Catalogue

Version 2019

2019 EN

ZCC Cutting Tools Europe GmbH

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Solid carbide drills Product overview

	Products	Solid Carbide Drills	L/D	✲	Ø	Application						Type	Page
						P	M	K	N	S	H		
SU	1534SU03		3xD		0.9-20	✓	✓	✓				Twist drills	C32
	1534SU03C		3xD	✲	3-20	✓	✓	✓				Twist drills	C32
	1634SU03C		3xD	✲	3-20	✓	✓	✓				Twist drills	C56
	1734SU03C		3xD	✲	3-20	✓	✓	✓				Twist drills	C64
	1536SU05		5xD		2-20	✓	✓	✓				Twist drills	C43
	1536SU05C		5xD	✲	3-20	✓	✓	✓				Twist drills	C43
	1636SU05C		5xD	✲	3-20	✓	✓	✓				Twist drills	C60
	1736SU05C		5xD	✲	3-20	✓	✓	✓				Twist drills	C68
	1538SU08C		8xD	✲	3-18	✓	✓	✓				Twist drills	C53
	1557SU03		3xD		M4-M16	✓	✓	✓				Step drills	C72
SL SP	1588SL10C		10xD	✲	3-14	✓	✓	✓	✓	✓		Deep hole drills	C74
	1588SL12C		12xD	✲	3-21	✓	✓	✓	✓	✓		Deep hole drills	C77
	1588SL15C		15xD	✲	3-14	✓	✓	✓	✓	✓		Deep hole drills	C81
	1588SL20C		20xD	✲	3-14	✓	✓	✓	✓	✓		Deep hole drills	C84
	1588SL30C		30xD	✲	3-10	✓	✓	✓	✓	✓		Deep hole drills	C87
	1534SP03C		3xD	✲	3.03-20.03	✓	✓	✓	✓	✓		Pilot drills	C89
ST	1534ST03C		3xD	✲	3-20	✓	✓			✓		Twist drills	C94
	1536ST05C		5xD	✲	3-20	✓	✓			✓		Twist drills	C98
	1636ST05C		5xD	✲	3-20	✓	✓			✓		Twist drills	C102
SH	1534SH03		3xD		3-16						✓	Twist drills	C106
SC	1105SC03		3xD		2-16				✓			Twist drills	C107
	1101SC05		5xD		2-16				✓			Twist drills	C110
PA	1165PA03		3xD		3-20				✓			Three-lips drills	C111
PC	1576PC05		5xD		4-20			✓				Straight flute drills	C116
	1576PC05C		5xD	✲	4-20			✓				Straight flute drills	C116
	1579PC15C		15xD	✲	5-14			✓				Straight flute drills	C118
SC*	1143SC90		-		5-20	✓	✓	✓	✓			Centuring drills	C119
	1143SC120		-	✲	5-20	✓	✓	✓	✓			Centuring drills	C120

✓ Very suitable ✓ Suitable

✲ With internal cooling SC*: Centuring drills

Coated cemented carbide PVD

Grade	Grade description
KDG303	PVD coated P10–P20/M10–M20/K10–K20 carbide grade for steel, stainless steel and cast iron. Good wear resistance and toughness for a wide application field.

Uncoated cemented carbide

Grade	Grade description
YK20F	Uncoated K20 carbide substrate for steel, cast iron and non ferrous materials.
YK30F	Uncoated K30 carbide substrate for steel, stainless steel, cast iron and non ferrous materials.

Solid carbide drills

System code – solid carbide drills

1	5	3	6	SU	05	(C)	–	0850	(S)
1	2	3	4	5	6	7		8	9

Type	
Code	Description
1	Forets

1

Shank type	
Code	Description
1	Straight shank
2	Square shank DIN 10
3	Double flattened straight shank DIN 1809
5	Straight shank DIN 6535 HA
6	Weldon shank DIN 6535 HB
7	Whistle Notch shank DIN 6535 HE
9	Morse taper shank

2

Drill type	
Code	Description
0	Twist drill
3	Universal twist drill
4	NC tapping device
5	Step drill
6	Three-lips drill
7	Straight flute drill
8	Deep hole drill

3

Tool length	
Code	Description
1	DIN 338
2	DIN 1897
3	QJ/ZZQ(TO)01.001.002
4	DIN 6537 K
5	DIN 6539
6	DIN 6537 L
7	Factory standard ZCC-C
8	Factory standard ZCC-D
9	Factory standard ZCC-E

4

Application	
Code	Description
SU	Twist drill for general machining
SUK	Twist drill for cast iron
SL	Twist drill for deep hole drilling
SLK	Deep hole drill for cast iron
SP	Pilot drill
ST	Twist drill for soft steel and stainless steel
SH	Twist drill for hardened materials
SC	Twist drill for non-ferrous metals and cast iron
PA	Three-lips drill for non-ferrous metals and cast iron
PC	Straight flute drill for non-ferrous metals and cast iron

5

L/D relation		Angle	
Drill		NC tapping device	
Code	Description	Code	Description
03	3xD	**90**	90°
05	5xD	**120**	120°
08	8xD		
10	10xD		
12	12xD		
15	15xD		
20	20xD		
30	30xD		

6

With inner cooling

7

Bore diameter [mm]	
Code	Description
0200	2,0
0850	8,5
1800	18,0
...	

8

Shank diameter [mm]	
Code	Description
S	4,0

9

a Boring **b Drilling** **c Profile drilling** **d Centering**

Notes

SU series

Twist drills for general applications

- For high-speed machining of steel and stainless steel.
- Longer tool life with AlTiN coating.
- Diameter range 0.9–20.0 mm (3xD, 5xD, 8xD)

S cut

SUK series

Twist drills for machining of cast iron

- Special cut for cast iron with ductile iron and malleable cast iron.
- Improved tool life due to impact resistant cutting edges.

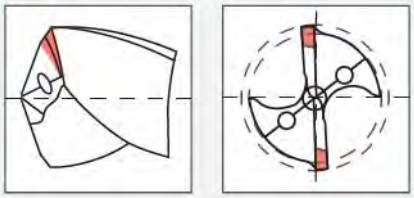
S cut

For cast iron

SUK

Twist drill

Form D: Cut for cast iron



SUK: all articles on demand

Please add K when ordering:

1534SUK03-0100

Solid carbide drills SU series

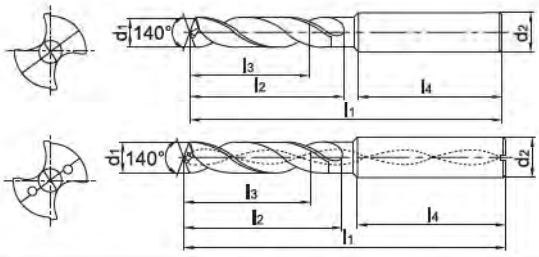
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03-0090S		0.9	4	47	4.2	3.4	37.9	○
1534SU03-0100S		1	4	47	4.7	3.8	37.6	●
1534SU03-0105S		1.05	4	47	4.9	3.9	37.5	●
1534SU03-0110S		1.1	4	47	5.2	4.1	37.2	○
1534SU03-0115S		1.15	4	47	5.4	4.3	37.1	○
1534SU03-0120S		1.2	4	47	5.6	4.5	37	●
1534SU03-0125S		1.25	4	47	5.9	4.7	36.8	○
1534SU03-0130S		1.3	4	47	6.1	4.9	36.6	●
1534SU03-0135S		1.35	4	47	6.3	5.1	36.5	○
1534SU03-0140S		1.4	4	47	6.6	5.3	36.3	○
1534SU03-0145S		1.45	4	47	6.8	5.4	36.2	○
1534SU03-0147S		1.47	4	47	6.9	5.5	36.1	●
1534SU03-0150S		1.5	4	47	7.1	5.6	36	●
1534SU03-0155S		1.55	4	47	7.3	5.8	35.8	○
1534SU03-0160S		1.6	4	47	7.5	6	35.7	●
1534SU03-0165S		1.65	4	47	7.8	6.2	35.5	○
1534SU03-0170S		1.7	4	47	8	6.4	35.4	●
1534SU03-0175S		1.75	4	47	8.2	6.6	35.2	○
1534SU03-0180S		1.8	4	47	8.5	6.8	35	●
1534SU03-0185S		1.85	4	47	8.7	6.9	34.9	○
1534SU03-0190S		1.9	4	47	8.9	7.1	34.8	●
1534SU03-0195S		1.95	4	47	9.2	7.3	34.5	○
1534SU03-0200		2	6	62	20	14	36	●
1534SU03-0210		2.1	6	62	20	14	36	●
1534SU03-0220		2.2	6	62	20	14	36	●
1534SU03-0230		2.33	3	59	13.8	14	36	●
1534SU03-0240		2.4	6	62	20	14	36	●
1534SU03-0250		2.5	6	62	20	14	36	●
1534SU03-0260		2.6	6	62	20	14	36	●
1534SU03-0270		2.7	6	62	20	14	36	●
1534SU03-0280		2.8	6	62	20	14	36	●

● Ex stock ○ On demand
All articles SUK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

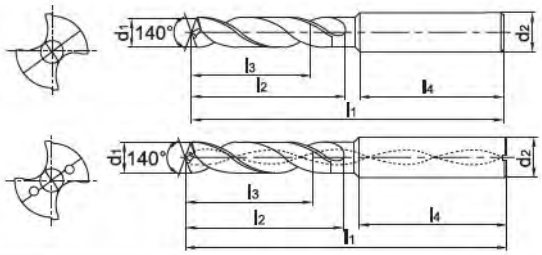
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	*	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03-0290		2.9	6	62	20	14	36	●
1534SU03-0300		3	6	62	20	14	36	●
1534SU03C-0300	✲	3	6	62	20	14	36	●
1534SU03-0310		3.1	6	62	20	14	36	●
1534SU03C-0310	✲	3.1	6	62	20	14	36	●
1534SU03-0320		3.2	6	62	20	14	36	●
1534SU03C-0320	✲	3.2	6	62	20	14	36	●
1534SU03-0325		3.25	6	62	20	14	36	●
1534SU03C-0325	✲	3.25	6	62	20	14	36	●
1534SU03-0330		3.3	6	62	20	14	36	●
1534SU03C-0330	✲	3.3	6	62	20	14	36	●
1534SU03-0340		3.4	6	62	20	14	36	●
1534SU03C-0340	✲	3.4	6	62	20	14	36	●
1534SU03-0350		3.5	6	62	20	14	36	●
1534SU03C-0350	✲	3.5	6	62	20	14	36	●
1534SU03-0360		3.6	6	62	20	14	36	●
1534SU03C-0360	✲	3.6	6	62	20	14	36	●
1534SU03-0370		3.7	6	62	20	14	36	●
1534SU03C-0370	✲	3.7	6	62	20	14	36	●
1534SU03-0380		3.8	6	66	24	17	36	●
1534SU03C-0380	✲	3.8	6	66	24	17	36	●
1534SU03-0390		3.9	6	66	24	17	36	●
1534SU03C-0390	✲	3.9	6	66	24	17	36	●
1534SU03-0400		4	6	66	24	17	36	●
1534SU03C-0400	✲	4	6	66	24	17	36	●
1534SU03-0410		4.1	6	66	24	17	36	●
1534SU03C-0410	✲	4.1	6	66	24	17	36	●
1534SU03-0420		4.2	6	66	24	17	36	●
1534SU03C-0420	✲	4.2	6	66	24	17	36	●
1534SU03-0430		4.3	6	66	24	17	36	●
1534SU03C-0430	✲	4.3	6	66	24	17	36	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

Solid carbide drills SU series

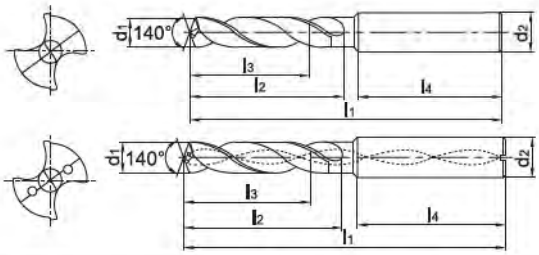
SU(K) drill 3xD General machining Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03-0440		4.4	6	66	24	17	36	●
1534SU03C-0440	✲	4.4	6	66	24	17	36	●
1534SU03-0450		4.5	6	66	24	17	36	●
1534SU03C-0450	✲	4.5	6	66	24	17	36	●
1534SU03-0460		4.6	6	66	24	17	36	●
1534SU03C-0460	✲	4.6	6	66	24	17	36	●
1534SU03-0465		4.65	6	66	24	17	36	●
1534SU03C-0465	✲	4.65	6	66	24	17	36	●
1534SU03-0470		4.7	6	66	24	17	36	●
1534SU03C-0470	✲	4.7	6	66	24	17	36	●
1534SU03-0480		4.8	6	66	28	20	36	●
1534SU03C-0480	✲	4.8	6	66	28	20	36	●
1534SU03-0490		4.9	6	66	28	20	36	●
1534SU03C-0490	✲	4.9	6	66	28	20	36	●
1534SU03-0500		5	6	66	28	20	36	●
1534SU03C-0500	✲	5	6	66	28	20	36	●
1534SU03-0510		5.1	6	66	28	20	36	●
1534SU03C-0510	✲	5.1	6	66	28	20	36	●
1534SU03-0520		5.2	6	66	28	20	36	●
1534SU03C-0520	✲	5.2	6	66	28	20	36	●
1534SU03-0530		5.3	6	66	28	20	36	●
1534SU03C-0530	✲	5.3	6	66	28	20	36	●
1534SU03-0540		5.4	6	66	28	20	36	●
1534SU03C-0540	✲	5.4	6	66	28	20	36	●
1534SU03-0550		5.5	6	66	28	20	36	●
1534SU03C-0550	✲	5.5	6	66	28	20	36	●
1534SU03-0555		5.55	6	66	28	20	36	●
1534SU03C-0555	✲	5.55	6	66	28	20	36	●
1534SU03-0560		5.6	6	66	28	20	36	●
1534SU03C-0560	✲	5.6	6	66	28	20	36	●
1534SU03-0570		5.7	6	66	28	20	36	●

● Ex stock ○ On demand
All articles SUK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

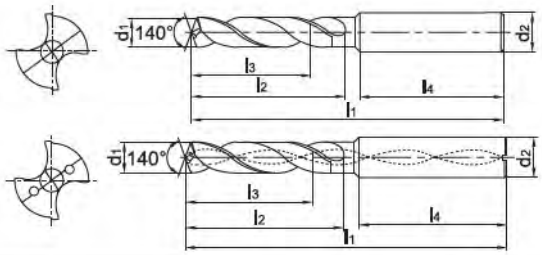
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03C-0570	✻	5.7	6	66	28	20	36	●
1534SU03-0580		5.8	6	66	28	20	36	●
1534SU03C-0580	✻	5.8	6	66	28	20	36	●
1534SU03-0590		5.9	6	66	28	20	36	●
1534SU03C-0590	✻	5.9	6	66	28	20	36	●
1534SU03-0600		6	6	66	28	20	36	●
1534SU03C-0600	✻	6	6	66	28	20	36	●
1534SU03-0610		6.1	8	79	34	24	36	●
1534SU03C-0610	✻	6.1	8	79	34	24	36	●
1534SU03-0620		6.2	8	79	34	24	36	●
1534SU03C-0620	✻	6.2	8	79	34	24	36	●
1534SU03-0630		6.3	8	79	34	24	36	●
1534SU03C-0630	✻	6.3	8	79	34	24	36	●
1534SU03-0640		6.4	8	79	34	24	36	●
1534SU03C-0640	✻	6.4	8	79	34	24	36	●
1534SU03-0650		6.5	8	79	34	24	36	●
1534SU03C-0650	✻	6.5	8	79	34	24	36	●
1534SU03-0660		6.6	8	79	34	24	36	●
1534SU03C-0660	✻	6.6	8	79	34	24	36	●
1534SU03-0670		6.7	8	79	34	24	36	●
1534SU03C-0670	✻	6.7	8	79	34	24	36	●
1534SU03-0675		6.75	8	79	34	24	36	●
1534SU03C-0675	✻	6.75	8	79	34	24	36	●
1534SU03-0680		6.8	8	79	34	24	36	●
1534SU03C-0680	✻	6.8	8	79	34	24	36	●
1534SU03-0690		6.9	8	79	34	24	36	●
1534SU03C-0690	✻	6.9	8	79	34	24	36	●
1534SU03-0700		7	8	79	34	24	36	●
1534SU03C-0700	✻	7	8	79	34	24	36	●
1534SU03-0710		7.1	8	79	41	29	36	●
1534SU03C-0710	✻	7.1	8	79	41	29	36	●

● Ex stock ○ On demand

All articles SUK on demand

✻ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

Solid carbide drills SU series

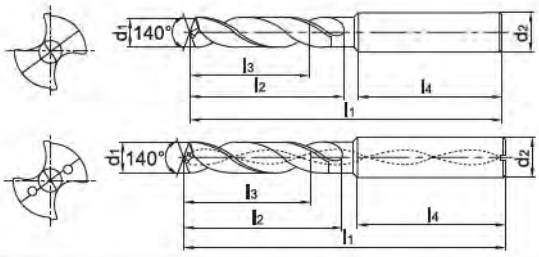
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03-0720		7.2	8	79	41	29	36	●
1534SU03C-0720	✲	7.2	8	79	41	29	36	●
1534SU03-0730		7.3	8	79	41	29	36	●
1534SU03C-0730	✲	7.3	8	79	41	29	36	●
1534SU03-0740		7.4	8	79	41	29	36	●
1534SU03C-0740	✲	7.4	8	79	41	29	36	●
1534SU03-0745		7.45	8	79	41	29	36	○
1534SU03C-0745	✲	7.45	8	79	41	29	36	○
1534SU03-0750		7.5	8	79	41	29	36	●
1534SU03C-0750	✲	7.5	8	79	41	29	36	●
1534SU03-0760		7.6	8	79	41	29	36	●
1534SU03C-0760	✲	7.6	8	79	41	29	36	●
1534SU03-0770		7.7	8	79	41	29	36	●
1534SU03C-0770	✲	7.7	8	79	41	29	36	●
1534SU03-0780		7.8	8	79	41	29	36	●
1534SU03C-0780	✲	7.8	8	79	41	29	36	●
1534SU03-0790		7.9	8	79	41	29	36	●
1534SU03C-0790	✲	7.9	8	79	41	29	36	●
1534SU03-0800		8	8	79	41	29	36	●
1534SU03C-0800	✲	8	8	79	41	29	36	●
1534SU03-0810		8.1	10	89	47	35	40	●
1534SU03C-0810	✲	8.1	10	89	47	35	40	●
1534SU03-0820		8.2	10	89	47	35	40	●
1534SU03C-0820	✲	8.2	10	89	47	35	40	●
1534SU03-0830		8.3	10	89	47	35	40	●
1534SU03C-0830	✲	8.3	10	89	47	35	40	●
1534SU03-0840		8.4	10	89	47	35	40	●
1534SU03C-0840	✲	8.4	10	89	47	35	40	●
1534SU03-0850		8.5	10	89	47	35	40	●
1534SU03C-0850	✲	8.5	10	89	47	35	40	●
1534SU03-0860		8.6	10	89	47	35	40	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

ZCC·CT

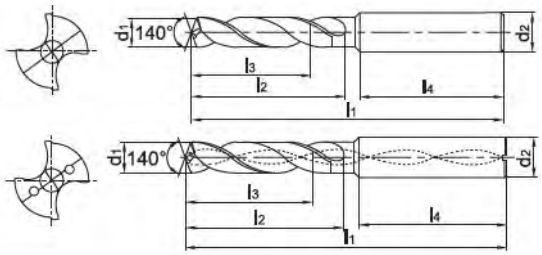
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03C-0860	✲	8.6	10	89	47	35	40	●
1534SU03-0870		8.7	10	89	47	35	40	●
1534SU03C-0870	✲	8.7	10	89	47	35	40	●
1534SU03-0880		8.8	10	89	47	35	40	●
1534SU03C-0880	✲	8.8	10	89	47	35	40	●
1534SU03-0890		8.9	10	89	47	35	40	●
1534SU03C-0890	✲	8.9	10	89	47	35	40	●
1534SU03-0900		9	10	89	47	35	40	●
1534SU03C-0900	✲	9	10	89	47	35	40	●
1534SU03-0910		9.1	10	89	47	35	40	●
1534SU03C-0910	✲	9.1	10	89	47	35	40	●
1534SU03-0920		9.2	10	89	47	35	40	●
1534SU03C-0920	✲	9.2	10	89	47	35	40	●
1534SU03-0930		9.3	10	89	47	35	40	●
1534SU03C-0930	✲	9.3	10	89	47	35	40	●
1534SU03-0935		9.35	10	89	47	35	40	○
1534SU03C-0935	✲	9.35	10	89	47	35	40	○
1534SU03-0940		9.4	10	89	47	35	40	●
1534SU03C-0940	✲	9.4	10	89	47	35	40	●
1534SU03-0945		9.45	10	89	47	35	40	○
1534SU03C-0945	✲	9.45	10	89	47	35	40	○
1534SU03-0950		9.5	10	89	47	35	40	●
1534SU03C-0950	✲	9.5	10	89	47	35	40	●
1534SU03-0960		9.6	10	89	47	35	40	●
1534SU03C-0960	✲	9.6	10	89	47	35	40	●
1534SU03-0970		9.7	10	89	47	35	40	●
1534SU03C-0970	✲	9.7	10	89	47	35	40	●
1534SU03-0980		9.8	10	89	47	35	40	●
1534SU03C-0980	✲	9.8	10	89	47	35	40	●
1534SU03-0990		9.9	10	89	47	35	40	●
1534SU03C-0990	✲	9.9	10	89	47	35	40	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

Solid carbide drills SU series

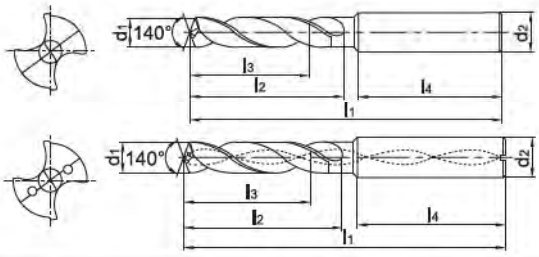
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03-1000		10	10	89	47	35	40	●
1534SU03C-1000	✲	10	10	89	47	35	40	●
1534SU03-1010		10.1	12	102	55	40	45	●
1534SU03C-1010	✲	10.1	12	102	55	40	45	●
1534SU03-1020		10.2	12	102	55	40	45	●
1534SU03C-1020	✲	10.2	12	102	55	40	45	●
1534SU03-1025		10.25	12	102	55	40	45	●
1534SU03C-1025	✲	10.25	12	102	55	40	45	●
1534SU03-1030		10.3	12	102	55	40	45	●
1534SU03C-1030	✲	10.3	12	102	55	40	45	●
1534SU03-1040		10.4	12	102	55	40	45	●
1534SU03C-1040	✲	10.4	12	102	55	40	45	●
1534SU03-1050		10.5	12	102	55	40	45	●
1534SU03C-1050	✲	10.5	12	102	55	40	45	●
1534SU03-1060		10.6	12	102	55	40	45	●
1534SU03C-1060	✲	10.6	12	102	55	40	45	●
1534SU03-1070		10.7	12	102	55	40	45	●
1534SU03C-1070	✲	10.7	12	102	55	40	45	●
1534SU03-1080		10.8	12	102	55	40	45	●
1534SU03C-1080	✲	10.8	12	102	55	40	45	●
1534SU03-1090		10.9	12	102	55	40	45	●
1534SU03C-1090	✲	10.9	12	102	55	40	45	●
1534SU03-1100		11	12	102	55	40	45	●
1534SU03C-1100	✲	11	12	102	55	40	45	●
1534SU03-1110		11.1	12	102	55	40	45	●
1534SU03C-1110	✲	11.1	12	102	55	40	45	●
1534SU03-1120		11.2	12	102	55	40	45	●
1534SU03C-1120	✲	11.2	12	102	55	40	45	●
1534SU03-1125		11.25	12	102	55	40	45	○
1534SU03C-1125	✲	11.25	12	102	55	40	45	○
1534SU03-1130		11.3	12	102	55	40	45	●

● Ex stock ○ On demand
All articles SUK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

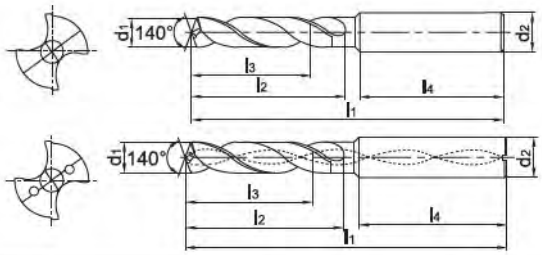
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03C-1130	✻	11.3	12	102	55	40	45	●
1534SU03-1135		11.35	12	102	55	40	45	○
1534SU03C-1135	✻	11.35	12	102	55	40	45	○
1534SU03-1140		11.4	12	102	55	40	45	●
1534SU03C-1140	✻	11.4	12	102	55	40	45	●
1534SU03-1145		11.45	12	102	55	40	45	○
1534SU03C-1145	✻	11.45	12	102	55	40	45	○
1534SU03-1150		11.5	12	102	55	40	45	●
1534SU03C-1150	✻	11.5	12	102	55	40	45	●
1534SU03-1160		11.6	12	102	55	40	45	●
1534SU03C-1160	✻	11.6	12	102	55	40	45	●
1534SU03-1170		11.7	12	102	55	40	45	●
1534SU03C-1170	✻	11.7	12	102	55	40	45	●
1534SU03-1180		11.8	12	102	55	40	45	●
1534SU03C-1180	✻	11.8	12	102	55	40	45	●
1534SU03-1190		11.9	12	102	55	40	45	●
1534SU03C-1190	✻	11.9	12	102	55	40	45	●
1534SU03-1200		12	12	102	55	40	45	●
1534SU03C-1200	✻	12	12	102	55	40	45	●
1534SU03-1210		12.1	14	107	60	43	45	●
1534SU03C-1210	✻	12.1	14	107	60	43	45	●
1534SU03-1220		12.2	14	107	60	43	45	●
1534SU03C-1220	✻	12.2	14	107	60	43	45	●
1534SU03-1225		12.25	14	107	60	43	45	●
1534SU03C-1225	✻	12.25	14	107	60	43	45	●
1534SU03-1230		12.3	14	107	60	43	45	●
1534SU03C-1230	✻	12.3	14	107	60	43	45	●
1534SU03-1250		12.5	14	107	60	43	45	●
1534SU03C-1250	✻	12.5	14	107	60	43	45	●
1534SU03-1270		12.7	14	107	60	43	45	●
1534SU03C-1270	✻	12.7	14	107	60	43	45	●

● Ex stock ○ On demand

All articles SUK on demand

✻ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

Solid carbide drills SU series

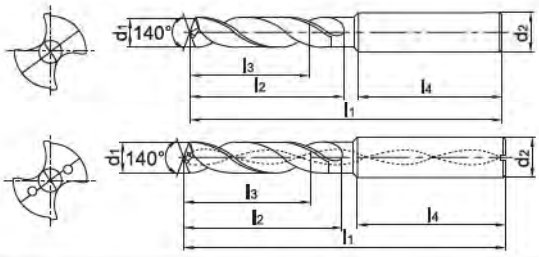
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03-1275		12.75	14	107	60	43	45	●
1534SU03C-1275	✲	12.75	14	107	60	43	45	●
1534SU03-1280		12.8	14	107	60	43	45	●
1534SU03C-1280	✲	12.8	14	107	60	43	45	●
1534SU03-1300		13	14	107	60	43	45	●
1534SU03C-1300	✲	13	14	107	60	43	45	●
1534SU03-1310		13.1	14	107	60	43	45	●
1534SU03C-1310	✲	13.1	14	107	60	43	45	●
1534SU03C-1335	✲	13.35	14	107	60	43	45	●
1534SU03-1350		13.5	14	107	60	43	45	●
1534SU03C-1350	✲	13.5	14	107	60	43	45	●
1534SU03-1380		13.8	14	107	60	43	45	●
1534SU03C-1380	✲	13.8	14	107	60	43	45	●
1534SU03-1400		14	14	107	60	43	45	●
1534SU03C-1400	✲	14	14	107	60	43	45	●
1534SU03-1420		14.2	16	107	60	43	45	●
1534SU03C-1420	✲	14.2	16	107	60	43	45	●
1534SU03-1425		14.25	16	115	65	45	48	●
1534SU03C-1425	✲	14.25	16	115	65	45	48	●
1534SU03-1430		14.3	16	115	65	45	48	●
1534SU03C-1430	✲	14.3	16	115	65	45	48	●
1534SU03-1450		14.5	16	115	65	45	48	●
1534SU03C-1450	✲	14.5	16	115	65	45	48	●
1534SU03-1475		14.75	16	115	65	45	48	●
1534SU03C-1475	✲	14.75	16	115	65	45	48	●
1534SU03-1480		14.8	16	115	65	45	48	●
1534SU03C-1480	✲	14.8	16	115	65	45	48	●
1534SU03-1500		15	16	115	65	45	48	●
1534SU03C-1500	✲	15	16	115	65	45	48	●
1534SU03-1510		15.1	16	115	65	45	48	●
1534SU03C-1510	✲	15.1	16	115	65	45	48	●

● Ex stock ○ On demand
All articles SUK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

