STRAIGHT SHANK DRILLS

D2104 SERIES

HSS Co8, STRAIGHT SHANK TWIST DRILLS

LONG

HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT — LANG

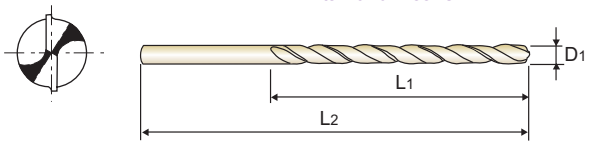
Forets HSS Co8, queue cylindrique, série longue — LONGUE

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8 — LUNGA

▶**Surface treatment** : Coloring(Gold color)
▶**Application** : Drilling deep holes in stainless steels and difficult - to - cut materials such as titanium and inconel.

▶**Oberflächenbehandlung** : Coloring(Goldfarbe)
▶**Verwendung** : Für Bohrarbeiten mit Bohrungen oder an tief liegenden Stellen. Zum Bohren von rostfreien und austenitischen Stählen, schwerzerspanbaren Werkstoffen wie Titan und Inconel.





DIN 340 | HSS Co8 | 33° | h8 | 135° | Gold Coloring

p.A262

Recommended ToolHolder — Plain Shank — ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2104020	2.0	56	85
D2104021	2.1	56	85
D2104022	2.2	59	90
D2104023	2.3	59	90
D2104024	2.4	62	95
D2104025	2.5	62	95
D2104026	2.6	62	95
D2104027	2.7	66	100
D2104028	2.8	66	100
D2104029	2.9	66	100
D2104030	3.0	66	100
D2104031	3.1	69	106
D2104032	3.2	69	106
D2104033	3.3	69	106
D2104034	3.4	73	112
D2104035	3.5	73	112
D2104036	3.6	73	112
D2104037	3.7	73	112
D2104038	3.8	78	119
D2104039	3.9	78	119
D2104040	4.0	78	119
D2104041	4.1	78	119
D2104042	4.2	78	119
D2104043	4.3	82	126
D2104044	4.4	82	126
D2104045	4.5	82	126

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2104046	4.6	82	126
D2104047	4.7	82	126
D2104048	4.8	87	132
D2104049	4.9	87	132
D2104050	5.0	87	132
D2104051	5.1	87	132
D2104052	5.2	87	132
D2104053	5.3	87	132
D2104054	5.4	91	139
D2104055	5.5	91	139
D2104056	5.6	91	139
D2104057	5.7	91	139
D2104058	5.8	91	139
D2104059	5.9	91	139
D2104060	6.0	91	139
D2104061	6.1	97	148
D2104062	6.2	97	148
D2104063	6.3	97	148
D2104064	6.4	97	148
D2104065	6.5	97	148
D2104066	6.6	97	148
D2104067	6.7	97	148
D2104068	6.8	102	156
D2104069	6.9	102	156
D2104070	7.0	102	156
D2104071	7.1	102	156

▶ HSS-E(DL104) is available on your request.
▶ TiN(D4104), TiCN(D7104) and TiAlN(DQ104) are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	○		◎	○	○		○		◎	○	○	○	○	○		○	

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○						○							○					

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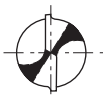

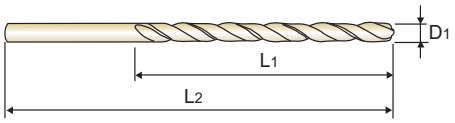

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Recommended ToolHolder — Plain Shank / ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2104072	7.2	102	156
D2104073	7.3	102	156
D2104074	7.4	102	156
D2104075	7.5	102	156
D2104076	7.6	109	165
D2104077	7.7	109	165
D2104078	7.8	109	165
D2104079	7.9	109	165
D2104080	8.0	109	165
D2104081	8.1	109	165
D2104082	8.2	109	165
D2104083	8.3	109	165
D2104084	8.4	109	165
D2104085	8.5	109	165
D2104086	8.6	115	175
D2104087	8.7	115	175
D2104088	8.8	115	175
D2104089	8.9	115	175
D2104090	9.0	115	175
D2104091	9.1	115	175

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2104092	9.2	115	175
D2104093	9.3	115	175
D2104094	9.4	115	175
D2104095	9.5	115	175
D2104096	9.6	121	184
D2104097	9.7	121	184
D2104098	9.8	121	184
D2104099	9.9	121	184
D2104100	10.0	121	184
D2104102	10.2	121	184
D2104105	10.5	121	184
D2104108	10.8	128	195
D2104110	11.0	128	195
D2104112	11.2	128	195
D2104115	11.5	128	195
D2104118	11.8	128	195
D2104120	12.0	134	205

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Recommended	○	○	○						○							○					

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