

CARBIDE DRILLS

SOLID CARBIDE DRILLS



Solid carbide drills

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Solid carbide drills Product overview

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	Products	Solid Carbide Drills	L/D	*	Ø	Application						Type	Page
						P	M	K	N	S	H		
SU	1534SU03		3xD		0.9-20	✓	✓	✓				Twist drills	C48
	1534SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C48
	1634SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C72
	1734SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C80
	1536SU05		5xD		2-20	✓	✓	✓				Twist drills	C59
	1536SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C59
	1636SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C76
	1736SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C84
	1538SU08C		8xD	*	3-18	✓	✓	✓				Twist drills	C69
	1557SU03		3xD		M4-M16	✓	✓	✓				Step drills	C88
SL SP	1588SL10C		10xD	*	3-14	✓	✓	✓	✓	✓		Deep hole drills	C89
	1588SL12C		12xD	*	3-21	✓	✓	✓	✓	✓		Deep hole drills	C92
	1588SL15C		15xD	*	3-14	✓	✓	✓	✓	✓		Deep hole drills	C96
	1588SL20C		20xD	*	3-14	✓	✓	✓	✓	✓		Deep hole drills	C99
	1588SL30C		30xD	*	3-10	✓	✓	✓	✓	✓		Deep hole drills	C102
	1534SP03C		3xD	*	3.03-20.03	✓	✓	✓	✓	✓		Pilot drills	C104
UD	1534UD03C		3xD	*	3-20	✓	✓			✓		Twist drills	C110
	1536UD05C		5xD	*	3-20	✓	✓			✓		Twist drills	C113
GD	1534GD03C		3xD	*	3-20	✓		✓				Twist drills	C118
	1536GD05C		5xD	*	3-20	✓		✓				Twist drills	C121
	1636GD05C		5xD	*	5-20	✓		✓				Twist drills	C124
SH	1534SH03		3xD		3-16						✓	Twist drills	C127
SC	1105SC03		3xD		2-16				✓			Twist drills	C129
	1101SC05		5xD		2-16				✓			Twist drills	C132
PA	1165PA03		3xD		3-20				✓			Three-lips drills	C133
PC	1576PC05		5xD		4-20			✓				Straight flute drills	C137
	1576PC05C		5xD	*	4-20			✓				Straight flute drills	C137

✓ Very suitable ✓ Suitable
* With internal cooling SC*: Centuring drills

	Products	Solid Carbide Drills	L/D	*	Ø	Application						Type	Page
						P	M	K	N	S	H		
PC	1579PC15C		15xD	*	5-14			✓				Straight flute drills	C139
SC*	1143SC90		-		5-20	✓	✓	✓	✓			Centuring drills	C141
	1143SC120		-	*	5-20	✓	✓	✓	✓			Centuring drills	C142
	1143SC142			*	5-20	✓	✓	✓	✓			Centuring drills	C143

✓ Very suitable ✓ Suitable

* With internal cooling SC*: Centuring drills

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Coated cemented carbide PVD

Grade	Grade description
-------	-------------------

Turning

KDG303 PVD coated P10–P20/M10–M20/K10–K20 carbide grade for steel, stainless steel and cast iron. Good wear resistance and toughness for a wide application field.

B

KDG304 PVD coated carbide substrate for machining caststeel and cast iron. Optimised toughness for high feeds.

Milling

KDG305 PVD coated carbide substrate for machining stainless steel and HRSA. High process reliability due to improved wear resistance.

C

Uncoated cemented carbide

Grade	Grade description
-------	-------------------

Drilling

YK20F Uncoated K20 carbide substrate for steel, cast iron and non ferrous materials.

D

YK30F Uncoated K30 carbide substrate for steel, stainless steel, cast iron and non ferrous materials.

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Notes

Lined area for taking notes, consisting of horizontal dotted lines.

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Turning

Type	
Code	Description
1	Forets

1

Shank type	
Code	Description
1	Straight shank
2	Square shank DIN 10
3	Double flattened straight shank DIN 1809
5	Straight shank DIN 6535 HA
6	Weldon shank DIN 6535 HB
7	Whistle Notch shank DIN 6535 HE
9	Morse taper shank

2

B

Milling

Drill type	
Code	Description
0	Twist drill
3	Universal twist drill
4	NC tapping device
5	Step drill
6	Three-lips drill
7	Straight flute drill
8	Deep hole drill

3

Tool length	
Code	Description
1	DIN 338
2	DIN 1897
3	QJ/ZZQ(TO)01.001.002
4	DIN 6537 K
5	DIN 6539
6	DIN 6537 L
7	Factory standard ZCC-C
8	Factory standard ZCC-D
9	Factory standard ZCC-E

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Drilling

Application	
Code	Description
UD	Twist drills for tough materials
GD	Twist drills for high feeds
SU	Twist drill for general machining
SUK	Twist drill for cast iron
SL	Twist drill for deep hole drilling
SLK	Deep hole drill for cast iron
SP	Pilot drill
SH	Twist drill for hardened materials
SC	Twist drill for non-ferrous metals and cast iron
PA	Three-lips drill for non-ferrous metals and cast iron
PC	Straight flute drill for non-ferrous metals and cast iron

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L/D relation		Angle	
Drill		NC tapping device	
Code	Description	Code	Description
03	3xD	90	90°
05	5xD	120	120°
08	8xD		
10	10xD		
12	12xD		
15	15xD		
20	20xD		
30	30xD		

With inner cooling

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Bore diameter [mm]	
Code	Description
0200	2,0
0850	8,5
1800	18,0
...	

Shank diameter [mm]	
Code	Description
S	4,0

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IMPORTANT INFORMATION

Recommended applications for the **SU series**

Feed calculator

ISO group	Material	Cutting speed v_c (m/min)	Feed factor F_m
P	Low-alloy steel	180	0,015
	High-alloy steel	120	0,012
M	Stainless steels	80	0,01
K	Cast iron	250	0,018
	Cast steel	180	0,015
S	H RSA	45	0,008
N	Aluminium	400	0,02

Formula: feed per revolution (F_n) $D \times F_m$
Example: drill diameter (D) 10 mm
material high-alloy steel

$$F_n = 10 \text{ mm} \times 0,012 = 0,12 \text{ mm/rev.}$$



Fig.: 1536SU05C

SU(K) drill 3xD **General machining** Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



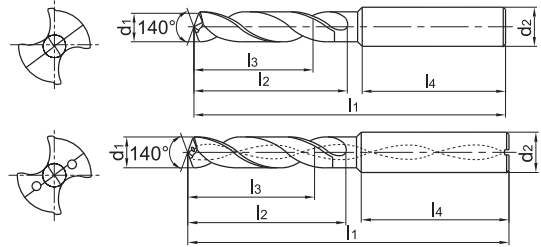
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-0090S		0.9	4	47	4.2	3.4	37.9	○
1534SU03-0100S		1	4	47	4.7	3.8	37.6	●
1534SU03-0105S		1.05	4	47	4.9	3.9	37.5	●
1534SU03-0110S		1.1	4	47	5.2	4.1	37.2	○
1534SU03-0115S		1.15	4	47	5.4	4.3	37.1	○
1534SU03-0120S		1.2	4	47	5.6	4.5	37	●
1534SU03-0125S		1.25	4	47	5.9	4.7	36.8	○
1534SU03-0130S		1.3	4	47	6.1	4.9	36.6	●
1534SU03-0135S		1.35	4	47	6.3	5.1	36.5	○
1534SU03-0140S		1.4	4	47	6.6	5.3	36.3	○
1534SU03-0145S		1.45	4	47	6.8	5.4	36.2	○
1534SU03-0147S		1.47	4	47	6.9	5.5	36.1	●
1534SU03-0150S		1.5	4	47	7.1	5.6	36	●
1534SU03-0155S		1.55	4	47	7.3	5.8	35.8	○
1534SU03-0160S		1.6	4	47	7.5	6	35.7	●
1534SU03-0165S		1.65	4	47	7.8	6.2	35.5	○
1534SU03-0170S		1.7	4	47	8	6.4	35.4	●
1534SU03-0175S		1.75	4	47	8.2	6.6	35.2	○
1534SU03-0180S		1.8	4	47	8.5	6.8	35	●
1534SU03-0185S		1.85	4	47	8.7	6.9	34.9	○
1534SU03-0190S		1.9	4	47	8.9	7.1	34.8	●
1534SU03-0195S		1.95	4	47	9.2	7.3	34.5	○
1534SU03-0200		2	6	62	20	14	36	●
1534SU03-0210		2.1	6	62	20	14	36	●
1534SU03-0220		2.2	6	62	20	14	36	●
1534SU03-0230		2.33	3	59	13.8	14	36	●
1534SU03-0240		2.4	6	62	20	14	36	●
1534SU03-0250		2.5	6	62	20	14	36	●
1534SU03-0260		2.6	6	62	20	14	36	●
1534SU03-0270		2.7	6	62	20	14	36	●
1534SU03-0280		2.8	6	62	20	14	36	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



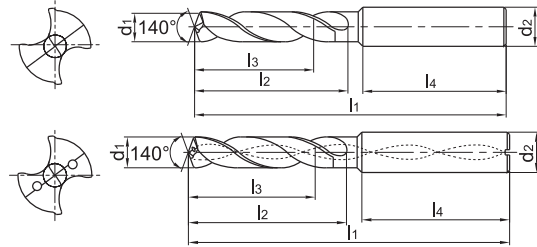
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-0290		2.9	6	62	20	14	36	●
1534SU03-0300		3	6	62	20	14	36	●
1534SU03C-0300	*	3	6	62	20	14	36	●
1534SU03-0310		3.1	6	62	20	14	36	●
1534SU03C-0310	*	3.1	6	62	20	14	36	●
1534SU03-0320		3.2	6	62	20	14	36	●
1534SU03C-0320	*	3.2	6	62	20	14	36	●
1534SU03-0325		3.25	6	62	20	14	36	●
1534SU03C-0325	*	3.25	6	62	20	14	36	●
1534SU03-0330		3.3	6	62	20	14	36	●
1534SU03C-0330	*	3.3	6	62	20	14	36	●
1534SU03-0340		3.4	6	62	20	14	36	●
1534SU03C-0340	*	3.4	6	62	20	14	36	●
1534SU03-0350		3.5	6	62	20	14	36	●
1534SU03C-0350	*	3.5	6	62	20	14	36	●
1534SU03-0360		3.6	6	62	20	14	36	●
1534SU03C-0360	*	3.6	6	62	20	14	36	●
1534SU03-0370		3.7	6	62	20	14	36	●
1534SU03C-0370	*	3.7	6	62	20	14	36	●
1534SU03-0380		3.8	6	66	24	17	36	●
1534SU03C-0380	*	3.8	6	66	24	17	36	●
1534SU03-0390		3.9	6	66	24	17	36	●
1534SU03C-0390	*	3.9	6	66	24	17	36	●
1534SU03-0400		4	6	66	24	17	36	●
1534SU03C-0400	*	4	6	66	24	17	36	●
1534SU03-0410		4.1	6	66	24	17	36	●
1534SU03C-0410	*	4.1	6	66	24	17	36	●
1534SU03-0420		4.2	6	66	24	17	36	●
1534SU03C-0420	*	4.2	6	66	24	17	36	●
1534SU03-0430		4.3	6	66	24	17	36	●
1534SU03C-0430	*	4.3	6	66	24	17	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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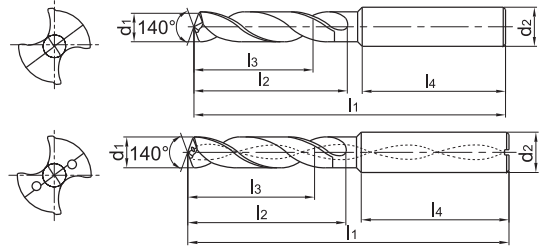
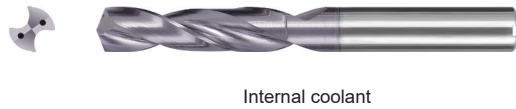
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SU(K) drill 3xD **General machining** Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-0440		4.4	6	66	24	17	36	●
1534SU03C-0440	*	4.4	6	66	24	17	36	●
1534SU03-0450		4.5	6	66	24	17	36	●
1534SU03C-0450	*	4.5	6	66	24	17	36	●
1534SU03-0460		4.6	6	66	24	17	36	●
1534SU03C-0460	*	4.6	6	66	24	17	36	●
1534SU03-0465		4.65	6	66	24	17	36	●
1534SU03C-0465	*	4.65	6	66	24	17	36	●
1534SU03-0470		4.7	6	66	24	17	36	●
1534SU03C-0470	*	4.7	6	66	24	17	36	●
1534SU03-0480		4.8	6	66	28	20	36	●
1534SU03C-0480	*	4.8	6	66	28	20	36	●
1534SU03-0490		4.9	6	66	28	20	36	●
1534SU03C-0490	*	4.9	6	66	28	20	36	●
1534SU03-0500		5	6	66	28	20	36	●
1534SU03C-0500	*	5	6	66	28	20	36	●
1534SU03-0510		5.1	6	66	28	20	36	●
1534SU03C-0510	*	5.1	6	66	28	20	36	●
1534SU03-0520		5.2	6	66	28	20	36	●
1534SU03C-0520	*	5.2	6	66	28	20	36	●
1534SU03-0530		5.3	6	66	28	20	36	●
1534SU03C-0530	*	5.3	6	66	28	20	36	●
1534SU03-0540		5.4	6	66	28	20	36	●
1534SU03C-0540	*	5.4	6	66	28	20	36	●
1534SU03-0550		5.5	6	66	28	20	36	●
1534SU03C-0550	*	5.5	6	66	28	20	36	●
1534SU03-0555		5.55	6	66	28	20	36	●
1534SU03C-0555	*	5.55	6	66	28	20	36	●
1534SU03-0560		5.6	6	66	28	20	36	●
1534SU03C-0560	*	5.6	6	66	28	20	36	●
1534SU03-0570		5.7	6	66	28	20	36	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



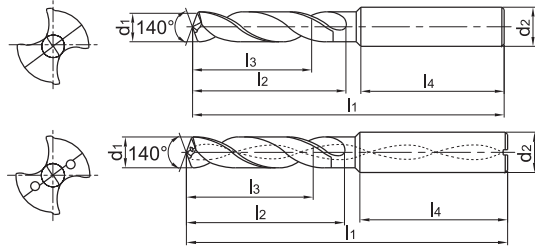
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03C-0570	*	5.7	6	66	28	20	36	●
1534SU03-0580		5.8	6	66	28	20	36	●
1534SU03C-0580	*	5.8	6	66	28	20	36	●
1534SU03-0590		5.9	6	66	28	20	36	●
1534SU03C-0590	*	5.9	6	66	28	20	36	●
1534SU03-0600		6	6	66	28	20	36	●
1534SU03C-0600	*	6	6	66	28	20	36	●
1534SU03-0610		6.1	8	79	34	24	36	●
1534SU03C-0610	*	6.1	8	79	34	24	36	●
1534SU03-0620		6.2	8	79	34	24	36	●
1534SU03C-0620	*	6.2	8	79	34	24	36	●
1534SU03-0630		6.3	8	79	34	24	36	●
1534SU03C-0630	*	6.3	8	79	34	24	36	●
1534SU03-0640		6.4	8	79	34	24	36	●
1534SU03C-0640	*	6.4	8	79	34	24	36	●
1534SU03-0650		6.5	8	79	34	24	36	●
1534SU03C-0650	*	6.5	8	79	34	24	36	●
1534SU03-0660		6.6	8	79	34	24	36	●
1534SU03C-0660	*	6.6	8	79	34	24	36	●
1534SU03-0670		6.7	8	79	34	24	36	●
1534SU03C-0670	*	6.7	8	79	34	24	36	●
1534SU03-0675		6.75	8	79	34	24	36	●
1534SU03C-0675	*	6.75	8	79	34	24	36	●
1534SU03-0680		6.8	8	79	34	24	36	●
1534SU03C-0680	*	6.8	8	79	34	24	36	●
1534SU03-0690		6.9	8	79	34	24	36	●
1534SU03C-0690	*	6.9	8	79	34	24	36	●
1534SU03-0700		7	8	79	34	24	36	●
1534SU03C-0700	*	7	8	79	34	24	36	●
1534SU03-0710		7.1	8	79	41	29	36	●
1534SU03C-0710	*	7.1	8	79	41	29	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 3xD **General machining** Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



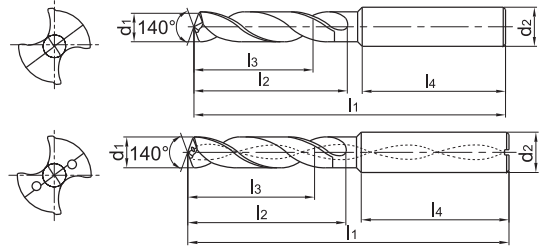
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-0720		7.2	8	79	41	29	36	●
1534SU03C-0720	*	7.2	8	79	41	29	36	●
1534SU03-0730		7.3	8	79	41	29	36	●
1534SU03C-0730	*	7.3	8	79	41	29	36	●
1534SU03-0740		7.4	8	79	41	29	36	●
1534SU03C-0740	*	7.4	8	79	41	29	36	●
1534SU03-0745		7.45	8	79	41	29	36	○
1534SU03C-0745	*	7.45	8	79	41	29	36	○
1534SU03-0750		7.5	8	79	41	29	36	●
1534SU03C-0750	*	7.5	8	79	41	29	36	●
1534SU03-0760		7.6	8	79	41	29	36	●
1534SU03C-0760	*	7.6	8	79	41	29	36	●
1534SU03-0770		7.7	8	79	41	29	36	●
1534SU03C-0770	*	7.7	8	79	41	29	36	●
1534SU03-0780		7.8	8	79	41	29	36	●
1534SU03C-0780	*	7.8	8	79	41	29	36	●
1534SU03-0790		7.9	8	79	41	29	36	●
1534SU03C-0790	*	7.9	8	79	41	29	36	●
1534SU03-0800		8	8	79	41	29	36	●
1534SU03C-0800	*	8	8	79	41	29	36	●
1534SU03-0810		8.1	10	89	47	35	40	●
1534SU03C-0810	*	8.1	10	89	47	35	40	●
1534SU03-0820		8.2	10	89	47	35	40	●
1534SU03C-0820	*	8.2	10	89	47	35	40	●
1534SU03-0830		8.3	10	89	47	35	40	●
1534SU03C-0830	*	8.3	10	89	47	35	40	●
1534SU03-0840		8.4	10	89	47	35	40	●
1534SU03C-0840	*	8.4	10	89	47	35	40	●
1534SU03-0850		8.5	10	89	47	35	40	●
1534SU03C-0850	*	8.5	10	89	47	35	40	●
1534SU03-0860		8.6	10	89	47	35	40	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



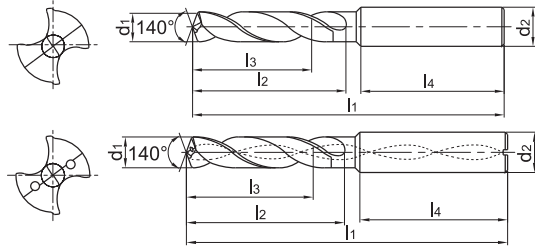
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03C-0860	*	8.6	10	89	47	35	40	●
1534SU03-0870		8.7	10	89	47	35	40	●
1534SU03C-0870	*	8.7	10	89	47	35	40	●
1534SU03-0880		8.8	10	89	47	35	40	●
1534SU03C-0880	*	8.8	10	89	47	35	40	●
1534SU03-0890		8.9	10	89	47	35	40	●
1534SU03C-0890	*	8.9	10	89	47	35	40	●
1534SU03-0900		9	10	89	47	35	40	●
1534SU03C-0900	*	9	10	89	47	35	40	●
1534SU03-0910		9.1	10	89	47	35	40	●
1534SU03C-0910	*	9.1	10	89	47	35	40	●
1534SU03-0920		9.2	10	89	47	35	40	●
1534SU03C-0920	*	9.2	10	89	47	35	40	●
1534SU03-0930		9.3	10	89	47	35	40	●
1534SU03C-0930	*	9.3	10	89	47	35	40	●
1534SU03-0935		9.35	10	89	47	35	40	○
1534SU03C-0935	*	9.35	10	89	47	35	40	○
1534SU03-0940		9.4	10	89	47	35	40	●
1534SU03C-0940	*	9.4	10	89	47	35	40	●
1534SU03-0945		9.45	10	89	47	35	40	○
1534SU03C-0945	*	9.45	10	89	47	35	40	○
1534SU03-0950		9.5	10	89	47	35	40	●
1534SU03C-0950	*	9.5	10	89	47	35	40	●
1534SU03-0960		9.6	10	89	47	35	40	●
1534SU03C-0960	*	9.6	10	89	47	35	40	●
1534SU03-0970		9.7	10	89	47	35	40	●
1534SU03C-0970	*	9.7	10	89	47	35	40	●
1534SU03-0980		9.8	10	89	47	35	40	●
1534SU03C-0980	*	9.8	10	89	47	35	40	●
1534SU03-0990		9.9	10	89	47	35	40	●
1534SU03C-0990	*	9.9	10	89	47	35	40	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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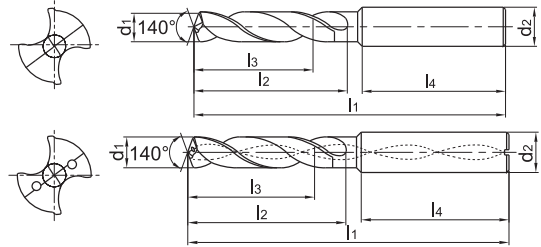
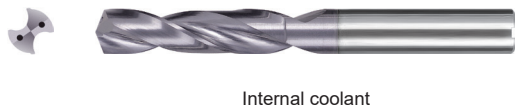
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SU(K) drill 3xD **General machining** Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-1000		10	10	89	47	35	40	●
1534SU03C-1000	*	10	10	89	47	35	40	●
1534SU03-1010		10.1	12	102	55	40	45	●
1534SU03C-1010	*	10.1	12	102	55	40	45	●
1534SU03-1020		10.2	12	102	55	40	45	●
1534SU03C-1020	*	10.2	12	102	55	40	45	●
1534SU03-1025		10.25	12	102	55	40	45	●
1534SU03C-1025	*	10.25	12	102	55	40	45	●
1534SU03-1030		10.3	12	102	55	40	45	●
1534SU03C-1030	*	10.3	12	102	55	40	45	●
1534SU03-1040		10.4	12	102	55	40	45	●
1534SU03C-1040	*	10.4	12	102	55	40	45	●
1534SU03-1050		10.5	12	102	55	40	45	●
1534SU03C-1050	*	10.5	12	102	55	40	45	●
1534SU03-1060		10.6	12	102	55	40	45	●
1534SU03C-1060	*	10.6	12	102	55	40	45	●
1534SU03-1070		10.7	12	102	55	40	45	●
1534SU03C-1070	*	10.7	12	102	55	40	45	●
1534SU03-1080		10.8	12	102	55	40	45	●
1534SU03C-1080	*	10.8	12	102	55	40	45	●
1534SU03-1090		10.9	12	102	55	40	45	●
1534SU03C-1090	*	10.9	12	102	55	40	45	●
1534SU03-1100		11	12	102	55	40	45	●
1534SU03C-1100	*	11	12	102	55	40	45	●
1534SU03-1110		11.1	12	102	55	40	45	●
1534SU03C-1110	*	11.1	12	102	55	40	45	●
1534SU03-1120		11.2	12	102	55	40	45	●
1534SU03C-1120	*	11.2	12	102	55	40	45	●
1534SU03-1125		11.25	12	102	55	40	45	○
1534SU03C-1125	*	11.25	12	102	55	40	45	○
1534SU03-1130		11.3	12	102	55	40	45	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



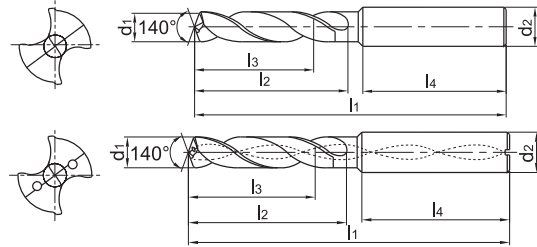
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03C-1130	*	11.3	12	102	55	40	45	●
1534SU03-1135		11.35	12	102	55	40	45	○
1534SU03C-1135	*	11.35	12	102	55	40	45	○
1534SU03-1140		11.4	12	102	55	40	45	●
1534SU03C-1140	*	11.4	12	102	55	40	45	●
1534SU03-1145		11.45	12	102	55	40	45	○
1534SU03C-1145	*	11.45	12	102	55	40	45	○
1534SU03-1150		11.5	12	102	55	40	45	●
1534SU03C-1150	*	11.5	12	102	55	40	45	●
1534SU03-1160		11.6	12	102	55	40	45	●
1534SU03C-1160	*	11.6	12	102	55	40	45	●
1534SU03-1170		11.7	12	102	55	40	45	●
1534SU03C-1170	*	11.7	12	102	55	40	45	●
1534SU03-1180		11.8	12	102	55	40	45	●
1534SU03C-1180	*	11.8	12	102	55	40	45	●
1534SU03-1190		11.9	12	102	55	40	45	●
1534SU03C-1190	*	11.9	12	102	55	40	45	●
1534SU03-1200		12	12	102	55	40	45	●
1534SU03C-1200	*	12	12	102	55	40	45	●
1534SU03-1210		12.1	14	107	60	43	45	●
1534SU03C-1210	*	12.1	14	107	60	43	45	●
1534SU03-1220		12.2	14	107	60	43	45	●
1534SU03C-1220	*	12.2	14	107	60	43	45	●
1534SU03-1225		12.25	14	107	60	43	45	●
1534SU03C-1225	*	12.25	14	107	60	43	45	●
1534SU03-1230		12.3	14	107	60	43	45	●
1534SU03C-1230	*	12.3	14	107	60	43	45	●
1534SU03-1250		12.5	14	107	60	43	45	●
1534SU03C-1250	*	12.5	14	107	60	43	45	●
1534SU03-1270		12.7	14	107	60	43	45	●
1534SU03C-1270	*	12.7	14	107	60	43	45	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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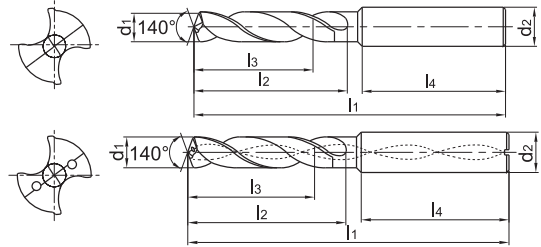
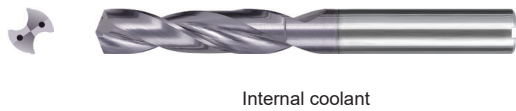
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SU(K) drill 3xD **General machining** Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-1275		12.75	14	107	60	43	45	●
1534SU03C-1275	*	12.75	14	107	60	43	45	●
1534SU03-1280		12.8	14	107	60	43	45	●
1534SU03C-1280	*	12.8	14	107	60	43	45	●
1534SU03-1300		13	14	107	60	43	45	●
1534SU03C-1300	*	13	14	107	60	43	45	●
1534SU03-1310		13.1	14	107	60	43	45	●
1534SU03C-1310	*	13.1	14	107	60	43	45	●
1534SU03-1335	*	13.35	14	107	60	43	45	●
1534SU03-1350		13.5	14	107	60	43	45	●
1534SU03C-1350	*	13.5	14	107	60	43	45	●
1534SU03-1380		13.8	14	107	60	43	45	●
1534SU03C-1380	*	13.8	14	107	60	43	45	●
1534SU03-1400		14	14	107	60	43	45	●
1534SU03C-1400	*	14	14	107	60	43	45	●
1534SU03-1420		14.2	16	107	60	43	45	●
1534SU03C-1420	*	14.2	16	107	60	43	45	●
1534SU03-1425		14.25	16	115	65	45	48	●
1534SU03C-1425	*	14.25	16	115	65	45	48	●
1534SU03-1430		14.3	16	115	65	45	48	●
1534SU03C-1430	*	14.3	16	115	65	45	48	●
1534SU03-1450		14.5	16	115	65	45	48	●
1534SU03C-1450	*	14.5	16	115	65	45	48	●
1534SU03-1475		14.75	16	115	65	45	48	●
1534SU03C-1475	*	14.75	16	115	65	45	48	●
1534SU03-1480		14.8	16	115	65	45	48	●
1534SU03C-1480	*	14.8	16	115	65	45	48	●
1534SU03-1500		15	16	115	65	45	48	●
1534SU03C-1500	*	15	16	115	65	45	48	●
1534SU03-1510		15.1	16	115	65	45	48	●
1534SU03C-1510	*	15.1	16	115	65	45	48	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C



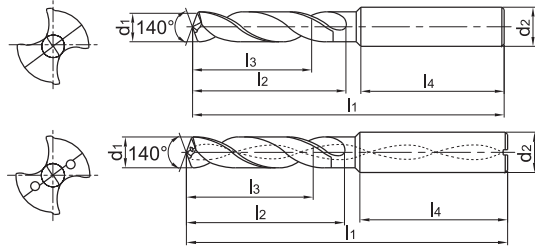
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-1530		15.3	16	115	65	45	48	●
1534SU03C-1535	*	15.35	16	115	65	45	48	○
1534SU03-1550		15.5	16	115	65	45	48	●
1534SU03C-1550	*	15.5	16	115	65	45	48	●
1534SU03-1580		15.8	16	115	65	45	48	●
1534SU03C-1580	*	15.8	16	115	65	45	48	●
1534SU03-1600		16	16	115	65	45	48	●
1534SU03C-1600	*	16	16	115	65	45	48	●
1534SU03-1610		16.1	18	123	73	51	48	●
1534SU03-1650		16.5	18	123	73	51	48	●
1534SU03C-1650	*	16.5	18	123	73	51	48	●
1534SU03-1675		16.75	18	123	73	51	48	●
1534SU03C-1675	*	16.75	18	123	73	51	48	●
1534SU03-1680		16.8	18	123	73	51	48	●
1534SU03C-1680	*	16.8	18	123	73	51	48	●
1534SU03-1700		17	18	123	73	51	48	●
1534SU03C-1700	*	17	18	123	73	51	48	●
1534SU03-1750		17.5	18	123	73	51	48	●
1534SU03C-1750	*	17.5	18	123	73	51	48	●
1534SU03-1780		17.8	18	123	73	51	48	●
1534SU03C-1780	*	17.8	18	123	73	51	48	●
1534SU03-1800		18	18	123	73	51	48	●
1534SU03C-1800	*	18	18	123	73	51	48	●
1534SU03-1850		18.5	20	131	79	55	50	●
1534SU03C-1850	*	18.5	20	131	79	55	50	●
1534SU03-1880		18.8	20	131	79	55	50	●
1534SU03C-1880	*	18.8	20	131	79	55	50	●
1534SU03-1900		19	20	131	79	55	50	●
1534SU03C-1900	*	19	20	131	79	55	50	●
1534SU03-1950		19.5	20	131	79	55	50	●
1534SU03C-1950	*	19.5	20	131	79	55	50	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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A

SU(K) drill 3xD **General machining** Add K (SUK) to the code for use on Cast Iron

Turning

1534SU03/1534SU03C



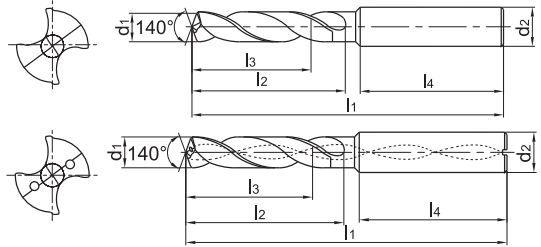
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



