



MORSE TAPER SHANK DRILLS

D1205 SERIES

HSS, MORSE TAPER SHANK TWIST DRILLS

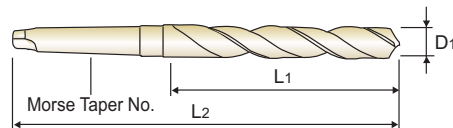
JOBBER

HSS, SPIRALBOHRER mit MORSEKEGELSCHAFT

KURZ

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

- **Oberflächenbehandlung** : Steam Homo(Schwarzoxidation)
 ► **Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sinter Eisen, Graphit.


DIN 345
HSS

 N
20~30°

1~5

h8

118°



P.202

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	No. of Morse Taper	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	No. of Morse Taper
D1205130	13.0	101	182	1	D1205205	20.5	145	243	2
D1205132	13.2	101	182	1	D120520B	20.75	145	243	2
D120513A	13.25	108	189	1	D1205210	21.0	145	243	2
D1205135	13.5	108	189	1	D120521A	21.25	150	248	2
D120513B	13.75	108	189	1	D1205215	21.5	150	248	2
D1205138	13.8	108	189	1	D120521B	21.75	150	248	2
D1205140	14.0	108	189	1	D1205220	22.0	150	248	2
D120514A	14.25	114	212	2	D120522A	22.25	150	248	2
D1205145	14.5	114	212	2	D1205225	22.5	155	253	2
D120514B	14.75	114	212	2	D120522B	22.75	155	253	2
D1205150	15.0	114	212	2	D1205230	23.0	155	253	2
D120515A	15.25	120	218	2	D120523A	23.25	155	276	3
D1205155	15.5	120	218	2	D1205235	23.5	155	276	3
D120515B	15.75	120	218	2	D120523B	23.75	160	281	3
D1205160	16.0	120	218	2	D1205240	24.0	160	281	3
D120516A	16.25	125	223	2	D120524A	24.25	160	281	3
D1205165	16.5	125	223	2	D1205245	24.5	160	281	3
D120516B	16.75	125	223	2	D120524B	24.75	160	281	3
D1205170	17.0	125	223	2	D1205250	25.0	160	281	3
D120517A	17.25	130	228	2	D120525A	25.25	165	286	3
D1205175	17.5	130	228	2	D1205255	25.5	165	286	3
D120517B	17.75	130	228	2	D120525B	25.75	165	286	3
D1205180	18.0	130	228	2	D1205260	26.0	165	286	3
D120518A	18.25	135	233	2	D120526A	26.25	165	286	3
D1205185	18.5	135	233	2	D1205265	26.5	165	286	3
D120518B	18.75	135	233	2	D120526B	26.75	170	291	3
D1205190	19.0	135	233	2	D1205270	27.0	170	291	3
D120519A	19.25	140	238	2	D120527A	27.25	170	291	3
D1205195	19.5	140	238	2	D1205275	27.5	170	291	3
D120519B	19.75	140	238	2	D120527B	27.75	170	291	3
D1205200	20.0	140	238	2	D1205280	28.0	170	291	3
D120520A	20.25	145	243	2	D120528A	28.25	175	296	3

◎ : 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~							
◎	◎	○			○	○	○		○		

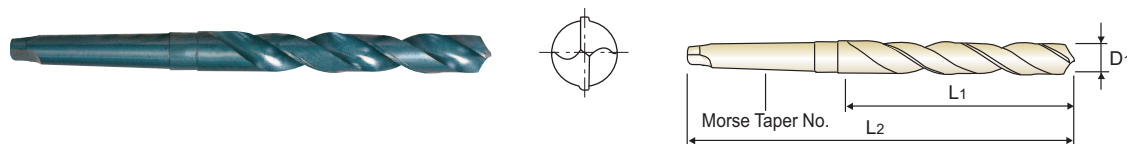
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Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	No. of Morse Taper	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	No. of Morse Taper
D1205285	28.5	175	296	3	D1205405	40.5	205	354	4
D1205288	28.75	175	296	3	D1205410	41.0	205	354	4
D1205290	29.0	175	296	3	D1205415	41.5	205	354	4
D120529A	29.25	175	296	3	D1205420	42.0	205	354	4
D1205295	29.5	175	296	3	D1205425	42.5	205	354	4
D120529B	29.75	175	296	3	D1205430	43.0	210	359	4
D1205300	30.0	175	296	3	D1205435	43.5	210	359	4
D120530A	30.25	180	301	3	D1205440	44.0	210	359	4
D1205305	30.5	180	301	3	D1205445	44.5	210	359	4
D120530B	30.75	180	301	3	D1205450	45.0	210	359	4
D1205310	31.0	180	301	3	D1205455	45.5	215	364	4
D120531A	31.25	180	301	3	D1205460	46.0	215	364	4
D1205315	31.5	180	301	3	D1205465	46.5	215	364	4
D120531B	31.75	185	306	3	D1205470	47.0	215	364	4
D1205320	32.0	185	334	4	D1205475	47.5	215	364	4
D1205325	32.5	185	334	4	D1205480	48.0	220	369	4
D1205330	33.0	185	334	4	D1205485	48.5	220	369	4
D1205335	33.5	185	334	4	D1205490	49.0	220	369	4
D1205340	34.0	190	339	4	D1205495	49.5	220	369	4
D1205345	34.5	190	339	4	D1205500	50.0	220	369	4
D1205350	35.0	190	339	4	D1205505	50.5	225	374	4
D1205355	35.5	190	339	4	D1205510	51.0	225	412	5
D1205360	36.0	195	344	4	D1205520	52.0	225	412	5
D1205365	36.5	195	344	4	D1205530	53.0	225	412	5
D1205370	37.0	195	344	4	D1205540	54.0	230	417	5
D1205375	37.5	195	344	4	D1205550	55.0	230	417	5
D1205380	38.0	200	349	4	D1205560	56.0	230	417	5
D1205385	38.5	200	349	4	D1205570	57.0	235	422	5
D1205390	39.0	200	349	4	D1205580	58.0	235	422	5
D1205395	39.5	200	349	4	D1205590	59.0	235	422	5
D1205400	40.0	200	349	4	D1205600	60.0	235	422	5

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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	
HARDNESS			~ HRC23		~ HRC23 ~ 28		HRC23 ~ 34		HRC34 ~ 38		HRC23			
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	
HARDNESS			~ HRC21									
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.)