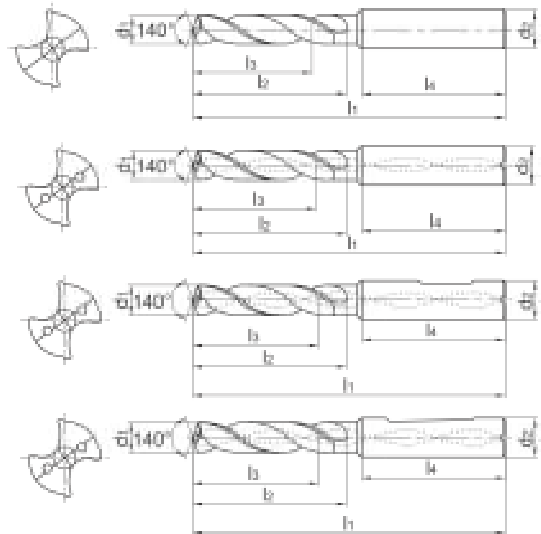
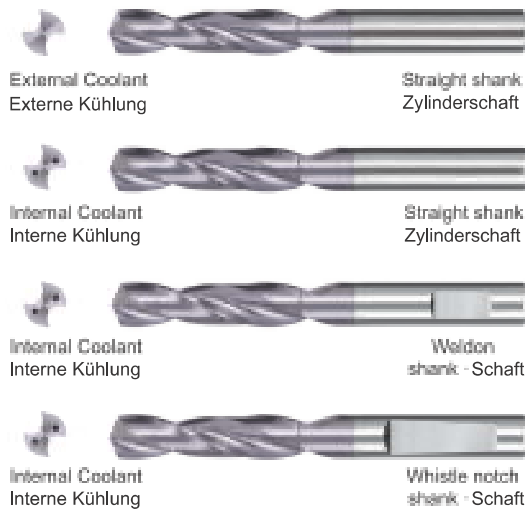


# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L1(d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                          | Type<br>Typ   | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|---------------------------------------|-----------------------------|------------------------------------------|---------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                       |                             |                                          |               | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                       |                             |                                          |               | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 0.9                                  | 3                                     | External<br>Extern          | Straight<br>shank<br>Zylinder-<br>schaft | 1534SU03-0090 | 3                                       | 47                            | 5.4                        | -                                             | -                           | ○              |
| 1.1                                  | 3                                     |                             |                                          | 1534SU03-0110 | 3                                       | 47                            | 6.6                        | -                                             | -                           | ○              |
| 1.47                                 | 3                                     |                             |                                          | 1534SU03-0147 | 3                                       | 47                            | 8.7                        | -                                             | -                           | ○              |
| 1.85                                 | 3                                     |                             |                                          | 1534SU03-0185 | 3                                       | 52                            | 11.1                       | -                                             | -                           | ○              |
| 2.0                                  | 3                                     |                             |                                          | 1534SU03-0200 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0200 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
| 2.1                                  | 3                                     |                             |                                          | 1534SU03-0210 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0210 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
| 2.2                                  | 3                                     |                             |                                          | 1534SU03-0220 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0220 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
| 2.3                                  | 3                                     |                             |                                          | 1534SU03-0230 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0230 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
| 2.33                                 | 3                                     |                             |                                          | 1534SU03-0230 | 3                                       | 59                            | 13.8                       | -                                             | -                           | ○              |
| 2.4                                  | 3                                     |                             |                                          | 1534SU03-0240 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0240 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
| 2.5                                  | 3                                     |                             |                                          | 1534SU03-0250 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0250 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
| 2.6                                  | 3                                     |                             |                                          | 1534SU03-0260 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0260 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
| 2.7                                  | 3                                     |                             |                                          | 1534SU03-0270 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0270 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
| 2.8                                  | 3                                     |                             |                                          | 1534SU03-0280 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                          | 1536SU05-0280 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                  |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 2.9                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0290  | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0290  | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
| 3.0                                               | 3                                                  |                             | Zylinder-<br>schaft              | 1534SU03-0300  | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0300  | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                  | 1534SU03C-0300 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0300 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft          | 1634SU03C-0300 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0300 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0300 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0300 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 8                                                  |                             | straight shank<br>Zylinderschaft | 1538SU08C-0300 | 6                                       | 72                            | 34                         | 29                                             | 36                          | ●              |
|                                                   |                                                    |                             |                                  |                |                                         |                               |                            |                                                |                             |                |
| 3.1                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0310  | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0310  | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Zylinder-<br>schaft              | 1534SU03C-0310 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0310 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft          | 1634SU05C-0310 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0310 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0310 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0310 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 8                                                  |                             |                                  | 1538SU08C-0310 | 6                                       | 72                            | 34                         | 29                                             | 36                          | ●              |
|                                                   |                                                    |                             |                                  |                |                                         |                               |                            |                                                |                             |                |
| 3.2                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0320  | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0320  | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Zylinder-<br>schaft              | 1534SU03C-0320 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0320 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft          | 1634SU03C-0320 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0320 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0320 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0320 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 8                                                  |                             |                                  | 1538SU08C-0320 | 6                                       | 72                            | 34                         | 29                                             | 36                          | ●              |
|                                                   |                                                    |                             |                                  |                |                                         |                               |                            |                                                |                             |                |
| 3.25                                              | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0325  | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0325  | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Zylinder-<br>schaft              | 1534SU03C-0325 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0325 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft          | 1634SU03C-0325 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ○              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0325 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ○              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0325 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0325 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

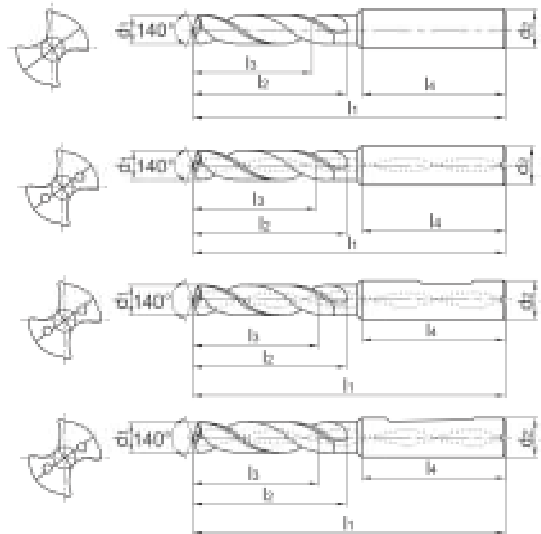
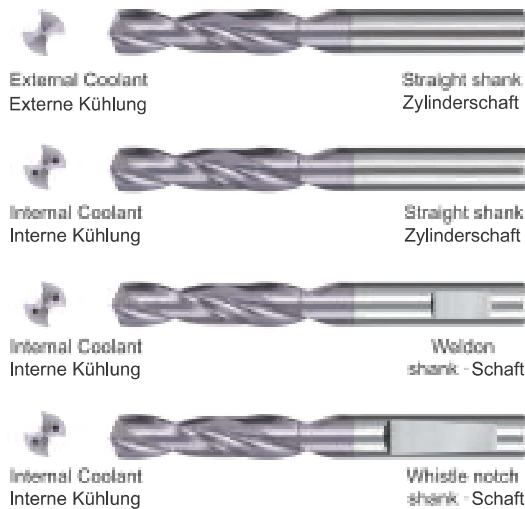
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L(d1) | Cooling mode<br>Kühlmittel | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|--------------------------------------|----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                      |                            |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                      |                            |                                  |                | d2(h8)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 3.3                                  | 3                                    | External<br>Extern         | Straight<br>shank                | 1534SU03-0330  | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1536SU05-0330  | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    | Internal<br>Intern         | Zylinder-<br>schaft              | 1534SU03C-0330 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1536SU05C-0330 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    |                            | Weldon<br>shank/ Schaft          | 1634SU03C-0330 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1636SU05C-0330 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    |                            | Whistle notch<br>shank/ Schaft   | 1734SU03C-0330 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1736SU05C-0330 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 8                                    |                            |                                  | 1538SU08C-0330 | 6                                       | 72                            | 34                         | 29                                            | 36                          | ●              |
| 3.4                                  | 3                                    | External<br>Extern         | Straight<br>shank                | 1534SU03-0340  | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1536SU05-0340  | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    | Internal<br>Intern         | Zylinder-<br>schaft              | 1534SU03C-0340 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1536SU05C-0340 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    |                            | Weldon<br>shank/ Schaft          | 1634SU03C-0340 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1636SU05C-0340 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    |                            | Whistle notch<br>shank/ Schaft   | 1734SU03C-0340 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1736SU05C-0340 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 8                                    |                            |                                  | 1538SU08C-0340 | 6                                       | 72                            | 34                         | 29                                            | 36                          | ●              |
| 3.5                                  | 3                                    | External<br>Extern         | Straight<br>shank                | 1534SU03-0350  | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1536SU05-0350  | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    | Internal<br>Intern         | Zylinder-<br>schaft              | 1534SU03C-0350 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1536SU05C-0350 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    |                            | Weldon<br>shank/ Schaft          | 1634SU03C-0350 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1636SU05C-0350 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 3                                    |                            | Whistle notch<br>shank/ Schaft   | 1734SU03C-0350 | 6                                       | 62                            | 20                         | 14                                            | 36                          | ●              |
|                                      | 5                                    |                            |                                  | 1736SU05C-0350 | 6                                       | 66                            | 28                         | 23                                            | 36                          | ●              |
|                                      | 8                                    |                            | straight shank<br>Zylinderschaft | 1538SU08C-0350 | 6                                       | 72                            | 34                         | 29                                            | 36                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) • Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 3.6                                               | 3                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-0360  | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05-0360  | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-0360 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-0360 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-0360 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-0360 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-0360 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-0360 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
| 3.7                                               | 8                                                  | External<br>Extern          | Straight<br>shank              | 1538SU08C-0360 | 6                                       | 72                            | 34                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0370  | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-0370  | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-0370 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05C-0370 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1634SU03C-0370 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
|                                                   | 5                                                  |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-0370 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-0370 | 6                                       | 62                            | 20                         | 14                                             | 36                          | ●              |
| 3.8                                               | 5                                                  | External<br>Extern          | Zylinder-<br>schaft            | 1736SU05C-0370 | 6                                       | 66                            | 28                         | 23                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1538SU08C-0370 | 6                                       | 72                            | 34                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Straight<br>shank              | 1534SU03-0380  | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1536SU05-0380  | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             | Zylinder-<br>schaft            | 1534SU03C-0380 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1536SU05C-0380 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-0380 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1636SU05C-0380 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
| 3.9                                               | 5                                                  | External<br>Extern          | Zylinder-<br>schaft            | 1734SU03C-0380 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1736SU05C-0380 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1538SU08C-0380 | 6                                       | 81                            | 43                         | 36                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0390  | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                             | Zylinder-<br>schaft            | 1536SU05-0390  | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-0390 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05C-0390 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1634SU03C-0390 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
| 4.0                                               | 5                                                  | External<br>Extern          | Zylinder-<br>schaft            | 1636SU05C-0390 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-0390 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Whistle notch<br>shank/ Schaft | 1736SU05C-0390 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1538SU08C-0390 | 6                                       | 81                            | 43                         | 36                                             | 36                          | ●              |
| 4.0                                               | 5                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-0400  | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1536SU05-0400  | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-0400 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1536SU05C-0400 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |

✓ = Very suitable • Sehr empfohlen  
✓ = Suitable • Empfohlen

### Material Overview • Material Übersicht

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

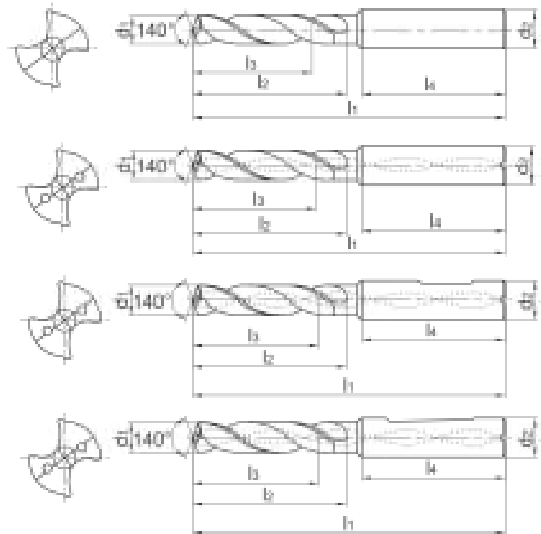
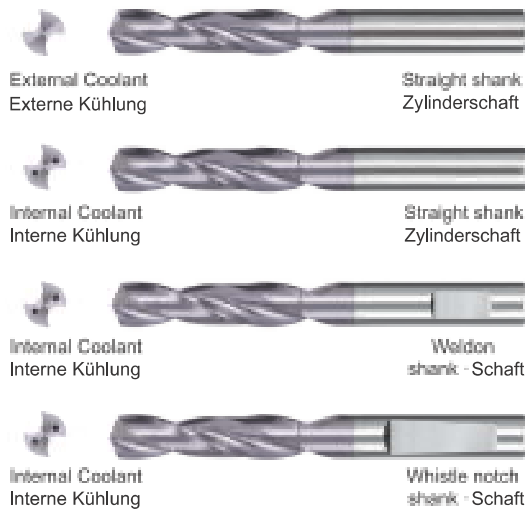
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|-------------------------------------|----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                     |                            |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                     |                            |                                |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 4.0                                  | 3                                   | Internal<br>Intern         | Weldon<br>shank/ Schaft        | 1634SU03C-0400 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1636SU05C-0400 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 3                                   |                            | Whistle notch<br>shank/ Schaft | 1734SU03C-0400 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1736SU05C-0400 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 8                                   |                            | Straight<br>shank              | 1538SU08C-0400 | 6                                       | 81                            | 43                         | 36                                            | 36                          | ●              |
| 4.1                                  | 3                                   | External<br>Extern         | Straight<br>shank              | 1534SU03-0410  | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1536SU05-0410  | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 3                                   |                            | Zylinder-<br>schaft            | 1534SU03C-0410 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1536SU05C-0410 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Weldon<br>shank/Schaft         | 1634SU03C-0410 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1636SU05C-0410 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 3                                   |                            | Whistle notch<br>shank/ Schaft | 1734SU03C-0410 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1736SU05C-0410 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 8                                   |                            | Straight<br>shank              | 1538SU08C-0410 | 6                                       | 81                            | 43                         | 36                                            | 36                          | ●              |
|                                      | 3                                   |                            |                                | 1534SU03-0420  | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
| 4.2                                  | 5                                   | External<br>Extern         | Zylinder-<br>schaft            | 1536SU05-0420  | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 3                                   |                            |                                | 1534SU03C-0420 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            | Weldon<br>shank/ Schaft        | 1536SU05C-0420 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 3                                   |                            |                                | 1634SU03C-0420 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   | Internal<br>Intern         | Weldon<br>shank/ Schaft        | 1636SU05C-0420 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 3                                   |                            |                                | 1734SU03C-0420 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            | Whistle notch<br>shank/ Schaft | 1736SU05C-0420 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 8                                   |                            |                                | 1538SU08C-0420 | 6                                       | 81                            | 43                         | 36                                            | 36                          | ●              |
|                                      | 3                                   |                            | Straight<br>shank              | 1534SU03-0430  | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1536SU05-0430  | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
| 4.3                                  | 3                                   | External<br>Extern         | Zylinder-<br>schaft            | 1534SU03C-0430 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1536SU05C-0430 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Zylinder-<br>schaft            | 1534SU03C-0430 | 6                                       | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                | 1536SU05C-0430 | 6                                       | 74                            | 36                         | 29                                            | 36                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel | Shank<br>Schaft               | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|----------------------------|-------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                            |                               |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                            |                               |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 4.3                                               | 3                                                  | Internal<br>Intern         | Weldon<br>shank/Schaft        | 1634SU03C-0430 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1636SU05C-0430 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/Schaft | 1734SU03C-0430 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1736SU05C-0430 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 8                                                  |                            | Zylinderschaft                | 1538SU08C-0430 | 6                                       | 81                            | 43                         | 36                                             | 36                          | ●              |
| 4.4                                               | 3                                                  | External<br>Extern         | Straight<br>shank             | 1534SU03-0440  | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1536SU05-0440  | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Zylinder-<br>schaft           | 1534SU03C-0440 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1536SU05C-0440 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern         | Weldon<br>shank/Schaft        | 1634SU03C-0440 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1636SU05C-0440 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/Schaft | 1734SU03C-0440 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1736SU05C-0440 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 8                                                  |                            |                               | 1538SU08C-0440 | 6                                       | 81                            | 43                         | 36                                             | 36                          | ●              |
| 4.5                                               | 3                                                  | External<br>Extern         | Straight<br>shank             | 1534SU03-0450  | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1536SU05-0450  | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Zylinder-<br>schaft           | 1534SU03C-0450 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1536SU05C-0450 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern         | Weldon<br>shank/Schaft        | 1634SU03C-0450 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1636SU05C-0450 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/Schaft | 1734SU03C-0450 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1736SU05C-0450 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 8                                                  |                            |                               | 1538SU08C-0450 | 6                                       | 81                            | 43                         | 36                                             | 36                          | ●              |
| 4.6                                               | 3                                                  | External<br>Extern         | Straight<br>shank             | 1534SU03-0460  | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1536SU05-0460  | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Zylinder-<br>schaft           | 1534SU03C-0460 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1536SU05C-0460 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern         | Weldon<br>shank/Schaft        | 1634SU03C-0460 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1636SU05C-0460 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/Schaft | 1734SU03C-0460 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1736SU05C-0460 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 8                                                  |                            |                               | 1538SU08C-0460 | 6                                       | 81                            | 43                         | 36                                             | 36                          | ●              |
| 4.65                                              | 3                                                  | External<br>Extern         | Straight<br>shank             | 1534SU03-0465  | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1536SU05-0465  | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Zylinder-<br>schaft           | 1534SU03C-0465 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1536SU05C-0465 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern         | Weldon<br>shank/Schaft        | 1634SU03C-0465 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ○              |
|                                                   | 5                                                  |                            |                               | 1636SU05C-0465 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/Schaft | 1734SU03C-0465 | 6                                       | 66                            | 24                         | 17                                             | 36                          | ●              |
|                                                   | 5                                                  |                            |                               | 1736SU05C-0465 | 6                                       | 74                            | 36                         | 29                                             | 36                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

