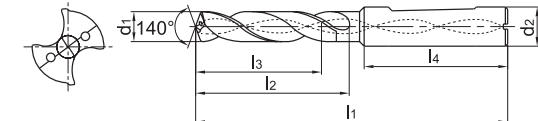
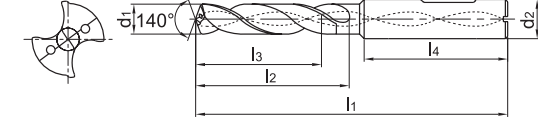
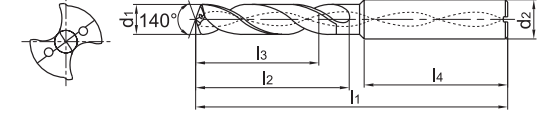
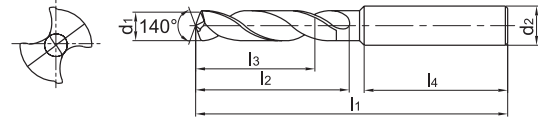
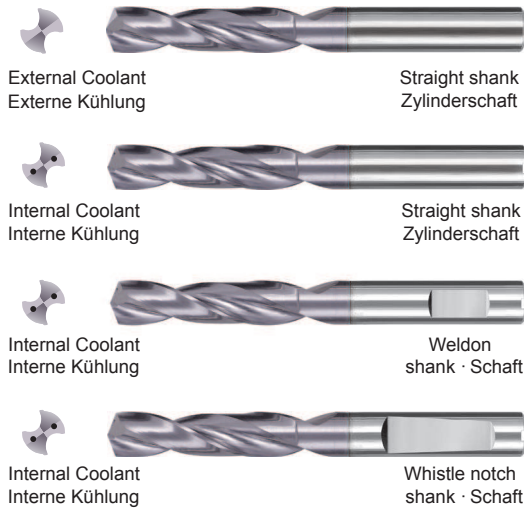


Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
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	●

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d ₂ (h6)	l ₁	l ₂	l ₃	l ₄		
2.9	3	External Extern	Straight shank	1534SU03-0290	6	62	20	14	36	●	
	5			1536SU05-0290	6	66	28	23	36	●	
3.0	3		Zylinder- schaft	Straight shank	1534SU03-0300	6	62	20	14	36	●
	5				1536SU05-0300	6	66	28	23	36	●
	3			Weld on shank/ Schaft	1534SU03C-0300	6	62	20	14	36	●
	5				1536SU05C-0300	6	66	28	23	36	●
	3		Internal Intern	Whistle notch shank/ Schaft	1634SU03C-0300	6	62	20	14	36	●
	5				1636SU05C-0300	6	62	20	14	36	●
	3			straight shank Zylinderschaft	1734SU03C-0300	6	66	28	23	36	●
	5				1736SU05C-0300	6	66	28	23	36	●
8	1538SU08C-0300	6	72	34	29	36	●				
3.1	3	External Extern	Straight shank	1534SU03-0310	6	62	20	14	36	●	
	5			1536SU05-0310	6	66	28	23	36	●	
	3.2	3	Zylinder- schaft	Straight shank	1534SU03C-0310	6	62	20	14	36	●
		5			1536SU05C-0310	6	66	28	23	36	●
		3		Weld on shank/ Schaft	1634SU05C-0310	6	62	20	14	36	●
		5			1636SU05C-0310	6	66	28	23	36	●
		3	Internal Intern	Whistle notch shank/ Schaft	1734SU03C-0310	6	62	20	14	36	●
		5			1736SU05C-0310	6	66	28	23	36	●
		8		1538SU08C-0310	6	72	34	29	36	●	
		3.2		3	External Extern	Straight shank	1534SU03-0320	6	62	20	14
5	1536SU05-0320		6	66			28	23	36	●	
3.25	3		Zylinder- schaft	Straight shank	1534SU03C-0320	6	62	20	14	36	●
	5				1536SU05C-0320	6	66	28	23	36	●
	3			Weld on shank/ Schaft	1634SU03C-0320	6	62	20	14	36	●
	5				1636SU05C-0320	6	66	28	23	36	●
	3		Internal Intern	Whistle notch shank/ Schaft	1734SU03C-0320	6	62	20	14	36	●
	5				1736SU05C-0320	6	66	28	23	36	●
	8			1538SU08C-0320	6	72	34	29	36	●	
	3.25			3	External Extern	Straight shank	1534SU03-0325	6	62	20	14
5		1536SU05-0325	6	66			28	23	36	●	
3.25		3	Zylinder- schaft	Straight shank	1534SU03C-0325	6	62	20	14	36	●
		5			1536SU05C-0325	6	66	28	23	36	●
		3		Internal Intern	Weld on 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	●	



Solid Carbide drills
Vollhartmetallbohrer

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 Wärmefeste Leg.
			~40HRC	~50HRC	~60HRC						
KDG303	✓	✓	✓			✓	✓	✓			

Code key C 10
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

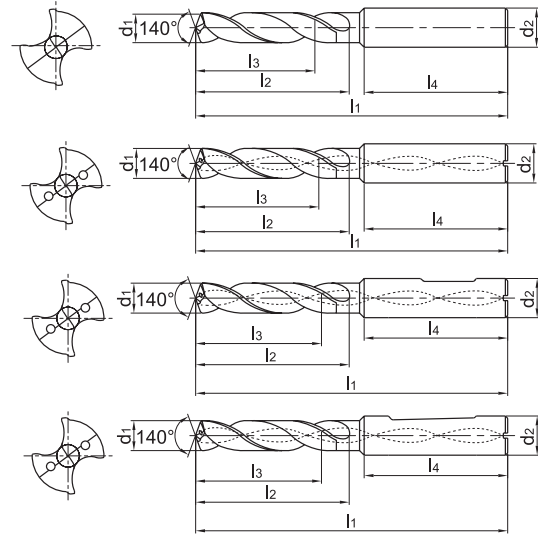
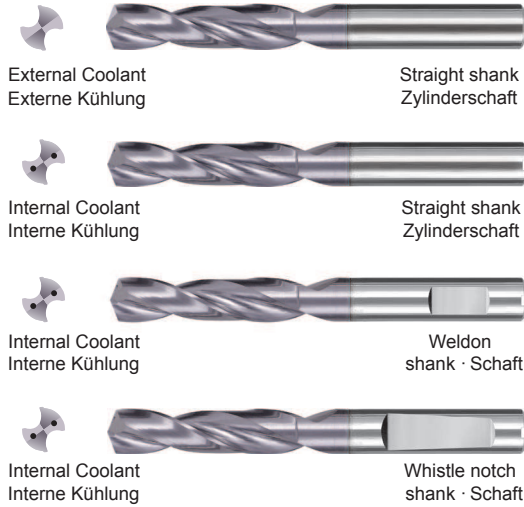
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
3.3	3	External Extern	Straight shank Zylinderschaft	1534SU03-0330	6	62	20	14	36	●
	5			1536SU05-0330	6	66	28	23	36	●
	3	Internal Intern	Weldon shank/Schaft	1534SU03C-0330	6	62	20	14	36	●
	5			1536SU05C-0330	6	66	28	23	36	●
	3		Whistle notch shank/Schaft	1634SU03C-0330	6	62	20	14	36	●
	5			1636SU05C-0330	6	66	28	23	36	●
	3			1734SU03C-0330	6	62	20	14	36	●
	5			1736SU05C-0330	6	66	28	23	36	●
8	1538SU08C-0330	6	72	34	29	36	●			
3.4	3	External Extern	Straight shank Zylinderschaft	1534SU03-0340	6	62	20	14	36	●
	5			1536SU05-0340	6	66	28	23	36	●
	3	Internal Intern	Weldon shank/Schaft	1534SU03C-0340	6	62	20	14	36	●
	5			1536SU05C-0340	6	66	28	23	36	●
	3		Whistle notch shank/Schaft	1634SU03C-0340	6	62	20	14	36	●
	5			1636SU05C-0340	6	66	28	23	36	●
	3			1734SU03C-0340	6	62	20	14	36	●
	5			1736SU05C-0340	6	66	28	23	36	●
8	1538SU08C-0340	6	72	34	29	36	●			
3.5	3	External Extern	Straight shank Zylinderschaft	1534SU03-0350	6	62	20	14	36	●
	5			1536SU05-0350	6	66	28	23	36	●
	3	Internal Intern	Weldon shank/Schaft	1534SU03C-0350	6	62	20	14	36	●
	5			1536SU05C-0350	6	66	28	23	36	●
	3		Whistle notch shank/Schaft	1634SU03C-0350	6	62	20	14	36	●
	5			1636SU05C-0350	6	66	28	23	36	●
	3			1734SU03C-0350	6	62	20	14	36	●
	5			1736SU05C-0350	6	66	28	23	36	●
8	1538SU08C-0350	6	72	34	29	36	●			

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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		Weld on 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	1538SU08C-0360		6	72	34	29	36	●		
3.7	3		External Extern	Straight shank	1534SU03-0370	6	62	20	14	36
	5	1536SU05-0370			6	66	28	23	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0370	6	62	20	14	36	●
	5			1536SU05C-0370	6	66	28	23	36	●
	3		Weld on 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	1538SU08C-0370		6	72	34	29	36	●		
3.8	3		External Extern	Straight shank	1534SU03-0380	6	66	24	17	36
	5	1536SU05-0380			6	74	36	29	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0380	6	66	24	17	36	●
	5			1536SU05C-0380	6	74	36	29	36	●
	3		Weld on 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	1538SU08C-0380		6	81	43	36	36	●		
3.9	3		External Extern	Straight shank	1534SU03-0390	6	66	24	17	36
	5	1536SU05-0390			6	74	36	29	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0390	6	66	24	17	36	●
	5			1536SU05C-0390	6	74	36	29	36	●
	3		Weld on 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	1538SU08C-0390		6	81	43	36	36	●		
4.0	3		External Extern	Straight shank	1534SU03-0400	6	66	24	17	36
	5	1536SU05-0400			6	74	36	29	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0400	6	66	24	17	36	●
	5			1536SU05C-0400	6	74	36	29	36	●

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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



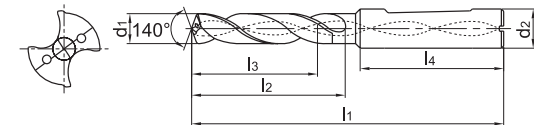
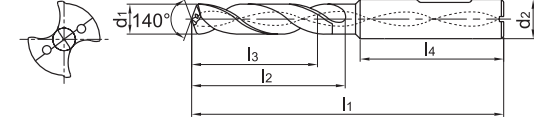
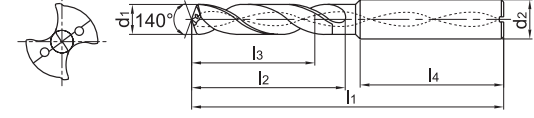
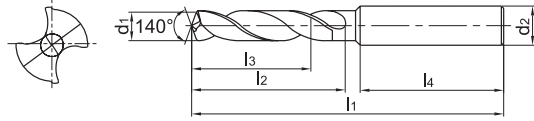
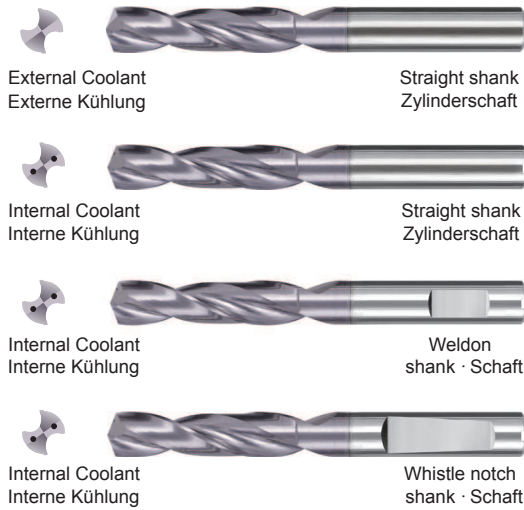
Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2(h6)	l1	l2	l3	l4		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				1538SU08C-0400	6	81	43	36	36	●
4.1	3	External Extern	Straight shank	1534SU03-0410	6	66	24	17	36	●	
	5			1536SU05-0410	6	74	36	29	36	●	
	3	Internal Intern	Zylinder- schaft	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		1538SU08C-0410		6	81	43	36	36	●	
	4.2		3	External Extern	Straight shank	1534SU03-0420	6	66	24	17	36
5		1536SU05-0420	6			74	36	29	36	●	
3		Internal Intern	Zylinder- schaft	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			1538SU08C-0420		6	81	43	36	36	●	
4.3			3	External Extern	Straight shank	1534SU03-0430	6	66	24	17	36
	5	1536SU05-0430	6			74	36	29	36	●	
	3	Internal Intern	Zylinder- schaft	1534SU03C-0430	6	66	24	17	36	●	
	5			1536SU05C-0430	6	74	36	29	36	●	