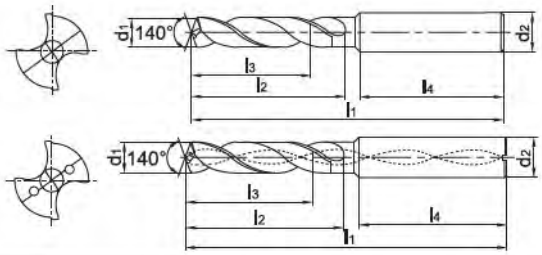
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03-1530		15.3	16	115	65	45	48	●
1534SU03C-1535	✻	15.35	16	115	65	45	48	○
1534SU03-1550		15.5	16	115	65	45	48	●
1534SU03C-1550	✻	15.5	16	115	65	45	48	●
1534SU03-1580		15.8	16	115	65	45	48	●
1534SU03C-1580	✻	15.8	16	115	65	45	48	●
1534SU03-1600		16	16	115	65	45	48	●
1534SU03C-1600	✻	16	16	115	65	45	48	●
1534SU03-1610		16.1	18	123	73	51	48	●
1534SU03-1650		16.5	18	123	73	51	48	●
1534SU03C-1650	✻	16.5	18	123	73	51	48	●
1534SU03-1675		16.75	18	123	73	51	48	●
1534SU03C-1675	✻	16.75	18	123	73	51	48	●
1534SU03-1680		16.8	18	123	73	51	48	●
1534SU03C-1680	✻	16.8	18	123	73	51	48	●
1534SU03-1700		17	18	123	73	51	48	●
1534SU03C-1700	✻	17	18	123	73	51	48	●
1534SU03-1750		17.5	18	123	73	51	48	●
1534SU03C-1750	✻	17.5	18	123	73	51	48	●
1534SU03-1780		17.8	18	123	73	51	48	●
1534SU03C-1780	✻	17.8	18	123	73	51	48	●
1534SU03-1800		18	18	123	73	51	48	●
1534SU03C-1800	✻	18	18	123	73	51	48	●
1534SU03-1850		18.5	20	131	79	55	50	●
1534SU03C-1850	✻	18.5	20	131	79	55	50	●
1534SU03-1880		18.8	20	131	79	55	50	●
1534SU03C-1880	✻	18.8	20	131	79	55	50	●
1534SU03-1900		19	20	131	79	55	50	●
1534SU03C-1900	✻	19	20	131	79	55	50	●
1534SU03-1950		19.5	20	131	79	55	50	●
1534SU03C-1950	✻	19.5	20	131	79	55	50	●

● Ex stock ○ On demand

All articles SUK on demand

✻ With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

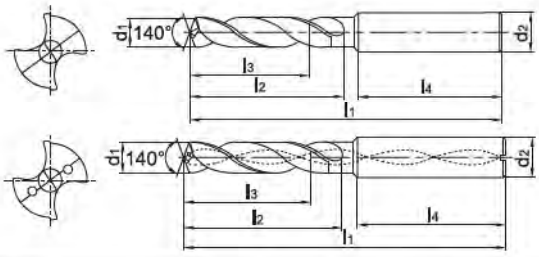
SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1534SU03/1534SU03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	*	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SU03-1980		19.8	20	131	79	55	50	●
1534SU03C-1980	*	19.8	20	131	79	55	50	●
1534SU03-2000		20	20	131	79	55	50	●
1534SU03C-2000	*	20	20	131	79	55	50	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✔	✔	✔			
1534SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

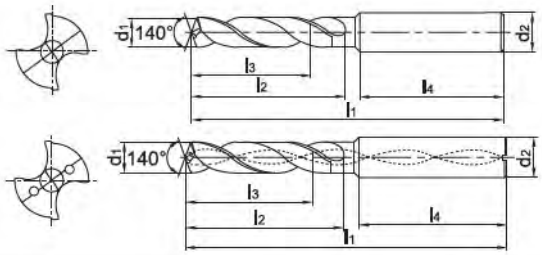
SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05-0200		2	6	66	28	23	36	●
1536SU05-0210		2.1	6	66	28	23	36	●
1536SU05-0220		2.2	6	66	28	23	36	●
1536SU05-0230		2.3	6	66	28	23	36	●
1536SU05-0240		2.4	6	66	28	23	36	●
1536SU05-0250		2.5	6	66	28	23	36	●
1536SU05-0260		2.6	6	66	28	23	36	●
1536SU05-0270		2.7	6	66	28	23	36	●
1536SU05-0280		2.8	6	66	28	23	36	●
1536SU05-0290		2.9	6	66	28	23	36	●
1536SU05-0300		3	6	66	28	23	36	●
1536SU05C-0300	✲	3	6	66	28	23	36	●
1536SU05-0310		3.1	6	66	28	23	36	●
1536SU05C-0310	✲	3.1	6	66	28	23	36	●
1536SU05-0320		3.2	6	66	28	23	36	●
1536SU05C-0320	✲	3.2	6	66	28	23	36	●
1536SU05-0325		3.25	6	66	28	23	36	●
1536SU05C-0325	✲	3.25	6	66	28	23	36	●
1536SU05-0330		3.3	6	66	28	23	36	●
1536SU05C-0330	✲	3.3	6	66	28	23	36	●
1536SU05-0340		3.4	6	66	28	23	36	●
1536SU05C-0340	✲	3.4	6	66	28	23	36	●
1536SU05-0350		3.5	6	66	28	23	36	●
1536SU05C-0350	✲	3.5	6	66	28	23	36	●
1536SU05-0360		3.6	6	66	28	23	36	●
1536SU05C-0360	✲	3.6	6	66	28	23	36	●
1536SU05-0370		3.7	6	66	28	23	36	●
1536SU05C-0370	✲	3.7	6	66	28	23	36	●
1536SU05-0380		3.8	6	74	36	29	36	●
1536SU05C-0380	✲	3.8	6	74	36	29	36	●
1536SU05-0390		3.9	6	74	36	29	36	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

Solid carbide drills SU series

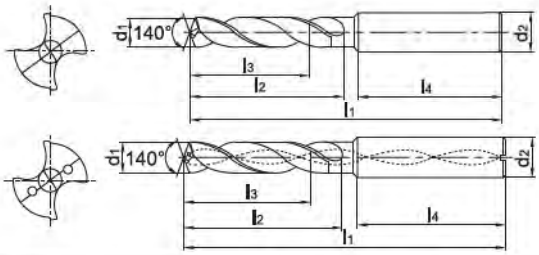
SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05C-0390	✲	3.9	6	74	36	29	36	●
1536SU05-0400		4	6	74	36	29	36	●
1536SU05C-0400	✲	4	6	74	36	29	36	●
1536SU05-0410		4.1	6	74	36	29	36	●
1536SU05C-0410	✲	4.1	6	74	36	29	36	●
1536SU05-0420		4.2	6	74	36	29	36	●
1536SU05C-0420	✲	4.2	6	74	36	29	36	●
1536SU05-0430		4.3	6	74	36	29	36	●
1536SU05C-0430	✲	4.3	6	74	36	29	36	●
1536SU05-0440		4.4	6	74	36	29	36	●
1536SU05C-0440	✲	4.4	6	74	36	29	36	●
1536SU05-0450		4.5	6	74	36	29	36	●
1536SU05C-0450	✲	4.5	6	74	36	29	36	●
1536SU05-0460		4.6	6	74	36	29	36	●
1536SU05C-0460	✲	4.6	6	74	36	29	36	●
1536SU05-0465		4.65	6	74	36	29	36	●
1536SU05C-0465	✲	4.65	6	74	36	29	36	●
1536SU05-0470		4.7	6	74	36	29	36	●
1536SU05C-0470	✲	4.7	6	74	36	29	36	●
1536SU05-0480		4.8	6	82	44	35	36	●
1536SU05C-0480	✲	4.8	6	82	44	35	36	●
1536SU05-0490		4.9	6	82	44	35	36	●
1536SU05C-0490	✲	4.9	6	82	44	35	36	●
1536SU05-0500		5	6	82	44	35	36	●
1536SU05C-0500	✲	5	6	82	44	35	36	●
1536SU05-0510		5.1	6	82	44	35	36	●
1536SU05C-0510	✲	5.1	6	82	44	35	36	●
1536SU05-0520		5.2	6	82	44	35	36	●
1536SU05C-0520	✲	5.2	6	82	44	35	36	●
1536SU05-0530		5.3	6	82	44	35	36	●
1536SU05C-0530	✲	5.3	6	82	44	35	36	●

● Ex stock ○ On demand
All articles SUK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

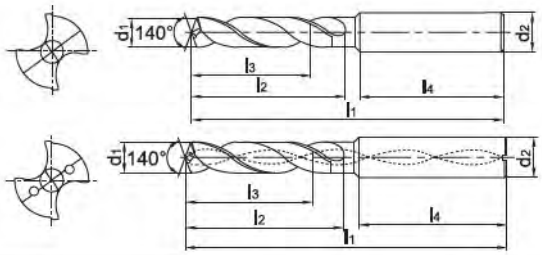
SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05-0540		5.4	6	82	44	35	36	●
1536SU05C-0540	✲	5.4	6	82	44	35	36	●
1536SU05-0550		5.5	6	82	44	35	36	●
1536SU05C-0550	✲	5.5	6	82	44	35	36	●
1536SU05-0555		5.55	6	82	44	35	36	●
1536SU05C-0555	✲	5.55	6	82	44	35	36	●
1536SU05-0560		5.6	6	82	44	35	36	●
1536SU05C-0560	✲	5.6	6	82	44	35	36	●
1536SU05-0570		5.7	6	82	44	35	36	●
1536SU05C-0570	✲	5.7	6	82	44	35	36	●
1536SU05-0580		5.8	6	82	44	35	36	●
1536SU05C-0580	✲	5.8	6	82	44	35	36	●
1536SU05-0590		5.9	6	82	44	35	36	●
1536SU05C-0590	✲	5.9	6	82	44	35	36	●
1536SU05-0600		6	6	82	44	35	36	●
1536SU05C-0600	✲	6	6	82	44	35	36	●
1536SU05-0610		6.1	8	91	53	43	36	●
1536SU05C-0610	✲	6.1	8	91	53	43	36	●
1536SU05-0620		6.2	8	91	53	43	36	●
1536SU05C-0620	✲	6.2	8	91	53	43	36	●
1536SU05-0630		6.3	8	91	53	43	36	●
1536SU05C-0630	✲	6.3	8	91	53	43	36	●
1536SU05-0640		6.4	8	91	53	43	36	●
1536SU05C-0640	✲	6.4	8	91	53	43	36	●
1536SU05-0650		6.5	8	91	53	43	36	●
1536SU05C-0650	✲	6.5	8	91	53	43	36	●
1536SU05-0660		6.6	8	91	53	43	36	●
1536SU05C-0660	✲	6.6	8	91	53	43	36	●
1536SU05-0670		6.7	8	91	53	43	36	●
1536SU05C-0670	✲	6.7	8	91	53	43	36	●
1536SU05-0675		6.75	8	91	53	43	36	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

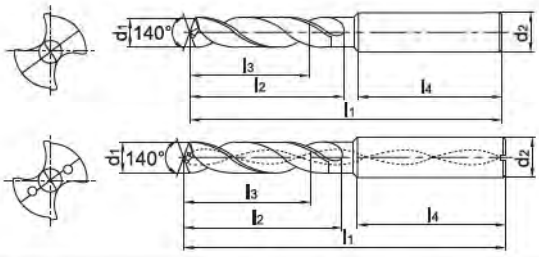
SU(K) drill 5xD — General machining — Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05C-0675	✲	6.75	8	91	53	43	36	●
1536SU05-0680		6.8	8	91	53	43	36	●
1536SU05C-0680	✲	6.8	8	91	53	43	36	●
1536SU05-0690		6.9	8	91	53	43	36	●
1536SU05C-0690	✲	6.9	8	91	53	43	36	●
1536SU05-0700		7	8	91	53	43	36	●
1536SU05C-0700	✲	7	8	91	53	43	36	●
1536SU05-0710		7.1	8	91	53	43	36	●
1536SU05C-0710	✲	7.1	8	91	53	43	36	●
1536SU05-0720		7.2	8	91	53	43	36	●
1536SU05C-0720	✲	7.2	8	91	53	43	36	●
1536SU05-0730		7.3	8	91	53	43	36	●
1536SU05C-0730	✲	7.3	8	91	53	43	36	●
1536SU05-0740		7.4	8	91	53	43	36	●
1536SU05C-0740	✲	7.4	8	91	53	43	36	●
1536SU05-0745		7.45	8	91	53	43	36	●
1536SU05C-0745	✲	7.45	8	91	53	43	36	●
1536SU05-0750		7.5	8	91	53	43	36	●
1536SU05C-0750	✲	7.5	8	91	53	43	36	●
1536SU05-0760		7.6	8	91	53	43	36	●
1536SU05C-0760	✲	7.6	8	91	53	43	36	●
1536SU05-0770		7.7	8	91	53	43	36	●
1536SU05C-0770	✲	7.7	8	91	53	43	36	●
1536SU05-0780		7.8	8	91	53	43	36	●
1536SU05C-0780	✲	7.8	8	91	53	43	36	●
1536SU05-0790		7.9	8	91	53	43	36	●
1536SU05C-0790	✲	7.9	8	91	53	43	36	●
1536SU05-0800		8	8	91	53	43	36	●
1536SU05C-0800	✲	8	8	91	53	43	36	●
1536SU05-0810		8.1	10	103	61	49	40	●
1536SU05C-0810	✲	8.1	10	103	61	49	40	●

● Ex stock ○ On demand
All articles SUK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

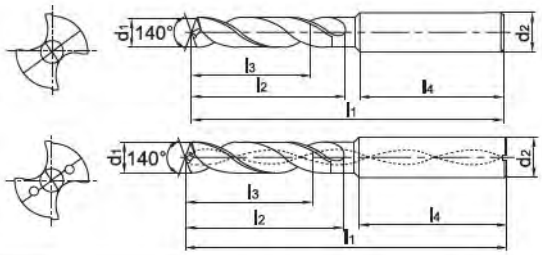
SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05-0820		8.2	10	103	61	49	40	●
1536SU05C-0820	✲	8.2	10	103	61	49	40	●
1536SU05-0830		8.3	10	103	61	49	40	●
1536SU05C-0830	✲	8.3	10	103	61	49	40	●
1536SU05-0840		8.4	10	103	61	49	40	●
1536SU05C-0840	✲	8.4	10	103	61	49	40	●
1536SU05-0850		8.5	10	103	61	49	40	●
1536SU05C-0850	✲	8.5	10	103	61	49	40	●
1536SU05-0860		8.6	10	103	61	49	40	●
1536SU05C-0860	✲	8.6	10	103	61	49	40	●
1536SU05-0870		8.7	10	103	61	49	40	●
1536SU05C-0870	✲	8.7	10	103	61	49	40	●
1536SU05-0880		8.8	10	103	61	49	40	●
1536SU05C-0880	✲	8.8	10	103	61	49	40	●
1536SU05-0890		8.9	10	103	61	49	40	●
1536SU05C-0890	✲	8.9	10	103	61	49	40	●
1536SU05-0900		9	10	103	61	49	40	●
1536SU05C-0900	✲	9	10	103	61	49	40	●
1536SU05-0910		9.1	10	103	61	49	40	●
1536SU05C-0910	✲	9.1	10	103	61	49	40	●
1536SU05-0920		9.2	10	103	61	49	40	●
1536SU05C-0920	✲	9.2	10	103	61	49	40	●
1536SU05-0930		9.3	10	103	61	49	40	●
1536SU05C-0930	✲	9.3	10	103	61	49	40	●
1536SU05-0935		9.35	10	103	61	49	40	●
1536SU05C-0935	✲	9.35	10	103	61	49	40	○
1536SU05-0940		9.4	10	103	61	49	40	●
1536SU05C-0940	✲	9.4	10	103	61	49	40	●
1536SU05-0945		9.45	10	103	61	49	40	●
1536SU05C-0945	✲	9.45	10	103	61	49	40	○
1536SU05-0950		9.5	10	103	61	49	40	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

Solid carbide drills SU series

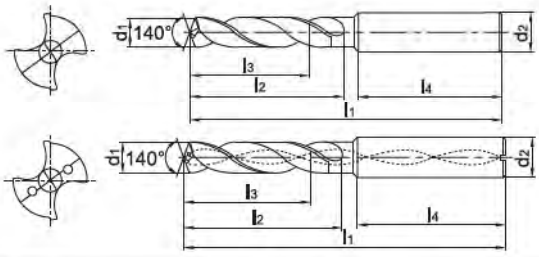
SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05C-0950	✲	9.5	10	103	61	49	40	●
1536SU05-0960		9.6	10	103	61	49	40	●
1536SU05C-0960	✲	9.6	10	103	61	49	40	●
1536SU05-0970		9.7	10	103	61	49	40	●
1536SU05C-0970	✲	9.7	10	103	61	49	40	●
1536SU05-0980		9.8	10	103	61	49	40	●
1536SU05C-0980	✲	9.8	10	103	61	49	40	●
1536SU05-0990		9.9	10	103	61	49	40	●
1536SU05C-0990	✲	9.9	10	103	61	49	40	●
1536SU05-1000		10	10	103	61	49	40	●
1536SU05C-1000	✲	10	10	103	61	49	40	●
1536SU05-1010		10.1	12	118	71	56	45	●
1536SU05C-1010	✲	10.1	12	118	71	56	45	●
1536SU05-1020		10.2	12	118	71	56	45	●
1536SU05C-1020	✲	10.2	12	118	71	56	45	●
1536SU05-1025		10.25	12	118	71	56	45	●
1536SU05C-1025	✲	10.25	12	118	71	56	45	●
1536SU05-1030		10.3	12	118	71	56	45	●
1536SU05C-1030	✲	10.3	12	118	71	56	45	●
1536SU05-1040		10.4	12	118	71	56	45	●
1536SU05C-1040	✲	10.4	12	118	71	56	45	●
1536SU05-1050		10.5	12	118	71	56	45	●
1536SU05C-1050	✲	10.5	12	118	71	56	45	●
1536SU05-1060		10.6	12	118	71	56	45	●
1536SU05C-1060	✲	10.6	12	118	71	56	45	●
1536SU05-1070		10.7	12	118	71	56	45	●
1536SU05C-1070	✲	10.7	12	118	71	56	45	●
1536SU05-1080		10.8	12	118	71	56	45	●
1536SU05C-1080	✲	10.8	12	118	71	56	45	●
1536SU05-1090		10.9	12	118	71	56	45	●
1536SU05C-1090	✲	10.9	12	118	71	56	45	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

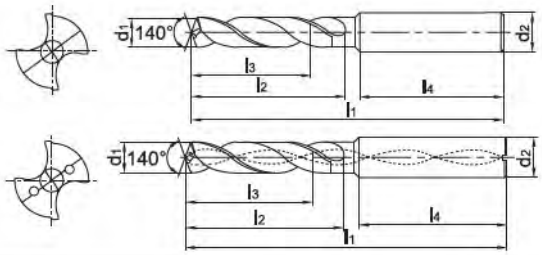
SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05-1100		11	12	118	71	56	45	●
1536SU05C-1100	✲	11	12	118	71	56	45	●
1536SU05-1110		11.1	12	118	71	56	45	●
1536SU05C-1110	✲	11.1	12	118	71	56	45	●
1536SU05-1120		11.2	12	118	71	56	45	●
1536SU05C-1120	✲	11.2	12	118	71	56	45	●
1536SU05-1125		11.25	12	118	71	56	45	●
1536SU05C-1125	✲	11.25	12	118	71	56	45	○
1536SU05-1130		11.3	12	118	71	56	45	●
1536SU05C-1130	✲	11.3	12	118	71	56	45	●
1536SU05-1135		11.35	12	118	71	56	45	●
1536SU05C-1135	✲	11.35	12	118	71	56	45	○
1536SU05-1140		11.4	12	118	71	56	45	●
1536SU05C-1140	✲	11.4	12	118	71	56	45	●
1536SU05-1145		11.45	12	118	71	56	45	○
1536SU05C-1145	✲	11.45	12	118	71	56	45	○
1536SU05-1150		11.5	12	118	71	56	45	●
1536SU05C-1150	✲	11.5	12	118	71	56	45	●
1536SU05-1160		11.6	12	118	71	56	45	●
1536SU05C-1160	✲	11.6	12	118	71	56	45	●
1536SU05-1170		11.7	12	118	71	56	45	●
1536SU05C-1170	✲	11.7	12	118	71	56	45	●
1536SU05-1180		11.8	12	118	71	56	45	●
1536SU05C-1180	✲	11.8	12	118	71	56	45	●
1536SU05-1190		11.9	12	118	71	56	45	●
1536SU05C-1190	✲	11.9	12	118	71	56	45	●
1536SU05-1200		12	12	118	71	56	45	●
1536SU05C-1200	✲	12	12	118	71	56	45	●
1536SU05-1210		12.1	14	124	77	60	45	●
1536SU05C-1210	✲	12.1	14	124	77	60	45	●
1536SU05-1220		12.2	14	124	77	60	45	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

Solid carbide drills SU series

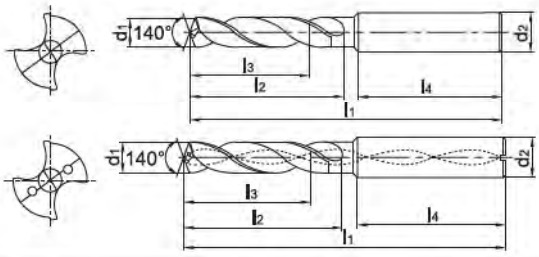
SU(K) drill 5xD — General machining — Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05C-1220	✲	12.2	14	124	77	60	45	●
1536SU05-1225		12.25	14	124	77	60	45	●
1536SU05C-1225	✲	12.25	14	124	77	60	45	●
1536SU05-1230		12.3	14	124	77	60	45	●
1536SU05C-1230	✲	12.3	14	124	77	60	45	●
1536SU05-1250		12.5	14	124	77	60	45	●
1536SU05C-1250	✲	12.5	14	124	77	60	45	●
1536SU05-1270		12.7	14	124	77	60	45	●
1536SU05C-1270	✲	12.7	14	124	77	60	45	●
1536SU05-1275		12.75	14	124	77	60	45	●
1536SU05C-1275	✲	12.75	14	124	77	60	45	●
1536SU05-1280		12.8	14	124	77	60	45	●
1536SU05C-1280	✲	12.8	14	124	77	60	45	●
1536SU05-1300		13	14	124	77	60	45	●
1536SU05C-1300	✲	13	14	124	77	60	45	●
1536SU05-1310		13.1	14	124	77	60	45	●
1536SU05C-1310	✲	13.1	14	124	77	60	45	●
1536SU05-1335		13.35	14	124	77	60	56	○
1536SU05C-1335	✲	13.35	14	124	77	60	56	○
1536SU05-1350		13.5	14	124	77	60	45	●
1536SU05C-1350	✲	13.5	14	124	77	60	45	●
1536SU05-1380		13.8	14	124	77	60	45	●
1536SU05C-1380	✲	13.8	14	124	77	60	45	●
1536SU05-1400		14	14	124	77	60	45	●
1536SU05C-1400	✲	14	14	124	77	60	45	●
1536SU05-1420		14.2	16	124	77	60	45	●
1536SU05C-1420	✲	14.2	16	124	77	60	45	●
1536SU05-1425		14.25	16	133	83	63	48	●
1536SU05C-1425	✲	14.25	16	133	83	63	48	●
1536SU05-1430		14.3	16	133	83	63	48	●
1536SU05C-1430	✲	14.3	16	133	83	63	48	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

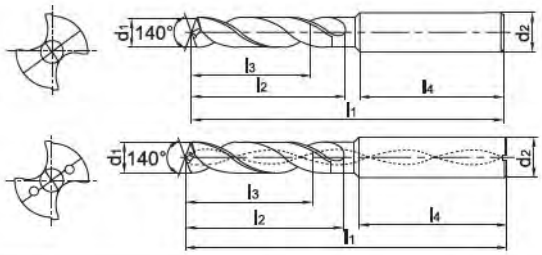
SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05-1450		14.5	16	133	83	63	48	●
1536SU05C-1450	✲	14.5	16	133	83	63	48	●
1536SU05-1475		14.75	16	133	83	63	48	●
1536SU05C-1475	✲	14.75	16	133	83	63	48	●
1536SU05-1480		14.8	16	133	83	63	48	●
1536SU05C-1480	✲	14.8	16	133	83	63	48	●
1536SU05-1500		15	16	133	83	63	48	●
1536SU05C-1500	✲	15	16	133	83	63	48	●
1536SU05-1510		15.1	16	133	83	63	48	●
1536SU05C-1510	✲	15.1	16	133	83	63	48	●
1536SU05C-1530	✲	15.3	16	133	83	63	48	●
1536SU05-1535		15.35	16	133	83	63	48	○
1536SU05C-1535	✲	15.35	16	133	83	63	48	○
1536SU05-1550		15.5	16	133	83	63	48	●
1536SU05C-1550	✲	15.5	16	133	83	63	48	●
1536SU05-1580		15.8	16	133	83	63	48	●
1536SU05C-1580	✲	15.8	16	133	83	63	48	●
1536SU05-1600		16	16	133	83	63	48	●
1536SU05C-1600	✲	16	16	133	83	63	48	●
1536SU05-1650		16.5	18	143	93	71	48	●
1536SU05C-1650	✲	16.5	18	143	93	71	48	●
1536SU05-1675		16.75	18	143	93	71	48	●
1536SU05C-1675	✲	16.75	18	143	93	71	48	●
1536SU05-1680		16.8	18	143	93	71	48	●
1536SU05C-1680	✲	16.8	18	143	93	71	48	●
1536SU05-1700		17	18	143	93	71	48	●
1536SU05C-1700	✲	17	18	143	93	71	48	●
1536SU05-1750		17.5	18	143	93	71	48	●
1536SU05C-1750	✲	17.5	18	143	93	71	48	●
1536SU05-1780		17.8	18	143	93	71	48	●
1536SU05C-1780	✲	17.8	18	143	93	71	48	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

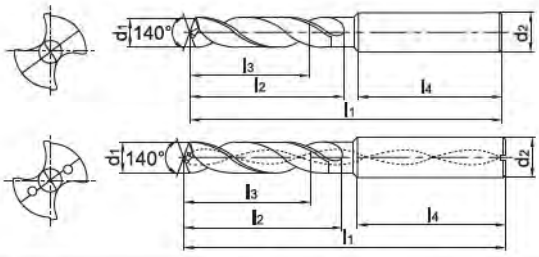
SU(K) drill 5xD — General machining — Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536SU05-1800		18	18	143	93	71	48	●
1536SU05C-1800	✲	18	18	143	93	71	48	●
1536SU05-1850		18.5	20	153	101	77	50	●
1536SU05C-1850	✲	18.5	20	153	101	77	50	●
1536SU05-1880		18.8	20	153	101	77	50	●
1536SU05C-1880	✲	18.8	20	153	101	77	50	●
1536SU05-1900		19	20	153	101	77	50	●
1536SU05C-1900	✲	19	20	153	101	77	50	●
1536SU05-1950		19.5	20	153	101	77	50	●
1536SU05C-1950	✲	19.5	20	153	101	77	50	●
1536SU05-1980		19.8	20	153	101	77	50	●
1536SU05C-1980	✲	19.8	20	153	101	77	50	●
1536SU05-2000		20	20	153	101	77	50	●
1536SU05C-2000	✲	20	20	153	101	77	50	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✔	✔	✔			
1536SUK*			✔			

✔ Very suitable
✔ Suitable

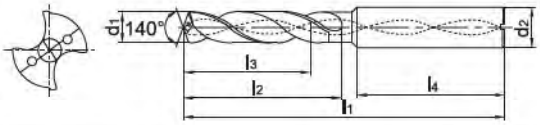
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SU(K) drill 8xD | General machining | Add K (SUK) to the code for use on Cast Iron

1538SU08C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1538SU08C-0300	✲	3	6	72	34	29	36	●
1538SU08C-0310	✲	3.1	6	72	34	29	36	●
1538SU08C-0320	✲	3.2	6	72	34	29	36	●
1538SU08C-0330	✲	3.3	6	72	34	29	36	●
1538SU08C-0340	✲	3.4	6	72	34	29	36	●
1538SU08C-0350	✲	3.5	6	72	34	29	36	●
1538SU08C-0360	✲	3.6	6	72	34	29	36	●
1538SU08C-0370	✲	3.7	6	72	34	29	36	●
1538SU08C-0380	✲	3.8	6	81	43	36	36	●
1538SU08C-0390	✲	3.9	6	81	43	36	36	●
1538SU08C-0400	✲	4	6	81	43	36	36	●
1538SU08C-0410	✲	4.1	6	81	43	36	36	●
1538SU08C-0420	✲	4.2	6	81	43	36	36	●
1538SU08C-0430	✲	4.3	6	81	43	36	36	●
1538SU08C-0440	✲	4.4	6	81	43	36	36	●
1538SU08C-0450	✲	4.5	6	81	43	36	36	●
1538SU08C-0460	✲	4.6	6	81	43	36	36	●
1538SU08C-0470	✲	4.7	6	81	43	36	36	●
1538SU08C-0480	✲	4.8	6	95	57	48	36	●
1538SU08C-0490	✲	4.9	6	95	57	48	36	●
1538SU08C-0500	✲	5	6	95	57	48	36	●
1538SU08C-0510	✲	5.1	6	95	57	48	36	●
1538SU08C-0520	✲	5.2	6	95	57	48	36	●
1538SU08C-0530	✲	5.3	6	95	57	48	36	●
1538SU08C-0540	✲	5.4	6	95	57	48	36	●
1538SU08C-0550	✲	5.5	6	95	57	48	36	●
1538SU08C-0560	✲	5.6	6	95	57	48	36	●
1538SU08C-0570	✲	5.7	6	95	57	48	36	●
1538SU08C-0580	✲	5.8	6	95	57	48	36	●
1538SU08C-0590	✲	5.9	6	95	57	48	36	●
1538SU08C-0600	✲	6	6	95	57	48	36	●
1538SU08C-0610	✲	6.1	8	114	76	66	36	●
1538SU08C-0620	✲	6.2	8	114	76	66	36	●
1538SU08C-0630	✲	6.3	8	114	76	66	36	●
1538SU08C-0640	✲	6.4	8	114	76	66	36	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1538SU*	✔	✔	✔			
1538SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