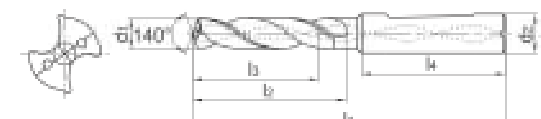
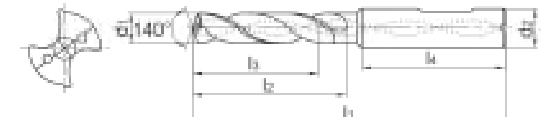
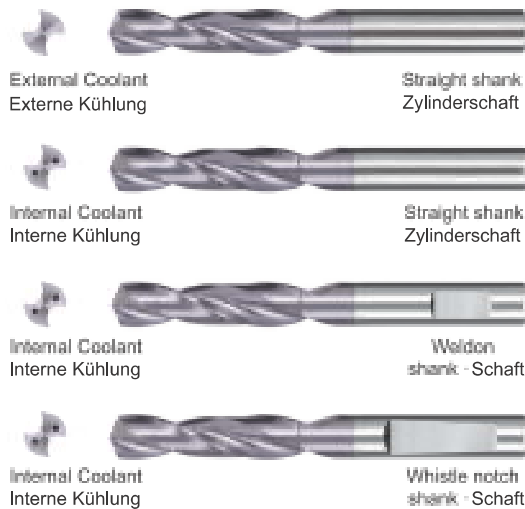
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1 (mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension (mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|---------------------------------------|-------------------------------------|----------------------------|----------------------------------|----------------|------------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                       |                                     |                            |                                  |                | Shank diameter Ø<br>Schaftdurchmesser    | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                       |                                     |                            |                                  |                | d2 (h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 4.7                                   | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-0470  | 6                                        | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-0470  | 6                                        | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                       | 3                                   | Internal<br>Intern         | Zylinderschaft                   | 1534SU03C-0470 | 6                                        | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0470 | 6                                        | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                       | 3                                   |                            | Weldon shank / Schaft            | 1634SU03C-0470 | 6                                        | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0470 | 6                                        | 74                            | 36                         | 29                                            | 36                          | ●              |
|                                       | 3                                   |                            | Whistle notch shank / Schaft     | 1734SU03C-0470 | 6                                        | 66                            | 24                         | 17                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-0470 | 6                                        | 74                            | 36                         | 29                                            | 36                          | ●              |
| 4.8                                   | 8                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1538SU08C-0470 | 6                                        | 81                            | 43                         | 36                                            | 36                          | ●              |
|                                       | 3                                   |                            |                                  | 1534SU03-0480  | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   | Internal<br>Intern         | Zylinderschaft                   | 1536SU05-0480  | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   |                            |                                  | 1534SU03C-0480 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0480 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   |                            | Weldon shank / Schaft            | 1634SU03C-0480 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0480 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   |                            | Whistle notch shank / Schaft     | 1734SU03C-0480 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
| 4.9                                   | 5                                   | External<br>Extern         | Zylinderschaft                   | 1736SU05C-0480 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 8                                   |                            |                                  | 1538SU08C-0480 | 6                                        | 95                            | 57                         | 48                                            | 36                          | ●              |
|                                       | 3                                   | Internal<br>Intern         | Straight shank<br>Zylinderschaft | 1534SU03-0490  | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-0490  | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   |                            | Zylinderschaft                   | 1534SU03C-0490 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0490 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   |                            | Weldon shank / Schaft            | 1634SU03C-0490 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0490 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   |                            | Whistle notch shank / Schaft     | 1734SU03C-0490 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-0490 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
| 4.9                                   | 8                                   | Internal<br>Intern         | straight shank<br>Zylinderschaft | 1538SU08C-0490 | 6                                        | 95                            | 57                         | 48                                            | 36                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                  |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 5.0                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0500  | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0500  | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0500 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0500 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0500 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ○              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0500 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0500 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0500 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 8                                                  |                             |                                  | 1538SU08C-0500 | 6                                       | 95                            | 57                         | 48                                             | 36                          | ●              |
| 5.1                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0510  | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0510  | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0510 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0510 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0510 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0510 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0510 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0510 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 8                                                  |                             |                                  | 1538SU08C-0510 | 6                                       | 95                            | 57                         | 48                                             | 36                          | ●              |
| 5.2                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0520  | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0520  | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0520 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0520 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0520 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0520 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0520 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0520 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 8                                                  |                             |                                  | 1538SU08C-0520 | 6                                       | 95                            | 57                         | 48                                             | 36                          | ●              |
| 5.3                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0530  | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0530  | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0530 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0530 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0530 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0530 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0530 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0530 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 8                                                  |                             | straight shank<br>Zylinderschaft | 1538SU08C-0530 | 6                                       | 95                            | 57                         | 48                                             | 36                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | ~40HRC                            | ~50HRC | ~60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 96-109  
Schnittdaten

Technical Information C110-116  
Technische Information

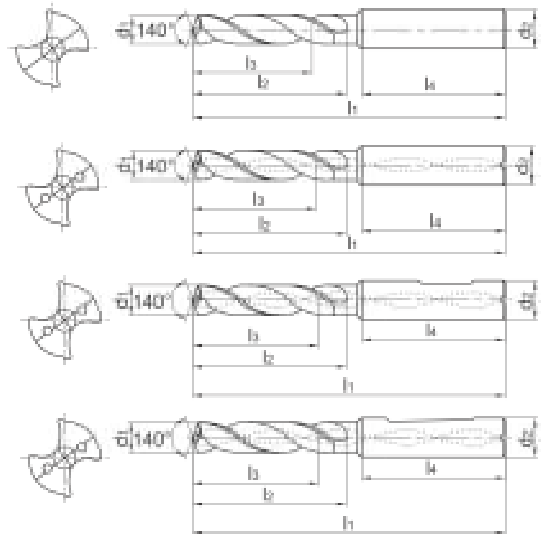
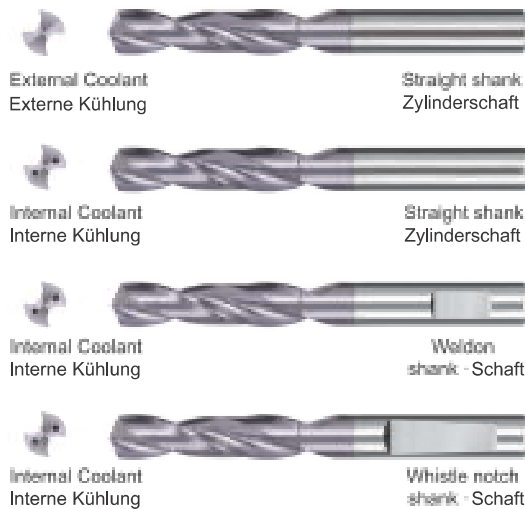
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ             | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|---------------------------------------|-----------------------------|--------------------------------|-------------------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                       |                             |                                |                         | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                       |                             |                                |                         | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          | KDGS303        |
| 5.4                                  | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-0540           | 6                                       | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-0540           | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-0540          | 6                                       | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-0540          | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-0540          | 6                                       | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-0540          | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-0540          | 6                                       | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-0540          | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 8                                     | Straight<br>shank           | 1538SU08C-0540                 | 6                       | 95                                      | 57                            | 48                         | 36                                            | ●                           |                |
| 3                                    | 1534SU03-0550                         |                             | 6                              | 66                      | 28                                      | 20                            | 36                         | ●                                             |                             |                |
| 5.5                                  | 5                                     | External<br>Extern          | Zylinder-<br>schaft            | 1536SU05-0550           | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 3                                     |                             |                                | 1534SU03C-0550          | 6                                       | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                      | 5                                     | Internal<br>Intern          | 1536SU05C-0550                 | 6                       | 82                                      | 44                            | 35                         | 36                                            | ●                           |                |
|                                      | 3                                     |                             |                                | Weldon<br>shank/ Schaft | 1634SU03C-0550                          | 6                             | 66                         | 28                                            | 20                          | 36             |
|                                      | 5                                     |                             | 1636SU05C-0550                 |                         | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-0550          | 6                                       | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-0550          | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 8                                     |                             | Straight<br>shank              | 1538SU08C-0550          | 6                                       | 95                            | 57                         | 48                                            | 36                          | ●              |
|                                      | 3                                     | 1534SU03-0555               |                                | 6                       | 66                                      | 28                            | 20                         | 36                                            | ●                           |                |
| 5.55                                 | 5                                     | External<br>Extern          | Zylinder-<br>schaft            | 1536SU05-0555           | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 3                                     |                             |                                | 1534SU03C-0555          | 6                                       | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                      | 5                                     | Internal<br>Intern          | 1536SU05C-0555                 | 6                       | 82                                      | 44                            | 35                         | 36                                            | ●                           |                |
|                                      | 3                                     |                             |                                | Weldon<br>shank/ Schaft | 1634SU03C-0555                          | 6                             | 66                         | 28                                            | 20                          | 36             |
|                                      | 5                                     |                             | 1636SU05C-0555                 |                         | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-0555          | 6                                       | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-0555          | 6                                       | 82                            | 44                         | 35                                            | 36                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                  |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 5.6                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0560  | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0560  | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0560 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0560 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0560 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0560 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0560 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0560 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
| 5.7                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0570  | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0570  | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0570 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0570 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0570 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0570 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0570 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0570 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
| 5.8                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0580  | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0580  | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0580 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0580 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0580 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0580 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0580 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0580 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
| 5.9                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0590  | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0590  | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0590 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0590 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/Schaft           | 1634SU03C-0590 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0590 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0590 | 6                                       | 66                            | 28                         | 20                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0590 | 6                                       | 82                            | 44                         | 35                                             | 36                          | ●              |
| 5.9                                               | 8                                                  | External<br>Extern          | straight shank<br>Zylinderschaft | 1538SU08C-0590 | 6                                       | 95                            | 57                         | 48                                             | 36                          | ●              |
|                                                   |                                                    |                             |                                  |                |                                         |                               |                            |                                                |                             |                |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

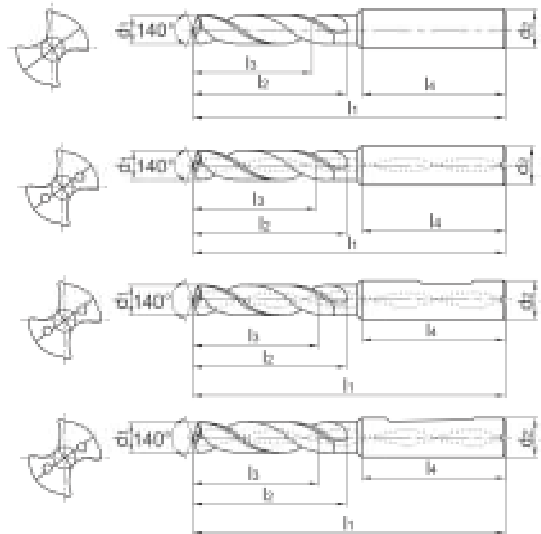
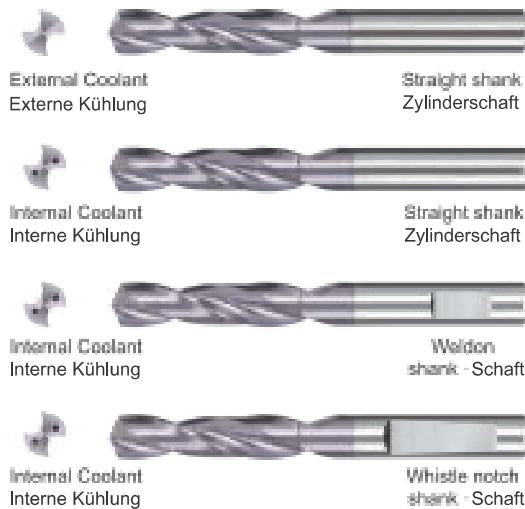
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1 (mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension (mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|---------------------------------------|-------------------------------------|----------------------------|----------------------------------|----------------|------------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                       |                                     |                            |                                  |                | Shank diameter Ø<br>Schaftdurchmesser    | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                       |                                     |                            |                                  |                | d2 (h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 6.0                                   | 3                                   | External<br>Extern         | Straight<br>shank                | 1534SU03-0600  | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-0600  | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   | Internal<br>Intern         | Zylinder-<br>schaft              | 1534SU03C-0600 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0600 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   |                            | Weldon<br>shank/ Schaft          | 1634SU03C-0600 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0600 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
|                                       | 3                                   |                            | Whistle notch<br>shank/ Schaft   | 1734SU03C-0600 | 6                                        | 66                            | 28                         | 20                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-0600 | 6                                        | 82                            | 44                         | 35                                            | 36                          | ●              |
| 6.1                                   | 8                                   | External<br>Extern         | Straight<br>shank                | 1538SU08C-0600 | 6                                        | 95                            | 57                         | 48                                            | 36                          | ●              |
|                                       | 3                                   |                            |                                  | 1534SU03-0610  | 8                                        | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-0610  | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            | Zylinder-<br>schaft              | 1534SU03C-0610 | 8                                        | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0610 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            |                                  | 1634SU03C-0610 | 8                                        | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0610 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            |                                  | 1734SU03C-0610 | 8                                        | 79                            | 34                         | 24                                            | 36                          | ●              |
| 6.2                                   | 5                                   |                            |                                  | 1736SU05C-0610 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 8                                   |                            |                                  | 1538SU08C-0610 | 8                                        | 114                           | 76                         | 66                                            | 36                          | ●              |
|                                       | 3                                   | External<br>Extern         | Straight<br>shank                | 1534SU03-0620  | 8                                        | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-0620  | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            | Zylinder-<br>schaft              | 1534SU03C-0620 | 8                                        | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0620 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            | Weldon<br>shank/ Schaft          | 1634SU03C-0620 | 8                                        | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0620 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   | Internal<br>Intern         | Whistle notch<br>shank/ Schaft   | 1734SU03C-0620 | 8                                        | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-0620 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
| 6.2                                   | 8                                   |                            | straight shank<br>Zylinderschaft | 1538SU08C-0620 | 8                                        | 114                           | 76                         | 66                                            | 36                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                  |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 6.3                                               | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-0630  | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0630  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-0630 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0630 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0630 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0630 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0630 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0630 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
| 6.4                                               | 8                                                  | External<br>Extern          | Straight<br>shank                | 1538SU08C-0630 | 8                                       | 114                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                  | 1534SU03-0640  | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1536SU05-0640  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                  | 1534SU03C-0640 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0640 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0640 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0640 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-0640 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
| 6.5                                               | 5                                                  |                             |                                  | 1736SU05C-0640 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 8                                                  | External<br>Extern          | Straight<br>shank                | 1538SU08C-0650 | 8                                       | 114                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                  | 1534SU03-0650  | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1536SU05-0650  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                  | 1534SU03C-0650 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0650 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-0650 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0650 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
| 6.6                                               | 3                                                  | External<br>Extern          | Zylinder-<br>schaft              | 1734SU03C-0650 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0650 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 8                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft          | 1538SU08C-0660 | 8                                       | 114                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                  | 1534SU03-0660  | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0660  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1534SU03C-0660 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0660 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1634SU03C-0660 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0660 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
| 6.6                                               | 8                                                  | External<br>Extern          | straight shank<br>Zylinderschaft | 1734SU03C-0660 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0660 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 8                                                  | Internal<br>Intern          | straight shank<br>Zylinderschaft | 1538SU08C-0660 | 8                                       | 114                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                  | 1534SU03-0660  | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0660  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1534SU03C-0660 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0660 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1634SU03C-0660 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0660 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | ~40HRC                            | ~50HRC | ~60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