Drilling - Bohren

Solid Carbide drills - Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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			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	Zylinder- schaft	1534SU03C-0440	6	66	24	17	36	●	
	5		1536SU05C-0440	6	74	36	29	36	●	
	3	Internal Intern	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	1538SU08C-0440		6	81	43	36	36	●	
	4.5	3	External Extern	Straight shank	1534SU03-0450	6	66	24	17	36
5		1536SU05-0450			6	74	36	29	36	●
3		Zylinder- schaft	1534SU03C-0450	6	66	24	17	36	●	
5			1536SU05C-0450	6	74	36	29	36	●	
3		Internal Intern	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		1538SU08C-0450		6	81	43	36	36	●	
4.6		3	External Extern	Straight shank	1534SU03-0460	6	66	24	17	36
	5	1536SU05-0460			6	74	36	29	36	●
	3	Zylinder- schaft	1534SU03C-0460	6	66	24	17	36	●	
	5		1536SU05C-0460	6	74	36	29	36	●	
	3	Internal Intern	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	1538SU08C-0460		6	81	43	36	36	●	
	4.65	3	External Extern	Straight shank	1534SU03-0465	6	66	24	17	36
5		1536SU05-0465			6	74	36	29	36	●
3		Zylinder- schaft	1534SU03C-0465	6	66	24	17	36	●	
5			1536SU05C-0465	6	74	36	29	36	●	
3		Internal Intern	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 Wärmefeste Leg.
			~40HRC	~50HRC	~60HRC						
KDG303	✓	✓	✓			✓	✓	✓			

Code key C 10
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

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

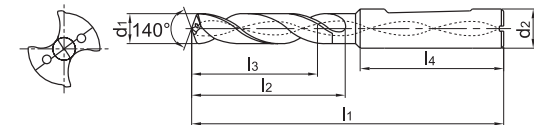
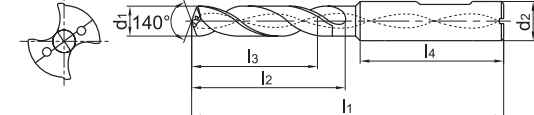
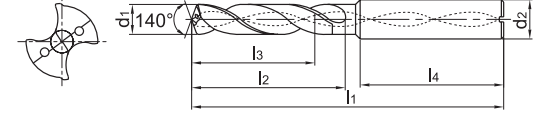
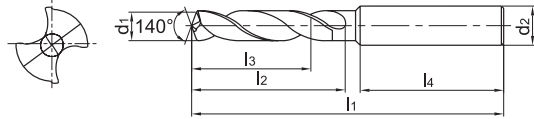
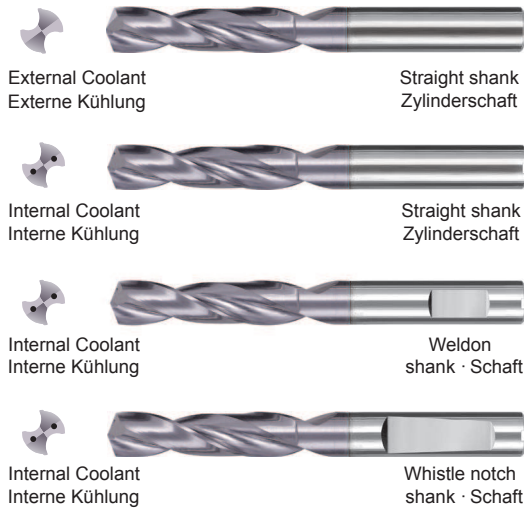


Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
4.7	3	External Extern	Straight shank Zylinderschaft	1534SU03-0470	6	66	24	17	36	●
	5			1536SU05-0470	6	74	36	29	36	●
	3	Internal Intern	Weld on 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		1538SU08C-0470	6	81	43	36	36	●	
	4.8		3	External Extern	Straight shank Zylinderschaft	1534SU03-0480	6	66	28	20
5		1536SU05-0480	6			82	44	35	36	●
3		Internal Intern	Weld on 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			1538SU08C-0480	6	95	57	48	36	●	
4.9			3	External Extern	Straight shank Zylinderschaft	1534SU03-0490	6	66	28	20
	5	1536SU05-0490	6			82	44	35	36	●
	3	Internal Intern	Weld on 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		1538SU08C-0490	6	95	57	48	36	●	

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	1538SU08C-0500		6	95	57	48	36	●		
5.1	3		External Extern	Straight shank	1534SU03-0510	6	66	28	20	36
	5	1536SU05-0510			6	82	44	35	36	●
	3	Internal Intern	Zylinder- schaft	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	1538SU08C-0510		6	95	57	48	36	●		
5.2	3		External Extern	Straight shank	1534SU03-0520	6	66	28	20	36
	5	1536SU05-0520			6	82	44	35	36	●
	3	Internal Intern	Zylinder- schaft	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	1538SU08C-0520		6	95	57	48	36	●		
5.3	3		External Extern	Straight shank	1534SU03-0530	6	66	28	20	36
	5	1536SU05-0530			6	82	44	35	36	●
	3	Internal Intern	Zylinder- schaft	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	●	



Solid Carbide drills
Vollhartmetallbohrer

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

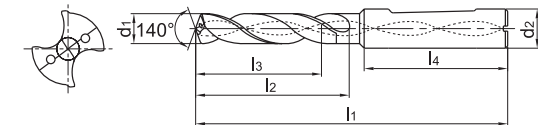
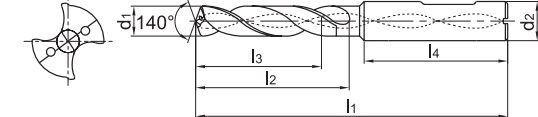
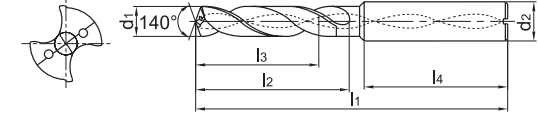
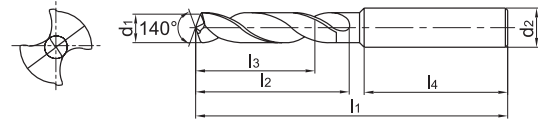
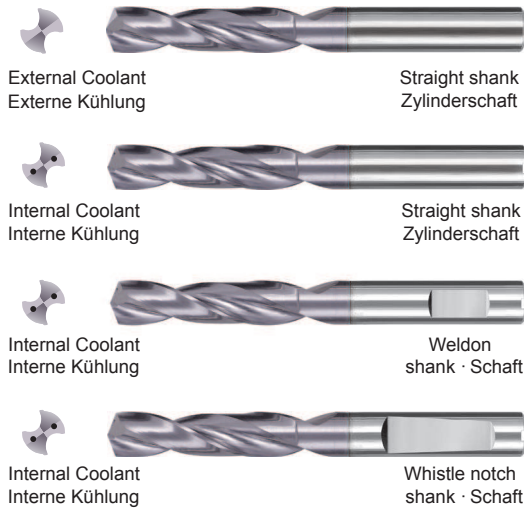
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2(h6)	l1	l2	l3	l4		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	Internal Intern	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	Internal Intern	Whistle notch shank/ Schaft	1538SU08C-0540	6	95	57	48	36	●		
3			External Extern	Straight shank	1534SU03-0550	6	66	28	20	36	●
5					1536SU05-0550	6	82	44	35	36	●
3			Internal Intern	Zylinder- schaft	1534SU03C-0550	6	66	28	20	36	●
5					1536SU05C-0550	6	82	44	35	36	●
3			Internal Intern	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	Internal Intern	Whistle notch shank/ Schaft	1538SU08C-0550	6	95	57	48	36	●		
3			External Extern	Straight shank	1534SU03-0555	6	66	28	20	36	●
5					1536SU05-0555	6	82	44	35	36	●
3			Internal Intern	Zylinder- schaft	1534SU03C-0555	6	66	28	20	36	●
5					1536SU05C-0555	6	82	44	35	36	●
3			Internal Intern	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	●	

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	1538SU08C-0560		6	95	57	48	36	●		
5.7	3		External Extern	Straight shank	1534SU03-0570	6	66	28	20	36
	5	1536SU05-0570			6	82	44	35	36	●
	3	Internal Intern	Zylinder- schaft	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	1538SU08C-0570		6	95	57	48	36	●		
5.8	3		External Extern	Straight shank	1534SU03-0580	6	66	28	20	36
	5	1536SU05-0580			6	82	44	35	36	●
	3	Internal Intern	Zylinder- schaft	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	1538SU08C-0580		6	95	57	48	36	●		
5.9	3		External Extern	Straight shank	1534SU03-0590	6	66	28	20	36
	5	1536SU05-0590			6	82	44	35	36	●
	3	Internal Intern	Zylinder- schaft	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	●	



Solid Carbide drills
Vollhartmetallbohrer

Material Overview · Material Übersicht

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Grade Sorte	Workpiece material · Werkstückstoff									
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KDG303	✓	✓	✓			✓	✓	✓		

Code key C 10
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

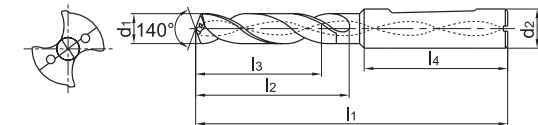
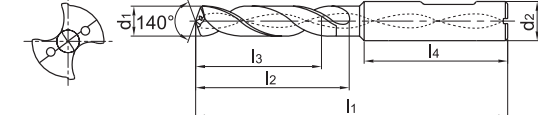
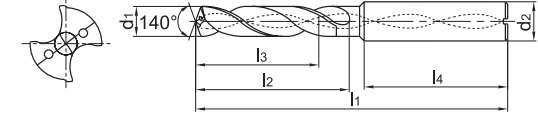
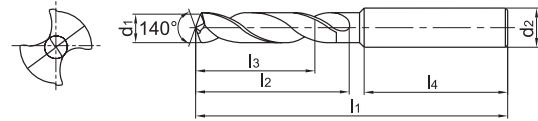
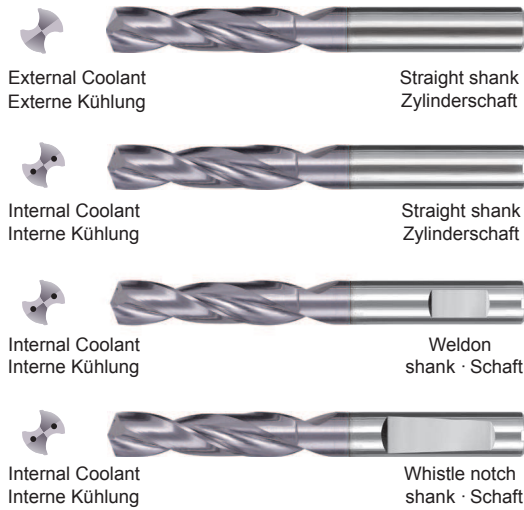
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
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		Weld on 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			1538SU08C-0600	6	95	57	48	36	●	
6.1	3		External Extern	Straight shank	1534SU03-0610	8	79	34	24	36
	5	1536SU05-0610			8	91	53	43	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0610	8	79	34	24	36	●
	5			1536SU05C-0610	8	91	53	43	36	●
	3		Weld on 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			1538SU08C-0610	8	114	76	66	36	●	
6.2	3		External Extern	Straight shank	1534SU03-0620	8	79	34	24	36
	5	1536SU05-0620			8	91	53	43	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0620	8	79	34	24	36	●
	5			1536SU05C-0620	8	91	53	43	36	●
	3		Weld on 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	●	

