



MORSE TAPER SHANK DRILLS

D1206 SERIES

HSS, MORSE TAPER SHANK TWIST DRILLS

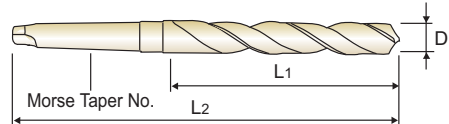
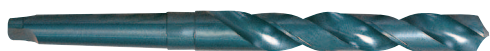
LONG

HSS, SPIRALBOHRER mit MORSEKEGELSCHAFT

LANG

► **Surface treatment** : Steam Tempered(Black Oxide Finish)
 ► **Application** : Drilling deep holes in steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron, graphite.

► **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)
 ► **Verwendung** : Für Bohrungen mit Bohrbuchsen oder an tief liegenden Stellen.
 Zum Bohren von Stahl und Stahlguß, Grauß, Temperguß, Sphäroguß, Sintereisen, Neusilber und Graphit.



DIN 341
HSS
N 20~30°
1~3
h8
118°
P.202

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	No. of Morse Taper	EDP No.	Drill Diameter	Flute Length	Overall Length	No. of Morse Taper
	D1	L1	L2			D1	L1	L2	
D1206130	13.0	134	215	1	D1206195	19.5	177	275	2
D1206135	13.5	142	223	1	D1206200	20.0	177	275	2
D1206140	14.0	142	223	1	D1206210	21.0	184	282	2
D1206145	14.5	147	245	2	D1206220	22.0	191	289	2
D1206150	15.0	147	245	2	D1206230	23.0	198	296	2
D1206155	15.5	153	251	2	D1206240	24.0	206	327	3
D1206160	16.0	153	251	2	D1206250	25.0	206	327	3
D1206165	16.5	159	257	2	D1206260	26.0	214	335	3
D1206170	17.0	159	257	2	D1206270	27.0	222	343	3
D1206175	17.5	165	263	2	D1206280	28.0	222	343	3
D1206180	18.0	165	263	2	D1206290	29.0	230	351	3
D1206185	18.5	171	269	2	D1206300	30.0	230	351	3
D1206190	19.0	171	269	2					

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 DRILLS DIN345, DIN341, DIN1870
HSS SPIRALBOHRER DIN 345, DIN 341, DIN 1870
D1205, D1206, D1209, D1210 SERIES

Unit : mm

WORK MATERIAL	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS		STAINLESS STEELS		TITANIUM ALLOYS	
			~ HRC23		~ HRC23 ~ 28		HRC23 ~ 34		HRC34 ~ 38		HRC23			
HARDNESS														
STRENGTH	~ 570 N/mm ²		~ 830 N/mm ²		830 ~ 950 N/mm ²		830 ~ 1110 N/mm ²		1110 ~ 1260 N/mm ²		830 N/mm ²		410 N/mm ²	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S
13	645	0.17	480	0.17	370	0.09	440	0.20	265	0.05	480	0.17	265	0.09
19	440	0.23	330	0.23	255	0.13	300	0.23	180	0.05	330	0.23	180	0.13
32	260	0.28	195	0.28	145	0.18	180	0.18	107	0.08	195	0.28	107	0.18
50	165	0.33	125	0.33	93	0.20	115	0.20	68	0.08	125	0.33	68	0.20
60	140	0.40	105	0.40	78	0.23	95	0.23	57	0.10	105	0.40	57	0.23

WORK MATERIAL	TOOL STEELS		CAST IRON		ALUMINUM ALLOYS		MAGNESIUM ALLOYS		ZINC ALLOYS		PLASTICS	
			~ HRC21									
HARDNESS												
STRENGTH	~ 270 N/mm ²		~ 800 N/mm ²									
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
13	645	0.17	480	0.17	1200	0.26	1600	0.26	1200	0.26	645	0.17
19	440	0.23	330	0.23	820	0.30	1100	0.30	820	0.30	440	0.23
32	240	0.30	195	0.28	490	0.38	660	0.38	490	0.38	260	0.28
50	150	0.43	125	0.33	310	0.46	415	0.46	310	0.46	165	0.33
60	125	0.48	105	0.40	260	0.50	345	0.50	260	0.50	140	0.40

N = R.P.M

S = Feed per Revolution (mm/rev.)