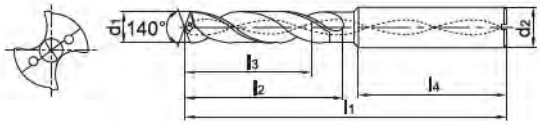
Solid carbide drills SU series

SU(K) drill 8xD | General machining | Add K (SUK) to the code for use on Cast Iron

1538SU08C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article		Dimensions [mm]						Grade
	✲	d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1538SU08C-0650	✲	6.5	8	114	76	66	36	●
1538SU08C-0660	✲	6.6	8	114	76	66	36	●
1538SU08C-0670	✲	6.7	8	114	76	66	36	●
1538SU08C-0680	✲	6.8	8	114	76	66	36	●
1538SU08C-0690	✲	6.9	8	114	76	66	36	●
1538SU08C-0700	✲	7	8	116	76	66	36	●
1538SU08C-0710	✲	7.1	8	116	76	66	36	●
1538SU08C-0720	✲	7.2	8	116	76	66	36	●
1538SU08C-0730	✲	7.3	8	116	76	66	36	●
1538SU08C-0740	✲	7.4	8	116	76	66	36	●
1538SU08C-0750	✲	7.5	8	116	76	66	36	●
1538SU08C-0760	✲	7.6	8	116	76	66	36	●
1538SU08C-0770	✲	7.7	8	116	76	66	36	●
1538SU08C-0780	✲	7.8	8	116	76	66	36	●
1538SU08C-0790	✲	7.9	8	116	76	66	36	●
1538SU08C-0800	✲	8	8	116	76	66	36	●
1538SU08C-0810	✲	8.1	10	142	95	83	40	●
1538SU08C-0820	✲	8.2	10	142	95	83	40	●
1538SU08C-0830	✲	8.3	10	142	95	83	40	●
1538SU08C-0840	✲	8.4	10	142	95	83	40	●
1538SU08C-0850	✲	8.5	10	142	95	83	40	●
1538SU08C-0860	✲	8.6	10	142	95	83	40	●
1538SU08C-0870	✲	8.7	10	142	95	83	40	●
1538SU08C-0880	✲	8.8	10	142	95	83	40	●
1538SU08C-0890	✲	8.9	10	142	95	83	40	●
1538SU08C-0900	✲	9	10	142	95	83	40	●
1538SU08C-0910	✲	9.1	10	142	95	83	40	●
1538SU08C-0920	✲	9.2	10	142	95	83	40	●
1538SU08C-0930	✲	9.3	10	142	95	83	40	●
1538SU08C-0940	✲	9.4	10	142	95	83	40	●
1538SU08C-0950	✲	9.5	10	142	95	83	40	●
1538SU08C-0960	✲	9.6	10	142	95	83	40	●
1538SU08C-0970	✲	9.7	10	142	95	83	40	●
1538SU08C-0980	✲	9.8	10	142	95	83	40	●
1538SU08C-0990	✲	9.9	10	142	95	83	40	●

● Ex stock ○ On demand
All articles SUK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1538SU*	✔	✔	✔			
1538SUK*			✔			

✔ Very suitable
✔ Suitable

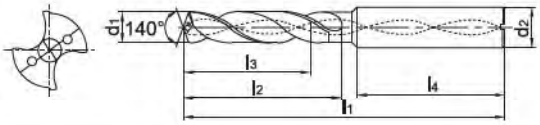
System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

SU(K) drill 8xD | General machining | Add K (SUK) to the code for use on Cast Iron

1538SU08C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1538SU08C-1000	✲	10	10	142	95	83	40	●
1538SU08C-1010	✲	10.1	12	162	114	99	45	●
1538SU08C-1020	✲	10.2	12	162	114	99	45	●
1538SU08C-1030	✲	10.3	12	162	114	99	45	●
1538SU08C-1040	✲	10.4	12	162	114	99	45	●
1538SU08C-1050	✲	10.5	12	162	114	99	45	●
1538SU08C-1060	✲	10.6	12	162	114	99	45	●
1538SU08C-1070	✲	10.7	12	162	114	99	45	●
1538SU08C-1080	✲	10.8	12	162	114	99	45	●
1538SU08C-1090	✲	10.9	12	162	114	99	45	●
1538SU08C-1100	✲	11	12	162	114	99	45	●
1538SU08C-1110	✲	11.1	12	162	114	99	45	●
1538SU08C-1120	✲	11.2	12	162	114	99	45	●
1538SU08C-1130	✲	11.3	12	162	114	99	45	●
1538SU08C-1140	✲	11.4	12	162	114	99	45	●
1538SU08C-1150	✲	11.5	12	162	114	99	45	●
1538SU08C-1160	✲	11.6	12	162	114	99	45	●
1538SU08C-1170	✲	11.7	12	162	114	99	45	●
1538SU08C-1180	✲	11.8	12	162	114	99	45	●
1538SU08C-1190	✲	11.9	12	162	114	99	45	●
1538SU08C-1200	✲	12	12	162	114	99	45	●
1538SU08C-1250	✲	12.5	14	178	133	116	45	●
1538SU08C-1270	✲	12.7	14	178	133	116	45	●
1538SU08C-1280	✲	12.8	14	178	133	116	45	●
1538SU08C-1300	✲	13	14	178	133	116	45	●
1538SU08C-1350	✲	13.5	14	178	133	116	45	●
1538SU08C-1400	✲	14	14	178	133	116	45	●
1538SU08C-1450	✲	14.5	16	204	152	132	48	●
1538SU08C-1480	✲	14.8	16	204	152	132	48	●
1538SU08C-1500	✲	15	16	204	152	132	48	●
1538SU08C-1550	✲	15.5	16	204	152	132	48	●
1538SU08C-1600	✲	16	16	204	152	132	48	●
1538SU08C-1650	✲	16.5	18	223	171	149	48	●
1538SU08C-1700	✲	17	18	223	171	149	48	●
1538SU08C-1750	✲	17.5	18	223	171	149	48	●
1538SU08C-1800	✲	18	18	223	171	149	48	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1538SU*	✔	✔	✔			
1538SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

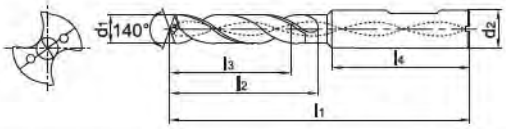
Solid carbide drills SU series

SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1634SU03C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1634SU03C-0300	✲	3	6	62	20	14	36	●
1634SU03C-0310	✲	3.1	6	62	20	14	36	●
1634SU03C-0320	✲	3.2	6	62	20	14	36	●
1634SU03C-0325	✲	3.25	6	62	20	14	36	○
1634SU03C-0330	✲	3.3	6	62	20	14	36	●
1634SU03C-0340	✲	3.4	6	62	20	14	36	●
1634SU03C-0350	✲	3.5	6	62	20	14	36	●
1634SU03C-0360	✲	3.6	6	62	20	14	36	●
1634SU03C-0370	✲	3.7	6	62	20	14	36	●
1634SU03C-0380	✲	3.8	6	66	24	17	36	●
1634SU03C-0390	✲	3.9	6	66	24	17	36	●
1634SU03C-0400	✲	4	6	66	24	17	36	●
1634SU03C-0410	✲	4.1	6	66	24	17	36	●
1634SU03C-0420	✲	4.2	6	66	24	17	36	●
1634SU03C-0430	✲	4.3	6	66	24	17	36	●
1634SU03C-0440	✲	4.4	6	66	24	17	36	●
1634SU03C-0450	✲	4.5	6	66	24	17	36	●
1634SU03C-0460	✲	4.6	6	66	24	17	36	●
1634SU03C-0465	✲	4.65	6	66	24	17	36	○
1634SU03C-0470	✲	4.7	6	66	24	17	36	●
1634SU03C-0480	✲	4.8	6	66	28	20	36	●
1634SU03C-0490	✲	4.9	6	66	28	20	36	●
1634SU03C-0500	✲	5	6	66	28	20	36	●
1634SU03C-0510	✲	5.1	6	66	28	20	36	●
1634SU03C-0520	✲	5.2	6	66	28	20	36	●
1634SU03C-0530	✲	5.3	6	66	28	20	36	●
1634SU03C-0540	✲	5.4	6	66	28	20	36	●
1634SU03C-0550	✲	5.5	6	66	28	20	36	●
1634SU03C-0555	✲	5.55	6	66	28	20	36	●
1634SU03C-0560	✲	5.6	6	66	28	20	36	●
1634SU03C-0570	✲	5.7	6	66	28	20	36	●
1634SU03C-0580	✲	5.8	6	66	28	20	36	●
1634SU03C-0590	✲	5.9	6	66	28	20	36	●
1634SU03C-0600	✲	6	6	66	28	20	36	●
1634SU03C-0610	✲	6.1	8	79	34	24	36	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1634SU*	✔	✔	✔			
1634SUK*			✔			

✔ Very suitable
✔ Suitable

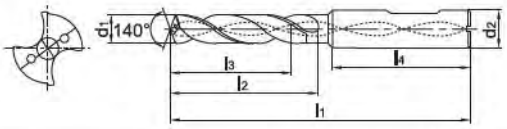
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1634SU03C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1634SU03C-0620	✲	6.2	8	79	34	24	36	●
1634SU03C-0630	✲	6.3	8	79	34	24	36	●
1634SU03C-0640	✲	6.4	8	79	34	24	36	●
1634SU03C-0650	✲	6.5	8	79	34	24	36	●
1634SU03C-0660	✲	6.6	8	79	34	24	36	●
1634SU03C-0670	✲	6.7	8	79	34	24	36	●
1634SU03C-0675	✲	6.75	8	79	34	24	36	○
1634SU03C-0680	✲	6.8	8	79	34	24	36	●
1634SU03C-0690	✲	6.9	8	79	34	24	36	●
1634SU03C-0700	✲	7	8	79	34	24	36	●
1634SU03C-0710	✲	7.1	8	79	41	29	36	●
1634SU03C-0720	✲	7.2	8	79	41	29	36	●
1634SU03C-0730	✲	7.3	8	79	41	29	36	●
1634SU03C-0740	✲	7.4	8	79	41	29	36	●
1634SU03C-0745	✲	7.45	8	79	41	29	36	○
1634SU03C-0750	✲	7.5	8	79	41	29	36	●
1634SU03C-0760	✲	7.6	8	79	41	29	36	●
1634SU03C-0770	✲	7.7	8	79	41	29	36	●
1634SU03C-0780	✲	7.8	8	79	41	29	36	●
1634SU03C-0790	✲	7.9	8	79	41	29	36	●
1634SU03C-0800	✲	8	8	79	41	29	36	●
1634SU03C-0810	✲	8.1	10	89	47	35	40	●
1634SU03C-0820	✲	8.2	10	89	47	35	40	●
1634SU03C-0830	✲	8.3	10	89	47	35	40	●
1634SU03C-0840	✲	8.4	10	89	47	35	40	●
1634SU03C-0850	✲	8.5	10	89	47	35	40	●
1634SU03C-0860	✲	8.6	10	89	47	35	40	●
1634SU03C-0870	✲	8.7	10	89	47	35	40	●
1634SU03C-0880	✲	8.8	10	89	47	35	40	●
1634SU03C-0890	✲	8.9	10	89	47	35	40	●
1634SU03C-0900	✲	9	10	89	47	35	40	●
1634SU03C-0910	✲	9.1	10	89	47	35	40	●
1634SU03C-0920	✲	9.2	10	89	47	35	40	●
1634SU03C-0930	✲	9.3	10	89	47	35	40	●
1634SU03C-0935	✲	9.35	10	89	47	35	40	○

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1634SU*	✔	✔	✔			
1634SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

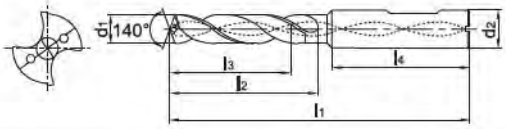
Solid carbide drills SU series

SU(K) drill 3xD General machining Add K (SUK) to the code for use on Cast Iron

1634SU03C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1634SU03C-0940	✲	9.4	10	89	47	35	40	●
1634SU03C-0945	✲	9.45	10	89	47	35	40	○
1634SU03C-0950	✲	9.5	10	89	47	35	40	●
1634SU03C-0960	✲	9.6	10	89	47	35	40	●
1634SU03C-0970	✲	9.7	10	89	47	35	40	●
1634SU03C-0980	✲	9.8	10	89	47	35	40	●
1634SU03C-0990	✲	9.9	10	89	47	35	40	●
1634SU03C-1000	✲	10	10	89	47	35	40	●
1634SU03C-1010	✲	10.1	12	102	55	40	45	●
1634SU03C-1020	✲	10.2	12	102	55	40	45	●
1634SU03C-1025	✲	10.25	12	102	55	40	45	○
1634SU03C-1030	✲	10.3	12	102	55	40	45	●
1634SU03C-1040	✲	10.4	12	102	55	40	45	●
1634SU03C-1050	✲	10.5	12	102	55	40	45	●
1634SU03C-1060	✲	10.6	12	102	55	40	45	●
1634SU03C-1070	✲	10.7	12	102	55	40	45	●
1634SU03C-1080	✲	10.8	12	102	55	40	45	●
1634SU03C-1090	✲	10.9	12	102	55	40	45	●
1634SU03C-1100	✲	11	12	102	55	40	45	●
1634SU03C-1110	✲	11.1	12	102	55	40	45	●
1634SU03C-1120	✲	11.2	12	102	55	40	45	●
1634SU03C-1125	✲	11.25	12	102	55	40	45	○
1634SU03C-1130	✲	11.3	12	102	55	40	45	●
1634SU03C-1135	✲	11.35	12	102	55	40	45	○
1634SU03C-1140	✲	11.4	12	102	55	40	45	●
1634SU03C-1145	✲	11.45	12	102	55	40	45	○
1634SU03C-1150	✲	11.5	12	102	55	40	45	●
1634SU03C-1160	✲	11.6	12	102	55	40	45	●
1634SU03C-1170	✲	11.7	12	102	55	40	45	●
1634SU03C-1180	✲	11.8	12	102	55	40	45	●
1634SU03C-1190	✲	11.9	12	102	55	40	45	●
1634SU03C-1200	✲	12	12	102	55	40	45	●
1634SU03C-1210	✲	12.1	14	107	60	43	45	●
1634SU03C-1220	✲	12.2	14	107	60	43	45	●
1634SU03C-1225	✲	12.25	14	107	60	43	45	○

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1634SU*	✔	✔	✔			
1634SUK*			✔			

✔ Very suitable
✔ Suitable

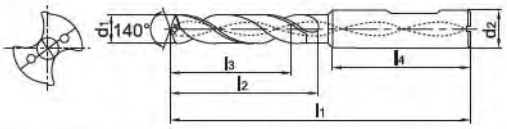
System code C28 Machining instructions C165 Cutting data C122 Nonstandard order C178

SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1634SU03C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1634SU03C-1230	✲	12.3	14	107	60	43	45	●
1634SU03C-1250	✲	12.5	14	107	60	43	45	●
1634SU03C-1270	✲	12.7	14	107	60	43	45	●
1634SU03C-1275	✲	12.75	14	107	60	43	45	○
1634SU03C-1280	✲	12.8	14	107	60	43	45	●
1634SU03C-1300	✲	13	14	107	60	43	45	●
1634SU03C-1310	✲	13.1	14	107	60	43	45	●
1634SU03C-1335	✲	13.35	14	107	60	43	45	○
1634SU03C-1350	✲	13.5	14	107	60	43	45	●
1634SU03C-1380	✲	13.8	14	107	60	43	45	●
1634SU03C-1400	✲	14	14	107	60	43	45	●
1634SU03C-1420	✲	14.2	16	107	60	43	45	○
1634SU03C-1425	✲	14.25	16	115	65	45	48	○
1634SU03C-1430	✲	14.3	16	115	65	45	48	○
1634SU03C-1450	✲	14.5	16	115	65	45	48	●
1634SU03C-1475	✲	14.75	16	115	65	45	48	○
1634SU03C-1480	✲	14.8	16	115	65	45	48	●
1634SU03C-1500	✲	15	16	115	65	45	48	●
1634SU03C-1510	✲	15.1	16	115	65	45	48	○
1634SU03C-1535	✲	15.35	16	115	65	45	48	○
1634SU03C-1550	✲	15.5	16	115	65	45	48	○
1634SU03C-1580	✲	15.8	16	115	65	45	48	○
1634SU03C-1600	✲	16	16	115	65	45	48	●
1634SU03C-1650	✲	16.5	18	123	73	51	48	○
1634SU03C-1675	✲	16.75	18	123	73	51	48	○
1634SU03C-1680	✲	16.8	18	123	73	51	48	○
1634SU03C-1700	✲	17	18	123	73	51	48	●
1634SU03C-1750	✲	17.5	18	123	73	51	48	●
1634SU03C-1780	✲	17.8	18	123	73	51	48	○
1634SU03C-1800	✲	18	18	123	73	51	48	●
1634SU03C-1850	✲	18.5	20	131	79	55	50	○
1634SU03C-1880	✲	18.8	20	131	79	55	50	○
1634SU03C-1900	✲	19	20	131	79	55	50	○
1634SU03C-1950	✲	19.5	20	131	79	55	50	●
1634SU03C-1980	✲	19.8	20	131	79	55	50	○
1634SU03C-2000	✲	20	20	131	79	55	50	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1634SU*	✔	✔	✔			
1634SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

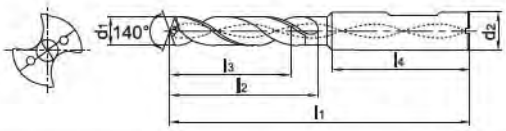
Solid carbide drills SU series

SU(K) drill 5xD General machining Add K (SUK) to the code for use on Cast Iron

1636SU05C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1636SU05C-0300	✲	3	6	62	20	14	36	●
1636SU05C-0310	✲	3.1	6	66	28	23	36	●
1636SU05C-0320	✲	3.2	6	66	28	23	36	●
1636SU05C-0325	✲	3.25	6	66	28	23	36	○
1636SU05C-0330	✲	3.3	6	66	28	23	36	●
1636SU05C-0340	✲	3.4	6	66	28	23	36	●
1636SU05C-0350	✲	3.5	6	66	28	23	36	●
1636SU05C-0360	✲	3.6	6	66	28	23	36	●
1636SU05C-0370	✲	3.7	6	66	28	23	36	●
1636SU05C-0380	✲	3.8	6	74	36	29	36	●
1636SU05C-0390	✲	3.9	6	74	36	29	36	●
1636SU05C-0400	✲	4	6	74	36	29	36	●
1636SU05C-0410	✲	4.1	6	74	36	29	36	●
1636SU05C-0420	✲	4.2	6	74	36	29	36	●
1636SU05C-0430	✲	4.3	6	74	36	29	36	●
1636SU05C-0440	✲	4.4	6	74	36	29	36	●
1636SU05C-0450	✲	4.5	6	74	36	29	36	●
1636SU05C-0460	✲	4.6	6	74	36	29	36	●
1636SU05C-0465	✲	4.65	6	74	36	29	36	●
1636SU05C-0470	✲	4.7	6	74	36	29	36	●
1636SU05C-0480	✲	4.8	6	82	44	35	36	●
1636SU05C-0490	✲	4.9	6	82	44	35	36	●
1636SU05C-0500	✲	5	6	82	44	35	36	●
1636SU05C-0510	✲	5.1	6	82	44	35	36	●
1636SU05C-0520	✲	5.2	6	82	44	35	36	●
1636SU05C-0530	✲	5.3	6	82	44	35	36	●
1636SU05C-0540	✲	5.4	6	82	44	35	36	●
1636SU05C-0550	✲	5.5	6	82	44	35	36	●
1636SU05C-0555	✲	5.55	6	82	44	35	36	●
1636SU05C-0560	✲	5.6	6	82	44	35	36	●
1636SU05C-0570	✲	5.7	6	82	44	35	36	●
1636SU05C-0580	✲	5.8	6	82	44	35	36	●
1636SU05C-0590	✲	5.9	6	82	44	35	36	●
1636SU05C-0600	✲	6	6	82	44	35	36	●
1636SU05C-0610	✲	6.1	8	91	53	43	36	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1636SU*	✔	✔	✔			
1636SUK*			✔			

✔ Very suitable
✔ Suitable

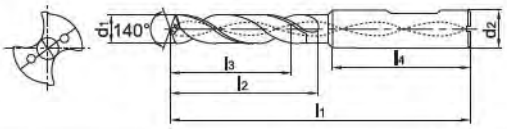
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1636SU05C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1636SU05C-0620	✲	6.2	8	91	53	43	36	●
1636SU05C-0630	✲	6.3	8	91	53	43	36	●
1636SU05C-0640	✲	6.4	8	91	53	43	36	●
1636SU05C-0650	✲	6.5	8	91	53	43	36	●
1636SU05C-0660	✲	6.6	8	91	53	43	36	●
1636SU05C-0670	✲	6.7	8	91	53	43	36	●
1636SU05C-0675	✲	6.75	8	91	53	43	36	●
1636SU05C-0680	✲	6.8	8	91	53	43	36	●
1636SU05C-0690	✲	6.9	8	91	53	43	36	●
1636SU05C-0700	✲	7	8	91	53	43	36	●
1636SU05C-0710	✲	7.1	8	91	53	43	36	●
1636SU05C-0720	✲	7.2	8	91	53	43	36	●
1636SU05C-0730	✲	7.3	8	91	53	43	36	●
1636SU05C-0740	✲	7.4	8	91	53	43	36	●
1636SU05C-0745	✲	7.45	8	91	53	43	36	●
1636SU05C-0750	✲	7.5	8	91	53	43	36	●
1636SU05C-0760	✲	7.6	8	91	53	43	36	●
1636SU05C-0770	✲	7.7	8	91	53	43	36	●
1636SU05C-0780	✲	7.8	8	91	53	43	36	●
1636SU05C-0790	✲	7.9	8	91	53	43	36	●
1636SU05C-0800	✲	8	8	91	53	43	36	●
1636SU05C-0810	✲	8.1	10	103	61	49	40	●
1636SU05C-0820	✲	8.2	10	103	61	49	40	●
1636SU05C-0830	✲	8.3	10	103	61	49	40	●
1636SU05C-0840	✲	8.4	10	103	61	49	40	●
1636SU05C-0850	✲	8.5	10	103	61	49	40	●
1636SU05C-0860	✲	8.6	10	103	61	49	40	●
1636SU05C-0870	✲	8.7	10	103	61	49	40	●
1636SU05C-0880	✲	8.8	10	103	61	49	40	●
1636SU05C-0890	✲	8.9	10	103	61	49	40	●
1636SU05C-0900	✲	9	10	103	61	49	40	●
1636SU05C-0910	✲	9.1	10	103	61	49	40	●
1636SU05C-0920	✲	9.2	10	103	61	49	40	●
1636SU05C-0930	✲	9.3	10	103	61	49	40	●
1636SU05C-0935	✲	9.35	10	103	61	49	40	○

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1636SU*	✔	✔	✔			
1636SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

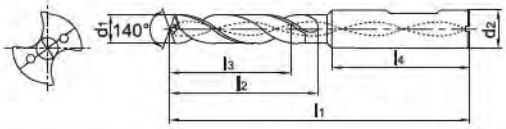
Solid carbide drills SU series

SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1636SU05C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article		Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1636SU05C-0940	✲	9.4	10	103	61	49	40	●
1636SU05C-0945	✲	9.45	10	103	61	49	40	○
1636SU05C-0950	✲	9.5	10	103	61	49	40	●
1636SU05C-0960	✲	9.6	10	103	61	49	40	●
1636SU05C-0970	✲	9.7	10	103	61	49	40	●
1636SU05C-0980	✲	9.8	10	103	61	49	40	●
1636SU05C-0990	✲	9.9	10	103	61	49	40	●
1636SU05C-1000	✲	10	10	103	61	49	40	●
1636SU05C-1010	✲	10.1	12	118	71	56	45	●
1636SU05C-1020	✲	10.2	12	118	71	56	45	●
1636SU05C-1025	✲	10.25	12	118	71	56	45	●
1636SU05C-1030	✲	10.3	12	118	71	56	45	●
1636SU05C-1040	✲	10.4	12	118	71	56	45	●
1636SU05C-1050	✲	10.5	12	118	71	56	45	●
1636SU05C-1060	✲	10.6	12	118	71	56	45	●
1636SU05C-1070	✲	10.7	12	118	71	56	45	●
1636SU05C-1080	✲	10.8	12	118	71	56	45	●
1636SU05C-1090	✲	10.9	12	118	71	56	45	●
1636SU05C-1100	✲	11	12	118	71	56	45	●
1636SU05C-1110	✲	11.1	12	118	71	56	45	●
1636SU05C-1120	✲	11.2	12	118	71	56	45	●
1636SU05C-1125	✲	11.25	12	118	71	56	45	○
1636SU05C-1130	✲	11.3	12	118	71	56	45	●
1636SU05C-1135	✲	11.35	12	118	71	56	45	○
1636SU05C-1140	✲	11.4	12	118	71	56	45	●
1636SU05C-1145	✲	11.45	12	118	71	56	45	○
1636SU05C-1150	✲	11.5	12	118	71	56	45	●
1636SU05C-1160	✲	11.6	12	118	71	56	45	●
1636SU05C-1170	✲	11.7	12	118	71	56	45	●
1636SU05C-1180	✲	11.8	12	118	71	56	45	●
1636SU05C-1190	✲	11.9	12	118	71	56	45	●
1636SU05C-1200	✲	12	12	118	71	56	45	●
1636SU05C-1210	✲	12.1	14	124	77	60	45	●
1636SU05C-1220	✲	12.2	14	124	77	60	45	●
1636SU05C-1225	✲	12.25	14	124	77	60	45	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1636SU*	✔	✔	✔			
1636SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

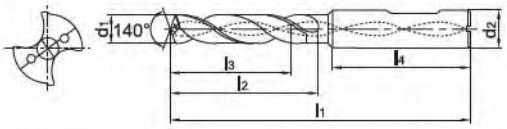
ZCC·CT

SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1636SU05C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1636SU05C-1230	✲	12.3	14	124	77	60	45	●
1636SU05C-1250	✲	12.5	14	124	77	60	45	●
1636SU05C-1270	✲	12.7	14	124	77	60	45	●
1636SU05C-1275	✲	12.75	14	124	77	60	45	○
1636SU05C-1280	✲	12.8	14	124	77	60	45	●
1636SU05C-1300	✲	13	14	124	77	60	45	●
1636SU05C-1310	✲	13.1	14	124	77	60	45	●
1636SU05C-1335	✲	13.35	14	124	77	60	56	○
1636SU05C-1350	✲	13.5	14	124	77	60	45	●
1636SU05C-1380	✲	13.8	14	124	77	60	45	●
1636SU05C-1400	✲	14	14	124	77	60	45	●
1636SU05C-1420	✲	14.2	16	124	77	60	45	●
1636SU05C-1425	✲	14.25	16	133	83	63	48	●
1636SU05C-1430	✲	14.3	16	133	83	63	48	●
1636SU05C-1450	✲	14.5	16	133	83	63	48	●
1636SU05C-1475	✲	14.75	16	133	83	63	48	○
1636SU05C-1480	✲	14.8	16	133	83	63	48	●
1636SU05C-1500	✲	15	16	133	83	63	48	●
1636SU05C-1510	✲	15.1	16	133	83	63	48	●
1636SU05C-1535	✲	15.35	16	133	83	63	48	○
1636SU05C-1550	✲	15.5	16	133	83	63	48	●
1636SU05C-1580	✲	15.8	16	133	83	63	48	●
1636SU05C-1600	✲	16	16	133	83	63	48	●
1636SU05C-1650	✲	16.5	18	143	93	71	48	●
1636SU05C-1675	✲	16.75	18	143	93	71	48	○
1636SU05C-1680	✲	16.8	18	143	93	71	48	●
1636SU05C-1700	✲	17	18	143	93	71	48	●
1636SU05C-1750	✲	17.5	18	143	93	71	48	●
1636SU05C-1780	✲	17.8	18	143	93	71	48	●
1636SU05C-1800	✲	18	18	143	93	71	48	●
1636SU05C-1850	✲	18.5	20	153	101	77	50	●
1636SU05C-1880	✲	18.8	20	153	101	77	50	●
1636SU05C-1900	✲	19	20	153	101	77	50	●
1636SU05C-1950	✲	19.5	20	153	101	77	50	●
1636SU05C-1980	✲	19.8	20	153	101	77	50	●
1636SU05C-2000	✲	20	20	153	101	77	50	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1636SU*	✔	✔	✔			
1636SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

