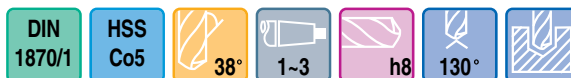
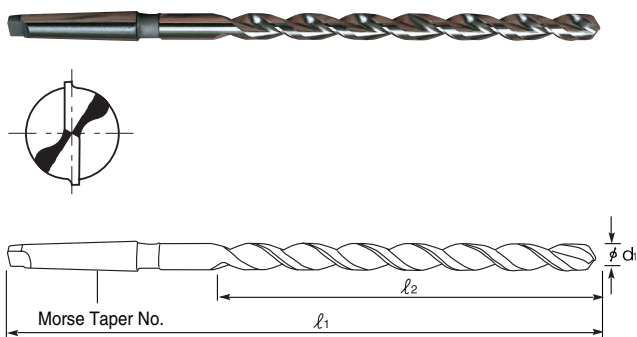


Spiralbohrer für tiefloch mit Morsekegelschaft

Morse Taper Shank Twist Drills for deep hole

ÜBERLANG
EXTRA LONG



P.617

► DH100 worm pattern drills

► **Verwendung** : Standardbohrer zum Bohren extreme tiefer Löcher
Zum Bohren von legiertem und unlegiertem stahl,
Grauguß, Temperguß, Sphäroguß, Druckguß,
Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.

► **Application** : Designed for drilling deep holes or deeply located holes.
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	Morse Taper No.	Art.-Nr. EDP No.	DRILL DIAMETER d ₁	OVERALL LENGTH l ₁	FLUTE LENGTH l ₂	Morse Taper No.
DL609130	13.0	310	205	1	DL609220	22.0	405	270	2
DL609135	13.5	325	220	1	DL609225	22.5	405	270	2
DL609140	14.0	325	220	1	DL609230	23.0	405	270	2
DL609145	14.5	340	220	2	DL609235	23.5	425	270	3
DL609150	15.0	340	220	2	DL609240	24.0	440	290	3
DL609155	15.5	355	230	2	DL609245	24.5	440	290	3
DL609160	16.0	355	230	2	DL609250	25.0	440	290	3
DL609165	16.5	355	230	2	DL609255	25.5	440	290	3
DL609170	17.0	355	230	2	DL609260	26.0	440	290	3
DL609175	17.5	370	245	2	DL609265	26.5	440	290	3
DL609180	18.0	370	245	2	DL609270	27.0	460	305	3
DL609185	18.5	370	245	2	DL609275	27.5	460	305	3
DL609190	19.0	370	245	2	DL609280	28.0	460	305	3
DL609195	19.5	385	260	2	DL609285	28.5	460	305	3
DL609200	20.0	385	260	2	DL609290	29.0	460	305	3
DL609205	20.5	385	260	2	DL609295	29.5	460	305	3
DL609210	21.0	385	260	2	DL609300	30.0	460	305	3
DL609215	21.5	405	270	2	DL609310	31.0	480	320	3

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