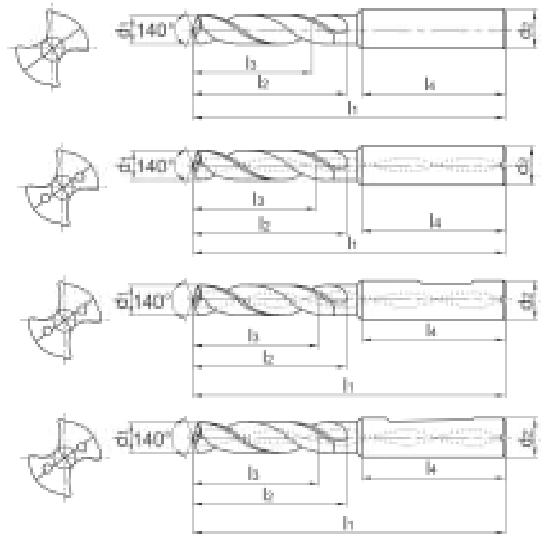
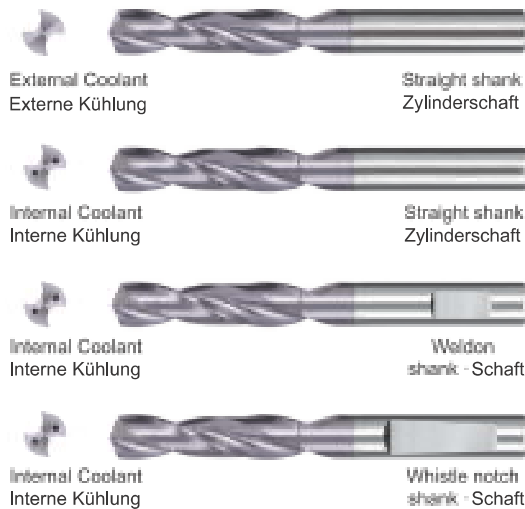
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

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## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|-------------------------------------|----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                     |                            |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                     |                            |                                  |                | d2(h8)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 6.7                                  | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-0670  | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05-0670  | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Straight shank<br>Zylinderschaft | 1534SU03C-0670 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05C-0670 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   |                            | Weldon shank/ Schaft             | 1634SU03C-0670 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1636SU05C-0670 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   |                            | Whistle notch shank/ Schaft      | 1734SU03C-0670 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1736SU05C-0670 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
| 6.75                                 | 8                                   |                            |                                  | 1538SU08C-0670 | 8                                       | 114                           | 76                         | 66                                            | 36                          | ●              |
|                                      | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-0675  | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05-0675  | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Straight shank<br>Zylinderschaft | 1534SU03C-0675 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05C-0675 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   |                            | Weldon shank/ Schaft             | 1634SU03C-0675 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1636SU05C-0675 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   |                            | Whistle notch shank/ Schaft      | 1734SU03C-0675 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1736SU05C-0675 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
| 6.8                                  | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-0680  | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05-0680  | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Straight shank<br>Zylinderschaft | 1534SU03C-0680 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05C-0680 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   |                            | Weldon shank/ Schaft             | 1634SU03C-0680 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1636SU05C-0680 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                   |                            | Whistle notch shank/ Schaft      | 1734SU03C-0680 | 8                                       | 79                            | 34                         | 24                                            | 36                          | ●              |
|                                      | 5                                   |                            |                                  | 1736SU05C-0680 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 8                                   |                            | straight shank<br>Zylinderschaft | 1538SU08C-0680 | 8                                       | 114                           | 76                         | 66                                            | 36                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 6.9                                               | 3                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-0690  | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05-0690  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-0690 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-0690 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-0690 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-0690 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-0690 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-0690 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
| 7.0                                               | 8                                                  | External<br>Extern          | Straight<br>shank              | 1538SU08C-0690 | 8                                       | 114                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0700  | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-0700  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-0700 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-0700 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-0700 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-0700 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-0700 | 8                                       | 79                            | 34                         | 24                                             | 36                          | ●              |
| 7.1                                               | 5                                                  |                             |                                | 1736SU05C-0700 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 8                                                  | External<br>Extern          | Straight<br>shank              | 1538SU08C-0700 | 8                                       | 116                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0710  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-0710  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-0710 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-0710 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-0710 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-0710 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
| 7.2                                               | 3                                                  | External<br>Extern          | Zylinder-<br>schaft            | 1734SU03C-0710 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-0710 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 8                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1538SU08C-0710 | 8                                       | 116                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0720  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05-0720  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1534SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1634SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
| 7.2                                               | 8                                                  | External<br>Extern          | Zylinder-<br>schaft            | 1734SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1538SU08C-0720 | 8                                       | 116                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1534SU03-0720  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05-0720  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1534SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1536SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1634SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
| 7.2                                               | 8                                                  | External<br>Extern          | Zylinder-<br>schaft            | 1636SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1736SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1538SU08C-0720 | 8                                       | 116                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1534SU03-0720  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05-0720  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1534SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1536SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1634SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
| 7.2                                               | 8                                                  | External<br>Extern          | Zylinder-<br>schaft            | 1636SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1736SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1538SU08C-0720 | 8                                       | 116                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1534SU03-0720  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05-0720  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1534SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1536SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1634SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
| 7.2                                               | 8                                                  | External<br>Extern          | Zylinder-<br>schaft            | 1636SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1736SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 3                                                  |                             |                                | 1538SU08C-0720 | 8                                       | 116                           | 76                         | 66                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1534SU03-0720  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05-0720  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1534SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1536SU05C-0720 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●              |
|                                                   | 5                                                  |                             |                                | 1634SU03C-0720 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

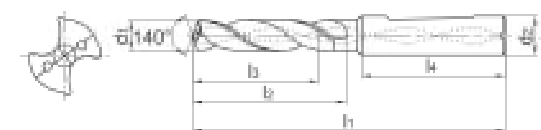
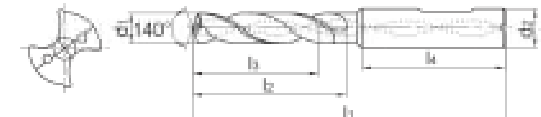
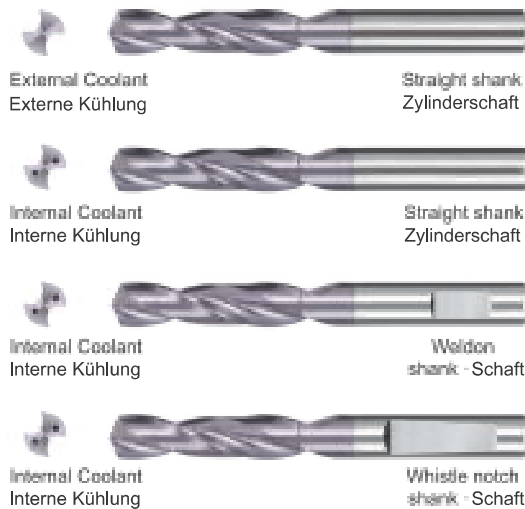
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1 (mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension (mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|---------------------------------------|-------------------------------------|----------------------------|----------------------------------|----------------|------------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                       |                                     |                            |                                  |                | Shank diameter Ø<br>Schaftdurchmesser    | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                       |                                     |                            |                                  |                | d2 (h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 7.3                                   | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-0730  | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-0730  | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   | Internal<br>Intern         | Zylinderschaft                   | 1534SU03C-0730 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0730 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            | Weldon shank / Schaft            | 1634SU03C-0730 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0730 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            | Whistle notch shank / Schaft     | 1734SU03C-0730 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-0730 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 8                                   |                            |                                  | 1538SU08C-0730 | 8                                        | 116                           | 76                         | 66                                            | 36                          | ●              |
| 7.4                                   | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-0740  | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-0740  | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   | Internal<br>Intern         | Zylinderschaft                   | 1534SU03C-0740 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0740 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            | Weldon shank / Schaft            | 1634SU03C-0740 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0740 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 3                                   |                            | Whistle notch shank / Schaft     | 1734SU03C-0740 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-0740 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                       | 8                                   |                            |                                  | 1538SU08C-0740 | 8                                        | 116                           | 76                         | 66                                            | 36                          | ●              |
| 7.45                                  | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-0745  | 8                                        | 79                            | 41                         | 29                                            | 36                          | ○              |
|                                       | 5                                   |                            |                                  | 1536SU05-0745  | 8                                        | 91                            | 53                         | 43                                            | 36                          | ○              |
|                                       | 3                                   | Internal<br>Intern         | Zylinderschaft                   | 1534SU03C-0745 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ○              |
|                                       | 5                                   |                            |                                  | 1536SU05C-0745 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ○              |
|                                       | 3                                   |                            | Weldon shank / Schaft            | 1634SU03C-0745 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ○              |
|                                       | 5                                   |                            |                                  | 1636SU05C-0745 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ○              |
|                                       | 3                                   |                            | Whistle notch shank / Schaft     | 1734SU03C-0745 | 8                                        | 79                            | 41                         | 29                                            | 36                          | ○              |
|                                       | 5                                   |                            |                                  | 1736SU05C-0745 | 8                                        | 91                            | 53                         | 43                                            | 36                          | ○              |
| 7.5                                   | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-0750  | 8                                        | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-0750  | 8                                        | 91                            | 53                         | 43                                            | 36                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (m7) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) • Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte<br><br>KDG303 |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|------------------------------|
|                                                   |                                                    |                             |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                              |
|                                                   |                                                    |                             |                                  |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                              |
| 7.5                                               | 3                                                  | Internal<br>Intern          | Straight shank<br>Zylinderschaft | 1534SU03C-0750 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0750 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             |                                  | 1634SU03C-0750 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             | Weldon shank/ Schaft             | 1636SU05C-0750 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             |                                  | 1734SU03C-0750 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             | Whistle notch shank/ Schaft      | 1736SU05C-0750 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 8                                                  |                             |                                  | 1538SU08C-0750 | 8                                       | 116                           | 76                         | 66                                             | 36                          | ●                            |
| 7.6                                               | 3                                                  | External<br>Extern          | Straight shank                   | 1534SU03-0760  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0760  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             | Zylinder-schaft                  | 1534SU03C-0760 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0760 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon shank/ Schaft             | 1634SU03C-0760 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0760 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             | Whistle notch shank/ Schaft      | 1734SU03C-0760 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0760 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 8                                                  |                             | 1538SU08C-0760                   | 8              | 116                                     | 76                            | 66                         | 36                                             | 36                          | ●                            |
| 7.7                                               | 3                                                  | External<br>Extern          | Straight shank                   | 1534SU03-0770  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0770  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             | Zylinder-schaft                  | 1534SU03C-0770 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0770 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon shank/ Schaft             | 1634SU03C-0770 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0770 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             | Whistle notch shank/ Schaft      | 1734SU03C-0770 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0770 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 8                                                  |                             | 1538SU08C-0770                   | 8              | 116                                     | 76                            | 66                         | 36                                             | 36                          | ●                            |
| 7.8                                               | 3                                                  | External<br>Extern          | Straight shank                   | 1534SU03-0780  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0780  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             | Zylinder-schaft                  | 1534SU03C-0780 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0780 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon shank/ Schaft             | 1634SU03C-0780 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0780 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             | Whistle notch shank/ Schaft      | 1734SU03C-0780 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-0780 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 8                                                  |                             | 1538SU08C-0780                   | 8              | 116                                     | 76                            | 66                         | 36                                             | 36                          | ●                            |
| 7.9                                               | 3                                                  | External<br>Extern          | Straight shank                   | 1534SU03-0790  | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05-0790  | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  |                             | Zylinder-schaft                  | 1534SU03C-0790 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-0790 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon shank/ Schaft             | 1634SU03C-0790 | 8                                       | 79                            | 41                         | 29                                             | 36                          | ●                            |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-0790 | 8                                       | 91                            | 53                         | 43                                             | 36                          | ●                            |

### Material Overview • Material Übersicht

✓ = Very suitable • Sehr empfohlen  
✓ = Suitable • Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

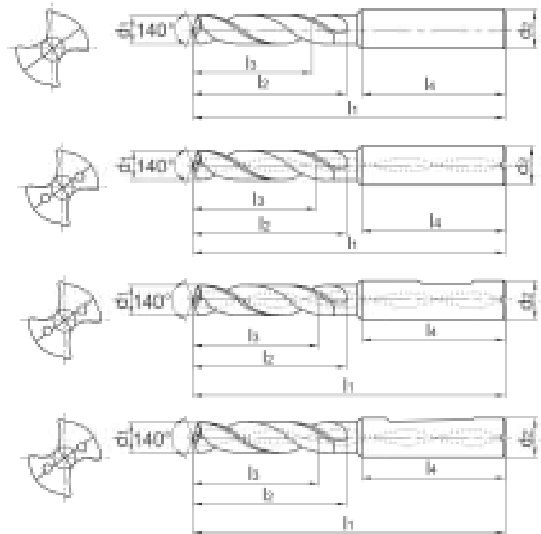
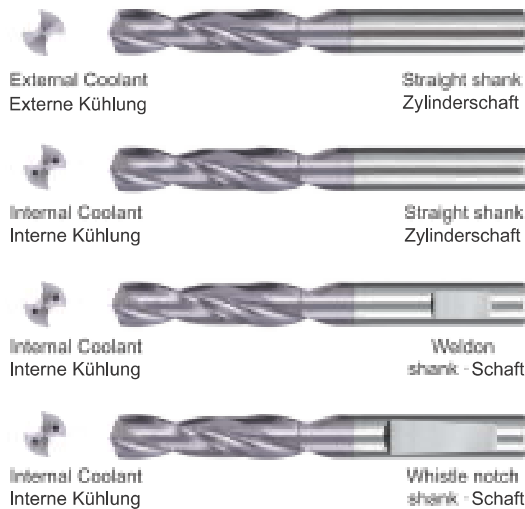
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ                    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|---------------------------------------|-----------------------------|--------------------------------|--------------------------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                       |                             |                                |                                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                       |                             |                                |                                | d2(h8)                                  | l1                            | l2                         | l3                                            | l4                          | KD G303        |
| 7.9                                  | 3                                     | Internal<br>Intern          | Whistle notch<br>shank/ Schaft | 1734SU03C-0790                 | 8                                       | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-0790                 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 8                                     |                             |                                | 1538SU08C-0790                 | 8                                       | 116                           | 76                         | 66                                            | 36                          | ●              |
| 8.0                                  | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-0800                  | 8                                       | 79                            | 41                         | 29                                            | 36                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-0800                  | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                     |                             |                                | Zylinder-<br>schaft            | 1534SU03C-0800                          | 8                             | 79                         | 41                                            | 29                          | 36             |
|                                      | 5                                     | 1536SU05C-0800              | 8                              |                                | 91                                      | 53                            | 43                         | 36                                            | ●                           |                |
|                                      | 3                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        |                                | 1634SU03C-0800                          | 8                             | 79                         | 41                                            | 29                          | 36             |
|                                      | 5                                     |                             |                                | 1636SU05C-0800                 | 8                                       | 91                            | 53                         | 43                                            | 36                          | ●              |
|                                      | 3                                     |                             |                                | Whistle notch<br>shank/ Schaft | 1734SU03C-0800                          | 8                             | 79                         | 41                                            | 29                          | 36             |
|                                      | 5                                     | 1736SU05C-0800              | 8                              |                                | 91                                      | 53                            | 43                         | 36                                            | ●                           |                |
|                                      | 8                                     | 1538SU08C-0800              | 8                              |                                | 116                                     | 76                            | 66                         | 36                                            | ●                           |                |
|                                      | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-0810                  | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-0810                  | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                     |                             |                                | Zylinder-<br>schaft            | 1534SU03C-0810                          | 10                            | 89                         | 47                                            | 35                          | 40             |
| 5                                    | 1536SU05C-0810                        | 10                          | 103                            |                                | 61                                      | 49                            | 40                         | ●                                             |                             |                |
| 3                                    | Internal<br>Intern                    | Weldon<br>shank/ Schaft     | 1634SU03C-0810                 |                                | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
| 5                                    |                                       |                             | 1636SU05C-0810                 | 10                             | 103                                     | 61                            | 49                         | 40                                            | ●                           |                |
| 3                                    |                                       |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-0810                 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
| 5                                    | 1736SU05C-0810                        | 10                          |                                | 103                            | 61                                      | 49                            | 40                         | ●                                             |                             |                |
| 8                                    | 1538SU08C-0810                        | 10                          |                                | 142                            | 95                                      | 83                            | 40                         | ●                                             |                             |                |
| 8.2                                  | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-0820                  | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-0820                  | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                     |                             |                                | Zylinder-<br>schaft            | 1534SU03C-0820                          | 10                            | 89                         | 47                                            | 35                          | 40             |
|                                      | 5                                     | 1536SU05C-0820              | 10                             |                                | 103                                     | 61                            | 49                         | 40                                            | ●                           |                |
|                                      | 3                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        |                                | 1634SU03C-0820                          | 10                            | 89                         | 47                                            | 35                          | 40             |
|                                      | 5                                     |                             |                                | 1636SU05C-0820                 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |

