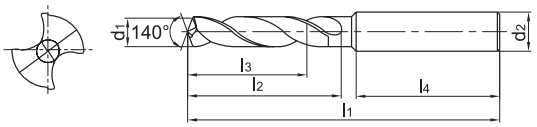
SU series · SU Serie

General machining · Allgemeine Bearbeitung

External Coolant
Externe Kühlung

Straight shank
Zylinderschaft

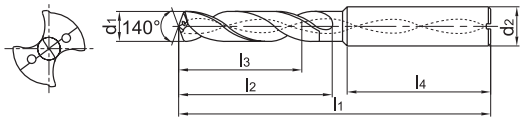
DIN 6535 HA



Internal Coolant
Interne Kühlung

Straight shank
Zylinderschaft

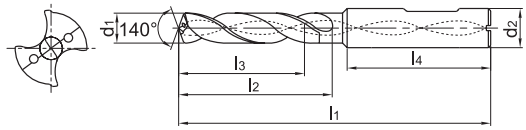
DIN 6535 HA



Internal Coolant
Interne Kühlung

Weldon shank · Schaft

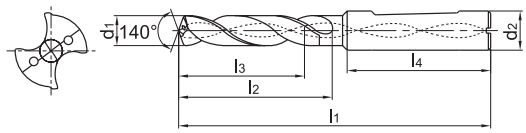
DIN 6535 HB



Internal Coolant
Interne Kühlung

Whistle notch shank · Schaft

DIN 6535 HE



- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
0.9	3	External Extern	Straight shank Zylinder-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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
2.9	3	External Extern	Straight shank Zylinder-schaft	**1534SU03-0290**	6	62	20	14	36	●
	5			**1536SU05-0290**	6	66	28	23	36	●
3.0	3			**1534SU03-0300**	6	62	20	14	36	●
	5			**1536SU05-0300**	6	66	28	23	36	●
	3	Internal Intern		**1534SU03C-0300**	6	62	20	14	36	●
	5			**1536SU05C-0300**	6	66	28	23	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0300**	6	62	20	14	36	●
	5			**1636SU05C-0300**	6	62	20	14	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0300**	6	66	28	23	36	●
	5			**1736SU05C-0300**	6	66	28	23	36	●
	8		straight shank Zylinderschaft	**1538SU08C-0300**	6	72	34	29	36	●
3.1	3	External Extern	Straight shank Zylinder-schaft	**1534SU03-0310**	6	62	20	14	36	●
	5			**1536SU05-0310**	6	66	28	23	36	●
	3	Internal Intern		**1534SU03C-0310**	6	62	20	14	36	●
	5			**1536SU05C-0310**	6	66	28	23	36	●
	3		Weldon shank/ Schaft	**1634SU05C-0310**	6	62	20	14	36	●
	5			**1636SU05C-0310**	6	66	28	23	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0310**	6	62	20	14	36	●
	5			**1736SU05C-0310**	6	66	28	23	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0310**	6	72	34	29	36	●
3.2	3	External Extern		**1534SU03-0320**	6	62	20	14	36	●
	5			**1536SU05-0320**	6	66	28	23	36	●
	3	Internal Intern		**1534SU03C-0320**	6	62	20	14	36	●
	5			**1536SU05C-0320**	6	66	28	23	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0320**	6	62	20	14	36	●
	5			**1636SU05C-0320**	6	66	28	23	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0320**	6	62	20	14	36	●
	5			**1736SU05C-0320**	6	66	28	23	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0320**	6	72	34	29	36	●
3.25	3	External Extern		**1534SU03-0325**	6	62	20	14	36	●
	5			**1536SU05-0325**	6	66	28	23	36	●
	3	Internal Intern		**1534SU03C-0325**	6	62	20	14	36	●
	5			**1536SU05C-0325**	6	66	28	23	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0325**	6	62	20	14	36	○
	5			**1636SU05C-0325**	6	66	28	23	36	○
	3		Whistle notch 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 Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

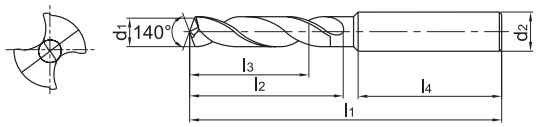
General machining · Allgemeine Bearbeitung

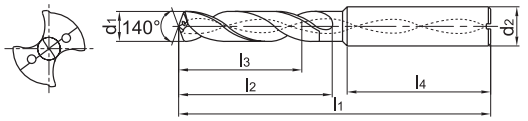

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

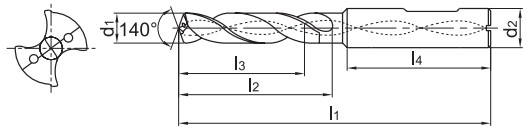

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

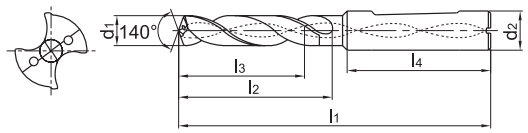

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
3.3	3	External Extern	Straight shank Zylinder-schaft	1534SU03-0330	6	62	20	14	36	●
	5			1536SU05-0330	6	66	28	23	36	●
	3	Internal Intern		1534SU03C-0330	6	62	20	14	36	●
	5			1536SU05C-0330	6	66	28	23	36	●
	3		Weldon shank/ Schaft	1634SU03C-0330	6	62	20	14	36	●
	5			1636SU05C-0330	6	66	28	23	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0330	6	62	20	14	36	●
	5			1736SU05C-0330	6	66	28	23	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0330	6	72	34	29	36	●
3.4	3	External Extern		1534SU03-0340	6	62	20	14	36	●
	5			1536SU05-0340	6	66	28	23	36	●
	3	Internal Intern		1534SU03C-0340	6	62	20	14	36	●
	5			1536SU05C-0340	6	66	28	23	36	●
	3		Weldon shank/ Schaft	1634SU03C-0340	6	62	20	14	36	●
	5			1636SU05C-0340	6	66	28	23	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0340	6	62	20	14	36	●
	5			1736SU05C-0340	6	66	28	23	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0340	6	72	34	29	36	●
3.5	3	External Extern		1534SU03-0350	6	62	20	14	36	●
	5			1536SU05-0350	6	66	28	23	36	●
	3	Internal Intern		1534SU03C-0350	6	62	20	14	36	●
	5			1536SU05C-0350	6	66	28	23	36	●
	3		Weldon shank/ Schaft	1634SU03C-0350	6	62	20	14	36	●
	5			1636SU05C-0350	6	66	28	23	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0350	6	62	20	14	36	●
	5			1736SU05C-0350	6	66	28	23	36	●
	8		straight shank Zylinderschaft	1538SU08C-0350	6	72	34	29	36	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
3.6	3	External Extern	Straight shank	1534SU03-0360	6	62	20	14	36	●
	5			1536SU05-0360	6	66	28	23	36	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-0360	6	62	20	14	36	●
	5			1536SU05C-0360	6	66	28	23	36	●
	3		Weldon shank/ Schaft	1634SU03C-0360	6	62	20	14	36	●
	5			1636SU05C-0360	6	66	28	23	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0360	6	62	20	14	36	●
	5			1736SU05C-0360	6	66	28	23	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0360	6	72	34	29	36	●
3.7	3	External Extern		1534SU03-0370	6	62	20	14	36	●
	5			1536SU05-0370	6	66	28	23	36	●
	3	Internal Intern		1534SU03C-0370	6	62	20	14	36	●
	5			1536SU05C-0370	6	66	28	23	36	●
	3		Weldon shank/ Schaft	1634SU03C-0370	6	62	20	14	36	●
	5			1636SU05C-0370	6	66	28	23	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0370	6	62	20	14	36	●
	5			1736SU05C-0370	6	66	28	23	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0370	6	72	34	29	36	●
3.8	3	External Extern		1534SU03-0380	6	66	24	17	36	●
	5			1536SU05-0380	6	74	36	29	36	●
	3	Internal Intern		1534SU03C-0380	6	66	24	17	36	●
	5			1536SU05C-0380	6	74	36	29	36	●
	3		Weldon shank/Schaft	1634SU03C-0380	6	66	24	17	36	●
	5			1636SU05C-0380	6	74	36	29	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0380	6	66	24	17	36	●
	5			1736SU05C-0380	6	74	36	29	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0380	6	81	43	36	36	●
3.9	3	External Extern		1534SU03-0390	6	66	24	17	36	●
	5			1536SU05-0390	6	74	36	29	36	●
	3	Internal Intern		1534SU03C-0390	6	66	24	17	36	●
	5			1536SU05C-0390	6	74	36	29	36	●
	3		Weldon shank/ Schaft	1634SU03C-0390	6	66	24	17	36	●
	5			1636SU05C-0390	6	74	36	29	36	●
	3		Whistle notch shank/Schaft	1734SU03C-0390	6	66	24	17	36	●
	5			1736SU05C-0390	6	74	36	29	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0390	6	81	43	36	36	●
4.0	3	External Extern		1534SU03-0400	6	66	24	17	36	●
	5			1536SU05-0400	6	74	36	29	36	●
	3	Internal Intern		1534SU03C-0400	6	66	24	17	36	●
	5			1536SU05C-0400	6	74	36	29	36	●

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Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

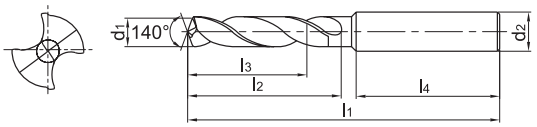
General machining · Allgemeine Bearbeitung

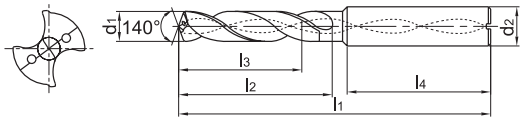

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

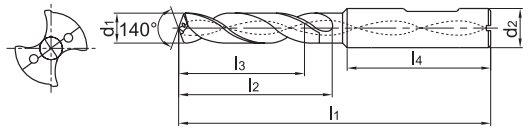

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

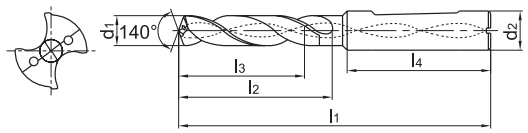

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
4.0	3	Internal Intern	Weldon shank/ Schaft	**1634SU03C-0400**	6	66	24	17	36	●
	5			**1636SU05C-0400**	6	74	36	29	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0400**	6	66	24	17	36	●
	5			**1736SU05C-0400**	6	74	36	29	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0400**	6	81	43	36	36	●
4.1	3	External Extern		**1534SU03-0410**	6	66	24	17	36	●
	5			**1536SU05-0410**	6	74	36	29	36	●
	3	Internal Intern		**1534SU03C-0410**	6	66	24	17	36	●
	5			**1536SU05C-0410**	6	74	36	29	36	●
	3		Weldon shank/Schaft	**1634SU03C-0410**	6	66	24	17	36	●
	5			**1636SU05C-0410**	6	74	36	29	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0410**	6	66	24	17	36	●
	5			**1736SU05C-0410**	6	74	36	29	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0410**	6	81	43	36	36	●
4.2	3	External Extern		**1534SU03-0420**	6	66	24	17	36	●
	5			**1536SU05-0420**	6	74	36	29	36	●
	3	Internal Intern		**1534SU03C-0420**	6	66	24	17	36	●
	5			**1536SU05C-0420**	6	74	36	29	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0420**	6	66	24	17	36	●
	5			**1636SU05C-0420**	6	74	36	29	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0420**	6	66	24	17	36	●
	5			**1736SU05C-0420**	6	74	36	29	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0420**	6	81	43	36	36	●
4.3	3	External Extern		**1534SU03-0430**	6	66	24	17	36	●
	5			**1536SU05-0430**	6	74	36	29	36	●
	3	Internal Intern		**1534SU03C-0430**	6	66	24	17	36	●
	5			**1536SU05C-0430**	6	74	36	29	36	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
4.3	3	Internal Intern	Weldon shank/Schaft	1634SU03C-0430	6	66	24	17	36	●
	5			1636SU05C-0430	6	74	36	29	36	●
	3		Whistle notch 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 Extern	Straight shank	1534SU03-0440	6	66	24	17	36	●
	5			1536SU05-0440	6	74	36	29	36	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-0440	6	66	24	17	36	●
	5			1536SU05C-0440	6	74	36	29	36	●
	3		Weldon shank/Schaft	1634SU03C-0440	6	66	24	17	36	●
	5			1636SU05C-0440	6	74	36	29	36	●
	3		Whistle notch shank/Schaft	1734SU03C-0440	6	66	24	17	36	●
	5			1736SU05C-0440	6	74	36	29	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0440	6	81	43	36	36	●
4.5	3	External Extern		1534SU03-0450	6	66	24	17	36	●
	5			1536SU05-0450	6	74	36	29	36	●
	3	Internal Intern		1534SU03C-0450	6	66	24	17	36	●
	5			1536SU05C-0450	6	74	36	29	36	●
	3		Weldon shank/Schaft	1634SU03C-0450	6	66	24	17	36	●
	5			1636SU05C-0450	6	74	36	29	36	●
	3		Whistle notch shank/Schaft	1734SU03C-0450	6	66	24	17	36	●
	5			1736SU05C-0450	6	74	36	29	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0450	6	81	43	36	36	●
4.6	3	External Extern		1534SU03-0460	6	66	24	17	36	●
	5			1536SU05-0460	6	74	36	29	36	●
	3	Internal Intern		1534SU03C-0460	6	66	24	17	36	●
	5			1536SU05C-0460	6	74	36	29	36	●
	3		Weldon shank/Schaft	1634SU03C-0460	6	66	24	17	36	●
	5			1636SU05C-0460	6	74	36	29	36	●
	3		Whistle notch shank/Schaft	1734SU03C-0460	6	66	24	17	36	●
	5			1736SU05C-0460	6	74	36	29	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0460	6	81	43	36	36	●
4.65	3	External Extern		1534SU03-0465	6	66	24	17	36	●
	5			1536SU05-0465	6	74	36	29	36	●
	3	Internal Intern		1534SU03C-0465	6	66	24	17	36	●
	5			1536SU05C-0465	6	74	36	29	36	●
	3		Weldon shank/ Schaft	1634SU03C-0465	6	66	24	17	36	○
	5			1636SU05C-0465	6	74	36	29	36	●
	3		Whistle notch 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 Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

