STRAIGHT SHANK DRILLS

D2107 SERIES

HSS Co8, STRAIGHT SHANK TWIST DRILLS

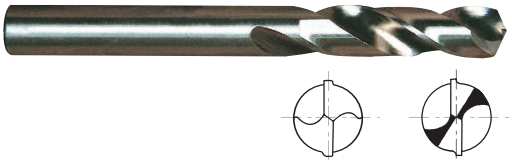
STUB

HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT
Forets HSS Co8, queue cylindrique, Forme C, série extra-courte
PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8

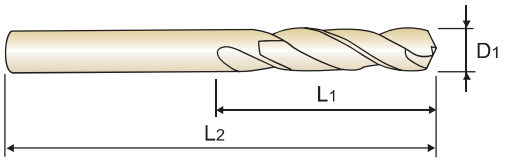
EXTRA KURZ
EXTRA-COURTE
EXTRA CORTA

▶**Surface treatment** : Coloring(Gold color)
▶**Application** : Suitable for drilling thin materials with portable electric drills.
Special twist drills for automatic and turret lathes

▶**Oberflächenbehandlung** : Coloring(Goldfarbe)
▶**Verwendung** : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken. Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.



under 1.6mm 1.6mm & over



DIN 1897 | 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
D2107010	1.0	6	26
D2107011	1.1	7	28
D2107012	1.2	8	30
D2107912	1.25	8	30
D2107013	1.3	8	30
D2107014	1.4	9	32
D2107015	1.5	9	32
D2107016	1.6	10	34
D2107017	1.7	10	34
D2107917	1.75	11	36
D2107018	1.8	11	36
D2107019	1.9	11	36
D2107020	2.0	12	38
D2107021	2.1	12	38
D2107022	2.2	13	40
D2107922	2.25	13	40
D2107023	2.3	13	40
D2107024	2.4	14	43
D2107025	2.5	14	43
D2107026	2.6	14	43
D2107027	2.7	16	46
D2107927	2.75	16	46
D2107028	2.8	16	46
D2107029	2.9	16	46
D2107030	3.0	16	46
D2107031	3.1	18	49

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2107032	3.2	18	49
D2107932	3.25	18	49
D2107033	3.3	18	49
D2107034	3.4	20	52
D2107035	3.5	20	52
D2107036	3.6	20	52
D2107037	3.7	20	52
D2107937	3.75	20	52
D2107038	3.8	22	55
D2107039	3.9	22	55
D2107040	4.0	22	55
D2107041	4.1	22	55
D2107042	4.2	22	55
D2107942	4.25	22	55
D2107043	4.3	24	58
D2107044	4.4	24	58
D2107045	4.5	24	58
D2107046	4.6	24	58
D2107946	4.65	24	58
D2107047	4.7	24	58
D2107947	4.75	24	58
D2107048	4.8	26	62
D2107049	4.9	26	62
D2107050	5.0	26	62
D2107051	5.1	26	62
D2107052	5.2	26	62

▶ HSS-E(DL107) is available on your request.
▶ TiN(D4107), TiCN(D7107) and TiAlN(DQ107) 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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Forets HSS Co8, queue cylindrique, Forme C, série extra-courte — *EXTRA-COURTE*

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8 — *EXTRA CORTA*

▶**Surface treatment** : Coloring(Gold color)
▶**Application** : Suitable for drilling thin materials with portable electric drills.
Special twist drills for automatic and turret lathes

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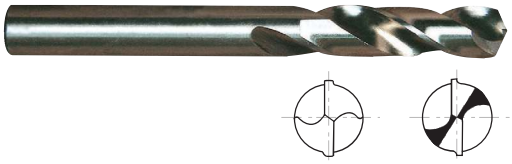

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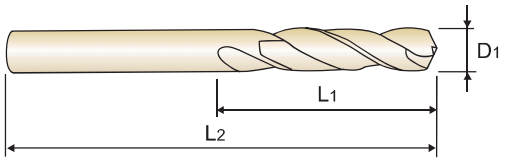

DIN 1897 | HSS Co8 | 33° | h8 | 135° | Gold Coloring

p.A262

Recommended ToolHolder — Plain Shank — ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2107952	5.25	26	62
D2107053	5.3	26	62
D2107054	5.4	28	66
D2107055	5.5	28	66
D2107955	5.55	28	66
D2107056	5.6	28	66
D2107057	5.7	28	66
D2107957	5.75	28	66
D2107058	5.8	28	66
D2107059	5.9	28	66
D2107060	6.0	28	66
D2107061	6.1	31	70
D2107062	6.2	31	70
D2107962	6.25	31	70
D2107063	6.3	31	70
D2107064	6.4	31	70
D2107065	6.5	31	70
D2107066	6.6	31	70
D2107067	6.7	31	70
D2107967	6.75	34	74
D2107068	6.8	34	74
D2107069	6.9	34	74
D2107070	7.0	34	74
D2107071	7.1	34	74
D2107072	7.2	34	74
D2107972	7.25	34	74