# Drilling · Bohren

## Solid Carbide drills · Vollhartmetallbohrer

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                       | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|---------------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                       |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                       |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 8.2                                               | 3                                                  | Internal<br>Intern          | Whistle notch<br>shank/ Schaft        | 1734SU03C-0820 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-0820 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                             |                                       | 1538SU08C-0820 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
| 8.3                                               | 3                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0830  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05-0830  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03C-0830 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft               | 1536SU05C-0830 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1634SU03C-0830 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-0830 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1734SU03C-0830 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-0830 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                             |                                       | 1538SU08C-0830 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
|                                                   | 3                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0840  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05-0840  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03C-0840 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-0840 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1634SU03C-0840 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-0840 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
| 8.4                                               | 3                                                  | Internal<br>Intern          | Whistle notch<br>shank/ Schaft        | 1734SU03C-0840 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-0840 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                             |                                       | 1538SU08C-0840 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
|                                                   | 3                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0850  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05-0850  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03C-0850 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-0850 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft               | 1634SU03C-0850 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-0850 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1734SU03C-0850 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-0850 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                             |                                       | 1538SU08C-0850 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
| 8.5                                               | 3                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0860  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05-0860  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03C-0860 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-0860 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft               | 1634SU03C-0860 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-0860 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1734SU03C-0860 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-0860 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                             |                                       | 1538SU08C-0860 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
|                                                   | 3                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0860  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05-0860  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03C-0860 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-0860 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon<br>shank/ Schaft               | 1634SU03C-0860 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-0860 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1734SU03C-0860 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-0860 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                             |                                       | 1538SU08C-0860 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 96-109  
Schnittdaten

Technical Information C110-116  
Technische Information

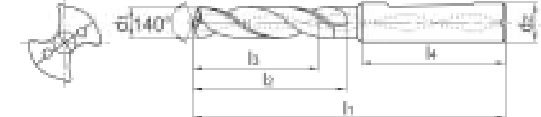
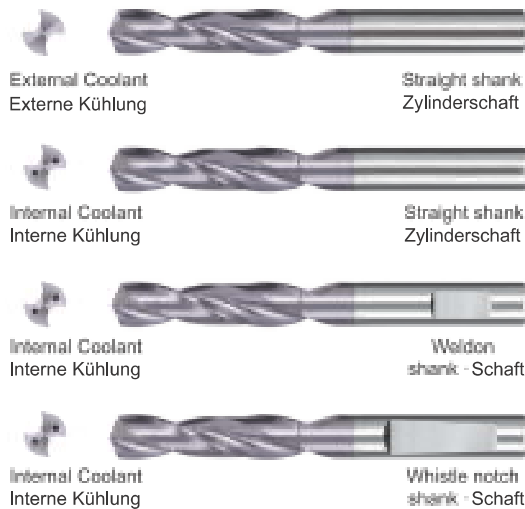
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L(d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                   | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|--------------------------------------|-----------------------------|-----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                      |                             |                                   |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                      |                             |                                   |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 8.7                                  | 3                                    | External<br>Extern          | Straight shank<br>Zylinderschaft  | 1534SU03-0870  | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                                   | 1536SU05-0870  | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    | Internal<br>Intern          | Zylinder-schaft                   | 1534SU03C-0870 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                                   | 1536SU05C-0870 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             | Weldon shank/ Schaft              | 1634SU03C-0870 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                                   | 1636SU05C-0870 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             | Whistle notch shank/ Schaft       | 1734SU03C-0870 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                                   | 1736SU05C-0870 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
| 8.8                                  | 8                                    | External<br>Extern          | Straight shank<br>Zylinder-schaft | 1538SU08C-0870 | 10                                      | 142                           | 95                         | 83                                            | 40                          | ●              |
|                                      | 3                                    |                             |                                   | 1534SU03-0880  | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    | Internal<br>Intern          | Zylinder-schaft                   | 1536SU05-0880  | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             |                                   | 1534SU03C-0880 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             | Weldon shank/ Schaft              | 1634SU03C-0880 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                                   | 1636SU05C-0880 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             | Whistle notch shank/ Schaft       | 1734SU03C-0880 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                                   | 1736SU05C-0880 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
| 8.9                                  | 8                                    | External<br>Extern          | Straight shank<br>Zylinder-schaft | 1538SU08C-0880 | 10                                      | 142                           | 95                         | 83                                            | 40                          | ●              |
|                                      | 3                                    |                             |                                   | 1534SU03-0890  | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    | Internal<br>Intern          | Zylinder-schaft                   | 1536SU05-0890  | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             |                                   | 1534SU03C-0890 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             | Weldon shank/ Schaft              | 1634SU03C-0890 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                                   | 1636SU05C-0890 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             | Whistle notch shank/ Schaft       | 1734SU03C-0890 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                                   | 1736SU05C-0890 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
| 8.9                                  | 8                                    | External<br>Extern          | Straight shank<br>Zylinderschaft  | 1538SU08C-0890 | 10                                      | 142                           | 95                         | 83                                            | 40                          | ●              |

# Drilling • Bohren

## Solid Carbide drills • Vollhartmetallbohrer

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) • Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 9.0                                               | 3                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-0900  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05-0900  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-0900 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-0900 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-0900 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-0900 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-0900 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-0900 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
| 9.1                                               | 8                                                  | External<br>Extern          | Straight<br>shank              | 1538SU08C-0900 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0910  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-0910  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-0910 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05C-0910 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1634SU03C-0910 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-0910 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-0910 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
| 9.2                                               | 5                                                  |                             |                                | 1736SU05C-0910 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  | External<br>Extern          | Straight<br>shank              | 1538SU08C-0910 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0920  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-0920  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-0920 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05C-0920 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1634SU03C-0920 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-0920 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-0920 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
| 9.3                                               | 5                                                  |                             |                                | 1736SU05C-0920 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  | External<br>Extern          | Straight<br>shank              | 1538SU08C-0920 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0930  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-0930  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-0930 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05C-0930 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1634SU03C-0930 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-0930 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-0930 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
| 9.35                                              | 5                                                  |                             |                                | 1736SU05C-0930 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  | External<br>Extern          | Straight<br>shank              | 1538SU08C-0930 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-0935  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ○              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-0935  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ○              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-0935 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ○              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-0935 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ○              |

### Material Overview • Material Übersicht

✓ = Very suitable • Sehr empfohlen  
✓ = Suitable • Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 96-109  
Schnittdaten

Technical Information C110-116  
Technische Information

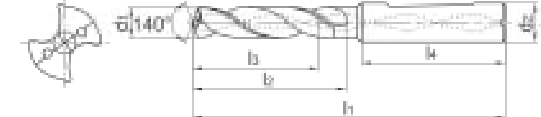
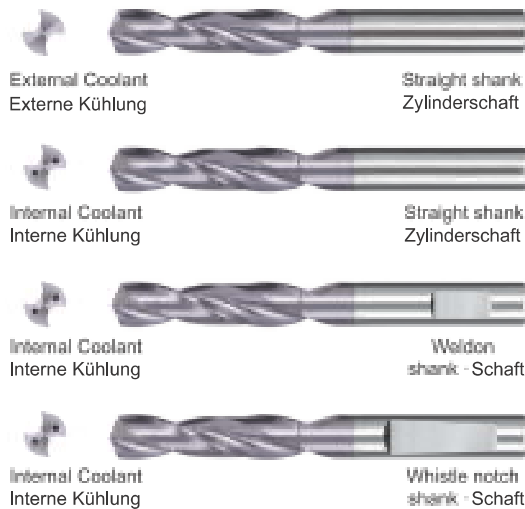
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L(d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft             | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|--------------------------------------|-----------------------------|-----------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                      |                             |                             |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                      |                             |                             |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 9.35                                 | 3                                    | Internal<br>Intern          | Weldon shank/ Schaft        | 1634SU03C-0935 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ○              |
|                                      | 5                                    |                             |                             | 1636SU05C-0935 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ○              |
|                                      | 3                                    |                             | Whistle notch shank/ Schaft | 1734SU03C-0935 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ○              |
|                                      | 5                                    |                             |                             | 1736SU05C-0935 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ○              |
| 9.4                                  | 3                                    | External<br>Extern          | Straight shank              | 1534SU03-0940  | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                             | 1536SU05-0940  | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             | Zylinder-schaft             | 1534SU03C-0940 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                             | 1536SU05C-0940 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    | Internal<br>Intern          | Weldon shank/ Schaft        | 1634SU03C-0940 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                             | 1636SU05C-0940 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             | Whistle notch shank/ Schaft | 1734SU03C-0940 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                             | 1736SU05C-0940 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 8                                    |                             |                             | 1538SU08C-0940 | 10                                      | 142                           | 95                         | 83                                            | 40                          | ●              |
|                                      | 3                                    | External<br>Extern          | Straight shank              | 1534SU03-0945  | 10                                      | 89                            | 47                         | 35                                            | 40                          | ○              |
|                                      | 5                                    |                             |                             | 1536SU05-0945  | 10                                      | 103                           | 61                         | 49                                            | 40                          | ○              |
|                                      | 3                                    |                             | Zylinder-schaft             | 1534SU03C-0945 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ○              |
|                                      | 5                                    |                             |                             | 1536SU05C-0945 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ○              |
| 9.45                                 | 3                                    | Internal<br>Intern          | Weldon shank/ Schaft        | 1634SU03C-0945 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ○              |
|                                      | 5                                    |                             |                             | 1636SU05C-0945 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ○              |
|                                      | 3                                    |                             | Whistle notch shank/ Schaft | 1734SU03C-0945 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ○              |
|                                      | 5                                    |                             |                             | 1736SU05C-0945 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ○              |
|                                      | 3                                    | External<br>Extern          | Straight shank              | 1534SU03-0950  | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                             | 1536SU05-0950  | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    |                             | Zylinder-schaft             | 1534SU03C-0950 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                             | 1536SU05C-0950 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                      | 3                                    | Internal<br>Intern          | Weldon shank/ Schaft        | 1634SU03C-0950 | 10                                      | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                      | 5                                    |                             |                             | 1636SU05C-0950 | 10                                      | 103                           | 61                         | 49                                            | 40                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel | Shank<br>Schaft                       | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|----------------------------|---------------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                            |                                       |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                            |                                       |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 9.5                                               | 3                                                  | Internal<br>Intern         | Whistle notch<br>shank/ Schaft        | 1734SU03C-0950 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1736SU05C-0950 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                            |                                       | 1538SU08C-0950 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
| 9.6                                               | 3                                                  | External<br>Extern         | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0960  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1536SU05-0960  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            |                                       | 1534SU03C-0960 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern         | Weldon<br>shank/ Schaft               | 1536SU05C-0960 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            |                                       | 1634SU03C-0960 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1636SU05C-0960 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/ Schaft        | 1734SU03C-0960 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1736SU05C-0960 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                            |                                       | 1538SU08C-0960 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
| 9.7                                               | 3                                                  | External<br>Extern         | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0970  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1536SU05-0970  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            |                                       | 1534SU03C-0970 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern         | Weldon<br>shank/ Schaft               | 1536SU05C-0970 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            |                                       | 1634SU03C-0970 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1636SU05C-0970 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/ Schaft        | 1734SU03C-0970 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1736SU05C-0970 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                            |                                       | 1538SU08C-0970 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
| 9.8                                               | 3                                                  | External<br>Extern         | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0980  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1536SU05-0980  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            |                                       | 1534SU03C-0980 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern         | Weldon<br>shank/ Schaft               | 1536SU05C-0980 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            |                                       | 1634SU03C-0980 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1636SU05C-0980 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/ Schaft        | 1734SU03C-0980 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1736SU05C-0980 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                            |                                       | 1538SU08C-0980 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |
| 9.9                                               | 3                                                  | External<br>Extern         | Straight shank<br>Zylinder-<br>schaft | 1534SU03-0990  | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1536SU05-0990  | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            |                                       | 1534SU03C-0990 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern         | Weldon<br>shank/ Schaft               | 1536SU05C-0990 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            |                                       | 1634SU03C-0990 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1636SU05C-0990 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/ Schaft        | 1734SU03C-0990 | 10                                      | 89                            | 47                         | 35                                             | 40                          | ●              |
|                                                   | 5                                                  |                            |                                       | 1736SU05C-0990 | 10                                      | 103                           | 61                         | 49                                             | 40                          | ●              |
|                                                   | 8                                                  |                            |                                       | 1538SU08C-0990 | 10                                      | 142                           | 95                         | 83                                             | 40                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 96-109  
Schnittdaten

