

Y/G NC-SPOTTING DRILLS

D5306 SERIES
D5307 SERIES

CARBIDE, NC-SPOTTING DRILLS
VOLLHARTMETALL NC-ANBOHRER

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

► **Verwendung** : Auf NC-Maschinen, Lehrenbohrwerken u.a. kapitalintensiven Bohrwerken, zum Zentrieren und Anfasen von Gewindebohrungen in einem Arbeitsgang. Besonders geeignet zum Anbohren von hochfesten Stählen, Stahlguß, Grauguß, Hartguß, Mangan-Hartstahl, CrNi-Stählen, Bronze, Leicht- und Buntmetallen.



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NC-Spotting drills 90°
NC-Anbohrer 90°

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D5306060	6.0	13	50
D5306080	8.0	23	60
D5306100	10.0	24	70
D5306120	12.0	24	70
D5306160	16.0	29	75
D5306200	20.0	35	100

NC-Spotting drills 120°
NC-Anbohrer 120°

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D5307060	6.0	13	50
D5307080	8.0	23	60
D5307100	10.0	24	70
D5307120	12.0	24	70
D5307160	16.0	29	75
D5307200	20.0	35	100

► TiN(D6306, D6307), TiCN(DG306, DG307) and TiAlN(DH306, DH307) are available on your request.

◎ : 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~								
◎	◎	◎			○	○	○	○	○			



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

CARBIDE NC - SPOTTING DRILLS 90°, 120°, 142° with FLATTED SHANK
VOLLHARTMETALL NC-ANBOHRER 90°, 120°, 142° mit MITNAHME FLÄCHE

D5306, D5307, D5320 SERIES

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON		STAINLESS STEELS		AI-SI ALLOYS, Si<10%		AI-SI ALLOYS, Si>10%		Ti, Ni ALLOY STEELS	
	STRENGTH		STRENGTH		STRENGTH		STRENGTH		STRENGTH		STRENGTH		STRENGTH		STRENGTH	
STRENGTH	< 700 N/mm ²		< 1000 N/mm ²		< HB240, GG25		< HB300, GG40									
DRILLING SPEED	65 ~ 75 m/min		45 ~ 55 m/min		90 ~ 100 m/min		65 ~ 75 m/min		35 ~ 40 m/min		145 ~ 165 m/min		115 ~ 135 m/min		35 ~ 40 m/min	
DIAMETER	N		S		N		S		N		S		N		S	
	N	S	N	S	N	S	N	S	N	S	N	S	N	S	N	S
6.0	3900	0.08	2850	0.08	5200	0.09	3800	0.09	2000	0.07	8800	0.11	7100	0.11	1950	0.07
8.0	2900	0.10	2150	0.10	3900	0.12	2850	0.12	1500	0.09	6600	0.15	5350	0.15	1450	0.09
10.0	2350	0.12	1700	0.12	3100	0.16	2300	0.16	1200	0.11	5300	0.19	4250	0.19	1200	0.11
12.0	1950	0.14	1450	0.14	2600	0.20	1900	0.20	1000	0.13	4450	0.23	3550	0.23	980	0.13
16.0	1450	0.17	1100	0.17	1950	0.24	1450	0.24	755	0.17	3300	0.27	2650	0.27	735	0.17
20.0	1150	0.19	850	0.19	1550	0.28	1150	0.28	590	0.20	2650	0.31	2150	0.31	590	0.20

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