STRAIGHT SHANK DRILLS

DL608 SERIES

HSS-E, MORSE TAPER SHANK TWIST DRILLS for DEEP HOLES — *LONG*

HSS-E, SPIRALBOHRER für TIEFLOCH mit MORSEKEGELSCHAFT — *LANG*

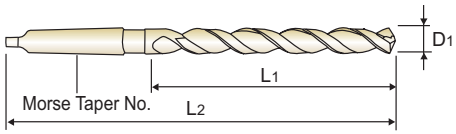
Forets HSS-E, queue cône morse pour perçage profond, série longue — *LONGUE*

PUNTE IN HSS - E, ATTACCO CONO MORSE PER FORI NON - STOP — *LUNGA*

▶**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 341 | HSS-E | 38° | 1 ~ 3 | h8 | 130° | Bright

p.A264

▶ **DH100** worm pattern drills

Recommended ToolHolder — Plain Shank — ER COLLET CHUCK

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	No.of Morse Taper
DL608130	13.0	134	215	1
DL608135	13.5	142	223	1
DL608140	14.0	142	223	1
DL608145	14.5	147	245	2
DL608150	15.0	147	245	2
DL608155	15.5	153	251	2
DL608160	16.0	153	251	2
DL608165	16.5	159	257	2
DL608170	17.0	159	257	2
DL608175	17.5	165	263	2
DL608180	18.0	165	263	2
DL608185	18.5	171	269	2
DL608190	19.0	171	269	2

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	No.of Morse Taper
DL608195	19.5	177	275	2
DL608200	20.0	177	275	2
DL608210	21.0	184	282	2
DL608220	22.0	191	289	2
DL608230	23.0	198	296	2
DL608240	24.0	206	327	3
DL608250	25.0	206	327	3
DL608260	26.0	214	335	3
DL608270	27.0	222	343	3
DL608280	28.0	222	343	3
DL608290	29.0	230	351	3
DL608300	30.0	230	351	3

◎ : 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																					