

## Twist drills

 $\leq 3 \times D$  drilling depth

Tool material		HSS			
		N	H	W	GT 80
Guh. no.	Type				
	Surface finish				
	DIN 1897	223	224	225	552
		226	227	228	553
straight shank	[R]				
	[L]				
	[R]				
G.S.	[L]				
	[R]				
MT	[L]				
	[R]				

HSS	
N	N
653	2460
672	

HSC0		M42	
GV 120	VA	N	N
329	1261		
330			
		128	129
			136
363	1263		

HSC0
P2000
2048

Material chart page 17

V <sub>c</sub> m/min	Feed column no.			
27	6			6
22	5			5
30	6			6
30	5			5
25	5			5
25	5			5
30	6			6
16	4			4
30	6			6
25	6			6
20	6			6
70		7		7
70		7		7
50	7*		7	7
50	6*			6
70	6*	6		6
60	5*		5	5
70		6		6
40	5*		5	5
30	4*	4		4
25	4*			4
15	4*			4
18	4	4		4
28	5*	5	5	5

(S)	(F)	Feed col. no.	
30	32	6	7
24	26	5	6
33	36	6	7
33	36	5	6
28	31	5	6
28	31	5	6
25	28	4	5
22	24	4	5
33	36	6	7
20	22	4	5
14	16	4	5
18	20	4	5
33	36	6	7
33	36	6	7
30	31	6	7
22	24	6	7
85		8	
85		8	
60		8	
60		7	
80	90	6	6
65	70	5	6
75	80	5	6
45	50	5	6
33	36	4	5
27	30	4	5
16	18	4	5
15	18	4	5
22	29	4	5
36	47	5	6

V <sub>c</sub> m/min	Feed column no.			
35	5	5		5
30	5	5		5
40	5	5		5
40	5	5	5	5
40	5	5		5
40	5	5		5
40	5	5		5
35	4			4
20	4		4	4
16	3		3	3
36	6	6		6
20	4		4	3
15	3		3	3
16	4		4	3
12	3		3	3
15	4		4	3
12	3		3	3
15	3		3	3
8	2		2	2
18	4	4	4	3
14	3	3	3	3
16	3	3	3	3
4	1			1
8	1		1	1
35	6			5
30	6			5
30	6			5
30	6			5
25	6			5
10	3			3
10	2	2		2
6	2	2		2
90	7			7
90	7			7
80	7			7
70	6			6
70	6			6
40	5			5
60	5			5
40	5			5
35	4	4		4
30	4	4		4
20	4	4		4
15	4	4		4
20	4		4	4
30		4		4

V <sub>c</sub> m/min	Feed col. no.
35	6
30	5
40	6
40	5
40	5
40	5
40	5
40	5
25	4
20	3
20	4
15	3
20	4
15	3
18	4
12	3
12	3
8	2
14	4
10	3
12	3
5	2
38	6
30	6
30	6
25	6
10	3
90	7
90	7
80	7
70	6
85	6
80	5
70	5
40	5
40	4
30	4
25	4
15	4
20	4
25	5

○ bright

● steam tempered

● nitrided lands

● nitrided

● golden brown

● TiAIN