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	1538SU08C-0630		8	114	76	66	36	●		
6.4	3		External Extern	Straight shank	1534SU03-0640	8	79	34	24	36
	5	1536SU05-0640			8	91	53	43	36	●
	3	Internal Intern	Zylinder- schaft	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	1534SU03-0650	8	79	34	24	36
	5	1536SU05-0650			8	91	53	43	36	●
	3	Internal Intern	Zylinder- schaft	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	1534SU03-0660	8	79	34	24	36
	5	1536SU05-0660			8	91	53	43	36	●
	3	Internal Intern	Zylinder- schaft	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	●	



Solid Carbide drills
Vollhartmetallbohrer

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

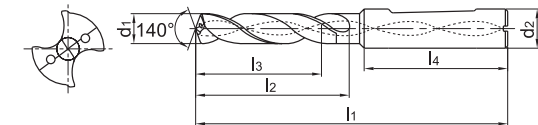
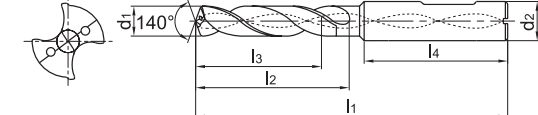
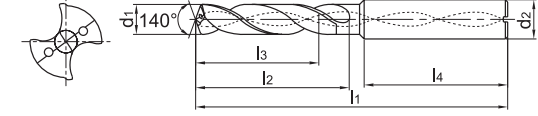
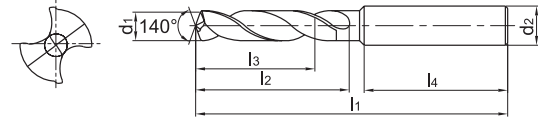
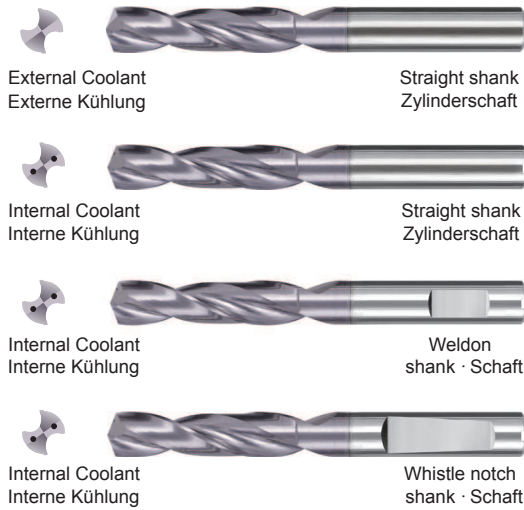
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
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	Weldon shank/ Schaft	1534SU03C-0670	8	79	34	24	36	●
	5			1536SU05C-0670	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1634SU03C-0670	8	79	34	24	36	●
	5			1636SU05C-0670	8	91	53	43	36	●
	3			1734SU03C-0670	8	79	34	24	36	●
	5			1736SU05C-0670	8	91	53	43	36	●
8	1538SU08C-0670	8	114	76	66	36	●			
6.75	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0675	8	79	34	24	36	●
	5			1536SU05-0675	8	91	53	43	36	●
	3	Internal Intern	Weldon shank/ Schaft	1534SU03C-0675	8	79	34	24	36	●
	5			1536SU05C-0675	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1634SU03C-0675	8	79	34	24	36	●
	5			1636SU05C-0675	8	91	53	43	36	●
	3			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	Weldon shank/ Schaft	1534SU03C-0680	8	79	34	24	36	●
	5			1536SU05C-0680	8	91	53	43	36	●
	3		Whistle notch shank/ Schaft	1634SU03C-0680	8	79	34	24	36	●
	5			1636SU05C-0680	8	91	53	43	36	●
	3			1734SU03C-0680	8	79	34	24	36	●
	5			1736SU05C-0680	8	91	53	43	36	●
	8			1538SU08C-0680	8	114	76	66	36	●

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	Internal Intern	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		1538SU08C-0690	8	114	76	66	36	●		
7.0	3	External Extern	Straight shank	1534SU03-0700	8	79	34	24	36	●
	5			1536SU05-0700	8	91	53	43	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0700	8	79	34	24	36	●
	5			1536SU05C-0700	8	91	53	43	36	●
	3	Internal Intern	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		1538SU08C-0700	8	116	76	66	36	●		
7.1	3	External Extern	Straight shank	1534SU03-0710	8	79	41	29	36	●
	5			1536SU05-0710	8	91	53	43	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0710	8	79	41	29	36	●
	5			1536SU05C-0710	8	91	53	43	36	●
	3	Internal Intern	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		1538SU08C-0710	8	116	76	66	36	●		
7.2	3	External Extern	Straight shank	1534SU03-0720	8	79	41	29	36	●
	5			1536SU05-0720	8	91	53	43	36	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0720	8	79	41	29	36	●
	5			1536SU05C-0720	8	91	53	43	36	●
	3	Internal Intern	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	●	



Solid Carbide drills
Vollhartmetallbohrer

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

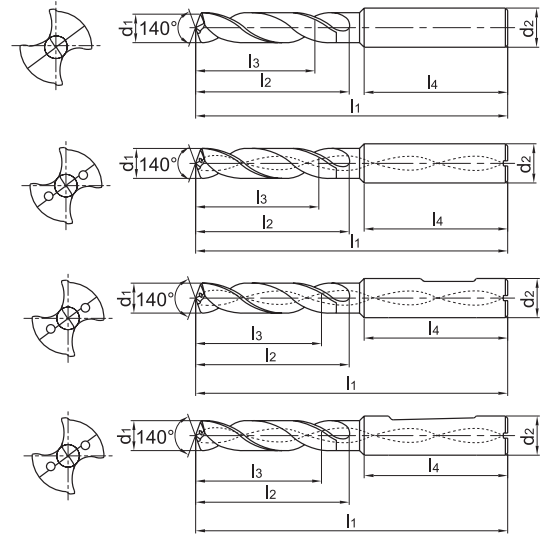
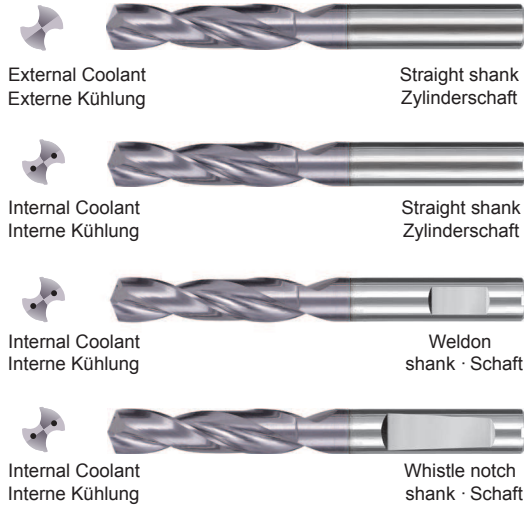
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2(h6)	l1	l2	l3	l4		
7.3	3	External Extern	Straight shank Zylinderschaft	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			1538SU08C-0730	8	116	76	66	36	●		
7.4	3	External Extern	Straight shank Zylinderschaft	1534SU03-0740	8	79	41	29	36	●	
	5			1536SU05-0740	8	91	53	43	36	●	
	3	Internal Intern	Zylinder-schaft	1534SU03C-0740	8	79	41	29	36	●	
	5			1536SU05C-0740	8	91	53	43	36	●	
	3		Weldon shank/Schaft	1634SU03C-0740	8	79	41	29	36	●	
	5			1636SU05C-0740	8	91	53	43	36	●	
	3			Whistle notch shank/Schaft	1734SU03C-0740	8	79	41	29	36	●
	5				1736SU05C-0740	8	91	53	43	36	●
8			1538SU08C-0740	8	116	76	66	36	●		
7.45	3	External Extern	Straight shank Zylinderschaft	1534SU03-0745	8	79	41	29	36	○	
	5			1536SU05-0745	8	91	53	43	36	○	
	3	Internal Intern	Zylinder-schaft	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	●	

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (mm)	Drilling depth Bohrtiefe (L/d ₁)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter 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			1538SU08C-0750	8	116	76	66	36	●	
7.6	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0760	8	79	41	29	36	●	
	5			1536SU05-0760	8	91	53	43	36	●	
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0760	8	79	41	29	36	●	
	5			1636SU05C-0760	8	91	53	43	36	●	
	3	Whistle notch shank/ Schaft	1734SU03C-0760	8	79	41	29	36	●		
	5		1736SU05C-0760	8	91	53	43	36	●		
	8		1538SU08C-0760	8	116	76	66	36	●		
	7.7	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0770	8	79	41	29	36	●
		5			1536SU05-0770	8	91	53	43	36	●
		3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0770	8	79	41	29	36	●
5		1636SU05C-0770			8	91	53	43	36	●	
3		Whistle notch shank/ Schaft	1734SU03C-0770	8	79	41	29	36	●		
5			1736SU05C-0770	8	91	53	43	36	●		
8			1538SU08C-0770	8	116	76	66	36	●		
7.8		3	External Extern	Straight shank Zylinder- schaft	1534SU03-0780	8	79	41	29	36	●
		5			1536SU05-0780	8	91	53	43	36	●
		3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0780	8	79	41	29	36	●
	5	1636SU05C-0780			8	91	53	43	36	●	
	3	Whistle notch shank/ Schaft	1734SU03C-0780	8	79	41	29	36	●		
	5		1736SU05C-0780	8	91	53	43	36	●		
	8		1538SU08C-0780	8	116	76	66	36	●		
	7.9	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0790	8	79	41	29	36	●
		5			1536SU05-0790	8	91	53	43	36	●
		3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0790	8	79	41	29	36	●
5		1636SU05C-0790			8	91	53	43	36	●	

Material Overview · Material Übersicht

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

Grade 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 Wärmefeste 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