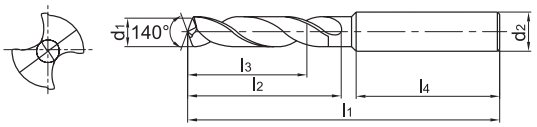
General machining · Allgemeine Bearbeitung

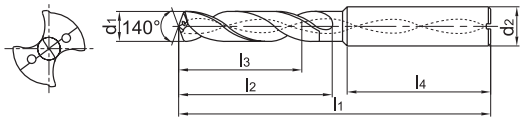

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

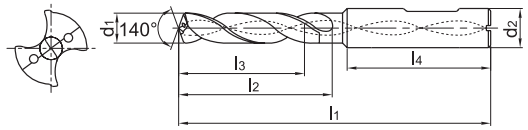

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

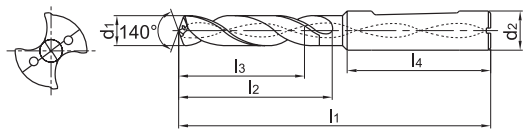

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
4.7	3	External Extern	Straight shank	**1534SU03-0470**	6	66	24	17	36	●
	5		Zylinder-schaft	**1536SU05-0470**	6	74	36	29	36	●
	3	Internal Intern		**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	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0470**	6	81	43	36	36	●
4.8	3	External Extern		**1534SU03-0480**	6	66	28	20	36	●
	5			**1536SU05-0480**	6	82	44	35	36	●
	3	Internal Intern		**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	●
	5			**1736SU05C-0480**	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0480**	6	95	57	48	36	●
4.9	3	External Extern		**1534SU03-0490**	6	66	28	20	36	●
	5			**1536SU05-0490**	6	82	44	35	36	●
	3	Internal Intern		**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	●
	8		straight shank Zylinderschaft	**1538SU08C-0490**	6	95	57	48	36	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
5.0	3	External Extern	Straight shank	1534SU03-0500	6	66	28	20	36	●
	5			1536SU05-0500	6	82	44	35	36	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-0500	6	66	28	20	36	●
	5			1536SU05C-0500	6	82	44	35	36	●
	3		Weldon shank/ Schaft	1634SU03C-0500	6	66	28	20	36	○
	5			1636SU05C-0500	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0500	6	66	28	20	36	●
	5			1736SU05C-0500	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0500	6	95	57	48	36	●
5.1	3	External Extern		1534SU03-0510	6	66	28	20	36	●
	5			1536SU05-0510	6	82	44	35	36	●
	3	Internal Intern		1534SU03C-0510	6	66	28	20	36	●
	5			1536SU05C-0510	6	82	44	35	36	●
	3		Weldon shank/ Schaft	1634SU03C-0510	6	66	28	20	36	●
	5			1636SU05C-0510	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0510	6	66	28	20	36	●
	5			1736SU05C-0510	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0510	6	95	57	48	36	●
5.2	3	External Extern		1534SU03-0520	6	66	28	20	36	●
	5			1536SU05-0520	6	82	44	35	36	●
	3	Internal Intern		1534SU03C-0520	6	66	28	20	36	●
	5			1536SU05C-0520	6	82	44	35	36	●
	3		Weldon shank/ Schaft	1634SU03C-0520	6	66	28	20	36	●
	5			1636SU05C-0520	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0520	6	66	28	20	36	●
	5			1736SU05C-0520	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0520	6	95	57	48	36	●
5.3	3	External Extern		1534SU03-0530	6	66	28	20	36	●
	5			1536SU05-0530	6	82	44	35	36	●
	3	Internal Intern		1534SU03C-0530	6	66	28	20	36	●
	5			1536SU05C-0530	6	82	44	35	36	●
	3		Weldon shank/ Schaft	1634SU03C-0530	6	66	28	20	36	●
	5			1636SU05C-0530	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0530	6	66	28	20	36	●
	5			1736SU05C-0530	6	82	44	35	36	●
	8		straight shank Zylinderschaft	1538SU08C-0530	6	95	57	48	36	●

Material Overview · Material Übersicht

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

Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

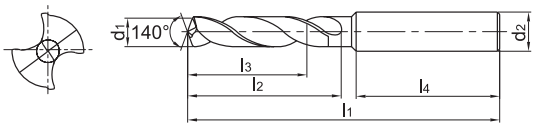
General machining · Allgemeine Bearbeitung

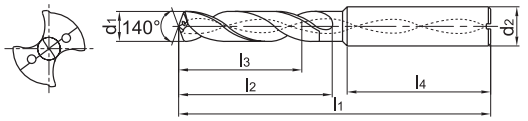

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

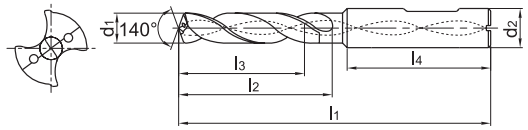

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

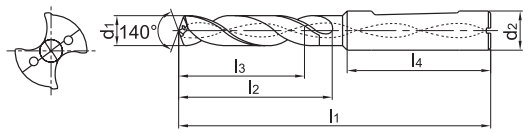

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
5.4	3	External Extern	Straight shank	**1534SU03-0540**	6	66	28	20	36	●
	5			**1536SU05-0540**	6	82	44	35	36	●
	3	Internal Intern	Zylinder-schaft	**1534SU03C-0540**	6	66	28	20	36	●
	5			**1536SU05C-0540**	6	82	44	35	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0540**	6	66	28	20	36	●
	5			**1636SU05C-0540**	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0540**	6	66	28	20	36	●
	5			**1736SU05C-0540**	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0540**	6	95	57	48	36	●
5.5	3	External Extern		**1534SU03-0550**	6	66	28	20	36	●
	5			**1536SU05-0550**	6	82	44	35	36	●
	3	Internal Intern		**1534SU03C-0550**	6	66	28	20	36	●
	5			**1536SU05C-0550**	6	82	44	35	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0550**	6	66	28	20	36	●
	5			**1636SU05C-0550**	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0550**	6	66	28	20	36	●
	5			**1736SU05C-0550**	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0550**	6	95	57	48	36	●
5.55	3	External Extern		**1534SU03-0555**	6	66	28	20	36	●
	5			**1536SU05-0555**	6	82	44	35	36	●
	3	Internal Intern		**1534SU03C-0555**	6	66	28	20	36	●
	5			**1536SU05C-0555**	6	82	44	35	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0555**	6	66	28	20	36	○
	5			**1636SU05C-0555**	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0555**	6	66	28	20	36	●
	5			**1736SU05C-0555**	6	82	44	35	36	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
5.6	3	External Extern	Straight shank	1534SU03-0560	6	66	28	20	36	●
	5			1536SU05-0560	6	82	44	35	36	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-0560	6	66	28	20	36	●
	5			1536SU05C-0560	6	82	44	35	36	●
	3		Weldon shank/ Schaft	1634SU03C-0560	6	66	28	20	36	●
	5			1636SU05C-0560	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0560	6	66	28	20	36	●
	5			1736SU05C-0560	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0560	6	95	57	48	36	●
5.7	3	External Extern		1534SU03-0570	6	66	28	20	36	●
	5			1536SU05-0570	6	82	44	35	36	●
	3	Internal Intern		1534SU03C-0570	6	66	28	20	36	●
	5			1536SU05C-0570	6	82	44	35	36	●
	3		Weldon shank/ Schaft	1634SU03C-0570	6	66	28	20	36	●
	5			1636SU05C-0570	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0570	6	66	28	20	36	●
	5			1736SU05C-0570	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0570	6	95	57	48	36	●
5.8	3	External Extern		1534SU03-0580	6	66	28	20	36	●
	5			1536SU05-0580	6	82	44	35	36	●
	3	Internal Intern		1534SU03C-0580	6	66	28	20	36	●
	5			1536SU05C-0580	6	82	44	35	36	●
	3		Weldon shank/ Schaft	1634SU03C-0580	6	66	28	20	36	●
	5			1636SU05C-0580	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0580	6	66	28	20	36	●
	5			1736SU05C-0580	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0580	6	95	57	48	36	●
5.9	3	External Extern		1534SU03-0590	6	66	28	20	36	●
	5			1536SU05-0590	6	82	44	35	36	●
	3	Internal Intern		1534SU03C-0590	6	66	28	20	36	●
	5			1536SU05C-0590	6	82	44	35	36	●
	3		Weldon shank/Schaft	1634SU03C-0590	6	66	28	20	36	●
	5			1636SU05C-0590	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0590	6	66	28	20	36	●
	5			1736SU05C-0590	6	82	44	35	36	●
	8		straight shank Zylinderschaft	1538SU08C-0590	6	95	57	48	36	●

Material Overview · Material Übersicht

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

Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

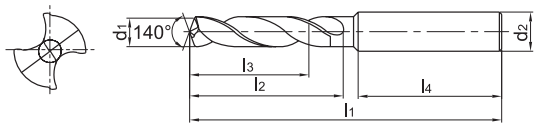
General machining · Allgemeine Bearbeitung

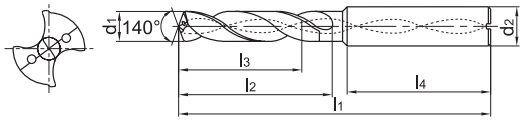

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

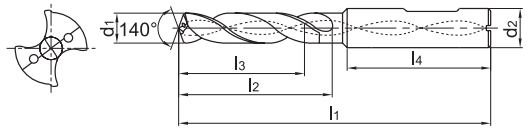

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

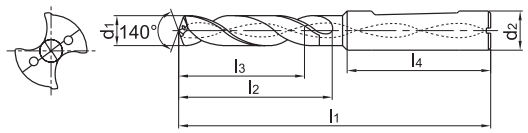

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
6.0	3	External Extern	Straight shank	1534SU03-0600	6	66	28	20	36	●
	5			1536SU05-0600	6	82	44	35	36	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-0600	6	66	28	20	36	●
	5			1536SU05C-0600	6	82	44	35	36	●
	3		Weldon shank/ Schaft	1634SU03C-0600	6	66	28	20	36	●
	5			1636SU05C-0600	6	82	44	35	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0600	6	66	28	20	36	●
	5			1736SU05C-0600	6	82	44	35	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0600	6	95	57	48	36	●
6.1	3	External Extern		1534SU03-0610	8	79	34	24	36	●
	5			1536SU05-0610	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0610	8	79	34	24	36	●
	5			1536SU05C-0610	8	91	53	43	36	●
	3		Weldon shank/ Schaft	1634SU03C-0610	8	79	34	24	36	●
	5			1636SU05C-0610	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0610	8	79	34	24	36	●
	5			1736SU05C-0610	8	91	53	43	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0610	8	114	76	66	36	●
6.2	3	External Extern		1534SU03-0620	8	79	34	24	36	●
	5			1536SU05-0620	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0620	8	79	34	24	36	●
	5			1536SU05C-0620	8	91	53	43	36	●
	3		Weldon shank/ Schaft	1634SU03C-0620	8	79	34	24	36	●
	5			1636SU05C-0620	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0620	8	79	34	24	36	●
	5			1736SU05C-0620	8	91	53	43	36	●
	8		straight shank Zylinderschaft	1538SU08C-0620	8	114	76	66	36	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
6.3	3	External Extern	Straight shank	1534SU03-0630	8	79	34	24	36	●
	5			1536SU05-0630	8	91	53	43	36	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-0630	8	79	34	24	36	●
	5			1536SU05C-0630	8	91	53	43	36	●
	3		Weldon shank/Schaft	1634SU03C-0630	8	79	34	24	36	●
	5			1636SU05C-0630	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0630	8	79	34	24	36	●
	5			1736SU05C-0630	8	91	53	43	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0630	8	114	76	66	36	●
6.4	3	External Extern		1534SU03-0640	8	79	34	24	36	●
	5			1536SU05-0640	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0640	8	79	34	24	36	●
	5			1536SU05C-0640	8	91	53	43	36	●
	3		Weldon shank/ Schaft	1634SU03C-0640	8	79	34	24	36	●
	5			1636SU05C-0640	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0640	8	79	34	24	36	●
	5			1736SU05C-0640	8	91	53	43	36	●
	8			1538SU08C-0640	8	114	76	66	36	●
6.5	3	External Extern	Straight shank Zylinder-schaft	1534SU03-0650	8	79	34	24	36	●
	5			1536SU05-0650	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0650	8	79	34	24	36	●
	5			1536SU05C-0650	8	91	53	43	36	●
	3		Weldon shank/ Schaft	1634SU03C-0650	8	79	34	24	36	●
	5			1636SU05C-0650	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0650	8	79	34	24	36	●
	5			1736SU05C-0650	8	91	53	43	36	●
	8			1538SU08C-0650	8	114	76	66	36	●
6.6	3	External Extern	Straight shank Zylinder-schaft	1534SU03-0660	8	79	34	24	36	●
	5			1536SU05-0660	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0660	8	79	34	24	36	●
	5			1536SU05C-0660	8	91	53	43	36	●
	3		Weldon shank/ Schaft	1634SU03C-0660	8	79	34	24	36	●
	3			1636SU05C-0660	8	91	53	43	36	●
	5		Whistle notch shank/ Schaft	1734SU03C-0660	8	79	34	24	36	●
	5			1736SU05C-0660	8	91	53	43	36	●
	8		straight shank Zylinderschaft	1538SU08C-0660	8	114	76	66	36	●

