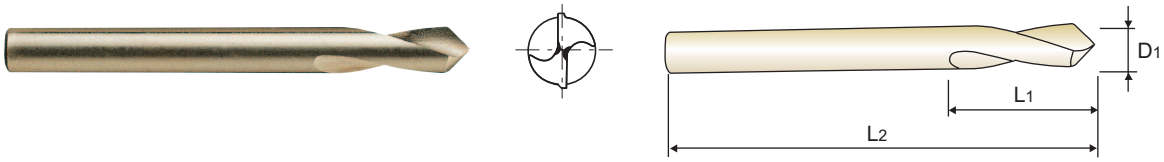
NC-SPOTTING DRILLS

D2306 SERIES
D2307 SERIES

HSSCo8, NC-SPOTTING DRILLS
HSSCo8, NC-ANBOHRER

▶ **Application** : For more precise centering work on NC/CNC Machines.
The large diameter of the tool permits chamfering work after centering continuously.

▶ **Verwendung** : Für positionsgenaues und schnelles Anbohren mit NC/CNC-Maschinen und Bearbeitungszentren, die Ausführung mit Spitzenwinkel 90° ermöglicht sowohl ein Zentrieren, als auch das Vorbohren für einen nächstgrößeren Durchmesser.



NC | HSS Co8 | h6 | h6 | 90° | 120° P.207

NC-Anbohrer 90°
NC-Spotting drills 90°

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2306030	3.0	12	46
D2306040	4.0	12	55
D2306050	5.0	15	60
D2306060	6.0	20	66
D2306080	8.0	25	79
D2306100	10.0	25	89
D2306120	12.0	30	102
D2306160	16.0	35	115
D2306200	20.0	40	131

NC-Anbohrer 120°
NC-Spotting drills 120°

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2307030	3.0	12	46
D2307040	4.0	12	55
D2307050	5.0	15	60
D2307060	6.0	20	66
D2307080	8.0	25	79
D2307100	10.0	25	89
D2307120	12.0	30	102
D2307160	16.0	35	115
D2307200	20.0	40	131

▶ TiN(D4306, D4307), TiCN(D7306, D7307) and TiAlN(DQ306, DQ307) 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~							
◎	◎					○	○		○		○

HSSCo8, NC-SPOTTING DRILLS 90°, 120°
HSSCo8, NC-ANBOHRER 90°, 120°

D2306, D2307 SERIES

Unit : mm

WORK MATERIAL	CARBON STEELS		ALLOY STEELS		ALLOY STEELS, TOOL STEELS, HARDENED STEELS		STAINLESS STEELS		ALUMINUM, ALUMINUM ALLOYS	
DIAMETER	N	S	N	S	N	S	N	S	N	S
3	2460	0.06	2110	0.06	1080	0.06	940	0.06	7040	0.14
4	1850	0.07	1580	0.07	800	0.07	700	0.07	5280	0.15
5	1510	0.08	1300	0.08	670	0.08	580	0.08	4400	0.17
6	1170	0.09	1030	0.09	540	0.09	460	0.09	3520	0.19
8	880	0.11	790	0.11	400	0.11	350	0.11	2640	0.22
10	700	0.12	630	0.12	320	0.12	290	0.12	2110	0.25
12	590	0.14	530	0.14	260	0.14	240	0.14	1760	0.28
16	460	0.20	400	0.20	200	0.20	180	0.20	1320	0.33
20	350	0.24	320	0.24	150	0.24	140	0.24	1060	0.45

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