



≤5xD drilling depth

Tool material Type		HSS										
		N			N			H		W		GT 100
Guh. no.	Morse straight flank lapper	Surface finish										
		○	○ _{0.25}	○	○	○	○ _{0.25}	○ _{0.10}	○	○	○ _{0.25}	○ _{0.10}
		560	205	240					206		207	549
	DIN 338	L	208					209		210	550	
	G.S.			268								
	DIN 345	R			229	245	592		246		247	558
	DIN 346	L			248							
							251					
		Feed column no.										
v _c m/min		27	6	6	6	6	6	6				6
		22	5	5	5	5	5	5				5
		30	6	6	6	6	6	6				6
		30	5	5	5	5	5	5				5
		25	5	5	5	5	5	5				5
		25	5	5	5	5	5	5				5
		30	6	6	6	6	6	6				6
		16		4	4	4	4	4				4
		30	6	6	6	6	6	6				6
		30	6	6	6	6	6	6				6
		25	6	6	6	6	6	6				6
		25	6	6	6	6	6	6				6
		70								7		7
		70								7		7
		70	7	7*	7*	7*	7*	7*		7		7
		50	6	6*	6*	6*	6*	6*	6			6
		50	5	5*	5*	5*	5*	5*		5		5
		40	5	5*	5*	5*	5*	5*	6			5
		30	4	4*	4*	4*	4*	4*	4			4
		25	4	4*	4*	4*	4*	4*				4
		15	4	4*	4*	4*	4*	4*				4
		18	4	4	4	4	4	4	4			4
		28	5	5*	5*	5*	5*	5*	5		5	

* Use bright finish drills or use drills with bright polished flutes.