B

Milling

Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-1980		19.8	20	131	79	55	50	●
1534SU03C-1980	*	19.8	20	131	79	55	50	●
1534SU03-2000		20	20	131	79	55	50	●
1534SU03C-2000	*	20	20	131	79	55	50	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

C

Drilling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

D

Technical Information

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System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



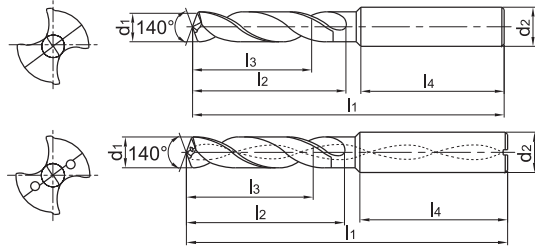
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-0200		2	6	66	28	23	36	●
1536SU05-0210		2.1	6	66	28	23	36	●
1536SU05-0220		2.2	6	66	28	23	36	●
1536SU05-0230		2.3	6	66	28	23	36	●
1536SU05-0240		2.4	6	66	28	23	36	●
1536SU05-0250		2.5	6	66	28	23	36	●
1536SU05-0260		2.6	6	66	28	23	36	●
1536SU05-0270		2.7	6	66	28	23	36	●
1536SU05-0280		2.8	6	66	28	23	36	●
1536SU05-0290		2.9	6	66	28	23	36	●
1536SU05-0300		3	6	66	28	23	36	●
1536SU05C-0300	*	3	6	66	28	23	36	●
1536SU05-0310		3.1	6	66	28	23	36	●
1536SU05C-0310	*	3.1	6	66	28	23	36	●
1536SU05-0320		3.2	6	66	28	23	36	●
1536SU05C-0320	*	3.2	6	66	28	23	36	●
1536SU05-0325		3.25	6	66	28	23	36	●
1536SU05C-0325	*	3.25	6	66	28	23	36	●
1536SU05-0330		3.3	6	66	28	23	36	●
1536SU05C-0330	*	3.3	6	66	28	23	36	●
1536SU05-0340		3.4	6	66	28	23	36	●
1536SU05C-0340	*	3.4	6	66	28	23	36	●
1536SU05-0350		3.5	6	66	28	23	36	●
1536SU05C-0350	*	3.5	6	66	28	23	36	●
1536SU05-0360		3.6	6	66	28	23	36	●
1536SU05C-0360	*	3.6	6	66	28	23	36	●
1536SU05-0370		3.7	6	66	28	23	36	●
1536SU05C-0370	*	3.7	6	66	28	23	36	●
1536SU05-0380		3.8	6	74	36	29	36	●
1536SU05C-0380	*	3.8	6	74	36	29	36	●
1536SU05-0390		3.9	6	74	36	29	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



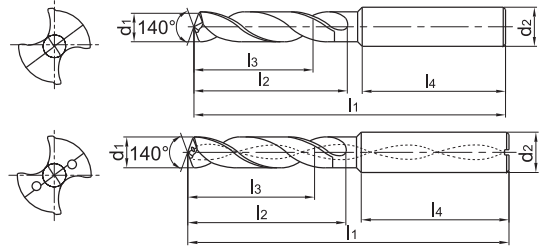
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05C-0390	*	3.9	6	74	36	29	36	●
1536SU05-0400		4	6	74	36	29	36	●
1536SU05C-0400	*	4	6	74	36	29	36	●
1536SU05-0410		4.1	6	74	36	29	36	●
1536SU05C-0410	*	4.1	6	74	36	29	36	●
1536SU05-0420		4.2	6	74	36	29	36	●
1536SU05C-0420	*	4.2	6	74	36	29	36	●
1536SU05-0430		4.3	6	74	36	29	36	●
1536SU05C-0430	*	4.3	6	74	36	29	36	●
1536SU05-0440		4.4	6	74	36	29	36	●
1536SU05C-0440	*	4.4	6	74	36	29	36	●
1536SU05-0450		4.5	6	74	36	29	36	●
1536SU05C-0450	*	4.5	6	74	36	29	36	●
1536SU05-0460		4.6	6	74	36	29	36	●
1536SU05C-0460	*	4.6	6	74	36	29	36	●
1536SU05-0465		4.65	6	74	36	29	36	●
1536SU05C-0465	*	4.65	6	74	36	29	36	●
1536SU05-0470		4.7	6	74	36	29	36	●
1536SU05C-0470	*	4.7	6	74	36	29	36	●
1536SU05-0480		4.8	6	82	44	35	36	●
1536SU05C-0480	*	4.8	6	82	44	35	36	●
1536SU05-0490		4.9	6	82	44	35	36	●
1536SU05C-0490	*	4.9	6	82	44	35	36	●
1536SU05-0500		5	6	82	44	35	36	●
1536SU05C-0500	*	5	6	82	44	35	36	●
1536SU05-0510		5.1	6	82	44	35	36	●
1536SU05C-0510	*	5.1	6	82	44	35	36	●
1536SU05-0520		5.2	6	82	44	35	36	●
1536SU05C-0520	*	5.2	6	82	44	35	36	●
1536SU05-0530		5.3	6	82	44	35	36	●
1536SU05C-0530	*	5.3	6	82	44	35	36	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



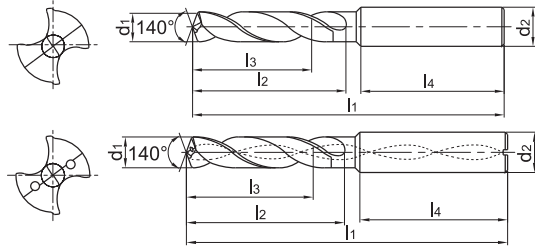
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-0540		5.4	6	82	44	35	36	●
1536SU05C-0540	*	5.4	6	82	44	35	36	●
1536SU05-0550		5.5	6	82	44	35	36	●
1536SU05C-0550	*	5.5	6	82	44	35	36	●
1536SU05-0555		5.55	6	82	44	35	36	●
1536SU05C-0555	*	5.55	6	82	44	35	36	●
1536SU05-0560		5.6	6	82	44	35	36	●
1536SU05C-0560	*	5.6	6	82	44	35	36	●
1536SU05-0570		5.7	6	82	44	35	36	●
1536SU05C-0570	*	5.7	6	82	44	35	36	●
1536SU05-0580		5.8	6	82	44	35	36	●
1536SU05C-0580	*	5.8	6	82	44	35	36	●
1536SU05-0590		5.9	6	82	44	35	36	●
1536SU05C-0590	*	5.9	6	82	44	35	36	●
1536SU05-0600		6	6	82	44	35	36	●
1536SU05C-0600	*	6	6	82	44	35	36	●
1536SU05-0610		6.1	8	91	53	43	36	●
1536SU05C-0610	*	6.1	8	91	53	43	36	●
1536SU05-0620		6.2	8	91	53	43	36	●
1536SU05C-0620	*	6.2	8	91	53	43	36	●
1536SU05-0630		6.3	8	91	53	43	36	●
1536SU05C-0630	*	6.3	8	91	53	43	36	●
1536SU05-0640		6.4	8	91	53	43	36	●
1536SU05C-0640	*	6.4	8	91	53	43	36	●
1536SU05-0650		6.5	8	91	53	43	36	●
1536SU05C-0650	*	6.5	8	91	53	43	36	●
1536SU05-0660		6.6	8	91	53	43	36	●
1536SU05C-0660	*	6.6	8	91	53	43	36	●
1536SU05-0670		6.7	8	91	53	43	36	●
1536SU05C-0670	*	6.7	8	91	53	43	36	●
1536SU05-0675		6.75	8	91	53	43	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



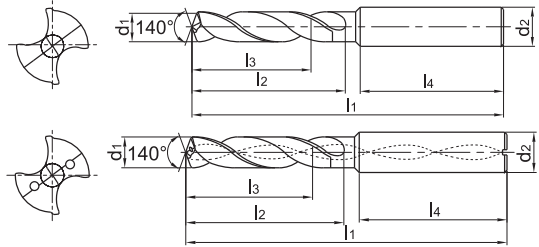
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05C-0675	*	6.75	8	91	53	43	36	●
1536SU05-0680		6.8	8	91	53	43	36	●
1536SU05C-0680	*	6.8	8	91	53	43	36	●
1536SU05-0690		6.9	8	91	53	43	36	●
1536SU05C-0690	*	6.9	8	91	53	43	36	●
1536SU05-0700		7	8	91	53	43	36	●
1536SU05C-0700	*	7	8	91	53	43	36	●
1536SU05-0710		7.1	8	91	53	43	36	●
1536SU05C-0710	*	7.1	8	91	53	43	36	●
1536SU05-0720		7.2	8	91	53	43	36	●
1536SU05C-0720	*	7.2	8	91	53	43	36	●
1536SU05-0730		7.3	8	91	53	43	36	●
1536SU05C-0730	*	7.3	8	91	53	43	36	●
1536SU05-0740		7.4	8	91	53	43	36	●
1536SU05C-0740	*	7.4	8	91	53	43	36	●
1536SU05-0745		7.45	8	91	53	43	36	●
1536SU05C-0745	*	7.45	8	91	53	43	36	●
1536SU05-0750		7.5	8	91	53	43	36	●
1536SU05C-0750	*	7.5	8	91	53	43	36	●
1536SU05-0760		7.6	8	91	53	43	36	●
1536SU05C-0760	*	7.6	8	91	53	43	36	●
1536SU05-0770		7.7	8	91	53	43	36	●
1536SU05C-0770	*	7.7	8	91	53	43	36	●
1536SU05-0780		7.8	8	91	53	43	36	●
1536SU05C-0780	*	7.8	8	91	53	43	36	●
1536SU05-0790		7.9	8	91	53	43	36	●
1536SU05C-0790	*	7.9	8	91	53	43	36	●
1536SU05-0800		8	8	91	53	43	36	●
1536SU05C-0800	*	8	8	91	53	43	36	●
1536SU05-0810		8.1	10	103	61	49	40	●
1536SU05C-0810	*	8.1	10	103	61	49	40	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

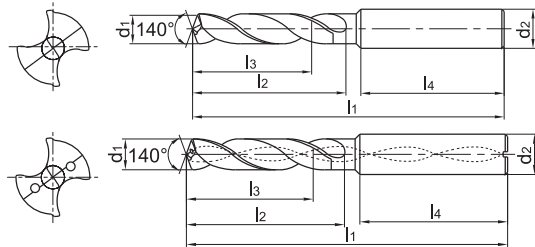
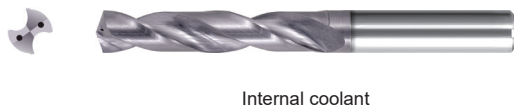
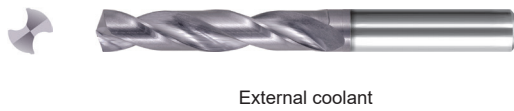
General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-0820		8.2	10	103	61	49	40	●
1536SU05C-0820	*	8.2	10	103	61	49	40	●
1536SU05-0830		8.3	10	103	61	49	40	●
1536SU05C-0830	*	8.3	10	103	61	49	40	●
1536SU05-0840		8.4	10	103	61	49	40	●
1536SU05C-0840	*	8.4	10	103	61	49	40	●
1536SU05-0850		8.5	10	103	61	49	40	●
1536SU05C-0850	*	8.5	10	103	61	49	40	●
1536SU05-0860		8.6	10	103	61	49	40	●
1536SU05C-0860	*	8.6	10	103	61	49	40	●
1536SU05-0870		8.7	10	103	61	49	40	●
1536SU05C-0870	*	8.7	10	103	61	49	40	●
1536SU05-0880		8.8	10	103	61	49	40	●
1536SU05C-0880	*	8.8	10	103	61	49	40	●
1536SU05-0890		8.9	10	103	61	49	40	●
1536SU05C-0890	*	8.9	10	103	61	49	40	●
1536SU05-0900		9	10	103	61	49	40	●
1536SU05C-0900	*	9	10	103	61	49	40	●
1536SU05-0910		9.1	10	103	61	49	40	●
1536SU05C-0910	*	9.1	10	103	61	49	40	●
1536SU05-0920		9.2	10	103	61	49	40	●
1536SU05C-0920	*	9.2	10	103	61	49	40	●
1536SU05-0930		9.3	10	103	61	49	40	●
1536SU05C-0930	*	9.3	10	103	61	49	40	●
1536SU05-0935		9.35	10	103	61	49	40	●
1536SU05C-0935	*	9.35	10	103	61	49	40	○
1536SU05-0940		9.4	10	103	61	49	40	●
1536SU05C-0940	*	9.4	10	103	61	49	40	●
1536SU05-0945		9.45	10	103	61	49	40	●
1536SU05C-0945	*	9.45	10	103	61	49	40	○
1536SU05-0950		9.5	10	103	61	49	40	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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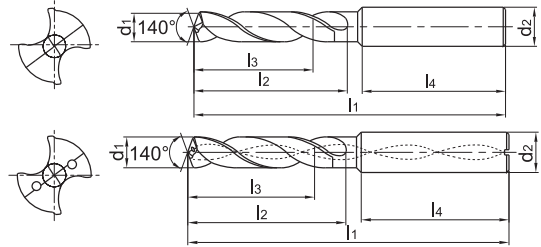
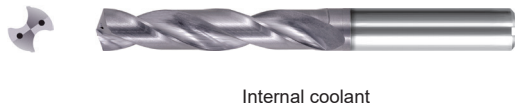
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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05C-0950	*	9.5	10	103	61	49	40	●
1536SU05-0960		9.6	10	103	61	49	40	●
1536SU05C-0960	*	9.6	10	103	61	49	40	●
1536SU05-0970		9.7	10	103	61	49	40	●
1536SU05C-0970	*	9.7	10	103	61	49	40	●
1536SU05-0980		9.8	10	103	61	49	40	●
1536SU05C-0980	*	9.8	10	103	61	49	40	●
1536SU05-0990		9.9	10	103	61	49	40	●
1536SU05C-0990	*	9.9	10	103	61	49	40	●
1536SU05-1000		10	10	103	61	49	40	●
1536SU05C-1000	*	10	10	103	61	49	40	●
1536SU05-1010		10.1	12	118	71	56	45	●
1536SU05C-1010	*	10.1	12	118	71	56	45	●
1536SU05-1020		10.2	12	118	71	56	45	●
1536SU05C-1020	*	10.2	12	118	71	56	45	●
1536SU05-1025		10.25	12	118	71	56	45	●
1536SU05C-1025	*	10.25	12	118	71	56	45	●
1536SU05-1030		10.3	12	118	71	56	45	●
1536SU05C-1030	*	10.3	12	118	71	56	45	●
1536SU05-1040		10.4	12	118	71	56	45	●
1536SU05C-1040	*	10.4	12	118	71	56	45	●
1536SU05-1050		10.5	12	118	71	56	45	●
1536SU05C-1050	*	10.5	12	118	71	56	45	●
1536SU05-1060		10.6	12	118	71	56	45	●
1536SU05C-1060	*	10.6	12	118	71	56	45	●
1536SU05-1070		10.7	12	118	71	56	45	●
1536SU05C-1070	*	10.7	12	118	71	56	45	●
1536SU05-1080		10.8	12	118	71	56	45	●
1536SU05C-1080	*	10.8	12	118	71	56	45	●
1536SU05-1090		10.9	12	118	71	56	45	●
1536SU05C-1090	*	10.9	12	118	71	56	45	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



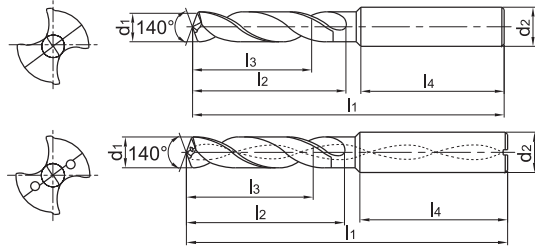
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-1100		11	12	118	71	56	45	●
1536SU05C-1100	*	11	12	118	71	56	45	●
1536SU05-1110		11.1	12	118	71	56	45	●
1536SU05C-1110	*	11.1	12	118	71	56	45	●
1536SU05-1120		11.2	12	118	71	56	45	●
1536SU05C-1120	*	11.2	12	118	71	56	45	●
1536SU05-1125		11.25	12	118	71	56	45	●
1536SU05C-1125	*	11.25	12	118	71	56	45	○
1536SU05-1130		11.3	12	118	71	56	45	●
1536SU05C-1130	*	11.3	12	118	71	56	45	●
1536SU05-1135		11.35	12	118	71	56	45	●
1536SU05C-1135	*	11.35	12	118	71	56	45	○
1536SU05-1140		11.4	12	118	71	56	45	●
1536SU05C-1140	*	11.4	12	118	71	56	45	●
1536SU05-1145		11.45	12	118	71	56	45	○
1536SU05C-1145	*	11.45	12	118	71	56	45	○
1536SU05-1150		11.5	12	118	71	56	45	●
1536SU05C-1150	*	11.5	12	118	71	56	45	●
1536SU05-1160		11.6	12	118	71	56	45	●
1536SU05C-1160	*	11.6	12	118	71	56	45	●
1536SU05-1170		11.7	12	118	71	56	45	●
1536SU05C-1170	*	11.7	12	118	71	56	45	●
1536SU05-1180		11.8	12	118	71	56	45	●
1536SU05C-1180	*	11.8	12	118	71	56	45	●
1536SU05-1190		11.9	12	118	71	56	45	●
1536SU05C-1190	*	11.9	12	118	71	56	45	●
1536SU05-1200		12	12	118	71	56	45	●
1536SU05C-1200	*	12	12	118	71	56	45	●
1536SU05-1210		12.1	14	124	77	60	45	●
1536SU05C-1210	*	12.1	14	124	77	60	45	●
1536SU05-1220		12.2	14	124	77	60	45	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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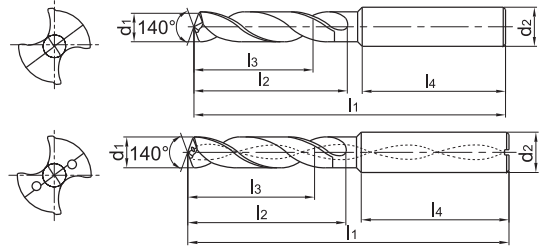
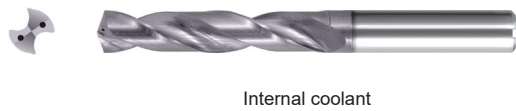
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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05C-1220	*	12.2	14	124	77	60	45	●
1536SU05-1225		12.25	14	124	77	60	45	●
1536SU05C-1225	*	12.25	14	124	77	60	45	●
1536SU05-1230		12.3	14	124	77	60	45	●
1536SU05C-1230	*	12.3	14	124	77	60	45	●
1536SU05-1250		12.5	14	124	77	60	45	●
1536SU05C-1250	*	12.5	14	124	77	60	45	●
1536SU05-1270		12.7	14	124	77	60	45	●
1536SU05C-1270	*	12.7	14	124	77	60	45	●
1536SU05-1275		12.75	14	124	77	60	45	●
1536SU05C-1275	*	12.75	14	124	77	60	45	●
1536SU05-1280		12.8	14	124	77	60	45	●
1536SU05C-1280	*	12.8	14	124	77	60	45	●
1536SU05-1300		13	14	124	77	60	45	●
1536SU05C-1300	*	13	14	124	77	60	45	●
1536SU05-1310		13.1	14	124	77	60	45	●
1536SU05C-1310	*	13.1	14	124	77	60	45	●
1536SU05-1335		13.35	14	124	77	60	56	○
1536SU05C-1335	*	13.35	14	124	77	60	56	○
1536SU05-1350		13.5	14	124	77	60	45	●
1536SU05C-1350	*	13.5	14	124	77	60	45	●
1536SU05-1380		13.8	14	124	77	60	45	●
1536SU05C-1380	*	13.8	14	124	77	60	45	●
1536SU05-1400		14	14	124	77	60	45	●
1536SU05C-1400	*	14	14	124	77	60	45	●
1536SU05-1420		14.2	16	124	77	60	45	●
1536SU05C-1420	*	14.2	16	124	77	60	45	●
1536SU05-1425		14.25	16	133	83	63	48	●
1536SU05C-1425	*	14.25	16	133	83	63	48	●
1536SU05-1430		14.3	16	133	83	63	48	●
1536SU05C-1430	*	14.3	16	133	83	63	48	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



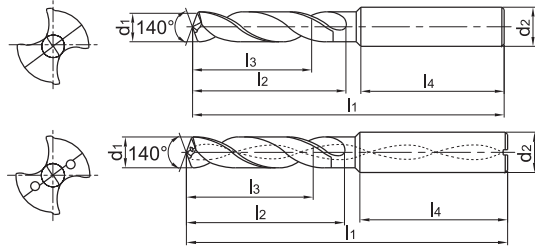
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-1450		14.5	16	133	83	63	48	●
1536SU05C-1450	*	14.5	16	133	83	63	48	●
1536SU05-1475		14.75	16	133	83	63	48	●
1536SU05C-1475	*	14.75	16	133	83	63	48	●
1536SU05-1480		14.8	16	133	83	63	48	●
1536SU05C-1480	*	14.8	16	133	83	63	48	●
1536SU05-1500		15	16	133	83	63	48	●
1536SU05C-1500	*	15	16	133	83	63	48	●
1536SU05-1510		15.1	16	133	83	63	48	●
1536SU05C-1510	*	15.1	16	133	83	63	48	●
1536SU05-1530	*	15.3	16	133	83	63	48	●
1536SU05-1535		15.35	16	133	83	63	48	○
1536SU05C-1535	*	15.35	16	133	83	63	48	○
1536SU05-1550		15.5	16	133	83	63	48	●
1536SU05C-1550	*	15.5	16	133	83	63	48	●
1536SU05-1580		15.8	16	133	83	63	48	●
1536SU05C-1580	*	15.8	16	133	83	63	48	●
1536SU05-1600		16	16	133	83	63	48	●
1536SU05C-1600	*	16	16	133	83	63	48	●
1536SU05-1650		16.5	18	143	93	71	48	●
1536SU05C-1650	*	16.5	18	143	93	71	48	●
1536SU05-1675		16.75	18	143	93	71	48	●
1536SU05C-1675	*	16.75	18	143	93	71	48	●
1536SU05-1680		16.8	18	143	93	71	48	●
1536SU05C-1680	*	16.8	18	143	93	71	48	●
1536SU05-1700		17	18	143	93	71	48	●
1536SU05C-1700	*	17	18	143	93	71	48	●
1536SU05-1750		17.5	18	143	93	71	48	●
1536SU05C-1750	*	17.5	18	143	93	71	48	●
1536SU05-1780		17.8	18	143	93	71	48	●
1536SU05C-1780	*	17.8	18	143	93	71	48	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



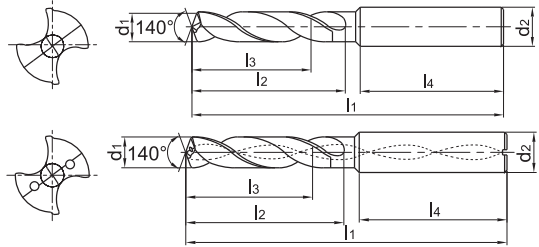
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-1800		18	18	143	93	71	48	●
1536SU05C-1800	*	18	18	143	93	71	48	●
1536SU05-1850		18.5	20	153	101	77	50	●
1536SU05C-1850	*	18.5	20	153	101	77	50	●
1536SU05-1880		18.8	20	153	101	77	50	●
1536SU05C-1880	*	18.8	20	153	101	77	50	●
1536SU05-1900		19	20	153	101	77	50	●
1536SU05C-1900	*	19	20	153	101	77	50	●
1536SU05-1950		19.5	20	153	101	77	50	●
1536SU05C-1950	*	19.5	20	153	101	77	50	●
1536SU05-1980		19.8	20	153	101	77	50	●
1536SU05C-1980	*	19.8	20	153	101	77	50	●
1536SU05-2000		20	20	153	101	77	50	●
1536SU05C-2000	*	20	20	153	101	77	50	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 8xD

General machining

Add K (SUK) to the code for use on Cast Iron

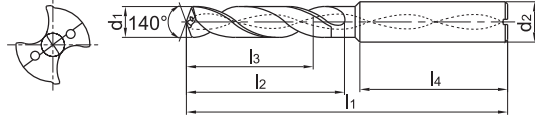
1538SU08C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1538SU08C-0300	*	3	6	72	34	29	36	●
1538SU08C-0310	*	3.1	6	72	34	29	36	●
1538SU08C-0320	*	3.2	6	72	34	29	36	●
1538SU08C-0330	*	3.3	6	72	34	29	36	●
1538SU08C-0340	*	3.4	6	72	34	29	36	●
1538SU08C-0350	*	3.5	6	72	34	29	36	●
1538SU08C-0360	*	3.6	6	72	34	29	36	●
1538SU08C-0370	*	3.7	6	72	34	29	36	●
1538SU08C-0380	*	3.8	6	81	43	36	36	●
1538SU08C-0390	*	3.9	6	81	43	36	36	●
1538SU08C-0400	*	4	6	81	43	36	36	●
1538SU08C-0410	*	4.1	6	81	43	36	36	●
1538SU08C-0420	*	4.2	6	81	43	36	36	●
1538SU08C-0430	*	4.3	6	81	43	36	36	●
1538SU08C-0440	*	4.4	6	81	43	36	36	●
1538SU08C-0450	*	4.5	6	81	43	36	36	●
1538SU08C-0460	*	4.6	6	81	43	36	36	●
1538SU08C-0470	*	4.7	6	81	43	36	36	●
1538SU08C-0480	*	4.8	6	95	57	48	36	●
1538SU08C-0490	*	4.9	6	95	57	48	36	●
1538SU08C-0500	*	5	6	95	57	48	36	●
1538SU08C-0510	*	5.1	6	95	57	48	36	●
1538SU08C-0520	*	5.2	6	95	57	48	36	●
1538SU08C-0530	*	5.3	6	95	57	48	36	●
1538SU08C-0540	*	5.4	6	95	57	48	36	●
1538SU08C-0550	*	5.5	6	95	57	48	36	●
1538SU08C-0560	*	5.6	6	95	57	48	36	●
1538SU08C-0570	*	5.7	6	95	57	48	36	●
1538SU08C-0580	*	5.8	6	95	57	48	36	●
1538SU08C-0590	*	5.9	6	95	57	48	36	●
1538SU08C-0600	*	6	6	95	57	48	36	●
1538SU08C-0610	*	6.1	8	114	76	66	36	●
1538SU08C-0620	*	6.2	8	114	76	66	36	●
1538SU08C-0630	*	6.3	8	114	76	66	36	●
1538SU08C-0640	*	6.4	8	114	76	66	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1538SU*	✓	✓	✓			
1538SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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Solid carbide drills SU series

SU(K) drill 8xD

General machining

Add K (SUK) to the code for use on Cast Iron

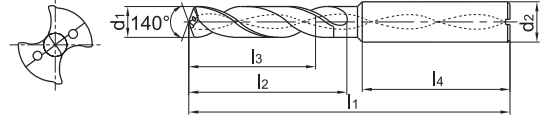
1538SU08C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1538SU08C-0650	*	6.5	8	114	76	66	36	●
1538SU08C-0660	*	6.6	8	114	76	66	36	●
1538SU08C-0670	*	6.7	8	114	76	66	36	●
1538SU08C-0680	*	6.8	8	114	76	66	36	●
1538SU08C-0690	*	6.9	8	114	76	66	36	●
1538SU08C-0700	*	7	8	116	76	66	36	●
1538SU08C-0710	*	7.1	8	116	76	66	36	●
1538SU08C-0720	*	7.2	8	116	76	66	36	●
1538SU08C-0730	*	7.3	8	116	76	66	36	●
1538SU08C-0740	*	7.4	8	116	76	66	36	●
1538SU08C-0750	*	7.5	8	116	76	66	36	●
1538SU08C-0760	*	7.6	8	116	76	66	36	●
1538SU08C-0770	*	7.7	8	116	76	66	36	●
1538SU08C-0780	*	7.8	8	116	76	66	36	●
1538SU08C-0790	*	7.9	8	116	76	66	36	●
1538SU08C-0800	*	8	8	116	76	66	36	●
1538SU08C-0810	*	8.1	10	142	95	83	40	●
1538SU08C-0820	*	8.2	10	142	95	83	40	●
1538SU08C-0830	*	8.3	10	142	95	83	40	●
1538SU08C-0840	*	8.4	10	142	95	83	40	●
1538SU08C-0850	*	8.5	10	142	95	83	40	●
1538SU08C-0860	*	8.6	10	142	95	83	40	●
1538SU08C-0870	*	8.7	10	142	95	83	40	●
1538SU08C-0880	*	8.8	10	142	95	83	40	●
1538SU08C-0890	*	8.9	10	142	95	83	40	●
1538SU08C-0900	*	9	10	142	95	83	40	●
1538SU08C-0910	*	9.1	10	142	95	83	40	●
1538SU08C-0920	*	9.2	10	142	95	83	40	●
1538SU08C-0930	*	9.3	10	142	95	83	40	●
1538SU08C-0940	*	9.4	10	142	95	83	40	●
1538SU08C-0950	*	9.5	10	142	95	83	40	●
1538SU08C-0960	*	9.6	10	142	95	83	40	●
1538SU08C-0970	*	9.7	10	142	95	83	40	●
1538SU08C-0980	*	9.8	10	142	95	83	40	●
1538SU08C-0990	*	9.9	10	142	95	83	40	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1538SU*	✓	✓	✓			
1538SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 8xD

General machining

Add K (SUK) to the code for use on Cast Iron

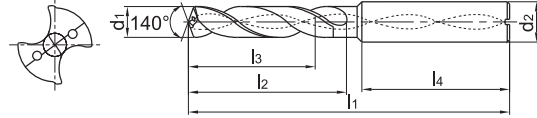
1538SU08C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1538SU08C-1000	*	10	10	142	95	83	40	●
1538SU08C-1010	*	10.1	12	162	114	99	45	●
1538SU08C-1020	*	10.2	12	162	114	99	45	●
1538SU08C-1030	*	10.3	12	162	114	99	45	●
1538SU08C-1040	*	10.4	12	162	114	99	45	●
1538SU08C-1050	*	10.5	12	162	114	99	45	●
1538SU08C-1060	*	10.6	12	162	114	99	45	●
1538SU08C-1070	*	10.7	12	162	114	99	45	●
1538SU08C-1080	*	10.8	12	162	114	99	45	●
1538SU08C-1090	*	10.9	12	162	114	99	45	●
1538SU08C-1100	*	11	12	162	114	99	45	●
1538SU08C-1110	*	11.1	12	162	114	99	45	●
1538SU08C-1120	*	11.2	12	162	114	99	45	●
1538SU08C-1130	*	11.3	12	162	114	99	45	●
1538SU08C-1140	*	11.4	12	162	114	99	45	●
1538SU08C-1150	*	11.5	12	162	114	99	45	●
1538SU08C-1160	*	11.6	12	162	114	99	45	●
1538SU08C-1170	*	11.7	12	162	114	99	45	●
1538SU08C-1180	*	11.8	12	162	114	99	45	●
1538SU08C-1190	*	11.9	12	162	114	99	45	●
1538SU08C-1200	*	12	12	162	114	99	45	●
1538SU08C-1250	*	12.5	14	178	133	116	45	●
1538SU08C-1270	*	12.7	14	178	133	116	45	●
1538SU08C-1280	*	12.8	14	178	133	116	45	●
1538SU08C-1300	*	13	14	178	133	116	45	●
1538SU08C-1350	*	13.5	14	178	133	116	45	●
1538SU08C-1400	*	14	14	178	133	116	45	●
1538SU08C-1450	*	14.5	16	204	152	132	48	●
1538SU08C-1480	*	14.8	16	204	152	132	48	●
1538SU08C-1500	*	15	16	204	152	132	48	●
1538SU08C-1550	*	15.5	16	204	152	132	48	●
1538SU08C-1600	*	16	16	204	152	132	48	●
1538SU08C-1650	*	16.5	18	223	171	149	48	●
1538SU08C-1700	*	17	18	223	171	149	48	●
1538SU08C-1750	*	17.5	18	223	171	149	48	●
1538SU08C-1800	*	18	18	223	171	149	48	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field						
Type	P	M	K	N	S	H
1538SU*	✓	✓	✓			
1538SUK*			✓			