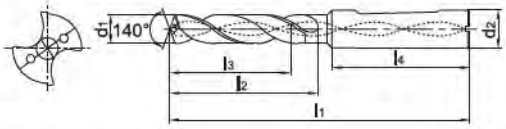
Solid carbide drills SU series

SU(K) drill 3xD General machining Add K (SUK) to the code for use on Cast Iron

1734SU03C

– Whistle Notch clamping surface
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1734SU03C-0300	✲	3	6	66	28	23	36	●
1734SU03C-0310	✲	3.1	6	62	20	14	36	●
1734SU03C-0320	✲	3.2	6	62	20	14	36	●
1734SU03C-0325	✲	3.25	6	62	20	14	36	○
1734SU03C-0330	✲	3.3	6	62	20	14	36	●
1734SU03C-0340	✲	3.4	6	62	20	14	36	●
1734SU03C-0350	✲	3.5	6	62	20	14	36	●
1734SU03C-0360	✲	3.6	6	62	20	14	36	●
1734SU03C-0370	✲	3.7	6	62	20	14	36	●
1734SU03C-0380	✲	3.8	6	66	24	17	36	●
1734SU03C-0390	✲	3.9	6	66	24	17	36	●
1734SU03C-0400	✲	4	6	66	24	17	36	●
1734SU03C-0410	✲	4.1	6	66	24	17	36	●
1734SU03C-0420	✲	4.2	6	66	24	17	36	●
1734SU03C-0430	✲	4.3	6	66	24	17	36	●
1734SU03C-0440	✲	4.4	6	66	24	17	36	●
1734SU03C-0450	✲	4.5	6	66	24	17	36	●
1734SU03C-0460	✲	4.6	6	66	24	17	36	●
1734SU03C-0465	✲	4.65	6	66	24	17	36	○
1734SU03C-0470	✲	4.7	6	66	24	17	36	●
1734SU03C-0480	✲	4.8	6	66	28	20	36	●
1734SU03C-0490	✲	4.9	6	66	28	20	36	●
1734SU03C-0500	✲	5	6	66	28	20	36	●
1734SU03C-0510	✲	5.1	6	66	28	20	36	●
1734SU03C-0520	✲	5.2	6	66	28	20	36	●
1734SU03C-0530	✲	5.3	6	66	28	20	36	●
1734SU03C-0540	✲	5.4	6	66	28	20	36	●
1734SU03C-0550	✲	5.5	6	66	28	20	36	●
1734SU03C-0555	✲	5.55	6	66	28	20	36	●
1734SU03C-0560	✲	5.6	6	66	28	20	36	●
1734SU03C-0570	✲	5.7	6	66	28	20	36	●
1734SU03C-0580	✲	5.8	6	66	28	20	36	●
1734SU03C-0590	✲	5.9	6	66	28	20	36	●
1734SU03C-0600	✲	6	6	66	28	20	36	●
1734SU03C-0610	✲	6.1	8	79	34	24	36	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1734SU*	✔	✔	✔			
1734SUK*			✔			

✔ Very suitable
✔ Suitable

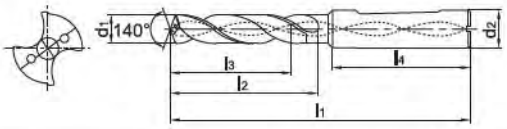
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1734SU03C

- Whistle Notch clamping surface
- Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1734SU03C-0620	✲	6.2	8	79	34	24	36	●
1734SU03C-0630	✲	6.3	8	79	34	24	36	●
1734SU03C-0640	✲	6.4	8	79	34	24	36	●
1734SU03C-0650	✲	6.5	8	79	34	24	36	●
1734SU03C-0660	✲	6.6	8	79	34	24	36	●
1734SU03C-0670	✲	6.7	8	79	34	24	36	●
1734SU03C-0675	✲	6.75	8	79	34	24	36	●
1734SU03C-0680	✲	6.8	8	79	34	24	36	●
1734SU03C-0690	✲	6.9	8	79	34	24	36	●
1734SU03C-0700	✲	7	8	79	34	24	36	●
1734SU03C-0710	✲	7.1	8	79	41	29	36	●
1734SU03C-0720	✲	7.2	8	79	41	29	36	●
1734SU03C-0730	✲	7.3	8	79	41	29	36	●
1734SU03C-0740	✲	7.4	8	79	41	29	36	●
1734SU03C-0745	✲	7.45	8	79	41	29	36	○
1734SU03C-0750	✲	7.5	8	79	41	29	36	●
1734SU03C-0760	✲	7.6	8	79	41	29	36	●
1734SU03C-0770	✲	7.7	8	79	41	29	36	●
1734SU03C-0780	✲	7.8	8	79	41	29	36	●
1734SU03C-0790	✲	7.9	8	79	41	29	36	●
1734SU03C-0800	✲	8	8	79	41	29	36	●
1734SU03C-0810	✲	8.1	10	89	47	35	40	●
1734SU03C-0820	✲	8.2	10	89	47	35	40	●
1734SU03C-0830	✲	8.3	10	89	47	35	40	●
1734SU03C-0840	✲	8.4	10	89	47	35	40	●
1734SU03C-0850	✲	8.5	10	89	47	35	40	●
1734SU03C-0860	✲	8.6	10	89	47	35	40	●
1734SU03C-0870	✲	8.7	10	89	47	35	40	●
1734SU03C-0880	✲	8.8	10	89	47	35	40	●
1734SU03C-0890	✲	8.9	10	89	47	35	40	●
1734SU03C-0900	✲	9	10	89	47	35	40	●
1734SU03C-0910	✲	9.1	10	89	47	35	40	●
1734SU03C-0920	✲	9.2	10	89	47	35	40	●
1734SU03C-0930	✲	9.3	10	89	47	35	40	●
1734SU03C-0935	✲	9.35	10	89	47	35	40	○

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1734SU*	✔	✔	✔			
1734SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

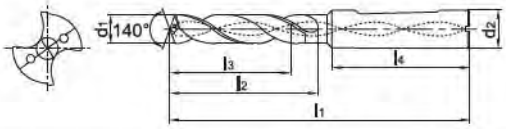
Solid carbide drills SU series

SU(K) drill 3xD General machining Add K (SUK) to the code for use on Cast Iron

1734SU03C

- Whistle Notch clamping surface
- Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1734SU03C-0940	✲	9.4	10	89	47	35	40	●
1734SU03C-0945	✲	9.45	10	89	47	35	40	○
1734SU03C-0950	✲	9.5	10	89	47	35	40	●
1734SU03C-0960	✲	9.6	10	89	47	35	40	●
1734SU03C-0970	✲	9.7	10	89	47	35	40	●
1734SU03C-0980	✲	9.8	10	89	47	35	40	●
1734SU03C-0990	✲	9.9	10	89	47	35	40	●
1734SU03C-1000	✲	10	10	89	47	35	40	●
1734SU03C-1010	✲	10.1	12	102	55	40	45	●
1734SU03C-1020	✲	10.2	12	102	55	40	45	●
1734SU03C-1025	✲	10.25	12	102	55	40	45	●
1734SU03C-1030	✲	10.3	12	102	55	40	45	●
1734SU03C-1040	✲	10.4	12	102	55	40	45	●
1734SU03C-1050	✲	10.5	12	102	55	40	45	●
1734SU03C-1060	✲	10.6	12	102	55	40	45	●
1734SU03C-1070	✲	10.7	12	102	55	40	45	●
1734SU03C-1080	✲	10.8	12	102	55	40	45	●
1734SU03C-1090	✲	10.9	12	102	55	40	45	●
1734SU03C-1100	✲	11	12	102	55	40	45	●
1734SU03C-1110	✲	11.1	12	102	55	40	45	●
1734SU03C-1120	✲	11.2	12	102	55	40	45	●
1734SU03C-1125	✲	11.25	12	102	55	40	45	○
1734SU03C-1130	✲	11.3	12	102	55	40	45	●
1734SU03C-1135	✲	11.35	12	102	55	40	45	○
1734SU03C-1140	✲	11.4	12	102	55	40	45	●
1734SU03C-1145	✲	11.45	12	102	55	40	45	○
1734SU03C-1150	✲	11.5	12	102	55	40	45	●
1734SU03C-1160	✲	11.6	12	102	55	40	45	●
1734SU03C-1170	✲	11.7	12	102	55	40	45	●
1734SU03C-1180	✲	11.8	12	102	55	40	45	●
1734SU03C-1190	✲	11.9	12	102	55	40	45	●
1734SU03C-1200	✲	12	12	102	55	40	45	●
1734SU03C-1210	✲	12.1	14	107	60	43	45	●
1734SU03C-1220	✲	12.2	14	107	60	43	45	●
1734SU03C-1225	✲	12.25	14	107	60	43	45	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1734SU*	✔	✔	✔			
1734SUK*			✔			

✔ Very suitable
✔ Suitable

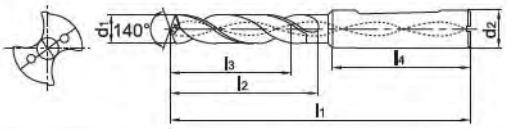
System code C28 Machining instructions C165 Cutting data C122 Nonstandard order C178

SU(K) drill 3xD | General machining | Add K (SUK) to the code for use on Cast Iron

1734SU03C

- Whistle Notch clamping surface
- Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1734SU03C-1230	✲	12.3	14	107	60	43	45	●
1734SU03C-1250	✲	12.5	14	107	60	43	45	●
1734SU03C-1270	✲	12.7	14	107	60	43	45	●
1734SU03C-1275	✲	12.75	14	107	60	43	45	●
1734SU03C-1280	✲	12.8	14	107	60	43	45	●
1734SU03C-1300	✲	13	14	107	60	43	45	●
1734SU03C-1310	✲	13.1	14	107	60	43	45	●
1734SU03C-1335	✲	13.35	14	107	60	43	45	○
1734SU03C-1350	✲	13.5	14	107	60	43	45	●
1734SU03C-1380	✲	13.8	14	107	60	43	45	●
1734SU03C-1400	✲	14	14	107	60	43	45	●
1734SU03C-1420	✲	14.2	16	107	60	43	45	●
1734SU03C-1425	✲	14.25	16	115	65	45	48	●
1734SU03C-1430	✲	14.3	16	115	65	45	48	●
1734SU03C-1450	✲	14.5	16	115	65	45	48	●
1734SU03C-1475	✲	14.75	16	115	65	45	48	●
1734SU03C-1480	✲	14.8	16	115	65	45	48	●
1734SU03C-1500	✲	15	16	115	65	45	48	●
1734SU03C-1510	✲	15.1	16	115	65	45	48	●
1734SU03C-1535	✲	15.35	16	115	65	45	48	○
1734SU03C-1550	✲	15.5	16	115	65	45	48	●
1734SU03C-1580	✲	15.8	16	115	65	45	48	●
1734SU03C-1600	✲	16	16	115	65	45	48	●
1734SU03C-1650	✲	16.5	18	123	73	51	48	●
1734SU03C-1675	✲	16.75	18	123	73	51	48	●
1734SU03C-1680	✲	16.8	18	123	73	51	48	●
1734SU03C-1700	✲	17	18	123	73	51	48	●
1734SU03C-1750	✲	17.5	18	123	73	51	48	●
1734SU03C-1780	✲	17.8	18	123	73	51	48	●
1734SU03C-1800	✲	18	18	123	73	51	48	●
1734SU03C-1850	✲	18.5	20	131	79	55	50	●
1734SU03C-1880	✲	18.8	20	131	79	55	50	●
1734SU03C-1900	✲	19	20	131	79	55	50	●
1734SU03C-1950	✲	19.5	20	131	79	55	50	●
1734SU03C-1980	✲	19.8	20	131	79	55	50	●
1734SU03C-2000	✲	20	20	131	79	55	50	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1734SU*	✔	✔	✔			
1734SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

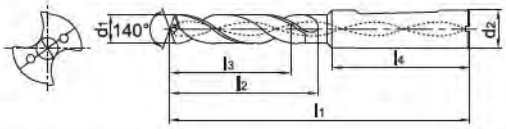
Solid carbide drills SU series

SU(K) drill 5xD — General machining — Add K (SUK) to the code for use on Cast Iron

1736SU05C

– Whistle Notch clamping surface
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1736SU05C-0300	✲	3	6	66	28	23	36	●
1736SU05C-0310	✲	3.1	6	66	28	23	36	●
1736SU05C-0320	✲	3.2	6	66	28	23	36	●
1736SU05C-0325	✲	3.25	6	66	28	23	36	○
1736SU05C-0330	✲	3.3	6	66	28	23	36	●
1736SU05C-0340	✲	3.4	6	66	28	23	36	●
1736SU05C-0350	✲	3.5	6	66	28	23	36	●
1736SU05C-0360	✲	3.6	6	66	28	23	36	●
1736SU05C-0370	✲	3.7	6	66	28	23	36	●
1736SU05C-0380	✲	3.8	6	74	36	29	36	●
1736SU05C-0390	✲	3.9	6	74	36	29	36	●
1736SU05C-0400	✲	4	6	74	36	29	36	●
1736SU05C-0410	✲	4.1	6	74	36	29	36	●
1736SU05C-0420	✲	4.2	6	74	36	29	36	●
1736SU05C-0430	✲	4.3	6	74	36	29	36	●
1736SU05C-0440	✲	4.4	6	74	36	29	36	●
1736SU05C-0450	✲	4.5	6	74	36	29	36	●
1736SU05C-0460	✲	4.6	6	74	36	29	36	●
1736SU05C-0465	✲	4.65	6	74	36	29	36	○
1736SU05C-0470	✲	4.7	6	74	36	29	36	●
1736SU05C-0480	✲	4.8	6	82	44	35	36	●
1736SU05C-0490	✲	4.9	6	82	44	35	36	●
1736SU05C-0500	✲	5	6	82	44	35	36	●
1736SU05C-0510	✲	5.1	6	82	44	35	36	●
1736SU05C-0520	✲	5.2	6	82	44	35	36	●
1736SU05C-0530	✲	5.3	6	82	44	35	36	●
1736SU05C-0540	✲	5.4	6	82	44	35	36	●
1736SU05C-0550	✲	5.5	6	82	44	35	36	●
1736SU05C-0555	✲	5.55	6	82	44	35	36	●
1736SU05C-0560	✲	5.6	6	82	44	35	36	●
1736SU05C-0570	✲	5.7	6	82	44	35	36	●
1736SU05C-0580	✲	5.8	6	82	44	35	36	●
1736SU05C-0590	✲	5.9	6	82	44	35	36	●
1736SU05C-0600	✲	6	6	82	44	35	36	●
1736SU05C-0610	✲	6.1	8	91	53	43	36	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1736SU*	✔	✔	✔			
1736SUK*			✔			

✔ Very suitable
✔ Suitable

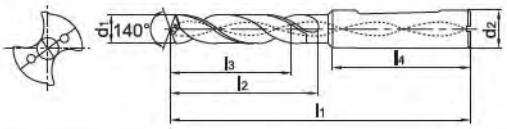
System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1736SU05C

- Whistle Notch clamping surface
- Coolant exit, axial concentric

Internal coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1736SU05C-0620	✻	6.2	8	91	53	43	36	●
1736SU05C-0630	✻	6.3	8	91	53	43	36	●
1736SU05C-0640	✻	6.4	8	91	53	43	36	●
1736SU05C-0650	✻	6.5	8	91	53	43	36	●
1736SU05C-0660	✻	6.6	8	91	53	43	36	●
1736SU05C-0670	✻	6.7	8	91	53	43	36	●
1736SU05C-0675	✻	6.75	8	91	53	43	36	●
1736SU05C-0680	✻	6.8	8	91	53	43	36	●
1736SU05C-0690	✻	6.9	8	91	53	43	36	●
1736SU05C-0700	✻	7	8	91	53	43	36	●
1736SU05C-0710	✻	7.1	8	91	53	43	36	●
1736SU05C-0720	✻	7.2	8	91	53	43	36	●
1736SU05C-0730	✻	7.3	8	91	53	43	36	●
1736SU05C-0740	✻	7.4	8	91	53	43	36	●
1736SU05C-0745	✻	7.45	8	91	53	43	36	○
1736SU05C-0750	✻	7.5	8	91	53	43	36	●
1736SU05C-0760	✻	7.6	8	91	53	43	36	●
1736SU05C-0770	✻	7.7	8	91	53	43	36	●
1736SU05C-0780	✻	7.8	8	91	53	43	36	●
1736SU05C-0790	✻	7.9	8	91	53	43	36	●
1736SU05C-0800	✻	8	8	91	53	43	36	●
1736SU05C-0810	✻	8.1	10	103	61	49	40	●
1736SU05C-0820	✻	8.2	10	103	61	49	40	●
1736SU05C-0830	✻	8.3	10	103	61	49	40	●
1736SU05C-0840	✻	8.4	10	103	61	49	40	●
1736SU05C-0850	✻	8.5	10	103	61	49	40	●
1736SU05C-0860	✻	8.6	10	103	61	49	40	●
1736SU05C-0870	✻	8.7	10	103	61	49	40	●
1736SU05C-0880	✻	8.8	10	103	61	49	40	●
1736SU05C-0890	✻	8.9	10	103	61	49	40	●
1736SU05C-0900	✻	9	10	103	61	49	40	●
1736SU05C-0910	✻	9.1	10	103	61	49	40	●
1736SU05C-0920	✻	9.2	10	103	61	49	40	●
1736SU05C-0930	✻	9.3	10	103	61	49	40	●
1736SU05C-0935	✻	9.35	10	103	61	49	40	○

● Ex stock ○ On demand

All articles SUK on demand

✻ With internal cooling

Application field

Type	P	M	K	N	S	H
1736SU*	✔	✔	✔			
1736SUK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

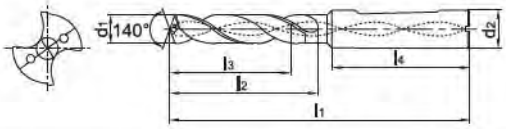
Solid carbide drills SU series

SU(K) drill 5xD General machining Add K (SUK) to the code for use on Cast Iron

1736SU05C

– Whistle Notch clamping surface
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1736SU05C-0940	✲	9.4	10	103	61	49	40	●
1736SU05C-0945	✲	9.45	10	103	61	49	40	○
1736SU05C-0950	✲	9.5	10	103	61	49	40	●
1736SU05C-0960	✲	9.6	10	103	61	49	40	●
1736SU05C-0970	✲	9.7	10	103	61	49	40	●
1736SU05C-0980	✲	9.8	10	103	61	49	40	●
1736SU05C-0990	✲	9.9	10	103	61	49	40	●
1736SU05C-1000	✲	10	10	103	61	49	40	●
1736SU05C-1010	✲	10.1	12	118	71	56	45	●
1736SU05C-1020	✲	10.2	12	118	71	56	45	●
1736SU05C-1025	✲	10.25	12	118	71	56	45	●
1736SU05C-1030	✲	10.3	12	118	71	56	45	●
1736SU05C-1040	✲	10.4	12	118	71	56	45	●
1736SU05C-1050	✲	10.5	12	118	71	56	45	●
1736SU05C-1060	✲	10.6	12	118	71	56	45	●
1736SU05C-1070	✲	10.7	12	118	71	56	45	●
1736SU05C-1080	✲	10.8	12	118	71	56	45	●
1736SU05C-1090	✲	10.9	12	118	71	56	45	●
1736SU05C-1100	✲	11	12	118	71	56	45	●
1736SU05C-1110	✲	11.1	12	118	71	56	45	●
1736SU05C-1120	✲	11.2	12	118	71	56	45	●
1736SU05C-1125	✲	11.25	12	118	71	56	45	○
1736SU05C-1130	✲	11.3	12	118	71	56	45	●
1736SU05C-1135	✲	11.35	12	118	71	56	45	○
1736SU05C-1140	✲	11.4	12	118	71	56	45	●
1736SU05C-1145	✲	11.45	12	118	71	56	45	○
1736SU05C-1150	✲	11.5	12	118	71	56	45	●
1736SU05C-1160	✲	11.6	12	118	71	56	45	●
1736SU05C-1170	✲	11.7	12	118	71	56	45	●
1736SU05C-1180	✲	11.8	12	118	71	56	45	●
1736SU05C-1190	✲	11.9	12	118	71	56	45	●
1736SU05C-1200	✲	12	12	118	71	56	45	●
1736SU05C-1210	✲	12.1	14	124	77	60	45	●
1736SU05C-1220	✲	12.2	14	124	77	60	45	●
1736SU05C-1225	✲	12.25	14	124	77	60	45	○

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1736SU*	✔	✔	✔			
1736SUK*			✔			

✔ Very suitable
✔ Suitable

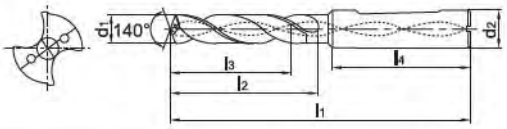
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SU(K) drill 5xD | General machining | Add K (SUK) to the code for use on Cast Iron

1736SU05C

- Whistle Notch clamping surface
- Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1736SU05C-1230	✲	12.3	14	124	77	60	45	●
1736SU05C-1250	✲	12.5	14	124	77	60	45	●
1736SU05C-1270	✲	12.7	14	124	77	60	45	●
1736SU05C-1275	✲	12.75	14	124	77	60	45	●
1736SU05C-1280	✲	12.8	14	124	77	60	45	●
1736SU05C-1300	✲	13	14	124	77	60	45	●
1736SU05C-1310	✲	13.1	14	124	77	60	45	●
1736SU05C-1335	✲	13.35	14	124	77	60	56	○
1736SU05C-1350	✲	13.5	14	124	77	60	45	●
1736SU05C-1380	✲	13.8	14	124	77	60	45	●
1736SU05C-1400	✲	14	14	124	77	60	45	●
1736SU05C-1420	✲	14.2	16	124	77	60	45	●
1736SU05C-1425	✲	14.25	16	133	83	63	48	●
1736SU05C-1430	✲	14.3	16	133	83	63	48	●
1736SU05C-1450	✲	14.5	16	133	83	63	48	●
1736SU05C-1475	✲	14.75	16	133	83	63	48	●
1736SU05C-1480	✲	14.8	16	133	83	63	48	●
1736SU05C-1500	✲	15	16	133	83	63	48	●
1736SU05C-1510	✲	15.1	16	133	83	63	48	●
1736SU05C-1535	✲	15.35	16	133	83	63	48	○
1736SU05C-1550	✲	15.5	16	133	83	63	48	●
1736SU05C-1580	✲	15.8	16	133	83	63	48	●
1736SU05C-1600	✲	16	16	133	83	63	48	●
1736SU05C-1650	✲	16.5	18	143	93	71	48	●
1736SU05C-1675	✲	16.75	18	143	93	71	48	●
1736SU05C-1680	✲	16.8	18	143	93	71	48	●
1736SU05C-1700	✲	17	18	143	93	71	48	●
1736SU05C-1750	✲	17.5	18	143	93	71	48	●
1736SU05C-1780	✲	17.8	18	143	93	71	48	●
1736SU05C-1800	✲	18	18	143	93	71	48	●
1736SU05C-1850	✲	18.5	20	153	101	77	50	●
1736SU05C-1880	✲	18.8	20	153	101	77	50	●
1736SU05C-1900	✲	19	20	153	101	77	50	●
1736SU05C-1950	✲	19.5	20	153	101	77	50	●
1736SU05C-1980	✲	19.8	20	153	101	77	50	●
1736SU05C-2000	✲	20	20	153	101	77	50	●

● Ex stock ○ On demand

All articles SUK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1736SU*	✔	✔	✔			
1736SUK*			✔			

✔ Very suitable
✔ Suitable

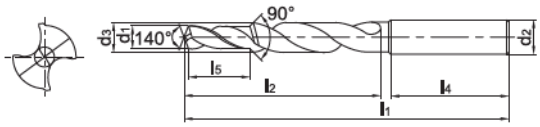
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SU drill 3xD General machining

1557SU03

– Type of shank DIN 6535HA

External coolant



Article	*	Dimensions [mm]							Grade
		d_1 (m8)	d_2 (h6)	d_3 (m7)	l_1	l_2	l_4	l_5	KDG303
1557SU03-M4		3.3	6	4.5	66	28	36	11.4	●
1557SU03-M5		4.2	6	6	66	28	36	13.6	●
1557SU03-M6		5	8	7	79	41	36	16.5	●
1557SU03-M8		6.75	10	9.5	89	47	40	21	●
1557SU03-M8x1.0		7	10	9.8	89	47	40	21	●
1557SU03-M10		8.5	12	12	102	55	45	25.5	●
1557SU03-M10x1.0		9	12	12	102	55	45	25.5	○
1557SU03-M12		10.25	14	14	107	60	45	30	●
1557SU03-M12x1.5		10.5	14	14	107	60	45	30	●
1557SU03-M14		12	16	16	115	65	48	34.5	●
1557SU03-M14x1.5		12.5	16	16	115	65	48	34.5	●
1557SU03-M16		14	18	18	123	73	48	38.5	●
1557SU03-M16x1.5		14.5	18	18	123	73	48	38.5	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✔	✔	✔			

✔ Very suitable
✔ Suitable

System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

1588SL

1588SL For deep hole drilling

10xD, 12xD, 15xD, 20xD and 30xD drills

- For machining of steel, non-ferrous metals, stainless steel and heat-resistant alloys.
- Double margin for high accuracy and stable machining.
- Special flute design for less friction and good chip flow.

1588SLK DIN 1412 D

Deep hole drills for machining of cast iron

- Special cut for cast iron with ductile iron and malleable cast iron.
- Improved tool life due to impact resistant cutting edges.

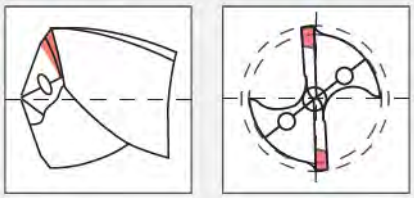
Straight cut

For cast iron

SLK

Deep hole drill

Form D: Cut for cast iron



SLK : All articles on demand.

Please add K when ordering:

1534SLK03-0100

SP series

For drilling pilot holes

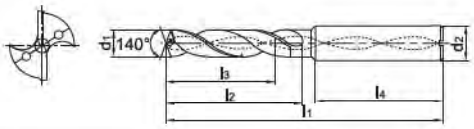
- Recommended for deep hole drills with 15xD and larger.

