



**NC-SPOTTING DRILLS**

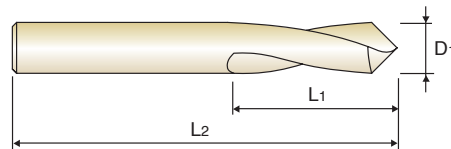
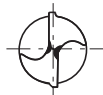
**D2306** SERIES

**D2321** SERIES

**HSSCo8, NC-SPOTTING DRILLS 90°**  
**HSSCo8, NC-ANBOHRER 90°**

► **Application** : For more precise centering work on NC/CNC Machines.  
 The large diameter of the tool permits chamfering work after centering continuously.

► **Verwendung** : Für positionsgenaueres und schnelles Anbohren mit NC/CNC-Maschinen und Bearbeitungszentren, die Ausführung mit Spitzenwinkel 90° ermöglicht sowohl ein Zentrieren, als auch das Vorbohren für einen nächstgrößeren Durchmesser.



NC HSS Co8 h6 h6 90° P.237

**LONG LENGTH**

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D2306030	3.0	12	46	D2321030	3.0	12	80
D2306040	4.0	12	55	D2321040	4.0	12	100
D2306050	5.0	15	60	D2321050	5.0	15	120
D2306060	6.0	20	66	D2321060	6.0	20	140
D2306080	8.0	25	79	D2321080	8.0	25	140
D2306100	10.0	25	89	D2321100	10.0	25	170
D2306120	12.0	30	102	D2321120	12.0	30	170
D2306160	16.0	35	115	D2321160	16.0	35	200
D2306200	20.0	40	131	D2321200	20.0	40	200

► TiN, TiCN and TiAlN are available on your request.

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

◎ : Excellent ○ : Good

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~								
◎	◎					○	○		○		○	



# NC-SPOTTING DRILLS

## RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

HSSCo8, NC-SPOTTING DRILLS 90°, 120°, 142°  
HSSCo8, NC-ANBOHRER 90°, 120°, 142°

### D2306, D2321, D2307, D2322, D2320, D2323 SERIES

WORK MATERIAL	CARBON STEELS		ALLOY STEELS		ALLOY STEELS, TOOL STEELS, HARDENED STEELS		STAINLESS STEELS		ALUMINUM, ALUMINUM ALLOYS	
	18 ~ 23 m/min		15 ~ 20 m/min		8 ~ 12 m/min		8 ~ 12 m/min		55 ~ 65 m/min	
DRILLING SPEED										
DIAMETER	N	S	N	S	N	S	N	S	N	S
3.0	2460	0.06	2110	0.06	1080	0.06	940	0.06	7040	0.14
4.0	1850	0.07	1580	0.07	800	0.07	700	0.07	5280	0.15
5.0	1510	0.08	1300	0.08	670	0.08	580	0.08	4400	0.17
6.0	1170	0.09	1030	0.09	540	0.09	460	0.09	3520	0.19
8.0	880	0.11	790	0.11	400	0.11	350	0.11	2640	0.22
10.0	700	0.12	630	0.12	320	0.12	290	0.12	2110	0.25
12.0	590	0.14	530	0.14	260	0.14	240	0.14	1760	0.28
16.0	460	0.20	400	0.20	200	0.20	180	0.20	1320	0.33
20.0	350	0.24	320	0.24	150	0.24	140	0.24	1060	0.45

N = R.P.M

S = Feed per Revolution (mm/rev.)

CARBIDE

HSS

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