- ✓ Very suitable
- ✓ Suitable



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SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

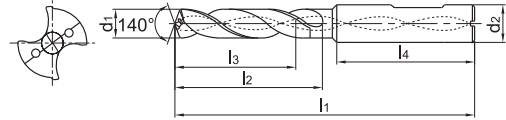
1634SU03C



- Type of shank: DIN 6535HB
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1634SU03C-0300	*	3	6	62	20	14	36	●
1634SU03C-0310	*	3.1	6	62	20	14	36	●
1634SU03C-0320	*	3.2	6	62	20	14	36	●
1634SU03C-0325	*	3.25	6	62	20	14	36	○
1634SU03C-0330	*	3.3	6	62	20	14	36	●
1634SU03C-0340	*	3.4	6	62	20	14	36	●
1634SU03C-0350	*	3.5	6	62	20	14	36	●
1634SU03C-0360	*	3.6	6	62	20	14	36	●
1634SU03C-0370	*	3.7	6	62	20	14	36	●
1634SU03C-0380	*	3.8	6	66	24	17	36	●
1634SU03C-0390	*	3.9	6	66	24	17	36	●
1634SU03C-0400	*	4	6	66	24	17	36	●
1634SU03C-0410	*	4.1	6	66	24	17	36	●
1634SU03C-0420	*	4.2	6	66	24	17	36	●
1634SU03C-0430	*	4.3	6	66	24	17	36	●
1634SU03C-0440	*	4.4	6	66	24	17	36	●
1634SU03C-0450	*	4.5	6	66	24	17	36	●
1634SU03C-0460	*	4.6	6	66	24	17	36	●
1634SU03C-0465	*	4.65	6	66	24	17	36	○
1634SU03C-0470	*	4.7	6	66	24	17	36	●
1634SU03C-0480	*	4.8	6	66	28	20	36	●
1634SU03C-0490	*	4.9	6	66	28	20	36	●
1634SU03C-0500	*	5	6	66	28	20	36	●
1634SU03C-0510	*	5.1	6	66	28	20	36	●
1634SU03C-0520	*	5.2	6	66	28	20	36	●
1634SU03C-0530	*	5.3	6	66	28	20	36	●
1634SU03C-0540	*	5.4	6	66	28	20	36	●
1634SU03C-0550	*	5.5	6	66	28	20	36	●
1634SU03C-0555	*	5.55	6	66	28	20	36	●
1634SU03C-0560	*	5.6	6	66	28	20	36	●
1634SU03C-0570	*	5.7	6	66	28	20	36	●
1634SU03C-0580	*	5.8	6	66	28	20	36	●
1634SU03C-0590	*	5.9	6	66	28	20	36	●
1634SU03C-0600	*	6	6	66	28	20	36	●
1634SU03C-0610	*	6.1	8	79	34	24	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1634SU*	✓	✓	✓			
1634SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

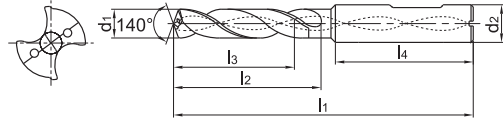
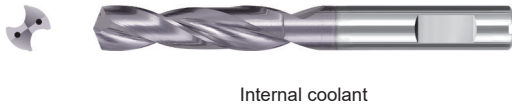
General machining

Add K (SUK) to the code for use on Cast Iron

1634SU03C



- Type of shank: DIN 6535HB
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1634SU03C-0620	*	6.2	8	79	34	24	36	●
1634SU03C-0630	*	6.3	8	79	34	24	36	●
1634SU03C-0640	*	6.4	8	79	34	24	36	●
1634SU03C-0650	*	6.5	8	79	34	24	36	●
1634SU03C-0660	*	6.6	8	79	34	24	36	●
1634SU03C-0670	*	6.7	8	79	34	24	36	●
1634SU03C-0675	*	6.75	8	79	34	24	36	○
1634SU03C-0680	*	6.8	8	79	34	24	36	●
1634SU03C-0690	*	6.9	8	79	34	24	36	●
1634SU03C-0700	*	7	8	79	34	24	36	●
1634SU03C-0710	*	7.1	8	79	41	29	36	●
1634SU03C-0720	*	7.2	8	79	41	29	36	●
1634SU03C-0730	*	7.3	8	79	41	29	36	●
1634SU03C-0740	*	7.4	8	79	41	29	36	●
1634SU03C-0745	*	7.45	8	79	41	29	36	○
1634SU03C-0750	*	7.5	8	79	41	29	36	●
1634SU03C-0760	*	7.6	8	79	41	29	36	●
1634SU03C-0770	*	7.7	8	79	41	29	36	●
1634SU03C-0780	*	7.8	8	79	41	29	36	●
1634SU03C-0790	*	7.9	8	79	41	29	36	●
1634SU03C-0800	*	8	8	79	41	29	36	●
1634SU03C-0810	*	8.1	10	89	47	35	40	●
1634SU03C-0820	*	8.2	10	89	47	35	40	●
1634SU03C-0830	*	8.3	10	89	47	35	40	●
1634SU03C-0840	*	8.4	10	89	47	35	40	●
1634SU03C-0850	*	8.5	10	89	47	35	40	●
1634SU03C-0860	*	8.6	10	89	47	35	40	●
1634SU03C-0870	*	8.7	10	89	47	35	40	●
1634SU03C-0880	*	8.8	10	89	47	35	40	●
1634SU03C-0890	*	8.9	10	89	47	35	40	●
1634SU03C-0900	*	9	10	89	47	35	40	●
1634SU03C-0910	*	9.1	10	89	47	35	40	●
1634SU03C-0920	*	9.2	10	89	47	35	40	●
1634SU03C-0930	*	9.3	10	89	47	35	40	●
1634SU03C-0935	*	9.35	10	89	47	35	40	○

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1634SU*	✓	✓	✓			
1634SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

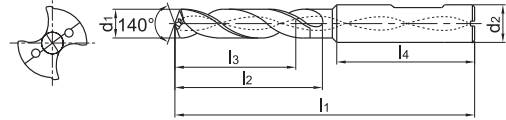
1634SU03C



- Type of shank: DIN 6535HB
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1634SU03C-0940	*	9.4	10	89	47	35	40	●
1634SU03C-0945	*	9.45	10	89	47	35	40	○
1634SU03C-0950	*	9.5	10	89	47	35	40	●
1634SU03C-0960	*	9.6	10	89	47	35	40	●
1634SU03C-0970	*	9.7	10	89	47	35	40	●
1634SU03C-0980	*	9.8	10	89	47	35	40	●
1634SU03C-0990	*	9.9	10	89	47	35	40	●
1634SU03C-1000	*	10	10	89	47	35	40	●
1634SU03C-1010	*	10.1	12	102	55	40	45	●
1634SU03C-1020	*	10.2	12	102	55	40	45	●
1634SU03C-1025	*	10.25	12	102	55	40	45	○
1634SU03C-1030	*	10.3	12	102	55	40	45	●
1634SU03C-1040	*	10.4	12	102	55	40	45	●
1634SU03C-1050	*	10.5	12	102	55	40	45	●
1634SU03C-1060	*	10.6	12	102	55	40	45	●
1634SU03C-1070	*	10.7	12	102	55	40	45	●
1634SU03C-1080	*	10.8	12	102	55	40	45	●
1634SU03C-1090	*	10.9	12	102	55	40	45	●
1634SU03C-1100	*	11	12	102	55	40	45	●
1634SU03C-1110	*	11.1	12	102	55	40	45	●
1634SU03C-1120	*	11.2	12	102	55	40	45	●
1634SU03C-1125	*	11.25	12	102	55	40	45	○
1634SU03C-1130	*	11.3	12	102	55	40	45	●
1634SU03C-1135	*	11.35	12	102	55	40	45	○
1634SU03C-1140	*	11.4	12	102	55	40	45	●
1634SU03C-1145	*	11.45	12	102	55	40	45	○
1634SU03C-1150	*	11.5	12	102	55	40	45	●
1634SU03C-1160	*	11.6	12	102	55	40	45	●
1634SU03C-1170	*	11.7	12	102	55	40	45	●
1634SU03C-1180	*	11.8	12	102	55	40	45	●
1634SU03C-1190	*	11.9	12	102	55	40	45	●
1634SU03C-1200	*	12	12	102	55	40	45	●
1634SU03C-1210	*	12.1	14	107	60	43	45	●
1634SU03C-1220	*	12.2	14	107	60	43	45	●
1634SU03C-1225	*	12.25	14	107	60	43	45	○

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1634SU*	✓	✓	✓			
1634SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

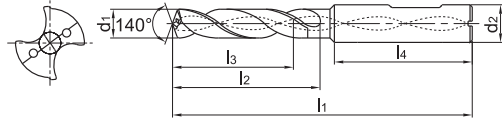
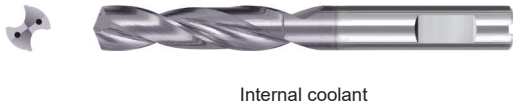
General machining

Add K (SUK) to the code for use on Cast Iron

1634SU03C



- Type of shank: DIN 6535HB
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1634SU03C-1230	*	12.3	14	107	60	43	45	●
1634SU03C-1250	*	12.5	14	107	60	43	45	●
1634SU03C-1270	*	12.7	14	107	60	43	45	●
1634SU03C-1275	*	12.75	14	107	60	43	45	○
1634SU03C-1280	*	12.8	14	107	60	43	45	●
1634SU03C-1300	*	13	14	107	60	43	45	●
1634SU03C-1310	*	13.1	14	107	60	43	45	●
1634SU03C-1335	*	13.35	14	107	60	43	45	○
1634SU03C-1350	*	13.5	14	107	60	43	45	●
1634SU03C-1380	*	13.8	14	107	60	43	45	●
1634SU03C-1400	*	14	14	107	60	43	45	●
1634SU03C-1420	*	14.2	16	107	60	43	45	○
1634SU03C-1425	*	14.25	16	115	65	45	48	○
1634SU03C-1430	*	14.3	16	115	65	45	48	○
1634SU03C-1450	*	14.5	16	115	65	45	48	●
1634SU03C-1475	*	14.75	16	115	65	45	48	○
1634SU03C-1480	*	14.8	16	115	65	45	48	●
1634SU03C-1500	*	15	16	115	65	45	48	●
1634SU03C-1510	*	15.1	16	115	65	45	48	○
1634SU03C-1535	*	15.35	16	115	65	45	48	○
1634SU03C-1550	*	15.5	16	115	65	45	48	○
1634SU03C-1580	*	15.8	16	115	65	45	48	○
1634SU03C-1600	*	16	16	115	65	45	48	●
1634SU03C-1650	*	16.5	18	123	73	51	48	○
1634SU03C-1675	*	16.75	18	123	73	51	48	○
1634SU03C-1680	*	16.8	18	123	73	51	48	○
1634SU03C-1700	*	17	18	123	73	51	48	●
1634SU03C-1750	*	17.5	18	123	73	51	48	●
1634SU03C-1780	*	17.8	18	123	73	51	48	○
1634SU03C-1800	*	18	18	123	73	51	48	●
1634SU03C-1850	*	18.5	20	131	79	55	50	○
1634SU03C-1880	*	18.8	20	131	79	55	50	○
1634SU03C-1900	*	19	20	131	79	55	50	○
1634SU03C-1950	*	19.5	20	131	79	55	50	●
1634SU03C-1980	*	19.8	20	131	79	55	50	○
1634SU03C-2000	*	20	20	131	79	55	50	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field						
Type	P	M	K	N	S	H
1634SU*	✓	✓	✓			
1634SUK*			✓			

- ✓ Very suitable
- ✓ Suitable



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SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

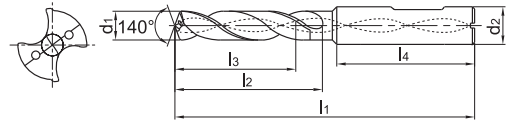
1636SU05C



- Type of shank: DIN 6535HB
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1636SU05C-0300	*	3	6	62	20	14	36	●
1636SU05C-0310	*	3.1	6	66	28	23	36	●
1636SU05C-0320	*	3.2	6	66	28	23	36	●
1636SU05C-0325	*	3.25	6	66	28	23	36	○
1636SU05C-0330	*	3.3	6	66	28	23	36	●
1636SU05C-0340	*	3.4	6	66	28	23	36	●
1636SU05C-0350	*	3.5	6	66	28	23	36	●
1636SU05C-0360	*	3.6	6	66	28	23	36	●
1636SU05C-0370	*	3.7	6	66	28	23	36	●
1636SU05C-0380	*	3.8	6	74	36	29	36	●
1636SU05C-0390	*	3.9	6	74	36	29	36	●
1636SU05C-0400	*	4	6	74	36	29	36	●
1636SU05C-0410	*	4.1	6	74	36	29	36	●
1636SU05C-0420	*	4.2	6	74	36	29	36	●
1636SU05C-0430	*	4.3	6	74	36	29	36	●
1636SU05C-0440	*	4.4	6	74	36	29	36	●
1636SU05C-0450	*	4.5	6	74	36	29	36	●
1636SU05C-0460	*	4.6	6	74	36	29	36	●
1636SU05C-0465	*	4.65	6	74	36	29	36	●
1636SU05C-0470	*	4.7	6	74	36	29	36	●
1636SU05C-0480	*	4.8	6	82	44	35	36	●
1636SU05C-0490	*	4.9	6	82	44	35	36	●
1636SU05C-0500	*	5	6	82	44	35	36	●
1636SU05C-0510	*	5.1	6	82	44	35	36	●
1636SU05C-0520	*	5.2	6	82	44	35	36	●
1636SU05C-0530	*	5.3	6	82	44	35	36	●
1636SU05C-0540	*	5.4	6	82	44	35	36	●
1636SU05C-0550	*	5.5	6	82	44	35	36	●
1636SU05C-0555	*	5.55	6	82	44	35	36	●
1636SU05C-0560	*	5.6	6	82	44	35	36	●
1636SU05C-0570	*	5.7	6	82	44	35	36	●
1636SU05C-0580	*	5.8	6	82	44	35	36	●
1636SU05C-0590	*	5.9	6	82	44	35	36	●
1636SU05C-0600	*	6	6	82	44	35	36	●
1636SU05C-0610	*	6.1	8	91	53	43	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1636SU*	✓	✓	✓			
1636SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

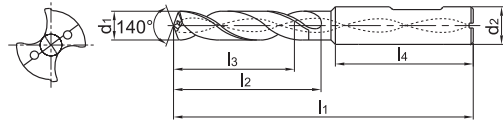
General machining

Add K (SUK) to the code for use on Cast Iron

1636SU05C



- Type of shank: DIN 6535HB
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1636SU05C-0620	*	6.2	8	91	53	43	36	●
1636SU05C-0630	*	6.3	8	91	53	43	36	●
1636SU05C-0640	*	6.4	8	91	53	43	36	●
1636SU05C-0650	*	6.5	8	91	53	43	36	●
1636SU05C-0660	*	6.6	8	91	53	43	36	●
1636SU05C-0670	*	6.7	8	91	53	43	36	●
1636SU05C-0675	*	6.75	8	91	53	43	36	●
1636SU05C-0680	*	6.8	8	91	53	43	36	●
1636SU05C-0690	*	6.9	8	91	53	43	36	●
1636SU05C-0700	*	7	8	91	53	43	36	●
1636SU05C-0710	*	7.1	8	91	53	43	36	●
1636SU05C-0720	*	7.2	8	91	53	43	36	●
1636SU05C-0730	*	7.3	8	91	53	43	36	●
1636SU05C-0740	*	7.4	8	91	53	43	36	●
1636SU05C-0745	*	7.45	8	91	53	43	36	●
1636SU05C-0750	*	7.5	8	91	53	43	36	●
1636SU05C-0760	*	7.6	8	91	53	43	36	●
1636SU05C-0770	*	7.7	8	91	53	43	36	●
1636SU05C-0780	*	7.8	8	91	53	43	36	●
1636SU05C-0790	*	7.9	8	91	53	43	36	●
1636SU05C-0800	*	8	8	91	53	43	36	●
1636SU05C-0810	*	8.1	10	103	61	49	40	●
1636SU05C-0820	*	8.2	10	103	61	49	40	●
1636SU05C-0830	*	8.3	10	103	61	49	40	●
1636SU05C-0840	*	8.4	10	103	61	49	40	●
1636SU05C-0850	*	8.5	10	103	61	49	40	●
1636SU05C-0860	*	8.6	10	103	61	49	40	●
1636SU05C-0870	*	8.7	10	103	61	49	40	●
1636SU05C-0880	*	8.8	10	103	61	49	40	●
1636SU05C-0890	*	8.9	10	103	61	49	40	●
1636SU05C-0900	*	9	10	103	61	49	40	●
1636SU05C-0910	*	9.1	10	103	61	49	40	●
1636SU05C-0920	*	9.2	10	103	61	49	40	●
1636SU05C-0930	*	9.3	10	103	61	49	40	●
1636SU05C-0935	*	9.35	10	103	61	49	40	○

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1636SU*	✓	✓	✓			
1636SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

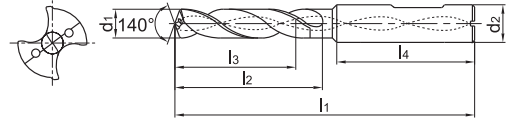
1636SU05C



- Type of shank: DIN 6535HB
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1636SU05C-0940	*	9.4	10	103	61	49	40	●
1636SU05C-0945	*	9.45	10	103	61	49	40	○
1636SU05C-0950	*	9.5	10	103	61	49	40	●
1636SU05C-0960	*	9.6	10	103	61	49	40	●
1636SU05C-0970	*	9.7	10	103	61	49	40	●
1636SU05C-0980	*	9.8	10	103	61	49	40	●
1636SU05C-0990	*	9.9	10	103	61	49	40	●
1636SU05C-1000	*	10	10	103	61	49	40	●
1636SU05C-1010	*	10.1	12	118	71	56	45	●
1636SU05C-1020	*	10.2	12	118	71	56	45	●
1636SU05C-1025	*	10.25	12	118	71	56	45	●
1636SU05C-1030	*	10.3	12	118	71	56	45	●
1636SU05C-1040	*	10.4	12	118	71	56	45	●
1636SU05C-1050	*	10.5	12	118	71	56	45	●
1636SU05C-1060	*	10.6	12	118	71	56	45	●
1636SU05C-1070	*	10.7	12	118	71	56	45	●
1636SU05C-1080	*	10.8	12	118	71	56	45	●
1636SU05C-1090	*	10.9	12	118	71	56	45	●
1636SU05C-1100	*	11	12	118	71	56	45	●
1636SU05C-1110	*	11.1	12	118	71	56	45	●
1636SU05C-1120	*	11.2	12	118	71	56	45	●
1636SU05C-1125	*	11.25	12	118	71	56	45	○
1636SU05C-1130	*	11.3	12	118	71	56	45	●
1636SU05C-1135	*	11.35	12	118	71	56	45	○
1636SU05C-1140	*	11.4	12	118	71	56	45	●
1636SU05C-1145	*	11.45	12	118	71	56	45	○
1636SU05C-1150	*	11.5	12	118	71	56	45	●
1636SU05C-1160	*	11.6	12	118	71	56	45	●
1636SU05C-1170	*	11.7	12	118	71	56	45	●
1636SU05C-1180	*	11.8	12	118	71	56	45	●
1636SU05C-1190	*	11.9	12	118	71	56	45	●
1636SU05C-1200	*	12	12	118	71	56	45	●
1636SU05C-1210	*	12.1	14	124	77	60	45	●
1636SU05C-1220	*	12.2	14	124	77	60	45	●
1636SU05C-1225	*	12.25	14	124	77	60	45	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1636SU*	✓	✓	✓			
1636SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

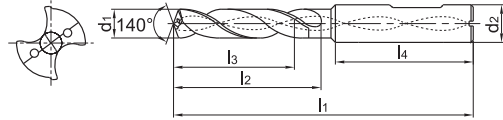
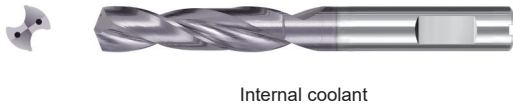
General machining

Add K (SUK) to the code for use on Cast Iron

1636SU05C



- Type of shank: DIN 6535HB
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1636SU05C-1230	*	12.3	14	124	77	60	45	●
1636SU05C-1250	*	12.5	14	124	77	60	45	●
1636SU05C-1270	*	12.7	14	124	77	60	45	●
1636SU05C-1275	*	12.75	14	124	77	60	45	○
1636SU05C-1280	*	12.8	14	124	77	60	45	●
1636SU05C-1300	*	13	14	124	77	60	45	●
1636SU05C-1310	*	13.1	14	124	77	60	45	●
1636SU05C-1335	*	13.35	14	124	77	60	56	○
1636SU05C-1350	*	13.5	14	124	77	60	45	●
1636SU05C-1380	*	13.8	14	124	77	60	45	●
1636SU05C-1400	*	14	14	124	77	60	45	●
1636SU05C-1420	*	14.2	16	124	77	60	45	●
1636SU05C-1425	*	14.25	16	133	83	63	48	●
1636SU05C-1430	*	14.3	16	133	83	63	48	●
1636SU05C-1450	*	14.5	16	133	83	63	48	●
1636SU05C-1475	*	14.75	16	133	83	63	48	○
1636SU05C-1480	*	14.8	16	133	83	63	48	●
1636SU05C-1500	*	15	16	133	83	63	48	●
1636SU05C-1510	*	15.1	16	133	83	63	48	●
1636SU05C-1535	*	15.35	16	133	83	63	48	○
1636SU05C-1550	*	15.5	16	133	83	63	48	●
1636SU05C-1580	*	15.8	16	133	83	63	48	●
1636SU05C-1600	*	16	16	133	83	63	48	●
1636SU05C-1650	*	16.5	18	143	93	71	48	●
1636SU05C-1675	*	16.75	18	143	93	71	48	○
1636SU05C-1680	*	16.8	18	143	93	71	48	●
1636SU05C-1700	*	17	18	143	93	71	48	●
1636SU05C-1750	*	17.5	18	143	93	71	48	●
1636SU05C-1780	*	17.8	18	143	93	71	48	●
1636SU05C-1800	*	18	18	143	93	71	48	●
1636SU05C-1850	*	18.5	20	153	101	77	50	●
1636SU05C-1880	*	18.8	20	153	101	77	50	●
1636SU05C-1900	*	19	20	153	101	77	50	●
1636SU05C-1950	*	19.5	20	153	101	77	50	●
1636SU05C-1980	*	19.8	20	153	101	77	50	●
1636SU05C-2000	*	20	20	153	101	77	50	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field						
Type	P	M	K	N	S	H
1636SU*	✓	✓	✓			
1636SUK*			✓			

- ✓ Very suitable
- ✓ Suitable



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SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

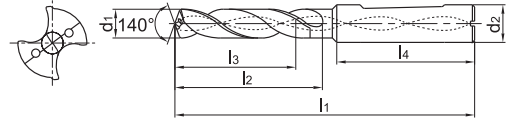
1734SU03C



- Whistle Notch clamping surface
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1734SU03C-0300	*	3	6	66	28	23	36	●
1734SU03C-0310	*	3.1	6	62	20	14	36	●
1734SU03C-0320	*	3.2	6	62	20	14	36	●
1734SU03C-0325	*	3.25	6	62	20	14	36	○
1734SU03C-0330	*	3.3	6	62	20	14	36	●
1734SU03C-0340	*	3.4	6	62	20	14	36	●
1734SU03C-0350	*	3.5	6	62	20	14	36	●
1734SU03C-0360	*	3.6	6	62	20	14	36	●
1734SU03C-0370	*	3.7	6	62	20	14	36	●
1734SU03C-0380	*	3.8	6	66	24	17	36	●
1734SU03C-0390	*	3.9	6	66	24	17	36	●
1734SU03C-0400	*	4	6	66	24	17	36	●
1734SU03C-0410	*	4.1	6	66	24	17	36	●
1734SU03C-0420	*	4.2	6	66	24	17	36	●
1734SU03C-0430	*	4.3	6	66	24	17	36	●
1734SU03C-0440	*	4.4	6	66	24	17	36	●
1734SU03C-0450	*	4.5	6	66	24	17	36	●
1734SU03C-0460	*	4.6	6	66	24	17	36	●
1734SU03C-0465	*	4.65	6	66	24	17	36	○
1734SU03C-0470	*	4.7	6	66	24	17	36	●
1734SU03C-0480	*	4.8	6	66	28	20	36	●
1734SU03C-0490	*	4.9	6	66	28	20	36	●
1734SU03C-0500	*	5	6	66	28	20	36	●
1734SU03C-0510	*	5.1	6	66	28	20	36	●
1734SU03C-0520	*	5.2	6	66	28	20	36	●
1734SU03C-0530	*	5.3	6	66	28	20	36	●
1734SU03C-0540	*	5.4	6	66	28	20	36	●
1734SU03C-0550	*	5.5	6	66	28	20	36	●
1734SU03C-0555	*	5.55	6	66	28	20	36	●
1734SU03C-0560	*	5.6	6	66	28	20	36	●
1734SU03C-0570	*	5.7	6	66	28	20	36	●
1734SU03C-0580	*	5.8	6	66	28	20	36	●
1734SU03C-0590	*	5.9	6	66	28	20	36	●
1734SU03C-0600	*	6	6	66	28	20	36	●
1734SU03C-0610	*	6.1	8	79	34	24	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1734SU*	✓	✓	✓			
1734SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

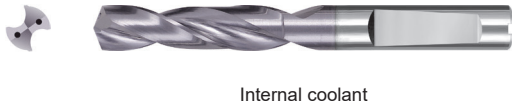
General machining

Add K (SUK) to the code for use on Cast Iron

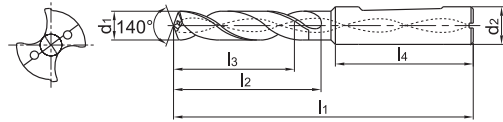
1734SU03C



- Whistle Notch clamping surface
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1734SU03C-0620	*	6.2	8	79	34	24	36	●
1734SU03C-0630	*	6.3	8	79	34	24	36	●
1734SU03C-0640	*	6.4	8	79	34	24	36	●
1734SU03C-0650	*	6.5	8	79	34	24	36	●
1734SU03C-0660	*	6.6	8	79	34	24	36	●
1734SU03C-0670	*	6.7	8	79	34	24	36	●
1734SU03C-0675	*	6.75	8	79	34	24	36	●
1734SU03C-0680	*	6.8	8	79	34	24	36	●
1734SU03C-0690	*	6.9	8	79	34	24	36	●
1734SU03C-0700	*	7	8	79	34	24	36	●
1734SU03C-0710	*	7.1	8	79	41	29	36	●
1734SU03C-0720	*	7.2	8	79	41	29	36	●
1734SU03C-0730	*	7.3	8	79	41	29	36	●
1734SU03C-0740	*	7.4	8	79	41	29	36	●
1734SU03C-0745	*	7.45	8	79	41	29	36	○
1734SU03C-0750	*	7.5	8	79	41	29	36	●
1734SU03C-0760	*	7.6	8	79	41	29	36	●
1734SU03C-0770	*	7.7	8	79	41	29	36	●
1734SU03C-0780	*	7.8	8	79	41	29	36	●
1734SU03C-0790	*	7.9	8	79	41	29	36	●
1734SU03C-0800	*	8	8	79	41	29	36	●
1734SU03C-0810	*	8.1	10	89	47	35	40	●
1734SU03C-0820	*	8.2	10	89	47	35	40	●
1734SU03C-0830	*	8.3	10	89	47	35	40	●
1734SU03C-0840	*	8.4	10	89	47	35	40	●
1734SU03C-0850	*	8.5	10	89	47	35	40	●
1734SU03C-0860	*	8.6	10	89	47	35	40	●
1734SU03C-0870	*	8.7	10	89	47	35	40	●
1734SU03C-0880	*	8.8	10	89	47	35	40	●
1734SU03C-0890	*	8.9	10	89	47	35	40	●
1734SU03C-0900	*	9	10	89	47	35	40	●
1734SU03C-0910	*	9.1	10	89	47	35	40	●
1734SU03C-0920	*	9.2	10	89	47	35	40	●
1734SU03C-0930	*	9.3	10	89	47	35	40	●
1734SU03C-0935	*	9.35	10	89	47	35	40	○

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1734SU*	✓	✓	✓			
1734SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 3xD

General machining

Add K (SUK) to the code for use on Cast Iron

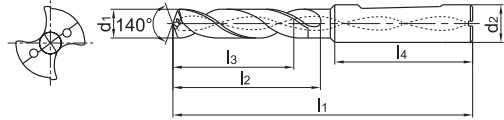
1734SU03C



- Whistle Notch clamping surface
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1734SU03C-0940	*	9.4	10	89	47	35	40	●
1734SU03C-0945	*	9.45	10	89	47	35	40	○
1734SU03C-0950	*	9.5	10	89	47	35	40	●
1734SU03C-0960	*	9.6	10	89	47	35	40	●
1734SU03C-0970	*	9.7	10	89	47	35	40	●
1734SU03C-0980	*	9.8	10	89	47	35	40	●
1734SU03C-0990	*	9.9	10	89	47	35	40	●
1734SU03C-1000	*	10	10	89	47	35	40	●
1734SU03C-1010	*	10.1	12	102	55	40	45	●
1734SU03C-1020	*	10.2	12	102	55	40	45	●
1734SU03C-1025	*	10.25	12	102	55	40	45	●
1734SU03C-1030	*	10.3	12	102	55	40	45	●
1734SU03C-1040	*	10.4	12	102	55	40	45	●
1734SU03C-1050	*	10.5	12	102	55	40	45	●
1734SU03C-1060	*	10.6	12	102	55	40	45	●
1734SU03C-1070	*	10.7	12	102	55	40	45	●
1734SU03C-1080	*	10.8	12	102	55	40	45	●
1734SU03C-1090	*	10.9	12	102	55	40	45	●
1734SU03C-1100	*	11	12	102	55	40	45	●
1734SU03C-1110	*	11.1	12	102	55	40	45	●
1734SU03C-1120	*	11.2	12	102	55	40	45	●
1734SU03C-1125	*	11.25	12	102	55	40	45	○
1734SU03C-1130	*	11.3	12	102	55	40	45	●
1734SU03C-1135	*	11.35	12	102	55	40	45	○
1734SU03C-1140	*	11.4	12	102	55	40	45	●
1734SU03C-1145	*	11.45	12	102	55	40	45	○
1734SU03C-1150	*	11.5	12	102	55	40	45	●
1734SU03C-1160	*	11.6	12	102	55	40	45	●
1734SU03C-1170	*	11.7	12	102	55	40	45	●
1734SU03C-1180	*	11.8	12	102	55	40	45	●
1734SU03C-1190	*	11.9	12	102	55	40	45	●
1734SU03C-1200	*	12	12	102	55	40	45	●
1734SU03C-1210	*	12.1	14	107	60	43	45	●
1734SU03C-1220	*	12.2	14	107	60	43	45	●
1734SU03C-1225	*	12.25	14	107	60	43	45	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1734SU*	✓	✓	✓			
1734SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 3xD