Material Overview · Material Übersicht

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

Code key C 10
ISO Kennzeichen
Cutting data 96-109
Schnittdaten
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Technische Information
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

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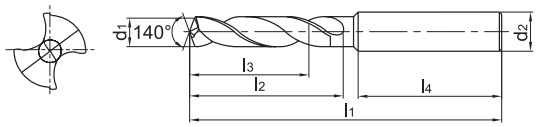
General machining · Allgemeine Bearbeitung

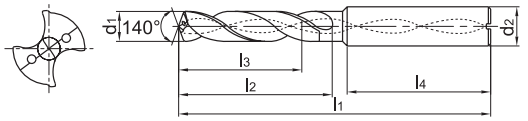

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

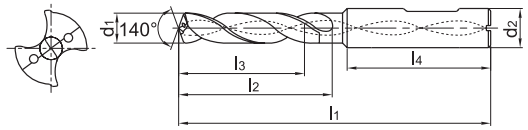

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

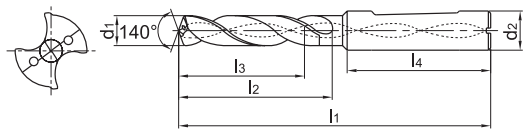

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
6.7	3	External Extern	Straight shank Zylinder-schaft	**1534SU03-0670**	8	79	34	24	36	●
	5			**1536SU05-0670**	8	91	53	43	36	●
	3	Internal Intern		**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	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0670**	8	114	76	66	36	●
6.75	3	External Extern		**1534SU03-0675**	8	79	34	24	36	●
	5			**1536SU05-0675**	8	91	53	43	36	●
	3	Internal Intern		**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 Extern	Straight shank Zylinder-schaft	**1534SU03-0680**	8	79	34	24	36	●
	5			**1536SU05-0680**	8	91	53	43	36	●
	3	Internal Intern		**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 Zylinderschaft	**1538SU08C-0680**	8	114	76	66	36	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
6.9	3	External Extern	Straight shank	**1534SU03-0690**	8	79	34	24	36	●
	5			**1536SU05-0690**	8	91	53	43	36	●
	3	Internal Intern	Zylinder-schaft	**1534SU03C-0690**	8	79	34	24	36	●
	5			**1536SU05C-0690**	8	91	53	43	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0690**	8	79	34	24	36	●
	5			**1636SU05C-0690**	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0690**	8	79	34	24	36	●
	5			**1736SU05C-0690**	8	91	53	43	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0690**	8	114	76	66	36	●
7.0	3	External Extern		**1534SU03-0700**	8	79	34	24	36	●
	5			**1536SU05-0700**	8	91	53	43	36	●
	3	Internal Intern		**1534SU03C-0700**	8	79	34	24	36	●
	5			**1536SU05C-0700**	8	91	53	43	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0700**	8	79	34	24	36	●
	5			**1636SU05C-0700**	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0700**	8	79	34	24	36	●
	5			**1736SU05C-0700**	8	91	53	43	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0700**	8	116	76	66	36	●
7.1	3	External Extern		**1534SU03-0710**	8	79	41	29	36	●
	5			**1536SU05-0710**	8	91	53	43	36	●
	3	Internal Intern		**1534SU03C-0710**	8	79	41	29	36	●
	5			**1536SU05C-0710**	8	91	53	43	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0710**	8	79	41	29	36	●
	5			**1636SU05C-0710**	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0710**	8	79	41	29	36	●
	5			**1736SU05C-0710**	8	91	53	43	36	●
	8		Straight shank Zylinder-schaft	**1538SU08C-0710**	8	116	76	66	36	●
7.2	3	External Extern		**1534SU03-0720**	8	79	41	29	36	●
	5			**1536SU05-0720**	8	91	53	43	36	●
	3	Internal Intern		**1534SU03C-0720**	8	79	41	29	36	●
	5			**1536SU05C-0720**	8	91	53	43	36	●
	3		Weldon shank/ Schaft	**1634SU03C-0720**	8	79	41	29	36	●
	5			**1636SU05C-0720**	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	**1734SU03C-0720**	8	79	41	29	36	●
	5			**1736SU05C-0720**	8	91	53	43	36	●
	8		straight shank Zylinderschaft	**1538SU08C-0720**	8	116	76	66	36	●

Material Overview · Material Übersicht

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

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

SU series · SU Serie

General machining · Allgemeine Bearbeitung


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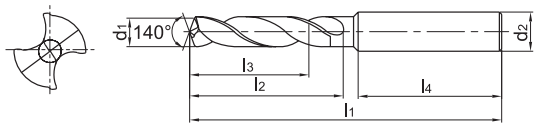
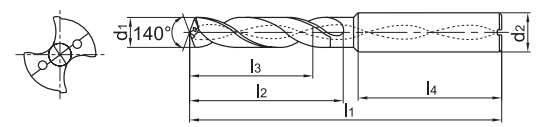
Externe Kühlung
Straight shank
Zylinderschaft

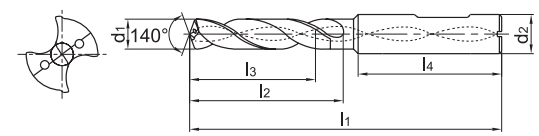

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

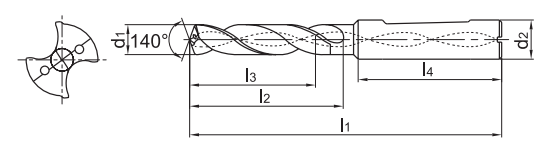

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
7.3	3	External Extern	Straight shank	**1534SU03-0730**	8	79	41	29	36	●
	5			**1536SU05-0730**	8	91	53	43	36	●
	3	Internal Intern	Zylinder-schaft	**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		Straight shank Zylinder-schaft	**1538SU08C-0730**	8	116	76	66	36	●
7.4	3	External Extern		**1534SU03-0740**	8	79	41	29	36	●
	5			**1536SU05-0740**	8	91	53	43	36	●
	3	Internal Intern		**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		Straight shank Zylinder-schaft	**1538SU08C-0740**	8	116	76	66	36	●
7.45	3	External Extern		**1534SU03-0745**	8	79	41	29	36	○
	5			**1536SU05-0745**	8	91	53	43	36	○
	3	Internal Intern		**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 Extern	Straight shank Zylinderschaft	**1534SU03-0750**	8	79	41	29	36	●
	5			**1536SU05-0750**	8	91	53	43	36	●

 ● ex Stock · ab Lager ○ on demand · auf Anfrage

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
7.5	3	Internal Intern	Straight shank Zylinderschaft	1534SU03C-0750	8	79	41	29	36	●
	5			1536SU05C-0750	8	91	53	43	36	●
	3		Weldon shank/ Schaft	1634SU03C-0750	8	79	41	29	36	●
	5			1636SU05C-0750	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0750	8	79	41	29	36	●
	5			1736SU05C-0750	8	91	53	43	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0750	8	116	76	66	36	●
7.6	3	External Extern		1534SU03-0760	8	79	41	29	36	●
	5			1536SU05-0760	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0760	8	79	41	29	36	●
	5			1536SU05C-0760	8	91	53	43	36	●
	3		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		Straight shank Zylinder-schaft	1538SU08C-0760	8	116	76	66	36	●
7.7	3	External Extern		1534SU03-0770	8	79	41	29	36	●
	5			1536SU05-0770	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0770	8	79	41	29	36	●
	5			1536SU05C-0770	8	91	53	43	36	●
	3		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		Straight shank Zylinder-schaft	1538SU08C-0770	8	116	76	66	36	●
7.8	3	External Extern		1534SU03-0780	8	79	41	29	36	●
	5			1536SU05-0780	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0780	8	79	41	29	36	●
	5			1536SU05C-0780	8	91	53	43	36	●
	3		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		Straight shank Zylinder-schaft	1538SU08C-0780	8	116	76	66	36	●
7.9	3	External Extern		1534SU03-0790	8	79	41	29	36	●
	5			1536SU05-0790	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0790	8	79	41	29	36	●
	5			1536SU05C-0790	8	91	53	43	36	●
	3		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 Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

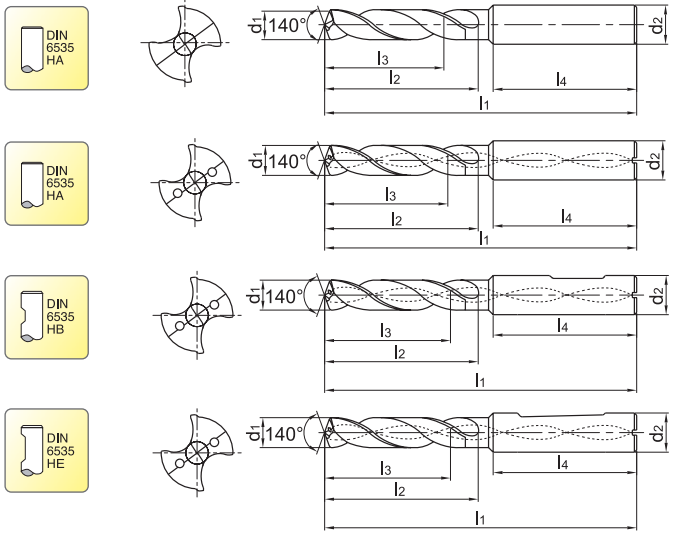
General machining · Allgemeine Bearbeitung


External Coolant
Externe Kühlung
Straight shank
Zylinderschaft


Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft


Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft



- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
7.9	3	Internal Intern	Whistle notch shank/ Schaft	1734SU03C-0790	8	79	41	29	36	●
	5			1736SU05C-0790	8	91	53	43	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0790	8	116	76	66	36	●
8.0	3	External Extern		1534SU03-0800	8	79	41	29	36	●
	5			1536SU05-0800	8	91	53	43	36	●
	3	Internal Intern		1534SU03C-0800	8	79	41	29	36	●
	5			1536SU05C-0800	8	91	53	43	36	●
	3		Weldon shank/ Schaft	1634SU03C-0800	8	79	41	29	36	●
	5			1636SU05C-0800	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1734SU03C-0800	8	79	41	29	36	●
	5			1736SU05C-0800	8	91	53	43	36	●
	8		Straight shank Zylinder-schaft	1538SU08C-0800	8	116	76	66	36	●
8.1	3	External Extern		1534SU03-0810	10	89	47	35	40	●
	5			1536SU05-0810	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0810	10	89	47	35	40	●
	5			1536SU05C-0810	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0810	10	89	47	35	40	●
	5			1636SU05C-0810	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0810	10	89	47	35	40	●
	5			1736SU05C-0810	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0810	10	142	95	83	40	●
8.2	3	External Extern		1534SU03-0820	10	89	47	35	40	●
	5			1536SU05-0820	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0820	10	89	47	35	40	●
	5			1536SU05C-0820	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0820	10	89	47	35	40	●
	5			1636SU05C-0820	10	103	61	49	40	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
8.2	3	Internal Intern	Whistle notch shank/ Schaft	1734SU03C-0820	10	89	47	35	40	●
	5			1736SU05C-0820	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0820	10	142	95	83	40	●
8.3	3	External Extern		1534SU03-0830	10	89	47	35	40	●
	5			1536SU05-0830	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0830	10	89	47	35	40	●
	5			1536SU05C-0830	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0830	10	89	47	35	40	●
	5			1636SU05C-0830	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0830	10	89	47	35	40	●
	5			1736SU05C-0830	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0830	10	142	95	83	40	●
8.4	3	External Extern		1534SU03-0840	10	89	47	35	40	●
	5			1536SU05-0840	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0840	10	89	47	35	40	●
	5			1536SU05C-0840	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0840	10	89	47	35	40	●
	5			1636SU05C-0840	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0840	10	89	47	35	40	●
	5			1736SU05C-0840	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0840	10	142	95	83	40	●
8.5	3	External Extern		1534SU03-0850	10	89	47	35	40	●
	5			1536SU05-0850	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0850	10	89	47	35	40	●
	5			1536SU05C-0850	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0850	10	89	47	35	40	●
	5			1636SU05C-0850	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0850	10	89	47	35	40	●
	5			1736SU05C-0850	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0850	10	142	95	83	40	●
8.6	3	External Extern		1534SU03-0860	10	89	47	35	40	●
	5			1536SU05-0860	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0860	10	89	47	35	40	●
	5			1536SU05C-0860	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0860	10	89	47	35	40	●
	5			1636SU05C-0860	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0860	10	89	47	35	40	●
	5			1736SU05C-0860	10	103	61	49	40	●
	8		straight shank Zylinderschaft	1538SU08C-0860	10	142	95	83	40	●