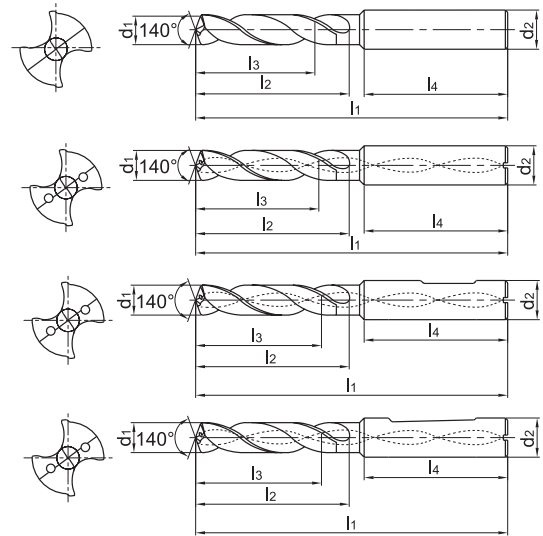
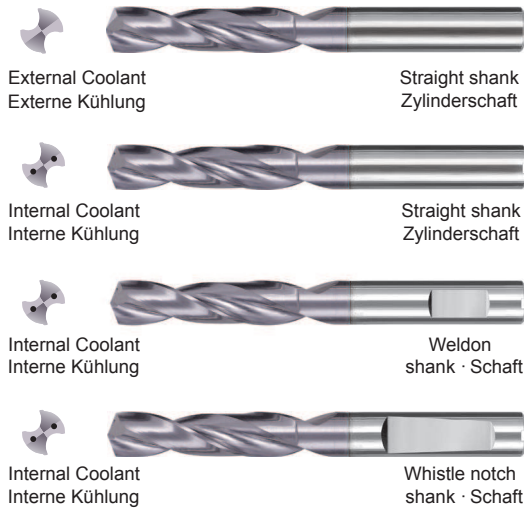
Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
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- Hocheffizientes Bohren von allgemeinen Stahlwerkstoffen, rostfreien Werkstoffen und Guss.
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Drill diameter Bohrer Ø d1 (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2 (h6)	l1	l2	l3	l4	
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			1538SU08C-0790	8	116	76	66	36	●
8.0	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0800	8	79	41	29	36	●
	5			1536SU05-0800	8	91	53	43	36	●
	3			1534SU03C-0800	8	79	41	29	36	●
	5	1536SU05C-0800	8	91	53	43	36	●		
	3	Internal Intern	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		1538SU08C-0800	8	116	76	66	36	●		
8.1	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0810	10	89	47	35	40	●
	5			1536SU05-0810	10	103	61	49	40	●
	3			1534SU03C-0810	10	89	47	35	40	●
	5	1536SU05C-0810	10	103	61	49	40	●		
	3	Internal Intern	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	1538SU08C-0810	10		142	95	83	40	●	
8.2	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0820	10	89	47	35	40	●
	5			1536SU05-0820	10	103	61	49	40	●
	3			1534SU03C-0820	10	89	47	35	40	●
	5	1536SU05C-0820	10	103	61	49	40	●		
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0820	10	89	47	35	40	●
	5			1636SU05C-0820	10	103	61	49	40	●

Drilling - Bohren

Solid Carbide drills - Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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			1538SU08C-0820	10	142	95	83	40	●
8.3	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0830	10	89	47	35	40	●
	5			1536SU05-0830	10	103	61	49	40	●
	3			1534SU03C-0830	10	89	47	35	40	●
	5	1536SU05C-0830	10	103	61	49	40	●		
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0830	10	89	47	35	40	●
	5			1636SU05C-0830	10	103	61	49	40	●
	3			1734SU03C-0830	10	89	47	35	40	●
	5	1736SU05C-0830	10	103	61	49	40	●		
	8	1538SU08C-0830	10	142	95	83	40	●		
8.4	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0840	10	89	47	35	40	●
	5			1536SU05-0840	10	103	61	49	40	●
	3			1534SU03C-0840	10	89	47	35	40	●
	5	1536SU05C-0840	10	103	61	49	40	●		
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0840	10	89	47	35	40	●
	5			1636SU05C-0840	10	103	61	49	40	●
	3			1734SU03C-0840	10	89	47	35	40	●
	5	1736SU05C-0840	10	103	61	49	40	●		
	8	1538SU08C-0840	10	142	95	83	40	●		
8.5	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0850	10	89	47	35	40	●
	5			1536SU05-0850	10	103	61	49	40	●
	3			1534SU03C-0850	10	89	47	35	40	●
	5	1536SU05C-0850	10	103	61	49	40	●		
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0850	10	89	47	35	40	●
	5			1636SU05C-0850	10	103	61	49	40	●
	3			1734SU03C-0850	10	89	47	35	40	●
	5	1736SU05C-0850	10	103	61	49	40	●		
	8	1538SU08C-0850	10	142	95	83	40	●		
8.6	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0860	10	89	47	35	40	●
	5			1536SU05-0860	10	103	61	49	40	●
	3			1534SU03C-0860	10	89	47	35	40	●
	5	1536SU05C-0860	10	103	61	49	40	●		
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0860	10	89	47	35	40	●
	5			1636SU05C-0860	10	103	61	49	40	●
	3			1734SU03C-0860	10	89	47	35	40	●
	5	1736SU05C-0860	10	103	61	49	40	●		
	8	1538SU08C-0860	10	142	95	83	40	●		

Material Overview · Material Übersicht

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

Grade 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.
~40HRC			~50HRC	~60HRC						
KDG303	✓	✓	✓			✓	✓	✓		

Code key C 10
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

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

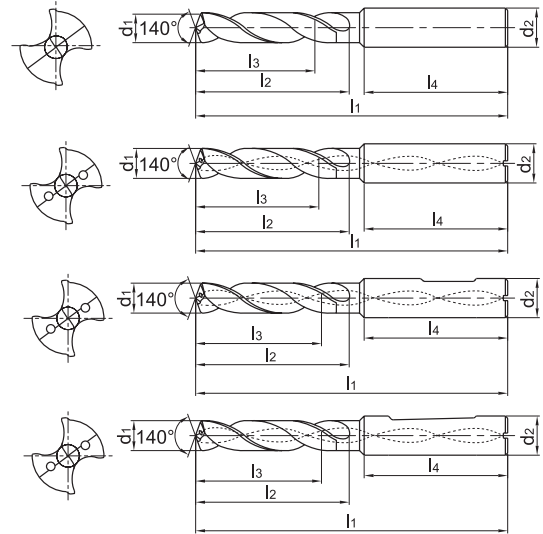
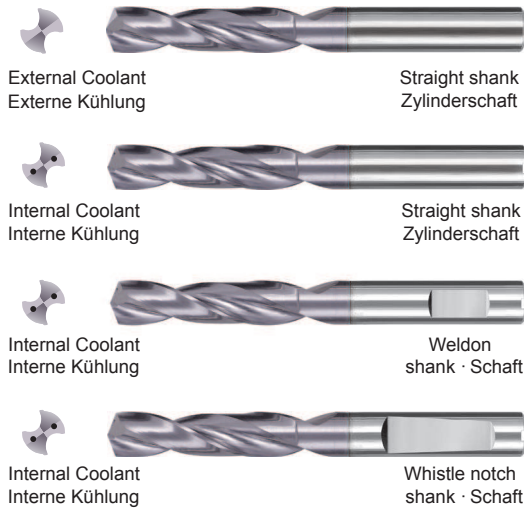


Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
8.7	3	External Extern	Straight shank	1534SU03-0870	10	89	47	35	40	●
	5			1536SU05-0870	10	103	61	49	40	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-0870	10	89	47	35	40	●
	5			1536SU05C-0870	10	103	61	49	40	●
	3		Weldon shank/ Schaft	1634SU03C-0870	10	89	47	35	40	●
	5			1636SU05C-0870	10	103	61	49	40	●
	3		Whistle notch shank/ Schaft	1734SU03C-0870	10	89	47	35	40	●
	5			1736SU05C-0870	10	103	61	49	40	●
8		1538SU08C-0870	10	142	95	83	40	●		
8.8	3	External Extern	Straight shank	1534SU03-0880	10	89	47	35	40	●
	5			1536SU05-0880	10	103	61	49	40	●
	3	Internal Intern	Zylinder- schaft	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		1538SU08C-0880	10	142	95	83	40	●		
8.9	3	External Extern	Straight shank	1534SU03-0890	10	89	47	35	40	●
	5			1536SU05-0890	10	103	61	49	40	●
	3	Internal Intern	Zylinder- schaft	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		1538SU08C-0890	10	142	95	83	40	●		

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	Internal Intern	Weldon shank/ Schaft	1634SU03C-0900	10	89	47	35	40	●
	5			1636SU05C-0900	10	103	61	49	40	●
	3	Internal Intern	Whistle notch shank/ Schaft	1734SU03C-0900	10	89	47	35	40	●
	5			1736SU05C-0900	10	103	61	49	40	●
8	External Extern	Straight shank	1538SU08C-0900	10	142	95	83	40	●	
3			External Extern	Zylinder- schaft	1534SU03-0910	10	89	47	35	40
5	Internal Intern	Weldon shank/ Schaft			1536SU05-0910	10	103	61	49	40
3			Internal Intern	Zylinder- schaft	1534SU03C-0910	10	89	47	35	40
5	Internal Intern	Weldon shank/ Schaft			1536SU05C-0910	10	103	61	49	40
3			Internal Intern	Whistle notch shank/ Schaft	1634SU03C-0910	10	89	47	35	40
5	Internal Intern	Whistle notch shank/ Schaft			1636SU05C-0910	10	103	61	49	40
3			External Extern	Straight shank	1734SU03C-0910	10	89	47	35	40
5	External Extern	Zylinder- schaft			1736SU05C-0910	10	103	61	49	40
8			External Extern	Straight shank	1538SU08C-0910	10	142	95	83	40
3	External Extern	Zylinder- schaft			1534SU03-0920	10	89	47	35	40
5			Internal Intern	Weldon shank/ Schaft	1536SU05-0920	10	103	61	49	40
3	Internal Intern	Zylinder- schaft			1534SU03C-0920	10	89	47	35	40
5			Internal Intern	Weldon shank/ Schaft	1536SU05C-0920	10	103	61	49	40
3	Internal Intern	Whistle notch shank/ Schaft			1634SU03C-0920	10	89	47	35	40
5			Internal Intern	Whistle notch shank/ Schaft	1636SU05C-0920	10	103	61	49	40
3	External Extern	Straight shank			1734SU03C-0920	10	89	47	35	40
5			External Extern	Zylinder- schaft	1736SU05C-0920	10	103	61	49	40
8	External Extern	Straight shank			1538SU08C-0920	10	142	95	83	40
3			External Extern	Zylinder- schaft	1534SU03-0930	10	89	47	35	40
5	Internal Intern	Weldon shank/ Schaft			1536SU05-0930	10	103	61	49	40
3			Internal Intern	Zylinder- schaft	1534SU03C-0930	10	89	47	35	40
5	Internal Intern	Weldon shank/ Schaft			1536SU05C-0930	10	103	61	49	40
3			Internal Intern	Whistle notch shank/ Schaft	1634SU03C-0930	10	89	47	35	40
5	Internal Intern	Whistle notch shank/ Schaft			1636SU05C-0930	10	103	61	49	40
3			External Extern	Straight shank	1734SU03C-0930	10	89	47	35	40
5	External Extern	Zylinder- schaft			1736SU05C-0930	10	103	61	49	40
8			External Extern	Straight shank	1538SU08C-0930	10	142	95	83	40
3	External Extern	Straight shank			1534SU03-0935	10	89	47	35	40
5			Internal Intern	Zylinder- schaft	1536SU05-0935	10	103	61	49	40
3	Internal Intern	Zylinder- schaft			1534SU03C-0935	10	89	47	35	40
5			Internal Intern	Zylinder- schaft	1536SU05C-0935	10	103	61	49	40

Material Overview · Material Übersicht

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 ✓ = 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.
~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