SL(K) drill 10xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL10C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL10C-0300	✲	3	6	80	43	39	36	●
1588SL10C-0310	✲	3.1	6	80	43	39	36	○
1588SL10C-0320	✲	3.2	6	80	43	39	36	●
1588SL10C-0330	✲	3.3	6	80	43	39	36	●
1588SL10C-0340	✲	3.4	6	80	43	39	36	●
1588SL10C-0350	✲	3.5	6	80	43	39	36	●
1588SL10C-0360	✲	3.6	6	80	43	39	36	●
1588SL10C-0370	✲	3.7	6	80	43	39	36	●
1588SL10C-0380	✲	3.8	6	80	43	39	36	●
1588SL10C-0390	✲	3.9	6	80	43	39	36	●
1588SL10C-0400	✲	4	6	92	55	50	36	●
1588SL10C-0410	✲	4.1	6	92	55	50	36	●
1588SL10C-0420	✲	4.2	6	92	55	50	36	●
1588SL10C-0430	✲	4.3	6	92	55	50	36	●
1588SL10C-0440	✲	4.4	6	92	55	50	36	●
1588SL10C-0450	✲	4.5	6	92	55	50	36	●
1588SL10C-0460	✲	4.6	6	92	55	50	36	●
1588SL10C-0470	✲	4.7	6	92	55	50	36	●
1588SL10C-0480	✲	4.8	6	92	55	50	36	●
1588SL10C-0490	✲	4.9	6	92	55	50	36	●
1588SL10C-0500	✲	5	6	104	68	61	36	●
1588SL10C-0510	✲	5.1	6	104	68	61	36	●
1588SL10C-0520	✲	5.2	6	104	68	61	36	●
1588SL10C-0530	✲	5.3	6	104	68	61	36	●
1588SL10C-0540	✲	5.4	6	104	68	61	36	●
1588SL10C-0550	✲	5.5	6	104	68	61	36	●
1588SL10C-0560	✲	5.6	6	104	68	61	36	●
1588SL10C-0570	✲	5.7	6	104	68	61	36	●
1588SL10C-0580	✲	5.8	6	104	68	61	36	●
1588SL10C-0590	✲	5.9	6	104	68	61	36	●
1588SL10C-0600	✲	6	6	104	68	61	36	●
1588SL10C-0610	✲	6.1	8	117	80	71	36	●
1588SL10C-0620	✲	6.2	8	117	80	71	36	●
1588SL10C-0630	✲	6.3	8	117	80	71	36	●
1588SL10C-0640	✲	6.4	8	117	80	71	36	●

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

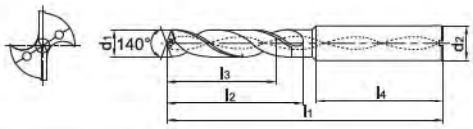
System code C28 Machining instructions C165 Cutting data C122 Nonstandard order C178

SL(K) drill 10xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL10C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL10C-0650	✲	6.5	8	117	80	71	36	●
1588SL10C-0660	✲	6.6	8	117	80	71	36	●
1588SL10C-0670	✲	6.7	8	117	80	71	36	●
1588SL10C-0680	✲	6.8	8	117	80	71	36	●
1588SL10C-0690	✲	6.9	8	117	80	71	36	●
1588SL10C-0700	✲	7	8	117	80	71	36	●
1588SL10C-0710	✲	7.1	8	130	94	84	36	●
1588SL10C-0720	✲	7.2	8	130	94	84	36	●
1588SL10C-0730	✲	7.3	8	130	94	84	36	●
1588SL10C-0740	✲	7.4	8	130	94	84	36	●
1588SL10C-0750	✲	7.5	8	130	94	84	36	●
1588SL10C-0760	✲	7.6	8	130	94	84	36	●
1588SL10C-0770	✲	7.7	8	130	94	84	36	●
1588SL10C-0780	✲	7.8	8	130	94	84	36	●
1588SL10C-0790	✲	7.9	8	130	94	84	36	●
1588SL10C-0800	✲	8	8	130	94	84	36	●
1588SL10C-0810	✲	8.1	10	148	105	94	40	●
1588SL10C-0820	✲	8.2	10	148	105	94	40	●
1588SL10C-0830	✲	8.3	10	148	105	94	40	●
1588SL10C-0840	✲	8.4	10	148	105	94	40	●
1588SL10C-0850	✲	8.5	10	148	105	94	40	●
1588SL10C-0860	✲	8.6	10	148	105	94	40	●
1588SL10C-0870	✲	8.7	10	148	105	94	40	●
1588SL10C-0880	✲	8.8	10	148	105	94	40	●
1588SL10C-0890	✲	8.9	10	148	105	94	40	●
1588SL10C-0900	✲	9	10	148	105	94	40	●
1588SL10C-0910	✲	9.1	10	158	115	103	40	●
1588SL10C-0920	✲	9.2	10	158	115	103	40	●
1588SL10C-0930	✲	9.3	10	158	115	103	40	●
1588SL10C-0940	✲	9.4	10	158	115	103	40	●
1588SL10C-0950	✲	9.5	10	158	115	103	40	●
1588SL10C-0960	✲	9.6	10	158	115	103	40	●
1588SL10C-0970	✲	9.7	10	158	115	103	40	●
1588SL10C-0980	✲	9.8	10	158	115	103	40	●
1588SL10C-0990	✲	9.9	10	158	115	103	40	●

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

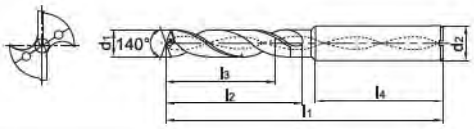
Solid carbide drills SL/SP series

SL(K) drill 10xD | General machining | Add K (SLK) to the code for use on Cast Iron

1588SL10C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL10C-1000	✲	10	10	158	115	103	40	●
1588SL10C-1010	✲	10.1	12	183	135	121	45	●
1588SL10C-1020	✲	10.2	12	183	135	121	45	●
1588SL10C-1030	✲	10.3	12	183	135	121	45	●
1588SL10C-1040	✲	10.4	12	183	135	121	45	●
1588SL10C-1050	✲	10.5	12	183	135	121	45	●
1588SL10C-1060	✲	10.6	12	183	135	121	45	●
1588SL10C-1070	✲	10.7	12	183	135	121	45	●
1588SL10C-1080	✲	10.8	12	183	135	121	45	●
1588SL10C-1090	✲	10.9	12	183	135	121	45	●
1588SL10C-1100	✲	11	12	183	135	121	45	●
1588SL10C-1110	✲	11.1	12	183	135	121	45	●
1588SL10C-1120	✲	11.2	12	183	135	121	45	●
1588SL10C-1130	✲	11.3	12	183	135	121	45	●
1588SL10C-1140	✲	11.4	12	183	135	121	45	●
1588SL10C-1150	✲	11.5	12	183	135	121	45	●
1588SL10C-1160	✲	11.6	12	183	135	121	45	●
1588SL10C-1170	✲	11.7	12	183	135	121	45	●
1588SL10C-1180	✲	11.8	12	183	135	121	45	●
1588SL10C-1190	✲	11.9	12	183	135	121	45	●
1588SL10C-1200	✲	12	12	183	135	121	45	●
1588SL10C-1225	✲	12.25	14	209	160	144	45	●
1588SL10C-1250	✲	12.5	14	209	160	144	45	●
1588SL10C-1270	✲	12.7	14	209	160	144	45	●
1588SL10C-1275	✲	12.75	14	209	160	144	45	●
1588SL10C-1280	✲	12.8	14	209	160	144	45	●
1588SL10C-1300	✲	13	14	209	160	144	45	●
1588SL10C-1310	✲	13.1	14	209	160	144	45	●
1588SL10C-1350	✲	13.5	14	209	160	144	45	●
1588SL10C-1380	✲	13.8	14	209	160	144	45	●
1588SL10C-1400	✲	14	14	209	160	144	45	●

● Ex stock ○ On demand
All articles SLK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

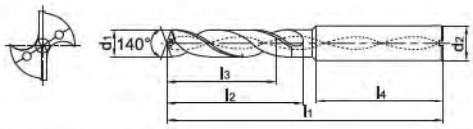
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SL(K) drill 12xD | General machining | Add K (SLK) to the code for use on Cast Iron

1588SL12C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL12C-0300	✲	3	6	90	50	40	36	●
1588SL12C-0310	✲	3.1	6	90	50	40	36	●
1588SL12C-0320	✲	3.2	6	90	50	40	36	●
1588SL12C-0330	✲	3.3	6	90	50	40	36	●
1588SL12C-0340	✲	3.4	6	90	50	40	36	●
1588SL12C-0350	✲	3.5	6	90	50	40	36	●
1588SL12C-0360	✲	3.6	6	90	50	40	36	●
1588SL12C-0370	✲	3.7	6	90	50	46	36	●
1588SL12C-0380	✲	3.8	6	90	50	46	36	●
1588SL12C-0390	✲	3.9	6	90	50	46	36	●
1588SL12C-0400	✲	4	6	102	64	56	36	●
1588SL12C-0410	✲	4.1	6	102	64	56	36	●
1588SL12C-0420	✲	4.2	6	102	64	56	36	●
1588SL12C-0430	✲	4.3	6	102	64	56	36	●
1588SL12C-0440	✲	4.4	6	102	64	56	36	●
1588SL12C-0450	✲	4.5	6	102	64	56	36	●
1588SL12C-0460	✲	4.6	6	102	64	56	36	●
1588SL12C-0470	✲	4.7	6	102	64	56	36	●
1588SL12C-0480	✲	4.8	6	102	64	56	36	●
1588SL12C-0490	✲	4.9	6	102	64	56	36	●
1588SL12C-0500	✲	5	6	116	78	72	36	●
1588SL12C-0510	✲	5.1	6	116	78	72	36	●
1588SL12C-0520	✲	5.2	6	116	78	72	36	●
1588SL12C-0530	✲	5.3	6	116	78	72	36	○
1588SL12C-0540	✲	5.4	6	116	78	72	36	○
1588SL12C-0550	✲	5.5	6	116	78	72	36	●
1588SL12C-0560	✲	5.6	6	116	78	72	36	●
1588SL12C-0570	✲	5.7	6	116	78	72	36	●
1588SL12C-0580	✲	5.8	6	116	78	72	36	●
1588SL12C-0590	✲	5.9	6	116	78	72	36	●
1588SL12C-0600	✲	6	6	116	78	72	36	●
1588SL12C-0610	✲	6.1	8	131	93	84	36	●
1588SL12C-0620	✲	6.2	8	131	93	84	36	●
1588SL12C-0630	✲	6.3	8	131	93	84	36	●
1588SL12C-0640	✲	6.4	8	131	93	84	36	●

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

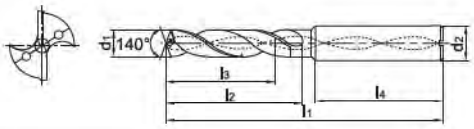
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SL(K) drill 12xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL12C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL12C-0650	✲	6.5	8	131	93	84	36	●
1588SL12C-0660	✲	6.6	8	131	93	84	36	●
1588SL12C-0670	✲	6.7	8	131	93	84	36	●
1588SL12C-0680	✲	6.8	8	131	93	84	36	●
1588SL12C-0690	✲	6.9	8	131	93	84	36	●
1588SL12C-0700	✲	7	8	131	93	84	36	●
1588SL12C-0710	✲	7.1	8	146	108	96	36	●
1588SL12C-0720	✲	7.2	8	146	108	96	36	●
1588SL12C-0730	✲	7.3	8	146	108	96	36	●
1588SL12C-0740	✲	7.4	8	146	108	96	36	●
1588SL12C-0750	✲	7.5	8	146	108	96	36	●
1588SL12C-0760	✲	7.6	8	146	108	96	36	○
1588SL12C-0770	✲	7.7	8	146	108	96	36	○
1588SL12C-0780	✲	7.8	8	146	108	96	36	●
1588SL12C-0790	✲	7.9	8	146	108	96	36	○
1588SL12C-0800	✲	8	8	146	108	96	36	●
1588SL12C-0810	✲	8.1	10	162	120	108	40	●
1588SL12C-0820	✲	8.2	10	162	120	108	40	●
1588SL12C-0830	✲	8.3	10	162	120	108	40	●
1588SL12C-0840	✲	8.4	10	162	120	108	40	●
1588SL12C-0850	✲	8.5	10	162	120	108	40	●
1588SL12C-0860	✲	8.6	10	162	120	108	40	●
1588SL12C-0870	✲	8.7	10	162	120	108	40	●
1588SL12C-0880	✲	8.8	10	162	120	108	40	●
1588SL12C-0890	✲	8.9	10	162	120	108	40	●
1588SL12C-0900	✲	9	10	162	120	108	40	●
1588SL12C-0910	✲	9.1	10	174	132	120	40	○
1588SL12C-0920	✲	9.2	10	174	132	120	40	●
1588SL12C-0930	✲	9.3	10	174	132	120	40	●
1588SL12C-0940	✲	9.4	10	174	132	120	40	●
1588SL12C-0950	✲	9.5	10	174	132	120	40	●
1588SL12C-0960	✲	9.6	10	174	132	120	40	○
1588SL12C-0970	✲	9.7	10	174	132	120	40	●
1588SL12C-0980	✲	9.8	10	174	132	120	40	●
1588SL12C-0990	✲	9.9	10	174	132	120	40	○

● Ex stock ○ On demand
All articles SLK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

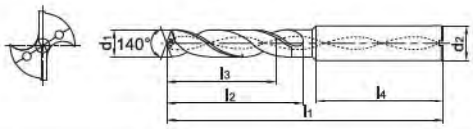
System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

SL(K) drill 12xD | General machining | Add K (SLK) to the code for use on Cast Iron

1588SL12C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL12C-1000	✲	10	10	174	132	120	40	●
1588SL12C-1010	✲	10.1	12	204	156	144	45	●
1588SL12C-1020	✲	10.2	12	204	156	144	45	●
1588SL12C-1030	✲	10.3	12	204	156	144	45	●
1588SL12C-1040	✲	10.4	12	204	156	144	45	●
1588SL12C-1050	✲	10.5	12	204	156	144	45	●
1588SL12C-1060	✲	10.6	12	204	156	144	45	●
1588SL12C-1070	✲	10.7	12	204	156	144	45	○
1588SL12C-1080	✲	10.8	12	204	156	144	45	○
1588SL12C-1090	✲	10.9	12	204	156	144	45	○
1588SL12C-1100	✲	11	12	204	156	144	45	●
1588SL12C-1110	✲	11.1	12	204	156	144	45	●
1588SL12C-1120	✲	11.2	12	204	156	144	45	●
1588SL12C-1130	✲	11.3	12	204	156	144	45	○
1588SL12C-1140	✲	11.4	12	204	156	144	45	○
1588SL12C-1150	✲	11.5	12	204	156	144	45	●
1588SL12C-1160	✲	11.6	12	204	156	144	45	○
1588SL12C-1170	✲	11.7	12	204	156	144	45	●
1588SL12C-1180	✲	11.8	12	204	156	144	45	●
1588SL12C-1190	✲	11.9	12	204	156	144	45	○
1588SL12C-1200	✲	12	12	204	156	144	45	●
1588SL12C-1250	✲	12.5	14	230	182	168	45	○
1588SL12C-1270	✲	12.7	14	230	182	168	45	○
1588SL12C-1280	✲	12.8	14	230	182	168	45	○
1588SL12C-1300	✲	13	14	230	182	168	45	○
1588SL12C-1350	✲	13.5	14	230	182	168	45	○
1588SL12C-1400	✲	14	14	230	182	168	45	○
1588SL12C-1450	✲	14.5	16	260	208	194	48	○
1588SL12C-1500	✲	15	16	260	208	194	48	○
1588SL12C-1550	✲	15.5	16	260	208	194	48	○
1588SL12C-1600	✲	16	16	260	208	194	48	○
1588SL12C-1650	✲	16.5	18	286	234	218	48	○
1588SL12C-1700	✲	17	18	286	234	218	48	○
1588SL12C-1750	✲	17.5	18	286	234	218	48	○
1588SL12C-1800	✲	18	18	286	234	218	48	○

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

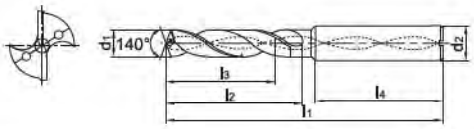
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SL(K) drill 12xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL12C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL12C-1850	✲	18.5	20	310	258	240	48	○
1588SL12C-1900	✲	19	20	310	258	240	48	○
1588SL12C-1950	✲	19.5	20	310	258	240	48	○
1588SL12C-2000	✲	20	20	310	258	240	48	○
1588SL12C-2050	✲	20.5	22	310	258	240	48	○
1588SL12C-2100	✲	21	22	310	258	240	48	○

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

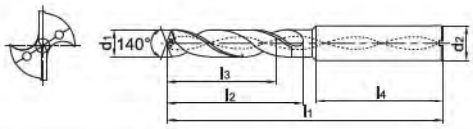
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SL(K) drill 15xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL15C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL15C-0300	✲	3	6	100	60	50	36	●
1588SL15C-0310	✲	3.1	6	105	65	55	36	●
1588SL15C-0320	✲	3.2	6	105	65	55	36	○
1588SL15C-0330	✲	3.3	6	105	65	55	36	●
1588SL15C-0340	✲	3.4	6	105	65	55	36	●
1588SL15C-0350	✲	3.5	6	105	65	55	36	●
1588SL15C-0360	✲	3.6	6	112	72	62	36	○
1588SL15C-0370	✲	3.7	6	112	72	68	36	●
1588SL15C-0380	✲	3.8	6	112	72	68	36	●
1588SL15C-0390	✲	3.9	6	112	72	68	36	○
1588SL15C-0400	✲	4	6	112	72	64	36	●
1588SL15C-0410	✲	4.1	6	120	80	72	36	○
1588SL15C-0420	✲	4.2	6	120	80	72	36	○
1588SL15C-0430	✲	4.3	6	120	80	72	36	○
1588SL15C-0440	✲	4.4	6	120	80	72	36	○
1588SL15C-0450	✲	4.5	6	120	80	72	36	●
1588SL15C-0460	✲	4.6	6	128	88	80	36	●
1588SL15C-0470	✲	4.7	6	128	88	80	36	○
1588SL15C-0480	✲	4.8	6	128	88	80	36	●
1588SL15C-0490	✲	4.9	6	128	88	80	36	●
1588SL15C-0500	✲	5	6	128	88	82	36	●
1588SL15C-0510	✲	5.1	6	136	96	90	36	●
1588SL15C-0520	✲	5.2	6	136	96	90	36	○
1588SL15C-0530	✲	5.3	6	136	96	90	36	●
1588SL15C-0540	✲	5.4	6	136	96	90	36	○
1588SL15C-0550	✲	5.5	6	136	96	90	36	○
1588SL15C-0560	✲	5.6	6	144	104	98	36	○
1588SL15C-0570	✲	5.7	6	144	104	98	36	○
1588SL15C-0580	✲	5.8	6	144	104	98	36	○
1588SL15C-0590	✲	5.9	6	144	104	98	36	○
1588SL15C-0600	✲	6	6	144	104	98	36	○
1588SL15C-0610	✲	6.1	8	152	112	103	36	●
1588SL15C-0620	✲	6.2	8	152	112	103	36	●
1588SL15C-0630	✲	6.3	8	152	112	103	36	○
1588SL15C-0640	✲	6.4	8	152	112	103	36	●

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

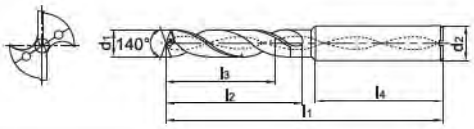
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SL(K) drill 15xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL15C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL15C-0650	✲	6.5	8	152	112	103	36	●
1588SL15C-0660	✲	6.6	8	160	120	111	36	○
1588SL15C-0670	✲	6.7	8	160	120	111	36	●
1588SL15C-0680	✲	6.8	8	160	120	111	36	○
1588SL15C-0690	✲	6.9	8	160	120	111	36	○
1588SL15C-0700	✲	7	8	160	120	111	36	●
1588SL15C-0710	✲	7.1	8	170	130	118	36	○
1588SL15C-0720	✲	7.2	8	170	130	118	36	○
1588SL15C-0730	✲	7.3	8	170	130	118	36	○
1588SL15C-0740	✲	7.4	8	170	130	118	36	○
1588SL15C-0750	✲	7.5	8	170	130	118	36	○
1588SL15C-0760	✲	7.6	8	180	140	128	36	○
1588SL15C-0770	✲	7.7	8	180	140	128	36	○
1588SL15C-0780	✲	7.8	8	180	140	128	36	○
1588SL15C-0790	✲	7.9	8	180	140	128	36	○
1588SL15C-0800	✲	8	8	180	140	128	36	●
1588SL15C-0810	✲	8.1	10	194	150	138	40	○
1588SL15C-0820	✲	8.2	10	194	150	138	40	○
1588SL15C-0830	✲	8.3	10	194	150	138	40	○
1588SL15C-0840	✲	8.4	10	194	150	138	40	○
1588SL15C-0850	✲	8.5	10	194	150	138	40	●
1588SL15C-0860	✲	8.6	10	204	160	148	40	●
1588SL15C-0870	✲	8.7	10	204	160	148	40	○
1588SL15C-0880	✲	8.8	10	204	160	148	40	●
1588SL15C-0890	✲	8.9	10	204	160	148	40	○
1588SL15C-0900	✲	9	10	204	160	148	40	○
1588SL15C-0910	✲	9.1	10	216	172	160	40	○
1588SL15C-0920	✲	9.2	10	216	172	160	40	○
1588SL15C-0930	✲	9.3	10	216	172	160	40	○
1588SL15C-0940	✲	9.4	10	216	172	160	40	○
1588SL15C-0950	✲	9.5	10	216	172	160	40	○
1588SL15C-0960	✲	9.6	10	226	182	170	40	○
1588SL15C-0970	✲	9.7	10	226	182	170	40	○
1588SL15C-0980	✲	9.8	10	226	182	170	40	○
1588SL15C-0990	✲	9.9	10	226	182	170	40	○

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

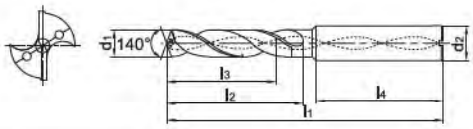
System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

SL(K) drill 15xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL15C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL15C-1000	✲	10	10	226	182	170	40	●
1588SL15C-1010	✲	10.1	12	240	190	178	45	○
1588SL15C-1020	✲	10.2	12	240	190	178	45	○
1588SL15C-1030	✲	10.3	12	240	190	178	45	○
1588SL15C-1040	✲	10.4	12	240	190	178	45	○
1588SL15C-1050	✲	10.5	12	240	190	178	45	○
1588SL15C-1060	✲	10.6	12	248	198	186	45	○
1588SL15C-1070	✲	10.7	12	248	198	186	45	○
1588SL15C-1080	✲	10.8	12	248	198	186	45	○
1588SL15C-1090	✲	10.9	12	248	198	186	45	○
1588SL15C-1100	✲	11	12	248	198	186	45	●
1588SL15C-1110	✲	11.1	12	262	212	200	45	○
1588SL15C-1120	✲	11.2	12	262	212	200	45	○
1588SL15C-1130	✲	11.3	12	262	212	200	45	○
1588SL15C-1140	✲	11.4	12	262	212	200	45	○
1588SL15C-1150	✲	11.5	12	262	212	200	45	●
1588SL15C-1160	✲	11.6	12	272	222	210	45	○
1588SL15C-1170	✲	11.7	12	272	222	210	45	○
1588SL15C-1180	✲	11.8	12	272	222	210	45	○
1588SL15C-1190	✲	11.9	12	272	222	210	45	○
1588SL15C-1200	✲	12	12	272	222	210	45	●

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

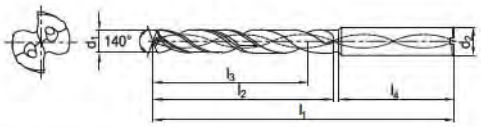
Solid carbide drills SL/SP series

SL(K) drill 20xD | General machining | Add K (SLK) to the code for use on Cast Iron

1588SL20C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL20C-0300	✲	3	6	110	70	62	36	●
1588SL20C-0310	✲	3.1	6	123	83	72	36	●
1588SL20C-0320	✲	3.2	6	123	83	72	36	●
1588SL20C-0330	✲	3.3	6	123	83	72	36	●
1588SL20C-0340	✲	3.4	6	123	83	72	36	●
1588SL20C-0350	✲	3.5	6	123	83	72	36	●
1588SL20C-0360	✲	3.6	6	136	96	84	36	●
1588SL20C-0370	✲	3.7	6	136	96	84	36	●
1588SL20C-0380	✲	3.8	6	136	96	84	36	●
1588SL20C-0390	✲	3.9	6	136	96	84	36	●
1588SL20C-0400	✲	4	6	136	96	84	36	●
1588SL20C-0410	✲	4.1	6	148	108	96	36	●
1588SL20C-0420	✲	4.2	6	148	108	96	36	●
1588SL20C-0430	✲	4.3	6	148	108	96	36	○
1588SL20C-0440	✲	4.4	6	148	108	96	36	○
1588SL20C-0450	✲	4.5	6	148	108	96	36	●
1588SL20C-0460	✲	4.6	6	158	118	106	36	○
1588SL20C-0470	✲	4.7	6	158	118	106	36	○
1588SL20C-0480	✲	4.8	6	158	118	106	36	●
1588SL20C-0490	✲	4.9	6	158	118	106	36	○
1588SL20C-0500	✲	5	6	158	118	106	36	●
1588SL20C-0510	✲	5.1	6	168	128	116	36	○
1588SL20C-0520	✲	5.2	6	168	128	116	36	●
1588SL20C-0530	✲	5.3	6	168	128	116	36	●
1588SL20C-0540	✲	5.4	6	168	128	116	36	●
1588SL20C-0550	✲	5.5	6	168	128	116	36	●
1588SL20C-0560	✲	5.6	6	180	140	126	36	○
1588SL20C-0570	✲	5.7	6	180	140	126	36	○
1588SL20C-0580	✲	5.8	6	180	140	126	36	●
1588SL20C-0590	✲	5.9	6	180	140	126	36	○
1588SL20C-0600	✲	6	6	180	140	126	36	●
1588SL20C-0610	✲	6.1	8	192	150	132	36	○
1588SL20C-0620	✲	6.2	8	192	150	132	36	○
1588SL20C-0630	✲	6.3	8	192	150	132	36	○
1588SL20C-0640	✲	6.4	8	192	150	132	36	○

● Ex stock ○ On demand
All articles SLK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

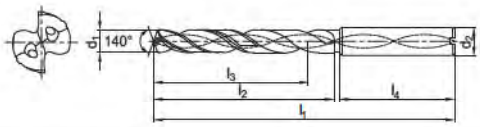
System code C28 | Machining instructions C165 | Cutting data C122 | Nonstandard order C178

SL(K) drill 20xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL20C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL20C-0650	✲	6.5	8	192	150	132	36	●
1588SL20C-0660	✲	6.6	8	202	162	144	36	○
1588SL20C-0670	✲	6.7	8	202	162	144	36	○
1588SL20C-0680	✲	6.8	8	202	162	144	36	●
1588SL20C-0690	✲	6.9	8	202	162	144	36	○
1588SL20C-0700	✲	7	8	202	162	144	36	●
1588SL20C-0710	✲	7.1	8	213	173	155	36	○
1588SL20C-0720	✲	7.2	8	213	173	155	36	○
1588SL20C-0730	✲	7.3	8	213	173	155	36	○
1588SL20C-0740	✲	7.4	8	213	173	155	36	○
1588SL20C-0750	✲	7.5	8	213	173	155	36	●
1588SL20C-0760	✲	7.6	8	223	183	165	36	○
1588SL20C-0770	✲	7.7	8	223	183	165	36	○
1588SL20C-0780	✲	7.8	8	223	183	165	36	○
1588SL20C-0790	✲	7.9	8	223	183	165	36	○
1588SL20C-0800	✲	8	8	223	183	165	36	●
1588SL20C-0810	✲	8.1	10	239	195	176	40	○
1588SL20C-0820	✲	8.2	10	239	195	176	40	○
1588SL20C-0830	✲	8.3	10	239	195	176	40	○
1588SL20C-0840	✲	8.4	10	239	195	176	40	○
1588SL20C-0850	✲	8.5	10	239	195	176	40	●
1588SL20C-0860	✲	8.6	10	249	205	186	40	○
1588SL20C-0870	✲	8.7	10	249	205	186	40	○
1588SL20C-0880	✲	8.8	10	249	205	186	40	○
1588SL20C-0890	✲	8.9	10	249	205	186	40	○
1588SL20C-0900	✲	9	10	249	205	186	40	○
1588SL20C-0910	✲	9.1	10	262	218	196	36	○
1588SL20C-0920	✲	9.2	10	262	218	196	36	○
1588SL20C-0930	✲	9.3	10	262	218	196	36	○
1588SL20C-0940	✲	9.4	10	262	218	196	36	○
1588SL20C-0950	✲	9.5	10	262	218	196	36	○
1588SL20C-0960	✲	9.6	10	272	228	206	40	○
1588SL20C-0970	✲	9.7	10	272	228	206	40	○
1588SL20C-0980	✲	9.8	10	272	228	206	40	○
1588SL20C-0990	✲	9.9	10	272	228	206	40	○

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

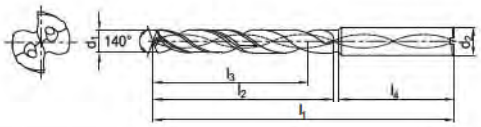
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SL(K) drill 20xD | General machining | Add K (SLK) to the code for use on Cast Iron

1588SL20C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL20C-1000	✲	10	10	272	228	206	40	●
1588SL20C-1010	✲	10.1	12	292	242	220	45	○
1588SL20C-1020	✲	10.2	12	292	242	220	45	○
1588SL20C-1030	✲	10.3	12	292	242	220	45	○
1588SL20C-1040	✲	10.4	12	292	242	220	45	○
1588SL20C-1050	✲	10.5	12	292	242	220	45	○
1588SL20C-1060	✲	10.6	12	300	250	228	45	○
1588SL20C-1070	✲	10.7	12	300	250	228	45	○
1588SL20C-1080	✲	10.8	12	300	250	228	45	○
1588SL20C-1090	✲	10.9	12	300	250	228	45	○
1588SL20C-1100	✲	11	12	300	250	228	45	○
1588SL20C-1110	✲	11.1	12	315	265	240	45	○
1588SL20C-1120	✲	11.2	12	315	265	240	45	○
1588SL20C-1130	✲	11.3	12	315	265	240	45	○
1588SL20C-1140	✲	11.4	12	315	265	240	45	○
1588SL20C-1150	✲	11.5	12	315	265	240	45	○
1588SL20C-1160	✲	11.6	12	325	275	250	45	○
1588SL20C-1170	✲	11.7	12	325	275	250	45	○
1588SL20C-1180	✲	11.8	12	325	275	250	45	○
1588SL20C-1190	✲	11.9	12	325	275	250	45	○
1588SL20C-1200	✲	12	12	325	275	250	45	○
1588SL20C-1250	✲	12.5	14	325	275	250	45	○
1588SL20C-1300	✲	13	14	338	290	265	45	○
1588SL20C-1350	✲	13.5	14	338	290	265	45	○
1588SL20C-1400	✲	14	14	367	318	290	45	○

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

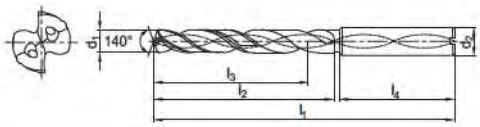
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SL(K) drill 30xD — General machining — Add K (SLK) to the code for use on Cast Iron

1588SL30C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL30C-0300	✲	3	6	140	100	92	36	●
1588SL30C-0310	✲	3.1	6	160	120	108	36	○
1588SL30C-0320	✲	3.2	6	160	120	108	36	●
1588SL30C-0330	✲	3.3	6	160	120	108	36	○
1588SL30C-0340	✲	3.4	6	160	120	108	36	●
1588SL30C-0350	✲	3.5	6	160	120	108	36	●
1588SL30C-0360	✲	3.6	6	176	136	124	36	○
1588SL30C-0370	✲	3.7	6	176	136	124	36	○
1588SL30C-0380	✲	3.8	6	176	136	124	36	●
1588SL30C-0390	✲	3.9	6	176	136	124	36	●
1588SL30C-0400	✲	4	6	176	136	124	36	●
1588SL30C-0410	✲	4.1	6	192	152	140	36	○
1588SL30C-0420	✲	4.2	6	192	152	140	36	○
1588SL30C-0430	✲	4.3	6	192	152	140	36	○
1588SL30C-0440	✲	4.4	6	192	152	140	36	○
1588SL30C-0450	✲	4.5	6	192	152	140	36	●
1588SL30C-0460	✲	4.6	6	208	168	156	36	○
1588SL30C-0470	✲	4.7	6	208	168	156	36	○
1588SL30C-0480	✲	4.8	6	208	168	156	36	●
1588SL30C-0490	✲	4.9	6	208	168	156	36	●
1588SL30C-0500	✲	5	6	208	168	156	36	●
1588SL30C-0510	✲	5.1	6	228	188	170	36	○
1588SL30C-0520	✲	5.2	6	228	188	170	36	●
1588SL30C-0530	✲	5.3	6	228	188	170	36	○
1588SL30C-0540	✲	5.4	6	228	188	170	36	○
1588SL30C-0550	✲	5.5	6	228	188	170	36	●
1588SL30C-0560	✲	5.6	6	240	200	182	36	○
1588SL30C-0570	✲	5.7	6	240	200	182	36	○
1588SL30C-0580	✲	5.8	6	240	200	182	36	●
1588SL30C-0590	✲	5.9	6	240	200	182	36	○
1588SL30C-0600	✲	6	6	240	200	182	36	●
1588SL30C-0610	✲	6.1	8	260	220	202	36	○
1588SL30C-0620	✲	6.2	8	260	220	202	36	○
1588SL30C-0630	✲	6.3	8	260	220	202	36	●
1588SL30C-0640	✲	6.4	8	260	220	202	36	○