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Grade Sorte	Workpiece material · Werkstückstoff										
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			~40HRC	~50HRC	~60HRC						
KDG303	✔	✔	✔			✔	✔	✔			

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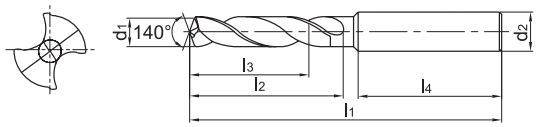
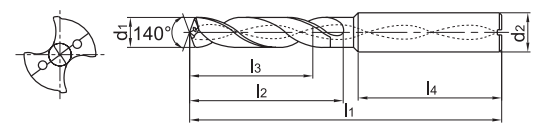
External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

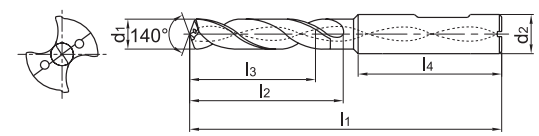

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

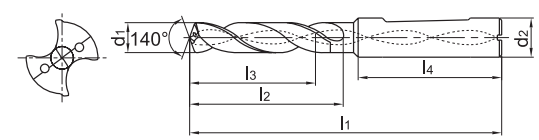

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
8.7	3	External Extern	Straight shank	**1534SU03-0870**	10	89	47	35	40	●
	5		Zylinder-schaft	**1536SU05-0870**	10	103	61	49	40	●
	3	Internal Intern		**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		Straight shank Zylinder schaft	**1538SU08C-0870**	10	142	95	83	40	●
8.8	3	External Extern		**1534SU03-0880**	10	89	47	35	40	●
	5			**1536SU05-0880**	10	103	61	49	40	●
	3	Internal Intern		**1534SU03C-0880**	10	89	47	35	40	●
	5			**1536SU05C-0880**	10	103	61	49	40	●
	3		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		Straight shank Zylinder schaft	**1538SU08C-0880**	10	142	95	83	40	●
8.9	3	External Extern		**1534SU03-0890**	10	89	47	35	40	●
	5			**1536SU05-0890**	10	103	61	49	40	●
	3	Internal Intern		**1534SU03C-0890**	10	89	47	35	40	●
	5			**1536SU05C-0890**	10	103	61	49	40	●
	3		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		straight shank Zylinderschaft	**1538SU08C-0890**	10	142	95	83	40	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
9.0	3	External Extern	Straight shank	1534SU03-0900	10	89	47	35	40	●
	5			1536SU05-0900	10	103	61	49	40	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-0900	10	89	47	35	40	●
	5			1536SU05C-0900	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0900	10	89	47	35	40	●
	5			1636SU05C-0900	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0900	10	89	47	35	40	●
	5			1736SU05C-0900	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0900	10	142	95	83	40	●
9.1	3	External Extern		1534SU03-0910	10	89	47	35	40	●
	5			1536SU05-0910	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0910	10	89	47	35	40	●
	5			1536SU05C-0910	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0910	10	89	47	35	40	●
	5			1636SU05C-0910	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0910	10	89	47	35	40	●
	5			1736SU05C-0910	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0910	10	142	95	83	40	●
9.2	3	External Extern		1534SU03-0920	10	89	47	35	40	●
	5			1536SU05-0920	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0920	10	89	47	35	40	●
	5			1536SU05C-0920	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0920	10	89	47	35	40	●
	5			1636SU05C-0920	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0920	10	89	47	35	40	●
	5			1736SU05C-0920	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0920	10	142	95	83	40	●
9.3	3	External Extern		1534SU03-0930	10	89	47	35	40	●
	5			1536SU05-0930	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0930	10	89	47	35	40	●
	5			1536SU05C-0930	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0930	10	89	47	35	40	●
	5			1636SU05C-0930	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0930	10	89	47	35	40	●
	5			1736SU05C-0930	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0930	10	142	95	83	40	●
9.35	3	External Extern		1534SU03-0935	10	89	47	35	40	○
	5			1536SU05-0935	10	103	61	49	40	○
	3	Internal Intern		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 Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

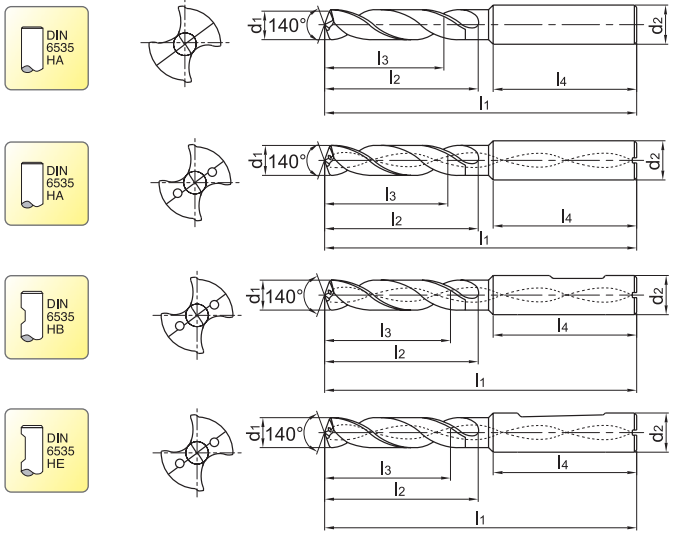
General machining · Allgemeine Bearbeitung


External Coolant
Externe Kühlung
Straight shank
Zylinderschaft


Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft


Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft



- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
9.35	3	Internal 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 Extern	Straight shank Zylinder-schaft	**1534SU03-0940**	10	89	47	35	40	●
	5			**1536SU05-0940**	10	103	61	49	40	●
	3	Internal Intern		**1534SU03C-0940**	10	89	47	35	40	●
	5			**1536SU05C-0940**	10	103	61	49	40	●
	3		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		Straight shank Zylinder-schaft	**1538SU08C-0940**	10	142	95	83	40	●
9.45	3	External Extern		**1534SU03-0945**	10	89	47	35	40	○
	5			**1536SU05-0945**	10	103	61	49	40	○
	3	Internal Intern		**1534SU03C-0945**	10	89	47	35	40	○
	5			**1536SU05C-0945**	10	103	61	49	40	○
	3		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	○
9.5	3	External Extern	Straight shank Zylinder-schaft	**1534SU03-0950**	10	89	47	35	40	●
	5			**1536SU05-0950**	10	103	61	49	40	●
	3	Internal Intern		**1534SU03C-0950**	10	89	47	35	40	●
	5			**1536SU05C-0950**	10	103	61	49	40	●
	3		Weldon shank/ Schaft	**1634SU03C-0950**	10	89	47	35	40	●
	5			**1636SU05C-0950**	10	103	61	49	40	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
9.5	3	Internal Intern	Whistle notch shank/ Schaft	1734SU03C-0950	10	89	47	35	40	●
	5			1736SU05C-0950	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0950	10	142	95	83	40	●
9.6	3	External Extern		1534SU03-0960	10	89	47	35	40	●
	5			1536SU05-0960	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0960	10	89	47	35	40	●
	5			1536SU05C-0960	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0960	10	89	47	35	40	●
	5			1636SU05C-0960	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0960	10	89	47	35	40	●
	5			1736SU05C-0960	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0960	10	142	95	83	40	●
9.7	3	External Extern		1534SU03-0970	10	89	47	35	40	●
	5			1536SU05-0970	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0970	10	89	47	35	40	●
	5			1536SU05C-0970	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0970	10	89	47	35	40	●
	5			1636SU05C-0970	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0970	10	89	47	35	40	●
	5			1736SU05C-0970	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0970	10	142	95	83	40	●
9.8	3	External Extern		1534SU03-0980	10	89	47	35	40	●
	5			1536SU05-0980	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0980	10	89	47	35	40	●
	5			1536SU05C-0980	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0980	10	89	47	35	40	●
	5			1636SU05C-0980	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0980	10	89	47	35	40	●
	5			1736SU05C-0980	10	103	61	49	40	●
	8		Straight shank Zylinder-schaft	1538SU08C-0980	10	142	95	83	40	●
9.9	3	External Extern		1534SU03-0990	10	89	47	35	40	●
	5			1536SU05-0990	10	103	61	49	40	●
	3	Internal Intern		1534SU03C-0990	10	89	47	35	40	●
	5			1536SU05C-0990	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0990	10	89	47	35	40	●
	5			1636SU05C-0990	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0990	10	89	47	35	40	●
	5			1736SU05C-0990	10	103	61	49	40	●
	8		straight shank Zylinderschaft	1538SU08C-0990	10	142	95	83	40	●

Material Overview · Material Übersicht

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Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

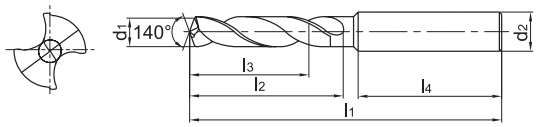
General machining · Allgemeine Bearbeitung

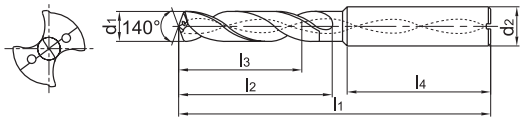

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

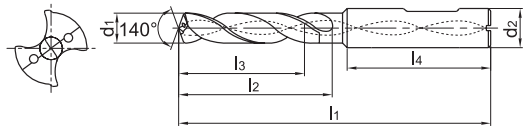

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

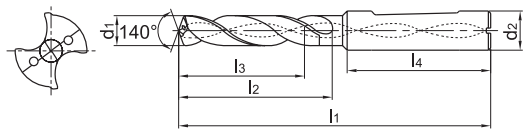

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









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- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
10.0	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1000	10	89	47	35	40	●
	5			1536SU05-1000	10	103	61	49	40	●
	3	Internal Intern		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	●
	8		Straight shank Zylinder-schaft	1538SU08C-1000	10	142	95	83	40	●
10.1	3	External Extern		1534SU03-1010	12	102	55	40	45	●
	5			1536SU05-1010	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1010	12	102	55	40	45	●
	5			1536SU05C-1010	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1010	12	102	55	40	45	●
	5			1636SU05C-1010	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1010	12	102	55	40	45	●
	5			1736SU05C-1010	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1010	12	162	114	99	45	●
10.2	3	External Extern		1534SU03-1020	12	102	55	40	45	●
	5			1536SU05-1020	12	118	71	56	45	●
	3	Internal Intern		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	●
	3		Whistle notch shank/ Schaft	1734SU03C-1020	12	102	55	40	45	●
	5			1736SU05C-1020	12	118	71	56	45	●
	8		straight shank Zylinderschaft	1538SU08C-1020	12	162	114	99	45	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
10.25	3	External Extern	Straight shank	1534SU03-1025	12	102	55	40	45	●
	5			1536SU05-1025	12	118	71	56	45	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1025	12	102	55	40	45	●
	5			1536SU05C-1025	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1025	12	102	55	40	45	○
	5			1636SU05C-1025	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1025	12	102	55	40	45	●
	5			1736SU05C-1025	12	118	71	56	45	●
10.3	3	External Extern	Straight shank	1534SU03-1030	12	102	55	40	45	●
	5			1536SU05-1030	12	118	71	56	45	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1030	12	102	55	40	45	●
	5			1536SU05C-1030	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1030	12	102	55	40	45	●
	5			1636SU05C-1030	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1030	12	102	55	40	45	●
	5			1736SU05C-1030	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1030	12	162	114	99	45	●
10.4	3	External Extern	Straight shank	1534SU03-1040	12	102	55	40	45	●
	5			1536SU05-1040	12	118	71	56	45	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1040	12	102	55	40	45	●
	5			1536SU05C-1040	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1040	12	102	55	40	45	●
	5			1636SU05C-1040	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1040	12	102	55	40	45	●
	5			1736SU05C-1040	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1040	12	162	114	99	45	●
10.5	3	External Extern	Straight shank	1534SU03-1050	12	102	55	40	45	●
	5			1536SU05-1050	12	118	71	56	45	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1050	12	102	55	40	45	●
	5			1536SU05C-1050	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1050	12	102	55	40	45	●
	5			1636SU05C-1050	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1050	12	102	55	40	45	●
	5			1736SU05C-1050	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1050	12	162	114	99	45	●
10.6	3	External Extern	Straight shank	1534SU03-1060	12	102	55	40	45	●
	5			1536SU05-1060	12	118	71	56	45	●
	3	Internal Intern	Zylinder schaft	1534SU03C-1060	12	102	55	40	45	●
	5			1536SU05C-1060	12	118	71	56	45	●

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Material Overview · Material Übersicht

Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

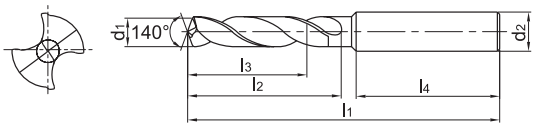
SU series · SU Serie

General machining · Allgemeine Bearbeitung


External Coolant
Externe Kühlung

Straight shank
Zylinderschaft

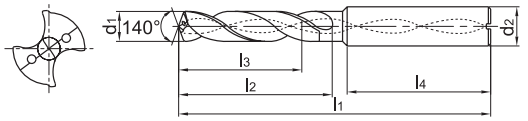
DIN 6535 HA




Internal Coolant
Interne Kühlung

Straight shank
Zylinderschaft

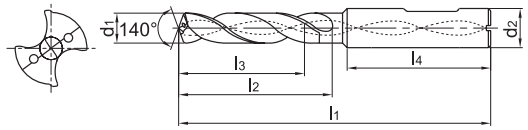
DIN 6535 HA




Internal Coolant
Interne Kühlung

Weldon shank · Schaft

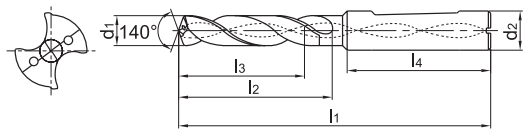
DIN 6535 HB




Internal Coolant
Interne Kühlung

Whistle notch shank · Schaft

DIN 6535 HE



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- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
10.6	3	Internal Intern	Weldon shank/ Schaft	**1634SU03C-1060**	12	102	55	40	45	●
	5			**1636SU05C-1060**	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1060**	12	102	55	40	45	●
	5			**1736SU05C-1060**	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	**1538SU08C-1060**	12	162	114	99	45	●
10.7	3	External Extern		**1534SU03-1070**	12	102	55	40	45	●
	5			**1536SU05-1070**	12	118	71	56	45	●
	3	Internal Intern		**1534SU03C-1070**	12	102	55	40	45	●
	5			**1536SU05C-1070**	12	118	71	56	45	●
	3		Weldon shank/ Schaft	**1634SU03C-1070**	12	102	55	40	45	●
	5			**1636SU05C-1070**	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1070**	12	102	55	40	45	●
	5			**1736SU05C-1070**	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	**1538SU08C-1070**	12	162	114	99	45	●
10.8	3	External Extern		**1534SU03-1080**	12	102	55	40	45	●
	5			**1536SU05-1080**	12	118	71	56	45	●
	3	Internal Intern		**1534SU03C-1080**	12	102	55	40	45	●
	5			**1536SU05C-1080**	12	118	71	56	45	●
	3		Weldon shank/ Schaft	**1634SU03C-1080**	12	102	55	40	45	●
	5			**1636SU05C-1080**	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1080**	12	102	55	40	45	●
	5			**1736SU05C-1080**	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	**1538SU08C-1080**	12	162	114	99	45	●
10.9	3	External Extern		**1534SU03-1090**	12	102	55	40	45	●
	5			**1536SU05-1090**	12	118	71	56	45	●
	3	Internal Intern		**1534SU03C-1090**	12	102	55	40	45	●
	5			**1536SU05C-1090**	12	118	71	56	45	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
10.9	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-1090	12	102	55	40	45	●
	5			1636SU05C-1090	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1090	12	102	55	40	45	●
	5			1736SU05C-1090	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1090	12	162	114	99	45	●
11.0	3	External Extern		1534SU03-1100	12	102	55	40	45	●
	5			1536SU05-1100	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1100	12	102	55	40	45	●
	5			1536SU05C-1100	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1100	12	102	55	40	45	●
	5			1636SU05C-1100	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1100	12	102	55	40	45	●
	5			1736SU05C-1100	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1100	12	162	114	99	45	●
11.1	3	External Extern		1534SU03-1110	12	102	55	40	45	●
	5			1536SU05-1110	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1110	12	102	55	40	45	●
	5			1536SU05C-1110	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1110	12	102	55	40	45	●
	5			1636SU05C-1110	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1110	12	102	55	40	45	●
	5			1736SU05C-1110	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1110	12	162	114	99	45	●
11.2	3	External Extern		1534SU03-1120	12	102	55	40	45	●
	5			1536SU05-1120	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1120	12	102	55	40	45	●
	5			1536SU05C-1120	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1120	12	102	55	40	45	●
	5			1636SU05C-1120	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1120	12	102	55	40	45	●
	5			1736SU05C-1120	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1120	12	162	114	99	45	●
11.25	3	External Extern		1534SU03-1125	12	102	55	40	45	○
	5			1536SU05-1125	12	118	71	56	45	○
	3	Internal Intern		1534SU03C-1125	12	102	55	40	45	○
	5			1536SU05C-1125	12	118	71	56	45	○
	3		Weldon shank/ Schaft	1634SU03C-1125	12	102	55	40	45	○
	5			1636SU05C-1125	12	118	71	56	45	○
	3		Whistle notch shank/ Schaft	1734SU03C-1125	12	102	55	40	45	○
	5			1736SU05C-1125	12	118	71	56	45	○

Material Overview · Material Übersicht

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

Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

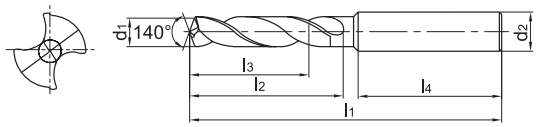
General machining · Allgemeine Bearbeitung

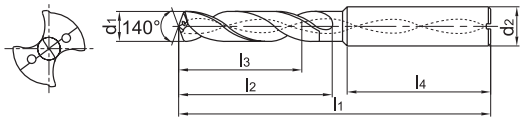

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

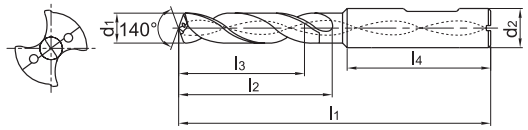

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

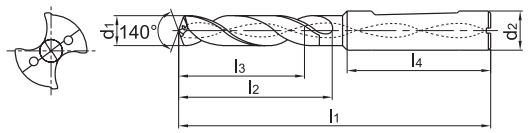

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
11.3	3	External Extern	Straight shank	1534SU03-1130	12	102	55	40	45	●
	5			1536SU05-1130	12	118	71	56	45	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1130	12	102	55	40	45	●
	5			1536SU05C-1130	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1130	12	102	55	40	45	●
	5			1636SU05C-1130	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1130	12	102	55	40	45	●
	5			1736SU05C-1130	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1130	12	162	114	99	45	●
11.35	3	External Extern		1534SU03-1135	12	102	55	40	45	○
	5			1536SU05-1135	12	118	71	56	45	○
	3	Internal Intern		1534SU03C-1135	12	102	55	40	45	○
	5			1536SU05C-1135	12	118	71	56	45	○
	3		Weldon shank/ Schaft	1634SU03C-1135	12	102	55	40	45	○
	5			1636SU05C-1135	12	118	71	56	45	○
	3		Whistle notch shank/ Schaft	1734SU03C-1135	12	102	55	40	45	○
	5			1736SU05C-1135	12	118	71	56	45	○
11.4	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1140	12	102	55	40	45	●
	5			1536SU05-1140	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1140	12	102	55	40	45	●
	5			1536SU05C-1140	12	118	71	56	45	●
	3		Weldon shank/Schaft	1634SU03C-1140	12	102	55	40	45	●
	5			1636SU05C-1140	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1140	12	102	55	40	45	●
	5			1736SU05C-1140	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1140	12	162	114	99	45	●
11.45	3	External Extern		1534SU03-1145	12	102	55	40	45	○
	5			1536SU05-1145	12	118	71	56	45	○

 ● ex Stock · ab Lager ○ on demand · auf Anfrage

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
11.45	3	Internal Intern	straight shank Zylinderschaft	1534SU03C-1145	12	102	55	40	45	○
	5			1536SU05C-1145	12	118	71	56	45	○
	3		Weldon shank/ Schaft	1634SU03C-1145	12	102	55	40	45	○
	5			1636SU05C-1145	12	118	71	56	45	○
	3		Whistle notch shank/ Schaft	1734SU03C-1145	12	102	55	40	45	○
	5			1736SU05C-1145	12	118	71	56	45	○
11.5	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1150	12	102	55	40	45	●
	5			1536SU05-1150	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1150	12	102	55	40	45	●
	5			1536SU05C-1150	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1150	12	102	55	40	45	●
	5			1636SU05C-1150	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1150	12	102	55	40	45	●
	5			1736SU05C-1150	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1150	12	162	114	99	45	●
11.6	3	External Extern		1534SU03-1160	12	102	55	40	45	●
	5			1536SU05-1160	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1160	12	102	55	40	45	●
	5			1536SU05C-1160	12	118	71	56	45	●
	3		Weldon shank/Schaft	1634SU03C-1160	12	102	55	40	45	●
	5			1636SU05C-1160	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1160	12	102	55	40	45	●
	5			1736SU05C-1160	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1160	12	162	114	99	45	●
11.7	3	External Extern		1534SU03-1170	12	102	55	40	45	●
	5			1536SU05-1170	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1170	12	102	55	40	45	●
	5			1536SU05C-1170	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1170	12	102	55	40	45	●
	5			1636SU05C-1170	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1170	12	102	55	40	45	●
	5			1736SU05C-1170	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1170	12	162	114	99	45	●
11.8	3	External Extern		1534SU03-1180	12	102	55	40	45	●
	5			1536SU05-1180	12	118	71	56	45	●
	3	Internal Intern		1534SU03C-1180	12	102	55	40	45	●
	5			1536SU05C-1180	12	118	71	56	45	●
	3		Weldon shank/ Schaft	1634SU03C-1180	12	102	55	40	45	●
	5			1636SU05C-1180	12	118	71	56	45	●

Material Overview · Material Übersicht

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Grade Sorte	Workpiece material · Werkstückstoff										
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			~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

SU series · SU Serie

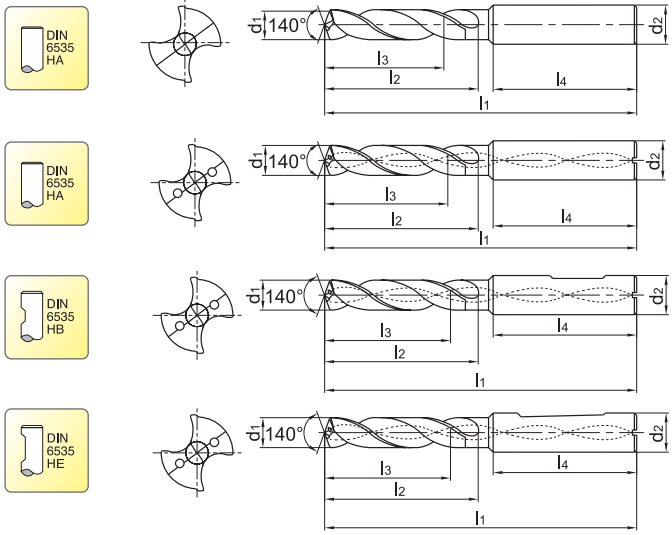
General machining · Allgemeine Bearbeitung


External Coolant
Externe Kühlung
Straight shank
Zylinderschaft


Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft


Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft



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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
11.8	3	Internal Intern	Whistle notch shank/ Schaft	**1734SU03C-1180**	12	102	55	40	45	●
	5			**1736SU05C-1180**	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	**1538SU08C-1180**	12	162	114	99	45	●
11.9	3	External Extern		**1534SU03-1190**	12	102	55	40	45	●
	5			**1536SU05-1190**	12	118	71	56	45	●
	3	Internal Intern		**1534SU03C-1190**	12	102	55	40	45	●
	5			**1536SU05C-1190**	12	118	71	56	45	●
	3		Weldon shank/ Schaft	**1634SU03C-1190**	12	102	55	40	45	●
	5			**1636SU05C-1190**	12	118	71	56	45	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1190**	12	102	55	40	45	●
	5			**1736SU05C-1190**	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	**1538SU08C-1190**	12	162	114	99	45	●
12.0	3	External Extern		**1534SU03-1200**	12	102	55	40	45	●
	5			**1536SU05-1200**	12	118	71	56	45	●
	3	Internal Intern		**1534SU03C-1200**	12	102	55	40	45	●
	5			**1536SU05C-1200**	12	118	71	56	45	●
	3		Weldon shank/Schaft	**1634SU03C-1200**	12	102	55	40	45	●
	5			**1636SU05C-1200**	12	118	71	56	45	●
	3		Whistle notch shank/Schaft	**1734SU03C-1200**	12	102	55	40	45	●
	5			**1736SU05C-1200**	12	118	71	56	45	●
	8		Straight shank Zylinder-schaft	**1538SU08C-1200**	12	162	114	99	45	●
12.1	3	External Extern		**1534SU03-1210**	14	107	60	43	45	●
	5			**1536SU05-1210**	14	124	77	60	45	●
	3	Internal Intern		**1534SU03C-1210**	14	107	60	43	45	●
	5			**1536SU05C-1210**	14	124	77	60	45	●
	3		Weldon shank/Schaft	**1634SU03C-1210**	14	107	60	43	45	●
	5			**1636SU05C-1210**	14	124	77	60	45	●
	3		Whistle notch shank/Schaft	**1734SU03C-1210**	14	107	60	43	45	●
	5			**1736SU05C-1210**	14	124	77	60	45	●