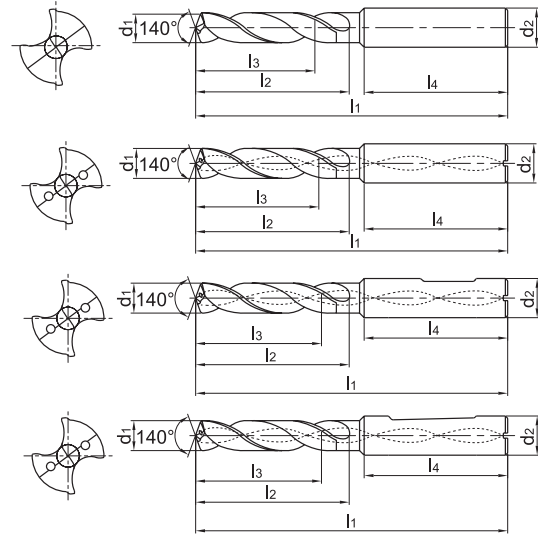
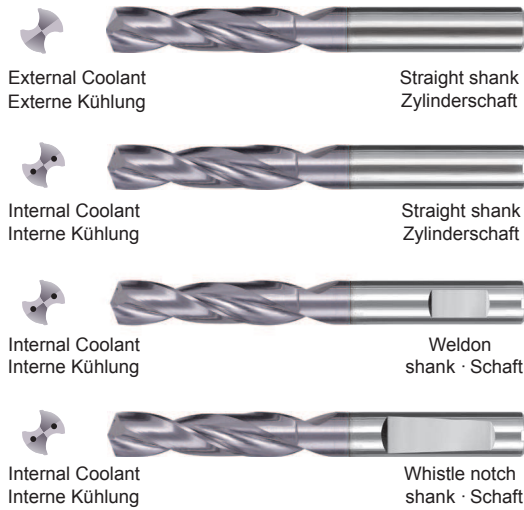
Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2(h6)	l1	l2	l3	l4		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	1534SU03-0940	10	89	47	35	40	●	
	5			1536SU05-0940	10	103	61	49	40	●	
	3	Zylinder- schaft	1534SU03C-0940	10	89	47	35	40	●		
	5		1536SU05C-0940	10	103	61	49	40	●		
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0940	10	89	47	35	40	●	
	5			1636SU05C-0940	10	103	61	49	40	●	
	3		Whistle notch shank/ Schaft	1734SU03C-0940	10	89	47	35	40	●	
	5			1736SU05C-0940	10	103	61	49	40	●	
	8			1538SU08C-0940	10	142	95	83	40	●	
	9.45	3	External Extern	Straight shank	1534SU03-0945	10	89	47	35	40	○
5		1536SU05-0945			10	103	61	49	40	○	
3		Zylinder- schaft	1534SU03C-0945	10	89	47	35	40	○		
5			1536SU05C-0945	10	103	61	49	40	○		
3		Internal Intern	Weldon shank/ Schaft	1634SU03C-0945	10	89	47	35	40	○	
5				1636SU05C-0945	10	103	61	49	40	○	
3			Whistle notch shank/ Schaft	1734SU03C-0945	10	89	47	35	40	○	
5				1736SU05C-0945	10	103	61	49	40	○	
9.5		3	External Extern	Straight shank	1534SU03-0950	10	89	47	35	40	●
		5			1536SU05-0950	10	103	61	49	40	●
	3	Zylinder- schaft	1534SU03C-0950	10	89	47	35	40	●		
	5		1536SU05C-0950	10	103	61	49	40	●		
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-0950	10	89	47	35	40	●	
	5			1636SU05C-0950	10	103	61	49	40	●	

Drilling - Bohren

Solid Carbide drills - Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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			1538SU08C-0950	10	142	95	83	40	●
9.6	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0960	10	89	47	35	40	●
	5			1536SU05-0960	10	103	61	49	40	●
	3			1534SU03C-0960	10	89	47	35	40	●
	5	1536SU05C-0960	10	103	61	49	40	●		
	3	Internal Intern	Weld on shank/ Schaft	1634SU03C-0960	10	89	47	35	40	●
	5			1636SU05C-0960	10	103	61	49	40	●
	3			1734SU03C-0960	10	89	47	35	40	●
	5	1736SU05C-0960	10	103	61	49	40	●		
	8	1538SU08C-0960	10	142	95	83	40	●		
9.7	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0970	10	89	47	35	40	●
	5			1536SU05-0970	10	103	61	49	40	●
	3			1534SU03C-0970	10	89	47	35	40	●
	5	1536SU05C-0970	10	103	61	49	40	●		
	3	Internal Intern	Weld on shank/ Schaft	1634SU03C-0970	10	89	47	35	40	●
	5			1636SU05C-0970	10	103	61	49	40	●
	3			1734SU03C-0970	10	89	47	35	40	●
	5	1736SU05C-0970	10	103	61	49	40	●		
	8	1538SU08C-0970	10	142	95	83	40	●		
9.8	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0980	10	89	47	35	40	●
	5			1536SU05-0980	10	103	61	49	40	●
	3			1534SU03C-0980	10	89	47	35	40	●
	5	1536SU05C-0980	10	103	61	49	40	●		
	3	Internal Intern	Weld on shank/ Schaft	1634SU03C-0980	10	89	47	35	40	●
	5			1636SU05C-0980	10	103	61	49	40	●
	3			1734SU03C-0980	10	89	47	35	40	●
	5	1736SU05C-0980	10	103	61	49	40	●		
	8	1538SU08C-0980	10	142	95	83	40	●		
9.9	3	External Extern	Straight shank Zylinder- schaft	1534SU03-0990	10	89	47	35	40	●
	5			1536SU05-0990	10	103	61	49	40	●
	3			1534SU03C-0990	10	89	47	35	40	●
	5	1536SU05C-0990	10	103	61	49	40	●		
	3	Internal Intern	Weld on shank/ Schaft	1634SU03C-0990	10	89	47	35	40	●
	5			1636SU05C-0990	10	103	61	49	40	●
	3			1734SU03C-0990	10	89	47	35	40	●
	5	1736SU05C-0990	10	103	61	49	40	●		
	8	1538SU08C-0990	10	142	95	83	40	●		

Material Overview · Material Übersicht

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

Grade 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.
KDG303	✓	✓	✓			✓	✓	✓		

Code key C 10
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

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

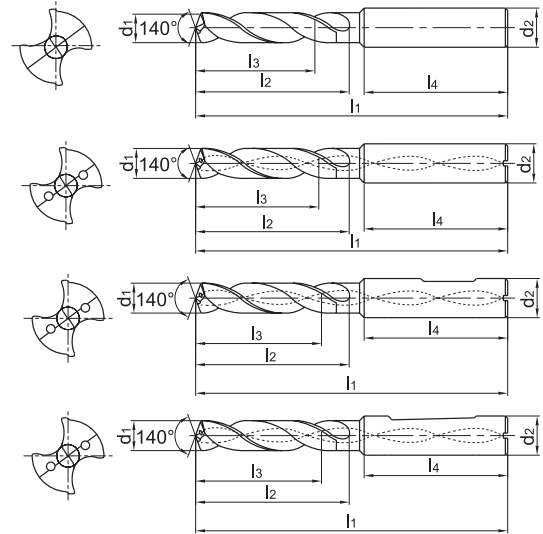
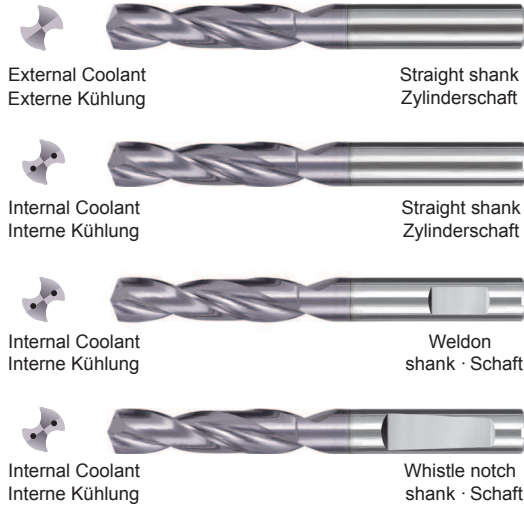


Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
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	Weldon shank/Schaft	1534SU03C-1000	10	89	47	35	40	●
	5			1536SU05C-1000	10	103	61	49	40	●
	3		Whistle notch shank/Schaft	1634SU03C-1000	10	89	47	35	40	●
	5			1636SU05C-1000	10	103	61	49	40	●
	3			1734SU03C-1000	10	89	47	35	40	●
	5			1736SU05C-1000	10	103	61	49	40	●
8	1538SU08C-1000	10	142	95	83	40	●			
10.1	3	External Extern	Straight shank Zylinder- schaft	1534SU03-1010	12	102	55	40	45	●
	5			1536SU05-1010	12	118	71	56	45	●
	3	Internal Intern	Weldon shank/Schaft	1534SU03C-1010	12	102	55	40	45	●
	5			1536SU05C-1010	12	118	71	56	45	●
	3		Whistle notch shank/Schaft	1634SU03C-1010	12	102	55	40	45	●
	5			1636SU05C-1010	12	118	71	56	45	●
	3			1734SU03C-1010	12	102	55	40	45	●
	5			1736SU05C-1010	12	118	71	56	45	●
8	1538SU08C-1010	12	162	114	99	45	●			
10.2	3	External Extern	Straight shank Zylinder- schaft	1534SU03-1020	12	102	55	40	45	●
	5			1536SU05-1020	12	118	71	56	45	●
	3	Internal Intern	Weldon shank/Schaft	1534SU03C-1020	12	102	55	40	45	●
	5			1536SU05C-1020	12	118	71	56	45	●
	3		Whistle notch shank/Schaft	1634SU03C-1020	12	102	55	40	45	●
	5			1636SU05C-1020	12	118	71	56	45	●
	3			1734SU03C-1020	12	102	55	40	45	●
	5			1736SU05C-1020	12	118	71	56	45	●
8	1538SU08C-1020	12	162	114	99	45	●			

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (mm)	Drilling depth Bohrtiefe (L/d ₁)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter 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	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1025	12	102	55	40	45	●
	5			1536SU05C-1025	12	118	71	56	45	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1025	12	102	55	40	45	○
	5			1636SU05C-1025	12	118	71	56	45	●
	3		Weld on 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	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1030	12	102	55	40	45	●
	5			1536SU05C-1030	12	118	71	56	45	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1030	12	102	55	40	45	●
	5			1636SU05C-1030	12	118	71	56	45	●
	3		Weld on shank/ Schaft	1734SU03C-1030	12	102	55	40	45	●
	5			1736SU05C-1030	12	118	71	56	45	●
10.4	3	External Extern	Straight shank	1534SU03-1040	12	102	55	40	45	●
	5			1536SU05-1040	12	118	71	56	45	●
	3	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1040	12	102	55	40	45	●
	5			1536SU05C-1040	12	118	71	56	45	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1040	12	102	55	40	45	●
	5			1636SU05C-1040	12	118	71	56	45	●
	3		Weld on shank/ Schaft	1734SU03C-1040	12	102	55	40	45	●
	5			1736SU05C-1040	12	118	71	56	45	●
10.5	3	External Extern	Straight shank	1534SU03-1050	12	102	55	40	45	●
	5			1536SU05-1050	12	118	71	56	45	●
	3	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1050	12	102	55	40	45	●
	5			1536SU05C-1050	12	118	71	56	45	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1050	12	102	55	40	45	●
	5			1636SU05C-1050	12	118	71	56	45	●
	3		Weld on shank/ Schaft	1734SU03C-1050	12	102	55	40	45	●
	5			1736SU05C-1050	12	118	71	56	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	●

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.
~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



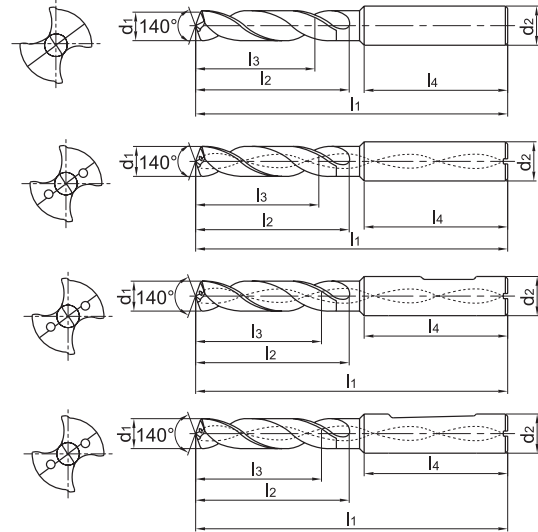
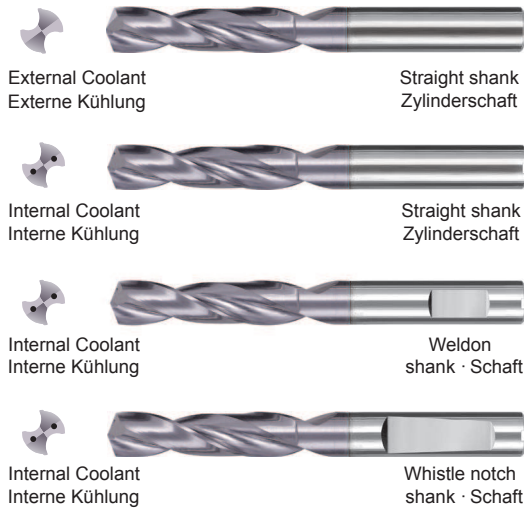
Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
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- Wellenförmige Schneidkante mit hoher Schneidenschärfe, Stabilität und guter Spanabfuhr.

