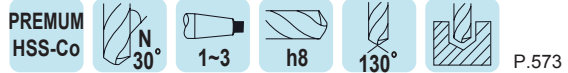
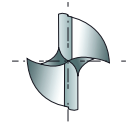
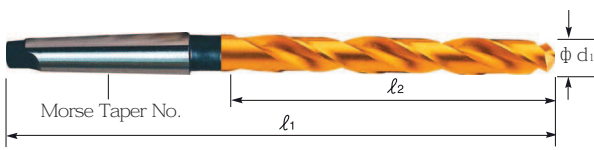


# HPD Spiralbohrer mit Morsekegelschaft

## HPD Morse Taper Shank Twist Drills

KURZ  
JOBBER



- **Anwendung** : Zum Hochgeschwindigkeitsbohren 4D ~ 5D Bohrtiefe geeignet zum Bearbeiten von Stahl, Gusseisen, Aluminium, Legierungen, Werkzeugstahl, usw.
- **Vorteile** : Gute Spanentfernung, selbstzentriert, geringere Abweichungen und verbesserte Genauigkeit, kurze Ausführung, verbesserte Stabilität, Zum Bearbeiten von Premium kobalt HSS mit hochwertiger TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit Verbesserte Oberflächengüte und Produktivität.
- **Application** : Designed for high speed non-step 4D ~ 5D drilling. Drilling in mild steel, cast iron, aluminum, alloyed, tool steel, etc.
- **Advantage** : Helical thinning - good chip removal, self-centering, reducing thrust and improving accuracy.  
Reinforced web and jobbers length - increasing rigidity and suitable for 4D~5D drilling  
Premium Cobalt HSS with superior TiN coating - higher speed and feed, longer service life  
High quality-good surface finishes, high productivity and weeding second operation.



Unit:mm

Art.-Nr. EDP No. TiN	DRILL DIAMETER d <sub>1</sub>	OVERALL LENGTH l <sub>1</sub>	FLUTE LENGTH l <sub>2</sub>	Morse Taper No.	Art.-Nr. EDP No. TiN	DRILL DIAMETER d <sub>1</sub>	OVERALL LENGTH l <sub>1</sub>	FLUTE LENGTH l <sub>2</sub>	Morse Taper No.
D4642130	13.0	184	101	1	D4642167	16.7	215	115	2
D4642135	13.5	189	106	1	D4642168	16.8	215	115	2
D4642140	14.0	189	106	1	D4642169	16.9	215	115	2
D4642141	14.1	209	109	2	D4642170	17.0	215	115	2
D4642142	14.2	209	109	2	D4642171	17.1	218	118	2
D4642143	14.3	209	109	2	D4642172	17.2	218	118	2
D4642144	14.4	209	109	2	D4642173	17.3	218	118	2
D4642145	14.5	209	109	2	D4642174	17.4	218	118	2
D4642146	14.6	209	109	2	D4642175	17.5	218	118	2
D4642147	14.7	209	109	2	D4642176	17.6	218	118	2
D4642148	14.8	209	109	2	D4642177	17.7	218	118	2
D4642149	14.9	209	109	2	D4642178	17.8	218	118	2
D4642150	15.0	209	109	2	D4642179	17.9	218	118	2
D4642151	15.1	212	112	2	D4642180	18.0	218	118	2
D4642152	15.2	212	112	2	D4642181	18.1	222	122	2
D4642153	15.3	212	112	2	D4642182	18.2	222	122	2
D4642154	15.4	212	112	2	D4642183	18.3	222	122	2
D4642155	15.5	212	112	2	D4642184	18.4	222	122	2
D4642156	15.6	212	112	2	D4642185	18.5	222	122	2
D4642157	15.7	212	112	2	D4642186	18.6	222	122	2
D4642158	15.8	212	112	2	D4642187	18.7	222	122	2
D4642159	15.9	212	112	2	D4642188	18.8	222	122	2
D4642160	16.0	212	112	2	D4642189	18.9	222	122	2
D4642161	16.1	215	115	2	D4642190	19.0	222	122	2
D4642162	16.2	215	115	2	D4642191	19.1	225	125	2
D4642163	16.3	215	115	2	D4642192	19.2	225	125	2
D4642164	16.4	215	115	2	D4642193	19.3	225	125	2
D4642165	16.5	215	115	2	D4642194	19.4	225	125	2
D4642166	16.6	215	115	2	D4642195	19.5	225	125	2

# RECOMMENDED CUTTING CONDITIONS

## EMPFOHLENE SCHNEIDKONDITIONEN



### PREMIUM COBALT HSS, HPD TWIST DRILLS, TiN COATED

PREMIUM KOBALT HSS, HPD SPIRALBOHRER, TiN-beschichtet

D4541, D4542, D4642 SERIES

Please decrease the feed rate in D4542, D4642 SERIES HPD drills.

Den Vorschub in der D4542, D4642 Gruppe HPD Bohrer bitte verringern.

WORK MATERIAL Werkstück	CARBON STEELS (S45C-S50C) Stähle		ALLOY STEELS (SCM-SNC-SNCM) Stahl-Legierungen		TOOL STEEL, ALLOY STEELS (SKD11) Werkzeugstähle Stahl-Legierungen		CAST IRON TOOL STEEL Gusseisen Werkzeugstähle		ALUMINIUM ALLOY MAGNESIUM ALLOY Aluminium-Legierungen Magnesium-Legierungen	
	~ 700 N/mm <sup>2</sup>		700 ~ 900 N/mm <sup>2</sup>		900 ~ 1100 N/mm <sup>2</sup>					
STRENGTH										
DIAMETER(mm)	N	S	N	S	N	S	N	S	N	S
2	4200	0.08	3600	0.08	1750	0.08	5800	0.11	10500	0.16
3	2900	0.13	2500	0.13	1170	0.13	4000	0.14	10500	0.25
4	2100	0.14	1900	0.14	880	0.14	3000	0.17	8000	0.30
5	1700	0.16	1500	0.16	700	0.16	2400	0.20	6500	0.36
6	1300	0.17	1300	0.17	580	0.17	2100	0.23	5200	0.42
8	1000	0.21	950	0.21	440	0.21	1500	0.26	4200	0.47
10	850	0.25	750	0.25	350	0.25	1100	0.32	3400	0.56
12	700	0.30	650	0.30	290	0.30	1000	0.38	2700	0.67
14	550	0.35	500	0.35	250	0.35	850	0.40	2400	0.72
16	520	0.38	470	0.38	220	0.38	750	0.42	2100	0.77
18	450	0.44	420	0.44	195	0.44	700	0.45	1900	0.80
20	400	0.45	350	0.45	175	0.45	600	0.51	1600	0.87
22	370	0.50	340	0.50	160	0.50	550	0.52	1500	0.95
24	350	0.54	300	0.54	145	0.54	500	0.58	1400	1.00
26	320	0.58	280	0.58	135	0.58	450	0.60	1300	1.05
28	300	0.62	260	0.62	125	0.62	420	0.63	1200	1.10
30	280	0.66	240	0.66	115	0.66	400	0.74	1100	1.15
32	260	0.70	230	0.70	110	0.70	380	0.74	950	1.20

N = R.P.M  
S = Feed per Revolution(mm/rev.)

DRILLS