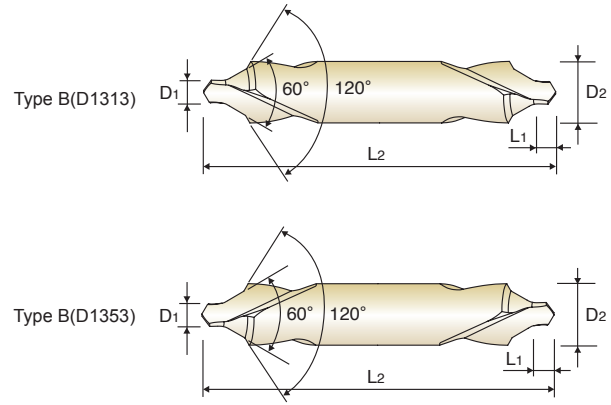
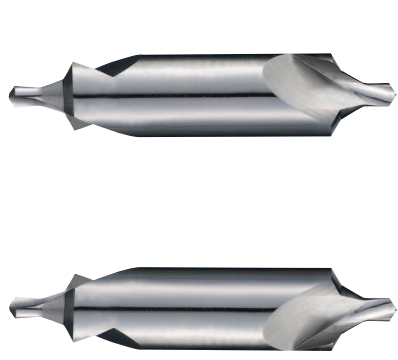


HSS, CENTER DRILLS FORM B
HSS, ZENTRIERBOHRER FORM B



DIN 333
HSS
h8
k12
120°
P.248

DIN 333
HSS
h8
k12
120°
P.248

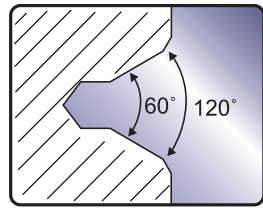
FORM B (60° + 120°)

LEFT HELIX / FORM B (60° + 120°)

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Pilot Length	Overall Length
	D1	D2	L1	L2
D1313010	1.0	4	1.3	35.5
D1313912	1.25	5	1.6	40
D1313016	1.6	6.3	2	45
D1313020	2.0	8	2.5	50
D1313025	2.5	10	3.1	55
D1313931	3.15	11.2	3.9	60
D1313040	4.0	14	5	67
D1313050	5.0	18	6.3	75
D1313063	6.3	20	8	80

EDP No.	Drill Diameter	Shank Diameter	Pilot Length	Overall Length
	D1	D2	L1	L2
D1353020	2.0	8	2.5	50
D1353025	2.5	10	3.1	55
D1353931	3.15	11.2	3.9	60
D1353040	4.0	14	5	67
D1353063	6.3	20	8	80



Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze	CFRP
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎				○	○	○	○	○	○	○	

◎ : Excellent ○ : Good

- I-DREAM DRILLS
- DREAM DRILLS -GENERAL
- DREAM DRILLS -INOX
- DREAM DRILLS -ALU
- DREAM DRILLS -CFRP
- DREAM DRILLS -MQL TYPE
- DREAM DRILLS for HARDENED STEELS
- GENERAL CARBIDE DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- MULTI-1 DRILLS
- HPD DRILLS
- GOLD-P DRILLS
- STRAIGHT SHANK DRILLS
- TAPER SHANK DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- SPADE DRILLS
- TECHNICAL DATA



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

HSS & HSS-EX, CENTER DRILLS
HSS & HSS-EX, ZENTRIERBOHRER

DV303, DV333, DV334, D1303, D1343, D1313, D1353, D1363, D1373, DV383 SERIES

WORK MATERIAL	MILD STEEL		ALLOY STEEL				STAINLESS STEEL	
	< 700 N/mm ²		~ HRc 23		~ HRc 32			
HARDNESS								
DIAMETER	SPEED	FEED	SPEED	FEED	SPEED	FEED	SPEED	FEED
2.0	30 ~ 45	0.02~0.05	25 ~ 30	0.02~0.05	15 ~ 25	0.01~0.03	6 ~ 10	0.01~0.03
3.0		0.06		0.06		0.04		0.04
6.0		0.08		0.08		0.06		0.06
10.0		0.15		0.15		0.10		0.10

SPEED(Shank Dia.) = m/min
 FEED(Drill Dia.) = mm/rev

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA