

# HSS-E, STRAIGHT SHANK TWIST DRILLS for DEEP HOLES

EXTRA LONG

🇩🇪 HSS-E, SPIRALBOHRER für TIEFLOCH mit ZYLINDERSCHAFT

ÜBERLANG

🇫🇷 Forets HSS-E, queue cylindrique pour perçage profond, Forme C, série extra-longue

EXTRA-LONGUE

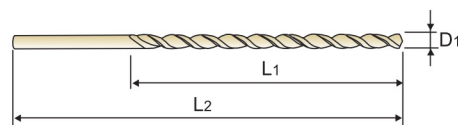
🇮🇹 PUNTA IN HSS-E, GAMBO CILINDRICO PER FORI NON - STOP

EXTRA LUNGA

† **Surface treatment** : TiAIN coating on working area.

† **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, special aluminum or magnesium alloys.

† **Verwendung** : Zum Bohren von legiertem und unlegiertem stahl, Grauguß, Temperguß, Sphäroguß, Druckguß, Alu-Legierungen kurzspanend, Bronze, Messing zäh, Neusilber.



## DH100 worm pattern drills



p.A265



### DT600 SERIES (DIN 1869/1)

EDP No.	Drill Diameter	Flute Length	Overall Length
	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>
DT600020	2.0	85	125
DT600025	2.5	95	140
DT600030	3.0	100	150
DT600035	3.5	115	165
DT600040	4.0	120	175
DT600045	4.5	125	185
DT600050	5.0	135	195
DT600055	5.5	140	205
DT600060	6.0	140	205
DT600065	6.5	150	215
DT600070	7.0	155	225
DT600075	7.5	155	225
DT600080	8.0	165	240
DT600085	8.5	165	240
DT600090	9.0	175	250
DT600095	9.5	175	250
DT600100	10.0	185	265
DT600105	10.5	185	265

### DT692 SERIES (DIN 1869/2)

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>
DT692030	3.0	130	190
DT692035	3.5	145	210
DT692040	4.0	150	220
DT692045	4.5	160	235
DT692050	5.0	170	245
DT692055	5.5	180	260
DT692060	6.0	180	260
DT692065	6.5	190	275
DT692070	7.0	200	290
DT692075	7.5	200	290
DT692080	8.0	210	305
DT692085	8.5	210	305
DT692090	9.0	220	320
DT692095	9.5	220	320
DT692100	10.0	235	340
DT692102	10.2	235	340

† TiN(DN600) and TiCN(DX600) are available on your request.

### DT693 SERIES (DIN 1869/3)

EDP No.	Drill Diameter	Flute Length	Overall Length
	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>
DT693040	4.0	190	280
DT693050	5.0	210	315
DT693060	6.0	225	330
DT693080	8.0	265	390
DT693100	10.0	295	430

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	40	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
ISO	N								S					H							
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials	Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34			55	60	42	55
HB											200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					