● ex Stock · ab Lager ○ on demand · auf Anfrage

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
12.2	3	External Extern	Straight shank	**1534SU03-1220**	14	107	60	43	45	●
	5			**1536SU05-1220**	14	124	77	60	45	●
	3	Internal Intern	Zylinder-schaft	**1534SU03C-1220**	14	107	60	43	45	●
	5			**1536SU05C-1220**	14	124	77	60	45	●
	3		Weldon shank/ Schaft	**1634SU03C-1220**	14	107	60	43	45	●
	5			**1636SU05C-1220**	14	124	77	60	45	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1220**	14	107	60	43	45	●
	5			**1736SU05C-1220**	14	124	77	60	45	●
12.25	3	External Extern	Straight shank	**1534SU03-1225**	14	107	60	43	45	●
	5			**1536SU05-1225**	14	124	77	60	45	●
	3	Internal Intern	Zylinder-schaft	**1534SU03C-1225**	14	107	60	43	45	●
	5			**1536SU05C-1225**	14	124	77	60	45	●
	3		Weldon shank/ Schaft	**1634SU03C-1225**	14	107	60	43	45	○
	5			**1636SU05C-1225**	14	124	77	60	45	○
	3		Whistle notch shank/ Schaft	**1734SU03C-1225**	14	107	60	43	45	●
	5			**1736SU05C-1225**	14	124	77	60	45	●
12.3	3	External Extern	Straight shank	**1534SU03-1230**	14	107	60	43	45	●
	5			**1536SU05-1230**	14	124	77	60	45	●
	3	Internal Intern	Zylinder-schaft	**1534SU03C-1230**	14	107	60	43	45	●
	5			**1536SU05C-1230**	14	124	77	60	45	●
	3		Weldon shank/ Schaft	**1634SU03C-1230**	14	107	60	43	45	●
	5			**1636SU05C-1230**	14	124	77	60	45	●
	3		Whistle notch 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 Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

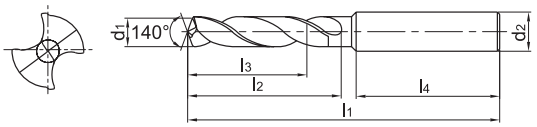
General machining · Allgemeine Bearbeitung

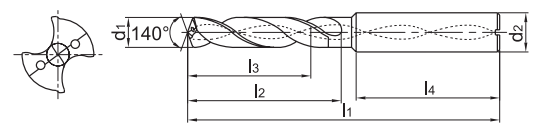

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

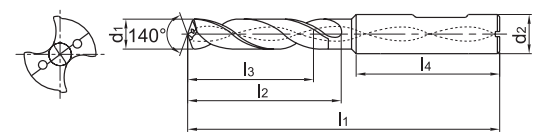

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

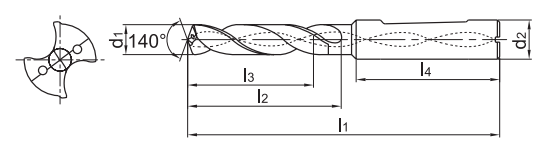

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









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- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
12.5	3	External Extern	Straight shank Zylinderschaft	1534SU03-1250	14	107	60	43	45	●
	5			1536SU05-1250	14	124	77	60	45	●
	3	Internal Intern		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		Straight shank Zylinderschaft	1538SU08C-1250	14	178	133	116	45	●
12.7	3	External Extern		1534SU03-1270	14	107	60	43	45	●
	5			1536SU05-1270	14	124	77	60	45	●
12.7	3	Internal Intern		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		Straight shank Zylinderschaft	1538SU08C-1270	14	178	133	116	45	●
12.75	3	External Extern		1534SU03-1275	14	107	60	43	45	●
	5			1536SU05-1275	14	124	77	60	45	●
	3	Internal Intern		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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
12.8	3	External Extern	Straight shank	1534SU03-1280	14	107	60	43	45	●
	5			1536SU05-1280	14	124	77	60	45	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1280	14	107	60	43	45	●
	5			1536SU05C-1280	14	124	77	60	45	●
	3		Weldon shank/ Schaft	1634SU03C-1280	14	107	60	43	45	●
	5			1636SU05C-1280	14	124	77	60	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1280	14	107	60	43	45	●
	5			1736SU05C-1280	14	124	77	60	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1280	14	178	133	116	45	●
13.0	3	External Extern		1534SU03-1300	14	107	60	43	45	●
	5			1536SU05-1300	14	124	77	60	45	●
	3	Internal Intern		1534SU03C-1300	14	107	60	43	45	●
	5			1536SU05C-1300	14	124	77	60	45	●
	3		Weldon shank/ Schaft	1634SU03C-1300	14	107	60	43	45	●
	5			1636SU05C-1300	14	124	77	60	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1300	14	107	60	43	45	●
	5			1736SU05C-1300	14	124	77	60	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1300	14	178	133	116	45	●
13.1	3	External Intern		1534SU03-1310	14	107	60	43	45	●
	5			1536SU05-1310	14	124	77	60	45	●
	3	Internal Intern		1534SU03C-1310	14	107	60	43	45	●
	5			1536SU05C-1310	14	124	77	60	45	●
	3		Weldon shank/ Schaft	1634SU03C-1310	14	107	60	43	45	●
	5			1636SU05C-1310	14	124	77	60	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1310	14	107	60	43	45	●
	5			1736SU05C-1310	14	124	77	60	45	●
13.35	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1335	16	107	60	43	45	○
	5			1536SU05-1335	16	124	77	60	56	○
	3	Internal Intern		1534SU03C-1335	16	107	60	43	45	○
	5			1536SU05C-1335	16	124	77	60	56	○
	3		Weldon shank/ Schaft	1634SU03C-1335	16	107	60	43	45	○
	5			1636SU05C-1335	16	124	77	60	56	○
	3		Whistle notch 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
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Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste Leg.
			~40HRC	~50HRC	~60HRC						
KDG303	✔	✔	✔			✔	✔	✔			

Code key C 10
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Cutting data 96-109
Schnittdaten
Technical Information C110-116
Technische Information
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

SU series · SU Serie

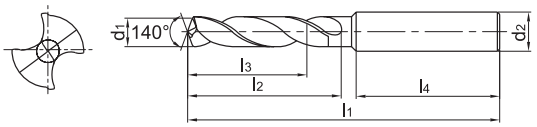
General machining · Allgemeine Bearbeitung

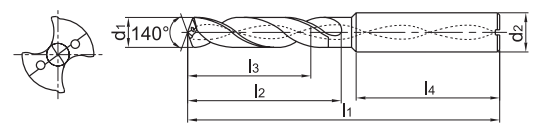

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

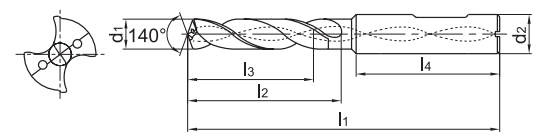

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

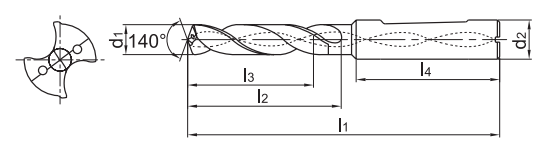

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
13.5	3	External Extern	Straight shank	**1534SU03-1350**	14	107	60	43	45	●
	5			**1536SU05-1350**	14	124	77	60	45	●
	3	Internal Intern	Zylinder-schaft	**1534SU03C-1350**	14	107	60	43	45	●
	5			**1536SU05C-1350**	14	124	77	60	45	●
	3		Weldon shank/ Schaft	**1634SU03C-1350**	14	107	60	43	45	●
	5			**1636SU05C-1350**	14	124	77	60	45	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1350**	14	107	60	43	45	●
	5			**1736SU05C-1350**	14	124	77	60	45	●
	8		Straight shank Zylinder-schaft	**1538SU08C-1350**	14	178	133	116	45	●
13.8	3	External Extern		**1534SU03-1380**	14	107	60	43	45	●
	5			**1536SU05-1380**	14	124	77	60	45	●
	3	Internal Intern		**1534SU03C-1380**	14	107	60	43	45	●
	5			**1536SU05C-1380**	14	124	77	60	45	●
	3		Weldon shank/ Schaft	**1634SU03C-1380**	14	107	60	43	45	●
	5			**1636SU05C-1380**	14	124	77	60	45	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1380**	14	107	60	43	45	●
	5			**1736SU05C-1380**	14	124	77	60	45	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
14.0	3	External Extern	Straight shank	1534SU03-1400	14	107	60	43	45	●
	5			1536SU05-1400	14	124	77	60	45	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1400	14	107	60	43	45	●
	5			1536SU05C-1400	14	124	77	60	45	●
	3		Weldon shank/ Schaft	1634SU03C-1400	14	107	60	43	45	○
	5			1636SU05C-1400	14	124	77	60	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1400	14	107	60	43	45	●
	5			1736SU05C-1400	14	124	77	60	45	●
	8		Straight shank Zylinder-schaft	1538SU08C-1400	14	178	133	116	45	●
14.2	3	External Extern		1534SU03-1420	14	107	60	43	45	●
	5			1536SU05-1420	14	124	77	60	45	●
	3	Internal Intern		1534SU03C-1420	14	107	60	43	45	●
	5			1536SU05C-1420	14	124	77	60	45	●
	3		Weldon shank/ Schaft	1634SU03C-1420	14	107	60	43	45	●
	5			1636SU05C-1420	14	124	77	60	45	●
	3		Whistle notch shank/ Schaft	1734SU03C-1420	14	107	60	43	45	●
	5			1736SU05C-1420	14	124	77	60	45	●
14.25	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1425	16	115	65	45	48	●
	5			1536SU05-1425	16	133	83	63	48	●
	3	Internal Intern		1534SU03C-1425	16	115	65	45	48	●
	5			1536SU05C-1425	16	133	83	63	48	●
	3		Weldon shank/ Schaft	1634SU03C-1425	16	115	65	45	48	○
	5			1636SU05C-1425	16	133	83	63	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1425	16	115	65	45	48	●
	5			1736SU05C-1425	16	133	83	63	48	●
14.3	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1430	16	115	65	45	48	●
	5			1536SU05-1430	16	133	83	63	48	●
	3	Internal Intern		1534SU03C-1430	16	115	65	45	48	●
	5			1536SU05C-1430	16	133	83	63	48	●
	3		Weldon shank/ Schaft	1634SU03C-1430	16	115	65	45	48	●
	5			1636SU05C-1430	16	133	83	63	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1430	16	115	65	45	48	●
	5			1736SU05C-1430	16	133	83	63	48	●

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

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Technische Information
Non-standard tailor made C 117-121
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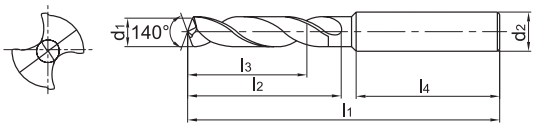
SU series · SU Serie

General machining · Allgemeine Bearbeitung

External Coolant
Externe Kühlung

Straight shank
Zylinderschaft

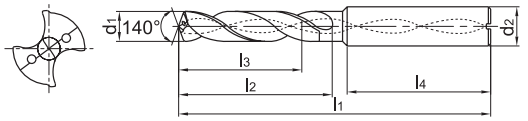
DIN 6535 HA



Internal Coolant
Interne Kühlung

Straight shank
Zylinderschaft

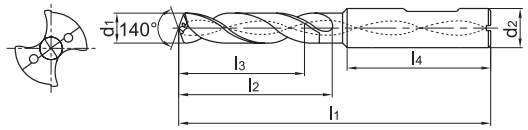
DIN 6535 HA



Internal Coolant
Interne Kühlung

Weldon shank · Schaft

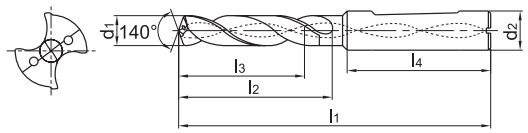
DIN 6535 HB



Internal Coolant
Interne Kühlung

Whistle notch shank · Schaft

DIN 6535 HE



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Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
14.5	3	External Extern	Straight shank Zylinder-schaft	**1534SU03-1450**	16	115	65	45	48	●
	5			**1536SU05-1450**	16	133	83	63	48	●
	3	Internal Intern		**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		Straight shank Zylinder-schaft	**1538SU08C-1450**	16	204	152	132	48	●
14.75	3	External Extern		**1534SU03-1475**	16	115	65	45	48	●
	5			**1536SU05-1475**	16	133	83	63	48	●
	3	Internal Intern		**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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
14.8	3	External Extern	Straight shank	1534SU03-1480	16	115	65	45	48	●
	5			1536SU05-1480	16	133	83	63	48	●
	3	Internal 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	●
	8		Straight shank Zylinder-schaft	1538SU08C-1480	16	204	152	132	48	●
15.0	3	External Extern		1534SU03-1500	16	115	65	45	48	●
	5			1536SU05-1500	16	133	83	63	48	●
	3	Internal Intern		1534SU03C-1500	16	115	65	45	48	●
	5			1536SU05C-1500	16	133	83	63	48	●
	3		Weldon shank/ Schaft	1634SU03C-1500	16	115	65	45	48	●
	5			1636SU05C-1500	16	133	83	63	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1500	16	115	65	45	48	●
	5			1736SU05C-1500	16	133	83	63	48	●
	8		Straight shank Zylinder-schaft	1538SU08C-1500	16	204	152	132	48	●
15.1	3	External Extern		1534SU03-1510	16	115	65	45	48	●
	5			1536SU05-1510	16	133	83	63	48	●
	3	Internal Intern		1534SU03C-1510	16	115	65	45	48	●
	5			1536SU05C-1510	16	133	83	63	48	●
	3		Weldon shank/ Schaft	1634SU03C-1510	16	115	65	45	48	●
	5			1636SU05C-1510	16	133	83	63	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1510	16	115	65	45	48	●
	5			1736SU05C-1510	16	133	83	63	48	●
15.3	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1530	16	115	65	45	48	●
	5	Internal Intern		1536SU05C-1530	16	133	83	63	48	●
15.35	3	External Extern		1534SU03-1535	16	115	65	45	48	○
	5			1536SU05-1535	16	133	83	63	48	○
	3	Internal Intern		1534SU03C-1535	16	115	65	45	48	○
	5			1536SU05C-1535	16	133	83	63	48	○
	3		Weldon shank/ Schaft	1634SU03C-1535	16	115	65	45	48	○
	5			1636SU05C-1535	16	133	83	63	48	○
	3		Whistle notch shank/ Schaft	1734SU03C-1535	16	115	65	45	48	○
	5			1736SU05C-1535	16	133	83	63	48	○