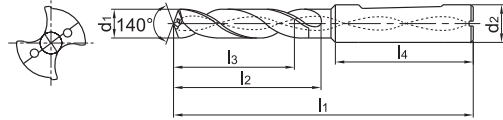
General machining

Add K (SUK) to the code for use on Cast Iron

1734SU03C



- Whistle Notch clamping surface
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1734SU03C-1230	*	12.3	14	107	60	43	45	●
1734SU03C-1250	*	12.5	14	107	60	43	45	●
1734SU03C-1270	*	12.7	14	107	60	43	45	●
1734SU03C-1275	*	12.75	14	107	60	43	45	●
1734SU03C-1280	*	12.8	14	107	60	43	45	●
1734SU03C-1300	*	13	14	107	60	43	45	●
1734SU03C-1310	*	13.1	14	107	60	43	45	●
1734SU03C-1335	*	13.35	14	107	60	43	45	○
1734SU03C-1350	*	13.5	14	107	60	43	45	●
1734SU03C-1380	*	13.8	14	107	60	43	45	●
1734SU03C-1400	*	14	14	107	60	43	45	●
1734SU03C-1420	*	14.2	16	107	60	43	45	●
1734SU03C-1425	*	14.25	16	115	65	45	48	●
1734SU03C-1430	*	14.3	16	115	65	45	48	●
1734SU03C-1450	*	14.5	16	115	65	45	48	●
1734SU03C-1475	*	14.75	16	115	65	45	48	●
1734SU03C-1480	*	14.8	16	115	65	45	48	●
1734SU03C-1500	*	15	16	115	65	45	48	●
1734SU03C-1510	*	15.1	16	115	65	45	48	●
1734SU03C-1535	*	15.35	16	115	65	45	48	○
1734SU03C-1550	*	15.5	16	115	65	45	48	●
1734SU03C-1580	*	15.8	16	115	65	45	48	●
1734SU03C-1600	*	16	16	115	65	45	48	●
1734SU03C-1650	*	16.5	18	123	73	51	48	●
1734SU03C-1675	*	16.75	18	123	73	51	48	●
1734SU03C-1680	*	16.8	18	123	73	51	48	●
1734SU03C-1700	*	17	18	123	73	51	48	●
1734SU03C-1750	*	17.5	18	123	73	51	48	●
1734SU03C-1780	*	17.8	18	123	73	51	48	●
1734SU03C-1800	*	18	18	123	73	51	48	●
1734SU03C-1850	*	18.5	20	131	79	55	50	●
1734SU03C-1880	*	18.8	20	131	79	55	50	●
1734SU03C-1900	*	19	20	131	79	55	50	●
1734SU03C-1950	*	19.5	20	131	79	55	50	●
1734SU03C-1980	*	19.8	20	131	79	55	50	●
1734SU03C-2000	*	20	20	131	79	55	50	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field						
Type	P	M	K	N	S	H
1734SU*	✓	✓	✓			
1734SUK*			✓			

- ✓ Very suitable
- ✓ Suitable



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SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

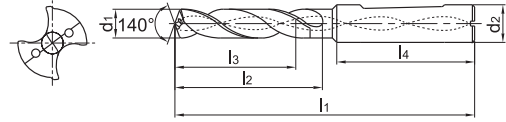
1736SU05C



- Whistle Notch clamping surface
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1736SU05C-0300	*	3	6	66	28	23	36	●
1736SU05C-0310	*	3.1	6	66	28	23	36	●
1736SU05C-0320	*	3.2	6	66	28	23	36	●
1736SU05C-0325	*	3.25	6	66	28	23	36	○
1736SU05C-0330	*	3.3	6	66	28	23	36	●
1736SU05C-0340	*	3.4	6	66	28	23	36	●
1736SU05C-0350	*	3.5	6	66	28	23	36	●
1736SU05C-0360	*	3.6	6	66	28	23	36	●
1736SU05C-0370	*	3.7	6	66	28	23	36	●
1736SU05C-0380	*	3.8	6	74	36	29	36	●
1736SU05C-0390	*	3.9	6	74	36	29	36	●
1736SU05C-0400	*	4	6	74	36	29	36	●
1736SU05C-0410	*	4.1	6	74	36	29	36	●
1736SU05C-0420	*	4.2	6	74	36	29	36	●
1736SU05C-0430	*	4.3	6	74	36	29	36	●
1736SU05C-0440	*	4.4	6	74	36	29	36	●
1736SU05C-0450	*	4.5	6	74	36	29	36	●
1736SU05C-0460	*	4.6	6	74	36	29	36	●
1736SU05C-0465	*	4.65	6	74	36	29	36	○
1736SU05C-0470	*	4.7	6	74	36	29	36	●
1736SU05C-0480	*	4.8	6	82	44	35	36	●
1736SU05C-0490	*	4.9	6	82	44	35	36	●
1736SU05C-0500	*	5	6	82	44	35	36	●
1736SU05C-0510	*	5.1	6	82	44	35	36	●
1736SU05C-0520	*	5.2	6	82	44	35	36	●
1736SU05C-0530	*	5.3	6	82	44	35	36	●
1736SU05C-0540	*	5.4	6	82	44	35	36	●
1736SU05C-0550	*	5.5	6	82	44	35	36	●
1736SU05C-0555	*	5.55	6	82	44	35	36	●
1736SU05C-0560	*	5.6	6	82	44	35	36	●
1736SU05C-0570	*	5.7	6	82	44	35	36	●
1736SU05C-0580	*	5.8	6	82	44	35	36	●
1736SU05C-0590	*	5.9	6	82	44	35	36	●
1736SU05C-0600	*	6	6	82	44	35	36	●
1736SU05C-0610	*	6.1	8	91	53	43	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1736SU*	✓	✓	✓			
1736SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

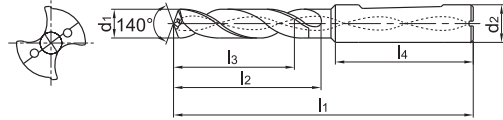
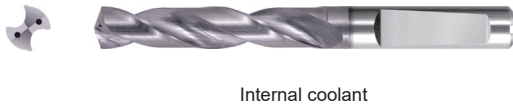
General machining

Add K (SUK) to the code for use on Cast Iron

1736SU05C



- Whistle Notch clamping surface
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1736SU05C-0620	*	6.2	8	91	53	43	36	●
1736SU05C-0630	*	6.3	8	91	53	43	36	●
1736SU05C-0640	*	6.4	8	91	53	43	36	●
1736SU05C-0650	*	6.5	8	91	53	43	36	●
1736SU05C-0660	*	6.6	8	91	53	43	36	●
1736SU05C-0670	*	6.7	8	91	53	43	36	●
1736SU05C-0675	*	6.75	8	91	53	43	36	●
1736SU05C-0680	*	6.8	8	91	53	43	36	●
1736SU05C-0690	*	6.9	8	91	53	43	36	●
1736SU05C-0700	*	7	8	91	53	43	36	●
1736SU05C-0710	*	7.1	8	91	53	43	36	●
1736SU05C-0720	*	7.2	8	91	53	43	36	●
1736SU05C-0730	*	7.3	8	91	53	43	36	●
1736SU05C-0740	*	7.4	8	91	53	43	36	●
1736SU05C-0745	*	7.45	8	91	53	43	36	○
1736SU05C-0750	*	7.5	8	91	53	43	36	●
1736SU05C-0760	*	7.6	8	91	53	43	36	●
1736SU05C-0770	*	7.7	8	91	53	43	36	●
1736SU05C-0780	*	7.8	8	91	53	43	36	●
1736SU05C-0790	*	7.9	8	91	53	43	36	●
1736SU05C-0800	*	8	8	91	53	43	36	●
1736SU05C-0810	*	8.1	10	103	61	49	40	●
1736SU05C-0820	*	8.2	10	103	61	49	40	●
1736SU05C-0830	*	8.3	10	103	61	49	40	●
1736SU05C-0840	*	8.4	10	103	61	49	40	●
1736SU05C-0850	*	8.5	10	103	61	49	40	●
1736SU05C-0860	*	8.6	10	103	61	49	40	●
1736SU05C-0870	*	8.7	10	103	61	49	40	●
1736SU05C-0880	*	8.8	10	103	61	49	40	●
1736SU05C-0890	*	8.9	10	103	61	49	40	●
1736SU05C-0900	*	9	10	103	61	49	40	●
1736SU05C-0910	*	9.1	10	103	61	49	40	●
1736SU05C-0920	*	9.2	10	103	61	49	40	●
1736SU05C-0930	*	9.3	10	103	61	49	40	●
1736SU05C-0935	*	9.35	10	103	61	49	40	○

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1736SU*	✓	✓	✓			
1736SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

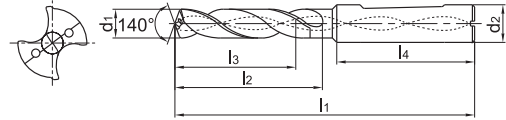
1736SU05C



- Whistle Notch clamping surface
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1736SU05C-0940	*	9.4	10	103	61	49	40	●
1736SU05C-0945	*	9.45	10	103	61	49	40	○
1736SU05C-0950	*	9.5	10	103	61	49	40	●
1736SU05C-0960	*	9.6	10	103	61	49	40	●
1736SU05C-0970	*	9.7	10	103	61	49	40	●
1736SU05C-0980	*	9.8	10	103	61	49	40	●
1736SU05C-0990	*	9.9	10	103	61	49	40	●
1736SU05C-1000	*	10	10	103	61	49	40	●
1736SU05C-1010	*	10.1	12	118	71	56	45	●
1736SU05C-1020	*	10.2	12	118	71	56	45	●
1736SU05C-1025	*	10.25	12	118	71	56	45	●
1736SU05C-1030	*	10.3	12	118	71	56	45	●
1736SU05C-1040	*	10.4	12	118	71	56	45	●
1736SU05C-1050	*	10.5	12	118	71	56	45	●
1736SU05C-1060	*	10.6	12	118	71	56	45	●
1736SU05C-1070	*	10.7	12	118	71	56	45	●
1736SU05C-1080	*	10.8	12	118	71	56	45	●
1736SU05C-1090	*	10.9	12	118	71	56	45	●
1736SU05C-1100	*	11	12	118	71	56	45	●
1736SU05C-1110	*	11.1	12	118	71	56	45	●
1736SU05C-1120	*	11.2	12	118	71	56	45	●
1736SU05C-1125	*	11.25	12	118	71	56	45	○
1736SU05C-1130	*	11.3	12	118	71	56	45	●
1736SU05C-1135	*	11.35	12	118	71	56	45	○
1736SU05C-1140	*	11.4	12	118	71	56	45	●
1736SU05C-1145	*	11.45	12	118	71	56	45	○
1736SU05C-1150	*	11.5	12	118	71	56	45	●
1736SU05C-1160	*	11.6	12	118	71	56	45	●
1736SU05C-1170	*	11.7	12	118	71	56	45	●
1736SU05C-1180	*	11.8	12	118	71	56	45	●
1736SU05C-1190	*	11.9	12	118	71	56	45	●
1736SU05C-1200	*	12	12	118	71	56	45	●
1736SU05C-1210	*	12.1	14	124	77	60	45	●
1736SU05C-1220	*	12.2	14	124	77	60	45	●
1736SU05C-1225	*	12.25	14	124	77	60	45	○

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1736SU*	✓	✓	✓			
1736SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

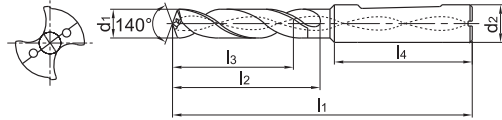
1736SU05C



- Whistle Notch clamping surface
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1736SU05C-1230	*	12.3	14	124	77	60	45	●
1736SU05C-1250	*	12.5	14	124	77	60	45	●
1736SU05C-1270	*	12.7	14	124	77	60	45	●
1736SU05C-1275	*	12.75	14	124	77	60	45	●
1736SU05C-1280	*	12.8	14	124	77	60	45	●
1736SU05C-1300	*	13	14	124	77	60	45	●
1736SU05C-1310	*	13.1	14	124	77	60	45	●
1736SU05C-1335	*	13.35	14	124	77	60	56	○
1736SU05C-1350	*	13.5	14	124	77	60	45	●
1736SU05C-1380	*	13.8	14	124	77	60	45	●
1736SU05C-1400	*	14	14	124	77	60	45	●
1736SU05C-1420	*	14.2	16	124	77	60	45	●
1736SU05C-1425	*	14.25	16	133	83	63	48	●
1736SU05C-1430	*	14.3	16	133	83	63	48	●
1736SU05C-1450	*	14.5	16	133	83	63	48	●
1736SU05C-1475	*	14.75	16	133	83	63	48	●
1736SU05C-1480	*	14.8	16	133	83	63	48	●
1736SU05C-1500	*	15	16	133	83	63	48	●
1736SU05C-1510	*	15.1	16	133	83	63	48	●
1736SU05C-1535	*	15.35	16	133	83	63	48	○
1736SU05C-1550	*	15.5	16	133	83	63	48	●
1736SU05C-1580	*	15.8	16	133	83	63	48	●
1736SU05C-1600	*	16	16	133	83	63	48	●
1736SU05C-1650	*	16.5	18	143	93	71	48	●
1736SU05C-1675	*	16.75	18	143	93	71	48	●
1736SU05C-1680	*	16.8	18	143	93	71	48	●
1736SU05C-1700	*	17	18	143	93	71	48	●
1736SU05C-1750	*	17.5	18	143	93	71	48	●
1736SU05C-1780	*	17.8	18	143	93	71	48	●
1736SU05C-1800	*	18	18	143	93	71	48	●
1736SU05C-1850	*	18.5	20	153	101	77	50	●
1736SU05C-1880	*	18.8	20	153	101	77	50	●
1736SU05C-1900	*	19	20	153	101	77	50	●
1736SU05C-1950	*	19.5	20	153	101	77	50	●
1736SU05C-1980	*	19.8	20	153	101	77	50	●
1736SU05C-2000	*	20	20	153	101	77	50	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1736SU*	✓	✓	✓			
1736SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU drill 3xD

General machining

Turning

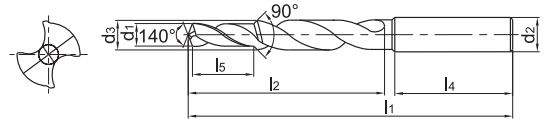
1557SU03



– Type of shank DIN 6535HA



External coolant



B

Milling

Article	*	Dimensions [mm]							Grade
		d ₁ (m8)	d ₂ (h6)	d ₃ (m7)	l ₁	l ₂	l ₄	l ₅	
1557SU03-M4		3.3	6	4.5	66	28	36	11.4	●
1557SU03-M5		4.2	6	6	66	28	36	13.6	●
1557SU03-M6		5	8	7	79	41	36	16.5	●
1557SU03-M8		6.75	10	9.5	89	47	40	21	●
1557SU03-M8x1.0		7	10	9.8	89	47	40	21	○
1557SU03-M10		8.5	12	12	102	55	45	25.5	●
1557SU03-M10x1.0		9	12	12	102	55	45	25.5	○
1557SU03-M12		10.25	14	14	107	60	45	30	●
1557SU03-M14		12	16	16	115	65	48	34.5	●
1557SU03-M16		14	18	18	123	73	48	38.5	●

● Ex stock ○ On demand

* With internal cooling

C

Drilling

Application field

P	M	K	N	S	H
✓	✓	✓			

✓ Very suitable

✓ Suitable

D

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System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SL(K) drill 10xD **General machining** Add K (SLK) to the code for use on Cast Iron

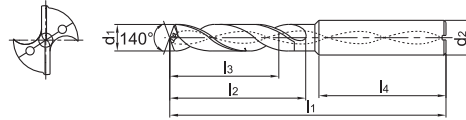
1588SL10C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	
1588SL10C-0300	*	3	6	80	43	39	36	●
1588SL10C-0310	*	3.1	6	80	43	39	36	○
1588SL10C-0320	*	3.2	6	80	43	39	36	●
1588SL10C-0330	*	3.3	6	80	43	39	36	●
1588SL10C-0340	*	3.4	6	80	43	39	36	●
1588SL10C-0350	*	3.5	6	80	43	39	36	●
1588SL10C-0360	*	3.6	6	80	43	39	36	●
1588SL10C-0370	*	3.7	6	80	43	39	36	●
1588SL10C-0380	*	3.8	6	80	43	39	36	●
1588SL10C-0390	*	3.9	6	80	43	39	36	●
1588SL10C-0400	*	4	6	92	55	50	36	●
1588SL10C-0410	*	4.1	6	92	55	50	36	●
1588SL10C-0420	*	4.2	6	92	55	50	36	●
1588SL10C-0430	*	4.3	6	92	55	50	36	●
1588SL10C-0440	*	4.4	6	92	55	50	36	●
1588SL10C-0450	*	4.5	6	92	55	50	36	●
1588SL10C-0460	*	4.6	6	92	55	50	36	●
1588SL10C-0470	*	4.7	6	92	55	50	36	●
1588SL10C-0480	*	4.8	6	92	55	50	36	●
1588SL10C-0490	*	4.9	6	92	55	50	36	●
1588SL10C-0500	*	5	6	104	68	61	36	●
1588SL10C-0510	*	5.1	6	104	68	61	36	●
1588SL10C-0520	*	5.2	6	104	68	61	36	●
1588SL10C-0530	*	5.3	6	104	68	61	36	●
1588SL10C-0540	*	5.4	6	104	68	61	36	●
1588SL10C-0550	*	5.5	6	104	68	61	36	●
1588SL10C-0560	*	5.6	6	104	68	61	36	●
1588SL10C-0570	*	5.7	6	104	68	61	36	●
1588SL10C-0580	*	5.8	6	104	68	61	36	●
1588SL10C-0590	*	5.9	6	104	68	61	36	●
1588SL10C-0600	*	6	6	104	68	61	36	●
1588SL10C-0610	*	6.1	8	117	80	71	36	●
1588SL10C-0620	*	6.2	8	117	80	71	36	●
1588SL10C-0630	*	6.3	8	117	80	71	36	●
1588SL10C-0640	*	6.4	8	117	80	71	36	●

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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Solid carbide drills SL/SP series

SL(K) drill 10xD

General machining

Add K (SLK) to the code for use on Cast Iron

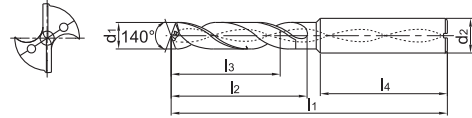
1588SL10C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL10C-0650	*	6.5	8	117	80	71	36	●
1588SL10C-0660	*	6.6	8	117	80	71	36	●
1588SL10C-0670	*	6.7	8	117	80	71	36	●
1588SL10C-0680	*	6.8	8	117	80	71	36	●
1588SL10C-0690	*	6.9	8	117	80	71	36	●
1588SL10C-0700	*	7	8	117	80	71	36	●
1588SL10C-0710	*	7.1	8	130	94	84	36	●
1588SL10C-0720	*	7.2	8	130	94	84	36	●
1588SL10C-0730	*	7.3	8	130	94	84	36	●
1588SL10C-0740	*	7.4	8	130	94	84	36	●
1588SL10C-0750	*	7.5	8	130	94	84	36	●
1588SL10C-0760	*	7.6	8	130	94	84	36	●
1588SL10C-0770	*	7.7	8	130	94	84	36	●
1588SL10C-0780	*	7.8	8	130	94	84	36	●
1588SL10C-0790	*	7.9	8	130	94	84	36	●
1588SL10C-0800	*	8	8	130	94	84	36	●
1588SL10C-0810	*	8.1	10	148	105	94	40	●
1588SL10C-0820	*	8.2	10	148	105	94	40	●
1588SL10C-0830	*	8.3	10	148	105	94	40	●
1588SL10C-0840	*	8.4	10	148	105	94	40	●
1588SL10C-0850	*	8.5	10	148	105	94	40	●
1588SL10C-0860	*	8.6	10	148	105	94	40	●
1588SL10C-0870	*	8.7	10	148	105	94	40	●
1588SL10C-0880	*	8.8	10	148	105	94	40	●
1588SL10C-0890	*	8.9	10	148	105	94	40	●
1588SL10C-0900	*	9	10	148	105	94	40	●
1588SL10C-0910	*	9.1	10	158	115	103	40	●
1588SL10C-0920	*	9.2	10	158	115	103	40	●
1588SL10C-0930	*	9.3	10	158	115	103	40	●
1588SL10C-0940	*	9.4	10	158	115	103	40	●
1588SL10C-0950	*	9.5	10	158	115	103	40	●
1588SL10C-0960	*	9.6	10	158	115	103	40	●
1588SL10C-0970	*	9.7	10	158	115	103	40	●
1588SL10C-0980	*	9.8	10	158	115	103	40	●
1588SL10C-0990	*	9.9	10	158	115	103	40	●

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

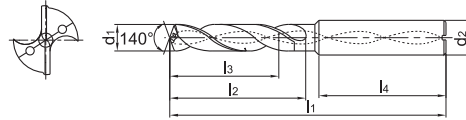
Nonstandard order > C150

SL(K) drill 10xD **General machining** Add K (SLK) to the code for use on Cast Iron

1588SL10C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL10C-1000	*	10	10	158	115	103	40	●
1588SL10C-1010	*	10.1	12	183	135	121	45	●
1588SL10C-1020	*	10.2	12	183	135	121	45	●
1588SL10C-1030	*	10.3	12	183	135	121	45	●
1588SL10C-1040	*	10.4	12	183	135	121	45	●
1588SL10C-1050	*	10.5	12	183	135	121	45	●
1588SL10C-1060	*	10.6	12	183	135	121	45	●
1588SL10C-1070	*	10.7	12	183	135	121	45	●
1588SL10C-1080	*	10.8	12	183	135	121	45	●
1588SL10C-1090	*	10.9	12	183	135	121	45	●
1588SL10C-1100	*	11	12	183	135	121	45	●
1588SL10C-1110	*	11.1	12	183	135	121	45	●
1588SL10C-1120	*	11.2	12	183	135	121	45	●
1588SL10C-1130	*	11.3	12	183	135	121	45	●
1588SL10C-1140	*	11.4	12	183	135	121	45	●
1588SL10C-1150	*	11.5	12	183	135	121	45	●
1588SL10C-1160	*	11.6	12	183	135	121	45	●
1588SL10C-1170	*	11.7	12	183	135	121	45	●
1588SL10C-1180	*	11.8	12	183	135	121	45	●
1588SL10C-1190	*	11.9	12	183	135	121	45	●
1588SL10C-1200	*	12	12	183	135	121	45	●
1588SL10C-1225	*	12.25	14	209	160	144	45	●
1588SL10C-1250	*	12.5	14	209	160	144	45	●
1588SL10C-1270	*	12.7	14	209	160	144	45	●
1588SL10C-1275	*	12.75	14	209	160	144	45	●
1588SL10C-1280	*	12.8	14	209	160	144	45	●
1588SL10C-1300	*	13	14	209	160	144	45	●
1588SL10C-1310	*	13.1	14	209	160	144	45	●
1588SL10C-1350	*	13.5	14	209	160	144	45	●
1588SL10C-1380	*	13.8	14	209	160	144	45	●
1588SL10C-1400	*	14	14	209	160	144	45	●

- Ex stock ○ On demand
- All articles SLK on demand
- * With internal cooling

Application field						
Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

- ✓ Very suitable
- ✓ Suitable



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SL(K) drill 12xD General machining Add K (SLK) to the code for use on Cast Iron

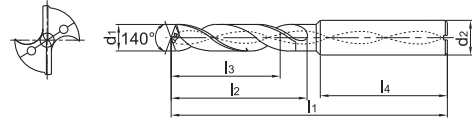
1588SL12C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL12C-0300	*	3	6	90	50	40	36	●
1588SL12C-0310	*	3.1	6	90	50	40	36	●
1588SL12C-0320	*	3.2	6	90	50	40	36	●
1588SL12C-0330	*	3.3	6	90	50	40	36	●
1588SL12C-0340	*	3.4	6	90	50	40	36	●
1588SL12C-0350	*	3.5	6	90	50	40	36	●
1588SL12C-0360	*	3.6	6	90	50	40	36	●
1588SL12C-0370	*	3.7	6	90	50	46	36	●
1588SL12C-0380	*	3.8	6	90	50	46	36	●
1588SL12C-0390	*	3.9	6	90	50	46	36	●
1588SL12C-0400	*	4	6	102	64	56	36	●
1588SL12C-0410	*	4.1	6	102	64	56	36	●
1588SL12C-0420	*	4.2	6	102	64	56	36	●
1588SL12C-0430	*	4.3	6	102	64	56	36	●
1588SL12C-0440	*	4.4	6	102	64	56	36	●
1588SL12C-0450	*	4.5	6	102	64	56	36	●
1588SL12C-0460	*	4.6	6	102	64	56	36	●
1588SL12C-0470	*	4.7	6	102	64	56	36	●
1588SL12C-0480	*	4.8	6	102	64	56	36	●
1588SL12C-0490	*	4.9	6	102	64	56	36	●
1588SL12C-0500	*	5	6	116	78	72	36	●
1588SL12C-0510	*	5.1	6	116	78	72	36	●
1588SL12C-0520	*	5.2	6	116	78	72	36	●
1588SL12C-0530	*	5.3	6	116	78	72	36	○
1588SL12C-0540	*	5.4	6	116	78	72	36	○
1588SL12C-0550	*	5.5	6	116	78	72	36	●
1588SL12C-0560	*	5.6	6	116	78	72	36	●
1588SL12C-0570	*	5.7	6	116	78	72	36	●
1588SL12C-0580	*	5.8	6	116	78	72	36	●
1588SL12C-0590	*	5.9	6	116	78	72	36	●
1588SL12C-0600	*	6	6	116	78	72	36	●
1588SL12C-0610	*	6.1	8	131	93	84	36	●
1588SL12C-0620	*	6.2	8	131	93	84	36	●
1588SL12C-0630	*	6.3	8	131	93	84	36	●
1588SL12C-0640	*	6.4	8	131	93	84	36	●

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SL(K) drill 12xD **General machining** Add K (SLK) to the code for use on Cast Iron

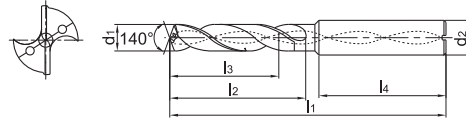
1588SL12C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL12C-0650	*	6.5	8	131	93	84	36	●
1588SL12C-0660	*	6.6	8	131	93	84	36	●
1588SL12C-0670	*	6.7	8	131	93	84	36	●
1588SL12C-0680	*	6.8	8	131	93	84	36	●
1588SL12C-0690	*	6.9	8	131	93	84	36	●
1588SL12C-0700	*	7	8	131	93	84	36	●
1588SL12C-0710	*	7.1	8	146	108	96	36	●
1588SL12C-0720	*	7.2	8	146	108	96	36	●
1588SL12C-0730	*	7.3	8	146	108	96	36	●
1588SL12C-0740	*	7.4	8	146	108	96	36	●
1588SL12C-0750	*	7.5	8	146	108	96	36	●
1588SL12C-0760	*	7.6	8	146	108	96	36	○
1588SL12C-0770	*	7.7	8	146	108	96	36	○
1588SL12C-0780	*	7.8	8	146	108	96	36	●
1588SL12C-0790	*	7.9	8	146	108	96	36	○
1588SL12C-0800	*	8	8	146	108	96	36	●
1588SL12C-0810	*	8.1	10	162	120	108	40	●
1588SL12C-0820	*	8.2	10	162	120	108	40	●
1588SL12C-0830	*	8.3	10	162	120	108	40	●
1588SL12C-0840	*	8.4	10	162	120	108	40	●
1588SL12C-0850	*	8.5	10	162	120	108	40	●
1588SL12C-0860	*	8.6	10	162	120	108	40	●
1588SL12C-0870	*	8.7	10	162	120	108	40	●
1588SL12C-0880	*	8.8	10	162	120	108	40	●
1588SL12C-0890	*	8.9	10	162	120	108	40	●
1588SL12C-0900	*	9	10	162	120	108	40	●
1588SL12C-0910	*	9.1	10	174	132	120	40	○
1588SL12C-0920	*	9.2	10	174	132	120	40	●
1588SL12C-0930	*	9.3	10	174	132	120	40	●
1588SL12C-0940	*	9.4	10	174	132	120	40	●
1588SL12C-0950	*	9.5	10	174	132	120	40	●
1588SL12C-0960	*	9.6	10	174	132	120	40	○
1588SL12C-0970	*	9.7	10	174	132	120	40	●
1588SL12C-0980	*	9.8	10	174	132	120	40	●
1588SL12C-0990	*	9.9	10	174	132	120	40	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SL(K) drill 12xD General machining Add K (SLK) to the code for use on Cast Iron

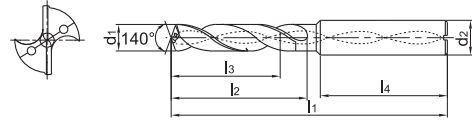
1588SL12C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL12C-1000	*	10	10	174	132	120	40	●
1588SL12C-1010	*	10.1	12	204	156	144	45	●
1588SL12C-1020	*	10.2	12	204	156	144	45	●
1588SL12C-1030	*	10.3	12	204	156	144	45	●
1588SL12C-1040	*	10.4	12	204	156	144	45	●
1588SL12C-1050	*	10.5	12	204	156	144	45	●
1588SL12C-1060	*	10.6	12	204	156	144	45	●
1588SL12C-1070	*	10.7	12	204	156	144	45	○
1588SL12C-1080	*	10.8	12	204	156	144	45	○
1588SL12C-1090	*	10.9	12	204	156	144	45	○
1588SL12C-1100	*	11	12	204	156	144	45	●
1588SL12C-1110	*	11.1	12	204	156	144	45	●
1588SL12C-1120	*	11.2	12	204	156	144	45	●
1588SL12C-1130	*	11.3	12	204	156	144	45	○
1588SL12C-1140	*	11.4	12	204	156	144	45	○
1588SL12C-1150	*	11.5	12	204	156	144	45	●
1588SL12C-1160	*	11.6	12	204	156	144	45	○
1588SL12C-1170	*	11.7	12	204	156	144	45	●
1588SL12C-1180	*	11.8	12	204	156	144	45	●
1588SL12C-1190	*	11.9	12	204	156	144	45	○
1588SL12C-1200	*	12	12	204	156	144	45	●
1588SL12C-1250	*	12.5	14	230	182	168	45	○
1588SL12C-1270	*	12.7	14	230	182	168	45	○
1588SL12C-1280	*	12.8	14	230	182	168	45	○
1588SL12C-1300	*	13	14	230	182	168	45	○
1588SL12C-1350	*	13.5	14	230	182	168	45	○
1588SL12C-1400	*	14	14	230	182	168	45	○
1588SL12C-1450	*	14.5	16	260	208	194	48	○
1588SL12C-1500	*	15	16	260	208	194	48	○
1588SL12C-1550	*	15.5	16	260	208	194	48	○
1588SL12C-1600	*	16	16	260	208	194	48	○
1588SL12C-1650	*	16.5	18	286	234	218	48	○
1588SL12C-1700	*	17	18	286	234	218	48	○
1588SL12C-1750	*	17.5	18	286	234	218	48	○
1588SL12C-1800	*	18	18	286	234	218	48	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SL(K) drill 12xD **General machining** Add K (SLK) to the code for use on Cast Iron

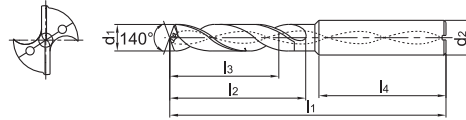
1588SL12C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL12C-1850	*	18.5	20	310	258	240	48	○
1588SL12C-1900	*	19	20	310	258	240	48	○
1588SL12C-1950	*	19.5	20	310	258	240	48	○
1588SL12C-2000	*	20	20	310	258	240	48	○
1588SL12C-2050	*	20.5	22	310	258	240	48	○
1588SL12C-2100	*	21	22	310	258	240	48	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

- ✓ Very suitable
- ✓ Suitable

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System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