● Ex stock ○ On demand

All articles SLK on demand

✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

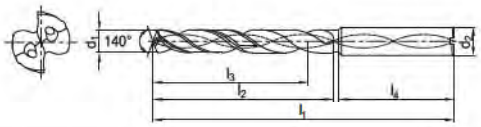
Solid carbide drills SL/SP series

SL(K) drill 30xD | General machining | Add K (SLK) to the code for use on Cast Iron

1588SL30C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1588SL30C-0650	✲	6.5	8	260	220	202	36	●
1588SL30C-0660	✲	6.6	8	272	232	214	36	○
1588SL30C-0670	✲	6.7	8	272	232	214	36	○
1588SL30C-0680	✲	6.8	8	272	232	214	36	●
1588SL30C-0690	✲	6.9	8	272	232	214	36	○
1588SL30C-0700	✲	7	8	272	232	214	36	●
1588SL30C-0710	✲	7.1	8	290	250	232	36	○
1588SL30C-0720	✲	7.2	8	290	250	232	36	○
1588SL30C-0730	✲	7.3	8	290	250	232	36	○
1588SL30C-0740	✲	7.4	8	290	250	232	36	○
1588SL30C-0750	✲	7.5	8	290	250	232	36	○
1588SL30C-0760	✲	7.6	8	305	265	246	36	○
1588SL30C-0770	✲	7.7	8	305	265	246	36	○
1588SL30C-0780	✲	7.8	8	305	265	246	36	○
1588SL30C-0790	✲	7.9	8	305	265	246	36	○
1588SL30C-0800	✲	8	8	305	265	246	36	●
1588SL30C-0810	✲	8.1	10	330	285	265	40	○
1588SL30C-0820	✲	8.2	10	330	285	265	40	○
1588SL30C-0830	✲	8.3	10	330	285	265	40	○
1588SL30C-0840	✲	8.4	10	330	285	265	40	○
1588SL30C-0850	✲	8.5	10	330	285	265	40	●
1588SL30C-0860	✲	8.6	10	340	295	275	40	○
1588SL30C-0870	✲	8.7	10	340	295	275	40	○
1588SL30C-0880	✲	8.8	10	340	295	275	40	○
1588SL30C-0890	✲	8.9	10	340	295	275	40	○
1588SL30C-0900	✲	9	10	340	295	275	40	○
1588SL30C-0910	✲	9.1	10	360	315	292	40	○
1588SL30C-0920	✲	9.2	10	360	315	292	40	○
1588SL30C-0930	✲	9.3	10	360	315	292	40	○
1588SL30C-0940	✲	9.4	10	360	315	292	40	○
1588SL30C-0950	✲	9.5	10	360	315	292	40	○
1588SL30C-0960	✲	9.6	10	372	328	305	40	○
1588SL30C-0970	✲	9.7	10	372	328	305	40	○
1588SL30C-0980	✲	9.8	10	372	328	305	40	○
1588SL30C-0990	✲	9.9	10	372	328	305	40	○
1588SL30C-1000	✲	10	10	372	328	305	40	○

● Ex stock ○ On demand
All articles SLK on demand
✲ With internal cooling

Application field

Type	P	M	K	N	S	H
1588SL*	✔	✔	✔	✔	✔	
1588SLK*			✔			

✔ Very suitable
✔ Suitable

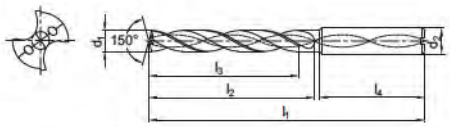
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SP drill 3xD — General machining

1534SP03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (h7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SP03C-0303	✻	3.03	6	62	20	14	36	●
1534SP03C-0313	✻	3.13	6	62	20	14	36	○
1534SP03C-0323	✻	3.23	6	62	20	14	36	○
1534SP03C-0333	✻	3.33	6	62	20	14	36	●
1534SP03C-0343	✻	3.43	6	62	20	14	36	●
1534SP03C-0353	✻	3.53	6	62	20	14	36	●
1534SP03C-0363	✻	3.63	6	62	20	14	36	○
1534SP03C-0373	✻	3.73	6	62	20	14	36	○
1534SP03C-0383	✻	3.83	6	66	24	17	36	○
1534SP03C-0393	✻	3.93	6	66	24	17	36	○
1534SP03C-0403	✻	4.03	6	66	24	17	36	●
1534SP03C-0413	✻	4.13	6	66	24	17	36	○
1534SP03C-0423	✻	4.23	6	66	24	17	36	○
1534SP03C-0433	✻	4.33	6	66	24	17	36	○
1534SP03C-0443	✻	4.43	6	66	24	17	36	○
1534SP03C-0453	✻	4.53	6	66	24	17	36	●
1534SP03C-0463	✻	4.63	6	66	24	17	36	○
1534SP03C-0473	✻	4.73	6	66	24	17	36	○
1534SP03C-0483	✻	4.83	6	66	28	20	36	○
1534SP03C-0493	✻	4.93	6	66	28	20	36	○
1534SP03C-0503	✻	5.03	6	66	28	20	36	●
1534SP03C-0513	✻	5.13	6	66	28	20	36	○
1534SP03C-0523	✻	5.23	6	66	28	20	36	○
1534SP03C-0533	✻	5.33	6	66	28	20	36	○
1534SP03C-0543	✻	5.43	6	66	28	20	36	○
1534SP03C-0553	✻	5.53	6	66	28	20	36	●
1534SP03C-0563	✻	5.63	6	66	28	20	36	○
1534SP03C-0573	✻	5.73	6	66	28	20	36	○
1534SP03C-0583	✻	5.83	6	66	28	20	36	○
1534SP03C-0593	✻	5.93	6	66	28	20	36	○
1534SP03C-0603	✻	6.03	6	66	28	20	36	●
1534SP03C-0613	✻	6.13	8	79	34	24	36	○
1534SP03C-0623	✻	6.23	8	79	34	24	36	○
1534SP03C-0633	✻	6.33	8	79	34	24	36	○
1534SP03C-0643	✻	6.43	8	79	34	24	36	○
1534SP03C-0653	✻	6.53	8	79	34	24	36	●
1534SP03C-0663	✻	6.63	8	79	34	24	36	○

● Ex stock ○ On demand

Pilot drill Ø = Deep drill Ø + 0,03 mm

✻ With internal cooling

Application field

P	M	K	N	S	H
✔	✔	✔	✔	✔	

✔ Very suitable
✔ Suitable

System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

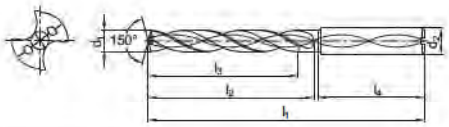
Solid carbide drills SL/SP series

SP drill 3xD General machining

1534SP03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (h7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SP03C-0673	✲	6.73	8	79	34	24	36	○
1534SP03C-0683	✲	6.83	8	79	34	24	36	○
1534SP03C-0693	✲	6.93	8	79	34	24	36	○
1534SP03C-0703	✲	7.03	8	79	34	24	36	●
1534SP03C-0713	✲	7.13	8	79	41	29	36	○
1534SP03C-0723	✲	7.23	8	79	41	29	36	○
1534SP03C-0733	✲	7.33	8	79	41	29	36	●
1534SP03C-0743	✲	7.43	8	79	41	29	36	○
1534SP03C-0753	✲	7.53	8	79	41	29	36	●
1534SP03C-0763	✲	7.63	8	79	41	29	36	○
1534SP03C-0773	✲	7.73	8	79	41	29	36	○
1534SP03C-0783	✲	7.83	8	79	41	29	36	○
1534SP03C-0793	✲	7.93	8	79	41	29	36	○
1534SP03C-0803	✲	8.03	8	79	41	29	36	●
1534SP03C-0813	✲	8.13	10	89	47	35	40	○
1534SP03C-0823	✲	8.23	10	89	47	35	40	○
1534SP03C-0833	✲	8.33	10	89	47	35	40	●
1534SP03C-0843	✲	8.43	10	89	47	35	40	○
1534SP03C-0853	✲	8.53	10	89	47	35	40	○
1534SP03C-0863	✲	8.63	10	89	47	35	40	○
1534SP03C-0873	✲	8.73	10	89	47	35	40	○
1534SP03C-0883	✲	8.83	10	89	47	35	40	●
1534SP03C-0893	✲	8.93	10	89	47	35	40	○
1534SP03C-0903	✲	9.03	10	89	47	35	40	●
1534SP03C-0913	✲	9.13	10	89	47	35	40	○
1534SP03C-0923	✲	9.23	10	89	47	35	40	○
1534SP03C-0933	✲	9.33	10	89	47	35	40	○
1534SP03C-0943	✲	9.43	10	89	47	35	40	○
1534SP03C-0953	✲	9.53	10	89	47	35	40	●
1534SP03C-0963	✲	9.63	10	89	47	35	40	○
1534SP03C-0973	✲	9.73	10	89	47	35	40	●
1534SP03C-0983	✲	9.83	10	89	47	35	40	●
1534SP03C-0993	✲	9.93	10	89	47	35	40	○
1534SP03C-1003	✲	10.03	10	89	47	35	40	●
1534SP03C-1013	✲	10.13	12	102	55	40	45	○
1534SP03C-1023	✲	10.23	12	102	55	40	45	○
1534SP03C-1033	✲	10.33	12	102	55	40	45	○

● Ex stock ○ On demand

Pilot drill Ø = Deep drill Ø + 0,03 mm

✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔	✔	✔	✔	

✔ Very suitable
✔ Suitable

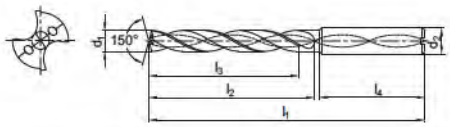
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SP drill 3xD — General machining

1534SP03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (h7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SP03C-1043	✻	10.43	12	102	55	40	45	○
1534SP03C-1053	✻	10.53	12	102	55	40	45	●
1534SP03C-1063	✻	10.63	12	102	55	40	45	○
1534SP03C-1073	✻	10.73	12	102	55	40	45	○
1534SP03C-1083	✻	10.83	12	102	55	40	45	●
1534SP03C-1093	✻	10.93	12	102	55	40	45	○
1534SP03C-1103	✻	11.03	12	102	55	40	45	●
1534SP03C-1113	✻	11.13	12	102	55	40	45	○
1534SP03C-1123	✻	11.23	12	102	55	40	45	○
1534SP03C-1133	✻	11.33	12	102	55	40	45	○
1534SP03C-1143	✻	11.43	12	102	55	40	45	○
1534SP03C-1153	✻	11.53	12	102	55	40	45	●
1534SP03C-1163	✻	11.63	12	102	55	40	45	○
1534SP03C-1173	✻	11.73	12	102	55	40	45	○
1534SP03C-1183	✻	11.83	12	102	55	40	45	●
1534SP03C-1193	✻	11.93	12	102	55	40	45	○
1534SP03C-1203	✻	12.03	12	102	55	40	45	●
1534SP03C-1213	✻	12.13	14	107	60	43	45	○
1534SP03C-1223	✻	12.23	14	107	60	43	45	○
1534SP03C-1233	✻	12.33	14	107	60	43	45	○
1534SP03C-1243	✻	12.43	14	107	60	43	45	○
1534SP03C-1253	✻	12.53	14	107	60	43	45	●
1534SP03C-1263	✻	12.63	14	107	60	43	45	○
1534SP03C-1273	✻	12.73	14	107	60	43	45	○
1534SP03C-1283	✻	12.83	14	107	60	43	45	○
1534SP03C-1293	✻	12.93	14	107	60	43	45	○
1534SP03C-1303	✻	13.03	14	107	60	43	45	○
1534SP03C-1353	✻	13.53	14	107	60	43	45	○
1534SP03C-1403	✻	14.03	14	107	60	43	45	○
1534SP03C-1453	✻	14.53	16	115	65	45	48	○
1534SP03C-1503	✻	15.03	16	115	65	45	48	○
1534SP03C-1553	✻	15.53	16	115	65	45	48	○
1534SP03C-1603	✻	16.03	16	115	65	45	48	○
1534SP03C-1653	✻	16.53	18	123	73	51	48	○
1534SP03C-1703	✻	17.03	18	123	73	51	48	○
1534SP03C-1753	✻	17.53	18	123	73	51	48	○
1534SP03C-1803	✻	18.03	18	123	73	51	48	○

● Ex stock ○ On demand

Pilot drill Ø = Deep drill Ø + 0,03 mm

✻ With internal cooling

Application field

P	M	K	N	S	H
✔	✔	✔	✔	✔	

✔ Very suitable
✔ Suitable

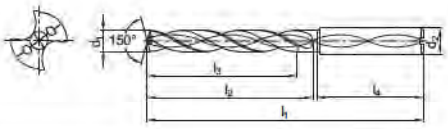
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SP drill 3xD — General machining

1534SP03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (h7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SP03C-1853	✲	18.53	20	131	79	55	50	○
1534SP03C-1903	✲	19.03	20	131	79	55	50	○
1534SP03C-1953	✲	19.53	20	131	79	55	50	○
1534SP03C-2003	✲	20.03	20	131	79	55	50	○

● Ex stock ○ On demand

Pilot drill Ø = Deep drill Ø + 0,03 mm

✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔	✔	✔	✔	

✔ Very suitable
✔ Suitable

System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

ST series

Twist drills with sharp cutting edge

- For machining of tough steel, stainless steel and heat-resistant alloys.
- Diameter range 3.0–20.0 mm (3xD, 5xD)

Straight cut

Chip comparison

Chip (competitor A)

1534ST03C-1000 chip (ZCC-CT)

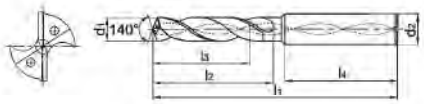
Solid carbide drills ST series

ST drill 3xD — Steel, stainless steel, heat-resistant alloys

1534ST03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534ST03C-0300	✲	3	6	62	20	14	36	●
1534ST03C-0310	✲	3.1	6	62	20	14	36	●
1534ST03C-0320	✲	3.2	6	62	20	14	36	●
1534ST03C-0325	✲	3.25	6	62	20	14	36	○
1534ST03C-0330	✲	3.3	6	62	20	14	36	●
1534ST03C-0340	✲	3.4	6	62	20	14	36	●
1534ST03C-0350	✲	3.5	6	62	20	14	36	●
1534ST03C-0360	✲	3.6	6	62	20	14	36	●
1534ST03C-0370	✲	3.7	6	62	20	14	36	●
1534ST03C-0380	✲	3.8	6	66	24	17	36	●
1534ST03C-0390	✲	3.9	6	66	24	17	36	●
1534ST03C-0400	✲	4	6	66	24	17	36	●
1534ST03C-0410	✲	4.1	6	66	24	17	36	●
1534ST03C-0420	✲	4.2	6	66	24	17	36	●
1534ST03C-0430	✲	4.3	6	66	24	17	36	●
1534ST03C-0440	✲	4.4	6	66	24	17	36	●
1534ST03C-0450	✲	4.5	6	66	24	17	36	●
1534ST03C-0460	✲	4.6	6	66	24	17	36	●
1534ST03C-0465	✲	4.65	6	66	24	17	36	○
1534ST03C-0470	✲	4.7	6	66	24	17	36	●
1534ST03C-0480	✲	4.8	6	66	28	20	36	●
1534ST03C-0490	✲	4.9	6	66	28	20	36	●
1534ST03C-0500	✲	5	6	66	28	20	36	●
1534ST03C-0510	✲	5.1	6	66	28	20	36	●
1534ST03C-0520	✲	5.2	6	66	28	20	36	●
1534ST03C-0530	✲	5.3	6	66	28	20	36	●
1534ST03C-0540	✲	5.4	6	66	28	20	36	●
1534ST03C-0550	✲	5.5	6	66	28	20	36	●
1534ST03C-0555	✲	5.55	6	66	28	20	36	○
1534ST03C-0560	✲	5.6	6	66	28	20	36	●
1534ST03C-0570	✲	5.7	6	66	28	20	36	●
1534ST03C-0580	✲	5.8	6	66	28	20	36	●
1534ST03C-0590	✲	5.9	6	66	28	20	36	●
1534ST03C-0600	✲	6	6	66	28	20	36	●
1534ST03C-0610	✲	6.1	8	79	34	24	36	○
1534ST03C-0620	✲	6.2	8	79	34	24	36	●
1534ST03C-0630	✲	6.3	8	79	34	24	36	●

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

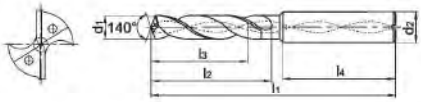
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

ST drill 3xD — Steel, stainless steel, heat-resistant alloys

1534ST03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534ST03C-0640	✲	6.4	8	79	34	24	36	●
1534ST03C-0650	✲	6.5	8	79	34	24	36	●
1534ST03C-0660	✲	6.6	8	79	34	24	36	●
1534ST03C-0670	✲	6.7	8	79	34	24	36	●
1534ST03C-0675	✲	6.75	8	79	34	24	36	○
1534ST03C-0690	✲	6.9	8	79	34	24	36	●
1534ST03C-0700	✲	7	8	79	34	24	36	●
1534ST03C-0710	✲	7.1	8	79	41	29	36	●
1534ST03C-0720	✲	7.2	8	79	41	29	36	●
1534ST03C-0730	✲	7.3	8	79	41	29	36	●
1534ST03C-0740	✲	7.4	8	79	41	29	36	●
1534ST03C-0750	✲	7.5	8	79	41	29	36	●
1534ST03C-0760	✲	7.6	8	79	41	29	36	●
1534ST03C-0770	✲	7.7	8	79	41	29	36	●
1534ST03C-0780	✲	7.8	8	79	41	29	36	●
1534ST03C-0790	✲	7.9	8	79	41	29	36	●
1534ST03C-0800	✲	8	8	79	41	29	36	●
1534ST03C-0810	✲	8.1	10	89	47	35	40	●
1534ST03C-0820	✲	8.2	10	89	47	35	40	●
1534ST03C-0830	✲	8.3	10	89	47	35	40	●
1534ST03C-0840	✲	8.4	10	89	47	35	40	●
1534ST03C-0850	✲	8.5	10	89	47	35	40	●
1534ST03C-0860	✲	8.6	10	89	47	35	40	●
1534ST03C-0870	✲	8.7	10	89	47	35	40	●
1534ST03C-0880	✲	8.8	10	89	47	35	40	●
1534ST03C-0890	✲	8.9	10	89	47	35	40	●
1534ST03C-0900	✲	9	10	89	47	35	40	○
1534ST03C-0910	✲	9.1	10	89	47	35	40	●
1534ST03C-0930	✲	9.3	10	89	47	35	40	●
1534ST03C-0940	✲	9.4	10	89	47	35	40	●
1534ST03C-0950	✲	9.5	10	89	47	35	40	●
1534ST03C-0960	✲	9.6	10	89	47	35	40	●
1534ST03C-0970	✲	9.7	10	89	47	35	40	●
1534ST03C-0980	✲	9.8	10	89	47	35	40	●
1534ST03C-0990	✲	9.9	10	89	47	35	40	●
1534ST03C-1000	✲	10	10	89	47	35	40	●
1534ST03C-1010	✲	10.1	12	102	55	40	45	●

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

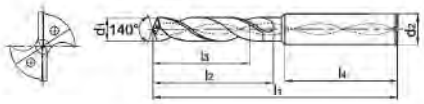
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

ST drill 3xD — Steel, stainless steel, heat-resistant alloys

1534ST03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534ST03C-1025	✲	10.25	12	102	55	40	45	●
1534ST03C-1030	✲	10.3	12	102	55	40	45	●
1534ST03C-1040	✲	10.4	12	102	55	40	45	●
1534ST03C-1050	✲	10.5	12	102	55	40	45	○
1534ST03C-1060	✲	10.6	12	102	55	40	45	●
1534ST03C-1070	✲	10.7	12	102	55	40	45	●
1534ST03C-1080	✲	10.8	12	102	55	40	45	●
1534ST03C-1090	✲	10.9	12	102	55	40	45	●
1534ST03C-1100	✲	11	12	102	55	40	45	●
1534ST03C-1110	✲	11.1	12	102	55	40	45	●
1534ST03C-1120	✲	11.2	12	102	55	40	45	●
1534ST03C-1130	✲	11.3	12	102	55	40	45	●
1534ST03C-1140	✲	11.4	12	102	55	40	45	●
1534ST03C-1150	✲	11.5	12	102	55	40	45	●
1534ST03C-1160	✲	11.6	12	102	55	40	45	●
1534ST03C-1170	✲	11.7	12	102	55	40	45	●
1534ST03C-1180	✲	11.8	12	102	55	40	45	●
1534ST03C-1190	✲	11.9	12	102	55	40	45	●
1534ST03C-1200	✲	12	12	102	55	40	45	●
1534ST03C-1225	✲	12.25	14	107	60	43	45	●
1534ST03C-1230	✲	12.3	14	107	60	43	45	●
1534ST03C-1250	✲	12.5	14	107	60	43	45	●
1534ST03C-1270	✲	12.7	14	107	60	43	45	●
1534ST03C-1275	✲	12.75	14	107	60	43	45	●
1534ST03C-1280	✲	12.8	14	107	60	43	45	●
1534ST03C-1300	✲	13	14	107	60	43	45	○
1534ST03C-1310	✲	13.1	14	107	60	43	45	●
1534ST03C-1350	✲	13.5	14	107	60	43	45	●
1534ST03C-1380	✲	13.8	14	107	60	43	45	●
1534ST03C-1400	✲	14	14	107	60	43	45	●
1534ST03C-1425	✲	14.25	16	115	65	45	48	●
1534ST03C-1430	✲	14.3	16	115	65	45	48	●
1534ST03C-1450	✲	14.5	16	115	65	45	48	●
1534ST03C-1475	✲	14.75	16	115	65	45	48	●
1534ST03C-1480	✲	14.8	16	115	65	45	48	●
1534ST03C-1500	✲	15	16	115	65	45	48	●
1534ST03C-1510	✲	15.1	16	115	65	45	48	●

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

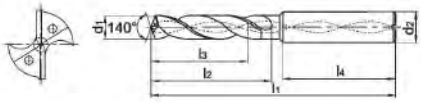
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

ST drill 3xD — Steel, stainless steel, heat-resistant alloys

1534ST03C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534ST03C-1550	✻	15.5	16	115	65	45	48	●
1534ST03C-1580	✻	15.8	16	115	65	45	48	●
1534ST03C-1600	✻	16	16	115	65	45	48	●
1534ST03C-1650	✻	16.5	18	123	73	51	48	●
1534ST03C-1675	✻	16.75	18	123	73	51	48	●
1534ST03C-1680	✻	16.8	18	123	73	51	48	●
1534ST03C-1700	✻	17	18	123	73	51	48	●
1534ST03C-1750	✻	17.5	18	123	73	51	48	●
1534ST03C-1780	✻	17.8	18	123	73	51	48	●
1534ST03C-1800	✻	18	18	123	73	51	48	●
1534ST03C-1850	✻	18.5	20	131	79	55	50	●
1534ST03C-1880	✻	18.8	20	131	79	55	50	●
1534ST03C-1900	✻	19	20	131	79	55	50	●
1534ST03C-1950	✻	19.5	20	131	79	55	50	●
1534ST03C-1980	✻	19.8	20	131	79	55	50	●
1534ST03C-2000	✻	20	20	131	79	55	50	●

● Ex stock ○ On demand
✻ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

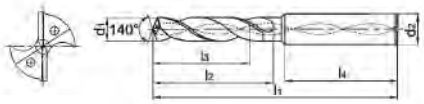
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

ST drill 5xD — Steel, stainless steel, heat-resistant alloys

1536ST05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536ST05C-0300	✲	3	6	66	28	23	36	●
1536ST05C-0310	✲	3.1	6	66	28	23	36	●
1536ST05C-0320	✲	3.2	6	66	28	23	36	●
1536ST05C-0325	✲	3.25	6	66	28	23	36	○
1536ST05C-0330	✲	3.3	6	66	28	23	36	●
1536ST05C-0340	✲	3.4	6	66	28	23	36	●
1536ST05C-0350	✲	3.5	6	66	28	23	36	●
1536ST05C-0360	✲	3.6	6	66	28	23	36	●
1536ST05C-0370	✲	3.7	6	66	28	23	36	●
1536ST05C-0380	✲	3.8	6	74	36	29	36	●
1536ST05C-0390	✲	3.9	6	74	36	29	36	●
1536ST05C-0400	✲	4	6	74	36	29	36	●
1536ST05C-0410	✲	4.1	6	74	36	29	36	●
1536ST05C-0420	✲	4.2	6	74	36	29	36	●
1536ST05C-0430	✲	4.3	6	74	36	29	36	●
1536ST05C-0440	✲	4.4	6	74	36	29	36	●
1536ST05C-0450	✲	4.5	6	74	36	29	36	●
1536ST05C-0460	✲	4.6	6	74	36	29	36	●
1536ST05C-0465	✲	4.65	6	74	36	29	36	○
1536ST05C-0470	✲	4.7	6	74	36	29	36	●
1536ST05C-0480	✲	4.8	6	82	44	35	36	●
1536ST05C-0490	✲	4.9	6	82	44	35	36	●
1536ST05C-0500	✲	5	6	82	44	35	36	●
1536ST05C-0510	✲	5.1	6	82	44	35	36	●
1536ST05C-0520	✲	5.2	6	82	44	35	36	●
1536ST05C-0530	✲	5.3	6	82	44	35	36	●
1536ST05C-0540	✲	5.4	6	82	44	35	36	●
1536ST05C-0550	✲	5.5	6	82	44	35	36	●
1536ST05C-0555	✲	5.55	6	82	44	35	36	○
1536ST05C-0560	✲	5.6	6	82	44	35	36	●
1536ST05C-0570	✲	5.7	6	82	44	35	36	●
1536ST05C-0580	✲	5.8	6	82	44	35	36	●
1536ST05C-0590	✲	5.9	6	82	44	35	36	●
1536ST05C-0600	✲	6	6	82	44	35	36	●
1536ST05C-0610	✲	6.1	8	91	53	43	36	●
1536ST05C-0620	✲	6.2	8	91	53	43	36	●
1536ST05C-0630	✲	6.3	8	91	53	43	36	●

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

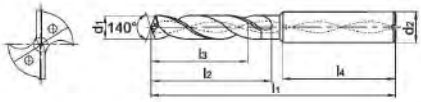
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

ST drill 5xD — Steel, stainless steel, heat-resistant alloys

1536ST05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536ST05C-0640	✲	6.4	8	91	53	43	36	●
1536ST05C-0650	✲	6.5	8	91	53	43	36	●
1536ST05C-0660	✲	6.6	8	91	53	43	36	●
1536ST05C-0670	✲	6.7	8	91	53	43	36	●
1536ST05C-0675	✲	6.75	8	91	53	43	36	○
1536ST05C-0680	✲	6.8	8	91	53	43	36	●
1536ST05C-0690	✲	6.9	8	91	53	43	36	●
1536ST05C-0700	✲	7	8	91	53	43	36	●
1536ST05C-0710	✲	7.1	8	91	53	43	36	●
1536ST05C-0720	✲	7.2	8	91	53	43	36	●
1536ST05C-0730	✲	7.3	8	91	53	43	36	●
1536ST05C-0740	✲	7.4	8	91	53	43	36	●
1536ST05C-0750	✲	7.5	8	91	53	43	36	●
1536ST05C-0760	✲	7.6	8	91	53	43	36	●
1536ST05C-0770	✲	7.7	8	91	53	43	36	●
1536ST05C-0780	✲	7.8	8	91	53	43	36	●
1536ST05C-0790	✲	7.9	8	91	53	43	36	●
1536ST05C-0800	✲	8	8	91	53	43	36	●
1536ST05C-0810	✲	8.1	10	103	61	49	40	●
1536ST05C-0820	✲	8.2	10	103	61	49	40	●
1536ST05C-0830	✲	8.3	10	103	61	49	40	●
1536ST05C-0840	✲	8.4	10	103	61	49	40	●
1536ST05C-0850	✲	8.5	10	103	61	49	40	●
1536ST05C-0860	✲	8.6	10	103	61	49	40	●
1536ST05C-0870	✲	8.7	10	103	61	49	40	●
1536ST05C-0880	✲	8.8	10	103	61	49	40	●
1536ST05C-0890	✲	8.9	10	103	61	49	40	●
1536ST05C-0900	✲	9	10	103	61	49	40	●
1536ST05C-0910	✲	9.1	10	103	61	49	40	●
1536ST05C-0920	✲	9.2	10	103	61	49	40	●
1536ST05C-0930	✲	9.3	10	103	61	49	40	●
1536ST05C-0940	✲	9.4	10	103	61	49	40	●
1536ST05C-0950	✲	9.5	10	103	61	49	40	●
1536ST05C-0960	✲	9.6	10	103	61	49	40	●
1536ST05C-0970	✲	9.7	10	103	61	49	40	●
1536ST05C-0980	✲	9.8	10	103	61	49	40	●
1536ST05C-0990	✲	9.9	10	103	61	49	40	●