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2107073	7.3	34	74
D2107074	7.4	34	74
D2107974	7.45	34	74
D2107075	7.5	34	74
D2107076	7.6	37	79
D2107077	7.7	37	79
D2107977	7.75	37	79
D2107078	7.8	37	79
D2107079	7.9	37	79
D2107080	8.0	37	79
D2107081	8.1	37	79
D2107082	8.2	37	79
D2107982	8.25	37	79
D2107083	8.3	37	79
D2107084	8.4	37	79
D2107085	8.5	37	79
D2107086	8.6	40	84
D2107087	8.7	40	84
D2107987	8.75	40	84
D2107088	8.8	40	84
D2107089	8.9	40	84
D2107090	9.0	40	84
D2107091	9.1	40	84
D2107092	9.2	40	84
D2107992	9.25	40	84
D2107093	9.3	40	84

▶ HSS-E(DL107) is available on your request.
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▶ 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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HSS Co8, SPIRALBOHRER mit ZYLINDERSCHAFT — *EXTRA KURZ*

Forets HSS Co8, queue cylindrique, Forme C, série extra-courte — *EXTRA-COURTE*

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSS Co8 — *EXTRA CORTA*

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Special twist drills for automatic and turret lathes

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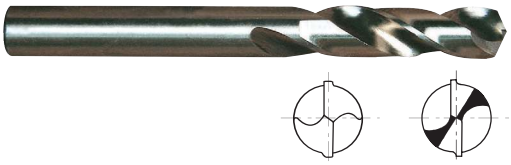

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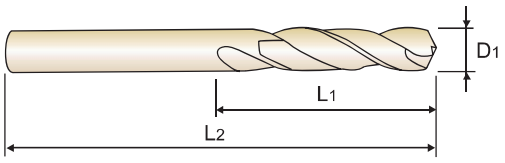

DIN 1897 | HSS Co8 | 33° | h8 | 135° | Gold Coloring

p.A262

Recommended ToolHolder — Plain Shank / ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2107993	9.35	40	84
D2107094	9.4	40	84
D2107095	9.5	40	84
D2107096	9.6	43	89
D2107097	9.7	43	89
D2107997	9.75	43	89
D2107098	9.8	43	89
D2107099	9.9	43	89
D2107100	10.0	43	89
D2107102	10.2	43	89
D2107802	10.25	43	89
D2107105	10.5	43	89
D2107807	10.75	47	95
D2107110	11.0	47	95
D2107812	11.25	47	95
D2107115	11.5	47	95
D2107817	11.75	47	95
D2107118	11.8	47	95
D2107120	12.0	51	102
D2107822	12.25	51	102
D2107125	12.5	51	102
D2107827	12.75	51	102
D2107130	13.0	51	102
D2107832	13.25	54	107
D2107135	13.5	54	107
D2107837	13.75	54	107

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2107138	13.8	54	107
D2107140	14.0	54	107
D2107842	14.25	56	111
D2107145	14.5	56	111
D2107847	14.75	56	111
D2107150	15.0	56	111
D2107852	15.25	58	115
D2107155	15.5	58	115
D2107857	15.75	58	115
D2107160	16.0	58	115
D2107862	16.25	60	119
D2107165	16.5	60	119
D2107867	16.75	60	119
D2107170	17.0	60	119
D2107872	17.25	62	123
D2107175	17.5	62	123
D2107877	17.75	62	123
D2107180	18.0	62	123
D2107882	18.25	64	127
D2107185	18.5	64	127
D2107887	18.75	64	127
D2107190	19.0	64	127
D2107892	19.25	66	131
D2107195	19.5	66	131
D2107897	19.75	66	131
D2107200	20.0	66	131

▶ HSS-E(DL107) is available on your request.
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▶ NEXT PAGE

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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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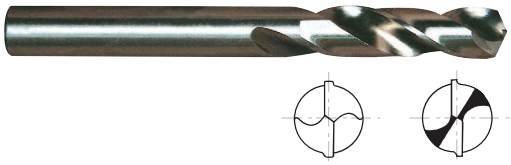

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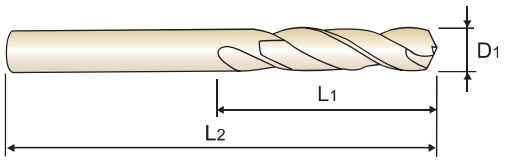

DIN 1897 | HSS Co8 | 33° | h8 | 135° | Gold Coloring

p.A262

Recommended ToolHolder — Plain Shank — ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2107205	20.5	68	136
D2107210	21.0	68	136
D2107215	21.5	70	141
D2107220	22.0	70	141
D2107225	22.5	72	146
D2107230	23.0	72	146
D2107235	23.5	72	146
D2107240	24.0	75	151

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2107245	24.5	75	151
D2107250	25.0	75	151
D2107260	26.0	78	156
D2107270	27.0	81	162
D2107280	28.0	81	162
D2107290	29.0	84	168
D2107300	30.0	84	168
D2107310	31.0	87	174

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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	
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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				
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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	○	○	○						○							○					