Technical Information C110-116  
Technische Information

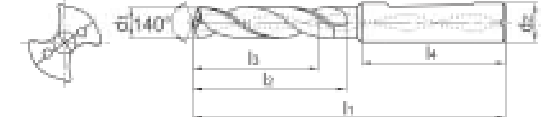
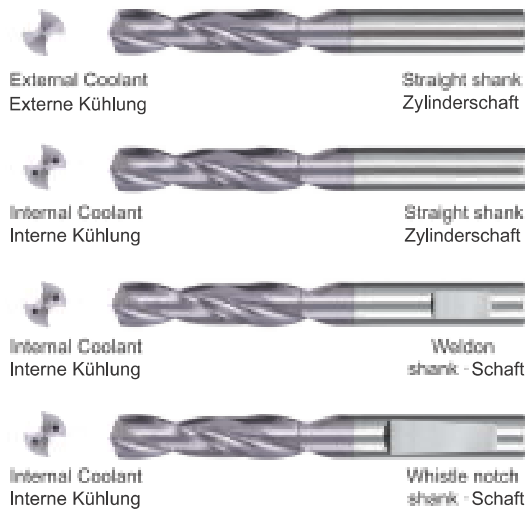
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1 (mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension (mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|---------------------------------------|-------------------------------------|----------------------------|----------------------------------|----------------|------------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                       |                                     |                            |                                  |                | Shank diameter Ø<br>Schaftdurchmesser    | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                       |                                     |                            |                                  |                | d2 (h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 10.0                                  | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft | 1534SU03-1000  | 10                                       | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-1000  | 10                                       | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                       | 3                                   | Internal<br>Intern         | Straight shank<br>Zylinderschaft | 1534SU03C-1000 | 10                                       | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-1000 | 10                                       | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                       | 3                                   |                            | Weldon shank/Schaft              | 1634SU03C-1000 | 10                                       | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-1000 | 10                                       | 103                           | 61                         | 49                                            | 40                          | ●              |
|                                       | 3                                   |                            | Whistle notch shank/Schaft       | 1734SU03C-1000 | 10                                       | 89                            | 47                         | 35                                            | 40                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-1000 | 10                                       | 103                           | 61                         | 49                                            | 40                          | ●              |
| 10.1                                  | 8                                   | Internal<br>Intern         | Straight shank<br>Zylinderschaft | 1538SU08C-1000 | 10                                       | 142                           | 95                         | 83                                            | 40                          | ●              |
|                                       | 3                                   |                            |                                  | 1534SU03-1010  | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            | Straight shank<br>Zylinderschaft | 1536SU05-1010  | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 3                                   |                            |                                  | 1534SU03C-1010 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            | Straight shank<br>Zylinderschaft | 1536SU05C-1010 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 3                                   |                            |                                  | 1634SU03C-1010 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            | Weldon shank/Schaft              | 1636SU05C-1010 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 3                                   |                            |                                  | 1734SU03C-1010 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
| 10.2                                  | 5                                   | Internal<br>Intern         | Whistle notch shank/Schaft       | 1736SU05C-1010 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 8                                   |                            |                                  | 1538SU08C-1010 | 12                                       | 162                           | 114                        | 99                                            | 45                          | ●              |
|                                       | 3                                   |                            | Straight shank<br>Zylinderschaft | 1534SU03-1020  | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05-1020  | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 3                                   |                            | Straight shank<br>Zylinderschaft | 1534SU03C-1020 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            |                                  | 1536SU05C-1020 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 3                                   |                            | Weldon shank/Schaft              | 1634SU03C-1020 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            |                                  | 1636SU05C-1020 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
| 10.2                                  | 3                                   | External<br>Extern         | Weldon shank/Schaft              | 1734SU03C-1020 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-1020 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 3                                   |                            | Whistle notch shank/Schaft       | 1734SU03C-1020 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-1020 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 3                                   |                            | straight shank<br>Zylinderschaft | 1734SU03C-1020 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-1020 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                       | 3                                   |                            | straight shank<br>Zylinderschaft | 1734SU03C-1020 | 12                                       | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                       | 5                                   |                            |                                  | 1736SU05C-1020 | 12                                       | 118                           | 71                         | 56                                            | 45                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                            |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                            |                                |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 10.25                                             | 3                                                  | External<br>Extern         | Straight<br>shank              | 1534SU03-1025  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1536SU05-1025  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern         | Zylinder-<br>schaft            | 1534SU03C-1025 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1536SU05C-1025 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Weldon<br>shank/ Schaft        | 1634SU03C-1025 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 5                                                  |                            |                                | 1636SU05C-1025 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/ Schaft | 1734SU03C-1025 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1736SU05C-1025 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
| 10.3                                              | 3                                                  | External<br>Extern         | Straight<br>shank              | 1534SU03-1030  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1536SU05-1030  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern         | Zylinder-<br>schaft            | 1534SU03C-1030 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1536SU05C-1030 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Weldon<br>shank/ Schaft        | 1634SU03C-1030 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1636SU05C-1030 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/ Schaft | 1734SU03C-1030 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1736SU05C-1030 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
| 10.4                                              | 8                                                  | External<br>Extern         | Straight<br>shank              | 1538SU08C-1030 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                                  |                            |                                | 1534SU03-1040  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern         | Zylinder-<br>schaft            | 1536SU05-1040  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            |                                | 1534SU03C-1040 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1536SU05C-1040 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Weldon<br>shank/ Schaft        | 1634SU03C-1040 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1636SU05C-1040 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/ Schaft | 1734SU03C-1040 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
| 10.5                                              | 5                                                  |                            |                                | 1736SU05C-1040 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 8                                                  | External<br>Extern         | Straight<br>shank              | 1538SU08C-1040 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                                  |                            |                                | 1534SU03-1050  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern         | Zylinder-<br>schaft            | 1536SU05-1050  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            |                                | 1534SU03C-1050 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1536SU05C-1050 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Weldon<br>shank/ Schaft        | 1634SU03C-1050 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1636SU05C-1050 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
| 10.6                                              | 3                                                  | External<br>Extern         | Straight<br>shank              | 1734SU03C-1050 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1736SU05C-1050 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 8                                                  | Internal<br>Intern         | Zylinder-<br>schaft            | 1538SU08C-1050 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                                  |                            |                                | 1534SU03-1060  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1536SU05-1060  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Weldon<br>shank/ Schaft        | 1534SU03C-1060 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1536SU05C-1060 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch<br>shank/ Schaft | 1734SU03C-1060 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                            |                                | 1736SU05C-1060 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 96-109  
Schnittdaten

Technical Information C110-116  
Technische Information

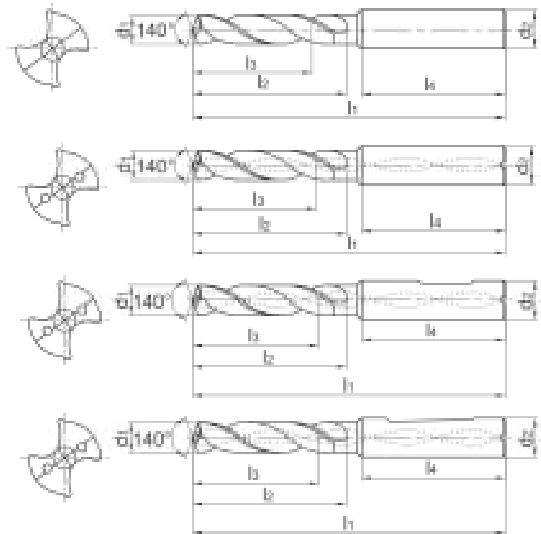
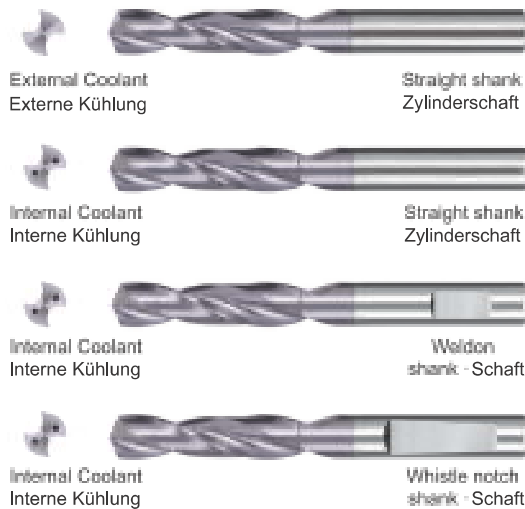
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ             | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |    |
|--------------------------------------|---------------------------------------|-----------------------------|--------------------------------|-------------------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|----|
|                                      |                                       |                             |                                |                         | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |    |
|                                      |                                       |                             |                                |                         | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          | KDG303         |    |
| 10.6                                 | 3                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1634SU03C-1060          | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |    |
|                                      | 5                                     |                             |                                | 1636SU05C-1060          | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |    |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1060          | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |    |
|                                      | 5                                     |                             |                                | 1736SU05C-1060          | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |    |
|                                      | 8                                     |                             | Zylinder-<br>schaft            | 1538SU08C-1060          | 12                                      | 162                           | 114                        | 99                                            | 45                          | ●              |    |
| 10.7                                 | External<br>Extern                    | Straight<br>shank           |                                | 1534SU03-1070           | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |    |
|                                      |                                       |                             |                                | 1536SU05-1070           | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |    |
|                                      |                                       | Zylinder-<br>schaft         |                                | 1534SU03C-1070          | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |    |
|                                      |                                       |                             | 1536SU05C-1070                 | 12                      | 118                                     | 71                            | 56                         | 45                                            | ●                           |                |    |
| 10.7                                 | 3                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1634SU03C-1070          | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |    |
|                                      |                                       |                             |                                | 1636SU05C-1070          | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |    |
|                                      | Whistle notch<br>shank/ Schaft        |                             | 1734SU03C-1070                 | 12                      | 102                                     | 55                            | 40                         | 45                                            | ●                           |                |    |
|                                      |                                       |                             | 1736SU05C-1070                 | 12                      | 118                                     | 71                            | 56                         | 45                                            | ●                           |                |    |
|                                      | 8                                     | Zylinder-<br>schaft         | 1538SU08C-1070                 | 12                      | 162                                     | 114                           | 99                         | 45                                            | ●                           |                |    |
|                                      | 10.8                                  |                             | External<br>Extern             | Straight<br>shank       | 1534SU03-1080                           | 12                            | 102                        | 55                                            | 40                          | 45             | ●  |
|                                      |                                       |                             |                                |                         | 1536SU05-1080                           | 12                            | 118                        | 71                                            | 56                          | 45             | ●  |
|                                      |                                       |                             |                                | Zylinder-<br>schaft     | 1534SU03C-1080                          | 12                            | 102                        | 55                                            | 40                          | 45             | ●  |
|                                      |                                       |                             |                                |                         | 1536SU05C-1080                          | 12                            | 118                        | 71                                            | 56                          | 45             | ●  |
|                                      | 10.8                                  |                             | Internal<br>Intern             | Weldon<br>shank/ Schaft | 1634SU03C-1080                          | 12                            | 102                        | 55                                            | 40                          | 45             | ●  |
| 1636SU05C-1080                       |                                       | 12                          |                                |                         | 118                                     | 71                            | 56                         | 45                                            | ●                           |                |    |
| Whistle notch<br>shank/ Schaft       |                                       | 1734SU03C-1080              |                                | 12                      | 102                                     | 55                            | 40                         | 45                                            | ●                           |                |    |
|                                      |                                       | 1736SU05C-1080              |                                | 12                      | 118                                     | 71                            | 56                         | 45                                            | ●                           |                |    |
| 8                                    |                                       | Zylinder-<br>schaft         |                                | 1538SU08C-1080          | 12                                      | 162                           | 114                        | 99                                            | 45                          | ●              |    |
| 10.9                                 |                                       |                             |                                | External<br>Extern      | Straight<br>shank                       | 1534SU03-1090                 | 12                         | 102                                           | 55                          | 40             | 45 |
|                                      | 1536SU05-1090                         |                             | 12                             |                         |                                         | 118                           | 71                         | 56                                            | 45                          | ●              |    |
|                                      | Zylinder-<br>schaft                   |                             | 1534SU03C-1090                 |                         | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |    |
|                                      |                                       | 1536SU05C-1090              | 12                             |                         | 118                                     | 71                            | 56                         | 45                                            | ●                           |                |    |

# Drilling • Bohren

## Solid Carbide drills • Vollhartmetallbohrer

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (m7) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) • Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|---------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                       |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                       |                             |                                |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 10.9                                              | 3                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1634SU03C-1090 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             |                                | 1636SU05C-1090 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1090 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             |                                | 1736SU05C-1090 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
| 11.0                                              | 8                                     | External<br>Extern          | Straight<br>shank              | 1538SU08C-1090 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                     |                             |                                | 1534SU03-1100  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             | Zylinder-<br>schaft            | 1536SU05-1100  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                     |                             |                                | 1534SU03C-1100 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1536SU05C-1100 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                     |                             |                                | 1634SU03C-1100 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-1100 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                     |                             |                                | 1734SU03C-1100 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     | External<br>Extern          | Straight<br>shank              | 1736SU05C-1100 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 8                                     |                             |                                | 1538SU08C-1100 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                     |                             | Zylinder-<br>schaft            | 1534SU03-1110  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             |                                | 1536SU05-1110  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
| 11.1                                              | 3                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1534SU03C-1110 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             |                                | 1636SU05C-1110 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1110 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             |                                | 1736SU05C-1110 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 8                                     | External<br>Extern          | Straight<br>shank              | 1538SU08C-1110 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                     |                             |                                | 1534SU03-1120  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             | Zylinder-<br>schaft            | 1536SU05-1120  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                     |                             |                                | 1534SU03C-1120 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1536SU05C-1120 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                     |                             |                                | 1634SU03C-1120 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                     |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-1120 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                     |                             |                                | 1734SU03C-1120 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
| 11.2                                              | 5                                     | External<br>Extern          | Straight<br>shank              | 1736SU05C-1120 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 8                                     |                             |                                | 1538SU08C-1120 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                     |                             | Zylinder-<br>schaft            | 1534SU03-1125  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 5                                     |                             |                                | 1536SU05-1125  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
|                                                   | 3                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1534SU03C-1125 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 5                                     |                             |                                | 1636SU05C-1125 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
|                                                   | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1125 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 5                                     |                             |                                | 1736SU05C-1125 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
| 11.25                                             | 3                                     | External<br>Extern          | Straight<br>shank              | 1538SU08C-1125 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ○              |
|                                                   | 5                                     |                             |                                | 1534SU03-1125  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 3                                     |                             | Zylinder-<br>schaft            | 1536SU05-1125  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
|                                                   | 5                                     |                             |                                | 1534SU03C-1125 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 3                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1636SU05C-1125 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
|                                                   | 5                                     |                             |                                | 1634SU03C-1125 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1736SU05C-1125 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
|                                                   | 5                                     |                             |                                | 1734SU03C-1125 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |

### Material Overview • Material Übersicht

✓ = Very suitable • Sehr empfohlen  
✓ = Suitable • Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |       |       |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|-------|-------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |       |       | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | 40HRC                             | 50HRC | 60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |       |       | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 96-109  
Schnittdaten

