/min.]	Speeds: Thermal Drilling optimal [U/min.]	Speeds: Alu, Cu, [U/min.]	Thread Forming [U/min].
M3 (2,7)	1,5	6,4	27FS	2,0	7,6	27FL	6,0	2.600	3.000	4.000	1.350
M4 (3,7)	1,5	7,6	37FS	2,5	10,1	37FL	6,0	2.300	2.600	3.800	1.000
M5 (4,5)	2,0	9,1	45FS	3,0	12,0	45FL	6,0	2.200	2.500	3.700	800
M6 (5,4)	2,0	10,1	54FS	3,5	14,4	54FL	8,0	2.000	2.400	3.600	650
M8 (7,4)	2,5	13,5	74FS	4,0	18,2	74FL	8,0	1.600	2.200	3.200	500
M10 (9,3)	2,5	16,2	93FS	4,5	21,7	93FL	10,0	1.500	2.000	3.000	400
M12 (11,0)	3,0	19,3	110FS	5,0	25,8	110FL	12,0	1.400	1.800	2.800	350
M16 (14,9)	3,5	26,2	149FS	6,0	35,7	149FL	16,0	1.200	1.400	2.200	250
M18 (16,8)	3,5	29,4	168FS	6,0	39,5	168FL	18,0	1.100	1.300	2.000	230
M20 (18,8)	4,0	33,1	188FS	8,0	43,4	188FL	20,0	1.000	1.200	1.900	200
1/8“ (9,3)	2,5	16,2	93FS	4,5	21,7	93FL	10,0	1.500	2.000	3.000	400
1/4" (12,5)	2,5	21,3	125FS	5,0	26,4	125FL	14,0	1.400	1.600	2.600	350
3/8“ (16,0)	2,5	27,0	160FS	5,0	31,0	160FL	16,0	1.200	1.400	2.200	300
1/2“ (20,0)	2,5	36,3	200FS				18,0	1.000	1.200	1.800	250
3/4" (25,5)	2,5	43,6	255FS				20,0	900	1.000	1.600	200
1“ (32,1)	2,5	52,3	321FS				20,0	900	1.000	1.500	150

Cut
with cutting edges

for a flat finish

without collar

Thread	Short Version: Maximum material thickness [mm]	Short Version: Lenght working part [mm]	Short Version: Art.no.	Long Version: Maximum material thickness [mm]	Long Version: Lenght working part [mm]	Long Version: Art.no.	Shaft Ø [mm]	Speeds: Thermal Drilling min. [U/min.]	Speeds: Thermal Drilling optimal [U/min.]	Speeds: Alu, Cu, [U/min.]	Thread Forming [U/min].
M3 (2,7)	1,5	6,4	27CS	3,0	7,6	27CL	6,0	2.600	3.000	4.000	1.350
M4 (3,7)	2,0	7,6	37CS	4,0	10,1	37CL	6,0	2.300	2.600	3.800	1.000
M5 (4,5)	3,0	9,1	45CS	4,5	12,0	45CL	6,0	2.200	2.500	3.700	800
M6 (5,4)	3,0	10,1	54CS	5,0	14,4	54CL	8,0	2.000	2.400	3.600	65
M8 (7,4)	4,0	13,5	74CS	6,0	18,2	74CL	8,0	1.600	2.200	3.200	500
M10 (9,3)	4,0	16,2	93CS	6,5	21,7	93CL	10,0	1.500	2.000	3.000	400
M12 (11,0)	4,5	19,3	110CS	7,0	25,8	110CL	12,0	1.400	1.800	2.800	350
M16 (14,9)	5,0	26,2	149CS	8,0	35,7	149CL	16,0	1.200	1.400	2.200	250
M18 (16,8)	5,0	29,4	168CS	8,0	39,5	168CL	18,0	1.100	1.300	2.000	230
M20 (18,8)	6,0	33,1	188CS	10,0	43,4	188CL	20,0	1.000	1.200	1.900	200
1/8“ (9,3)	4,0	16,2	93CS	6,5	21,7	93CL	10,0	1.500	2.000	3.000	400
1/4" (12,5)	4,0	21,3	125CS	7,0	26,4	125CL	14,0	1.400	1.600	2.600	350
3/8“ (16,0)	4,0	27,0	160CS	7,0	31,0	160CL	16,0	1.200	1.400	2.200	300
1/2“ (20,0)	4,0	36,3	200CS				18,0	1.000	1.200	1.800	250
3/4" (25,5)	4,0	43,6	255CS				20,0	900	1.000	1.600	200
1“ (32,1)	4,0	52,3	321CS				20,0	900	1.000	1.500	150