Material Overview · Material Übersicht

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

Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

SU series · SU Serie

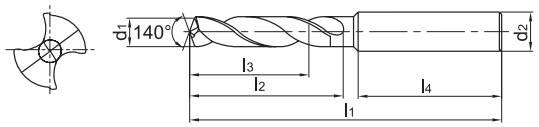
General machining · Allgemeine Bearbeitung

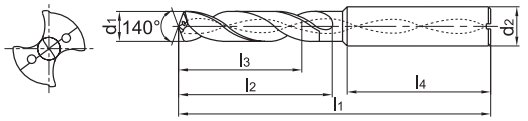

External Coolant
Externe Kühlung
Straight shank
Zylinderschaft

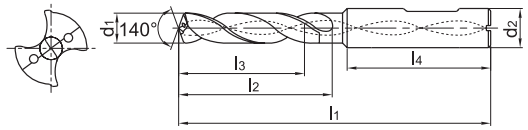

Internal Coolant
Interne Kühlung
Straight shank
Zylinderschaft

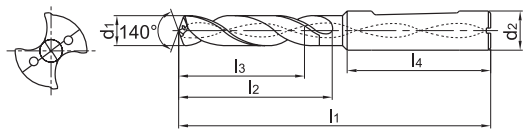

Internal Coolant
Interne Kühlung
Weldon
shank · Schaft


Internal Coolant
Interne Kühlung
Whistle notch
shank · Schaft









- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
15.5	3	External Extern	Straight shank	1534SU03-1550	16	115	65	45	48	●
	5			1536SU05-1550	16	133	83	63	48	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1550	16	115	65	45	48	●
	5			1536SU05C-1550	16	133	83	63	48	●
	3		Weldon shank/ Schaft	1634SU03C-1550	16	115	65	45	48	●
	5			1636SU05C-1550	16	133	83	63	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1550	16	115	65	45	48	●
	5			1736SU05C-1550	16	133	83	63	48	●
	8		Straight shank Zylinder-schaft	1538SU08C-1550	16	204	152	132	48	●
15.8	3	External Extern		1534SU03-1580	16	115	65	45	48	●
	5			1536SU05-1580	16	133	83	63	48	●
	3	Internal Intern		1534SU03C-1580	16	115	65	45	48	●
	5			1536SU05C-1580	16	133	83	63	48	●
	3		Weldon shank/ Schaft	1634SU03C-1580	16	115	65	45	48	●
	5			1636SU05C-1580	16	133	83	63	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1580	16	115	65	45	48	●
	5			1736SU05C-1580	16	133	83	63	48	●
16.0	3	External Extern	Straight shank	1534SU03-1600	16	115	65	45	48	●
	5			1536SU05-1600	16	133	83	63	48	●
	3	Internal Intern	Zylinde-r schaft	1534SU03C-1600	16	115	65	45	48	●
	5			1536SU05C-1600	16	133	83	63	48	●
	3		Weldon shank/ Schaft	1634SU03C-1600	16	115	65	45	48	●
	5			1636SU05C-1600	16	133	83	63	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1600	16	115	65	45	48	●
	5			1736SU05C-1600	16	133	83	63	48	●
	8		Straight shank Zylinde-r schaft	1538SU08C-1600	16	204	152	132	48	●
16.1	3	External Extern		1534SU03-1610	18	123	73	51	48	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
16.5	3	External Extern	Straight shank	1534SU03-1650	18	123	73	51	48	●
	5			1536SU05-1650	18	143	93	71	48	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1650	18	123	73	51	48	●
	5			1536SU05C-1650	18	143	93	71	48	●
	3		Weldon shank/ Schaft	1634SU03C-1650	18	123	73	51	48	●
	5			1636SU05C-1650	18	143	93	71	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1650	18	123	73	51	48	●
	5			1736SU05C-1650	18	143	93	71	48	●
	8		Straight shank Zylinder-schaft	1538SU08C-1650	18	223	171	149	48	●
16.75	3	External Extern		1534SU03-1675	18	123	73	51	48	●
	5			1536SU05-1675	18	143	93	71	48	●
	3	Internal Intern		1534SU03C-1675	18	123	73	51	48	●
	5			1536SU05C-1675	18	143	93	71	48	●
	3		Weldon shank/ Schaft	1634SU03C-1675	18	123	73	51	48	○
	5			1636SU05C-1675	18	143	93	71	48	○
	3		Whistle notch shank/ Schaft	1734SU03C-1675	18	123	73	51	48	●
	5			1736SU05C-1675	18	143	93	71	48	●
16.8	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1680	18	123	73	51	48	●
	5			1536SU05-1680	18	143	93	71	48	●
	3	Internal Intern		1534SU03C-1680	18	123	73	51	48	●
	5			1536SU05C-1680	18	143	93	71	48	●
	3		Weldon shank/ Schaft	1634SU03C-1680	18	123	73	51	48	●
	5			1636SU05C-1680	18	143	93	71	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1680	18	123	73	51	48	●
	5			1736SU05C-1680	18	143	93	71	48	●
17.0	3	External Extern	Straight shank Zylinder-schaft	1534SU03-1700	18	123	73	51	48	●
	5			1536SU05-1700	18	143	93	71	48	●
	3	Internal Intern		1534SU03C-1700	18	123	73	51	48	●
	5			1536SU05C-1700	18	143	93	71	48	●
	3		Weldon shank/ Schaft	1634SU03C-1700	18	123	73	51	48	●
	5			1636SU05C-1700	18	143	93	71	48	●
	3		Whistle notch shank/ Schaft	1734SU03C-1700	18	123	73	51	48	●
	5			1736SU05C-1700	18	143	93	71	48	●
	8		straight shank Zylinderschaft	1538SU08C-1700	18	223	171	149	48	●

Material Overview · Material Übersicht

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

Grade Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste 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

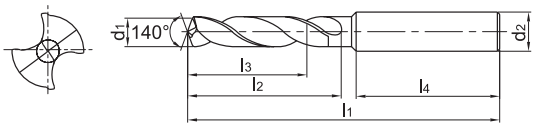
SU series · SU Serie

General machining · Allgemeine Bearbeitung

External Coolant
Externe Kühlung

Straight shank
Zylinderschaft

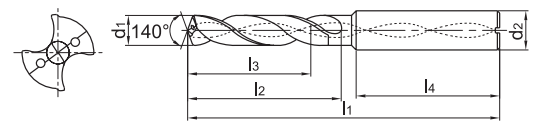
DIN 6535 HA



Internal Coolant
Interne Kühlung

Straight shank
Zylinderschaft

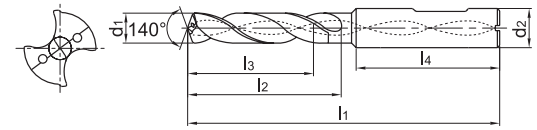
DIN 6535 HA



Internal Coolant
Interne Kühlung

Weldon shank · Schaft

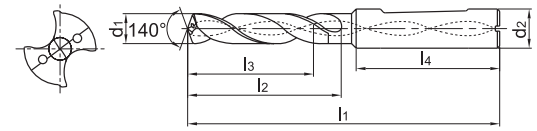
DIN 6535 HB



Internal Coolant
Interne Kühlung

Whistle notch shank · Schaft

DIN 6535 HE



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
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- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
17.5	3	External Extern	Straight shank	**1534SU03-1750**	18	123	73	51	48	●
	5		Zylinder-schaft	**1536SU05-1750**	18	143	93	71	48	●
	3	Internal Intern		**1534SU03C-1750**	18	123	73	51	48	●
	5			**1536SU05C-1750**	18	143	93	71	48	●
	3		Weldon shank/ Schaft	**1634SU03C-1750**	18	123	73	51	48	●
	5			**1636SU05C-1750**	18	143	93	71	48	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1750**	18	123	73	51	48	●
	5			**1736SU05C-1750**	18	143	93	71	48	●
	8		Straight shank Zylinder-schaft	**1538SU08C-1750**	18	223	171	149	48	●
17.8	3	External Extern		**1534SU03-1780**	18	123	73	51	48	●
	5			**1536SU05-1780**	18	143	93	71	48	●
	3	Internal Intern		**1534SU03C-1780**	18	123	73	51	48	●
	5			**1536SU05C-1780**	18	143	93	71	48	●
	3		Weldon shank/ Schaft	**1634SU03C-1780**	18	123	73	51	48	●
	5			**1636SU05C-1780**	18	143	93	71	48	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1780**	18	123	73	51	48	●
	5			**1736SU05C-1780**	18	143	93	71	48	●
18.0	3	External Extern	Straight shank Zylinder-schaft	**1534SU03-1800**	18	123	73	51	48	●
	5			**1536SU05-1800**	18	143	93	71	48	●
	3	Internal Intern		**1534SU03C-1800**	18	123	73	51	48	●
	5			**1536SU05C-1800**	18	143	93	71	48	●
	3		Weldon shank/ Schaft	**1634SU03C-1800**	18	123	73	51	48	●
	5			**1636SU05C-1800**	18	143	93	71	48	●
	3		Whistle notch shank/ Schaft	**1734SU03C-1800**	18	123	73	51	48	●
	5			**1736SU05C-1800**	18	143	93	71	48	●
	8		straight shank Zylinderschaft	**1538SU08C-1800**	18	223	171	149	48	●

Drill diameter Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
18.5	3	External Extern	Straight shank	1534SU03-1850	20	131	79	55	50	●
	5			1536SU05-1850	20	153	101	77	50	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1850	20	131	79	55	50	●
	5			1536SU05C-1850	20	153	101	77	50	●
	3		Weldon shank/ Schaft	1634SU03C-1850	20	131	79	55	50	●
	5			1636SU05C-1850	20	153	101	77	50	●
	3		Whistle notch shank/ Schaft	1734SU03C-1850	20	131	79	55	50	●
	5			1736SU05C-1850	20	153	101	77	50	●
18.8	3	External Extern	Straight shank	1534SU03-1880	20	131	79	55	50	●
	5			1536SU05-1880	20	153	101	77	50	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1880	20	131	79	55	50	●
	5			1536SU05C-1880	20	153	101	77	50	●
	3		Weldon shank/ Schaft	1634SU03C-1880	20	131	79	55	50	●
	5			1636SU05C-1880	20	153	101	77	50	●
	3		Whistle notch shank/ Schaft	1734SU03C-1880	20	131	79	55	50	●
	5			1736SU05C-1880	20	153	101	77	50	●
19.0	3	External Extern	Straight shank	1534SU03-1900	20	131	79	55	50	●
	5			1536SU05-1900	20	153	101	77	50	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1900	20	131	79	55	50	●
	5			1536SU05C-1900	20	153	101	77	50	●
	3		Weldon shank/ Schaft	1634SU03C-1900	20	131	79	55	50	●
	5			1636SU05C-1900	20	153	101	77	50	●
	3		Whistle notch shank/ Schaft	1734SU03C-1900	20	131	79	55	50	●
	5			1736SU05C-1900	20	153	101	77	50	●
19.5	3	External Extern	Straight shank	1534SU03-1950	20	131	79	55	50	●
	5			1536SU05-1950	20	153	101	77	50	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1950	20	131	79	55	50	●
	5			1536SU05C-1950	20	153	101	77	50	●
	3		Weldon shank/ Schaft	1634SU03C-1950	20	131	79	55	50	●
	5			1636SU05C-1950	20	153	101	77	50	●
	3		Whistle notch shank/ Schaft	1734SU03C-1950	20	131	79	55	50	●
	5			1736SU05C-1950	20	153	101	77	50	●
19.8	3	Externa Extern	Straight shank	1534SU03-1980	20	131	79	55	50	●
	5			1536SU05-1980	20	153	101	77	50	●
	3	Internal Intern	Zylinder-schaft	1534SU03C-1980	20	131	79	55	50	●
	5			1536SU05C-1980	20	153	101	77	50	●
	3		Weldon shank/ Schaft	1634SU03C-1980	20	131	79	55	50	●
	5			1636SU05C-1980	20	153	101	77	50	●
	3		Whistle notch 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 Sorte	Workpiece material · Werkstückstoff										
	Carbon steel Kohlenstoff - Stahl HB≤180	Alloy steel Legierter Stahl	Hardened steel · Gehärteter Stahl			Stainless steel Rostfreier Stahl	Cast iron, Grauguss	Nodular cast iron GGG Kugelgra-phitguss	Aluminum alloy Aluleg.	Copper alloy Kupferleg.	Heat resist. alloy Warmfeste Leg.
			~40HRC	~50HRC	~60HRC						
KDG303	✔	✔	✔			✔	✔	✔			

