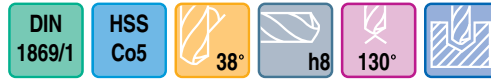
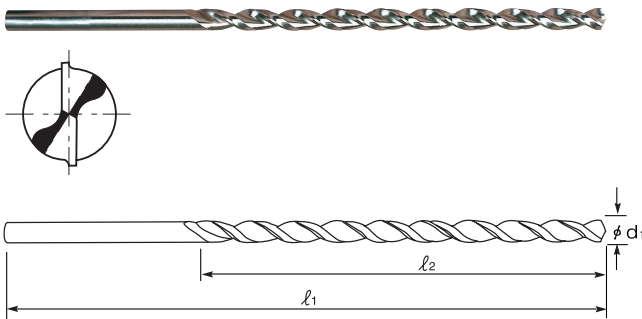


Spiralbohrer für tiefloch mit Zylinderschaft

Straight Shank Twist Drills for deep hole

ÜBERLANG
EXTRA LONG



P.617

► DH100 worm pattern drills

- **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.
- **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

Unit:mm

Art.-Nr. EDP No.	DRILL DIAMETER d ₁	OVERALL LENGTH l ₁	FLUTE LENGTH l ₂	Art.-Nr. EDP No.	DRILL DIAMETER d ₁	OVERALL LENGTH l ₁	FLUTE LENGTH l ₂
DL600020	2.0	125	85	DL600070	7.0	225	155
DL600922	2.25	135	90	DL600972	7.25	225	155
DL600025	2.5	140	95	DL600075	7.5	225	155
DL600927	2.75	150	100	DL600977	7.75	240	165
DL600030	3.0	150	100	DL600080	8.0	240	165
DL600932	3.25	155	105	DL600982	8.25	240	165
DL600035	3.5	165	115	DL600085	8.5	240	165
DL600937	3.75	165	115	DL600987	8.75	250	175
DL600040	4.0	175	120	DL600090	9.0	250	175
DL600942	4.25	175	120	DL600992	9.25	250	175
DL600045	4.5	185	125	DL600095	9.5	250	175
DL600947	4.75	185	125	DL600997	9.75	265	185
DL600050	5.0	195	135	DL600100	10.0	265	185
DL600952	5.25	195	135	DL600105	10.5	265	185
DL600055	5.5	205	140	DL600110	11.0	280	195
DL600957	5.75	205	140	DL600115	11.5	280	195
DL600060	6.0	205	140	DL600120	12.0	295	205
DL600962	6.25	215	150	DL600125	12.5	295	205
DL600065	6.5	215	150	DL600130	13.0	295	205
DL600967	6.75	225	155				

► The TiN(DN600), TiCN(DX600) and TiAlN(DT600) are available on your request.

WORM PATTERN DRILLS

RECOMMENDED CUTTING CONDITIONS

EMPFOHLENE SCHNEIDKONDITIONEN

HSSCo5 DH100, DH50 type WORM PATTERN DRILLS, DIN1897, DIN338, DIN340, DIN1869, DIN341, DIN1870

HSSCo5 DH100, DH50 type WORM PATTERN SPIRALBOHRER, DIN1897, DIN 338, DIN 340, DIN 1869, DIN 341, DIN 1870

DL510, DL508, DL509, DL505, DL504, DL507, DL600, DL608, DL609, DL610 SERIES

WORK MATERIAL Werkstück	CARBON STEELS ALLOY STEELS Stähle Stahl-Legierungen		TOOL STEELS HARDENED STEELS Werkzeugstähle, gehärtete Stähle		SOFT GREY CAST IRON Weicher Grauguss		HARD GREY CAST IRON Harter Grauguss	
	HARDNESS HRc15 ~ HRc30		HRc20 ~ HRc40					
STRENGTH 700 ~ 1000N/mm ²		800 ~ 1200N/mm ²						
DIAMETER(mm)	N	S	N	S	N	S	N	S
2.0	2630	0.03	2100	0.025	4200	0.06	1680	0.05
2.5	2100	0.04	1680	0.03	3300	0.08	1310	0.06
3.0	1680	0.05	1310	0.04	2630	0.10	1050	0.08
4.0	1310	0.06	1050	0.05	2100	0.13	840	0.10
5.0	1050	0.06	840	0.05	1680	0.13	660	0.10
6.0	840	0.08	660	0.06	1310	0.16	530	0.13
8.0	660	0.10	530	0.08	1050	0.20	420	0.17
10.0	530	0.13	420	0.10	840	0.25	330	0.21
13.0	420	0.13	330	0.10	660	0.25	260	0.21
16.0	330	0.15	260	0.13	530	0.30	210	0.25
20.0	260	0.20	210	0.15	420	0.40	170	0.30
25.0	210	0.25	170	0.20	330	0.50	130	0.50
30.0	170	0.25	130	0.20	260	0.50	110	0.50

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

WORM PATTERN DRILLS