STRAIGHT SHANK DRILLS

DL109 SERIES

HSS-E, STRAIGHT SHANK TWIST DRILLS for HEAVY DUTY

JOBBER

HSS-E, SPIRALBOHRER für HOHE LEISTUNGEN mit ZYLINDERSCHAFT — *KURZ*

Forets HSS-E, queue cylindrique pour matériaux durs, série courte — *COURTE*

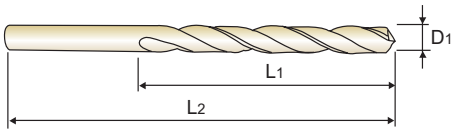
PUNTE ELICOIDALI PER IMPIEGHI GRAVOSI, GAMBO CILINDRICO, HSS - E — *CORTA*

▶**Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron and graphite.

▶**Verwendung** : Zum Bohren von Stahl und Stahlguß, Grauguß, Temperguß, Sphäroguß, Sintereisen, Graphit.







DIN 338 | HSS-E | N 20~30° | h8 | 118° | Bright

p.A262

Recommended ToolHolder — Plain Shank — ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DL109015	1.5	18	40
DL109917	1.75	22	46
DL109020	2.0	24	49
DL109922	2.25	27	53
DL109025	2.5	30	57
DL109927	2.75	33	61
DL109030	3.0	33	61
DL109932	3.25	36	65
DL109035	3.5	39	70
DL109937	3.75	39	70
DL109040	4.0	43	75
DL109942	4.25	43	75
DL109045	4.5	47	80
DL109947	4.75	47	80
DL109050	5.0	52	86
DL109952	5.25	52	86
DL109055	5.5	57	93
DL109957	5.75	57	93
DL109060	6.0	57	93
DL109962	6.25	63	101
DL109065	6.5	63	101
DL109967	6.75	69	109
DL109070	7.0	69	109
DL109972	7.25	69	109
DL109075	7.5	69	109
DL109977	7.75	75	117

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
DL109080	8.0	75	117
DL109982	8.25	75	117
DL109085	8.5	75	117
DL109987	8.75	81	125
DL109090	9.0	81	125
DL109992	9.25	81	125
DL109095	9.5	81	125
DL109997	9.75	87	133
DL109100	10.0	87	133
DL109105	10.5	87	133
DL109110	11.0	94	142
DL109115	11.5	94	142
DL109120	12.0	101	151
DL109125	12.5	101	151
DL109130	13.0	101	151

▶ TiN(DN109), TiCN(DX109) and TiAlN(DT109) are available on your request.

◎ : 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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