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter 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	
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	●
10.7	8	External Extern	Straight shank	1538SU08C-1060	12	162	114	99	45	●
	3			Zylinder- schaft	1534SU03-1070	12	102	55	40	45
	5	1536SU05-1070	12		118	71	56	45	●	
	3	Internal Intern	Weldon shank/ Schaft	1534SU03C-1070	12	102	55	40	45	●
	5			1536SU05C-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	External Extern	Straight shank	1538SU08C-1070	12	162	114	99	45	●
	3			Zylinder- schaft	1534SU03-1080	12	102	55	40	45
	10.8	5	Internal Intern		Weldon shank/ Schaft	1536SU05-1080	12	118	71	56
3		1534SU03C-1080		12		102	55	40	45	●
5		Whistle notch shank/ Schaft	1536SU05C-1080	12	118	71	56	45	●	
3			1634SU03C-1080	12	102	55	40	45	●	
5		Internal Intern	Weldon shank/ Schaft	1636SU05C-1080	12	118	71	56	45	●
3				1734SU03C-1080	12	102	55	40	45	●
5		Whistle notch shank/ Schaft	1736SU05C-1080	12	118	71	56	45	●	
8			External Extern	Straight shank	1538SU08C-1080	12	162	114	99	45
3		Zylinder- schaft			1534SU03-1090	12	102	55	40	45
10.9			5	Internal Intern	Weldon shank/ Schaft	1536SU05-1090	12	118	71	56
	3	1534SU03C-1090	12			102	55	40	45	●
	3	External Extern	Straight shank	1534SU03-1090	12	102	55	40	45	●
	5			1536SU05C-1090	12	118	71	56	45	●

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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			1538SU08C-1090	12	162	114	99	45	●
11.0	3	External Extern	Straight shank	1534SU03-1100	12	102	55	40	45	●
	5			1536SU05-1100	12	118	71	56	45	●
	3		Zylinder- schaft	1534SU03C-1100	12	102	55	40	45	●
	5			1536SU05C-1100	12	118	71	56	45	●
	3	Internal Intern	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			1538SU08C-1100	12	162	114	99	45	●
	3			External Extern	Straight shank	1534SU03-1110	12	102	55	40
5	1536SU05-1110	12	118			71	56	45	●	
3	Zylinder- schaft	1534SU03C-1110	12		102	55	40	45	●	
5		1536SU05C-1110	12		118	71	56	45	●	
11.1	3	Internal Intern	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			1538SU08C-1110	12	162	114	99	45	●
	3			External Extern	Straight shank	1534SU03-1120	12	102	55	40
	5	1536SU05-1120	12			118	71	56	45	●
	3	Zylinder- schaft	1534SU03C-1120		12	102	55	40	45	●
	5		1536SU05C-1120		12	118	71	56	45	●
	11.2	3	Internal Intern	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				1538SU08C-1120	12	162	114	99	45	●
3				External Extern	Straight shank	1534SU03-1125	12	102	55	40
5		1536SU05-1125	12			118	71	56	45	○
3		Zylinder- schaft	1534SU03C-1125		12	102	55	40	45	○
5			1536SU05C-1125		12	118	71	56	45	○
11.25		3	Internal Intern	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	○
	8			1538SU08C-1125	12	162	114	99	45	○

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 Wärmefeste 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



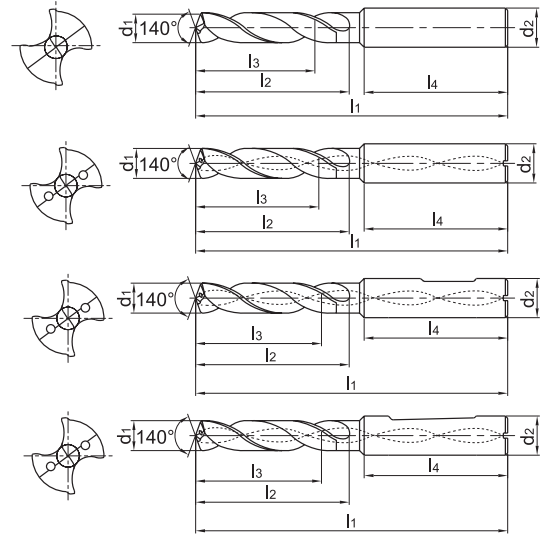
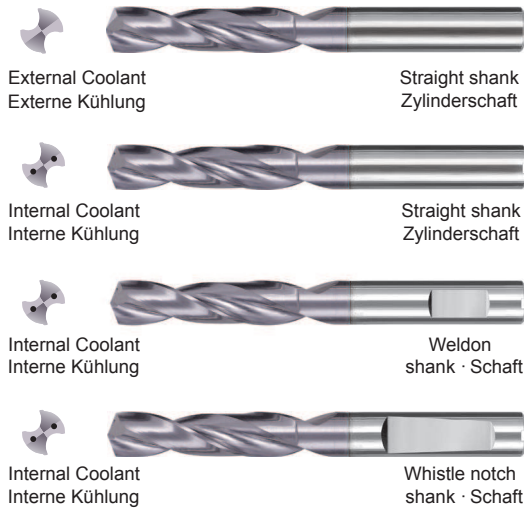
Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2(h6)	l1	l2	l3	l4		
11.3	3	External Extern	Straight shank Zylinderschaft	1534SU03-1130	12	102	55	40	45	●	
	5			1536SU05-1130	12	118	71	56	45	●	
	3	Internal Intern	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			1538SU08C-1130	12	162	114	99	45	●	
	3			External Extern	Straight shank Zylinderschaft	1534SU03-1135	12	102	55	40	45
5	1536SU05-1135	12	118			71	56	45	○		
3	Internal Intern	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	○	
8			Internal Intern		Straight shank Zylinderschaft	1534SU03-1140	12	102	55	40	45
5	1536SU05-1140	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 Zylinderschaft	1538SU08C-1140	12	162	114	99	45	●
3					External Extern	1534SU03-1145	12	102	55	40	45
5	1536SU05-1145	12	118	71		56	45	○			

Drilling - Bohren

Solid Carbide drills - Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d ₂ (h6)	l ₁	l ₂	l ₃	l ₄		
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		Weldon shank/ Schaft	1634SU03C-1150	12	102	55	40	45	●	
	5			1636SU05C-1150	12	118	71	56	45	●	
	3	Internal Intern	Whistle notch shank/ Schaft	1734SU03C-1150	12	102	55	40	45	●	
	5			1736SU05C-1150	12	118	71	56	45	●	
	8	External Extern	Straight shank Zylinder- schaft	1538SU08C-1150	12	162	114	99	45	●	
	3			1534SU03-1160	12	102	55	40	45	●	
	11.6	5	Internal Intern	Weldon shank/ Schaft	1636SU05C-1160	12	118	71	56	45	●
		3			1734SU03C-1160	12	102	55	40	45	●
5		Whistle notch shank/ Schaft		1736SU05C-1160	12	118	71	56	45	●	
3				1538SU08C-1160	12	162	114	99	45	●	
3		External Extern	Straight shank Zylinder- schaft	1534SU03-1170	12	102	55	40	45	●	
5				1536SU05-1170	12	118	71	56	45	●	
11.7		3	Internal Intern	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	External Extern	Straight shank Zylinder- schaft	1538SU08C-1170	12	162	114	99	45	●	
	3			1534SU03-1180	12	102	55	40	45	●	
	11.8	5	Internal Intern	Weldon shank/ Schaft	1634SU03C-1180	12	102	55	40	45	●
		3			1636SU05C-1180	12	118	71	56	45	●
3		External Extern	Straight shank Zylinder- schaft	1534SU03C-1180	12	102	55	40	45	●	
5				1536SU05C-1180	12	118	71	56	45	●	
3		Internal Intern	Weldon shank/ Schaft	1634SU03C-1180	12	102	55	40	45	●	
5				1636SU05C-1180	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.
~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



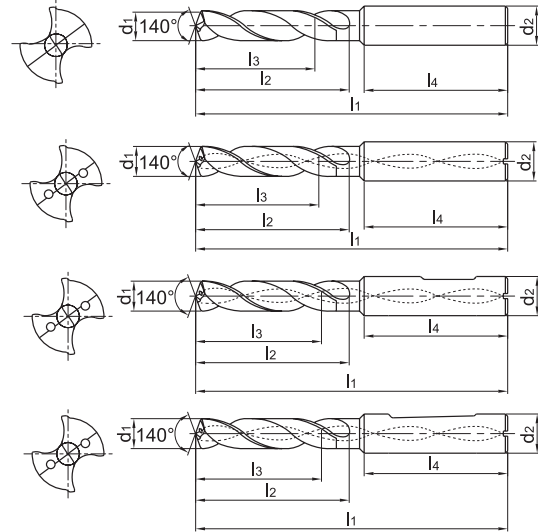
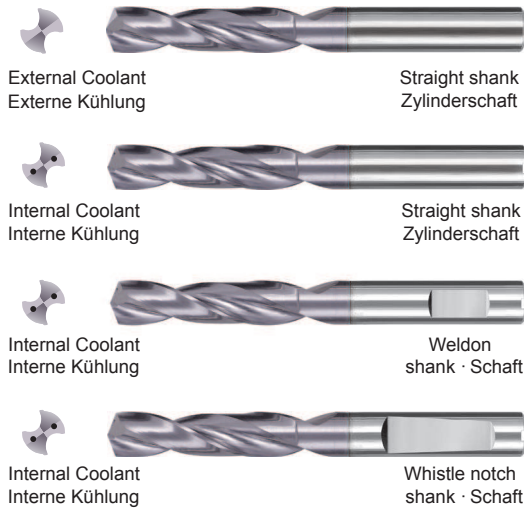
Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1 (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2 (h6)	l1	l2	l3	l4		
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			1538SU08C-1180	12	162	114	99	45	●	
11.9	3	External Extern	Straight shank Zylinder- schaft	1534SU03-1190	12	102	55	40	45	●	
	5			1536SU05-1190	12	118	71	56	45	●	
	3			1534SU03C-1190	12	102	55	40	45	●	
	5	1536SU05C-1190	12	118	71	56	45	●			
	3	Internal Intern	Weldon shank/ Schaft	1634SU03C-1190	12	102	55	40	45	●	
	5			1636SU05C-1190	12	118	71	56	45	●	
3	1734SU03C-1190			12	102	55	40	45	●		
12.0	5	Whistle notch shank/ Schaft	Whistle notch shank/ Schaft	1736SU05C-1190	12	118	71	56	45	●	
	8			1538SU08C-1190	12	162	114	99	45	●	
	3			External Extern	Straight shank Zylinder- schaft	1534SU03-1200	12	102	55	40	45
	5	1536SU05-1200	12			118	71	56	45	●	
	3	1534SU03C-1200	12			102	55	40	45	●	
	12.1	5	Internal Intern	Weldon shank/ Schaft	1536SU05C-1200	12	118	71	56	45	●
		3			1634SU03C-1200	12	102	55	40	45	●
		5			1636SU05C-1200	12	118	71	56	45	●
		3	Whistle notch shank/ Schaft	Whistle notch shank/ Schaft	1734SU03C-1200	12	102	55	40	45	●
		5			1736SU05C-1200	12	118	71	56	45	●
8		1538SU08C-1200			12	162	114	99	45	●	
12.1		3	External Extern	Straight shank Zylinder- schaft	1534SU03-1210	14	107	60	43	45	●
		5			1536SU05-1210	14	124	77	60	45	●
	3	1534SU03C-1210			14	107	60	43	45	●	
	5	Internal Intern	Weldon shank/ Schaft	1536SU05C-1210	14	124	77	60	45	●	
	3			1634SU03C-1210	14	107	60	43	45	●	
	5			1636SU05C-1210	14	124	77	60	45	●	
	3	Whistle notch shank/ Schaft	Whistle notch shank/ Schaft	1734SU03C-1210	14	107	60	43	45	●	
	5			1736SU05C-1210	14	124	77	60	45	●	