Code key C 10
ISO Kennzeichen
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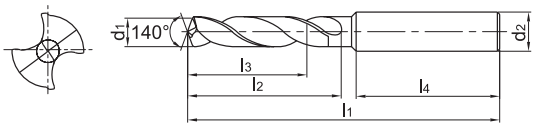
Technische Information
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

SU series · SU Serie

General machining · Allgemeine Bearbeitung

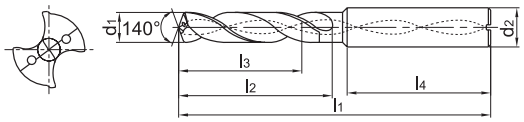

External Coolant
Externe Kühlung

Straight shank
Zylinderschaft



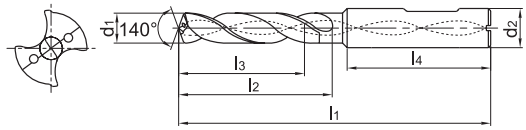

Internal Coolant
Interne Kühlung

Straight shank
Zylinderschaft



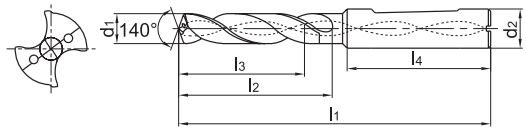

Internal Coolant
Interne Kühlung

Weldon
shank · Schaft




Internal Coolant
Interne Kühlung

Whistle notch
shank · Schaft



- 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 Bohrer Ø $d_1(m_7)$	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shankdiameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					$d_2(h_6)$	l_1	l_2	l_3	l_4	KDG303
20.0	3	External Extern	Straight shank	**1534SU03-2000**	20	131	79	55	50	●
	5			**1536SU05-2000**	20	153	101	77	50	●
	3	Internal Intern	Zylinder-schaft	**1534SU03C-2000**	20	131	79	55	50	●
	5			**1536SU05C-2000**	20	153	101	77	50	●
	3		Weldon shank/ Schaft	**1634SU03C-2000**	20	131	79	55	50	●
	5			**1636SU05C-2000**	20	153	101	77	50	●
	3		Whistle notch shank/ Schaft	**1734SU03C-2000**	20	131	79	55	50	●
	5			**1736SU05C-2000**	20	153	101	77	50	●

SU series twist drills · SU Spiralbohrer Serie (External coolant / Kühlung)

3D 5D

Workpiece material Werkstück-stoff	Mild steel Baustahl HB≤180		Carbon steel, alloy steel Kohlenstoffstahl Leg. Stahl ~30HRC		Pre-hardened steel Vergüteter Stahl ~40HRC		Stainless steel Rostfreier Stahl		Cast iron Gusseisen		Nodular cast iron GGG Kugelgra-phitguss		Aluminum alloy Alulegierungen		Heat resistant alloy Warmfeste Legierungen	
Vc	60~120m/min		60~120m/min		40~70m/min		25~40m/min		60~120m/min		50~100m/min		60~140m/min		15~25m/min	
Ø (mm)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)
2	14000	0.06~0.08	14000	0.06~0.08	9500	0.06~0.08	5500	0.02~0.05	14000	0.06~0.08	11000	0.06~0.08	16000	0.06~0.08	3200	0.02~0.04
3	9500	0.09~0.12	9500	0.09~0.12	6300	0.09~0.12	3700	0.03~0.07	9500	0.09~0.12	7400	0.09~0.12	10600	0.09~0.12	2100	0.03~0.06
4	7000	0.10~0.15	7000	0.10~0.15	4700	0.10~0.15	2700	0.04~0.08	7000	0.10~0.15	5600	0.10~0.15	8000	0.10~0.15	1600	0.04~0.07
5	5700	0.12~0.18	5700	0.12~0.18	3800	0.12~0.18	2200	0.05~0.10	5700	0.12~0.18	4500	0.12~0.18	6400	0.12~0.18	1250	0.05~0.09
6	4700	0.14~0.20	4700	0.14~0.20	3100	0.14~0.20	1850	0.06~0.12	4700	0.14~0.20	3700	0.14~0.20	5300	0.14~0.20	1050	0.06~0.11
8	3600	0.16~0.24	3600	0.16~0.24	2400	0.16~0.24	1400	0.08~0.16	3600	0.16~0.24	2800	0.16~0.24	4000	0.16~0.24	800	0.08~0.14
10	2800	0.18~0.27	2800	0.18~0.27	1900	0.18~0.27	1100	0.10~0.18	2800	0.18~0.27	2200	0.18~0.27	3200	0.18~0.27	600	0.10~0.16
12	2400	0.20~0.30	2400	0.20~0.30	1600	0.20~0.30	930	0.12~0.20	2400	0.20~0.30	1900	0.20~0.30	2700	0.20~0.30	500	0.12~0.18
14	2100	0.22~0.35	2100	0.22~0.35	1400	0.22~0.35	800	0.13~0.22	2100	0.22~0.35	1600	0.22~0.35	2300	0.22~0.35	450	0.13~0.20
16	1800	0.25~0.36	1800	0.25~0.36	1200	0.25~0.36	700	0.14~0.25	1800	0.25~0.36	1400	0.25~0.36	2000	0.25~0.36	400	0.14~0.23
18	1600	0.28~0.38	1600	0.28~0.38	1100	0.28~0.38	620	0.15~0.28	1600	0.28~0.38	1200	0.28~0.38	1800	0.28~0.38	350	0.15~0.25
20	1400	0.30~0.40	1400	0.30~0.40	950	0.30~0.40	550	0.16~0.30	1400	0.30~0.40	1100	0.30~0.40	1600	0.30~0.40	320	0.16~0.28

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 5D.

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 5xD ausgelegt.

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

3D 5D

Workpiece material Werkstück-stoff	Mild steel Baustahl HB≤180		Carbon steel, alloy steel Kohlenstoffstahl Leg. Stahl ~30HRC		Pre-hardened steel Vergüteter Stahl ~40HRC		Stainless steel Rostfreier Stahl		Cast iron Gusseisen		Nodular cast iron GGG Kugelgra-phitguss		Aluminum alloy Alulegierungen		Heat resistant alloy Warmfeste Legierungen	
Vc	80~150m/min		80~150m/min		50~80m/min		50~80m/min		80~150m/min		60~120m/min		100~180m/min		15~25m/min	
Ø (mm)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)
3	12700	0.09~0.12	12700	0.09~0.12	7400	0.09~0.12	6300	0.03~0.07	12700	0.09~0.12	9500	0.09~0.12	15000	0.09~0.12	2100	0.03~0.06
4	9600	0.10~0.15	9600	0.10~0.15	5600	0.10~0.15	4700	0.04~0.08	9600	0.10~0.15	7000	0.10~0.15	11100	0.10~0.15	1600	0.04~0.07
5	7600	0.12~0.18	7600	0.12~0.18	4500	0.12~0.18	3800	0.05~0.10	7600	0.12~0.18	5700	0.12~0.18	9000	0.12~0.18	1250	0.05~0.09
6	6400	0.14~0.20	6400	0.14~0.20	3700	0.14~0.20	3200	0.06~0.12	6400	0.14~0.20	4700	0.14~0.20	7400	0.14~0.20	1050	0.06~0.11
8	4800	0.16~0.24	4800	0.16~0.24	2800	0.16~0.24	2400	0.08~0.16	4800	0.16~0.24	3600	0.16~0.24	5600	0.16~0.24	800	0.08~0.14
10	3800	0.18~0.27	3800	0.18~0.27	2200	0.18~0.27	1900	0.10~0.18	3800	0.18~0.27	2800	0.18~0.27	4500	0.18~0.27	600	0.10~0.16
12	3200	0.20~0.30	3200	0.20~0.30	1900	0.20~0.30	1600	0.12~0.20	3200	0.20~0.30	2400	0.20~0.30	3700	0.20~0.30	500	0.12~0.18
14	2700	0.22~0.35	2700	0.22~0.35	1600	0.22~0.35	1350	0.13~0.22	2700	0.22~0.35	2100	0.22~0.35	3200	0.22~0.35	450	0.13~0.20
16	2400	0.25~0.36	2400	0.25~0.36	1400	0.25~0.36	1200	0.14~0.25	2400	0.25~0.36	1800	0.25~0.36	2800	0.25~0.36	400	0.14~0.23
18	2100	0.28~0.38	2100	0.28~0.38	1200	0.28~0.38	1050	0.15~0.28	2100	0.28~0.38	1600	0.28~0.38	2500	0.28~0.38	350	0.15~0.25
20	1900	0.30~0.40	1900	0.30~0.40	1100	0.30~0.40	950	0.16~0.30	1900	0.30~0.40	1400	0.30~0.40	2300	0.30~0.40	320	0.16~0.28

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 5D.

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 5xD ausgelegt.

SU series step drills · SU Stufenbohrer Serie (External coolant / Kühlung)

3D

workpiece material / Werkstück-stoff	Mild steel Baustahl HB≤180		Carbon steel, alloy steel Kohlenstoffstahl Leg. Stahl ~30HRC		Pre-hardened steel Vergüteter Stahl ~40HRC		Stainless steel Rostfreier Stahl		Cast iron Gusseisen		Nodular cast iron GGG Kugelgra-phitguss		Aluminum alloy Alulegierungen		Heat resistant alloy Warmfeste Legierungen	
Vc	50~100m/min		50~100m/min		30~50m/min		25~40m/min		50~100m/min		40~80m/min		60~120m/min		15~25m/min	
Ø (mm)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)	n (min^{-1})	f (mm/r)
3.3	5800	0.09~0.12	5800	0.09~0.12	3850	0.09~0.12	2900	0.03~0.07	5800	0.09~0.12	5000	0.09~0.12	10000	0.09~0.12	1600	0.03~0.06
4.2	4550	0.10~0.15	4550	0.10~0.15	3000	0.10~0.15	2300	0.04~0.08	4550	0.10~0.15	3800	0.10~0.15	7600	0.10~0.15	1250	0.04~0.07
5	3800	0.12~0.18	3800	0.12~0.18	2550	0.12~0.18	1900	0.05~0.10	3800	0.12~0.18	3200	0.12~0.18	6400	0.12~0.18	1050	0.05~0.10
6.75	2850	0.14~0.20	2850	0.14~0.20	1900	0.14~0.20	1400	0.06~0.12	2850	0.14~0.20	2400	0.14~0.20	4800	0.14~0.20	800	0.06~0.11
7	2750	0.15~0.22	2750	0.15~0.22	1800	0.15~0.22	1350	0.07~0.14	2750	0.15~0.22	2300	0.15~0.22	4550	0.15~0.22	730	0.07~0.12
8.5	2250	0.16~0.24	2250	0.16~0.24	1500	0.16~0.24	1100	0.08~0.16	2250	0.16~0.24	1800	0.16~0.24	3600	0.16~0.24	600	0.08~0.14
9	2100	0.17~0.25	2100	0.17~0.25	1400	0.17~0.25	1050	0.09~0.17	2100	0.17~0.25	1750	0.17~0.25	3500	0.17~0.25	560	0.09~0.15
10.25	1850	0.18~0.27	1850	0.18~0.27	1250	0.18~0.27	930	0.10~0.18	1850	0.18~0.27	1550	0.18~0.27	3100	0.18~0.27	500	0.10~0.16
10.5	1800	0.19~0.28	1800	0.19~0.28	1200	0.19~0.28	900	0.11~0.19	1800	0.19~0.28	1500	0.19~0.28	3000	0.19~0.28	480	0.11~0.17
12	1600	0.20~0.30	1600	0.20~0.30	1050	0.20~0.30	800	0.12~0.20	1600	0.20~0.30	1300	0.20~0.30	2600	0.20~0.30	450	0.12~0.18
12.5	1550	0.20~0.30	1550	0.20~0.30	1000	0.20~0.30	760	0.12~0.20	1550	0.20~0.30	1250	0.20~0.30	2550	0.20~0.30	410	0.12~0.18
14	1350	0.22~0.35	1350	0.22~0.35	900	0.22~0.35	700	0.14~0.24	1350	0.22~0.35	1150	0.22~0.35	2300	0.22~0.35	370	0.13~0.20
14.5	1300	0.22~0.35	1300	0.22~0.35	880	0.22~0.35	650	0.14~0.24	1300	0.22~0.35	1050	0.22~0.35	2200	0.22~0.35	350	0.13~0.20

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2. Die obigen Schnittdatenempfehlungen basieren auf dem Einsatz von Emulsion.
3. Keine defekte Werkzeugaufnahme wählen. Die Rundlaufgenauigkeit muss unten 0,02mm liegen.