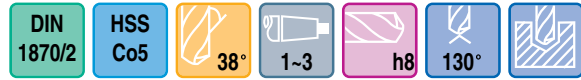
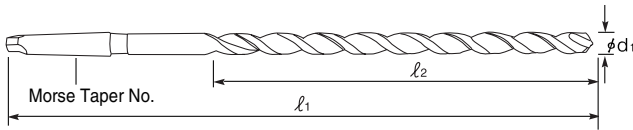
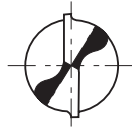


Spiralbohrer für tiefloch mit Morsekegelschaft

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.
DL610130	13.0	395	260	1
DL610135	13.5	410	275	1
DL610140	14.0	410	275	1
DL610145	14.5	425	275	2
DL610150	15.0	425	275	2
DL610155	15.5	445	295	2
DL610160	16.0	445	295	2
DL610165	16.5	445	295	2
DL610170	17.0	445	295	2
DL610175	17.5	465	310	2
DL610180	18.0	465	310	2
DL610185	18.5	465	310	2
DL610190	19.0	465	310	2
DL610195	19.5	490	325	2
DL610200	20.0	490	325	2
DL610205	20.5	490	325	2
DL610210	21.0	490	325	2
DL610215	21.5	515	345	2

Art.-Nr. EDP No.	DRILL DIAMETER d_1	OVERALL LENGTH l_1	FLUTE LENGTH l_2	Morse Taper No.
DL610220	22.0	515	345	2
DL610225	22.5	515	345	2
DL610230	23.0	515	345	2
DL610235	23.5	535	345	3
DL610240	24.0	555	365	3
DL610245	24.5	555	365	3
DL610250	25.0	555	365	3
DL610255	25.5	555	365	3
DL610260	26.0	555	365	3
DL610265	26.5	555	365	3
DL610270	27.0	580	385	3
DL610275	27.5	580	385	3
DL610280	28.0	580	385	3
DL610285	28.5	580	385	3
DL610290	29.0	580	385	3
DL610295	29.5	580	385	3
DL610300	30.0	580	385	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