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

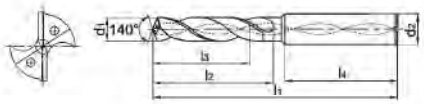
Solid carbide drills ST series

ST drill 5xD — Steel, stainless steel, heat-resistant alloys

1536ST05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536ST05C-1000	✲	10	10	103	61	49	40	●
1536ST05C-1010	✲	10.1	12	118	71	56	45	●
1536ST05C-1020	✲	10.2	12	118	71	56	45	●
1536ST05C-1025	✲	10.25	12	118	71	56	45	○
1536ST05C-1030	✲	10.3	12	118	71	56	45	●
1536ST05C-1040	✲	10.4	12	118	71	56	45	●
1536ST05C-1050	✲	10.5	12	118	71	56	45	●
1536ST05C-1060	✲	10.6	12	118	71	56	45	●
1536ST05C-1070	✲	10.7	12	118	71	56	45	●
1536ST05C-1080	✲	10.8	12	118	71	56	45	●
1536ST05C-1090	✲	10.9	12	118	71	56	45	●
1536ST05C-1100	✲	11	12	118	71	56	45	●
1536ST05C-1110	✲	11.1	12	118	71	56	45	●
1536ST05C-1120	✲	11.2	12	118	71	56	45	●
1536ST05C-1130	✲	11.3	12	118	71	56	45	●
1536ST05C-1140	✲	11.4	12	118	71	56	45	●
1536ST05C-1150	✲	11.5	12	118	71	56	45	●
1536ST05C-1160	✲	11.6	12	118	71	56	45	●
1536ST05C-1170	✲	11.7	12	118	71	56	45	●
1536ST05C-1180	✲	11.8	12	118	71	56	45	●
1536ST05C-1190	✲	11.9	12	118	71	56	45	●
1536ST05C-1200	✲	12	12	118	71	56	45	●
1536ST05C-1220	✲	12.2	14	124	77	60	45	●
1536ST05C-1225	✲	12.25	14	124	77	60	45	○
1536ST05C-1230	✲	12.3	14	124	77	60	45	●
1536ST05C-1250	✲	12.5	14	124	77	60	45	●
1536ST05C-1270	✲	12.7	14	124	77	60	45	●
1536ST05C-1275	✲	12.75	14	124	77	60	45	○
1536ST05C-1280	✲	12.8	14	124	77	60	45	●
1536ST05C-1300	✲	13	14	124	77	60	45	●
1536ST05C-1310	✲	13.1	14	124	77	60	45	●
1536ST05C-1350	✲	13.5	14	124	77	60	45	●
1536ST05C-1380	✲	13.8	14	124	77	60	45	●
1536ST05C-1400	✲	14	14	124	77	60	45	●
1536ST05C-1425	✲	14.25	16	133	83	63	48	○
1536ST05C-1430	✲	14.3	16	133	83	63	48	●
1536ST05C-1450	✲	14.5	16	133	83	63	48	●

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

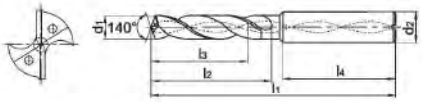
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

ST drill 5xD — Steel, stainless steel, heat-resistant alloys

1536ST05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1536ST05C-1475	✻	14.75	16	133	83	63	48	○
1536ST05C-1480	✻	14.8	16	133	83	63	48	●
1536ST05C-1500	✻	15	16	133	83	63	48	●
1536ST05C-1510	✻	15.1	16	133	83	63	48	●
1536ST05C-1550	✻	15.5	16	133	83	63	48	●
1536ST05C-1580	✻	15.8	16	133	83	63	48	●
1536ST05C-1600	✻	16	16	133	83	63	48	●
1536ST05C-1650	✻	16.5	18	143	93	71	48	●
1536ST05C-1675	✻	16.75	18	143	93	71	48	○
1536ST05C-1680	✻	16.8	18	143	93	71	48	●
1536ST05C-1700	✻	17	18	143	93	71	48	●
1536ST05C-1750	✻	17.5	18	143	93	71	48	●
1536ST05C-1780	✻	17.8	18	143	93	71	48	●
1536ST05C-1800	✻	18	18	143	93	71	48	●
1536ST05C-1850	✻	18.5	20	153	101	77	50	●
1536ST05C-1880	✻	18.8	20	153	101	77	50	●
1536ST05C-1900	✻	19	20	153	101	77	50	●
1536ST05C-1950	✻	19.5	20	153	101	77	50	●
1536ST05C-1980	✻	19.8	20	153	101	77	50	●
1536ST05C-2000	✻	20	20	153	101	77	50	●

● Ex stock ○ On demand
✻ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

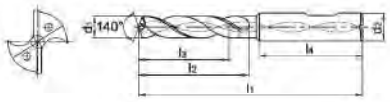
Solid carbide drills ST series

ST drill 5xD — Steel, stainless steel, heat-resistant alloys

1636ST05C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1636ST05C-0520	✲	5.2	6	82	44	35	36	○
1636ST05C-0730	✲	7.3	8	91	53	43	36	○
1636ST05C-0800	✲	8	8	91	53	43	36	○
1636ST05C-0810	✲	8.1	10	103	61	49	40	○
1636ST05C-0820	✲	8.2	10	103	61	49	40	○
1636ST05C-0830	✲	8.3	10	103	61	49	40	○
1636ST05C-0840	✲	8.4	10	103	61	49	40	○
1636ST05C-0850	✲	8.5	10	103	61	49	40	○
1636ST05C-0860	✲	8.6	10	103	61	49	40	○
1636ST05C-0870	✲	8.7	10	103	61	49	40	○
1636ST05C-0880	✲	8.8	10	103	61	49	40	○
1636ST05C-0890	✲	8.9	10	103	61	49	40	○
1636ST05C-0900	✲	9	10	103	61	49	40	○
1636ST05C-0910	✲	9.1	10	103	61	49	40	○
1636ST05C-0930	✲	9.3	10	103	61	49	40	○
1636ST05C-0940	✲	9.4	10	103	61	49	40	○
1636ST05C-0950	✲	9.5	10	103	61	49	40	○
1636ST05C-0960	✲	9.6	10	103	61	49	40	○
1636ST05C-0970	✲	9.7	10	103	61	49	40	○
1636ST05C-0980	✲	9.8	10	103	61	49	40	○
1636ST05C-0990	✲	9.9	10	103	61	49	40	○
1636ST05C-1000	✲	10	10	103	61	49	40	○
1636ST05C-1010	✲	10.1	12	118	71	56	45	○
1636ST05C-1025	✲	10.25	12	118	71	56	45	○
1636ST05C-1030	✲	10.3	12	118	71	56	45	○
1636ST05C-1040	✲	10.4	12	118	71	56	45	○
1636ST05C-1050	✲	10.5	12	118	71	56	45	○
1636ST05C-1060	✲	10.6	12	118	71	56	45	○
1636ST05C-1070	✲	10.7	12	118	71	56	45	○
1636ST05C-1080	✲	10.8	12	118	71	56	45	○
1636ST05C-1090	✲	10.9	12	118	71	56	45	○
1636ST05C-1100	✲	11	12	118	71	56	45	○
1636ST05C-1110	✲	11.1	12	118	71	56	45	○
1636ST05C-1120	✲	11.2	12	118	71	56	45	○
1636ST05C-1130	✲	11.3	12	118	71	56	45	○
1636ST05C-1140	✲	11.4	12	118	71	56	45	○
1636ST05C-1150	✲	11.5	12	118	71	56	45	○

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

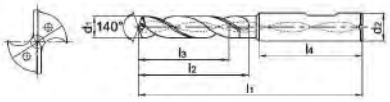
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

ST drill 5xD — Steel, stainless steel, heat-resistant alloys

1636ST05C

– Type of shank: DIN 6535HB
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1636ST05C-1160	✲	11.6	12	118	71	56	45	○
1636ST05C-1170	✲	11.7	12	118	71	56	45	○
1636ST05C-1180	✲	11.8	12	118	71	56	45	○
1636ST05C-1190	✲	11.9	12	118	71	56	45	○
1636ST05C-1200	✲	12	12	118	71	56	45	○
1636ST05C-1225	✲	12.25	14	124	77	60	45	○
1636ST05C-1230	✲	12.3	14	124	77	60	45	○
1636ST05C-1250	✲	12.5	14	124	77	60	45	○
1636ST05C-1270	✲	12.7	14	124	77	60	45	○
1636ST05C-1275	✲	12.75	14	124	77	60	45	○
1636ST05C-1280	✲	12.8	14	124	77	60	45	○
1636ST05C-1300	✲	13	14	124	77	60	45	○
1636ST05C-1310	✲	13.1	14	124	77	60	45	○
1636ST05C-1350	✲	13.5	14	124	77	60	45	○
1636ST05C-1380	✲	13.8	14	124	77	60	45	○
1636ST05C-1400	✲	14	14	124	77	60	45	○
1636ST05C-1425	✲	14.25	16	133	83	63	48	○
1636ST05C-1430	✲	14.3	16	133	83	63	48	○
1636ST05C-1450	✲	14.5	16	133	83	63	48	○
1636ST05C-1475	✲	14.75	16	133	83	63	48	○
1636ST05C-1480	✲	14.8	16	133	83	63	48	○
1636ST05C-1500	✲	15	16	133	83	63	48	○
1636ST05C-1510	✲	15.1	16	133	83	63	48	○
1636ST05C-1550	✲	15.5	16	133	83	63	48	○
1636ST05C-1580	✲	15.8	16	133	83	63	48	○
1636ST05C-1600	✲	16	16	133	83	63	48	○
1636ST05C-1650	✲	16.5	18	143	93	71	48	○
1636ST05C-1675	✲	16.75	18	143	93	71	48	○
1636ST05C-1680	✲	16.8	18	143	93	71	48	○
1636ST05C-1700	✲	17	18	143	93	71	48	●
1636ST05C-1750	✲	17.5	18	143	93	71	48	○
1636ST05C-1780	✲	17.8	18	143	93	71	48	○
1636ST05C-1800	✲	18	18	143	93	71	48	○
1636ST05C-1850	✲	18.5	20	153	101	77	50	○
1636ST05C-1880	✲	18.8	20	153	101	77	50	○
1636ST05C-1900	✲	19	20	153	101	77	50	○
1636ST05C-1950	✲	19.5	20	153	101	77	50	○
1636ST05C-1980	✲	19.8	20	153	101	77	50	○
1636ST05C-2000	✲	20	20	153	101	77	50	○

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔			✔	

✔ Very suitable
✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

Notes

SH series

Twist drills for hardened materials

- Specially designed chip geometry for very high stability.
- High performance coating for longer tool life.
- Diameter range 3.0–16.0 mm (3xD)

S cut

SC series

Twist drills for aluminium alloys

- Equal nominal diameter and shank diameter.
- Diameter meter 2.0–16.0 mm (3xD, 5xD)

Straight cut

PA series

Three-lips drills for aluminium alloys

- Three cutting edges provide high concentricity and therefore high feed rates.
- Equal nominal diameter and shank diameter.
- Diameter range 3.0–20.0 mm (3xD)

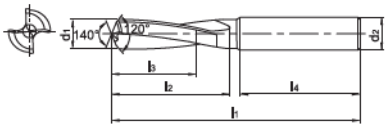
Straight cut

SH drill 3xD — Hard materials

1534SH03

– Type of shank DIN 6535HA

External coolant



Article	✻	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	KDG303
1534SH03-0300		3	6	62	20	14	36	○
1534SH03-0330		3.3	6	62	20	14	36	●
1534SH03-0400		4	6	66	24	17	36	○
1534SH03-0420		4.2	6	66	24	17	36	●
1534SH03-0500		5	6	66	28	20	36	○
1534SH03-0600		6	6	66	28	20	36	○
1534SH03-0675		6.75	8	79	34	24	36	○
1534SH03-0700		7	8	79	34	24	36	○
1534SH03-0800		8	8	79	41	29	36	○
1534SH03-0850		8.5	10	89	47	35	40	○
1534SH03-0900		9	10	89	47	35	40	○
1534SH03-1000		10	10	89	47	35	40	○
1534SH03-1025		10.25	12	102	55	40	45	○
1534SH03-1050		10.5	12	102	55	40	45	○
1534SH03-1200		12	12	102	55	40	45	○
1534SH03-1250		12.5	14	107	60	43	45	○
1534SH03-1400		14	14	107	60	43	45	○
1534SH03-1450		14.5	16	115	65	45	48	○
1534SH03-1600		16	16	115	65	45	48	○

● Ex stock ○ On demand

✻ With internal cooling

Application field

P	M	K	N	S	H
					✔

✔ Very suitable
✔ Suitable

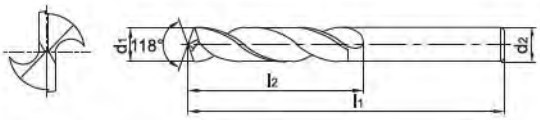
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SC drill 3xD — Non-ferrous metals

1105SC03

– Factory standard

External coolant



Article	✻	Dimensions [mm]				Grade
		d_1 (h8)	d_2 (h7)	l_1	l_2	YK20F
1105SC03-0200		2	2	38	12	○
1105SC03-0250		2.5	2.5	43	14	○
1105SC03-0280		2.8	2.8	46	16	○
1105SC03-0300		3	3	46	16	○
1105SC03-0310		3.1	3.1	49	18	○
1105SC03-0320		3.2	3.2	49	18	○
1105SC03-0330		3.3	3.3	49	18	○
1105SC03-0340		3.4	3.4	52	20	○
1105SC03-0350		3.5	3.5	52	20	○
1105SC03-0360		3.6	3.6	52	20	○
1105SC03-0370		3.7	3.7	52	20	○
1105SC03-0380		3.8	3.8	55	22	○
1105SC03-0390		3.9	3.9	55	22	○
1105SC03-0400		4	4	55	22	○
1105SC03-0410		4.1	4.1	55	22	○
1105SC03-0420		4.2	4.2	55	22	○
1105SC03-0430		4.3	4.3	58	24	○
1105SC03-0440		4.4	4.4	58	24	○
1105SC03-0450		4.5	4.5	58	24	○
1105SC03-0460		4.6	4.6	58	24	○
1105SC03-0470		4.7	4.7	58	24	○
1105SC03-0480		4.8	4.8	62	26	○
1105SC03-0490		4.9	4.9	62	26	○
1105SC03-0500		5	5	62	26	○
1105SC03-0510		5.1	5.1	62	26	○
1105SC03-0520		5.2	5.2	62	26	○
1105SC03-0530		5.3	5.3	62	26	○
1105SC03-0540		5.4	5.4	66	28	○
1105SC03-0550		5.5	5.5	66	28	○
1105SC03-0560		5.6	5.6	66	28	○
1105SC03-0570		5.7	5.7	66	28	○
1105SC03-0580		5.8	5.8	66	28	○
1105SC03-0590		5.9	5.9	66	28	○
1105SC03-0600		6	6	66	28	○
1105SC03-0610		6.1	6.1	70	31	○
1105SC03-0620		6.2	6.2	70	31	○
1105SC03-0630		6.3	6.3	70	31	○
1105SC03-0640		6.4	6.4	70	31	○

● Ex stock ○ On demand

✻ With internal cooling

Application field

P	M	K	N	S	H
			✔		

✔ Very suitable

✔ Suitable

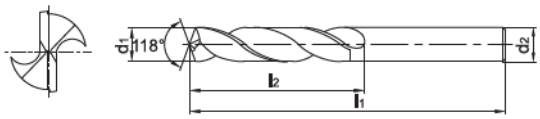
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

SC drill 3xD — Non-ferrous metals

1105SC03

– Factory standard

External coolant



Article	✻	Dimensions [mm]				Grade
		d_1 (h8)	d_2 (h7)	l_1	l_2	YK20F
1105SC03-0650		6.5	6.5	70	31	○
1105SC03-0660		6.6	6.6	70	31	○
1105SC03-0670		6.7	6.7	70	31	○
1105SC03-0680		6.8	6.8	74	34	○
1105SC03-0690		6.9	6.9	74	34	○
1105SC03-0700		7	7	74	34	○
1105SC03-0710		7.1	7.1	74	34	○
1105SC03-0720		7.2	7.2	74	34	○
1105SC03-0730		7.3	7.3	74	34	○
1105SC03-0740		7.4	7.4	74	34	○
1105SC03-0750		7.5	7.5	74	34	○
1105SC03-0760		7.6	7.6	79	37	○
1105SC03-0770		7.7	7.7	79	37	○
1105SC03-0780		7.8	7.8	79	37	○
1105SC03-0790		7.9	7.9	79	37	○
1105SC03-0800		8	8	79	37	○
1105SC03-0810		8.1	8.1	79	37	○
1105SC03-0820		8.2	8.2	79	37	○
1105SC03-0830		8.3	8.3	79	37	○
1105SC03-0840		8.4	8.4	79	37	○
1105SC03-0850		8.5	8.5	79	37	○
1105SC03-0860		8.6	8.6	84	40	○
1105SC03-0870		8.7	8.7	84	40	○
1105SC03-0880		8.8	8.8	84	40	○
1105SC03-0890		8.9	8.9	84	40	○
1105SC03-0900		9	9	84	40	○
1105SC03-0910		9.1	9.1	84	40	○
1105SC03-0920		9.2	9.2	84	40	○
1105SC03-0930		9.3	9.3	84	40	○
1105SC03-0940		9.4	9.4	84	40	○
1105SC03-0950		9.5	9.5	84	40	○
1105SC03-0960		9.6	9.6	89	43	○
1105SC03-0970		9.7	9.7	89	43	○
1105SC03-0980		9.8	9.8	89	43	○
1105SC03-0990		9.9	9.9	89	43	○
1105SC03-1000		10	10	89	43	○
1105SC03-1010		10.1	10.1	89	43	○
1105SC03-1020		10.2	10.2	89	43	○

● Ex stock ○ On demand

✻ With internal cooling

Application field

P	M	K	N	S	H
			✔		

✔ Very suitable
✔ Suitable

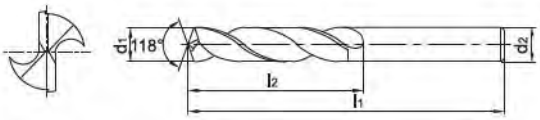
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SC drill 3xD — Non-ferrous metals

1105SC03

– Factory standard

External coolant



Article	✲	Dimensions [mm]				Grade
		d_1 (h8)	d_2 (h7)	l_1	l_2	YK20F
1105SC03-1040		10.4	10.4	89	43	○
1105SC03-1050		10.5	10.5	89	43	○
1105SC03-1070		10.7	10.7	95	47	○
1105SC03-1080		10.8	10.8	95	47	○
1105SC03-1100		11	11	95	47	○
1105SC03-1150		11.5	11.5	95	47	○
1105SC03-1200		12	12	102	51	○
1105SC03-1250		12.5	12.5	102	51	○
1105SC03-1280		12.8	12.8	102	51	○
1105SC03-1300		13	13	102	51	○
1105SC03-1310		13.1	13.1	102	51	○
1105SC03-1350		13.5	13.5	107	54	○
1105SC03-1400		14	14	107	54	○
1105SC03-1430		14.3	14.3	111	56	○
1105SC03-1450		14.5	14.5	111	56	○
1105SC03-1500		15	15	111	56	○
1105SC03-1600		16	16	115	58	○

● Ex stock ○ On demand

✲ With internal cooling

Application field

P	M	K	N	S	H
			✔		

✔ Very suitable

✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

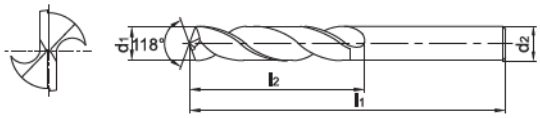
Solid carbide drills SC series

SC drill 5xD Non-ferrous metals

1101SC05

– Factory standard

External coolant



Article	✲	Dimensions [mm]				Grade
		d_1 (h8)	d_2 (h7)	l_1	l_2	YK20F
1101SC05-0200		2	2	49	24	○
1101SC05-0250		2.5	2.5	57	30	○
1101SC05-0280		2.8	2.8	61	33	○
1101SC05-0300		3	3	61	33	○
1101SC05-0350		3.5	3.5	70	39	○
1101SC05-0380		3.8	3.8	75	43	○
1101SC05-0400		4	4	75	43	○
1101SC05-0420		4.2	4.2	75	43	○
1101SC05-0450		4.5	4.5	80	47	○
1101SC05-0480		4.8	4.8	86	52	○
1101SC05-0500		5	5	86	52	○
1101SC05-0550		5.5	5.5	93	57	○
1101SC05-0580		5.8	5.8	93	57	○
1101SC05-0600		6	6	93	57	○
1101SC05-0650		6.5	6.5	101	63	○
1101SC05-0680		6.8	6.8	109	69	○
1101SC05-0700		7	7	109	69	○
1101SC05-0750		7.5	7.5	109	69	○
1101SC05-0780		7.8	7.8	117	75	○
1101SC05-0800		8	8	117	75	○
1101SC05-0850		8.5	8.5	117	75	○
1101SC05-0880		8.8	8.8	125	81	○
1101SC05-0900		9	9	125	81	○
1101SC05-0950		9.5	9.5	125	81	○
1101SC05-0980		9.8	9.8	133	87	○
1101SC05-1000		10	10	133	87	○
1101SC05-1050		10.5	10.5	133	87	○
1101SC05-1080		10.8	10.8	142	94	○
1101SC05-1100		11	11	142	94	○
1101SC05-1150		11.5	11.5	142	94	○
1101SC05-1200		12	12	151	101	○
1101SC05-1250		12.5	12.5	151	101	○
1101SC05-1300		13	13	151	101	○
1101SC05-1350		13.5	13.5	160	108	○
1101SC05-1400		14	14	160	108	○
1101SC05-1450		14.5	14.5	169	114	○
1101SC05-1500		15	15	169	114	○
1101SC05-1550		15.5	15.5	178	120	○
1101SC05-1600		16	16	178	120	○

● Ex stock ○ On demand

✲ With internal cooling

Application field

P	M	K	N	S	H
			✔		

✔ Very suitable
✔ Suitable

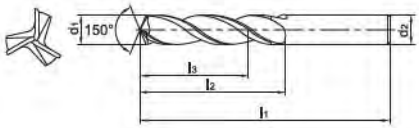
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

PA drill 3xD — Non-ferrous metals

1165PA03

– Factory standard

External coolant



Article	✻	Dimensions [mm]					Grade	
		d_1 (h7)	d_2 (h7)	l_1	l_2	l_3	KDG303	YK30F
1165PA03-0300		3	3	46	16	12	●	●
1165PA03-0310		3.1	3.1	49	18	14	○	○
1165PA03-0320		3.2	3.2	49	18	14	○	●
1165PA03-0330		3.3	3.3	49	18	14	○	○
1165PA03-0340		3.4	3.4	52	20	15	○	●
1165PA03-0350		3.5	3.5	52	20	15	○	○
1165PA03-0360		3.6	3.6	52	20	15	○	○
1165PA03-0370		3.7	3.7	52	20	15	○	○
1165PA03-0380		3.8	3.8	55	22	17	○	○
1165PA03-0390		3.9	3.9	55	22	17	○	○
1165PA03-0400		4	4	55	22	17	○	○
1165PA03-0410		4.1	4.1	55	22	17	○	○
1165PA03-0420		4.2	4.2	55	22	17	○	○
1165PA03-0430		4.3	4.3	58	24	18	○	○
1165PA03-0440		4.4	4.4	58	24	18	○	○
1165PA03-0450		4.5	4.5	58	24	18	○	○
1165PA03-0460		4.6	4.6	58	24	18	○	○
1165PA03-0470		4.7	4.7	58	24	18	○	○
1165PA03-0480		4.8	4.8	62	26	20	○	○
1165PA03-0490		4.9	4.9	62	26	20	○	○
1165PA03-0500		5	5	62	26	20	○	○
1165PA03-0510		5.1	5.1	62	26	20	○	○
1165PA03-0520		5.2	5.2	62	26	20	○	○
1165PA03-0530		5.3	5.3	62	26	20	○	○
1165PA03-0540		5.4	5.4	66	28	21	○	○
1165PA03-0550		5.5	5.5	66	28	21	○	○
1165PA03-0560		5.6	5.6	66	28	21	○	○
1165PA03-0570		5.7	5.7	66	28	21	○	○
1165PA03-0580		5.8	5.8	66	28	21	○	○
1165PA03-0590		5.9	5.9	66	28	21	○	○
1165PA03-0600		6	6	66	28	21	○	○
1165PA03-0610		6.1	6.1	70	31	23	○	○
1165PA03-0620		6.2	6.2	70	31	23	○	○
1165PA03-0630		6.3	6.3	70	31	23	○	○
1165PA03-0640		6.4	6.4	70	31	23	○	○
1165PA03-0650		6.5	6.5	70	31	23	○	○
1165PA03-0660		6.6	6.6	70	31	23	○	●
1165PA03-0670		6.7	6.7	70	31	23	○	●

● Ex stock ○ On demand

✻ With internal cooling

Application field

P	M	K	N	S	H
			✔		

✔ Very suitable

✔ Suitable

System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

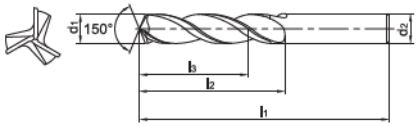
Solid carbide drills PA series

PA drill 3xD Non-ferrous metals

1165PA03

– Factory standard

External coolant



Article	✲	Dimensions [mm]					Grade	
		d_1 (h7)	d_2 (h7)	l_1	l_2	l_3	KDG303	YK30F
1165PA03-0680		6.8	6.8	74	34	25	○	○
1165PA03-0690		6.9	6.9	74	34	25	○	○
1165PA03-0700		7	7	74	34	25	○	○
1165PA03-0710		7.1	7.1	74	34	25	○	○
1165PA03-0720		7.2	7.2	74	34	25	○	○
1165PA03-0730		7.3	7.3	74	34	25	○	○
1165PA03-0740		7.4	7.4	74	34	25	○	○
1165PA03-0750		7.5	7.5	74	34	25	○	○
1165PA03-0760		7.6	7.6	79	37	27	○	○
1165PA03-0770		7.7	7.7	79	37	27	○	○
1165PA03-0780		7.8	7.8	79	37	27	○	○
1165PA03-0790		7.9	7.9	79	37	27	○	○
1165PA03-0800		8	8	79	37	27	○	○
1165PA03-0810		8.1	8.1	79	37	27	○	○
1165PA03-0820		8.2	8.2	79	37	27	○	○
1165PA03-0830		8.3	8.3	79	37	27	○	○
1165PA03-0840		8.4	8.4	79	37	27	○	○
1165PA03-0850		8.5	8.5	79	37	27	○	○
1165PA03-0860		8.6	8.6	84	40	29	○	●
1165PA03-0870		8.7	8.7	84	40	29	○	○
1165PA03-0880		8.8	8.8	84	40	29	○	○
1165PA03-0890		8.9	8.9	84	40	29	○	○
1165PA03-0900		9	9	84	40	29	○	○
1165PA03-0910		9.1	9.1	84	40	29	○	○
1165PA03-0920		9.2	9.2	84	40	29	○	○
1165PA03-0930		9.3	9.3	84	40	29	○	○
1165PA03-0940		9.4	9.4	84	40	29	○	○
1165PA03-0950		9.5	9.5	84	40	29	○	○
1165PA03-0960		9.6	9.6	89	43	31	○	○
1165PA03-0970		9.7	9.7	89	43	31	○	○
1165PA03-0980		9.8	9.8	89	43	31	○	○
1165PA03-0990		9.9	9.9	89	43	31	○	○
1165PA03-1000		10	10	89	43	31	○	○
1165PA03-1010		10.1	10.1	89	43	31	○	○
1165PA03-1020		10.2	10.2	89	43	31	○	○
1165PA03-1030		10.3	10.3	89	43	31	○	○
1165PA03-1050		10.5	10.5	89	43	31	○	○
1165PA03-1100		11	11	95	47	33	○	○

● Ex stock ○ On demand

✲ With internal cooling

Application field

P	M	K	N	S	H
			✔		

✔ Very suitable
✔ Suitable

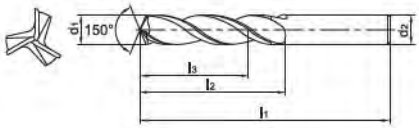
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