Technical Information C110-116  
Technische Information

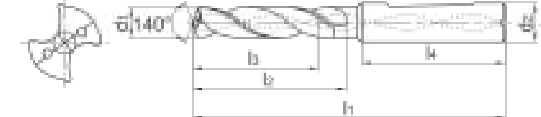
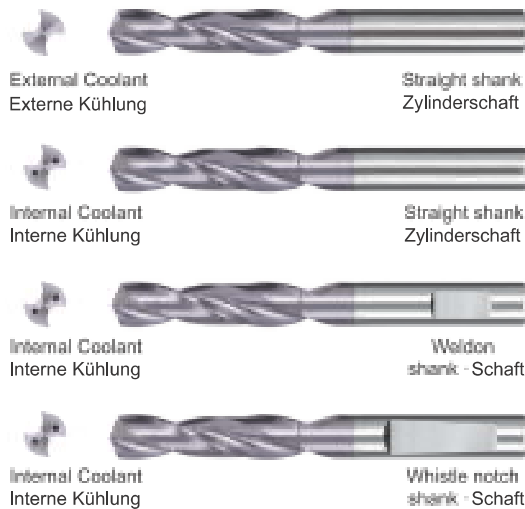
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                   | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|-------------------------------------|----------------------------|-----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                     |                            |                                   |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                     |                            |                                   |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 11.3                                 | 3                                   | External<br>Extern         | Straight shank<br>Zylinder-schaft | 1534SU03-1130  | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1536SU05-1130  | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Weldon shank/Schaft               | 1534SU03C-1130 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1536SU05C-1130 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            | Whistle notch shank/Schaft        | 1634SU03C-1130 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1636SU05C-1130 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                   | 1734SU03C-1130 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1736SU05C-1130 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
| 11.35                                | 8                                   | External<br>Extern         | Straight shank<br>Zylinder-schaft | 1538SU08C-1130 | 12                                      | 162                           | 114                        | 99                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                   | 1534SU03-1135  | 12                                      | 102                           | 55                         | 40                                            | 45                          | ○              |
|                                      | 5                                   | Internal<br>Intern         | Weldon shank/Schaft               | 1536SU05-1135  | 12                                      | 118                           | 71                         | 56                                            | 45                          | ○              |
|                                      | 3                                   |                            |                                   | 1534SU03C-1135 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ○              |
|                                      | 5                                   |                            | Whistle notch shank/Schaft        | 1536SU05C-1135 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ○              |
|                                      | 3                                   |                            |                                   | 1634SU03C-1135 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ○              |
|                                      | 5                                   |                            |                                   | 1636SU05C-1135 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ○              |
|                                      | 3                                   |                            |                                   | 1734SU03C-1135 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ○              |
| 11.4                                 | 5                                   | External<br>Extern         | Straight shank<br>Zylinder-schaft | 1736SU05C-1135 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ○              |
|                                      | 3                                   |                            |                                   | 1534SU03-1140  | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   | Internal<br>Intern         | Weldon shank/Schaft               | 1536SU05-1140  | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                   | 1534SU03C-1140 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            | Whistle notch shank/Schaft        | 1536SU05C-1140 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                   | 1634SU03C-1140 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1636SU05C-1140 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                   | 1734SU03C-1140 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
| 11.45                                | 8                                   | External<br>Extern         | Straight shank<br>Zylinder-schaft | 1538SU08C-1140 | 12                                      | 162                           | 114                        | 99                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                   | 1534SU03-1145  | 12                                      | 102                           | 55                         | 40                                            | 45                          | ○              |
|                                      | 5                                   |                            |                                   | 1536SU05-1145  | 12                                      | 118                           | 71                         | 56                                            | 45                          | ○              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (m7) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                       | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|---------------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                       |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                       |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 11.45                                             | 3                                                  | Internal<br>Intern          | straight shank<br>Zylinderschaft      | 1534SU03C-1145 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-1145 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
|                                                   | 3                                                  |                             | Weldon shank/<br>Schaft               | 1634SU03C-1145 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-1145 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
|                                                   | 3                                                  |                             | Whistle notch shank/<br>Schaft        | 1734SU03C-1145 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ○              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-1145 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ○              |
| 11.5                                              | 3                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1534SU03-1150  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05-1150  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03C-1150 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-1150 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon shank/<br>Schaft               | 1634SU03C-1150 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-1150 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch shank/<br>Schaft        | 1734SU03C-1150 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-1150 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 8                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1538SU08C-1150 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03-1160  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
| 11.6                                              | 5                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1536SU05-1160  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03C-1160 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-1160 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1634SU03C-1160 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Weldon shank/<br>Schaft               | 1636SU05C-1160 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1734SU03C-1160 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             | Whistle notch shank/<br>Schaft        | 1736SU05C-1160 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 8                                                  |                             |                                       | 1538SU08C-1160 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1534SU03-1170  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05-1170  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
| 11.7                                              | 3                                                  |                             |                                       | 1534SU03C-1170 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-1170 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Weldon shank/<br>Schaft               | 1634SU03C-1170 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-1170 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch shank/<br>Schaft        | 1734SU03C-1170 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1736SU05C-1170 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 8                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1538SU08C-1170 | 12                                      | 162                           | 114                        | 99                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03-1180  | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
| 11.8                                              | 5                                                  | External<br>Extern          | Straight shank<br>Zylinder-<br>schaft | 1536SU05-1180  | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1534SU03C-1180 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1536SU05C-1180 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                       | 1634SU03C-1180 | 12                                      | 102                           | 55                         | 40                                             | 45                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Weldon shank/<br>Schaft               | 1636SU05C-1180 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                       | 1636SU05C-1180 | 12                                      | 118                           | 71                         | 56                                             | 45                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

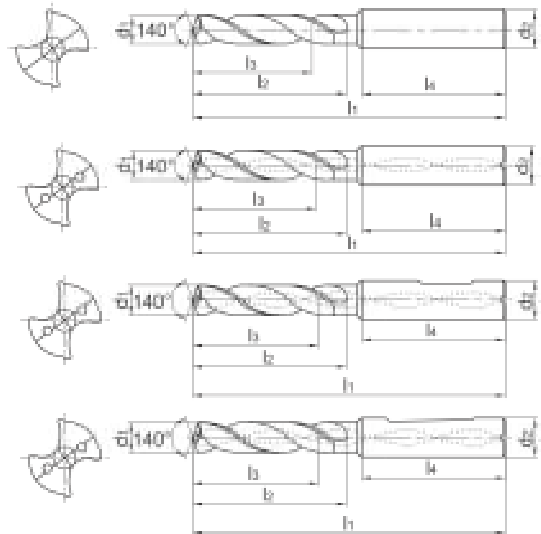
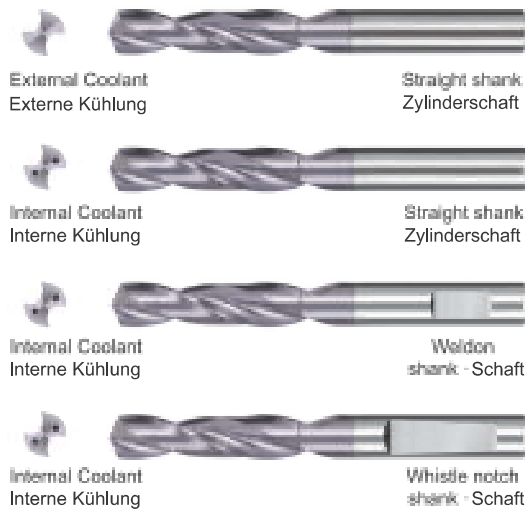
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                          | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|-------------------------------------|----------------------------|------------------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                     |                            |                                          |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                     |                            |                                          |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 11.8                                 | 3                                   | Internal<br>Intern         | Whistle notch<br>shank/ Schaft           | 1734SU03C-1180 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1736SU05C-1180 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 8                                   |                            |                                          | 1538SU08C-1180 | 12                                      | 162                           | 114                        | 99                                            | 45                          | ●              |
| 11.9                                 | 3                                   | External<br>Extern         | Straight<br>shank<br>Zylinder-<br>schaft | 1534SU03-1190  | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1536SU05-1190  | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                          | 1534SU03C-1190 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   | Internal<br>Intern         | Weldon<br>shank/ Schaft                  | 1536SU05C-1190 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                          | 1634SU03C-1190 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1636SU05C-1190 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            | Whistle notch<br>shank/ Schaft           | 1734SU03C-1190 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1736SU05C-1190 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 8                                   |                            |                                          | 1538SU08C-1190 | 12                                      | 162                           | 114                        | 99                                            | 45                          | ●              |
|                                      | 3                                   | External<br>Extern         | Straight<br>shank<br>Zylinder-<br>schaft | 1534SU03-1200  | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1536SU05-1200  | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                          | 1534SU03C-1200 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1536SU05C-1200 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            | Weldon<br>shank/Schaft                   | 1634SU03C-1200 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1636SU05C-1200 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 3                                   |                            | Whistle notch<br>shank/Schaft            | 1734SU03C-1200 | 12                                      | 102                           | 55                         | 40                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1736SU05C-1200 | 12                                      | 118                           | 71                         | 56                                            | 45                          | ●              |
|                                      | 8                                   |                            |                                          | 1538SU08C-1200 | 12                                      | 162                           | 114                        | 99                                            | 45                          | ●              |
|                                      | 3                                   | External<br>Extern         | Straight<br>shank<br>Zylinder-<br>schaft | 1534SU03-1210  | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
| 12.1                                 | 5                                   |                            |                                          | 1536SU05-1210  | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   |                            |                                          | 1534SU03C-1210 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1536SU05C-1210 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   |                            | Weldon<br>shank/Schaft                   | 1634SU03C-1210 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1636SU05C-1210 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   |                            | Whistle notch<br>shank/Schaft            | 1734SU03C-1210 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                          | 1736SU05C-1210 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d₁(m7) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|--------------------------------------|---------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                      |                                       |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                       |                             |                                |                | d₂(h₆)                                  | l₁                            | l₂                         | l₃                                             | l₄                          |                |
| 12.2                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1220  | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1220  | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1220 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1220 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1220 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1220 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1220 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1220 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
| 12.25                                | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1225  | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1225  | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1225 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1225 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1225 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ○              |
|                                      | 5                                     |                             |                                | 1636SU05C-1225 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ○              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1225 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1225 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
| 12.3                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1230  | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1230  | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1230 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1230 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1230 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1230 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1230 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1230 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                        |                        |                                                 |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|----------------------------------------|------------------------|-------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgraphitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | ~40HRC                            | ~50HRC | ~60HRC |                                        |                        |                                                 |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                      | ✓                      | ✓                                               |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 96-109  
Schnittdaten

Technical information C110-116  
Technische Information

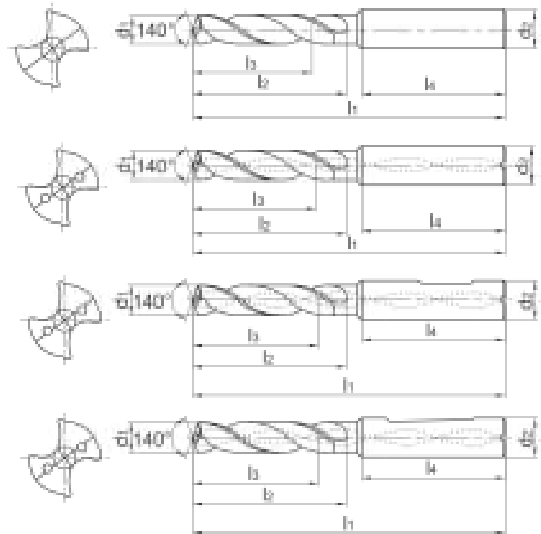
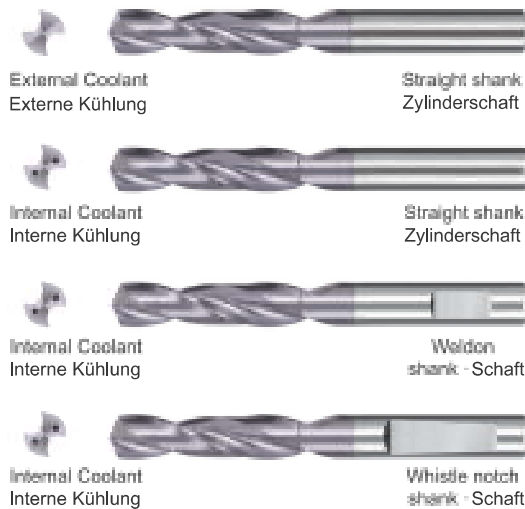
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- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
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- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                   | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|-------------------------------------|----------------------------|-----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                     |                            |                                   |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                     |                            |                                   |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 12.5                                 | 3                                   | External<br>Extern         | Straight shank<br>Zylinderschaft  | 1534SU03-1250  | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1536SU05-1250  | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Zylinder-schaft                   | 1534SU03C-1250 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1536SU05C-1250 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   |                            | Weldon shank/ Schaft              | 1634SU03C-1250 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1636SU05C-1250 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   |                            | Whistle notch shank/ Schaft       | 1734SU03C-1250 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1736SU05C-1250 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 8                                   |                            |                                   | 1538SU08C-1250 | 14                                      | 178                           | 133                        | 116                                           | 45                          | ●              |
| 12.7                                 | 3                                   | External<br>Extern         | Straight shank<br>Zylinder-schaft | 1534SU03-1270  | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1536SU05-1270  | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Zylinder-schaft                   | 1534SU03C-1270 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1536SU05C-1270 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   |                            | Weldon shank/ Schaft              | 1634SU03C-1270 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1636SU05C-1270 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   |                            | Whistle notch shank/ Schaft       | 1734SU03C-1270 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1736SU05C-1270 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 8                                   |                            |                                   | 1538SU08C-1270 | 14                                      | 178                           | 133                        | 116                                           | 45                          | ●              |
| 12.75                                | 3                                   | External<br>Extern         | Straight shank<br>Zylinder-schaft | 1534SU03-1275  | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1536SU05-1275  | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Zylinder-schaft                   | 1534SU03C-1275 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1536SU05C-1275 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                   |                            | Weldon shank/ Schaft              | 1634SU03C-1275 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ○              |
|                                      | 5                                   |                            |                                   | 1636SU05C-1275 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ○              |
|                                      | 3                                   |                            | Weldon shank/ Schaft              | 1734SU03C-1275 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                   |                            |                                   | 1736SU05C-1275 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 12.8                                              | 3                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-1280  | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05-1280  | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1280 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-1280 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1280 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-1280 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1280 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-1280 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 8                                                  |                             |                                | 1538SU08C-1280 | 14                                      | 178                           | 133                        | 116                                            | 45                          | ●              |
| 13.0                                              | 3                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-1300  | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05-1300  | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1300 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-1300 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1300 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-1300 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1300 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-1300 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 8                                                  |                             |                                | 1538SU08C-1300 | 14                                      | 178                           | 133                        | 116                                            | 45                          | ●              |
| 13.1                                              | 3                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-1310  | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05-1310  | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1310 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-1310 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1310 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-1310 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1310 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-1310 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
| 13.35                                             | 3                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-1335  | 16                                      | 107                           | 60                         | 43                                             | 45                          | ○              |
|                                                   | 5                                                  |                             |                                | 1536SU05-1335  | 16                                      | 124                           | 77                         | 60                                             | 56                          | ○              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1335 | 16                                      | 107                           | 60                         | 43                                             | 45                          | ○              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-1335 | 16                                      | 124                           | 77                         | 60                                             | 56                          | ○              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1335 | 16                                      | 107                           | 60                         | 43                                             | 45                          | ○              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-1335 | 16                                      | 124                           | 77                         | 60                                             | 56                          | ○              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1335 | 16                                      | 107                           | 60                         | 43                                             | 45                          | ○              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-1335 | 16                                      | 124                           | 77                         | 60                                             | 56                          | ○              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

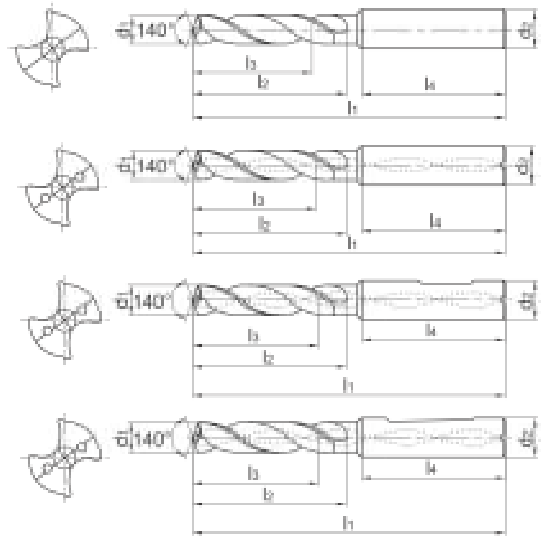
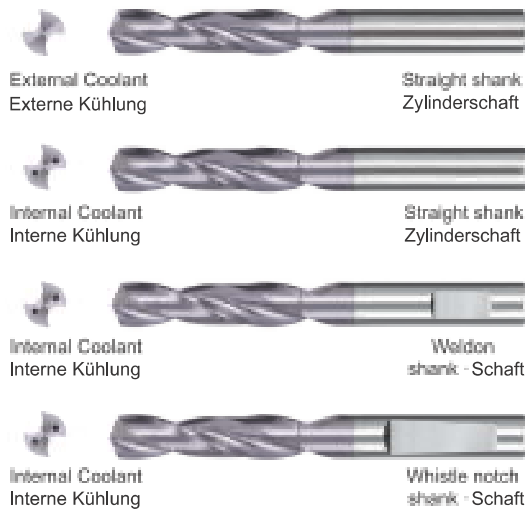
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|---------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                       |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                       |                             |                                |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          | KDGB300        |
| 13.5                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1350  | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1350  | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1350 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1350 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1350 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1350 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1350 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1350 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
| 13.8                                 | 8                                     | External<br>Extern          | Straight<br>shank              | 1538SU08C-1350 | 14                                      | 178                           | 133                        | 116                                           | 45                          | ●              |
|                                      | 3                                     |                             |                                | 1534SU03-1380  | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                     | Zylinder-<br>schaft         | 1536SU05-1380                  | 14             | 124                                     | 77                            | 60                         | 45                                            | ●                           |                |
|                                      | 3                                     |                             | 1534SU03C-1380                 | 14             | 107                                     | 60                            | 43                         | 45                                            | ●                           |                |
|                                      | 5                                     | Internal<br>Intern          | Weldon<br>shank/ Schaft        | 1536SU05C-1380 | 14                                      | 124                           | 77                         | 60                                            | 45                          | ●              |
|                                      | 3                                     |                             |                                | 1634SU03C-1380 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                     |                             | 1636SU05C-1380                 | 14             | 124                                     | 77                            | 60                         | 45                                            | ●                           |                |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1380 | 14                                      | 107                           | 60                         | 43                                            | 45                          | ●              |
|                                      | 5                                     | 1736SU05C-1380              |                                | 14             | 124                                     | 77                            | 60                         | 45                                            | ●                           |                |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 14.0                                              | 3                                                  | External<br>Extern          | Straight<br>shank              | 1534SU03-1400  | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05-1400  | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1400 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1536SU05C-1400 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1400 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ○              |
|                                                   | 5                                                  |                             |                                | 1636SU05C-1400 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1400 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             |                                | 1736SU05C-1400 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
| 14.2                                              | 8                                                  | External<br>Extern          | Straight<br>shank              | 1538SU08C-1400 | 14                                      | 178                           | 133                        | 116                                            | 45                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-1420  | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-1420  | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-1420 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05C-1420 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                | 1634SU03C-1420 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
|                                                   | 5                                                  |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-1420 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-1420 | 14                                      | 107                           | 60                         | 43                                             | 45                          | ●              |
| 14.25                                             | 5                                                  | External<br>Extern          | Straight<br>shank              | 1736SU05C-1420 | 14                                      | 124                           | 77                         | 60                                             | 45                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-1425  | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-1425  | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-1425 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05C-1425 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                             |                                | 1634SU03C-1425 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ○              |
|                                                   | 5                                                  |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-1425 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-1425 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
| 14.3                                              | 5                                                  | External<br>Extern          | Straight<br>shank              | 1736SU05C-1425 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03-1430  | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern          | Zylinder-<br>schaft            | 1536SU05-1430  | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                             |                                | 1534SU03C-1430 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                             | Weldon<br>shank/ Schaft        | 1536SU05C-1430 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                             |                                | 1634SU03C-1430 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                             | Whistle notch<br>shank/ Schaft | 1636SU05C-1430 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                             |                                | 1734SU03C-1430 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                 |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|-------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgraphitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                 |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                               |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical information C110-116  
Technische Information