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	Internal Intern	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	Internal Intern	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	Internal Intern	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

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✓ = 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.
KDG303	✓	✓	✓			✓	✓	✓		

Code key C 10
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

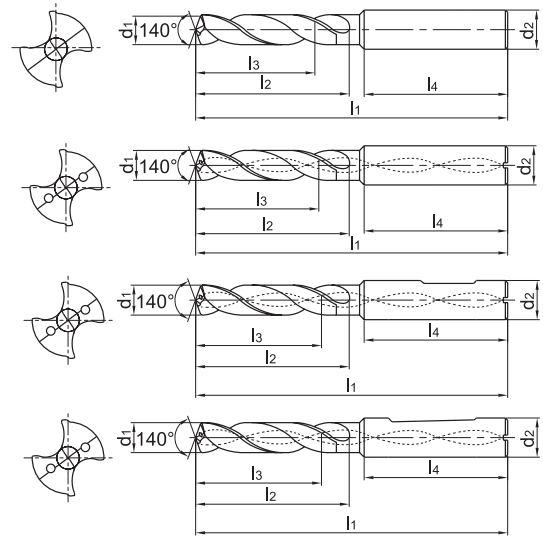
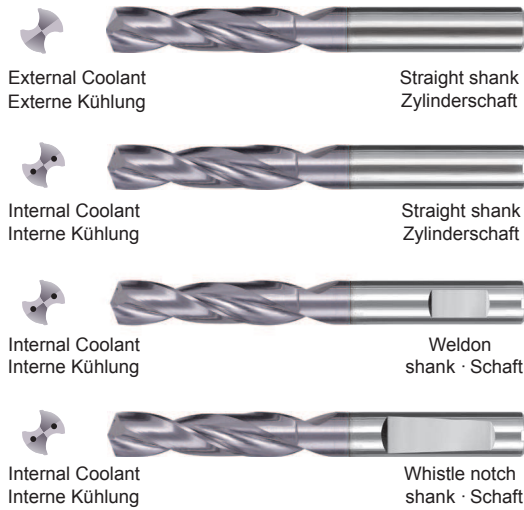
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



- For high efficient drilling of P (steel), M (stainless steel) and K (cast iron) with high performance.
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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2(h6)	l1	l2	l3	l4		
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	Zylinder-schaft	1534SU03C-1250	14	107	60	43	45	●	
	5			1536SU05C-1250	14	124	77	60	45	●	
	3		Weldon shank/Schaft	1634SU03C-1250	14	107	60	43	45	●	
	5			1636SU05C-1250	14	124	77	60	45	●	
	3			Whistle notch shank/Schaft	1734SU03C-1250	14	107	60	43	45	●
	5				1736SU05C-1250	14	124	77	60	45	●
8			1538SU08C-1250	14	178	133	116	45	●		
12.7	3	External Extern	Straight shank Zylinderschaft	1534SU03-1270	14	107	60	43	45	●	
	5			1536SU05-1270	14	124	77	60	45	●	
	3	Internal Intern	Zylinder-schaft	1534SU03C-1270	14	107	60	43	45	●	
	5			1536SU05C-1270	14	124	77	60	45	●	
3	Weldon shank/Schaft		1634SU03C-1270	14	107	60	43	45	●		
5			1636SU05C-1270	14	124	77	60	45	●		
3	Whistle notch shank/Schaft	1734SU03C-1270	14	107	60	43	45	●			
5		1736SU05C-1270	14	124	77	60	45	●			
8				1538SU08C-1270	14	178	133	116	45	●	
12.75	3	External Extern	Straight shank Zylinderschaft	1534SU03-1275	14	107	60	43	45	●	
	5			1536SU05-1275	14	124	77	60	45	●	
	3	Internal Intern	Zylinder-schaft	1534SU03C-1275	14	107	60	43	45	●	
	5			1536SU05C-1275	14	124	77	60	45	●	
	3		Weldon shank/Schaft	1634SU03C-1275	14	107	60	43	45	○	
	5			1636SU05C-1275	14	124	77	60	45	○	
	3			Weldon shank/Schaft	1734SU03C-1275	14	107	60	43	45	●
	5				1736SU05C-1275	14	124	77	60	45	●

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	Internal Intern	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	External Extern	Straight shank	1538SU08C-1280	14	178	133	116	45	●	
3			13.0	Zylinder- schaft	1534SU03-1300	14	107	60	43	45
5	1536SU05-1300	14			124	77	60	45	●	
3	Internal Intern	Weldon shank/ Schaft		1534SU03C-1300	14	107	60	43	45	●
5				1536SU05C-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	External Extern	Straight shank		1538SU08C-1300	14	178	133	116	45	●
3				13.1	Zylinder- schaft	1534SU03-1310	14	107	60	43
5	1536SU05-1310	14	124			77	60	45	●	
3	Internal Intern	Weldon shank/ Schaft	1534SU03C-1310		14	107	60	43	45	●
5			1536SU05C-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	●
3	External Extern	Straight shank	1534SU03-1335		16	107	60	43	45	○
5			13.35		Zylinder- schaft	1536SU05-1335	16	124	77	60
3	Internal Intern	Weldon shank/ Schaft		1534SU03C-1335		16	107	60	43	45
5				1536SU05C-1335	16	124	77	60	56	○
3		Whistle notch shank/ Schaft		1634SU03C-1335	16	107	60	43	45	○
5				1636SU05C-1335	16	124	77	60	56	○
3	External Extern	Straight shank		1734SU03C-1335	16	107	60	43	45	○
5				1736SU05C-1335	16	124	77	60	56	○



Solid Carbide drills
Vollhartmetallbohrer

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
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

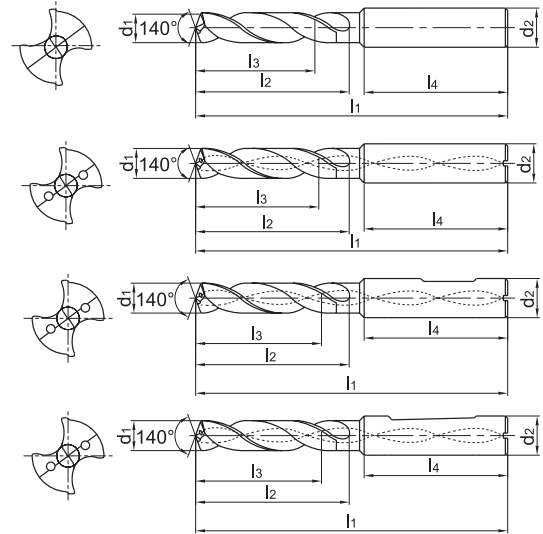
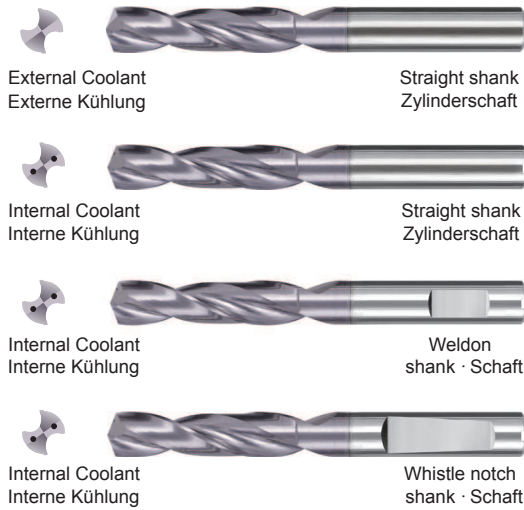
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
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			1538SU08C-1350	14	178	133	116	45	●	
13.8	3	External Extern	Straight shank	1534SU03-1380	14	107	60	43	45	●
	5			1536SU05-1380	14	124	77	60	45	●
	3	Internal Intern	Zylinder- schaft	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	●

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (mm)	Drilling depth Bohrtiefe (L/d ₁)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte		
					Shank diameter 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	Internal Intern	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	External Extern	Straight shank	1538SU08C-1400	14	178	133	116	45	●			
3			Internal Intern	Zylinder- schaft	1534SU03-1420	14	107	60	43	45	●	
5					1536SU05-1420	14	124	77	60	45	●	
3			Internal Intern	Weldon shank/ Schaft	1534SU03C-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	1534SU03-1425	16	115	65	45	48	●
	5	1536SU05-1425	16			133	83	63	48	●		
	3	Internal Intern	Zylinder- schaft	1534SU03C-1425	16	115	65	45	48	●		
	5			1536SU05C-1425	16	133	83	63	48	●		
	3	Internal Intern	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	1534SU03-1430	16	115	65	45	48	●		
	5			1536SU05-1430	16	133	83	63	48	●		
	3	Internal Intern	Zylinder- schaft	1534SU03C-1430	16	115	65	45	48	●		
	5			1536SU05C-1430	16	133	83	63	48	●		
	3	Internal Intern	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	●	



Solid Carbide drills
Vollhartmetallbohrer

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

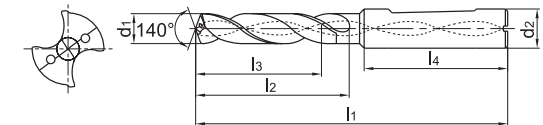
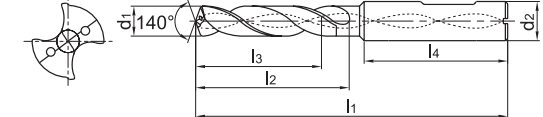
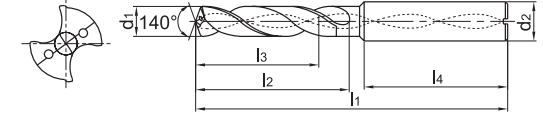
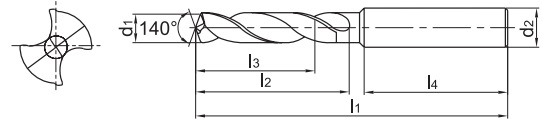
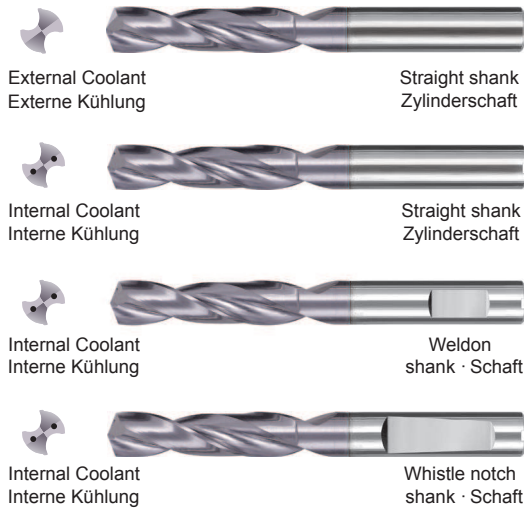
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
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	External Extern	Straight shank Zylinder- schaft	1538SU08C-1450	16	204	152	132	48	●	
3			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	●	

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	Internal Intern	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			1538SU08C-1480	16	204	152	132	48	●	
15.0	3	External Extern	Straight shank	1534SU03-1500	16	115	65	45	48	●
	5			1536SU05-1500	16	133	83	63	48	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-1500	16	115	65	45	48	●
	5			1536SU05C-1500	16	133	83	63	48	●
	3	Internal Intern	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			1538SU08C-1500	16	204	152	132	48	●	
15.1	3	External Extern	Straight shank	1534SU03-1510	16	115	65	45	48	●
	5			1536SU05-1510	16	133	83	63	48	●
	3	Internal Intern	Zylinder- schaft	1534SU03C-1510	16	115	65	45	48	●
	5			1536SU05C-1510	16	133	83	63	48	●
	3	Internal Intern	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	1534SU03-1530	16	115	65	45	48	●
	5	Internal Intern		1536SU05C-1530	16	133	83	63	48	●
15.35	3	External Extern	Straight shank	1534SU03-1535	16	115	65	45	48	○
	5			1536SU05-1535	16	133	83	63	48	○
	3	Internal Intern	Zylinder- schaft	1534SU03C-1535	16	115	65	45	48	○
	5			1536SU05C-1535	16	133	83	63	48	○
	3	Internal Intern	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	○