SL(K) drill 15xD General machining Add K (SLK) to the code for use on Cast Iron

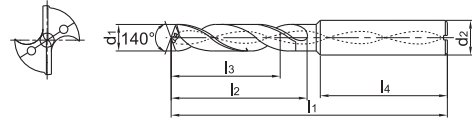
1588SL15C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL15C-0300	*	3	6	100	60	50	36	●
1588SL15C-0310	*	3.1	6	105	65	55	36	●
1588SL15C-0320	*	3.2	6	105	65	55	36	○
1588SL15C-0330	*	3.3	6	105	65	55	36	●
1588SL15C-0335	*	3.35	6	105	65	55	36	○
1588SL15C-0340	*	3.4	6	105	65	55	36	●
1588SL15C-0350	*	3.5	6	105	65	55	36	●
1588SL15C-0360	*	3.6	6	112	72	62	36	○
1588SL15C-0370	*	3.7	6	112	72	68	36	●
1588SL15C-0380	*	3.8	6	112	72	68	36	●
1588SL15C-0390	*	3.9	6	112	72	68	36	○
1588SL15C-0400	*	4	6	112	72	64	36	●
1588SL15C-0410	*	4.1	6	120	80	72	36	○
1588SL15C-0420	*	4.2	6	120	80	72	36	○
1588SL15C-0430	*	4.3	6	120	80	72	36	○
1588SL15C-0440	*	4.4	6	120	80	72	36	○
1588SL15C-0450	*	4.5	6	120	80	72	36	●
1588SL15C-0460	*	4.6	6	128	88	80	36	●
1588SL15C-0470	*	4.7	6	128	88	80	36	○
1588SL15C-0480	*	4.8	6	128	88	80	36	●
1588SL15C-0490	*	4.9	6	128	88	80	36	●
1588SL15C-0500	*	5	6	128	88	82	36	●
1588SL15C-0510	*	5.1	6	136	96	90	36	●
1588SL15C-0520	*	5.2	6	136	96	90	36	○
1588SL15C-0530	*	5.3	6	136	96	90	36	●
1588SL15C-0540	*	5.4	6	136	96	90	36	○
1588SL15C-0550	*	5.5	6	136	96	90	36	○
1588SL15C-0560	*	5.6	6	144	104	98	36	○
1588SL15C-0570	*	5.7	6	144	104	98	36	○
1588SL15C-0580	*	5.8	6	144	104	98	36	○
1588SL15C-0590	*	5.9	6	144	104	98	36	○
1588SL15C-0600	*	6	6	144	104	98	36	○
1588SL15C-0610	*	6.1	8	152	112	103	36	●
1588SL15C-0620	*	6.2	8	152	112	103	36	●
1588SL15C-0630	*	6.3	8	152	112	103	36	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SL(K) drill 15xD **General machining** Add K (SLK) to the code for use on Cast Iron

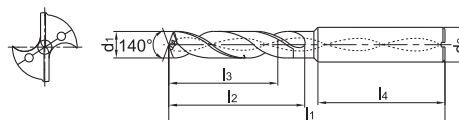
1588SL15C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL15C-0640	*	6.4	8	152	112	103	36	●
1588SL15C-0650	*	6.5	8	152	112	103	36	●
1588SL15C-0660	*	6.6	8	160	120	111	36	○
1588SL15C-0670	*	6.7	8	160	120	111	36	●
1588SL15C-0680	*	6.8	8	160	120	111	36	○
1588SL15C-0690	*	6.9	8	160	120	111	36	○
1588SL15C-0700	*	7	8	160	120	111	36	●
1588SL15C-0710	*	7.1	8	170	130	118	36	○
1588SL15C-0720	*	7.2	8	170	130	118	36	○
1588SL15C-0730	*	7.3	8	170	130	118	36	○
1588SL15C-0740	*	7.4	8	170	130	118	36	○
1588SL15C-0750	*	7.5	8	170	130	118	36	○
1588SL15C-0760	*	7.6	8	180	140	128	36	○
1588SL15C-0770	*	7.7	8	180	140	128	36	○
1588SL15C-0780	*	7.8	8	180	140	128	36	○
1588SL15C-0790	*	7.9	8	180	140	128	36	○
1588SL15C-0800	*	8	8	180	140	128	36	●
1588SL15C-0810	*	8.1	10	194	150	138	40	○
1588SL15C-0820	*	8.2	10	194	150	138	40	○
1588SL15C-0830	*	8.3	10	194	150	138	40	○
1588SL15C-0840	*	8.4	10	194	150	138	40	○
1588SL15C-0850	*	8.5	10	194	150	138	40	●
1588SL15C-0860	*	8.6	10	204	160	148	40	●
1588SL15C-0870	*	8.7	10	204	160	148	40	○
1588SL15C-0880	*	8.8	10	204	160	148	40	●
1588SL15C-0890	*	8.9	10	204	160	148	40	○
1588SL15C-0900	*	9	10	204	160	148	40	○
1588SL15C-0910	*	9.1	10	216	172	160	40	○
1588SL15C-0920	*	9.2	10	216	172	160	40	○
1588SL15C-0930	*	9.3	10	216	172	160	40	○
1588SL15C-0940	*	9.4	10	216	172	160	40	○
1588SL15C-0950	*	9.5	10	216	172	160	40	○
1588SL15C-0960	*	9.6	10	226	182	170	40	○
1588SL15C-0970	*	9.7	10	226	182	170	40	○
1588SL15C-0980	*	9.8	10	226	182	170	40	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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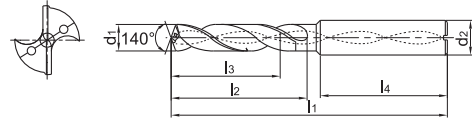
SL(K) drill 15xD General machining Add K (SLK) to the code for use on Cast Iron

1588SL15C

- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL15C-0990	*	9.9	10	226	182	170	40	○
1588SL15C-1000	*	10	10	226	182	170	40	●
1588SL15C-1010	*	10.1	12	240	190	178	45	○
1588SL15C-1020	*	10.2	12	240	190	178	45	○
1588SL15C-1030	*	10.3	12	240	190	178	45	○
1588SL15C-1040	*	10.4	12	240	190	178	45	○
1588SL15C-1050	*	10.5	12	240	190	178	45	○
1588SL15C-1060	*	10.6	12	248	198	186	45	○
1588SL15C-1070	*	10.7	12	248	198	186	45	○
1588SL15C-1080	*	10.8	12	248	198	186	45	○
1588SL15C-1090	*	10.9	12	248	198	186	45	○
1588SL15C-1100	*	11	12	248	198	186	45	●
1588SL15C-1110	*	11.1	12	262	212	200	45	○
1588SL15C-1120	*	11.2	12	262	212	200	45	○
1588SL15C-1130	*	11.3	12	262	212	200	45	○
1588SL15C-1140	*	11.4	12	262	212	200	45	○
1588SL15C-1150	*	11.5	12	262	212	200	45	●
1588SL15C-1160	*	11.6	12	272	222	210	45	○
1588SL15C-1170	*	11.7	12	272	222	210	45	○
1588SL15C-1180	*	11.8	12	272	222	210	45	○
1588SL15C-1190	*	11.9	12	272	222	210	45	○
1588SL15C-1200	*	12	12	272	222	210	45	●

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SL(K) drill 20xD **General machining** Add K (SLK) to the code for use on Cast Iron

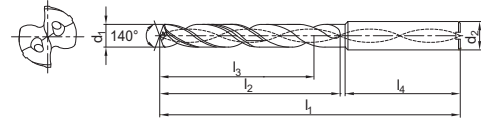
1588SL20C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL20C-0300	*	3	6	110	70	62	36	●
1588SL20C-0310	*	3.1	6	123	83	72	36	●
1588SL20C-0320	*	3.2	6	123	83	72	36	●
1588SL20C-0330	*	3.3	6	123	83	72	36	●
1588SL20C-0340	*	3.4	6	123	83	72	36	●
1588SL20C-0350	*	3.5	6	123	83	72	36	●
1588SL20C-0360	*	3.6	6	136	96	84	36	●
1588SL20C-0370	*	3.7	6	136	96	84	36	●
1588SL20C-0380	*	3.8	6	136	96	84	36	●
1588SL20C-0390	*	3.9	6	136	96	84	36	●
1588SL20C-0400	*	4	6	136	96	84	36	●
1588SL20C-0410	*	4.1	6	148	108	96	36	●
1588SL20C-0420	*	4.2	6	148	108	96	36	●
1588SL20C-0430	*	4.3	6	148	108	96	36	○
1588SL20C-0440	*	4.4	6	148	108	96	36	○
1588SL20C-0450	*	4.5	6	148	108	96	36	●
1588SL20C-0460	*	4.6	6	158	118	106	36	○
1588SL20C-0470	*	4.7	6	158	118	106	36	○
1588SL20C-0480	*	4.8	6	158	118	106	36	●
1588SL20C-0490	*	4.9	6	158	118	106	36	○
1588SL20C-0500	*	5	6	158	118	106	36	●
1588SL20C-0510	*	5.1	6	168	128	116	36	○
1588SL20C-0520	*	5.2	6	168	128	116	36	●
1588SL20C-0530	*	5.3	6	168	128	116	36	●
1588SL20C-0540	*	5.4	6	168	128	116	36	●
1588SL20C-0550	*	5.5	6	168	128	116	36	●
1588SL20C-0560	*	5.6	6	180	140	126	36	○
1588SL20C-0570	*	5.7	6	180	140	126	36	○
1588SL20C-0580	*	5.8	6	180	140	126	36	●
1588SL20C-0590	*	5.9	6	180	140	126	36	○
1588SL20C-0600	*	6	6	180	140	126	36	●
1588SL20C-0610	*	6.1	8	192	150	132	36	○
1588SL20C-0620	*	6.2	8	192	150	132	36	○
1588SL20C-0630	*	6.3	8	192	150	132	36	●
1588SL20C-0640	*	6.4	8	192	150	132	36	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



Solid carbide drills SL/SP series

SL(K) drill 20xD **General machining** Add K (SLK) to the code for use on Cast Iron

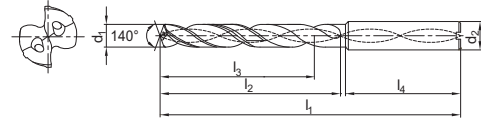
1588SL20C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL20C-0650	*	6.5	8	192	150	132	36	●
1588SL20C-0660	*	6.6	8	202	162	144	36	○
1588SL20C-0670	*	6.7	8	202	162	144	36	○
1588SL20C-0680	*	6.8	8	202	162	144	36	●
1588SL20C-0690	*	6.9	8	202	162	144	36	○
1588SL20C-0700	*	7	8	202	162	144	36	●
1588SL20C-0710	*	7.1	8	213	173	155	36	○
1588SL20C-0720	*	7.2	8	213	173	155	36	○
1588SL20C-0730	*	7.3	8	213	173	155	36	○
1588SL20C-0740	*	7.4	8	213	173	155	36	○
1588SL20C-0750	*	7.5	8	213	173	155	36	●
1588SL20C-0760	*	7.6	8	223	183	165	36	○
1588SL20C-0770	*	7.7	8	223	183	165	36	○
1588SL20C-0780	*	7.8	8	223	183	165	36	○
1588SL20C-0790	*	7.9	8	223	183	165	36	○
1588SL20C-0800	*	8	8	223	183	165	36	●
1588SL20C-0810	*	8.1	10	239	195	176	40	○
1588SL20C-0820	*	8.2	10	239	195	176	40	○
1588SL20C-0830	*	8.3	10	239	195	176	40	○
1588SL20C-0840	*	8.4	10	239	195	176	40	○
1588SL20C-0850	*	8.5	10	239	195	176	40	●
1588SL20C-0860	*	8.6	10	249	205	186	40	○
1588SL20C-0870	*	8.7	10	249	205	186	40	○
1588SL20C-0880	*	8.8	10	249	205	186	40	○
1588SL20C-0890	*	8.9	10	249	205	186	40	○
1588SL20C-0900	*	9	10	249	205	186	40	○
1588SL20C-0910	*	9.1	10	262	218	196	36	○
1588SL20C-0920	*	9.2	10	262	218	196	36	○
1588SL20C-0930	*	9.3	10	262	218	196	36	○
1588SL20C-0940	*	9.4	10	262	218	196	36	○
1588SL20C-0950	*	9.5	10	262	218	196	36	○
1588SL20C-0960	*	9.6	10	272	228	206	40	○
1588SL20C-0970	*	9.7	10	272	228	206	40	○
1588SL20C-0980	*	9.8	10	272	228	206	40	○
1588SL20C-0990	*	9.9	10	272	228	206	40	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SL(K) drill 20xD **General machining** Add K (SLK) to the code for use on Cast Iron

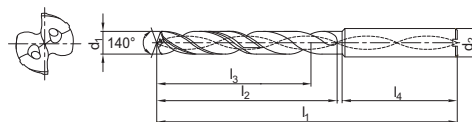
1588SL20C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL20C-1000	*	10	10	272	228	206	40	●
1588SL20C-1010	*	10.1	12	292	242	220	45	○
1588SL20C-1020	*	10.2	12	292	242	220	45	○
1588SL20C-1030	*	10.3	12	292	242	220	45	○
1588SL20C-1040	*	10.4	12	292	242	220	45	○
1588SL20C-1050	*	10.5	12	292	242	220	45	○
1588SL20C-1060	*	10.6	12	300	250	228	45	○
1588SL20C-1070	*	10.7	12	300	250	228	45	○
1588SL20C-1080	*	10.8	12	300	250	228	45	○
1588SL20C-1090	*	10.9	12	300	250	228	45	○
1588SL20C-1100	*	11	12	300	250	228	45	○
1588SL20C-1110	*	11.1	12	315	265	240	45	○
1588SL20C-1120	*	11.2	12	315	265	240	45	○
1588SL20C-1130	*	11.3	12	315	265	240	45	○
1588SL20C-1140	*	11.4	12	315	265	240	45	○
1588SL20C-1150	*	11.5	12	315	265	240	45	○
1588SL20C-1160	*	11.6	12	325	275	250	45	○
1588SL20C-1170	*	11.7	12	325	275	250	45	○
1588SL20C-1180	*	11.8	12	325	275	250	45	○
1588SL20C-1190	*	11.9	12	325	275	250	45	○
1588SL20C-1200	*	12	12	325	275	250	45	○
1588SL20C-1250	*	12.5	14	325	275	250	45	○
1588SL20C-1300	*	13	14	338	290	265	45	○
1588SL20C-1350	*	13.5	14	338	290	265	45	○
1588SL20C-1400	*	14	14	367	318	290	45	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



SL(K) drill 30xD General machining Add K (SLK) to the code for use on Cast Iron

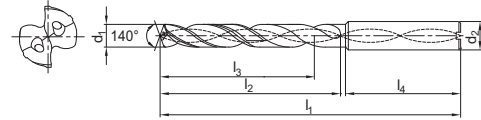
1588SL30C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL30C-0300	*	3	6	140	100	92	36	●
1588SL30C-0310	*	3.1	6	160	120	108	36	○
1588SL30C-0320	*	3.2	6	160	120	108	36	●
1588SL30C-0330	*	3.3	6	160	120	108	36	○
1588SL30C-0340	*	3.4	6	160	120	108	36	●
1588SL30C-0350	*	3.5	6	160	120	108	36	●
1588SL30C-0360	*	3.6	6	176	136	124	36	○
1588SL30C-0370	*	3.7	6	176	136	124	36	○
1588SL30C-0380	*	3.8	6	176	136	124	36	●
1588SL30C-0390	*	3.9	6	176	136	124	36	●
1588SL30C-0400	*	4	6	176	136	124	36	●
1588SL30C-0410	*	4.1	6	192	152	140	36	○
1588SL30C-0420	*	4.2	6	192	152	140	36	○
1588SL30C-0430	*	4.3	6	192	152	140	36	○
1588SL30C-0440	*	4.4	6	192	152	140	36	○
1588SL30C-0450	*	4.5	6	192	152	140	36	●
1588SL30C-0460	*	4.6	6	208	168	156	36	○
1588SL30C-0470	*	4.7	6	208	168	156	36	○
1588SL30C-0480	*	4.8	6	208	168	156	36	●
1588SL30C-0490	*	4.9	6	208	168	156	36	●
1588SL30C-0500	*	5	6	208	168	156	36	●
1588SL30C-0510	*	5.1	6	228	188	170	36	○
1588SL30C-0520	*	5.2	6	228	188	170	36	●
1588SL30C-0530	*	5.3	6	228	188	170	36	○
1588SL30C-0540	*	5.4	6	228	188	170	36	○
1588SL30C-0550	*	5.5	6	228	188	170	36	●
1588SL30C-0560	*	5.6	6	240	200	182	36	○
1588SL30C-0570	*	5.7	6	240	200	182	36	○
1588SL30C-0580	*	5.8	6	240	200	182	36	●
1588SL30C-0590	*	5.9	6	240	200	182	36	○
1588SL30C-0600	*	6	6	240	200	182	36	●
1588SL30C-0610	*	6.1	8	260	220	202	36	○
1588SL30C-0620	*	6.2	8	260	220	202	36	○
1588SL30C-0630	*	6.3	8	260	220	202	36	●
1588SL30C-0640	*	6.4	8	260	220	202	36	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SL(K) drill 30xD **General machining** Add K (SLK) to the code for use on Cast Iron

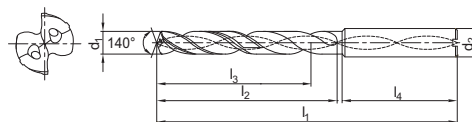
1588SL30C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1588SL30C-0650	*	6.5	8	260	220	202	36	●
1588SL30C-0660	*	6.6	8	272	232	214	36	○
1588SL30C-0670	*	6.7	8	272	232	214	36	○
1588SL30C-0680	*	6.8	8	272	232	214	36	●
1588SL30C-0690	*	6.9	8	272	232	214	36	○
1588SL30C-0700	*	7	8	272	232	214	36	●
1588SL30C-0710	*	7.1	8	290	250	232	36	○
1588SL30C-0720	*	7.2	8	290	250	232	36	○
1588SL30C-0730	*	7.3	8	290	250	232	36	○
1588SL30C-0740	*	7.4	8	290	250	232	36	○
1588SL30C-0750	*	7.5	8	290	250	232	36	○
1588SL30C-0760	*	7.6	8	305	265	246	36	○
1588SL30C-0770	*	7.7	8	305	265	246	36	○
1588SL30C-0780	*	7.8	8	305	265	246	36	○
1588SL30C-0790	*	7.9	8	305	265	246	36	○
1588SL30C-0800	*	8	8	305	265	246	36	●
1588SL30C-0810	*	8.1	10	330	285	265	40	○
1588SL30C-0820	*	8.2	10	330	285	265	40	○
1588SL30C-0830	*	8.3	10	330	285	265	40	○
1588SL30C-0840	*	8.4	10	330	285	265	40	○
1588SL30C-0850	*	8.5	10	330	285	265	40	●
1588SL30C-0860	*	8.6	10	340	295	275	40	○
1588SL30C-0870	*	8.7	10	340	295	275	40	○
1588SL30C-0880	*	8.8	10	340	295	275	40	○
1588SL30C-0890	*	8.9	10	340	295	275	40	○
1588SL30C-0900	*	9	10	340	295	275	40	○
1588SL30C-0910	*	9.1	10	360	315	292	40	○
1588SL30C-0920	*	9.2	10	360	315	292	40	○
1588SL30C-0930	*	9.3	10	360	315	292	40	○
1588SL30C-0940	*	9.4	10	360	315	292	40	○
1588SL30C-0950	*	9.5	10	360	315	292	40	○
1588SL30C-0960	*	9.6	10	372	328	305	40	○
1588SL30C-0970	*	9.7	10	372	328	305	40	○
1588SL30C-0980	*	9.8	10	372	328	305	40	○
1588SL30C-0990	*	9.9	10	372	328	305	40	○
1588SL30C-1000	*	10	10	372	328	305	40	○

● Ex stock ○ On demand

All articles SLK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1588SL*	✓	✓	✓	✓	✓	
1588SLK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

SP drill 3xD

General machining

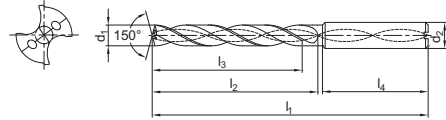
1534SP03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (h7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SP03C-0303	*	3.03	6	62	20	14	36	●
1534SP03C-0313	*	3.13	6	62	20	14	36	○
1534SP03C-0323	*	3.23	6	62	20	14	36	○
1534SP03C-0333	*	3.33	6	62	20	14	36	●
1534SP03C-0343	*	3.43	6	62	20	14	36	●
1534SP03C-0353	*	3.53	6	62	20	14	36	●
1534SP03C-0363	*	3.63	6	62	20	14	36	○
1534SP03C-0373	*	3.73	6	62	20	14	36	○
1534SP03C-0383	*	3.83	6	66	24	17	36	○
1534SP03C-0393	*	3.93	6	66	24	17	36	○
1534SP03C-0403	*	4.03	6	66	24	17	36	●
1534SP03C-0413	*	4.13	6	66	24	17	36	○
1534SP03C-0423	*	4.23	6	66	24	17	36	○
1534SP03C-0433	*	4.33	6	66	24	17	36	○
1534SP03C-0443	*	4.43	6	66	24	17	36	○
1534SP03C-0453	*	4.53	6	66	24	17	36	●
1534SP03C-0463	*	4.63	6	66	24	17	36	○
1534SP03C-0473	*	4.73	6	66	24	17	36	○
1534SP03C-0483	*	4.83	6	66	28	20	36	○
1534SP03C-0493	*	4.93	6	66	28	20	36	○
1534SP03C-0503	*	5.03	6	66	28	20	36	●
1534SP03C-0513	*	5.13	6	66	28	20	36	○
1534SP03C-0523	*	5.23	6	66	28	20	36	○
1534SP03C-0533	*	5.33	6	66	28	20	36	○
1534SP03C-0543	*	5.43	6	66	28	20	36	○
1534SP03C-0553	*	5.53	6	66	28	20	36	●
1534SP03C-0563	*	5.63	6	66	28	20	36	○
1534SP03C-0573	*	5.73	6	66	28	20	36	○
1534SP03C-0583	*	5.83	6	66	28	20	36	○
1534SP03C-0593	*	5.93	6	66	28	20	36	○
1534SP03C-0603	*	6.03	6	66	28	20	36	●
1534SP03C-0613	*	6.13	8	79	34	24	36	○
1534SP03C-0623	*	6.23	8	79	34	24	36	○
1534SP03C-0633	*	6.33	8	79	34	24	36	○
1534SP03C-0643	*	6.43	8	79	34	24	36	○
1534SP03C-0653	*	6.53	8	79	34	24	36	●
1534SP03C-0663	*	6.63	8	79	34	24	36	○

● Ex stock ○ On demand

Pilot drill Ø = Deep drill Ø + 0,03 mm

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓	✓	✓	

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

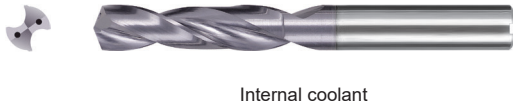
SP drill 3xD

General machining

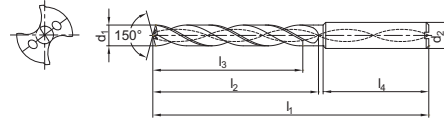
1534SP03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (h7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SP03C-0673	*	6.73	8	79	34	24	36	○
1534SP03C-0683	*	6.83	8	79	34	24	36	○
1534SP03C-0693	*	6.93	8	79	34	24	36	○
1534SP03C-0703	*	7.03	8	79	34	24	36	●
1534SP03C-0713	*	7.13	8	79	41	29	36	○
1534SP03C-0723	*	7.23	8	79	41	29	36	○
1534SP03C-0733	*	7.33	8	79	41	29	36	●
1534SP03C-0743	*	7.43	8	79	41	29	36	○
1534SP03C-0753	*	7.53	8	79	41	29	36	●
1534SP03C-0763	*	7.63	8	79	41	29	36	○
1534SP03C-0773	*	7.73	8	79	41	29	36	○
1534SP03C-0783	*	7.83	8	79	41	29	36	○
1534SP03C-0793	*	7.93	8	79	41	29	36	○
1534SP03C-0803	*	8.03	8	79	41	29	36	●
1534SP03C-0813	*	8.13	10	89	47	35	40	○
1534SP03C-0823	*	8.23	10	89	47	35	40	○
1534SP03C-0833	*	8.33	10	89	47	35	40	●
1534SP03C-0843	*	8.43	10	89	47	35	40	○
1534SP03C-0853	*	8.53	10	89	47	35	40	○
1534SP03C-0863	*	8.63	10	89	47	35	40	○
1534SP03C-0873	*	8.73	10	89	47	35	40	○
1534SP03C-0883	*	8.83	10	89	47	35	40	●
1534SP03C-0893	*	8.93	10	89	47	35	40	○
1534SP03C-0903	*	9.03	10	89	47	35	40	●
1534SP03C-0913	*	9.13	10	89	47	35	40	○
1534SP03C-0923	*	9.23	10	89	47	35	40	○
1534SP03C-0933	*	9.33	10	89	47	35	40	○
1534SP03C-0943	*	9.43	10	89	47	35	40	○
1534SP03C-0953	*	9.53	10	89	47	35	40	●
1534SP03C-0963	*	9.63	10	89	47	35	40	○
1534SP03C-0973	*	9.73	10	89	47	35	40	●
1534SP03C-0983	*	9.83	10	89	47	35	40	●
1534SP03C-0993	*	9.93	10	89	47	35	40	○
1534SP03C-1003	*	10.03	10	89	47	35	40	●
1534SP03C-1013	*	10.13	12	102	55	40	45	○
1534SP03C-1023	*	10.23	12	102	55	40	45	○
1534SP03C-1033	*	10.33	12	102	55	40	45	○

● Ex stock ○ On demand

Pilot drill Ø = Deep drill Ø + 0,03 mm

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓	✓	✓	

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SP drill 3xD

General machining

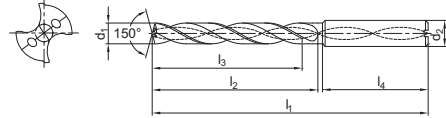
1534SP03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (h7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SP03C-1043	*	10.43	12	102	55	40	45	○
1534SP03C-1053	*	10.53	12	102	55	40	45	●
1534SP03C-1063	*	10.63	12	102	55	40	45	○
1534SP03C-1073	*	10.73	12	102	55	40	45	○
1534SP03C-1083	*	10.83	12	102	55	40	45	●
1534SP03C-1093	*	10.93	12	102	55	40	45	○
1534SP03C-1103	*	11.03	12	102	55	40	45	●
1534SP03C-1113	*	11.13	12	102	55	40	45	○
1534SP03C-1123	*	11.23	12	102	55	40	45	○
1534SP03C-1133	*	11.33	12	102	55	40	45	○
1534SP03C-1143	*	11.43	12	102	55	40	45	○
1534SP03C-1153	*	11.53	12	102	55	40	45	●
1534SP03C-1163	*	11.63	12	102	55	40	45	○
1534SP03C-1173	*	11.73	12	102	55	40	45	○
1534SP03C-1183	*	11.83	12	102	55	40	45	●
1534SP03C-1193	*	11.93	12	102	55	40	45	○
1534SP03C-1203	*	12.03	12	102	55	40	45	●
1534SP03C-1213	*	12.13	14	107	60	43	45	○
1534SP03C-1223	*	12.23	14	107	60	43	45	○
1534SP03C-1233	*	12.33	14	107	60	43	45	○
1534SP03C-1243	*	12.43	14	107	60	43	45	○
1534SP03C-1253	*	12.53	14	107	60	43	45	●
1534SP03C-1263	*	12.63	14	107	60	43	45	○
1534SP03C-1273	*	12.73	14	107	60	43	45	○
1534SP03C-1283	*	12.83	14	107	60	43	45	○
1534SP03C-1293	*	12.93	14	107	60	43	45	○
1534SP03C-1303	*	13.03	14	107	60	43	45	○
1534SP03C-1353	*	13.53	14	107	60	43	45	○
1534SP03C-1403	*	14.03	14	107	60	43	45	○
1534SP03C-1453	*	14.53	16	115	65	45	48	○
1534SP03C-1503	*	15.03	16	115	65	45	48	○
1534SP03C-1553	*	15.53	16	115	65	45	48	○
1534SP03C-1603	*	16.03	16	115	65	45	48	○
1534SP03C-1653	*	16.53	18	123	73	51	48	○
1534SP03C-1703	*	17.03	18	123	73	51	48	○
1534SP03C-1753	*	17.53	18	123	73	51	48	○
1534SP03C-1803	*	18.03	18	123	73	51	48	○

● Ex stock ○ On demand

Pilot drill Ø = Deep drill Ø + 0,03 mm

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓	✓	✓	

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

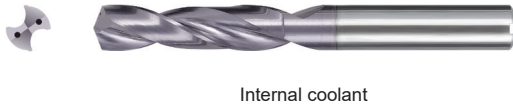
SP drill 3xD

General machining

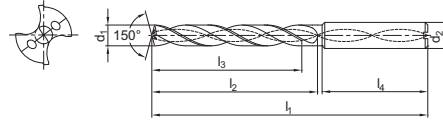
1534SP03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (h7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SP03C-1853	*	18.53	20	131	79	55	50	○
1534SP03C-1903	*	19.03	20	131	79	55	50	○
1534SP03C-1953	*	19.53	20	131	79	55	50	○
1534SP03C-2003	*	20.03	20	131	79	55	50	○

- Ex stock ○ On demand

Pilot drill Ø = Deep drill Ø + 0,03 mm

- * With internal cooling

Application field					
P	M	K	N	S	H
✓	✓	✓	✓	✓	

✓ Very suitable

✓ Suitable

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IMPORTANT INFORMATION

Recommended applications for the **UD series**

Feed calculator

ISO group	Material	Cutting speed v_c (m/min)	Feed factor F_m
M	Stainless steels	80	0,02
S	Ni- / Co-based alloys	40	0,01
S	Titanium alloys	60	0,012

Formula: feed per revolution (F_n) $D \times F_m$
Example: drill diameter (D) 10 mm
 material stainless steel

$F_n = 10 \text{ mm} \times 0,02 = 0,2 \text{ mm/r}$
--



Fig.: 1536UD05C

UD drill 3xD Steel, stainless steel, heat-resistant alloys

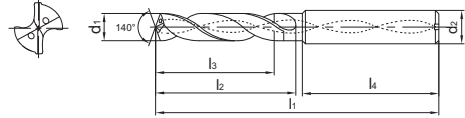
1534UD03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1534UD03C-0300	*	3	6	62	20	14	36	●
1534UD03C-0310	*	3.1	6	62	20	14	36	○
1534UD03C-0320	*	3.2	6	62	20	14	36	○
1534UD03C-0330	*	3.3	6	62	20	14	36	●
1534UD03C-0340	*	3.4	6	62	20	14	36	○
1534UD03C-0350	*	3.5	6	62	20	14	36	●
1534UD03C-0360	*	3.6	6	62	20	14	36	○
1534UD03C-0370	*	3.7	6	62	20	14	36	●
1534UD03C-0380	*	3.8	6	66	24	17	36	○
1534UD03C-0390	*	3.9	6	66	24	17	36	○
1534UD03C-0400	*	4	6	66	24	17	36	●
1534UD03C-0410	*	4.1	6	66	24	17	36	○
1534UD03C-0420	*	4.2	6	66	24	17	36	●
1534UD03C-0430	*	4.3	6	66	24	17	36	●
1534UD03C-0440	*	4.4	6	66	24	17	36	○
1534UD03C-0450	*	4.5	6	66	24	17	36	●
1534UD03C-0460	*	4.6	6	66	24	17	36	○
1534UD03C-0465	*	4.65	6	66	24	17	36	●
1534UD03C-0470	*	4.7	6	66	24	17	36	○
1534UD03C-0480	*	4.8	6	66	28	20	36	●
1534UD03C-0490	*	4.9	6	66	28	20	36	○
1534UD03C-0500	*	5	6	66	28	20	36	●
1534UD03C-0510	*	5.1	6	66	28	20	36	○
1534UD03C-0520	*	5.2	6	66	28	20	36	○
1534UD03C-0530	*	5.3	6	66	28	20	36	○
1534UD03C-0540	*	5.4	6	66	28	20	36	○
1534UD03C-0550	*	5.5	6	66	28	20	36	●
1534UD03C-0560	*	5.6	6	66	28	20	36	○
1534UD03C-0570	*	5.7	6	66	28	20	36	●
1534UD03C-0580	*	5.8	6	66	28	20	36	○
1534UD03C-0590	*	5.9	6	66	28	20	36	●
1534UD03C-0600	*	6	6	66	28	20	36	●
1534UD03C-0610	*	6.1	8	79	34	24	36	○
1534UD03C-0620	*	6.2	8	79	34	24	36	○
1534UD03C-0630	*	6.3	8	79	34	24	36	○
1534UD03C-0640	*	6.4	8	79	34	24	36	○
1534UD03C-0650	*	6.5	8	79	34	24	36	●