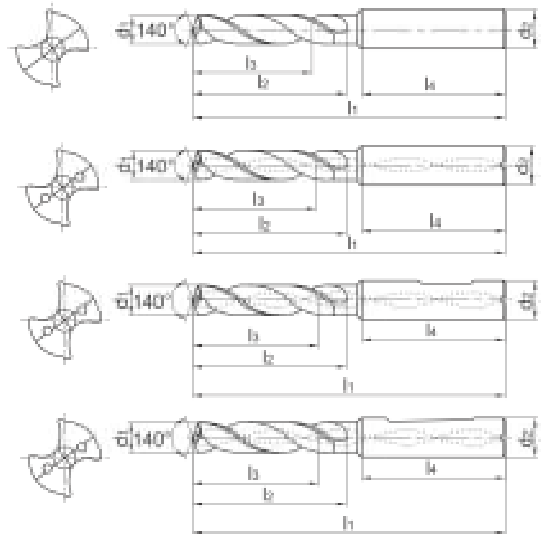
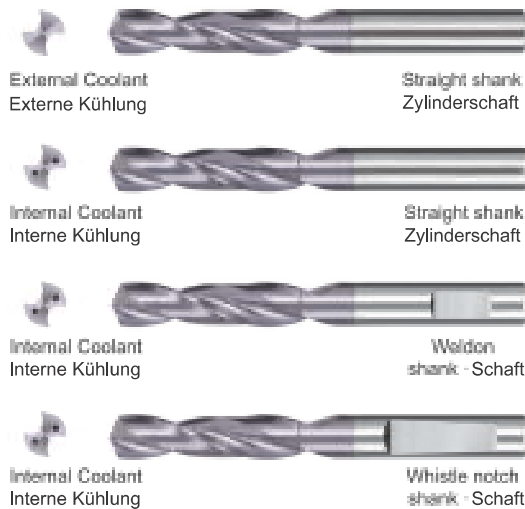
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L(d1) | Cooling mode<br>Kühlmittel | Shank<br>Schaft                       | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|--------------------------------------|----------------------------|---------------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                      |                            |                                       |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                      |                            |                                       |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 14.5                                 | 3                                    | External<br>Extern         | Straight shank<br>Zylinder-<br>schaft | 1534SU03-1450  | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                    |                            |                                       | 1536SU05-1450  | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                    | Internal<br>Intern         | Straight shank<br>Zylinder-<br>schaft | 1534SU03C-1450 | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                    |                            |                                       | 1536SU05C-1450 | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                    |                            | Weldon shank / Schaft                 | 1634SU03C-1450 | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                    |                            |                                       | 1636SU05C-1450 | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                    |                            | Whistle notch shank / Schaft          | 1734SU03C-1450 | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                    |                            |                                       | 1736SU05C-1450 | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 8                                    |                            |                                       | 1538SU08C-1450 | 16                                      | 204                           | 152                        | 132                                           | 48                          | ●              |
| 14.75                                | 3                                    | External<br>Extern         | Straight shank<br>Zylinder-<br>schaft | 1534SU03-1475  | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                    |                            |                                       | 1536SU05-1475  | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                    | Internal<br>Intern         | Straight shank<br>Zylinder-<br>schaft | 1534SU03C-1475 | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                    |                            |                                       | 1536SU05C-1475 | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                    |                            | Weldon shank / Schaft                 | 1634SU03C-1475 | 16                                      | 115                           | 65                         | 45                                            | 48                          | ○              |
|                                      | 5                                    |                            |                                       | 1636SU05C-1475 | 16                                      | 133                           | 83                         | 63                                            | 48                          | ○              |
|                                      | 3                                    |                            | Whistle notch shank / Schaft          | 1734SU03C-1475 | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                    |                            |                                       | 1736SU05C-1475 | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel | Shank<br>Schaft             | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|----------------------------|-----------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                            |                             |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                            |                             |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 14.8                                              | 3                                                  | External<br>Extern         | Straight shank              | 1534SU03-1480  | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                            |                             | 1536SU05-1480  | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern         | Zylinder-schaft             | 1534SU03C-1480 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                            |                             | 1536SU05C-1480 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                            | Weldon shank/ Schaft        | 1634SU03C-1480 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                            |                             | 1636SU05C-1480 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                            | Whistle notch shank/ Schaft | 1734SU03C-1480 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                            |                             | 1736SU05C-1480 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
| 15.0                                              | 8                                                  | External<br>Extern         | Straight shank              | 1538SU08C-1480 | 16                                      | 204                           | 152                        | 132                                            | 48                          | ●              |
|                                                   | 3                                                  |                            |                             | 1534SU03-1500  | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  | Internal<br>Intern         | Zylinder-schaft             | 1536SU05-1500  | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                            |                             | 1534SU03C-1500 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                            | Weldon shank/ Schaft        | 1536SU05C-1500 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                            |                             | 1634SU03C-1500 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 5                                                  |                            | Whistle notch shank/ Schaft | 1636SU05C-1500 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                            |                             | 1734SU03C-1500 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
| 15.1                                              | 5                                                  | Internal<br>Intern         | Weldon shank/ Schaft        | 1736SU05C-1500 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 3                                                  |                            |                             | 1538SU08C-1500 | 16                                      | 204                           | 152                        | 132                                            | 48                          | ●              |
|                                                   | 5                                                  |                            | Straight shank              | 1534SU03-1510  | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 3                                                  |                            |                             | 1536SU05-1510  | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 5                                                  | External<br>Extern         | Zylinder-schaft             | 1534SU03C-1510 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 3                                                  |                            |                             | 1536SU05C-1510 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
|                                                   | 5                                                  |                            | Weldon shank/ Schaft        | 1534SU03-1530  | 16                                      | 115                           | 65                         | 45                                             | 48                          | ●              |
|                                                   | 3                                                  |                            |                             | 1536SU05C-1530 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ●              |
| 15.3                                              | 5                                                  | Internal<br>Intern         | Weldon shank/ Schaft        | 1534SU03-1535  | 16                                      | 115                           | 65                         | 45                                             | 48                          | ○              |
|                                                   | 3                                                  |                            |                             | 1536SU05C-1535 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ○              |
|                                                   | 5                                                  |                            | Zylinder-schaft             | 1534SU03C-1535 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ○              |
|                                                   | 3                                                  |                            |                             | 1536SU05C-1535 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ○              |
|                                                   | 5                                                  | External<br>Extern         | Weldon shank/ Schaft        | 1634SU03C-1535 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ○              |
|                                                   | 3                                                  |                            |                             | 1636SU05C-1535 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ○              |
|                                                   | 5                                                  |                            | Whistle notch shank/ Schaft | 1734SU03C-1535 | 16                                      | 115                           | 65                         | 45                                             | 48                          | ○              |
|                                                   | 3                                                  |                            |                             | 1736SU05C-1535 | 16                                      | 133                           | 83                         | 63                                             | 48                          | ○              |

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

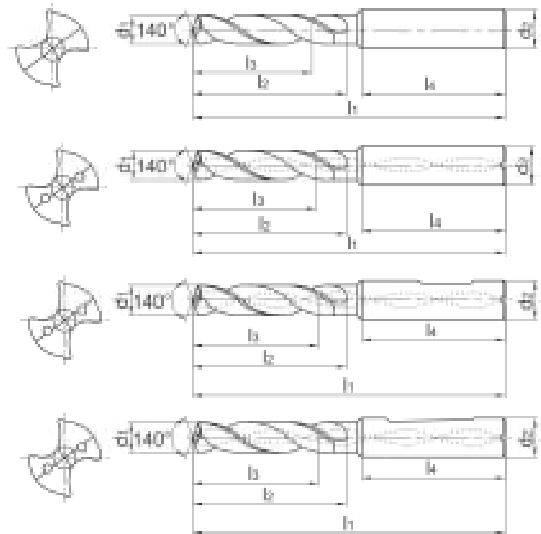
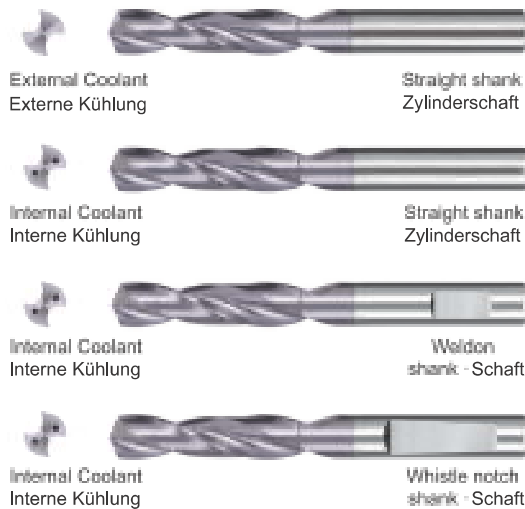
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ         | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|---------------------------------------|-----------------------------|--------------------------------|---------------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                       |                             |                                |                     | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | Effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                       |                             |                                |                     | d2(h6)                                  | L1                            | L2                         | L3                                            | L4                          | KD-G303        |
| 15.5                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1550       | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1550       | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1550      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1550      | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1550      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1550      | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1550      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1550      | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
| 15.8                                 | 8                                     | External<br>Extern          | Straight<br>shank              | 1538SU08C-1550      | 16                                      | 204                           | 152                        | 132                                           | 48                          | ●              |
|                                      | 3                                     |                             |                                | Zylinder-<br>schaft | 1534SU03-1580                           | 16                            | 115                        | 65                                            | 45                          | 48             |
|                                      | 5                                     | 1536SU05-1580               | 16                             |                     | 133                                     | 83                            | 63                         | 48                                            | ●                           |                |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1580      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1580      | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1580      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1580      | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1580      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
| 5                                    | 1736SU05C-1580                        |                             |                                | 16                  | 133                                     | 83                            | 63                         | 48                                            | ●                           |                |
| 16.0                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1600       | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1600       | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1600      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1600      | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1600      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1600      | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1600      | 16                                      | 115                           | 65                         | 45                                            | 48                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1600      | 16                                      | 133                           | 83                         | 63                                            | 48                          | ●              |
|                                      | 8                                     | External<br>Extern          | Straight<br>shank              | 1538SU08C-1600      | 16                                      | 204                           | 152                        | 132                                           | 48                          | ●              |
|                                      | 3                                     |                             |                                | 1534SU03-1610       | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |

| Drill diameter<br>Bohrer Ø<br>d <sub>1</sub> (mm) | Drilling depth<br>Bohrtiefe<br>(L/d <sub>1</sub> ) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|---------------------------------------------------|----------------------------------------------------|-----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                                   |                                                    |                             |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                                   |                                                    |                             |                                  |                | d <sub>2</sub> (h <sub>6</sub> )        | l <sub>1</sub>                | l <sub>2</sub>             | l <sub>3</sub>                                 | l <sub>4</sub>              |                |
| 16.5                                              | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-1650  | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-1650  | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-1650 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-1650 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-1650 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-1650 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-1650 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-1650 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 8                                                  |                             |                                  | 1538SU08C-1650 | 18                                      | 223                           | 171                        | 149                                            | 48                          | ●              |
| 16.75                                             | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-1675  | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-1675  | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-1675 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-1675 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-1675 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ○              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-1675 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ○              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-1675 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-1675 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
| 16.8                                              | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-1680  | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-1680  | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-1680 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-1680 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-1680 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-1680 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-1680 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-1680 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
| 17.0                                              | 3                                                  | External<br>Extern          | Straight<br>shank                | 1534SU03-1700  | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05-1700  | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  | Internal<br>Intern          | Zylinder-<br>schaft              | 1534SU03C-1700 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1536SU05C-1700 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  |                             | Weldon<br>shank/ Schaft          | 1634SU03C-1700 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1636SU05C-1700 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 3                                                  |                             | Whistle notch<br>shank/ Schaft   | 1734SU03C-1700 | 18                                      | 123                           | 73                         | 51                                             | 48                          | ●              |
|                                                   | 5                                                  |                             |                                  | 1736SU05C-1700 | 18                                      | 143                           | 93                         | 71                                             | 48                          | ●              |
|                                                   | 8                                                  |                             | straight shank<br>Zylinderschaft | 1538SU08C-1700 | 18                                      | 223                           | 171                        | 149                                            | 48                          | ●              |

C

Solid Carbide drills  
Vollhartmetallbohrer

### Material Overview · Material Übersicht

✓ = Very suitable · Sehr empfohlen  
✓ = Suitable · Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |        |        |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|--------|--------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |        |        | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | -40HRC                            | -50HRC | -60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |        |        | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 98-109  
Schnittdaten

