

## CARBIDE DRILL

### Stub length



Submicron  
grade carbide

DIN 6539

'S' pattern flute allows good chip clearance, good performance on very hard or abrasive materials, both long and short chipping, and cast Aluminium alloys.

Various coatings available.

Price and delivery on request.

Ø	Overall Length	Flute Length	Price £ each	Ø	Overall Length	Flute Length	Price £ each	Ø	Overall Length	Flute Length	Price £ each
1,0	30	7	4.17	4,7	58	18	12.81	8,4	79	27	46.64
1,1	30	8	4.17	4,8	62	20	13.44	8,5	79	27	42.79
1,2	30	8	4.32	4,9	62	20	13.89	9,0	84	29	42.79
1,3	30	8	4.31	5,0	62	20	13.70	9,5	84	29	52.36
1,4	30	8	4.82	5,1	62	20	14.61	10,0	89	31	52.59
1,5	30	8	4.70	5,2	62	20	16.74	10,2	89	31	64.86
1,6	38	9	4.99	5,3	62	20	17.01	10,5	89	31	64.98
1,7	38	9	4.99	5,4	66	21	18.61	11,0	95	33	68.83
1,8	38	9	5.04	5,5	66	21	18.18	11,5	95	33	78.75
1,9	38	9	5.04	5,6	66	21	19.85	12,0	102	35	81.67
2,0	38	9	5.68	5,7	66	21	20.02	12,5	102	35	102.30
2,1	38	9	5.80	5,8	66	21	20.38	13,0	102	35	98.86
2,2	40	10	6.01	5,9	66	21	20.81	14,0	107	37	127.90
2,3	40	10	6.01	6,0	66	21	20.06	16,0	115	58	151.77
2,4	43	11	6.44	6,1	70	23	23.79				
2,5	43	11	6.33	6,2	70	23	23.79				
2,6	43	11	6.76	6,3	70	23	23.16				
2,7	46	12	7.61	6,4	70	23	23.79				
2,8	46	12	7.76	6,5	70	23	23.67				
2,9	46	12	8.04	6,6	70	23	28.65				
3,0	46	12	7.53	6,7	70	23	28.65				
3,1	49	14	8.56	6,8	74	25	29.90				
3,2	49	14	8.59	6,9	74	25	30.25				
3,3	49	14	8.93	7,0	74	25	27.66				
3,4	52	15	9.79	7,1	74	25	34.68				
3,5	52	15	9.53	7,2	74	25	34.68				
3,6	52	15	10.12	7,3	74	25	34.68				
3,7	52	15	10.16	7,4	74	25	34.68				
3,8	55	17	10.62	7,5	74	25	32.59				
3,9	55	17	10.75	7,6	79	27	38.41				
4,0	55	17	10.89	7,7	79	27	38.77				
4,1	55	17	11.39	7,8	79	27	40.10				
4,2	55	17	11.36	7,9	79	27	40.36				
4,3	58	18	12.62	8,0	79	27	34.25				
4,4	58	18	12.62	8,1	79	27	46.64				
4,5	58	18	12.46	8,2	79	27	46.64				
4,6	58	18	12.81	8,3	79	27	46.64				

	Unalloyed Steel	Heat Treatable Steel	Heat Treatable Steel		Stainless Steel		Special Nickel & Titanium		Short Chipping	Long Chipping	Cast Iron & SG Iron	
	200-400 N/mm <sup>2</sup>	400-900 N/mm <sup>2</sup>	900-1400 N/mm <sup>2</sup>	Tool Steels 40 - 50 HRC	Ferric & Martensitic	Austenitic	700-900 N/mm <sup>2</sup>	900-1600 N/mm <sup>2</sup>	Non-ferrous Alloys	Non-ferrous Alloys	Short Chipping	Malleable
Cutting speed	60 M/min	60 M/min	40 M/min	20 M/min	30 M/min	30 M/min	20 M/min	15 M/min	70 M/min	100 M/min	60 M/min	40 M/min
Feed rate mm/rev	ø2	0.02	0.02	0.01	0.01	0.01	0.01	0.01	0.02	0.02	0.02	0.02
	ø4	0.04	0.04	0.02	0.02	0.02	0.02	0.02	0.04	0.04	0.04	0.04
	ø6	0.06	0.05	0.04	0.04	0.04	0.04	0.04	0.05	0.06	0.06	0.06
	ø8	0.08	0.07	0.05	0.05	0.05	0.05	0.05	0.07	0.08	0.08	0.08
	ø10	0.10	0.09	0.06	0.06	0.06	0.06	0.06	0.09	0.10	0.10	0.10
	ø12	0.12	0.11	0.07	0.07	0.07	0.07	0.07	0.11	0.12	0.12	0.12
	ø14	0.14	0.13	0.08	0.08	0.08	0.08	0.08	0.13	0.14	0.14	0.14
ø16	0.16	0.14	0.10	0.10	0.10	0.10	0.10	0.14	0.16	0.16	0.16	