- Ex stock ○ On demand
- * With internal cooling

Application field

P	M	K	N	S	H
✓	✓			✓	

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

UD drill 3xD

Steel, stainless steel, heat-resistant alloys

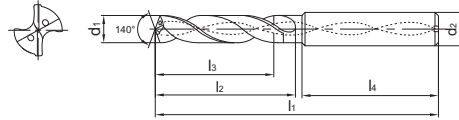
1534UD03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1534UD03C-0660	*	6.6	8	79	34	24	36	○
1534UD03C-0670	*	6.7	8	79	34	24	36	○
1534UD03C-0680	*	6.8	8	79	34	24	36	●
1534UD03C-0690	*	6.9	8	79	34	24	36	○
1534UD03C-0700	*	7	8	79	34	24	36	●
1534UD03C-0710	*	7.1	8	79	41	29	36	○
1534UD03C-0720	*	7.2	8	79	41	29	36	○
1534UD03C-0730	*	7.3	8	79	41	29	36	○
1534UD03C-0740	*	7.4	8	79	41	29	36	●
1534UD03C-0750	*	7.5	8	79	41	29	36	●
1534UD03C-0760	*	7.6	8	79	41	29	36	○
1534UD03C-0770	*	7.7	8	79	41	29	36	○
1534UD03C-0780	*	7.8	8	79	41	29	36	○
1534UD03C-0790	*	7.9	8	79	41	29	36	○
1534UD03C-0800	*	8	8	79	41	29	36	●
1534UD03C-0810	*	8.1	10	89	47	35	40	○
1534UD03C-0820	*	8.2	10	89	47	35	40	○
1534UD03C-0830	*	8.3	10	89	47	35	40	○
1534UD03C-0840	*	8.4	10	89	47	35	40	○
1534UD03C-0850	*	8.5	10	89	47	35	40	●
1534UD03C-0860	*	8.6	10	89	47	35	40	○
1534UD03C-0870	*	8.7	10	89	47	35	40	○
1534UD03C-0880	*	8.8	10	89	47	35	40	●
1534UD03C-0890	*	8.9	10	89	47	35	40	○
1534UD03C-0900	*	9	10	89	47	35	40	●
1534UD03C-0910	*	9.1	10	89	47	35	40	○
1534UD03C-0920	*	9.2	10	89	47	35	40	○
1534UD03C-0930	*	9.3	10	89	47	35	40	●
1534UD03C-0940	*	9.4	10	89	47	35	40	○
1534UD03C-0950	*	9.5	10	89	47	35	40	●
1534UD03C-0960	*	9.6	10	89	47	35	40	○
1534UD03C-0970	*	9.7	10	89	47	35	40	○
1534UD03C-0980	*	9.8	10	89	47	35	40	○
1534UD03C-0990	*	9.9	10	89	47	35	40	○
1534UD03C-1000	*	10	10	89	47	35	40	●
1534UD03C-1020	*	10.2	12	102	55	40	45	●
1534UD03C-1050	*	10.5	12	102	55	40	45	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓			✓	

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



UD drill 3xD Steel, stainless steel, heat-resistant alloys

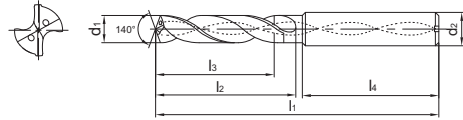
1534UD03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1534UD03C-1100	*	11	12	102	55	40	45	●
1534UD03C-1150	*	11.5	12	102	55	40	45	●
1534UD03C-1200	*	12	12	102	55	40	45	●
1534UD03C-1250	*	12.5	14	107	60	43	45	●
1534UD03C-1300	*	13	14	107	60	43	45	●
1534UD03C-1350	*	13.5	14	107	60	43	45	●
1534UD03C-1400	*	14	14	107	60	43	45	●
1534UD03C-1450	*	14.5	16	115	65	45	48	●
1534UD03C-1500	*	15	16	115	65	45	48	●
1534UD03C-1550	*	15.5	16	115	65	45	48	●
1534UD03C-1600	*	16	16	115	65	45	48	●
1534UD03C-1650	*	16.5	18	123	73	51	48	●
1534UD03C-1700	*	17	18	123	73	51	48	●
1534UD03C-1750	*	17.5	18	123	73	51	48	●
1534UD03C-1800	*	18	18	123	73	51	48	●
1534UD03C-1850	*	18.5	20	131	79	55	50	●
1534UD03C-1900	*	19	20	131	79	55	50	●
1534UD03C-1950	*	19.5	20	131	79	55	50	●
1534UD03C-2000	*	20	20	131	79	55	50	●

- Ex stock ○ On demand
- * With internal cooling

Application field

P	M	K	N	S	H
✓	✓			✓	

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

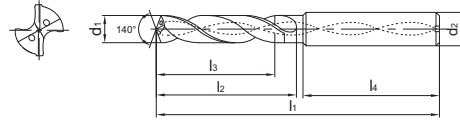
Nonstandard order > C150

UD drill 5xD**Steel, stainless steel, heat-resistant alloys****1536UD05C**

- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1536UD05C-0300	*	3	6	66	28	23	36	●
1536UD05C-0310	*	3.1	6	66	28	23	36	●
1536UD05C-0320	*	3.2	6	66	28	23	36	○
1536UD05C-0330	*	3.3	6	66	28	23	36	●
1536UD05C-0340	*	3.4	6	66	28	23	36	●
1536UD05C-0350	*	3.5	6	66	28	23	36	●
1536UD05C-0360	*	3.6	6	66	28	23	36	○
1536UD05C-0370	*	3.7	6	66	28	23	36	●
1536UD05C-0380	*	3.8	6	74	36	29	36	●
1536UD05C-0390	*	3.9	6	74	36	29	36	○
1536UD05C-0400	*	4	6	74	36	29	36	●
1536UD05C-0410	*	4.1	6	74	36	29	36	○
1536UD05C-0420	*	4.2	6	74	36	29	36	●
1536UD05C-0430	*	4.3	6	74	36	29	36	○
1536UD05C-0440	*	4.4	6	74	36	29	36	○
1536UD05C-0450	*	4.5	6	74	36	29	36	●
1536UD05C-0460	*	4.6	6	74	36	29	36	○
1536UD05C-0465	*	4.65	6	74	36	29	36	●
1536UD05C-0470	*	4.7	6	74	36	29	36	○
1536UD05C-0480	*	4.8	6	82	44	35	36	○
1536UD05C-0490	*	4.9	6	82	44	35	36	○
1536UD05C-0500	*	5	6	82	44	35	36	●
1536UD05C-0510	*	5.1	6	82	44	35	36	●
1536UD05C-0520	*	5.2	6	82	44	35	36	●
1536UD05C-0530	*	5.3	6	82	44	35	36	○
1536UD05C-0540	*	5.4	6	82	44	35	36	○
1536UD05C-0550	*	5.5	6	82	44	35	36	●
1536UD05C-0560	*	5.6	6	82	44	35	36	○
1536UD05C-0570	*	5.7	6	82	44	35	36	○
1536UD05C-0580	*	5.8	6	82	44	35	36	●
1536UD05C-0590	*	5.9	6	82	44	35	36	○
1536UD05C-0600	*	6	6	82	44	35	36	●
1536UD05C-0610	*	6.1	8	91	53	43	36	○
1536UD05C-0620	*	6.2	8	91	53	43	36	○
1536UD05C-0630	*	6.3	8	91	53	43	36	○
1536UD05C-0640	*	6.4	8	91	53	43	36	○
1536UD05C-0650	*	6.5	8	91	53	43	36	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓			✓	

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

UD drill 5xD Steel, stainless steel, heat-resistant alloys

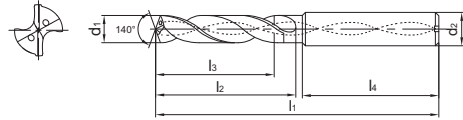
1536UD05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1536UD05C-0660	*	6.6	8	91	53	43	36	○
1536UD05C-0670	*	6.7	8	91	53	43	36	●
1536UD05C-0680	*	6.8	8	91	53	43	36	●
1536UD05C-0690	*	6.9	8	91	53	43	36	○
1536UD05C-0700	*	7	8	91	53	43	36	●
1536UD05C-0710	*	7.1	8	91	53	43	36	○
1536UD05C-0720	*	7.2	8	91	53	43	36	○
1536UD05C-0730	*	7.3	8	91	53	43	36	○
1536UD05C-0740	*	7.4	8	91	53	43	36	●
1536UD05C-0750	*	7.5	8	91	53	43	36	●
1536UD05C-0760	*	7.6	8	91	53	43	36	○
1536UD05C-0770	*	7.7	8	91	53	43	36	○
1536UD05C-0780	*	7.8	8	91	53	43	36	○
1536UD05C-0790	*	7.9	8	91	53	43	36	○
1536UD05C-0800	*	8	8	91	53	43	36	●
1536UD05C-0810	*	8.1	10	103	61	49	40	○
1536UD05C-0820	*	8.2	10	103	61	49	40	○
1536UD05C-0830	*	8.3	10	103	61	49	40	●
1536UD05C-0840	*	8.4	10	103	61	49	40	●
1536UD05C-0850	*	8.5	10	103	61	49	40	●
1536UD05C-0860	*	8.6	10	103	61	49	40	○
1536UD05C-0870	*	8.7	10	103	61	49	40	○
1536UD05C-0880	*	8.8	10	103	61	49	40	○
1536UD05C-0890	*	8.9	10	103	61	49	40	○
1536UD05C-0900	*	9	10	103	61	49	40	●
1536UD05C-0910	*	9.1	10	103	61	49	40	○
1536UD05C-0920	*	9.2	10	103	61	49	40	○
1536UD05C-0930	*	9.3	10	103	61	49	40	●
1536UD05C-0940	*	9.4	10	103	61	49	40	○
1536UD05C-0950	*	9.5	10	103	61	49	40	●
1536UD05C-0960	*	9.6	10	103	61	49	40	○
1536UD05C-0970	*	9.7	10	103	61	49	40	○
1536UD05C-0980	*	9.8	10	103	61	49	40	○
1536UD05C-0990	*	9.9	10	103	61	49	40	○
1536UD05C-1000	*	10	10	103	61	49	40	●
1536UD05C-1020	*	10.2	12	118	71	56	45	●
1536UD05C-1050	*	10.5	12	118	71	56	45	●

- Ex stock ○ On demand
- * With internal cooling

Application field

P	M	K	N	S	H
✓	✓			✓	

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

UD drill 5xD

Steel, stainless steel, heat-resistant alloys

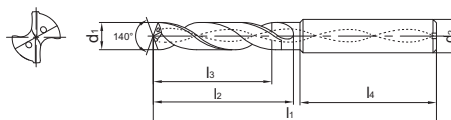
1536UD05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1536UD05C-1100	*	11	12	118	71	56	45	●
1536UD05C-1150	*	11.5	12	118	71	56	45	●
1536UD05C-1200	*	12	12	118	71	56	45	●
1536UD05C-1250	*	12.5	14	124	77	60	45	●
1536UD05C-1300	*	13	14	124	77	60	45	●
1536UD05C-1350	*	13.5	14	124	77	60	45	●
1536UD05C-1400	*	14	14	124	77	60	45	●
1536UD05C-1450	*	14.5	16	133	83	63	48	●
1536UD05C-1500	*	15	16	133	83	63	48	●
1536UD05C-1550	*	15.5	16	133	83	63	48	●
1536UD05C-1600	*	16	16	133	83	63	48	●
1536UD05C-1650	*	16.5	18	143	93	71	48	●
1536UD05C-1700	*	17	18	143	93	71	48	●
1536UD05C-1750	*	17.5	18	143	93	71	48	●
1536UD05C-1800	*	18	18	143	93	71	48	●
1536UD05C-1850	*	18.5	20	153	101	77	50	●
1536UD05C-1900	*	19	20	153	101	77	50	●
1536UD05C-1950	*	19.5	20	153	101	77	50	●
1536UD05C-2000	*	20	20	153	101	77	50	●

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
✓	✓			✓	

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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IMPORTANT INFORMATION

Recommended applications for the **GD series**

Feed calculator

ISO group	Material	Cutting speed v_c (m/min)	Feed factor* F_m
P	Low-alloy steel	130	0,04
	High-alloy steel	100	0,03
K	Cast iron	160	0,04
	Cast steel	130	0,03

Formula: feed per revolution (F_n) $D \times F_m$
Example: drill diameter (D) 10 mm
 material high-alloy steel

$F_n = 10 \text{ mm} \times 0,03 = 0,3 \text{ mm/rev.}$

*The stated values are maximum values. For unstable clamping set-ups or low-powered machines, we recommend reducing the feed by around 30% for a drill diameter of $\varnothing 12$ mm or greater.



Fig.: 1536GD05C

Solid carbide drills GD series

GD drill 3xD

Steel, cast iron

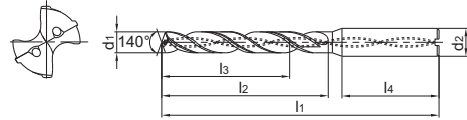
1534GD03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG304
1534GD03C-0300	*	3	6	62	20	14	36	●
1534GD03C-0310	*	3.1	6	62	20	14	36	●
1534GD03C-0320	*	3.2	6	62	20	14	36	●
1534GD03C-0330	*	3.3	6	62	20	14	36	●
1534GD03C-0340	*	3.4	6	62	20	14	36	●
1534GD03C-0350	*	3.5	6	62	20	14	36	●
1534GD03C-0360	*	3.6	6	62	20	14	36	●
1534GD03C-0370	*	3.7	6	62	20	14	36	●
1534GD03C-0380	*	3.8	6	66	24	17	36	●
1534GD03C-0390	*	3.9	6	66	24	17	36	●
1534GD03C-0400	*	4	6	66	24	17	36	●
1534GD03C-0410	*	4.1	6	66	24	17	36	●
1534GD03C-0420	*	4.2	6	66	24	17	36	●
1534GD03C-0430	*	4.3	6	66	24	17	36	●
1534GD03C-0440	*	4.4	6	66	24	17	36	●
1534GD03C-0450	*	4.5	6	66	24	17	36	●
1534GD03C-0460	*	4.6	6	66	24	17	36	●
1534GD03C-0465	*	4.65	6	66	24	17	36	●
1534GD03C-0470	*	4.7	6	66	24	17	36	●
1534GD03C-0480	*	4.8	6	66	28	20	36	●
1534GD03C-0490	*	4.9	6	66	28	20	36	●
1534GD03C-0500	*	5	6	66	28	20	36	●
1534GD03C-0510	*	5.1	6	66	28	20	36	●
1534GD03C-0520	*	5.2	6	66	28	20	36	●
1534GD03C-0530	*	5.3	6	66	28	20	36	●
1534GD03C-0540	*	5.4	6	66	28	20	36	●
1534GD03C-0550	*	5.5	6	66	28	20	36	●
1534GD03C-0560	*	5.6	6	66	28	20	36	●
1534GD03C-0570	*	5.7	6	66	28	20	36	●
1534GD03C-0580	*	5.8	6	66	28	20	36	●
1534GD03C-0590	*	5.9	6	66	28	20	36	●
1534GD03C-0600	*	6	6	66	28	20	36	●
1534GD03C-0610	*	6.1	8	79	34	24	36	●
1534GD03C-0620	*	6.2	8	79	34	24	36	●
1534GD03C-0630	*	6.3	8	79	34	24	36	●
1534GD03C-0640	*	6.4	8	79	34	24	36	●
1534GD03C-0650	*	6.5	8	79	34	24	36	●

- Ex stock ○ On demand
- * With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

GD drill 3xD

Steel, cast iron

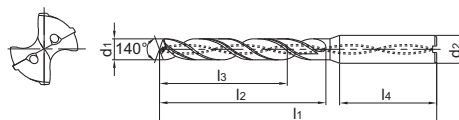
1534GD03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	
1534GD03C-0660	*	6.6	8	79	34	24	36	●
1534GD03C-0670	*	6.7	8	79	34	24	36	●
1534GD03C-0680	*	6.8	8	79	34	24	36	●
1534GD03C-0690	*	6.9	8	79	34	24	36	●
1534GD03C-0700	*	7	8	79	34	24	36	●
1534GD03C-0710	*	7.1	8	79	41	29	36	●
1534GD03C-0720	*	7.2	8	79	41	29	36	●
1534GD03C-0730	*	7.3	8	79	41	29	36	●
1534GD03C-0740	*	7.4	8	79	41	29	36	●
1534GD03C-0750	*	7.5	8	79	41	29	36	●
1534GD03C-0760	*	7.6	8	79	41	29	36	●
1534GD03C-0770	*	7.7	8	79	41	29	36	●
1534GD03C-0780	*	7.8	8	79	41	29	36	●
1534GD03C-0790	*	7.9	8	79	41	29	36	●
1534GD03C-0800	*	8	8	79	41	29	36	●
1534GD03C-0810	*	8.1	10	89	47	35	40	●
1534GD03C-0820	*	8.2	10	89	47	35	40	●
1534GD03C-0830	*	8.3	10	89	47	35	40	●
1534GD03C-0840	*	8.4	10	89	47	35	40	●
1534GD03C-0850	*	8.5	10	89	47	35	40	●
1534GD03C-0860	*	8.6	10	89	47	35	40	●
1534GD03C-0870	*	8.7	10	89	47	35	40	●
1534GD03C-0880	*	8.8	10	89	47	35	40	●
1534GD03C-0890	*	8.9	10	89	47	35	40	●
1534GD03C-0900	*	9	10	89	47	35	40	●
1534GD03C-0910	*	9.1	10	89	47	35	40	●
1534GD03C-0920	*	9.2	10	89	47	35	40	●
1534GD03C-0930	*	9.3	10	89	47	35	40	●
1534GD03C-0940	*	9.4	10	89	47	35	40	●
1534GD03C-0950	*	9.5	10	89	47	35	40	●
1534GD03C-0960	*	9.6	10	89	47	35	40	●
1534GD03C-0970	*	9.7	10	89	47	35	40	●
1534GD03C-0980	*	9.8	10	89	47	35	40	●
1534GD03C-0990	*	9.9	10	89	47	35	40	●
1534GD03C-1000	*	10	10	89	47	35	40	●
1534GD03C-1020	*	10.2	12	102	55	40	45	●
1534GD03C-1050	*	10.5	12	102	55	40	45	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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GD drill 3xD

Steel, cast iron

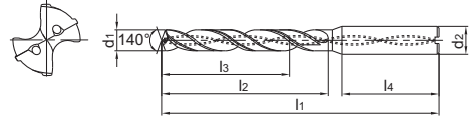
1534GD03C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG304
1534GD03C-1100	*	11	12	102	55	40	45	●
1534GD03C-1140	*	11.4	12	102	55	40	45	●
1534GD03C-1150	*	11.5	12	102	55	40	45	●
1534GD03C-1200	*	12	12	102	55	40	45	●
1534GD03C-1250	*	12.5	14	107	60	43	45	●
1534GD03C-1300	*	13	14	107	60	43	45	●
1534GD03C-1350	*	13.5	14	107	60	43	45	●
1534GD03C-1400	*	14	14	107	60	43	45	●
1534GD03C-1450	*	14.5	16	115	65	45	48	●
1534GD03C-1500	*	15	16	115	65	45	48	●
1534GD03C-1550	*	15.5	16	115	65	45	48	●
1534GD03C-1600	*	16	16	115	65	45	48	●
1534GD03C-1650	*	16.5	18	123	73	51	48	●
1534GD03C-1700	*	17	18	123	73	51	48	●
1534GD03C-1750	*	17.5	18	123	73	51	48	●
1534GD03C-1800	*	18	18	123	73	51	48	●
1534GD03C-1850	*	18.5	20	131	79	55	50	●
1534GD03C-1900	*	19	20	131	79	55	50	●
1534GD03C-1950	*	19.5	20	131	79	55	50	●
1534GD03C-2000	*	20	20	131	79	55	50	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

GD drill 5xD

Steel, cast iron

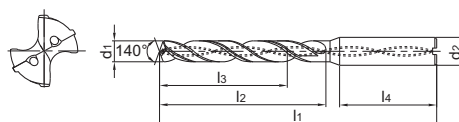
1536GD05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG304
1536GD05C-0300	*	3	6	66	28	23	36	●
1536GD05C-0310	*	3.1	6	66	28	23	36	●
1536GD05C-0320	*	3.2	6	66	28	23	36	●
1536GD05C-0330	*	3.3	6	66	28	23	36	●
1536GD05C-0340	*	3.4	6	66	28	23	36	●
1536GD05C-0350	*	3.5	6	66	28	23	36	●
1536GD05C-0360	*	3.6	6	66	28	23	36	●
1536GD05C-0370	*	3.7	6	66	28	23	36	●
1536GD05C-0380	*	3.8	6	74	36	29	36	●
1536GD05C-0390	*	3.9	6	74	36	29	36	●
1536GD05C-0400	*	4	6	74	36	29	36	●
1536GD05C-0410	*	4.1	6	74	36	29	36	●
1536GD05C-0420	*	4.2	6	74	36	29	36	●
1536GD05C-0430	*	4.3	6	74	36	29	36	●
1536GD05C-0440	*	4.4	6	74	36	29	36	●
1536GD05C-0450	*	4.5	6	74	36	29	36	●
1536GD05C-0460	*	4.6	6	74	36	29	36	●
1536GD05C-0465	*	4.65	6	74	36	29	36	●
1536GD05C-0470	*	4.7	6	74	36	29	36	●
1536GD05C-0480	*	4.8	6	82	44	35	36	●
1536GD05C-0490	*	4.9	6	82	44	35	36	●
1536GD05C-0500	*	5	6	82	44	35	36	●
1536GD05C-0508	*	5.08	6	82	44	35	36	○
1536GD05C-0510	*	5.1	6	82	44	35	36	●
1536GD05C-0520	*	5.2	6	82	44	35	36	●
1536GD05C-0530	*	5.3	6	82	44	35	36	●
1536GD05C-0540	*	5.4	6	82	44	35	36	●
1536GD05C-0550	*	5.5	6	82	44	35	36	●
1536GD05C-0560	*	5.6	6	82	44	35	36	●
1536GD05C-0570	*	5.7	6	82	44	35	36	●
1536GD05C-0580	*	5.8	6	82	44	35	36	●
1536GD05C-0590	*	5.9	6	82	44	35	36	●
1536GD05C-0600	*	6	6	82	44	35	36	●
1536GD05C-0610	*	6.1	8	91	53	43	36	●
1536GD05C-0620	*	6.2	8	91	53	43	36	●
1536GD05C-0630	*	6.3	8	91	53	43	36	●
1536GD05C-0640	*	6.4	8	91	53	43	36	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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GD drill 5xD

Steel, cast iron

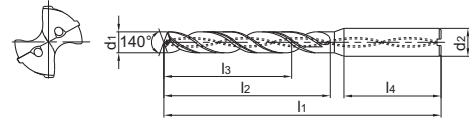
1536GD05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG304
1536GD05C-0650	*	6.5	8	91	53	43	36	●
1536GD05C-0660	*	6.6	8	91	53	43	36	●
1536GD05C-0670	*	6.7	8	91	53	43	36	●
1536GD05C-0680	*	6.8	8	91	53	43	36	●
1536GD05C-0690	*	6.9	8	91	53	43	36	●
1536GD05C-0700	*	7	8	91	53	43	36	●
1536GD05C-0710	*	7.1	8	91	53	43	36	●
1536GD05C-0720	*	7.2	8	91	53	43	36	●
1536GD05C-0730	*	7.3	8	91	53	43	36	●
1536GD05C-0740	*	7.4	8	91	53	43	36	●
1536GD05C-0750	*	7.5	8	91	53	43	36	●
1536GD05C-0760	*	7.6	8	91	53	43	36	●
1536GD05C-0770	*	7.7	8	91	53	43	36	●
1536GD05C-0780	*	7.8	8	91	53	43	36	●
1536GD05C-0790	*	7.9	8	91	53	43	36	●
1536GD05C-0800	*	8	8	91	53	43	36	●
1536GD05C-0810	*	8.1	10	103	61	49	40	●
1536GD05C-0820	*	8.2	10	103	61	49	40	●
1536GD05C-0830	*	8.3	10	103	61	49	40	●
1536GD05C-0840	*	8.4	10	103	61	49	40	●
1536GD05C-0850	*	8.5	10	103	61	49	40	●
1536GD05C-0860	*	8.6	10	103	61	49	40	●
1536GD05C-0870	*	8.7	10	103	61	49	40	●
1536GD05C-0880	*	8.8	10	103	61	49	40	●
1536GD05C-0890	*	8.9	10	103	61	49	40	●
1536GD05C-0900	*	9	10	103	61	49	40	●
1536GD05C-0910	*	9.1	10	103	61	49	40	●
1536GD05C-0920	*	9.2	10	103	61	49	40	●
1536GD05C-0930	*	9.3	10	103	61	49	40	●
1536GD05C-0940	*	9.4	10	103	61	49	40	●
1536GD05C-0950	*	9.5	10	103	61	49	40	●
1536GD05C-0960	*	9.6	10	103	61	49	40	●
1536GD05C-0970	*	9.7	10	103	61	49	40	●
1536GD05C-0980	*	9.8	10	103	61	49	40	●
1536GD05C-0990	*	9.9	10	103	61	49	40	●
1536GD05C-1000	*	10	10	103	61	49	40	●
1536GD05C-1010	*	10.1	12	118	71	56	45	●

- Ex stock ○ On demand
- * With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

GD drill 5xD

Steel, cast iron

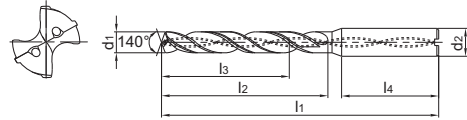
1536GD05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG304
1536GD05C-1020	*	10.2	12	118	71	56	45	●
1536GD05C-1030	*	10.3	12	118	71	56	45	●
1536GD05C-1040	*	10.4	12	118	71	56	45	●
1536GD05C-1050	*	10.5	12	118	71	56	45	●
1536GD05C-1060	*	10.6	12	118	71	56	45	●
1536GD05C-1070	*	10.7	12	118	71	56	45	●
1536GD05C-1080	*	10.8	12	118	71	56	45	●
1536GD05C-1090	*	10.9	12	118	71	56	45	●
1536GD05C-1100	*	11	12	118	71	56	45	●
1536GD05C-1130	*	11.3	12	118	71	56	45	●
1536GD05C-1140	*	11.4	12	118	71	56	45	●
1536GD05C-1150	*	11.5	12	118	71	56	45	●
1536GD05C-1200	*	12	12	118	71	56	45	●
1536GD05C-1250	*	12.5	14	124	77	60	45	●
1536GD05C-1280	*	12.8	14	124	77	60	45	●
1536GD05C-1300	*	13	14	124	77	60	45	●
1536GD05C-1350	*	13.5	14	124	77	60	45	●
1536GD05C-1380	*	13.8	14	124	77	60	45	○
1536GD05C-1400	*	14	14	124	77	60	45	●
1536GD05C-1450	*	14.5	16	133	83	63	48	●
1536GD05C-1500	*	15	16	133	83	63	48	●
1536GD05C-1510	*	15.1	16	133	83	63	48	○
1536GD05C-1550	*	15.5	16	133	83	63	48	●
1536GD05C-1600	*	16	16	133	83	63	48	●
1536GD05C-1650	*	16.5	18	143	93	71	48	●
1536GD05C-1700	*	17	18	143	93	71	48	●
1536GD05C-1750	*	17.5	18	143	93	71	48	●
1536GD05C-1800	*	18	18	143	93	71	48	●
1536GD05C-1850	*	18.5	20	153	101	77	50	●
1536GD05C-1900	*	19	20	153	101	77	50	●
1536GD05C-1950	*	19.5	20	153	101	77	50	●
1536GD05C-2000	*	20	20	153	101	77	50	●

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
✓		✓			

- ✓ Very suitable
- ✓ Suitable



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Solid carbide drills GD series

GD drill 5xD

Steel, cast iron

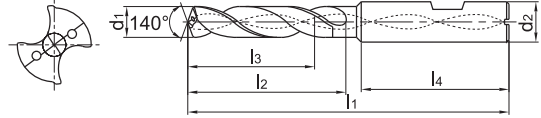
1636GD05C



- Type of shank DIN 6535HB
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG304
1636GD05C-0500	*	5	6	82	44	35	36	●
1636GD05C-0550	*	5.5	6	82	44	35	36	●
1636GD05C-0600	*	6	6	82	44	35	36	●
1636GD05C-0650	*	6.5	8	91	53	43	36	●
1636GD05C-0680	*	6.8	8	91	53	43	36	●
1636GD05C-0700	*	7	8	91	53	43	36	●
1636GD05C-0740	*	7.4	8	91	53	43	36	●
1636GD05C-0750	*	7.5	8	91	53	43	36	●
1636GD05C-0780	*	7.8	8	91	53	43	36	●
1636GD05C-0800	*	8	8	91	53	43	36	●
1636GD05C-0850	*	8.5	10	103	61	49	40	●
1636GD05C-0880	*	8.8	10	103	61	49	40	●
1636GD05C-0900	*	9	10	103	61	49	40	●
1636GD05C-0930	*	9.3	10	103	61	49	40	●
1636GD05C-0950	*	9.5	10	103	61	49	40	●
1636GD05C-0980	*	9.8	10	103	61	49	40	●
1636GD05C-1000	*	10	10	103	61	49	40	●
1636GD05C-1020	*	10.2	12	118	71	56	45	●
1636GD05C-1050	*	10.5	12	118	71	56	45	●
1636GD05C-1080	*	10.8	12	118	71	56	45	●
1636GD05C-1100	*	11	12	118	71	56	45	●
1636GD05C-1150	*	11.5	12	118	71	56	45	●
1636GD05C-1180	*	11.8	12	118	71	56	45	●
1636GD05C-1200	*	12	12	118	71	56	45	●
1636GD05C-1250	*	12.5	14	124	77	60	45	●
1636GD05C-1280	*	12.8	14	124	77	60	45	○
1636GD05C-1300	*	13	14	124	77	60	45	●
1636GD05C-1350	*	13.5	14	124	77	60	45	●
1636GD05C-1380	*	13.8	14	124	77	60	45	●
1636GD05C-1400	*	14	14	124	77	60	45	●
1636GD05C-1450	*	14.5	16	133	83	63	48	●
1636GD05C-1480	*	14.8	16	133	83	63	48	●
1636GD05C-1500	*	15	16	133	83	63	48	●
1636GD05C-1550	*	15.5	16	133	83	63	48	●
1636GD05C-1580	*	15.8	16	133	83	63	48	●
1636GD05C-1600	*	16	16	133	83	63	48	●
1636GD05C-1650	*	16.5	18	143	93	71	48	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