Solid Carbide drills
Vollhartmetallbohrer

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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.
KDG303	✓	✓	✓			✓	✓	✓		

Code key C 10
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

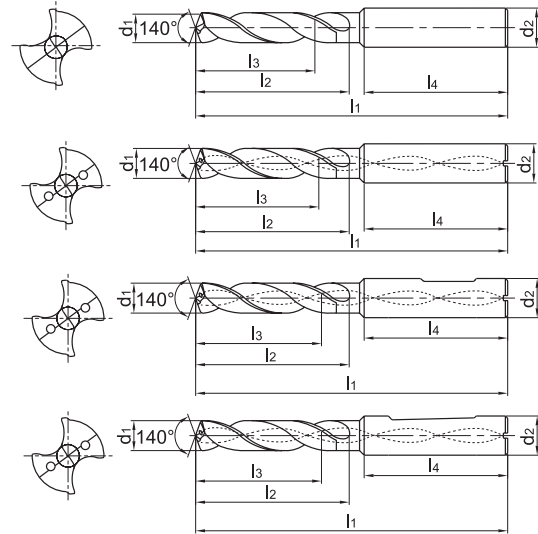
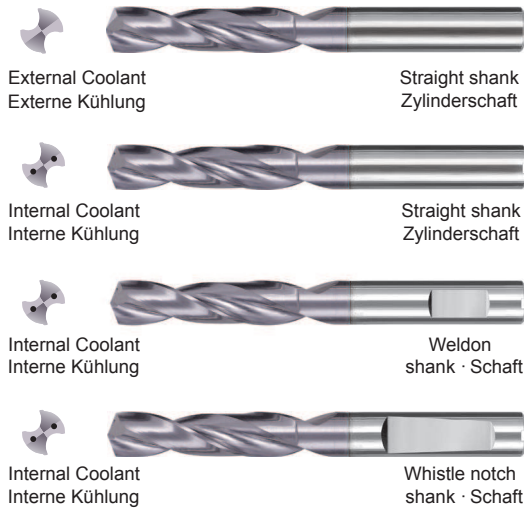
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2(h6)	l1	l2	l3	l4		
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				1538SU08C-1550	16	204	152	132	48	●	
15.8	3		External Extern	Straight shank	1534SU03-1580	16	115	65	45	48	●
	5	1536SU05-1580			16	133	83	63	48	●	
	3	Internal Intern	Zylinder- schaft	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	Zylinder- 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				1538SU08C-1600	16	204	152	132	48	●	
16.1	3		External Extern	Straight shank Zylinder- schaft	1534SU03-1610	18	123	73	51	48	●

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d ₂ (h6)	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			1538SU08C-1650	18	223	171	149	48	●		
16.75	3		External Extern	Straight shank	1534SU03-1675	18	123	73	51	48	●
	5	1536SU05-1675			18	143	93	71	48	●	
	3	Internal Intern	Zylinder- schaft	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	1534SU03-1680	18	123	73	51	48	●
	5				1536SU05-1680	18	143	93	71	48	●
	3	Internal Intern	Zylinder- schaft	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	1534SU03-1700	18	123	73	51	48	●
	5				1536SU05-1700	18	143	93	71	48	●
	3	Internal Intern	Zylinder- schaft	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	●	



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			~40HRC	~50HRC	~60HRC						
KDG303	✓	✓	✓			✓	✓	✓			

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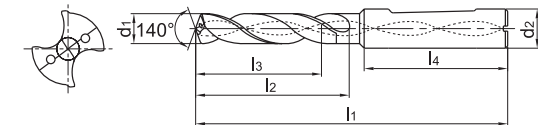
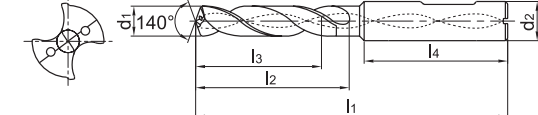
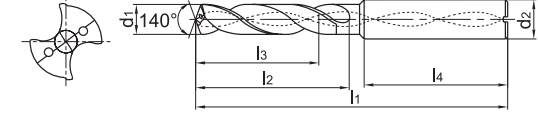
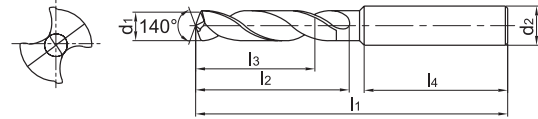
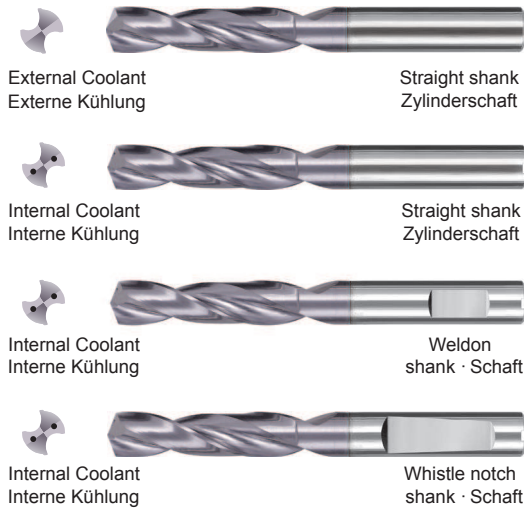
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Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte	
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge		
					d2(h6)	l1	l2	l3	l4		
17.5	3	External Extern	Straight shank	1534SU03-1750	18	123	73	51	48	●	
	5			1536SU05-1750	18	143	93	71	48	●	
	3	Internal Intern	Zylinder- schaft	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			1538SU08C-1750	18	223	171	149	48	●		
17.8	3		External Extern	Straight shank	1534SU03-1780	18	123	73	51	48	●
	5	1536SU05-1780			18	143	93	71	48	●	
	3	Internal Intern	Zylinder- schaft	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	1534SU03-1800	18	123	73	51	48	●
	5				1536SU05-1800	18	143	93	71	48	●
	3	Internal Intern	Zylinder- schaft	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	●	

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

Drill diameter Bohrer Ø d ₁ (m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d ₂ (h6)	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	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1850	20	131	79	55	50	●
	5			1536SU05C-1850	20	153	101	77	50	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1850	20	131	79	55	50	●
	5			1636SU05C-1850	20	153	101	77	50	●
	3	External Extern	Straight shank	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	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1880	20	131	79	55	50	●
	5			1536SU05C-1880	20	153	101	77	50	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1880	20	131	79	55	50	●
	5			1636SU05C-1880	20	153	101	77	50	●
	3	External Extern	Straight shank	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	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1900	20	131	79	55	50	●
	5			1536SU05C-1900	20	153	101	77	50	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1900	20	131	79	55	50	●
	5			1636SU05C-1900	20	153	101	77	50	●
	3	External Extern	Straight shank	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	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1950	20	131	79	55	50	●
	5			1536SU05C-1950	20	153	101	77	50	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1950	20	131	79	55	50	●
	5			1636SU05C-1950	20	153	101	77	50	●
	3	External Extern	Straight shank	1734SU03C-1950	20	131	79	55	50	●
	5			1736SU05C-1950	20	153	101	77	50	●
19.8	3	External Extern	Straight shank	1534SU03-1980	20	131	79	55	50	●
	5			1536SU05-1980	20	153	101	77	50	●
	3	Zylinder- schaft	Weld on shank/ Schaft	1534SU03C-1980	20	131	79	55	50	●
	5			1536SU05C-1980	20	153	101	77	50	●
	3	Internal Intern	Whistle notch shank/ Schaft	1634SU03C-1980	20	131	79	55	50	●
	5			1636SU05C-1980	20	153	101	77	50	●
	3	External Extern	Straight shank	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 HBs180	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.
~40HRC			~50HRC	~60HRC						
KDG303	✓	✓	✓			✓	✓	✓		

Code key C 10
ISO Kennzeichen

Cutting data 96-109
Schnittdaten

Technical Information C110-116
Technische Information

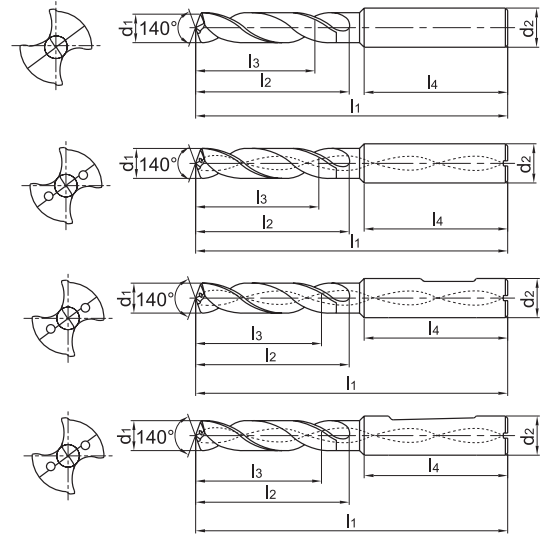
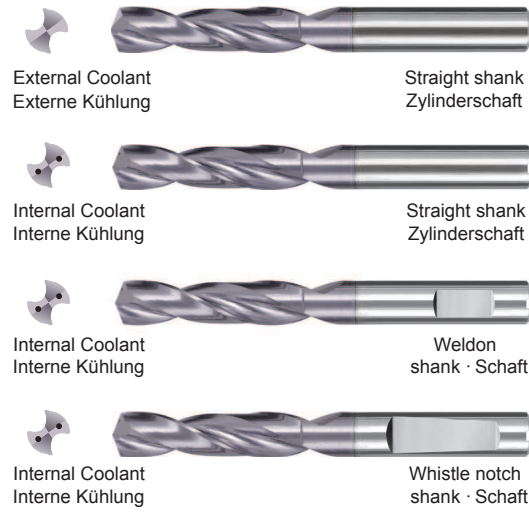
Non-standard tailor made C 117-121
Bestellformular für Sonderwerkzeuge

Drilling · Bohren

Solid Carbide drills · Vollhartmetallbohrer

SU series · SU Serie

General machining · Allgemeine Bearbeitung



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

Drill diameter Bohrer Ø d1(m7)	Drilling depth Bohrtiefe (L/d1)	Cooling mode Kühlmittel.	Shank Schaft	Type Typ	Basic dimension(mm) · Basis Abmessungen					Grade Sorte KDG303
					Shank diameter Ø Schaftdurchmesser	Overall length Gesamtlänge	Flute length Nutenlänge	effective drill. length Effektive Nutzlänge	Shank length Schaftlänge	
					d2(h6)	l1	l2	l3	l4	
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	Internal Intern	Weldon shank/ Schaft	1634SU03C-2000	20	131	79	55	50	●
	5			1636SU05C-2000	20	153	101	77	50	●
	3	Internal Intern	Whistle notch shank/ Schaft	1734SU03C-2000	20	131	79	55	50	●
	5			1736SU05C-2000	20	153	101	77	50	●

Solid Carbide drills
Vollhartmetallbohrer

Drilling · Bohren

Recommended cutting data · Schnittdatenempfehlung

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

3D

5D

Workpiece material Werkstückstoff	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 Kugelgraphitguss		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 Werkstückstoff	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 Kugelgraphitguss		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

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3. Keine defekte Werkzeugaufnahme wählen. Die Rundlaufgenauigkeit muss unter 0,02mm liegen.
4. Die obigen Schnittdaten sind für Bohrungstiefen unter 5xD ausgelegt.

