



WORM PATTERN DRILLS

DL600 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT

EXTRA LONG

ÜBERLANG

► **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

► **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



DIN 1869/1

HSS-E

38°

h8

130°



P.157

► DH100 worm pattern drills

Unit : mm

EDP No.	Drill Diameter	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter	Flute Length L1	Overall Length L2
	D1				D1		
DL600020	2.0	85	125	DL600070	7.0	155	225
DL600922	2.25	90	135	DL600972	7.25	155	225
DL600025	2.5	95	140	DL600075	7.5	155	225
DL600927	2.75	100	150	DL600977	7.75	165	240
DL600030	3.0	100	150	DL600080	8.0	165	240
DL600932	3.25	105	155	DL600982	8.25	165	240
DL600035	3.5	115	165	DL600085	8.5	165	240
DL600937	3.75	115	165	DL600987	8.75	175	250
DL600040	4.0	120	175	DL600090	9.0	175	250
DL600942	4.25	120	175	DL600992	9.25	175	250
DL600045	4.5	125	185	DL600095	9.5	175	250
DL600947	4.75	125	185	DL600997	9.75	185	265
DL600050	5.0	135	195	DL600100	10.0	185	265
DL600952	5.25	135	195	DL600105	10.5	185	265
DL600055	5.5	140	205	DL600110	11.0	195	280
DL600957	5.75	140	205	DL600115	11.5	195	280
DL600060	6.0	140	205	DL600120	12.0	205	295
DL600962	6.25	150	215	DL600125	12.5	205	295
DL600065	6.5	150	215	DL600130	13.0	205	295
DL600967	6.75	155	225				

► TiN(DN600), TiCN(DX600) and TiAlN(DT600) are available on your request.

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎				○	○			○		

CARBIDE

HSS

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA



WORM PATTERN DRILLS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

HSS-E, DH100 TYPE WORM PATTERN DRILLS, DIN1897, DIN338, DIN340, DIN1869, DIN341, DIN1870
HSS-E, DH100 TYPE WORM PATTERN SPIRALBOHRER, DIN1897, DIN 338, DIN 340, DIN 1869, DIN 341, DIN 1870

DL510, DL508, DL509, DL505, DL504, DL600, DL608, DL609, DL610 SERIES

Unit : mm

WORK MATERIAL	CARBON STEELS ALLOY STEELS		TOOL STEELS HARDENED STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
	HRc15 ~ 30		HRc20 ~ 40					
HARDNESS	700 ~ 1000 N/mm ²		800 ~ 1200 N/mm ²					
STRENGTH								
DIAMETER	N	S	N	S	N	S	N	S
2.0	2630	0.03	2100	0.025	4200	0.06	1680	0.05
2.5	2100	0.04	1680	0.03	3300	0.08	1310	0.06
3.0	1680	0.05	1310	0.04	2630	0.10	1050	0.08
4.0	1310	0.06	1050	0.05	2100	0.13	840	0.10
5.0	1050	0.06	840	0.05	1680	0.13	660	0.10
6.0	840	0.08	660	0.06	1310	0.16	530	0.13
8.0	660	0.10	530	0.08	1050	0.20	420	0.17
10.0	530	0.13	420	0.10	840	0.25	330	0.21
13.0	420	0.13	330	0.10	660	0.25	260	0.21
16.0	330	0.15	260	0.13	530	0.30	210	0.25
20.0	260	0.20	210	0.15	420	0.40	170	0.30
25.0	210	0.25	170	0.20	330	0.50	130	0.50
30.0	170	0.25	130	0.20	260	0.50	110	0.50

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

HSS-E, DH50 TYPE WORM PATTERN DRILLS HSS-E, DH50 TYPE WORM PATTERN SPIRALBOHRER

DL507 SERIES

Unit : mm

WORK MATERIAL	CARBON STEELS ALLOY STEELS		SOFT GREY CAST IRON		ALUMINUM ALLOY	
	HRc15 ~ 30					
HARDNESS	700 ~ 1000 N/mm ²					
STRENGTH						
DIAMETER	N	S	N	S	N	S
2.0	2630	0.03	4200	0.06	8700	0.04
2.5	2100	0.04	3300	0.08	6950	0.05
3.0	1680	0.05	2630	0.10	5800	0.06
4.0	1310	0.06	2100	0.13	4300	0.08
5.0	1050	0.06	1680	0.13	3500	0.10
6.0	840	0.08	1310	0.16	2900	0.12
8.0	660	0.10	1050	0.20	2200	0.16
10.0	530	0.13	840	0.25	1750	0.20
13.0	420	0.13	660	0.25	1350	0.26

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