GD drill 5xD

Steel, cast iron

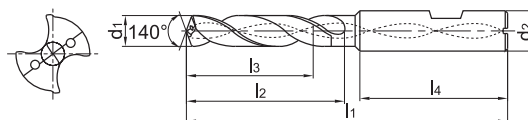
1636GD05C



- Type of shank DIN 6535HB
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG304
1636GD05C-1680	*	16.8	18	143	93	71	48	○
1636GD05C-1700	*	17	18	143	93	71	48	●
1636GD05C-1750	*	17.5	18	143	93	71	48	●
1636GD05C-1780	*	17.8	18	143	93	71	48	●
1636GD05C-1800	*	18	18	143	93	71	48	●
1636GD05C-1850	*	18.5	20	153	101	77	50	●
1636GD05C-1880	*	18.8	20	153	101	77	50	○
1636GD05C-1900	*	19	20	153	101	77	50	●
1636GD05C-1950	*	19.5	20	153	101	77	50	●
1636GD05C-1980	*	19.8	20	153	101	77	50	●
1636GD05C-2000	*	20	20	153	101	77	50	●

- Ex stock ○ On demand
- * With internal cooling

Application field					
P	M	K	N	S	H
✓		✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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Hard materials

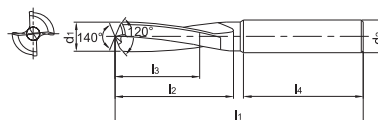
1534SH03



– Type of shank DIN 6535HA



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SH03-0300		3	6	62	20	14	36	○
1534SH03-0330		3.3	6	62	20	14	36	●
1534SH03-0400		4	6	66	24	17	36	○
1534SH03-0420		4.2	6	66	24	17	36	●
1534SH03-0500		5	6	66	28	20	36	○
1534SH03-0600		6	6	66	28	20	36	○
1534SH03-0675		6.75	8	79	34	24	36	○
1534SH03-0700		7	8	79	34	24	36	○
1534SH03-0800		8	8	79	41	29	36	○
1534SH03-0850		8.5	10	89	47	35	40	○
1534SH03-0900		9	10	89	47	35	40	○
1534SH03-1000		10	10	89	47	35	40	○
1534SH03-1025		10.25	12	102	55	40	45	○
1534SH03-1050		10.5	12	102	55	40	45	○
1534SH03-1200		12	12	102	55	40	45	○
1534SH03-1250		12.5	14	107	60	43	45	○
1534SH03-1400		14	14	107	60	43	45	○
1534SH03-1450		14.5	16	115	65	45	48	○
1534SH03-1600		16	16	115	65	45	48	○
1534SH03-2000		20	20	131	79	53	50	○

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
					✓

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

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SC drill 3xD

Non-ferrous metals

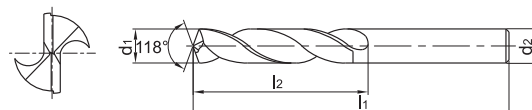
1105SC03



- Factory standard



External coolant



Article	*	Dimensions [mm]				Grade
		d ₁ (h8)	d ₂ (h7)	l ₁	l ₂	YK20F
1105SC03-0200		2	2	38	12	○
1105SC03-0250		2.5	2.5	43	14	○
1105SC03-0280		2.8	2.8	46	16	○
1105SC03-0300		3	3	46	16	○
1105SC03-0310		3.1	3.1	49	18	○
1105SC03-0320		3.2	3.2	49	18	○
1105SC03-0330		3.3	3.3	49	18	○
1105SC03-0340		3.4	3.4	52	20	○
1105SC03-0350		3.5	3.5	52	20	○
1105SC03-0360		3.6	3.6	52	20	○
1105SC03-0370		3.7	3.7	52	20	○
1105SC03-0380		3.8	3.8	55	22	○
1105SC03-0390		3.9	3.9	55	22	○
1105SC03-0400		4	4	55	22	○
1105SC03-0410		4.1	4.1	55	22	○
1105SC03-0420		4.2	4.2	55	22	○
1105SC03-0430		4.3	4.3	58	24	○
1105SC03-0440		4.4	4.4	58	24	○
1105SC03-0450		4.5	4.5	58	24	○
1105SC03-0460		4.6	4.6	58	24	○
1105SC03-0470		4.7	4.7	58	24	○
1105SC03-0480		4.8	4.8	62	26	○
1105SC03-0490		4.9	4.9	62	26	○
1105SC03-0500		5	5	62	26	○
1105SC03-0510		5.1	5.1	62	26	○
1105SC03-0520		5.2	5.2	62	26	○
1105SC03-0530		5.3	5.3	62	26	○
1105SC03-0540		5.4	5.4	66	28	○
1105SC03-0550		5.5	5.5	66	28	○
1105SC03-0560		5.6	5.6	66	28	○
1105SC03-0570		5.7	5.7	66	28	○
1105SC03-0580		5.8	5.8	66	28	○
1105SC03-0590		5.9	5.9	66	28	○
1105SC03-0600		6	6	66	28	○
1105SC03-0610		6.1	6.1	70	31	○
1105SC03-0620		6.2	6.2	70	31	○
1105SC03-0630		6.3	6.3	70	31	○
1105SC03-0640		6.4	6.4	70	31	○

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
			✓		

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

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Non-ferrous metals

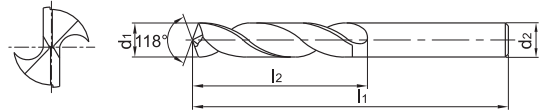
1105SC03



– Factory standard



External coolant



Article	*	Dimensions [mm]				Grade
		d ₁ (h8)	d ₂ (h7)	l ₁	l ₂	YK20F
1105SC03-0650		6.5	6.5	70	31	○
1105SC03-0660		6.6	6.6	70	31	○
1105SC03-0670		6.7	6.7	70	31	○
1105SC03-0680		6.8	6.8	74	34	○
1105SC03-0690		6.9	6.9	74	34	○
1105SC03-0700		7	7	74	34	○
1105SC03-0710		7.1	7.1	74	34	○
1105SC03-0720		7.2	7.2	74	34	○
1105SC03-0730		7.3	7.3	74	34	○
1105SC03-0740		7.4	7.4	74	34	○
1105SC03-0750		7.5	7.5	74	34	○
1105SC03-0760		7.6	7.6	79	37	○
1105SC03-0770		7.7	7.7	79	37	○
1105SC03-0780		7.8	7.8	79	37	○
1105SC03-0790		7.9	7.9	79	37	○
1105SC03-0800		8	8	79	37	○
1105SC03-0810		8.1	8.1	79	37	○
1105SC03-0820		8.2	8.2	79	37	○
1105SC03-0830		8.3	8.3	79	37	○
1105SC03-0840		8.4	8.4	79	37	○
1105SC03-0850		8.5	8.5	79	37	○
1105SC03-0860		8.6	8.6	84	40	○
1105SC03-0870		8.7	8.7	84	40	○
1105SC03-0880		8.8	8.8	84	40	○
1105SC03-0890		8.9	8.9	84	40	○
1105SC03-0900		9	9	84	40	○
1105SC03-0910		9.1	9.1	84	40	○
1105SC03-0920		9.2	9.2	84	40	○
1105SC03-0930		9.3	9.3	84	40	○
1105SC03-0940		9.4	9.4	84	40	○
1105SC03-0950		9.5	9.5	84	40	○
1105SC03-0960		9.6	9.6	89	43	○
1105SC03-0970		9.7	9.7	89	43	○
1105SC03-0980		9.8	9.8	89	43	○
1105SC03-0990		9.9	9.9	89	43	○
1105SC03-1000		10	10	89	43	○
1105SC03-1010		10.1	10.1	89	43	○
1105SC03-1020		10.2	10.2	89	43	○

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
			✓		

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SC drill 3xD

Non-ferrous metals

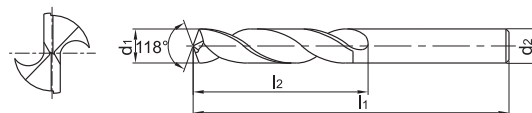
1105SC03



- Factory standard



External coolant



Article	*	Dimensions [mm]				Grade
		d ₁ (h8)	d ₂ (h7)	l ₁	l ₂	YK20F
1105SC03-1040		10.4	10.4	89	43	o
1105SC03-1050		10.5	10.5	89	43	o
1105SC03-1070		10.7	10.7	95	47	o
1105SC03-1080		10.8	10.8	95	47	o
1105SC03-1100		11	11	95	47	o
1105SC03-1150		11.5	11.5	95	47	o
1105SC03-1200		12	12	102	51	o
1105SC03-1250		12.5	12.5	102	51	o
1105SC03-1280		12.8	12.8	102	51	o
1105SC03-1300		13	13	102	51	o
1105SC03-1310		13.1	13.1	102	51	o
1105SC03-1350		13.5	13.5	107	54	o
1105SC03-1400		14	14	107	54	o
1105SC03-1430		14.3	14.3	111	56	o
1105SC03-1450		14.5	14.5	111	56	o
1105SC03-1500		15	15	111	56	o
1105SC03-1600		16	16	115	58	o

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
			✓		

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



SC drill 5xD

Non-ferrous metals

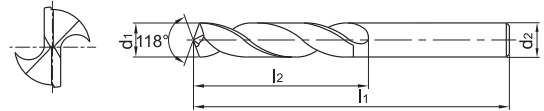
1101SC05



– Factory standard



External coolant



Article	*	Dimensions [mm]				Grade
		d ₁ (h8)	d ₂ (h7)	l ₁	l ₂	YK20F
1101SC05-0200		2	2	49	24	○
1101SC05-0250		2.5	2.5	57	30	○
1101SC05-0280		2.8	2.8	61	33	○
1101SC05-0300		3	3	61	33	○
1101SC05-0350		3.5	3.5	70	39	○
1101SC05-0380		3.8	3.8	75	43	○
1101SC05-0400		4	4	75	43	○
1101SC05-0420		4.2	4.2	75	43	○
1101SC05-0450		4.5	4.5	80	47	○
1101SC05-0480		4.8	4.8	86	52	○
1101SC05-0500		5	5	86	52	○
1101SC05-0550		5.5	5.5	93	57	○
1101SC05-0580		5.8	5.8	93	57	○
1101SC05-0600		6	6	93	57	○
1101SC05-0650		6.5	6.5	101	63	○
1101SC05-0680		6.8	6.8	109	69	○
1101SC05-0700		7	7	109	69	○
1101SC05-0750		7.5	7.5	109	69	○
1101SC05-0780		7.8	7.8	117	75	○
1101SC05-0800		8	8	117	75	○
1101SC05-0850		8.5	8.5	117	75	○
1101SC05-0880		8.8	8.8	125	81	○
1101SC05-0900		9	9	125	81	○
1101SC05-0950		9.5	9.5	125	81	○
1101SC05-0980		9.8	9.8	133	87	○
1101SC05-1000		10	10	133	87	○
1101SC05-1050		10.5	10.5	133	87	○
1101SC05-1080		10.8	10.8	142	94	○
1101SC05-1100		11	11	142	94	○
1101SC05-1150		11.5	11.5	142	94	○
1101SC05-1200		12	12	151	101	○
1101SC05-1250		12.5	12.5	151	101	○
1101SC05-1300		13	13	151	101	○
1101SC05-1350		13.5	13.5	160	108	○
1101SC05-1400		14	14	160	108	○
1101SC05-1450		14.5	14.5	169	114	○
1101SC05-1500		15	15	169	114	○
1101SC05-1550		15.5	15.5	178	120	○
1101SC05-1600		16	16	178	120	○

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
			✓		

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

PA drill 3xD

Non-ferrous metals

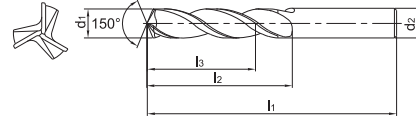
1165PA03



- Factory standard



External coolant



Article	*	Dimensions [mm]					Grade	
		d ₁ (h7)	d ₂ (h7)	l ₁	l ₂	l ₃	KDG303	YK30F
1165PA03-0300		3	3	46	16	12	●	●
1165PA03-0310		3.1	3.1	49	18	14	○	○
1165PA03-0320		3.2	3.2	49	18	14	○	●
1165PA03-0330		3.3	3.3	49	18	14	○	○
1165PA03-0340		3.4	3.4	52	20	15	○	●
1165PA03-0350		3.5	3.5	52	20	15	○	○
1165PA03-0360		3.6	3.6	52	20	15	○	○
1165PA03-0370		3.7	3.7	52	20	15	○	○
1165PA03-0380		3.8	3.8	55	22	17	○	○
1165PA03-0390		3.9	3.9	55	22	17	○	○
1165PA03-0400		4	4	55	22	17	○	○
1165PA03-0410		4.1	4.1	55	22	17	○	○
1165PA03-0420		4.2	4.2	55	22	17	○	○
1165PA03-0430		4.3	4.3	58	24	18	○	○
1165PA03-0440		4.4	4.4	58	24	18	○	○
1165PA03-0450		4.5	4.5	58	24	18	○	○
1165PA03-0460		4.6	4.6	58	24	18	○	○
1165PA03-0470		4.7	4.7	58	24	18	○	○
1165PA03-0480		4.8	4.8	62	26	20	○	○
1165PA03-0490		4.9	4.9	62	26	20	○	○
1165PA03-0500		5	5	62	26	20	○	○
1165PA03-0510		5.1	5.1	62	26	20	○	○
1165PA03-0520		5.2	5.2	62	26	20	○	○
1165PA03-0530		5.3	5.3	62	26	20	○	○
1165PA03-0540		5.4	5.4	66	28	21	○	○
1165PA03-0550		5.5	5.5	66	28	21	○	○
1165PA03-0560		5.6	5.6	66	28	21	○	○
1165PA03-0570		5.7	5.7	66	28	21	○	○
1165PA03-0580		5.8	5.8	66	28	21	○	○
1165PA03-0590		5.9	5.9	66	28	21	○	○
1165PA03-0600		6	6	66	28	21	○	○
1165PA03-0610		6.1	6.1	70	31	23	○	○
1165PA03-0620		6.2	6.2	70	31	23	○	○
1165PA03-0630		6.3	6.3	70	31	23	○	○
1165PA03-0640		6.4	6.4	70	31	23	○	○
1165PA03-0650		6.5	6.5	70	31	23	○	○
1165PA03-0660		6.6	6.6	70	31	23	○	●
1165PA03-0670		6.7	6.7	70	31	23	○	●

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
			✓		

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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PA drill 3xD

Non-ferrous metals

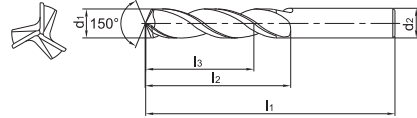
1165PA03



– Factory standard



External coolant



Article	*	Dimensions [mm]					Grade	
		d ₁ (h7)	d ₂ (h7)	l ₁	l ₂	l ₃	KDG303	YK30F
1165PA03-0680		6.8	6.8	74	34	25	○	○
1165PA03-0690		6.9	6.9	74	34	25	○	○
1165PA03-0700		7	7	74	34	25	○	○
1165PA03-0710		7.1	7.1	74	34	25	○	○
1165PA03-0720		7.2	7.2	74	34	25	○	○
1165PA03-0730		7.3	7.3	74	34	25	○	○
1165PA03-0740		7.4	7.4	74	34	25	○	○
1165PA03-0750		7.5	7.5	74	34	25	○	○
1165PA03-0760		7.6	7.6	79	37	27	○	○
1165PA03-0770		7.7	7.7	79	37	27	○	○
1165PA03-0780		7.8	7.8	79	37	27	○	○
1165PA03-0790		7.9	7.9	79	37	27	○	○
1165PA03-0800		8	8	79	37	27	○	○
1165PA03-0810		8.1	8.1	79	37	27	○	○
1165PA03-0820		8.2	8.2	79	37	27	○	○
1165PA03-0830		8.3	8.3	79	37	27	○	○
1165PA03-0840		8.4	8.4	79	37	27	○	○
1165PA03-0850		8.5	8.5	79	37	27	○	○
1165PA03-0860		8.6	8.6	84	40	29	○	●
1165PA03-0870		8.7	8.7	84	40	29	○	○
1165PA03-0880		8.8	8.8	84	40	29	○	○
1165PA03-0890		8.9	8.9	84	40	29	○	○
1165PA03-0900		9	9	84	40	29	○	○
1165PA03-0910		9.1	9.1	84	40	29	○	○
1165PA03-0920		9.2	9.2	84	40	29	○	○
1165PA03-0930		9.3	9.3	84	40	29	○	○
1165PA03-0940		9.4	9.4	84	40	29	○	○
1165PA03-0950		9.5	9.5	84	40	29	○	○
1165PA03-0960		9.6	9.6	89	43	31	○	○
1165PA03-0970		9.7	9.7	89	43	31	○	○
1165PA03-0980		9.8	9.8	89	43	31	○	○
1165PA03-0990		9.9	9.9	89	43	31	○	○
1165PA03-1000		10	10	89	43	31	○	○
1165PA03-1010		10.1	10.1	89	43	31	○	○
1165PA03-1020		10.2	10.2	89	43	31	○	○
1165PA03-1030		10.3	10.3	89	43	31	○	○
1165PA03-1050		10.5	10.5	89	43	31	○	○
1165PA03-1100		11	11	95	47	33	○	○

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
			✓		

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

PA drill 3xD

Non-ferrous metals

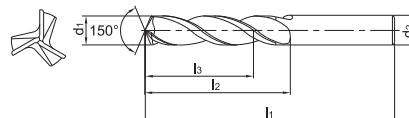
1165PA03



– Factory standard



External coolant



Article	*	Dimensions [mm]					Grade	
		d ₁ (h7)	d ₂ (h7)	l ₁	l ₂	l ₃	KDG303	YK30F
1165PA03-1120		11.2	11.2	95	47	33	○	○
1165PA03-1150		11.5	11.5	95	47	33	○	○
1165PA03-1180		11.8	11.8	95	47	33	○	○
1165PA03-1200		12	12	102	51	35	○	○
1165PA03-1210		12.1	12.1	102	51	35	○	○
1165PA03-1250		12.5	12.5	102	51	35	○	○
1165PA03-1300		13	13	102	51	35	○	○
1165PA03-1350		13.5	13.5	107	54	37	○	○
1165PA03-1400		14	14	107	54	37	○	○
1165PA03-1450		14.5	14.5	111	56	38	○	○
1165PA03-1500		15	15	111	56	38	○	○
1165PA03-1550		15.5	15.5	115	58	38	○	○
1165PA03-1600		16	16	115	58	38	○	○
1165PA03-1650		16.5	16.5	119	60	39	○	○
1165PA03-1700		17	17	119	60	39	○	○
1165PA03-1750		17.5	17.5	123	62	40	○	○
1165PA03-1800		18	18	123	62	40	○	○
1165PA03-1850		18.5	18.5	127	64	41	○	○
1165PA03-1900		19	19	127	64	41	○	○
1165PA03-1950		19.5	19.5	131	66	42	○	○
1165PA03-2000		20	20	131	66	42	○	○

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
			✓		

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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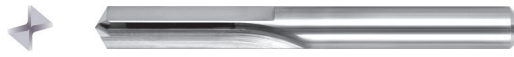
PC drill 5xD

Cast iron

1576PC05/1576PC05C



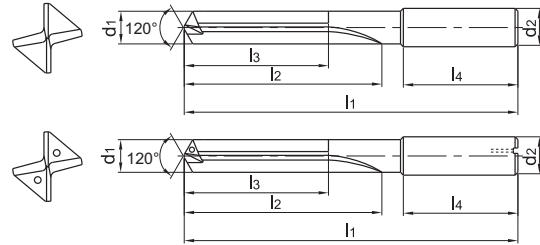
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade	
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	YK20F	
1576PC05-0400		4	6	74	36	29	36		○
1576PC05C-0400	*	4	6	74	36	29	36		●
1576PC05-0420		4.2	6	74	36	29	36		○
1576PC05C-0420	*	4.2	6	74	36	29	36		●
1576PC05-0500		5	6	82	44	35	36		○
1576PC05C-0500	*	5	6	82	44	35	36		●
1576PC05-0600		6	6	82	44	35	36		○
1576PC05C-0600	*	6	6	82	44	35	36		●
1576PC05-0675		6.75	8	91	53	43	36		○
1576PC05C-0675	*	6.75	8	91	53	43	36		●
1576PC05-0700		7	8	91	53	43	36		○
1576PC05C-0700	*	7	8	91	53	43	36		●
1576PC05-0800		8	8	91	53	43	36		○
1576PC05C-0800	*	8	8	91	53	43	36		●
1576PC05-0850		8.5	10	103	61	49	40		○
1576PC05C-0850	*	8.5	10	103	61	49	40		●
1576PC05-0900		9	10	103	61	49	40		○
1576PC05C-0900	*	9	10	103	61	49	40		●
1576PC05-1000		10	10	103	61	49	40		○
1576PC05C-1000	*	10	10	103	61	49	40		●
1576PC05-1025		10.25	12	118	71	56	45		○
1576PC05C-1025	*	10.25	12	118	71	56	45		●
1576PC05-1100		11	12	118	71	56	45		○
1576PC05C-1100	*	11	12	118	71	56	45		●
1576PC05-1200		12	12	118	71	56	45		○
1576PC05C-1200	*	12	12	118	71	56	45		●
1576PC05-1300		13	14	124	77	60	45		○
1576PC05C-1300	*	13	14	124	77	60	45		●
1576PC05-1400		14	14	124	77	60	45		○
1576PC05C-1400	*	14	14	124	77	60	45		●
1576PC05-1500		15	16	133	83	63	48		○
1576PC05C-1500	*	15	16	133	83	63	48		●
1576PC05-1550		15.5	16	133	83	63	48		○

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
		✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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PC drill 5xD

Cast iron

1576PC05/1576PC05C



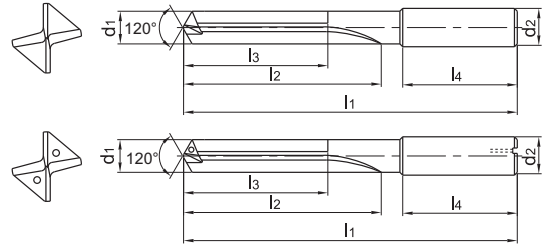
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	YK20F
1576PC05C-1550	*	15.5	16	133	83	63	48	○
1576PC05-1600		16	16	133	83	63	48	○
1576PC05C-1600	*	16	16	133	83	63	48	○
1576PC05-1700		17	18	143	93	71	48	○
1576PC05C-1700	*	17	18	143	93	71	48	○
1576PC05-1750		17.5	18	143	93	71	48	○
1576PC05C-1750	*	17.5	18	143	93	71	48	○
1576PC05-1800		18	18	143	93	71	48	○
1576PC05C-1800	*	18	18	143	93	71	48	●
1576PC05-1950		19.5	20	153	101	77	50	○
1576PC05C-1950	*	19.5	20	153	101	77	50	○
1576PC05-2000		20	20	153	101	77	50	○
1576PC05C-2000	*	20	20	153	101	77	50	○

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
		✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

PC drill 15xD

Cast iron

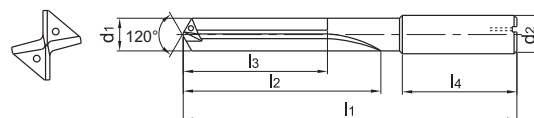
1579PC15C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	YK20F
1579PC15C-0500	*	5	6	145	105	96	36	○
1579PC15C-0600	*	6	6	145	105	96	36	○
1579PC15C-0800	*	8	8	180	137	127	36	○
1579PC15C-0900	*	9	10	217	170	158	40	○
1579PC15C-1000	*	10	10	217	170	158	40	○
1579PC15C-1100	*	11	12	258	205	190	45	○
1579PC15C-1200	*	12	12	258	205	190	45	○
1579PC15C-1400	*	14	14	290	236	219	45	○

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
		✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SC drill – NC tapping device 90°

General machining

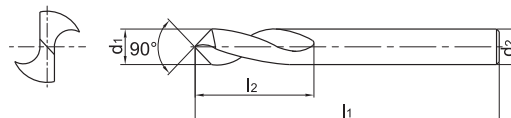
1143SC90



– Factory standard



External coolant



Article	*	Dimensions [mm]				Grade	
		d ₁ (h6)	d ₂ (h6)	l ₁	l ₂	KDG303	YK30F
1143SC90-0500		5	5	62	10	●	
1143SC90-0600		6	6	66	15	●	
1143SC90-0800		8	8	79	17	●	
1143SC90-1000		10	10	89	20	●	
1143SC90-1200		12	12	102	25	●	
1143SC90-1400		14	14	107	30	●	
1143SC90-1600		16	16	115	35	●	
1143SC90-2000		20	20	131	40	●	○

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓	✓		

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

A

SC drill – NC tapping device 120°

General machining

Turning

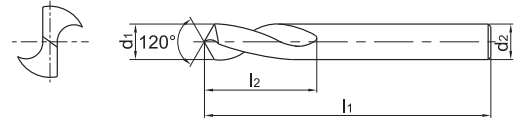
1143SC120



– Factory standard



External coolant



B

Milling

Article	*	Dimensions [mm]				Grade
		d ₁ (h6)	d ₂ (h6)	l ₁	l ₂	KDG303
1143SC120-0400		4	4	62	10	○
1143SC120-0500		5	5	62	10	●
1143SC120-0600		6	6	66	15	●
1143SC120-0800		8	8	79	17	●
1143SC120-1000		10	10	89	20	●
1143SC120-1200		12	12	102	25	●
1143SC120-1400		14	14	107	30	●
1143SC120-1600		16	16	115	35	●
1143SC120-2000		20	20	131	42	●

● Ex stock ○ On demand

* With internal cooling

C

Drilling

Application field						
P	M	K	N	S	H	
✓	✓	✓	✓			✓ Very suitable
						✓ Suitable

D

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System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SC drill – NC tapping device 142°

General machining

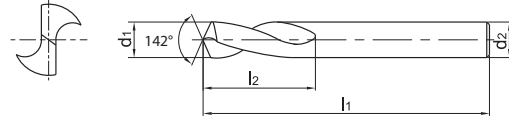
1143SC142



– Factory standard



External coolant



Article	*	Dimensions [mm]				Grade
		d ₁ (h6)	d ₂ (h6)	l ₁	l ₂	KDG303
1143SC142-0500		5	5	62	10	●
1143SC142-0600		6	6	66	15	●
1143SC142-0800		8	8	79	17	●
1143SC142-1000		10	10	89	20	●
1143SC142-1200		12	12	102	25	●
1143SC142-1400		14	14	107	30	●
1143SC142-1600		16	16	115	35	●
1143SC142-2000		20	20	131	42	●

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
✓	✓	✓	✓		

✓ Very suitable

✓ Suitable

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System code > C44

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Cutting data > C144

Nonstandard order > C150



Guide for recommended cutting data – solid carbide drilling

Solid carbide drills

Material group	Composition / structure / heat treatment	Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]										
				SU Series			SU-Drill			SU Step Drill				
				3-5xD	8xD	3xD	KDG 303	KDG 303	KDG 303	Coolant				
				internal	external	f-group	internal	external	f-group	internal	external	f-group		
P Unalloyed steel	ca. 0,15 % C	annealed	125	1	150	135	8	135	125	7	150	135	8	
	ca. 0,45 % C	annealed	190	2	130	120	8	120	110	7	130	120	8	
	ca. 0,45 % C	tempered	250	3	120	110	6	110	100	5	120	110	6	
	ca. 0,75 % C	annealed	270	4	110	100	6	100	90	5	110	100	6	
	ca. 0,75 % C	tempered	300	5	100	90	6	90	85	5	100	90	6	
P Low-alloyed steel		annealed	180	6	130	120	8	120	110	7	130	120	8	
		tempered	275	7	110	100	6	100	90	5	110	100	6	
		tempered	300	8	100	90	6	90	85	5	100	90	6	
		tempered	350	9	90	85	6	85	80	5	90	85	6	
P High-alloyed steel and high-alloyed tool steel		annealed	200	10	120	110	8	110	100	7	120	110	8	
		hardened and tempered	325	11	100	90	6	90	85	5	100	90	6	
M Stainless steel	ferritic/martensitic	annealed	200	12	80	75	5	75	70	5	80	75	5	
	martensitic	tempered	240	13	55	50	5	50	45	5	55	50	5	
	austenitic	quench hardened	180	14	60	55	5	55	50	5	60	55	5	
	austenitic-ferritic		230	15	50	45	5	45	45	5	50	45	5	
K Grey cast iron	perlite/ferritic		180	16	135	125	8	125	115	7	135	125	8	
	perlite (martensitic)		260	17	110	100	8	100	90	7	110	100	8	
	ferritic		160	18	120	110	8	110	100	7	120	110	8	
	perlite		250	19	80	75	8	75	70	7	80	75	8	
	ferritic		130	20	130	120	8	120	110	7	130	120	8	
K Malleable cast iron	perlite		230	21	80	75	8	75	70	7	80	75	8	
N Aluminium wrought alloys	cannot be hardened		60	22										
	hardenable	hardened	100	23										
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24									
		≤ 12% Si, hardenable	hardened	90	25									
		> 12% Si, cannot be hardened		130	26									
N Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27										
	CuZn, CuSnZn		90	28										
	CuSn, Pb-free copper, electrolytic copper		100	29										
S Heat-resistant alloys	Fe-based alloys	annealed	200	30										
		hardened	280	31										
	Ni or Co base	annealed	250	32										
		hardened	350	33										
		cast	320	34										
S Titanium alloys	pure titanium		R _m 400	35										
	α and β alloys	hardened	R _m 1050	36										
H Hardened steel		hardened and tempered	55 HRC	37										
		hardened and tempered	60 HRC	38										
	Hard cast iron	cast	400	39										
X Hardened cast iron		hardened and tempered	55 HRC	40										
	Non-metallic materials	Thermoplasts		41										
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
Plastic, carbon fibre reinforced CFRP				44										
X Graphite				45										
	Wood			46										

Note: The given cutting values are guide values, which were determined under ideal conditions. The values have to be adapted in individual cases. With hole depths of 5xD adjust the cutting data accordingly to the application. f-group = feed rate recommendations on page C126. For examples of material for cutting tool groups view page D22.

Recommend feed rate

Solid carbide drilling

f-group	Feed rate [mm]																				
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20	
4	1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10	
	2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,10	0,10	0,11	0,11	0,11
	3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
	4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,13	0,14	0,14	0,14	0,15	0,15
	5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
	6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
	7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
5	8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
	9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
	10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
	11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
	12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
	13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
	14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
	15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

1. Select the appropriate product series.
2. Determine the immersion.
3. Select the used material and read the cutting speed.
4. Determine the feed rate group and have a look at the appropriate feed rate recommendations.
5. Select the diameter of tool and determine the immersion.