Technical Information C110-116  
Technische Information

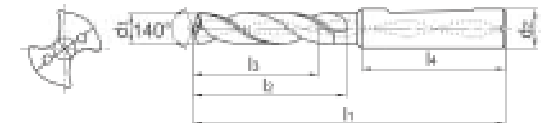
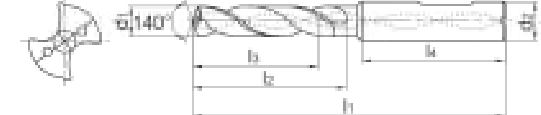
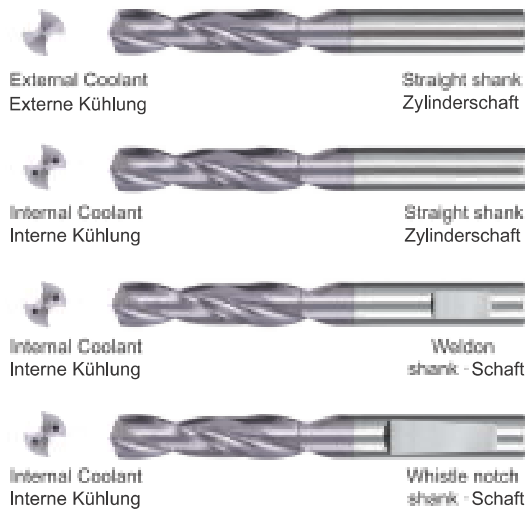
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>L/d1 | Cooling mode<br>Kühlmittel | Shank<br>Schaft                  | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|-------------------------------------|----------------------------|----------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                     |                            |                                  |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                     |                            |                                  |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 17.5                                 | 3                                   | External<br>Extern         | Straight<br>shank                | 1534SU03-1750  | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05-1750  | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Zylinder-<br>schaft              | 1534SU03C-1750 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05C-1750 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   |                            | Weldon<br>shank/ Schaft          | 1634SU03C-1750 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1636SU05C-1750 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   |                            | Whistle notch<br>shank/ Schaft   | 1734SU03C-1750 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1736SU05C-1750 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
| 17.8                                 | 8                                   | External<br>Extern         | Straight<br>shank                | 1538SU08C-1750 | 18                                      | 223                           | 171                        | 149                                           | 48                          | ●              |
|                                      | 3                                   |                            |                                  | 1534SU03-1780  | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   | Internal<br>Intern         | Zylinder-<br>schaft              | 1536SU05-1780  | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   |                            |                                  | 1534SU03C-1780 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05C-1780 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   |                            | Weldon<br>shank/ Schaft          | 1634SU03C-1780 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1636SU05C-1780 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   |                            | Whistle notch<br>shank/ Schaft   | 1734SU03C-1780 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
| 18.0                                 | 5                                   |                            |                                  | 1736SU05C-1780 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   | External<br>Extern         | Straight<br>shank                | 1534SU03-1800  | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05-1800  | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   | Internal<br>Intern         | Zylinder-<br>schaft              | 1534SU03C-1800 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1536SU05C-1800 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   |                            | Weldon<br>shank/ Schaft          | 1634SU03C-1800 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1636SU05C-1800 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 3                                   |                            | Whistle notch<br>shank/ Schaft   | 1734SU03C-1800 | 18                                      | 123                           | 73                         | 51                                            | 48                          | ●              |
|                                      | 5                                   |                            |                                  | 1736SU05C-1800 | 18                                      | 143                           | 93                         | 71                                            | 48                          | ●              |
|                                      | 8                                   |                            | straight shank<br>Zylinderschaft | 1538SU08C-1800 | 18                                      | 223                           | 171                        | 149                                           | 48                          | ●              |

# Drilling • Bohren

## Solid Carbide drills • Vollhartmetallbohrer

| Drill diameter<br>Bohrer Ø<br>d₁(m7) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel. | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) • Basis Abmessungen |                               |                            |                                                |                             | Grade<br>Sorte |
|--------------------------------------|---------------------------------------|-----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|------------------------------------------------|-----------------------------|----------------|
|                                      |                                       |                             |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill. length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                       |                             |                                |                | d₂(h₆)                                  | l₁                            | l₂                         | l₃                                             | l₄                          |                |
| 18.5                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1850  | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1850  | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1850 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1850 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1850 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1850 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1850 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1850 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
| 18.8                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1880  | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1880  | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1880 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1880 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1880 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1880 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1880 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1880 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
| 19.0                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1900  | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1900  | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1900 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1900 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1900 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1900 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1900 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1900 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
| 19.5                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1950  | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1950  | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1950 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1950 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1950 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1950 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1950 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1950 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
| 19.8                                 | 3                                     | External<br>Extern          | Straight<br>shank              | 1534SU03-1980  | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05-1980  | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     | Internal<br>Intern          | Zylinder-<br>schaft            | 1534SU03C-1980 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1536SU05C-1980 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Weldon<br>shank/ Schaft        | 1634SU03C-1980 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1636SU05C-1980 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |
|                                      | 3                                     |                             | Whistle notch<br>shank/ Schaft | 1734SU03C-1980 | 20                                      | 131                           | 79                         | 55                                             | 50                          | ●              |
|                                      | 5                                     |                             |                                | 1736SU05C-1980 | 20                                      | 153                           | 101                        | 77                                             | 50                          | ●              |

### Material Overview • Material Übersicht

✓ = Very suitable • Sehr empfohlen  
✓ = Suitable • Empfohlen

| Grade<br>Sorte | Workpiece material · Werkstückstoff           |                                   |                                   |       |       |                                           |                        |                                                      |                              |                               |                                            |
|----------------|-----------------------------------------------|-----------------------------------|-----------------------------------|-------|-------|-------------------------------------------|------------------------|------------------------------------------------------|------------------------------|-------------------------------|--------------------------------------------|
|                | Carbon steel<br>Kohlenstoff - Stahl<br>HB≤180 | Alloy steel<br>Legierter<br>Stahl | Hardened steel · Gehärteter Stahl |       |       | Stainless<br>steel<br>Rostfreier<br>Stahl | Cast iron,<br>Grauguss | Nodular<br>cast iron<br>GGG<br>Kugelgra-<br>phitguss | Aluminum<br>alloy<br>Aluleg. | Copper<br>alloy<br>Kupferleg. | Heat resist.<br>alloy<br>Warmfeste<br>Leg. |
|                |                                               |                                   | 40HRC                             | 50HRC | 60HRC |                                           |                        |                                                      |                              |                               |                                            |
| KDG303         | ✓                                             | ✓                                 | ✓                                 |       |       | ✓                                         | ✓                      | ✓                                                    |                              |                               |                                            |

Code key C 10  
ISO Kennzeichen

Cutting data 96-109  
Schnittdaten

Technical Information C110-116  
Technische Information

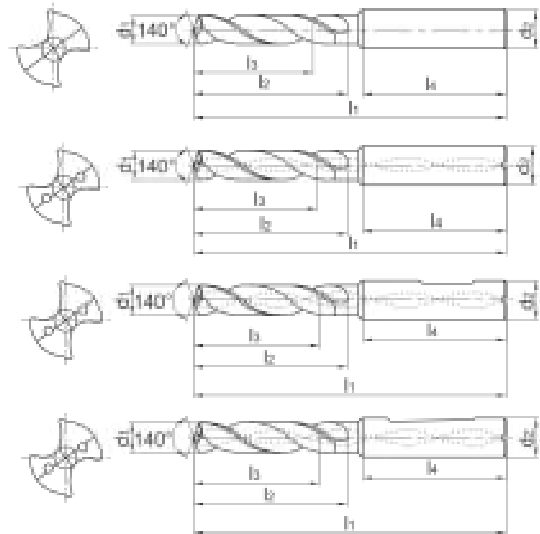
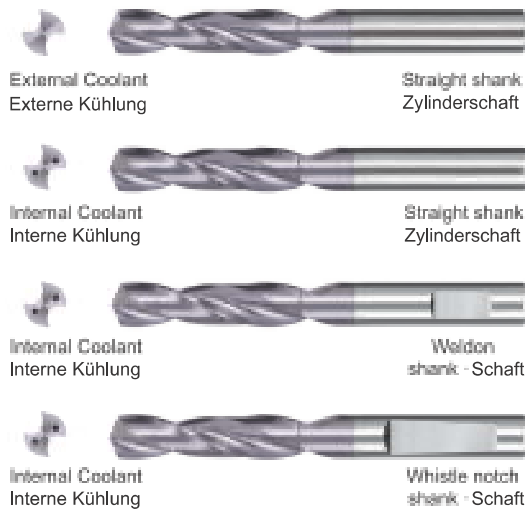
Non-standard tailor made C 117-121  
Bestellformular für Sonderwerkzeuge

# Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

## SU series · SU Serie

## General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
- Waveform cutting edges achieve outstanding sharpness and strength, promoting chip removal.
- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidschärfe, Stabilität und guter Spanabfuhr.

| Drill diameter<br>Bohrer Ø<br>d1(mm) | Drilling depth<br>Bohrtiefe<br>(L/d1) | Cooling mode<br>Kühlmittel | Shank<br>Schaft                | Type<br>Typ    | Basic dimension(mm) · Basis Abmessungen |                               |                            |                                               |                             | Grade<br>Sorte |
|--------------------------------------|---------------------------------------|----------------------------|--------------------------------|----------------|-----------------------------------------|-------------------------------|----------------------------|-----------------------------------------------|-----------------------------|----------------|
|                                      |                                       |                            |                                |                | Shank diameter Ø<br>Schaftdurchmesser   | Overall length<br>Gesamtlänge | Flute length<br>Nutenlänge | effective drill length<br>Effektive Nutzlänge | Shank length<br>Schaftlänge |                |
|                                      |                                       |                            |                                |                | d2(h6)                                  | l1                            | l2                         | l3                                            | l4                          |                |
| 20.0                                 | 3                                     | External<br>Extern         | Straight<br>shank              | 1534SU03-2000  | 20                                      | 131                           | 79                         | 55                                            | 50                          | ●              |
|                                      | 5                                     |                            |                                | 1536SU05-2000  | 20                                      | 153                           | 101                        | 77                                            | 50                          | ●              |
|                                      | 3                                     | Internal<br>Intern         | Zylinder-<br>schaft            | 1534SU03C-2000 | 20                                      | 131                           | 79                         | 55                                            | 50                          | ●              |
|                                      | 5                                     |                            |                                | 1536SU05C-2000 | 20                                      | 153                           | 101                        | 77                                            | 50                          | ●              |
|                                      | 3                                     |                            | Weldon<br>shank/ Schaft        | 1634SU03C-2000 | 20                                      | 131                           | 79                         | 55                                            | 50                          | ●              |
|                                      | 5                                     |                            |                                | 1636SU05C-2000 | 20                                      | 153                           | 101                        | 77                                            | 50                          | ●              |
|                                      | 3                                     |                            | Whistle notch<br>shank/ Schaft | 1734SU03C-2000 | 20                                      | 131                           | 79                         | 55                                            | 50                          | ●              |
|                                      | 5                                     |                            |                                | 1736SU05C-2000 | 20                                      | 153                           | 101                        | 77                                            | 50                          | ●              |

# Drilling - Bohren

Recommended cutting data - Schnittdatenempfehlung

## SU series twist drills - SU Spiralbohrer Serie (Internal coolant / Kühlung)

8D

| Workpiece material<br>Werkstückstoff | Mild steel<br>Baustahl<br>HB≤180 |             | Carbon steel,<br>alloy steel<br>Kohlenstoffstahl<br>Leg. Stahl<br>~30HRC |             | Pre-hardened<br>steel<br>Vergüteter Stahl<br>~40HRC |             | Stainless steel<br>Rostfreier Stahl |             | Cast iron<br>Gusseisen    |             | Nodular cast iron<br>GGG<br>Kugelgraphitguss |             | Aluminum alloy<br>Alulegierungen |             | Heat resistant alloy<br>Warmfeste Legierungen |             |
|--------------------------------------|----------------------------------|-------------|--------------------------------------------------------------------------|-------------|-----------------------------------------------------|-------------|-------------------------------------|-------------|---------------------------|-------------|----------------------------------------------|-------------|----------------------------------|-------------|-----------------------------------------------|-------------|
| Vc                                   | 80~150m/min                      |             | 80~150m/min                                                              |             | 50~80m/min                                          |             | 40~60m/min                          |             | 80~150m/min               |             | 60~120m/min                                  |             | 100~180m/min                     |             | 15~25m/min                                    |             |
| Ø<br>(mm)                            | n<br>(min <sup>-1</sup> )        | f<br>(mm/r) | n<br>(min <sup>-1</sup> )                                                | f<br>(mm/r) | n<br>(min <sup>-1</sup> )                           | f<br>(mm/r) | n<br>(min <sup>-1</sup> )           | f<br>(mm/r) | n<br>(min <sup>-1</sup> ) | f<br>(mm/r) | n<br>(min <sup>-1</sup> )                    | f<br>(mm/r) | n<br>(min <sup>-1</sup> )        | f<br>(mm/r) | n<br>(min <sup>-1</sup> )                     | f<br>(mm/r) |
| 3                                    | 12700                            | 0.06~0.10   | 12700                                                                    | 0.06~0.10   | 7400                                                | 0.06~0.10   | 5300                                | 0.03~0.07   | 12700                     | 0.06~0.10   | 9500                                         | 0.06~0.10   | 15000                            | 0.09~0.12   | 2100                                          | 0.03~0.06   |
| 4                                    | 9600                             | 0.08~0.12   | 9600                                                                     | 0.08~0.12   | 5600                                                | 0.08~0.12   | 4000                                | 0.04~0.08   | 9600                      | 0.08~0.12   | 7000                                         | 0.08~0.12   | 11100                            | 0.10~0.15   | 1600                                          | 0.04~0.07   |
| 5                                    | 7600                             | 0.10~0.14   | 7600                                                                     | 0.10~0.14   | 4500                                                | 0.10~0.14   | 3200                                | 0.05~0.10   | 7600                      | 0.10~0.14   | 5700                                         | 0.10~0.14   | 9000                             | 0.10~0.14   | 1250                                          | 0.05~0.09   |
| 6                                    | 6400                             | 0.11~0.16   | 6400                                                                     | 0.11~0.16   | 3700                                                | 0.11~0.16   | 2700                                | 0.06~0.12   | 6400                      | 0.11~0.16   | 4700                                         | 0.11~0.16   | 7400                             | 0.11~0.16   | 1050                                          | 0.06~0.11   |
| 8                                    | 4800                             | 0.13~0.19   | 4800                                                                     | 0.13~0.19   | 2800                                                | 0.13~0.19   | 2000                                | 0.08~0.16   | 4800                      | 0.13~0.19   | 3600                                         | 0.13~0.19   | 5600                             | 0.13~0.19   | 800                                           | 0.08~0.14   |
| 10                                   | 3800                             | 0.14~0.22   | 3800                                                                     | 0.14~0.22   | 2200                                                | 0.14~0.22   | 1600                                | 0.10~0.18   | 3800                      | 0.14~0.22   | 2800                                         | 0.14~0.22   | 4500                             | 0.14~0.22   | 600                                           | 0.10~0.16   |
| 12                                   | 3200                             | 0.16~0.24   | 3200                                                                     | 0.16~0.24   | 1900                                                | 0.16~0.24   | 1300                                | 0.12~0.20   | 3200                      | 0.16~0.24   | 2400                                         | 0.16~0.24   | 3700                             | 0.16~0.24   | 500                                           | 0.12~0.18   |
| 14                                   | 2700                             | 0.18~0.28   | 2700                                                                     | 0.18~0.28   | 1600                                                | 0.18~0.28   | 1100                                | 0.13~0.22   | 2700                      | 0.18~0.28   | 2100                                         | 0.18~0.28   | 3200                             | 0.18~0.28   | 450                                           | 0.13~0.20   |
| 16                                   | 2400                             | 0.20~0.29   | 2400                                                                     | 0.20~0.29   | 1400                                                | 0.20~0.29   | 1000                                | 0.14~0.25   | 2400                      | 0.20~0.29   | 1800                                         | 0.20~0.29   | 2800                             | 0.20~0.29   | 400                                           | 0.14~0.23   |
| 18                                   | 2100                             | 0.24~0.32   | 2100                                                                     | 0.24~0.32   | 1200                                                | 0.24~0.32   | 880                                 | 0.15~0.28   | 2100                      | 0.24~0.32   | 1600                                         | 0.24~0.32   | 2500                             | 0.24~0.32   | 350                                           | 0.15~0.25   |

1. When the tool is used for the first time, please make a test cutting with 90% of cutting speed or 85% feed rate mentioned above. If the cutting conditions remain stable, gradually increase the cutting speed and feed rate.
2. The cutting conditions above are for drilling with emulsion.
3. Use a collet without any defect or dust. The radial run-out of drill must be under 0.02mm.
4. These conditions above are for cutting depth under 8D.

1. Beim ersten Einsatz 90% der empfohlenen Schnittgeschwindigkeit oder 85% des Vorschubes wählen. Bei stabiler Bearbeitung die Schnittdaten entsprechend erhöhen.
2. Die obigen Schnittdatenempfehlungen basieren auf dem Einsatz von Emulsion.
3. Keine defekte Werkzeugaufnahme wählen. Die Rundlaufgenauigkeit muss unter 0,02mm liegen.
4. Die obigen Schnittdaten sind für Bohrungstiefen unter 8xD ausgelegt.

C

Solid Carbide drills  
Vollhartmetallbohrer