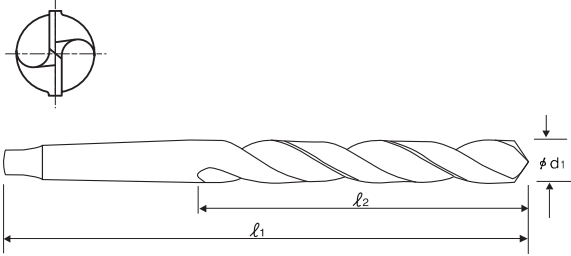


# Spiralbohrer mit Morsekegelschaft

## Morse Taper Shank Twist Drills

KURZ  
SHORT



P.649

- **Verwendung** : Der kurze Bohrer ist geeignet fuer Hochgeschwindigkeitsbohrungen, praezises Positionieren und Durchmesser. Sehr nuetzlich bei Materialien von Karbon- und rostfreiem Stahl bis zu Aluminium.
- **Application** : Short length - designed for high speed drilling in wide materials, carbon steels, stainless steels and aluminum.

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.
DN221070	7.0	125.5	44.5	1	DN221200	20.0	188	90	2
DN221075	7.5	125.5	44.5	1	DN221205	20.5	191	93	2
DN221080	8.0	129.5	48.5	1	DN221210	21.0	191	93	2
DN221085	8.5	129.5	48.5	1	DN221215	21.5	193.5	95.5	2
DN221090	9.0	133	52	1	DN221220	22.0	193.5	95.5	2
DN221095	9.5	133	52	1	DN221225	22.5	197.5	99.5	2
DN221100	10.0	137	56	1	DN221230	23.0	197.5	99.5	2
DN221105	10.5	137	56	1	DN221235	23.5	223.5	102.5	3
DN221110	11.0	142	61	1	DN221240	24.0	223.5	102.5	3
DN221115	11.5	142	61	1	DN221245	24.5	223.5	102.5	3
DN221120	12.0	146.5	65.5	1	DN221250	25.0	223.5	102.5	3
DN221125	12.5	146.5	65.5	1	DN221255	25.5	226	105	3
DN221130	13.0	146.5	65.5	1	DN221260	26.0	226	105	3
DN221135	13.5	150.5	69.5	1	DN221265	26.5	226	105	3
DN221140	14.0	150.5	69.5	1	DN221270	27.0	229.5	108.5	3
DN221145	14.5	171	73	2	DN221275	27.5	229.5	108.5	3
DN221150	15.0	171	73	2	DN221280	28.0	229.5	108.5	3
DN221155	15.5	175	77	2	DN221285	28.5	232	111	3
DN221160	16.0	175	77	2	DN221290	29.0	232	111	3
DN221165	16.5	178.5	80.5	2	DN221295	29.5	232	111	3
DN221170	17.0	178.5	80.5	2	DN221300	30.0	232	111	3
DN221175	17.5	181.5	83.5	2	DN221305	30.5	235	114	3
DN221180	18.0	181.5	83.5	2	DN221310	31.0	235	114	3
DN221185	18.5	184.5	86.5	2	DN221315	31.5	235	114	3
DN221190	19.0	184.5	86.5	2	DN221320	32.0	235	114	3
DN221195	19.5	188	90	2					

MORSE TAPER SHANK DRILLS

# RECOMMENDED CUTTING CONDITIONS

## EMPFOHLENE SCHNEIDKONDITIONEN

### HSSCo5 MORSE TAPER SHANK TWIST DRILLS, TIN COATED

HSSCo5 SPIRALBOHTER MIT MORSEKEGEL SCHAFT, TiN-beschichtet

DN221 SERIES

WORK MATERIAL Werkstück	CARBON STEELS Stähle		ALLOY STEELS Stahl-Legierungen		TOOL STEEL, ALLOY STEELS Werkzeugstähle Stahl-Legierungen		CAST IRON TOOL STEEL Gusseisen Werkzeugstähle		ALUMINIUM ALLOY MAGNESIUM ALLOY Aluminium-Legierungen Magnesium-Legierungen	
	N	S	N	S	N	S	N	S	N	S
8	825	0.15	785	0.15	330	0.15	3460	0.19	3460	0.34
10	700	0.18	620	0.18	250	0.18	2800	0.23	2800	0.40
12	580	0.21	535	0.21	230	0.21	2230	0.27	2230	0.48
14	455	0.25	415	0.25	200	0.25	1980	0.29	1980	0.51
16	430	0.27	390	0.27	175	0.27	1730	0.30	1730	0.55
18	370	0.31	350	0.31	155	0.31	1570	0.33	1570	0.57
20	330	0.33	290	0.33	140	0.33	1320	0.36	1320	0.62
22	305	0.36	280	0.36	132	0.36	1240	0.37	1240	0.68
24	290	0.37	250	0.37	125	0.37	1150	0.42	1150	0.72
26	265	0.40	230	0.40	105	0.40	1070	0.43	1070	0.75
28	250	0.43	215	0.43	100	0.43	990	0.45	990	0.79
30	230	0.45	200	0.45	88	0.45	910	0.53	910	0.83
32	215	0.49	190	0.49	88	0.49	785	0.53	785	0.86

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

MORSE TAPER SHANK DRILLS