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Solid carbide drills

Material group	Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
					SL-Drill		SL-Drill		SP-Drill		ST-Drill		
					12-15xD		20-30xD		3xD		3-5xD		
					KDG 303		KDG 303		KDG 303		KDG 303		
					Coolant								
					Int.	f-group	Int.	f-group	Int.	f-group	Int.	f-group	
P Unalloyed steel	approx. 0,15 % C	annealed	125	1	130	7	95	7	165	8	150	8	
	approx. 0,45 % C	annealed	190	2	110	7	80	7	145	8	130	8	
	approx. 0,45 % C	tempered	250	3	100	5	70	5	135	6	120	6	
	approx. 0,75 % C	annealed	270	4	85	5	60	5	125	6	110	6	
	approx. 0,75 % C	tempered	300	5	75	5	55	5	110	6	100	6	
P Low-alloyed steel		annealed	180	6	110	7	80	7	145	8	130	8	
		tempered	275	7	85	5	60	5	125	6	110	6	
		tempered	300	8	75	5	55	5	110	6	100	6	
		tempered	350	9	65	5	50	5	100	6	90	6	
P High-alloyed steel and high-alloyed tool steel		annealed	200	10	100	7	70	7	135	8	120	8	
		hardened and tempered	325	11	75	5	55	5	110	6	100	6	
M Stainless steel	ferritic/martensitic	annealed	200	12	60	4	55	4	90	5	80	5	
	martensitic	tempered	240	13	35	4	30	4	65	5	55	5	
	austenitic	quench hardened	180	14	40	4	35	4	70	5	60	5	
	austenitic-ferritic		230	15	35	4	35	4	55	5	50	5	
K Grey cast iron	perlitic/ferritic		180	16	125	7	90	7	150	8			
	perlitic (martensitic)		260	17	100	7	70	7	125	8			
K Cast iron with spheroidal graphite	ferritic		160	18	110	7	80	7	135	8			
	perlitic		250	19	70	7	50	7	90	8			
K Malleable cast iron	ferritic		130	20	120	7	85	7	145	8			
	perlitic		230	21	70	7	50	7	90	8			
N Aluminium wrought alloys	cannot be hardened		60	22	150	8	105	8	170	8			
	hardenable	hardened	100	23	150	8	105	8	170	8			
	Cast aluminium alloys	$\leq 12\%$ Si, cannot be hardened		75	24	150	8	105	8	170	8		
		$\leq 12\%$ Si, hardenable	hardened	90	25	150	8	105	8	170	8		
		$> 12\%$ Si, cannot be hardened		130	26	150	8	105	8	170	8		
Copper and copper alloys (bronze/brass)	machining steel, PB > 1%		110	27	150	8	105	8	170	8			
	CuZn, CuSnZn		90	28	150	8	105	8	170	8			
	CuSn, Pb-free copper, electrolytic copper		100	29	150	8	105	8	170	8			
S Heat-resistant alloys	Fe-based alloys	annealed	200	30	30	4	20	4	30	5	30	5	
		hardened	280	31	35	4	25	4	35	5	35	5	
	Ni or Co bass	annealed	250	32	35	4	25	4	35	5	35	5	
		hardened	350	33	15	4	10	4	15	5	15	5	
		cast	320	34	15	4	10	4	15	5	15	5	
Titanium alloys	pure titanium	R_m 400	35	30	4	20	4	30	5	30	5		
	α and β alloys	hardened R_m 1050	36	30	4	20	4	30	5	30	5		
H Hardened steel		hardened and tempered	55 HRC	37									
		hardened and tempered	60 HRC	38									
	Hard cast iron	cast	400	39									
H Hardened cast iron		hardened and tempered	55 HRC	40									
X Non-metallic materials	Thermoplasts			41									
	Thermosetting plastics			42									
	Plastic, glass-fibre reinforced GFRP			43									
	Plastic, carbon fibre reinforced CFRP			44									
	Graphite			45									
	Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
 The values have to be adapted in individual cases.
 With hole depths of 5xD adjust the cutting data accordingly to the application.
 f-group = feed rate recommendations on page C148.
 For examples of material for cutting tool groups view page D11.

A

Recommended feed rate

Solid carbide drills

f-group	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10
2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,09	0,10	0,10	0,10	0,11	0,11	0,11
3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15	0,15
5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

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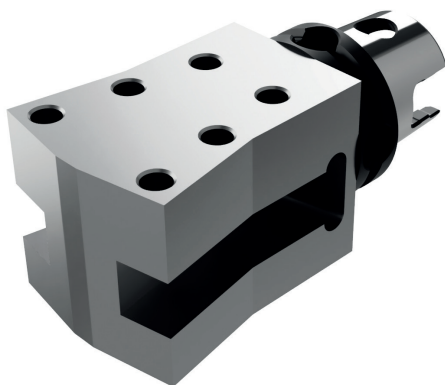
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Special applications call for special solutions optimised to the task. Special tools are able to deliver real benefits from a commercial, technical or process perspective over standard tool solutions in all industry sectors. We work with you to assess the potential in each individual case, taking into account the general conditions available at your company ZCC Cutting Tools Europe's R&D department then develops a custom solution for you at our EU headquarters in Düsseldorf to keep your machining costs as low as possible.

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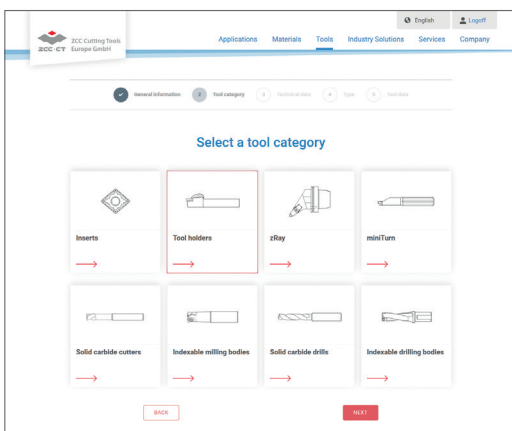
Example: Special tool holder



Example: Special solid carbide step drill

The easy way to order your custom-made special tool

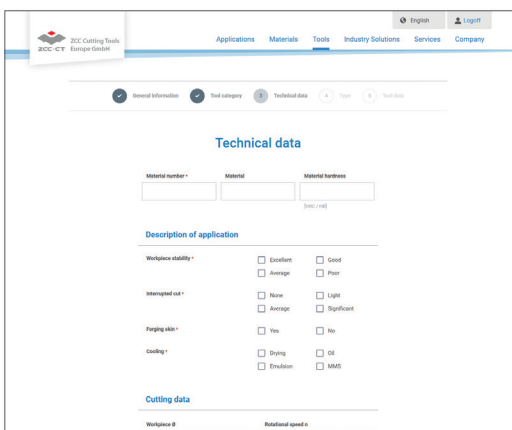
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SOLID CARBIDE REAMERS

Solid carbide reamers

Product overview	C154
Grade overview	C155
System code – solid carbide reamers	C156
Solid carbide reamers	C157-C163
Recommended cutting data	C164-C169
Trouble shooting	C206
Technical information	C210
Special tools	C170-C171



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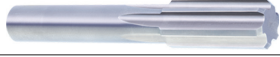


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Turning

Products	Solid carbide reamers	Ø	Application						Type	Page
			P	M	K	N	S	H		
3101H7		4-20			✓	✓			Right helical flute	C157
3102H7		4-20			✓	✓			Straight flute	C158
3112H7		4-20	✓		✓				Straight flute with inner hole	C159
3103H7		4-20			✓	✓			Left helical flute	C163

✓ Very suitable ✓ Suitable

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Coated cemented carbide PVD

Grade	Grade description
-------	-------------------

KRG102	PVD coated P10–P20/K10–K20 carbide substrate for steel and cast iron.
---------------	---

Uncoated cemented carbide

Grade	Grade description
-------	-------------------

YK10F	Uncoated N10/K10 carbide substrate for cast iron and non ferrous materials.
--------------	---

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Turning

Type	
Code	Description
3	Reamer

Shank type	
Code	Description
1	Straight shank
2	Straight shank DIN10
5	Straight shank DIN 6535 HA
9	Morse taper shank

B

Milling

1

2

Coolant supply	
Code	Description
0	External
1	Internal

Flute	
Code	Description
1	Right-hand twist
2	Straight flute
3	Left-hand twist

3

4

C

Drilling

Classe de tolérance	
Code	Description
H7	The tolerance class of the reamed hole is equivalent to H7 (GB/T1800-1804)

Diameter [mm]	
Code	Description
0850	8,5
...	

5

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a Reaming

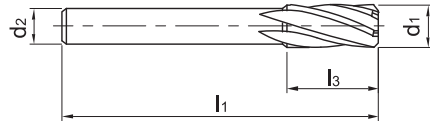
Reamer, right-hand twist

Cast iron, non-ferrous metals

3101H7



– Factory standard



Article	*	Dimensions [mm]				Teeth	Grade
		d ₁	d ₂ (h6)	l ₁	l ₃		YK10F
3101H7-0400		4	3.55	56	20	4	●
3101H7-0500		5	4	63	22	6	○
3101H7-0600		6	5	63	22	6	○
3101H7-0700		7	6.3	71	25	6	○
3101H7-0800		8	6.3	71	25	6	○
3101H7-0900		9	8	71	25	6	○
3101H7-1000		10	8	71	25	6	○
3101H7-1200		12	10	80	28	6	○
3101H7-1300		13	10	80	28	6	○
3101H7-1450		14.5	12.5	90	32	6	○
3101H7-1600		16	12.5	90	32	6	○

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
		✓	✓		

✓ Very suitable

✓ Suitable

System code > C156

Machining instructions > C201

Cutting data > C164

Nonstandard order > C170

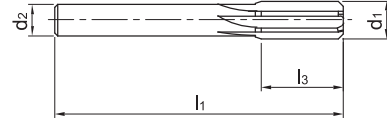
A

Reamer, straight flute **Cast iron, non-ferrous metals**

3102H7



– Factory standard



Turning

B

Milling

Article	*	Dimensions [mm]				Teeth	Grade
		d ₁	d ₂ (h6)	l ₁	l ₃		YK10F
3102H7-0400		4	3.55	56	20	4	○
3102H7-0500		5	4	63	22	6	○
3102H7-0600		6	5	63	22	6	○
3102H7-1000		10	8	71	25	6	○
3102H7-1050		10.5	8	71	25	6	○
3102H7-1100		11	10	80	28	6	○
3102H7-1300		13	10	80	28	6	○
3102H7-1400		14	12.5	90	32	6	○

● Ex stock ○ On demand

* With internal cooling

C

Drilling

Application field						
P	M	K	N	S	H	
		✓	✓			✓ Very suitable
						✓ Suitable

D

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System code > C156

Machining instructions > C201

Cutting data > C164

Nonstandard order > C170

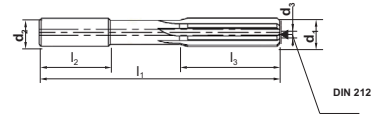
Reamer, straight flute

Steel, cast iron

3112H7



- Factory standard
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Teeth	Grade
		d ₁	d ₂ (h6)	d ₃ (m7)	l ₁	l ₂	l ₃		KRG102
3112H7-0295	*	2.95	4	0.6	70	28	20	4	○
3112H7-0296	*	2.96	4	0.6	70	28	20	4	○
3112H7-0297	*	2.97	4	0.6	70	28	20	4	○
3112H7-0298	*	2.98	4	0.6	70	28	20	4	○
3112H7-0299	*	2.99	4	0.6	70	28	20	4	○
3112H7-0300	*	3	3.5	0.6	70	28	20	4	●
3112H7-0301	*	3.01	4	0.6	70	28	20	4	●
3112H7-0302	*	3.02	4	0.6	70	28	20	4	●
3112H7-0303	*	3.03	4	0.6	70	28	20	4	●
3112H7-0318	*	3.18	4	0.6	70	28	20	4	○
3112H7-0348	*	3.48	4	0.6	70	28	20	4	○
3112H7-0350	*	3.5	4	0.6	70	28	20	4	○
3112H7-0395	*	3.95	4	0.6	70	28	20	4	○
3112H7-0396	*	3.96	4	0.6	70	28	20	4	○
3112H7-0397	*	3.97	4	0.6	70	28	20	4	○
3112H7-0398	*	3.98	4	0.6	70	28	20	4	○
3112H7-0399	*	3.99	4	0.6	70	28	20	4	○
3112H7-0400	*	4	4	0.6	70	28	20	6	●
3112H7-0401	*	4.01	4	1	70	28	20	4	●
3112H7-0402	*	4.02	4	1	70	28	20	4	●
3112H7-0403	*	4.03	4	1	70	28	20	4	●
3112H7-0404	*	4.04	4	1	70	28	20	4	○
3112H7-0405	*	4.05	4	1	70	28	20	4	○
3112H7-0407	*	4.07	4	1	70	28	20	4	○
3112H7-0408	*	4.08	4	1	70	28	20	4	●
3112H7-0450	*	4.5	5	1	70	28	20	4	○
3112H7-0452	*	4.52	5	1	70	28	20	4	○
3112H7-0457	*	4.57	5	1	70	28	20	4	○
3112H7-0495	*	4.95	5	1	70	28	22	6	○
3112H7-0496	*	4.96	5	1	70	28	22	6	○
3112H7-0497	*	4.97	5	1	70	28	22	6	○
3112H7-0498	*	4.98	5	1	70	28	22	6	○
3112H7-0499	*	4.99	5	1	70	28	22	6	○
3112H7-0500	*	5	5	1	70	28	22	6	●
3112H7-0501	*	5.01	5	1	70	28	22	6	●
3112H7-0502	*	5.02	5	1	70	28	22	6	●
3112H7-0503	*	5.03	5	1	70	28	22	6	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

✓ Very suitable

✓ Suitable

System code > C156

Machining instructions > C201

Cutting data > C164

Nonstandard order > C170



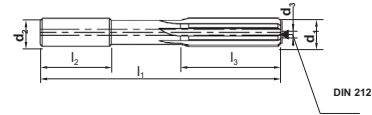
Reamer, straight flute

Steel, cast iron

3112H7



- Factory standard
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Teeth	Grade
		d ₁	d ₂ (h6)	d ₃ (m7)	l ₁	l ₂	l ₃		
3112H7-0504	*	5.04	5	1	70	28	22	6	○
3112H7-0505	*	5.05	5	1	70	28	22	6	○
3112H7-0550	*	5.5	6	1	70	28	22	6	○
3112H7-0553	*	5.53	6	1	70	28	22	6	○
3112H7-0561	*	5.61	6	1	70	28	22	6	○
3112H7-0593	*	5.93	6	1	70	28	22	6	○
3112H7-0595	*	5.95	6	1	100	36	22	6	●
3112H7-0596	*	5.96	6	1	100	36	22	6	●
3112H7-0597	*	5.97	6	1	100	36	22	6	●
3112H7-0598	*	5.98	6	1	100	36	22	6	●
3112H7-0599	*	5.99	6	1	100	36	22	6	●
3112H7-0600	*	6	6	1	100	36	22	6	●
3112H7-0601	*	6.01	6	1.3	100	36	22	6	●
3112H7-0602	*	6.02	6	1.3	100	36	22	6	●
3112H7-0603	*	6.03	6	1.3	100	36	22	6	●
3112H7-0635	*	6.35	8	1.3	100	36	22	6	○
3112H7-0650	*	6.5	8	1.3	100	36	22	6	○
3112H7-0655	*	6.55	8	1.3	100	36	22	6	○
3112H7-0693	*	6.93	8	1.3	100	36	22	6	○
3112H7-0695	*	6.95	8	1.3	110	42	25	6	○
3112H7-0696	*	6.96	8	1.3	110	42	25	6	○
3112H7-0697	*	6.97	8	1.3	110	42	25	6	○
3112H7-0698	*	6.98	8	1.3	110	42	25	6	○
3112H7-0699	*	6.99	8	1.3	110	42	25	6	○
3112H7-0700	*	7	8	1.3	110	42	25	6	●
3112H7-0701	*	7.01	8	1.3	110	42	25	6	●
3112H7-0702	*	7.02	8	1.3	110	42	25	6	●
3112H7-0703	*	7.03	8	1.3	110	42	25	6	●
3112H7-0750	*	7.5	8	1.3	110	42	25	6	○
3112H7-0770	*	7.7	8	1.3	110	42	25	6	○
3112H7-0793	*	7.93	8	1.3	110	42	25	6	○
3112H7-0795	*	7.95	8	1.3	110	42	25	6	○
3112H7-0796	*	7.96	8	1.3	110	42	25	6	○
3112H7-0797	*	7.97	8	1.3	110	42	25	6	○
3112H7-0798	*	7.98	8	1.3	110	42	25	6	○
3112H7-0799	*	7.99	8	1.3	110	42	25	6	○
3112H7-0800	*	8	8	1.3	110	42	25	6	●

- Ex stock ○ On demand
- * With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

- ✓ Very suitable
- ✓ Suitable

System code > C156

Machining instructions > C201

Cutting data > C164

Nonstandard order > C170

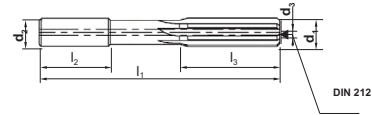
Reamer, straight flute

Steel, cast iron

3112H7



- Factory standard
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Teeth	Grade
		d ₁	d ₂ (h6)	d ₃ (m7)	l ₁	l ₂	l ₃		KRG102
3112H7-0801	*	8.01	8	2	110	42	25	6	●
3112H7-0802	*	8.02	8	2	110	42	25	6	●
3112H7-0803	*	8.03	8	2	110	42	25	6	●
3112H7-0880	*	8.8	10	2	110	42	25	6	○
3112H7-0885	*	8.85	10	2	110	42	25	6	○
3112H7-0900	*	9	10	2	110	42	25	6	●
3112H7-0901	*	9.01	10	2	110	42	25	6	●
3112H7-0902	*	9.02	10	2	110	42	25	6	○
3112H7-0903	*	9.03	10	2	110	42	25	6	●
3112H7-0920	*	9.2	10	2	110	42	25	6	○
3112H7-0930	*	9.3	10	2	110	42	25	6	○
3112H7-0993	*	9.93	10	2	110	42	25	6	○
3112H7-0995	*	9.95	10	2	110	38	25	6	○
3112H7-0996	*	9.96	10	2	110	38	25	6	○
3112H7-0997	*	9.97	10	2	110	38	25	6	○
3112H7-0998	*	9.98	10	2	110	38	25	6	○
3112H7-0999	*	9.99	10	2	110	38	25	6	○
3112H7-1000	*	10	10	2	110	38	25	6	●
3112H7-1001	*	10.01	10	2	110	38	25	6	●
3112H7-1002	*	10.02	10	2	110	38	25	6	●
3112H7-1003	*	10.03	10	2	110	38	25	6	●
3112H7-1024	*	10.24	10	2	110	38	24	6	○
3112H7-1100	*	11	12	2	110	38	28	6	●
3112H7-1101	*	11.01	10	2	110	38	24	6	●
3112H7-1102	*	11.02	10	2	110	38	24	6	○
3112H7-1103	*	11.03	10	2	110	38	24	6	●
3112H7-1155	*	11.55	12	2	110	38	28	6	○
3112H7-1195	*	11.95	12	2	110	38	28	6	○
3112H7-1196	*	11.96	12	2	110	38	28	6	○
3112H7-1197	*	11.97	12	2	110	38	28	6	○
3112H7-1198	*	11.98	12	2	110	38	28	6	○
3112H7-1199	*	11.99	12	2	110	38	28	6	○
3112H7-1200	*	12	12	2	110	38	28	6	●
3112H7-1201	*	12.01	12	2	110	38	28	6	●
3112H7-1202	*	12.02	12	2	110	38	28	6	●
3112H7-1203	*	12.03	12	2	110	38	28	6	●
3112H7-1300	*	13	14	2	110	38	28	6	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓		✓			

✓ Very suitable

✓ Suitable

System code > C156

Machining instructions > C201

Cutting data > C164

Nonstandard order > C170



A

Reamer, straight flute

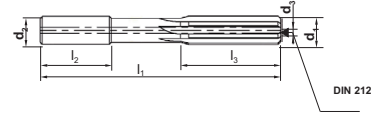
Steel, cast iron

Turning

3112H7



- Factory standard
- Coolant exit, axial concentric



B

Milling

Article	*	Dimensions [mm]						Teeth	Grade
		d ₁	d ₂ (h6)	d ₃ (m7)	l ₁	l ₂	l ₃		KRG102
3112H7-1301	*	13.01	14	2	110	38	28	6	●
3112H7-1302	*	13.02	14	2	110	38	28	6	●
3112H7-1303	*	13.03	14	2	110	38	28	6	●
3112H7-1394	*	13.94	14	2	110	38	28	6	○
3112H7-1400	*	14	14	2	110	38	32	6	●
3112H7-1401	*	14.01	14	2	110	38	28	6	●
3112H7-1402	*	14.02	14	2	110	38	28	6	●
3112H7-1403	*	14.03	14	2	110	38	28	6	●
3112H7-1500	*	15	16	2	110	38	32	6	●
3112H7-1501	*	15.01	16	2	110	38	28	6	●
3112H7-1502	*	15.02	16	2	110	38	28	6	○
3112H7-1503	*	15.03	16	2	110	38	28	6	●
3112H7-1565	*	15.65	16	2	110	38	28	6	○
3112H7-1593	*	15.93	16	2	110	38	28	6	○
3112H7-1595	*	15.95	16	2	150	52	32	6	○
3112H7-1596	*	15.96	16	2	150	52	32	6	○
3112H7-1597	*	15.97	16	2	150	52	32	6	○
3112H7-1598	*	15.98	16	2	150	52	32	6	○
3112H7-1599	*	15.99	16	2	150	52	32	6	○
3112H7-1600	*	16	16	2	150	52	32	6	●
3112H7-1601	*	16.01	16	3	150	52	32	6	●
3112H7-1602	*	16.02	16	3	150	52	32	6	○
3112H7-1603	*	16.03	16	3	150	52	32	6	●
3112H7-1800	*	18	18	3	150	52	36	6	●
3112H7-2000	*	20	20	3	150	50	36	6	●

● Ex stock ○ On demand

* With internal cooling

C

Drilling

D

Technical Information

E

Index

Application field					
P	M	K	N	S	H
✓		✓			

✓ Very suitable

✓ Suitable

System code > C156

Machining instructions > C201

Cutting data > C164

Nonstandard order > C170

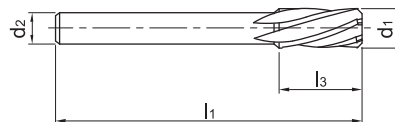
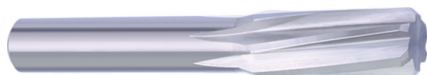
Reamer, left-hand twist

Cast iron, non-ferrous metals

3103H7



– Factory standard



Article	*	Dimensions [mm]				Teeth	Grade
		d ₁	d ₂ (h6)	l ₁	l ₃		YK10F
3103H7-0400		4	3.55	56	20	4	○
3103H7-0500		5	4	63	22	6	○
3103H7-0600		6	5	63	22	6	○
3103H7-0800		8	6.3	71	25	6	○
3103H7-0950		9.5	8	71	25	6	○
3103H7-1000		10	8	71	25	6	○
3103H7-1150		11.5	10	80	28	6	○
3103H7-1200		12	10	80	28	6	○
3103H7-1600		16	12.5	90	32	6	○
3103H7-1800		18	16	100	36	6	○

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
		✓	✓		

✓ Very suitable
 ✓ Suitable

System code > C156

Machining instructions > C201

Cutting data > C164

Nonstandard order > C170

Guide for recommended cutting data – Solid carbide reamers

Solid carbide reamers

Material group	Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]							
					3101H7		3102H7		3112H7		3103H7	
					YK10F		YK10F		KRG102		YK10F	
					Coolant							
				external	f-group	external	f-group	internal	f-group	external	f-group	
P Unalloyed steel	ca. 0,15 % C	annealed	125	1								
	ca. 0,45 % C	annealed	190	2								
	ca. 0,45 % C	tempered	250	3								
	ca. 0,75 % C	annealed	270	4								
	ca. 0,75 % C	tempered	300	5								
P Low-alloyed steel		annealed	180	6						75	5	
		tempered	275	7						60	5	
		tempered	300	8						55	5	
		tempered	350	9						55	5	
P High-alloyed steel and high-alloyed tool steel		annealed	200	10						70	5	
		hardened and tempered	325	11						55	5	
M Stainless steel	ferritic/martensitic	annealed	200	12								
	martensitic	tempered	240	13								
	austenitic	quench hardened	180	14								
	austenitic-ferritic		230	15								
K Grey cast iron	perlitic/ferritic		180	16	23	5	23	5	75	5	23	5
	perlitic (martensitic)		260	17	19	5	19	5	60	5	19	5
	ferritic		160	18	19	5	19	5	60	5	19	5
	perlitic		250	19	17	5	17	5	50	5	17	5
K Malleable cast iron	ferritic		130	20	23	5	23	5	75	5	23	5
	perlitic		230	21	14	5	14	5	55	5	14	5
N Aluminium wrought alloys	cannot be hardened		60	22	45	6	45	6			45	6
	hardenable	hardened	100	23	40	6	40	6			40	6
	≤ 12% Si, cannot be hardened		75	24	37	6	37	6			37	6
	≤ 12% Si, hardenable	hardened	90	25	35	6	35	6			35	6
	> 12% Si, cannot be hardened		130	26	32	6	32	6			32	6
N Cast aluminium alloys	machining steel, PB > 1%		110	27	37	6	37	6			37	6
	CuZn, CuSnZn		90	28	34	6	34	6			34	6
	CuSn, Pb-free copper, electrolytic copper		100	29	37	6	37	6			37	6
S Heat-resistant alloys	Fe-based alloys	annealed	200	30								
		hardened	280	31								
	Ni or Co base	annealed	250	32								
		hardened	350	33								
		cast	320	34								
S Titanium alloys	pure titanium		R _m 400	35								
	α and β alloys	hardened	R _m 1050	36								
H Hardened steel		hardened and tempered	55 HRC	37								
		hardened and tempered	60 HRC	38								
	Hard cast iron	cast	400	39								
H Hardened cast iron		hardened and tempered	55 HRC	40								
X Non-metallic materials	Thermoplasts			41								
	Thermosetting plastics			42								
	Plastic, glass-fibre reinforced GFRP			43								
	Plastic, carbon fibre reinforced CFRP			44								
	Graphite			45								
	Wood			46								

Note: The given cutting values are guide values, which were determined under ideal conditions. The values have to be adapted in individual cases. With hole depths of 5xD adjust the cutting data accordingly to the application. f-group = feed rate recommendations on page C140. For examples of material for cutting tool groups view page D22.

Recommend feed rate

Solid carbide reamers

f _r -group	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
4	1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,10	0,10
	2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,10	0,10	0,11	0,11
	3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13
	4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15
5	5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17
	6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19
	7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22
	8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26
	9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29
	10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34
	11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39
	12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45
	13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52
	14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59
	15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68

Note: The given cutting values are guide values, which were determined under ideal conditions. The values have to be adapted in individual cases.

1. Select the appropriate product series.
2. Determine the immersion.
3. Select the used material and read the cutting speed.
4. Determine the feed rate group and have a look at the appropriate feed rate recommendations.
5. Select the diameter of tool and determine the immersion.

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

Index

Solid carbide reamers

Material group	Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
					3101H7		3102H7		3112H7		3103H7		
					YK10F		YK10F		KRG102		YK10F		
					Coolant								
				Ext.	f-group	Ext.	f-group	Int.	f-group	Ext.	f-group		
P Unalloyed steel	approx. 0,15 % C	annealed	125	1					85	5			
	approx. 0,45 % C	annealed	190	2					75	5			
	approx. 0,45 % C	tempered	250	3					70	5			
	approx. 0,75 % C	annealed	270	4					60	5			
	approx. 0,75 % C	tempered	300	5					55	5			
P Low-alloyed steel		annealed	180	6					75	5			
		tempered	275	7					60	5			
		tempered	300	8					55	5			
		tempered	350	9					55	5			
P High-alloyed steel and high-alloyed tool steel		annealed	200	10					70	5			
		hardened and tempered	325	11					55	5			
M Stainless steel	ferritic/martensitic	annealed	200	12									
	martensitic	tempered	240	13									
	austenitic	quench hardened	180	14									
	austenitic-ferritic		230	15									
K Grey cast iron	perlitic/ferritic		180	16	23	5	23	5	75	5	23	5	
	perlitic (martensitic)		260	17	19	5	19	5	60	5	19	5	
K Cast iron with spheroidal graphite	ferritic		160	18	19	5	19	5	60	5	19	5	
	perlitic		250	19	17	5	17	5	50	5	17	5	
K Malleable cast iron	ferritic		130	20	23	5	23	5	75	5	23	5	
	perlitic		230	21	14	5	14	5	55	5	14	5	
N Aluminium wrought alloys	cannot be hardened		60	22	45	6	45	6			45	6	
	hardenable	hardened	100	23	40	6	40	6			40	6	
	Cast aluminium alloys	$\leq 12\%$ Si, cannot be hardened		75	24	37	6	37	6			37	6
		$\leq 12\%$ Si, hardenable	hardened	90	25	35	6	35	6			35	6
		$> 12\%$ Si, cannot be hardened		130	26	32	6	32	6			32	6
Copper and copper alloys (bronze/brass)	machining steel, PB > 1%		110	27	37	6	37	6			37	6	
	CuZn, CuSnZn		90	28	34	6	34	6			34	6	
	CuSn, Pb-free copper, electrolytic copper		100	29	37	6	37	6			37	6	
S Heat-resistant alloys	Fe-based alloys	annealed	200	30									
		hardened	280	31									
	Ni or Co bass	annealed	250	32									
		hardened	350	33									
		cast	320	34									
Titanium alloys	pure titanium		R _m 400	35									
	α and β alloys	hardened	R _m 1050	36									
H Hardened steel		hardened and tempered	55 HRC	37									
		hardened and tempered	60 HRC	38									
	Hard cast iron	cast	400	39									
H Hardened cast iron		hardened and tempered	55 HRC	40									
X Non-metallic materials	Thermoplasts			41									
	Thermosetting plastics			42									
	Plastic, glass-fibre reinforced GFRP			43									
	Plastic, carbon fibre reinforced CFRP			44									
	Graphite			45									
X Wood				46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
 The values have to be adapted in individual cases.
 With hole depths of 5xD adjust the cutting data accordingly to the application.
 f-group = feed rate recommendations on page C168.
 For examples of material for cutting tool groups view page D11.

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Recommended feed rate

Solid carbide reamers

f-group	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10
2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,09	0,10	0,10	0,10	0,11	0,11	0,11
3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15	0,15
5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

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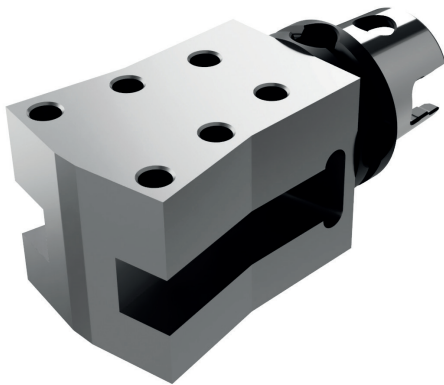
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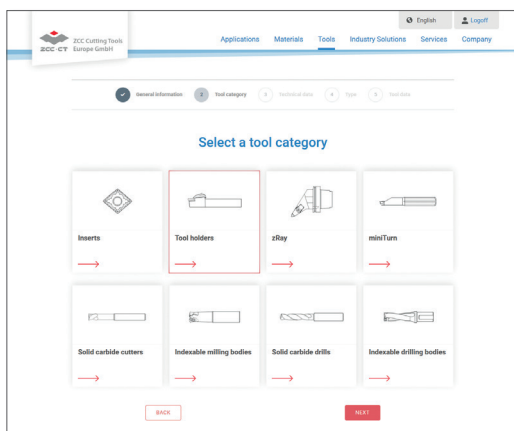
Example: Special tool holder



Example: Special solid carbide step drill

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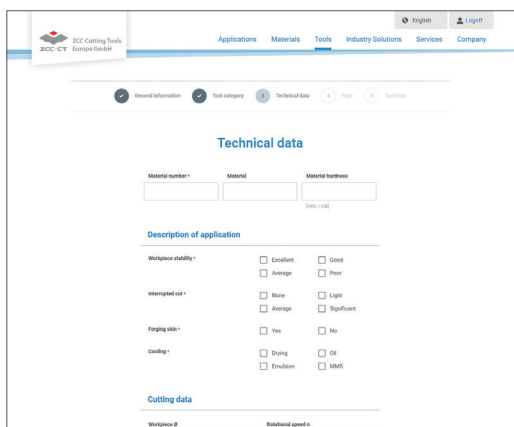
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