



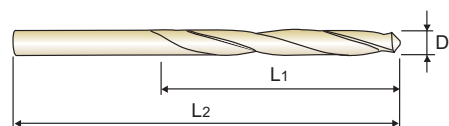
HSS, STRAIGHT SHANK TWIST DRILLS for BRASS

JOBBER

HSS, SPIRALBOHRER für HOHE LEISTUNGEN mit ZYLINDERSCHAFT **KURZ**

► **Application** : Drilling hard, brittle and short-chip materials. i.e., brass, bronze, phosphor bronze and magnesium alloys.

► **Verwendung** : Zum Bohren von harten und spröden Werkstoffen wie Messing, Magnesium-Legierungen, Bronze, Phosphorbronze.


DIN 338
HSS
N 15~20°
h8
118°


P.189

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D1100015	1.5	18	40	D1100043	4.3	47	80
D1100016	1.6	20	43	D1100044	4.4	47	80
D1100017	1.7	20	43	D1100045	4.5	47	80
D1100018	1.8	22	46	D1100046	4.6	47	80
D1100019	1.9	22	46	D1100047	4.7	47	80
D1100020	2.0	24	49	D1100048	4.8	52	86
D1100021	2.1	24	49	D1100049	4.9	52	86
D1100022	2.2	27	53	D1100050	5.0	52	86
D1100023	2.3	27	53	D1100051	5.1	52	86
D1100024	2.4	30	57	D1100052	5.2	52	86
D1100025	2.5	30	57	D1100053	5.3	52	86
D1100026	2.6	30	57	D1100054	5.4	57	93
D1100027	2.7	33	61	D1100055	5.5	57	93
D1100028	2.8	33	61	D1100056	5.6	57	93
D1100029	2.9	33	61	D1100057	5.7	57	93
D1100030	3.0	33	61	D1100058	5.8	57	93
D1100031	3.1	36	65	D1100059	5.9	57	93
D1100032	3.2	36	65	D1100060	6.0	57	93
D1100033	3.3	36	65	D1100061	6.1	63	101
D1100034	3.4	39	70	D1100062	6.2	63	101
D1100035	3.5	39	70	D1100063	6.3	63	101
D1100036	3.6	39	70	D1100064	6.4	63	101
D1100037	3.7	39	70	D1100065	6.5	63	101
D1100038	3.8	43	75	D1100066	6.6	63	101
D1100039	3.9	43	75	D1100067	6.7	63	101
D1100040	4.0	43	75	D1100068	6.8	69	109
D1100041	4.1	43	75	D1100069	6.9	69	109
D1100042	4.2	43	75	D1100070	7.0	69	109

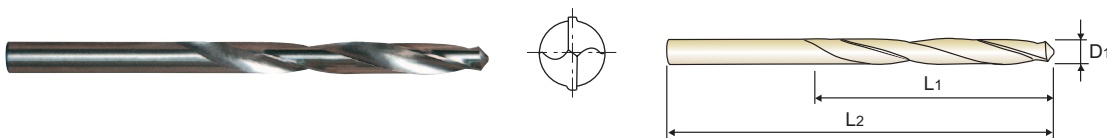
◎ : Excellent ○ : Good

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~							
											◎

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Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D1100071	7.1	69	109	D1100089	8.9	81	125
D1100072	7.2	69	109	D1100090	9.0	81	125
D1100073	7.3	69	109	D1100091	9.1	81	125
D1100074	7.4	69	109	D1100092	9.2	81	125
D1100075	7.5	69	109	D1100093	9.3	81	125
D1100076	7.6	75	117	D1100094	9.4	81	125
D1100077	7.7	75	117	D1100095	9.5	81	125
D1100078	7.8	75	117	D1100096	9.6	87	133
D1100079	7.9	75	117	D1100097	9.7	87	133
D1100080	8.0	75	117	D1100098	9.8	87	133
D1100081	8.1	75	117	D1100099	9.9	87	133
D1100082	8.2	75	117	D1100100	10.0	87	133
D1100083	8.3	75	117	D1100105	10.5	87	133
D1100084	8.4	75	117	D1100110	11.0	94	142
D1100085	8.5	75	117	D1100115	11.5	94	142
D1100086	8.6	81	125	D1100120	12.0	101	151
D1100087	8.7	81	125	D1100125	12.5	101	151
D1100088	8.8	81	125	D1100130	13.0	101	151

◎ : 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~							
											◎

HSS, TWIST DRILLS for BRASS, DIN 338
HSS, SPIRALBOHRER für MESSING, DIN338
D1100 SERIES

Unit : mm

WORK MATERIAL	BRASS	
DIAMETER	N	S
2	8750	0.08
3	5850	0.10
4	4400	0.12
5	3500	0.14
6	2900	0.16
7	2500	0.18
8	2200	0.20
9	1950	0.22
10	1750	0.25
11	1600	0.27
12	1450	0.29
13	1350	0.32

N = R.P.M

S = Feed per Revolution (mm/rev.)

HSS, TWIST DRILLS for ALUMINUM, DIN338
HSS, SPIRALBOHRER für ALUMINIUM, DIN338
D1106 SERIES

Unit : mm

WORK MATERIAL	LONG CHIP ALUMINUM ALLOYS		SHORT CHIP ALUMINUM ALLOYS	
DIAMETER	N	S	N	S
2	7950	0.08	5550	0.06
3	5300	0.10	3700	0.07
4	4000	0.12	2800	0.08
5	3200	0.14	2230	0.09
6	2650	0.16	1850	0.10
7	2250	0.18	1600	0.11
8	2000	0.20	1400	0.12
9	1750	0.22	1250	0.14
10	1600	0.25	1100	0.16
11	1450	0.28	1000	0.18
12	1330	0.32	930	0.20
13	1220	0.35	860	0.22

N = R.P.M

S = Feed per Revolution (mm/rev.)