

HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT

LONG
LANG

► **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
340**
HSS-E
42°
h8
130°


P.157

► **DH100**
worm pattern drills

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DL509074	7.4	102	156	DL509090	9.0	115	175
DL509075	7.5	102	156	DL509091	9.1	115	175
DL509076	7.6	109	165	DL509092	9.2	115	175
DL509077	7.7	109	165	DL509093	9.3	115	175
DL509078	7.8	109	165	DL509094	9.4	115	175
DL509079	7.9	109	165	DL509095	9.5	115	175
DL509080	8.0	109	165	DL509096	9.6	121	184
DL509081	8.1	109	165	DL509097	9.7	121	184
DL509082	8.2	109	165	DL509098	9.8	121	184
DL509083	8.3	109	165	DL509099	9.9	121	184
DL509084	8.4	109	165	DL509100	10.0	121	184
DL509085	8.5	109	165	DL509102	10.2	121	184
DL509086	8.6	115	175	DL509105	10.5	121	184
DL509087	8.7	115	175	DL509110	11.0	128	195
DL509088	8.8	115	175	DL509115	11.5	128	195
DL509089	8.9	115	175	DL509120	12.0	134	205

© : 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~							
◎	◎				○	○			○		



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	
HARDNESS	HRC15 ~ 30		HRC20 ~ 40					
STRENGTH	700 ~ 1000 N/mm ²		800 ~ 1200 N/mm ²					
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	
HARDNESS	HRC15 ~ 30					
STRENGTH	700 ~ 1000 N/mm ²					
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.)