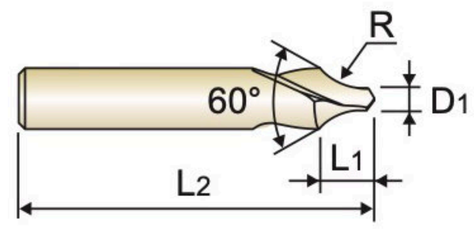
CENTER DRILLS

D1363 SERIES
D1373 SERIES

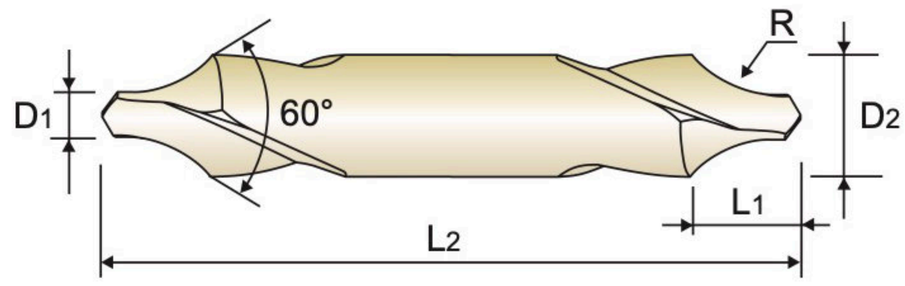
HSS, CENTER DRILLS / FORM R

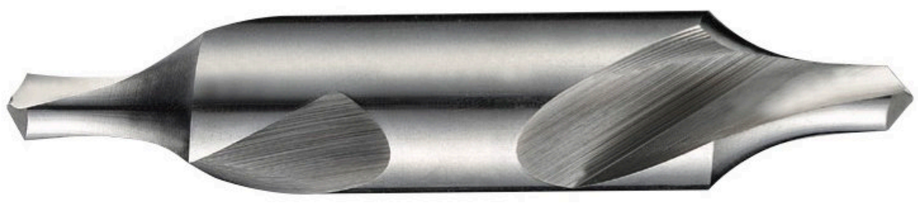
- HSS, ZENTRIERBOHRER / FORM R
- Forets HSS à centrer / Forme R
- PUNTE A CENTRARE PER TORNI IN HSS / FORMA R

Form R
(D1363, Ø0.5, Ø0.8)

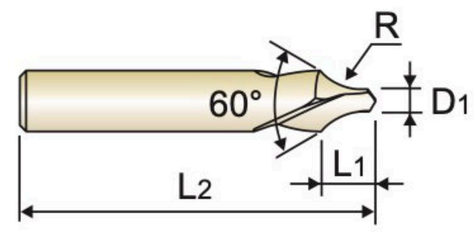


Form R(D1363)

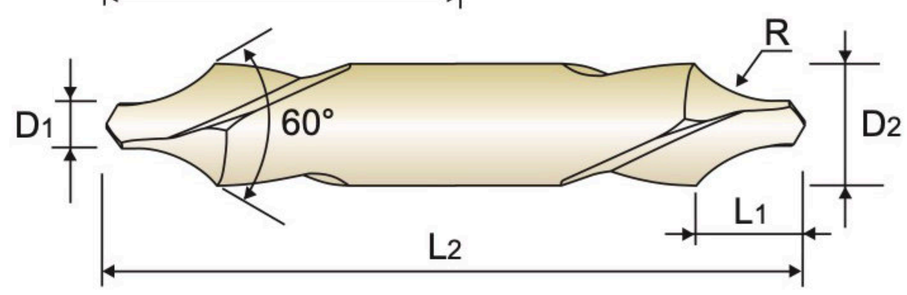




Form R
(D1373, Ø0.8)



Form R (D1373)



DIN 333 | HSS | h8 | k12 | 120° | Bright

p.A297

Recommended ToolHolder: Plain Shank — NC DRILL CHUCK & OTHER TOOL HOLDERS; ER COLLET CHUCK

FORM R

EDP No.	Drill Diameter	Shank Diameter	Pilot Length (Include Radius)	Overall Length	Radius
	D1	D2	L1	L2	R
D1363005	**0.5**	3.15	2.12	25	1.25
D1363008	**0.8**	3.15	2.65	25	2
D1363010	**1.0**	3.15	3	31.5	2.5
D1363912	**1.25**	3.15	3.35	31.5	3.15
D1363016	**1.6**	4	4.25	35.5	4
D1363020	**2.0**	5	5.3	40	5
D1363025	**2.5**	6.3	6.7	45	6.3
D1363931	**3.15**	8	8.5	50	8
D1363040	**4.0**	10	10.6	56	10
D1363050	**5.0**	12.5	13.2	63	12.5
D1363063	**6.3**	16	17	71	16
D1363080	**8.0**	20	21.2	80	20

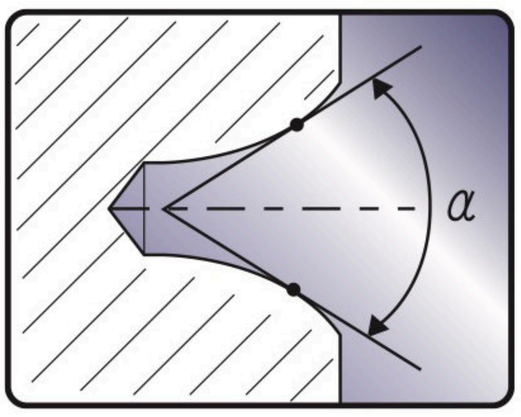
▶ Under 1.0mm : Single End

LEFT HELIX / FORM R

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Pilot Length (Include Radius)	Overall Length	Radius
	D1	D2	L1	L2	R
D1373008	**0.8**	3.15	2.65	25	2
D1373010	**1.0**	3.15	3	31.5	2.5
D1373912	**1.25**	3.15	3.35	31.5	3.15
D1373016	**1.6**	4	4.25	35.5	4
D1373020	**2.0**	5	5.3	40	5
D1373025	**2.5**	6.3	6.7	45	6.3
D1373931	**3.15**	8	8.5	50	8
D1373040	**4.0**	10	10.6	56	10
D1373050	**5.0**	12.5	13.2	63	12.5

▶ Under 1.0mm : Single End



◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○			◎	○					○			◎	○	○		○	

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					