PA drill 3xD — Non-ferrous metals

1165PA03

– Factory standard

External coolant



Article	✲	Dimensions [mm]					Grade	
		d_1 (h7)	d_2 (h7)	l_1	l_2	l_3	KDG303	YK30F
1165PA03-1120		11.2	11.2	95	47	33	○	○
1165PA03-1150		11.5	11.5	95	47	33	○	○
1165PA03-1180		11.8	11.8	95	47	33	○	○
1165PA03-1200		12	12	102	51	35	○	○
1165PA03-1210		12.1	12.1	102	51	35	○	○
1165PA03-1250		12.5	12.5	102	51	35	○	○
1165PA03-1300		13	13	102	51	35	○	○
1165PA03-1350		13.5	13.5	107	54	37	○	○
1165PA03-1400		14	14	107	54	37	○	○
1165PA03-1450		14.5	14.5	111	56	38	○	○
1165PA03-1500		15	15	111	56	38	○	○
1165PA03-1550		15.5	15.5	115	58	38	○	○
1165PA03-1600		16	16	115	58	38	○	○
1165PA03-1650		16.5	16.5	119	60	39	○	○
1165PA03-1700		17	17	119	60	39	○	○
1165PA03-1750		17.5	17.5	123	62	40	○	○
1165PA03-1800		18	18	123	62	40	○	○
1165PA03-1850		18.5	18.5	127	64	41	○	○
1165PA03-1900		19	19	127	64	41	○	○
1165PA03-1950		19.5	19.5	131	66	42	○	○
1165PA03-2000		20	20	131	66	42	○	○

● Ex stock ○ On demand

✲ With internal cooling

Application field

P	M	K	N	S	H
			✔		

✔ Very suitable

✔ Suitable

System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

Notes

PC series

Straight flute drill for cast iron

- High precision (hole quality up to H7) and good surface quality on the complete bore length.
- Diameter range 4.0–20.0 mm (5xD, 15xD)

Straight cut

SC series

NC tapping device for steel, stainless steel, cast iron and non-ferrous metals

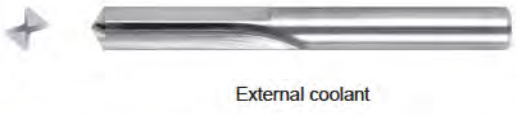
- For centring and chamfering.
- With 90° and 120° point angle.
- Diameter range 5.0–20.0 mm

Solid carbide drills PC series

PC drill 5xD Cast iron

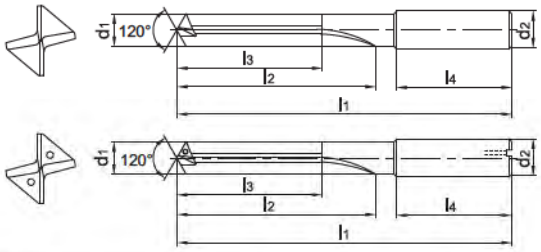
1576PC05/1576PC05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric



External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	YK20F
1576PC05-0400		4	6	74	36	29	36	○
1576PC05C-0400	✲	4	6	74	36	29	36	●
1576PC05-0420		4.2	6	74	36	29	36	○
1576PC05C-0420	✲	4.2	6	74	36	29	36	●
1576PC05-0500		5	6	82	44	35	36	○
1576PC05C-0500	✲	5	6	82	44	35	36	●
1576PC05-0600		6	6	82	44	35	36	○
1576PC05C-0600	✲	6	6	82	44	35	36	●
1576PC05-0675		6.75	8	91	53	43	36	○
1576PC05C-0675	✲	6.75	8	91	53	43	36	●
1576PC05-0700		7	8	91	53	43	36	○
1576PC05C-0700	✲	7	8	91	53	43	36	●
1576PC05-0800		8	8	91	53	43	36	○
1576PC05C-0800	✲	8	8	91	53	43	36	●
1576PC05-0850		8.5	10	103	61	49	40	○
1576PC05C-0850	✲	8.5	10	103	61	49	40	●
1576PC05-0900		9	10	103	61	49	40	○
1576PC05C-0900	✲	9	10	103	61	49	40	●
1576PC05-1000		10	10	103	61	49	40	○
1576PC05C-1000	✲	10	10	103	61	49	40	●
1576PC05-1025		10.25	12	118	71	56	45	○
1576PC05C-1025	✲	10.25	12	118	71	56	45	●
1576PC05-1100		11	12	118	71	56	45	○
1576PC05C-1100	✲	11	12	118	71	56	45	●
1576PC05-1200		12	12	118	71	56	45	○
1576PC05C-1200	✲	12	12	118	71	56	45	●
1576PC05-1300		13	14	124	77	60	45	○
1576PC05C-1300	✲	13	14	124	77	60	45	●
1576PC05-1400		14	14	124	77	60	45	○
1576PC05C-1400	✲	14	14	124	77	60	45	●
1576PC05-1500		15	16	133	83	63	48	○
1576PC05C-1500	✲	15	16	133	83	63	48	○
1576PC05-1550		15.5	16	133	83	63	48	○

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
		✔			

✔ Very suitable
✔ Suitable

System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

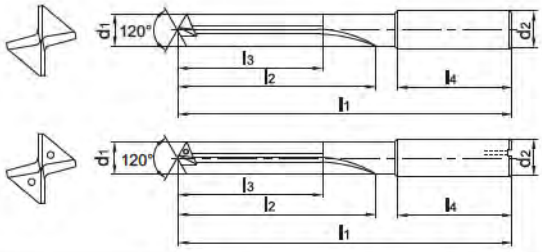
PC drill 5xD — Cast iron

1576PC05/1576PC05C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

External coolant

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	YK20F
1576PC05C-1550	✲	15.5	16	133	83	63	48	○
1576PC05-1600		16	16	133	83	63	48	○
1576PC05C-1600	✲	16	16	133	83	63	48	○
1576PC05-1700		17	18	143	93	71	48	○
1576PC05C-1700	✲	17	18	143	93	71	48	○
1576PC05-1750		17.5	18	143	93	71	48	○
1576PC05C-1750	✲	17.5	18	143	93	71	48	○
1576PC05-1800		18	18	143	93	71	48	○
1576PC05C-1800	✲	18	18	143	93	71	48	●
1576PC05-1950		19.5	20	153	101	77	50	○
1576PC05C-1950	✲	19.5	20	153	101	77	50	○
1576PC05-2000		20	20	153	101	77	50	○
1576PC05C-2000	✲	20	20	153	101	77	50	○

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
		✔			

✔ Very suitable
✔ Suitable

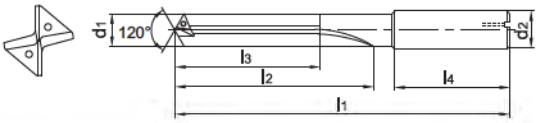
System code > C28 | Machining instructions > C165 | Cutting data > C122 | Nonstandard order > C178

PC drill 15xD — Cast iron

1579PC15C

– Type of shank DIN 6535HA
– Coolant exit, axial concentric

Internal coolant



Article	✲	Dimensions [mm]						Grade
		d_1 (m7)	d_2 (h6)	l_1	l_2	l_3	l_4	YK20F
1579PC15C-0500	✲	5	6	145	105	96	36	○
1579PC15C-0600	✲	6	6	145	105	96	36	○
1579PC15C-0800	✲	8	8	180	137	127	36	○
1579PC15C-0900	✲	9	10	217	170	158	40	○
1579PC15C-1000	✲	10	10	217	170	158	40	○
1579PC15C-1100	✲	11	12	258	205	190	45	○
1579PC15C-1200	✲	12	12	258	205	190	45	○
1579PC15C-1400	✲	14	14	290	236	219	45	○

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
		✔			

✔ Very suitable
✔ Suitable

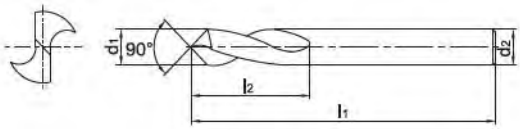
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SC drill – NC tapping device 90° General machining

1143SC90

– Factory standard

External coolant



Article	✻	Dimensions [mm]				Grade	
		d_1 (h6)	d_2 (h6)	l_1	l_2	KDG303	YK30F
1143SC90-0500		5	5	62	10	●	
1143SC90-0600		6	6	66	15	●	
1143SC90-0800		8	8	79	17	●	
1143SC90-1000		10	10	89	20	●	
1143SC90-1200		12	12	102	25	●	
1143SC90-1400		14	14	107	30	●	
1143SC90-1600		16	16	115	35	●	
1143SC90-2000		20	20	131	40	●	○

● Ex stock ○ On demand

✻ With internal cooling

Application field

P	M	K	N	S	H
✔	✔	✔	✔		

✔ Very suitable

✔ Suitable

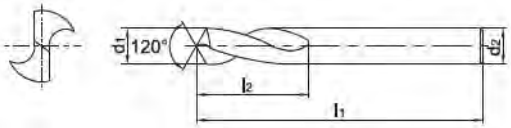
System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

SC drill – NC tapping device 120° General machining

1143SC120

– Factory standard

External coolant



Article	✲	Dimensions [mm]				Grade
		d_1 (h6)	d_2 (h6)	l_1	l_2	KDG303
1143SC120-0500		5	5	62	10	●
1143SC120-0600		6	6	66	15	●
1143SC120-0800		8	8	79	17	●
1143SC120-1000		10	10	89	20	●
1143SC120-1200		12	12	102	25	●
1143SC120-1400		14	14	107	30	●
1143SC120-1600		16	16	115	35	●
1143SC120-2000		20	20	131	42	●

● Ex stock ○ On demand

✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔	✔	✔		

✔ Very suitable
✔ Suitable

System code > C28 Machining instructions > C165 Cutting data > C122 Nonstandard order > C178

Notes

Guide for recommended cutting data – solid carbide drilling

Solid carbide drills

Material group		Composition / structure / heat treatment		Strength / hardness HB	Machining group	Starting values for cutting speed v_c [m/min] SU Series 3-5xD KDG 303 Coolant			SU-Drill 8xD KDG 303 Coolant			SU Step Drill 3xD KDG 303 Coolant		
						internal	external	f-group	internal	external	f-group	internal	external	f-group
P	Unalloyed steel	ca. 0,15 % C	annealed	125	1	150	135	8	135	125	7	150	135	8
		ca. 0,45 % C	annealed	190	2	130	120	8	120	110	7	130	120	8
		ca. 0,45 % C	tempered	250	3	120	110	6	110	100	5	120	110	6
		ca. 0,75 % C	annealed	270	4	110	100	6	100	90	5	110	100	6
		ca. 0,75 % C	tempered	300	5	100	90	6	90	85	5	100	90	6
	Low-alloyed steel		annealed	180	6	130	120	8	120	110	7	130	120	8
			tempered	275	7	110	100	6	100	90	5	110	100	6
			tempered	300	8	100	90	6	90	85	5	100	90	6
			tempered	350	9	90	85	6	85	80	5	90	85	6
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	120	110	8	110	100	7	120	110	8
			hardened and tempered	325	11	100	90	6	90	85	5	100	90	6
M	Stainless steel	ferritic/martensitic	annealed	200	12	80	75	5	75	70	5	80	75	5
		martensitic	tempered	240	13	55	50	5	50	45	5	55	50	5
		austenitic	quench hardened	180	14	60	55	5	55	50	5	60	55	5
		austenitic-ferritic		230	15	50	45	5	45	45	5	50	45	5
K	Grey cast iron	perlitic/ferritic		180	16	135	125	8	125	115	7	135	125	8
		perlitic (martensitic)		260	17	110	100	8	100	90	7	110	100	8
	Cast iron with spheroidal graphite	ferritic		160	18	120	110	8	110	100	7	120	110	8
		perlitic		250	19	80	75	8	75	70	7	80	75	8
	Malleable cast iron	ferritic		130	20	130	120	8	120	110	7	130	120	8
		perlitic		230	21	80	75	8	75	70	7	80	75	8
N	Aluminium wrought alloys	cannot be hardened		60	22									
		hardenable	hardened	100	23									
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24									
		≤ 12% Si, hardenable	hardened	90	25									
		> 12% Si, cannot be hardened		130	26									
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27									
		CuZn, CuSnZn		90	28									
		CuSn, Pb-free copper, electrolytic copper		100	29									
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30									
			hardened	280	31									
		Ni or Co bass	annealed	250	32									
			hardened	350	33									
			cast	320	34									
	Titanium alloys	pure titanium		R_m 400	35									
		α and β alloys	hardened	R_m 1050	36									
H	Hardened steel		hardened and tempered	55 HRC	37									
			hardened and tempered	60 HRC	38									
	Hard cast iron		cast	400	39									
	Hardened cast iron		hardened and tempered	55 HRC	40									
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
With hole depths of 5xD adjust the cutting data accordingly to the application.
f-group = feed rate recommendations on page C126.
For examples of material for cutting tool groups view page D22.

Recommend feed rate

Solid carbide drilling

4

5

F-group	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10
2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,09	0,10	0,10	0,10	0,11	0,11	0,11
3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15	0,15
5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

1. Select the appropriate product series.
2. Determine the immersion.
3. Select the used material and read the cutting speed.
4. Determine the feed rate group and have a look at the appropriate feed rate recommendations.
5. Select the diameter of tool and determine the immersion.

Solid carbide drills

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
						SU Series			SU-Drill			SU Step Drill		
						3-5xD			8xD			3xD		
						KDG 303			KDG 303			KDG 303		
						Coolant								
						Int.	Ext.	f-group	Int.	Ext.	f-group	Int.	Ext.	f-group
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1	150	135	8	135	125	7	150	135	8
		approx. 0,45 % C	annealed	190	2	130	120	8	120	110	7	130	120	8
		approx. 0,45 % C	tempered	250	3	120	110	6	110	100	5	120	110	6
		approx. 0,75 % C	annealed	270	4	110	100	6	100	90	5	110	100	6
		approx. 0,75 % C	tempered	300	5	100	90	6	90	85	5	100	90	6
	Low-alloyed steel		annealed	180	6	130	120	8	120	110	7	130	120	8
			tempered	275	7	110	100	6	100	90	5	110	100	6
			tempered	300	8	100	90	6	90	85	5	100	90	6
			tempered	350	9	90	85	6	85	80	5	90	85	6
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	120	110	8	110	100	7	120	110	8
			hardened and tempered	325	11	100	90	6	90	85	5	100	90	6
M	Stainless steel	ferritic/martensitic	annealed	200	12	80	75	5	75	70	5	80	75	5
		martensitic	tempered	240	13	55	50	5	50	45	5	55	50	5
		austenitic	quench hardened	180	14	60	55	5	55	50	5	60	55	5
		austenitic-ferritic		230	15	50	45	5	45	45	5	50	45	5
K	Grey cast iron	perlitic/ferritic		180	16	135	125	8	125	115	7	135	125	8
		perlitic (martensitic)		260	17	110	100	8	100	90	7	110	100	8
	Cast iron with spheroidal graphite	ferritic		160	18	120	110	8	110	100	7	120	110	8
		perlitic		250	19	80	75	8	75	70	7	80	75	8
	Malleable cast iron	ferritic		130	20	130	120	8	120	110	7	130	120	8
		perlitic		230	21	80	75	8	75	70	7	80	75	8
N	Aluminium wrought alloys	cannot be hardened		60	22									
		hardenable	hardened	100	23									
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24									
		≤ 12 % Si, hardenable	hardened	90	25									
		> 12 % Si, cannot be hardened		130	26									
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27									
		CuZn, CuSnZn		90	28									
		CuSn, Pb-free copper, electrolytic copper		100	29									
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30									
			hardened	280	31									
		Ni or Co bass	annealed	250	32									
			hardened	350	33									
			cast	320	34									
	Titanium alloys	pure titanium		R_m 400	35									
		α and β alloys	hardened	R_m 1050	36									
H	Hardened steel		hardened and tempered	55 HRC	37									
			hardened and tempered	60 HRC	38									
	Hard cast iron		cast	400	39									
	Hardened cast iron		hardened and tempered	55 HRC	40									
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
With hole depths of 5xD adjust the cutting data accordingly to the application.
f-group = feed rate recommendations on page C126.
For examples of material for cutting tool groups view page D22.

Starting values for cutting speed v_c [m/min]																					
SL-Drill		SL-Drill		SP-Drill		ST-Drill		SH-Drill		SC-Drill		PA-Drill		PC-Drill		PC-Drill		SC-Drill			
12-15xD		20-30xD		3xD		3-5xD		3xD		3 -5xD		3xD		3-5xD		15xD		Centering drill			
KDG 303		KDG 303		KDG 303		KDG 303		KDG 303		YK20F		YK 30F		YK20F		YK20F		KDG 303			
Int.	f-group	Int.	f-group	Int.	f-group	Int.	f-group	Ext.	f-group	Ext.	f-group	Ext.	f-group	Ext.	f-group	Int.	f-group	Ext.	f-group		
130	7	95	7	165	8	150	8											135	8		
110	7	80	7	145	8	130	8											120	8		
100	5	70	5	135	6	120	6											110	6		
85	5	60	5	125	6	110	6											100	6		
75	5	55	5	110	6	100	6											90	6		
110	7	80	7	145	8	130	8											120	8		
85	5	60	5	125	6	110	6											100	6		
75	5	55	5	110	6	100	6											90	6		
65	5	50	5	100	6	90	6											85	6		
100	7	70	7	135	8	120	8											110	8		
75	5	55	5	110	6	100	6											90	6		
60	4	55	4	90	5	80	5											75	5		
35	4	30	4	65	5	55	5											50	5		
40	4	35	4	70	5	60	5											55	5		
35	4	35	4	55	5	50	5											45	5		
125	7	90	7	150	8									120	8	100	7	120	8		
100	7	70	7	125	8									100	8	80	7	100	8		
110	7	80	7	135	8									100	8	80	7	100	8		
70	7	50	7	90	8									80	8	65	7	80	8		
120	7	85	7	145	8									120	8	100	7	120	8		
70	7	50	7	90	8									90	8	75	7	90	8		
150	8	105	8	170	8					180	9	180	9					180	9		
150	8	105	8	170	8					180	9	180	9					180	9		
150	8	105	8	170	8					130	9	130	9					130	9		
150	8	105	8	170	8					130	9	130	9					130	9		
150	8	105	8	170	8					120	9	120	9					120	9		
150	8	105	8	170	8					130	9	130	9					130	9		
150	8	105	8	170	8					130	9	130	9					130	9		
150	8	105	8	170	8					130	9	130	9					130	9		
30	4	20	4	30	5	30	5														
35	4	25	4	35	5	35	5														
35	4	25	4	35	5	35	5														
15	4	10	4	15	5	15	5														
15	4	10	4	15	5	15	5														
30	4	20	4	30	5	30	5														
30	4	20	4	30	5	30	5														
								25	2												
								20	1												
								50	3												
								25	2												

Recommended feed rate

Solid carbide drills

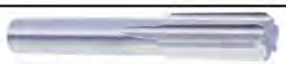
f-group	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10
2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,09	0,10	0,10	0,10	0,11	0,11	0,11
3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15	0,15
5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

Solid carbide reamers

Product overview	**C128**
Grade overview	**C129**
System code – solid carbide reamers	**C130**
Solid carbide reamers	**C131-C135**
Recommended cutting data	**C136-C140**
Technical information	**C173-C174**
Form nonstandard order	**C181**

Solid carbide reamers Product overview

Products	Solid carbide reamers	Ø	Application						Type	Page
			P	M	K	N	S	H		
3101H7		4-20			✔	✔			Right helical flute	C131
3102H7		4-20			✔	✔			Straight flute	C132
3112H7		4-20	✔		✔				Straight flute with inner hole	C133
3103H7		4-20			✔	✔			Left helical flute	C134

✔ Very suitable ✔ Suitable

Coated cemented carbide PVD

Grade	Grade description
KRG102	PVD coated P10–P20/K10–K20 carbide substrate for steel and cast iron.

Uncoated cemented carbide

Grade	Grade description
YK10F	Uncoated N10/K10 carbide substrate for cast iron and non ferrous materials.

Solid carbide reamers

System code – solid carbide reamers

3	1	0	1	H7	– 0850
1	2	3	4	5	6

Type	
Code	Description
3	Reamer

1

Shank type	
Code	Description
1	Straight shank
2	Straight shank DIN10
5	Straight shank DIN 6535 HA
9	Morse taper shank

2

Coolant supply	
Code	Description
0	External
1	Internal

3

Flute	
Code	Description
1	Right-hand twist
2	Straight flute
3	Left-hand twist

4

Classe de tolérance	
Code	Description
H7	The tolerance class of the reamed hole is equivalent to H7 (GB/T1800-1804)

5

Diameter [mm]	
Code	Description
0850	8,5
...	

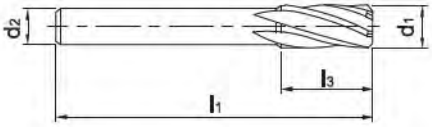
6

a Reaming

Reamer, right-hand twist — Cast iron, non-ferrous metals

3101H7

– Factory standard



Article	✻	Dimensions [mm]				Teeth	Grade
		d_1	d_2 (h6)	l_1	l_3		YK10F
3101H7-0400		4	3.55	56	20	4	●
3101H7-0500		5	4	63	22	6	○
3101H7-0600		6	5	63	22	6	○
3101H7-0700		7	6.3	71	25	6	○
3101H7-0800		8	6.3	71	25	6	○
3101H7-0900		9	8	71	25	6	○
3101H7-1000		10	8	71	25	6	○
3101H7-1100		11	10	80	28	6	○
3101H7-1200		12	10	80	28	6	○
3101H7-1300		13	10	80	28	6	○
3101H7-1400		14	12.5	90	32	6	○
3101H7-1450		14.5	12.5	90	32	6	○
3101H7-1500		15	12.5	90	32	6	○
3101H7-1600		16	12.5	90	32	6	○
3101H7-1700		17	12.5	90	32	6	○
3101H7-1800		18	16	100	36	6	○
3101H7-1900		19	16	100	36	6	○
3101H7-2000		20	16	100	36	6	○

● Ex stock ○ On demand

✻ With internal cooling

Application field

P	M	K	N	S	H
		✔	✔		

✔ Very suitable

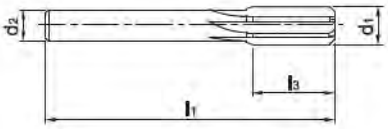
✔ Suitable

System code > C130 Machining instructions > C165 Cutting data > C136 Nonstandard order > C181

Reamer, straight flute — Cast iron, non-ferrous metals

3102H7

– Factory standard



Article	✲	Dimensions [mm]				Teeth	Grade
		d_1	d_2 (h6)	l_1	l_3		YK10F
3102H7-0400		4	3.55	56	20	4	○
3102H7-0500		5	4	63	22	6	○
3102H7-0600		6	5	63	22	6	○
3102H7-0700		7	6.3	71	25	6	○
3102H7-0800		8	6.3	71	25	6	○
3102H7-0900		9	8	71	25	6	○
3102H7-1000		10	8	71	25	6	○
3102H7-1050		10.5	8	71	25	6	○
3102H7-1100		11	10	80	28	6	○
3102H7-1200		12	10	80	28	6	○
3102H7-1300		13	10	80	28	6	○
3102H7-1400		14	12.5	90	32	6	○
3102H7-1450		14.5	12.5	90	32	6	○
3102H7-1500		15	12.5	90	32	6	○
3102H7-1600		16	12.5	90	32	6	○
3102H7-1700		17	12.5	90	32	6	○
3102H7-1800		18	16	100	36	6	○
3102H7-1900		19	16	100	36	6	○
3102H7-2000		20	16	100	36	6	○

● Ex stock ○ On demand

✲ With internal cooling

Application field

P	M	K	N	S	H
		✔	✔		

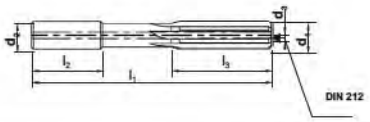
✔ Very suitable
✔ Suitable

System code > C130 Machining instructions > C165 Cutting data > C136 Nonstandard order > C181

Reamer, straight flute — Steel, cast iron

3112H7

– Factory standard
– Coolant exit, axial concentric



Article	✲	Dimensions [mm]						Teeth	Grade
		d_1	d_2 (h6)	d_3 (m7)	l_1	l_2	l_3		KRG102
3112H7-0400	✲	4	4	0.6	70	28	20	6	●
3112H7-0500	✲	5	5	1	70	28	22	6	●
3112H7-0600	✲	6	6	1	100	36	22	6	●
3112H7-0700	✲	7	8	1.3	110	42	25	6	●
3112H7-0800	✲	8	8	1.3	110	42	25	6	●
3112H7-0900	✲	9	10	2	110	42	25	6	●
3112H7-1000	✲	10	10	2	110	38	25	6	●
3112H7-1100	✲	11	12	2	110	38	28	6	●
3112H7-1200	✲	12	12	2	110	38	28	6	●
3112H7-1300	✲	13	14	2	110	38	28	6	●
3112H7-1400	✲	14	14	2	110	38	32	6	●
3112H7-1500	✲	15	16	2	110	38	32	6	●
3112H7-1600	✲	16	16	2	150	52	32	6	●
3112H7-1800	✲	18	18	3	150	52	36	6	●
3112H7-2000	✲	20	20	3	150	50	36	6	●

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔		✔			

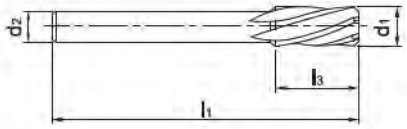
✔ Very suitable
✔ Suitable

System code > C130 Machining instructions > C165 Cutting data > C136 Nonstandard order > C181

Reamer, left-hand twist — Cast iron, non-ferrous metals

3103H7

– Factory standard



Article	✲	Dimensions [mm]				Teeth	Grade
		d_1	d_2 (h6)	l_1	l_3		YK10F
3103H7-0400		4	3.55	56	20	4	○
3103H7-0450		4.5	4	63	22	6	○
3103H7-0500		5	4	63	22	6	○
3103H7-0600		6	5	63	22	6	○
3103H7-0700		7	6.3	71	25	6	○
3103H7-0800		8	6.3	71	25	6	○
3103H7-0900		9	8	71	25	6	○
3103H7-1000		10	8	71	25	6	○
3103H7-1100		11	10	80	28	6	○
3103H7-1150		11.5	10	80	28	6	○
3103H7-1200		12	10	80	28	6	○
3103H7-1300		13	10	80	28	6	○
3103H7-1350		13.5	12.5	90	32	6	○
3103H7-1400		14	12.5	90	32	6	○
3103H7-1500		15	12.5	90	32	6	○
3103H7-1600		16	12.5	90	32	6	○
3103H7-1700		17	12.5	90	32	6	○
3103H7-1800		18	16	100	36	6	○
3103H7-1900		19	16	100	36	6	○
3103H7-2000		20	16	100	36	6	○

● Ex stock ○ On demand

✲ With internal cooling

Application field

P	M	K	N	S	H
		✔	✔		

✔ Very suitable
✔ Suitable

System code > C130 Machining instructions > C165 Cutting data > C136 Nonstandard order > C181

Notes

Guide for recommended cutting data – Solid carbide reamers

Solid carbide reamers

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]							
						3101H7				3112H7		3103H7	
						YK10F				KRG102		YK10F	
						Coolant							
						external	f-group	external	f-group	internal	f-group	external	f-group
P	Unalloyed steel	ca. 0,15 % C	annealed	125	1					85	5		
		ca. 0,45 % C	annealed	190	2					75	5		
		ca. 0,45 % C	tempered	250	3					70	5		
		ca. 0,75 % C	annealed	270	4					60	5		
		ca. 0,75 % C	tempered	300	5					55	5		
	Low-alloyed steel		annealed	180	6					75	5		
			tempered	275	7					60	5		
			tempered	300	8					55	5		
			tempered	350	9					55	5		
	High-alloyed steel and high-alloyed tool steel		annealed	200	10					70	5		
			hardened and tempered	325	11					55	5		
M	Stainless steel	ferritic/martensitic	annealed	200	12								
		martensitic	tempered	240	13								
		austenitic	quench hardened	180	14								
		austenitic-ferritic		230	15								
K	Grey cast iron	perlitic/ferritic		180	16	23	5	23	5	75	5	23	5
		perlitic (martensitic)		260	17	19	5	19	5	60	5	19	5
	Cast iron with spheroidal graphite	ferritic		160	18	19	5	19	5	60	5	19	5
		perlitic		250	19	17	5	17	5	50	5	17	5
	Malleable cast iron	ferritic		130	20	23	5	23	5	75	5	23	5
		perlitic		230	21	14	5	14	5	55	5	14	5
N	Aluminium wrought alloys	cannot be hardened		60	22	45	6	45	6			45	6
		hardenable	hardened	100	23	40	6	40	6			40	6
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24	37	6	37	6			37	6
		≤ 12 % Si, hardenable	hardened	90	25	35	6	35	6			35	6
		> 12 % Si, cannot be hardened		130	26	32	6	32	6			32	6
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27	37	6	37	6			37	6
		CuZn, CuSnZn		90	28	34	6	34	6			34	6
		CuSn, Pb-free copper, electrolytic copper		100	29	37	6	37	6			37	6
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30								
			hardened	280	31								
		Ni or Co bass	annealed	250	32								
			hardened	350	33								
			cast	320	34								
	Titanium alloys	pure titanium		R_m 400	35								
		α and β alloys	hardened	R_m 1050	36								
H	Hardened steel		hardened and tempered	55 HRC	37								
			hardened and tempered	60 HRC	38								
	Hard cast iron		cast	400	39								
	Hardened cast iron		hardened and tempered	55 HRC	40								
X	Non-metallic materials	Thermoplasts			41								
		Thermosetting plastics			42								
		Plastic, glass-fibre reinforced GFRP			43								
		Plastic, carbon fibre reinforced CFRP			44								
		Graphite			45								
		Wood			46								

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
With hole depths of 5xD adjust the cutting data accordingly to the application.
f-group = feed rate recommendations on page C140.
For examples of material for cutting tool groups view page D22.

Recommend feed rate

Solid carbide reamers

4

5

	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10
2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,09	0,10	0,10	0,10	0,11	0,11	0,11
3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15	0,15
5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
7	0,03	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

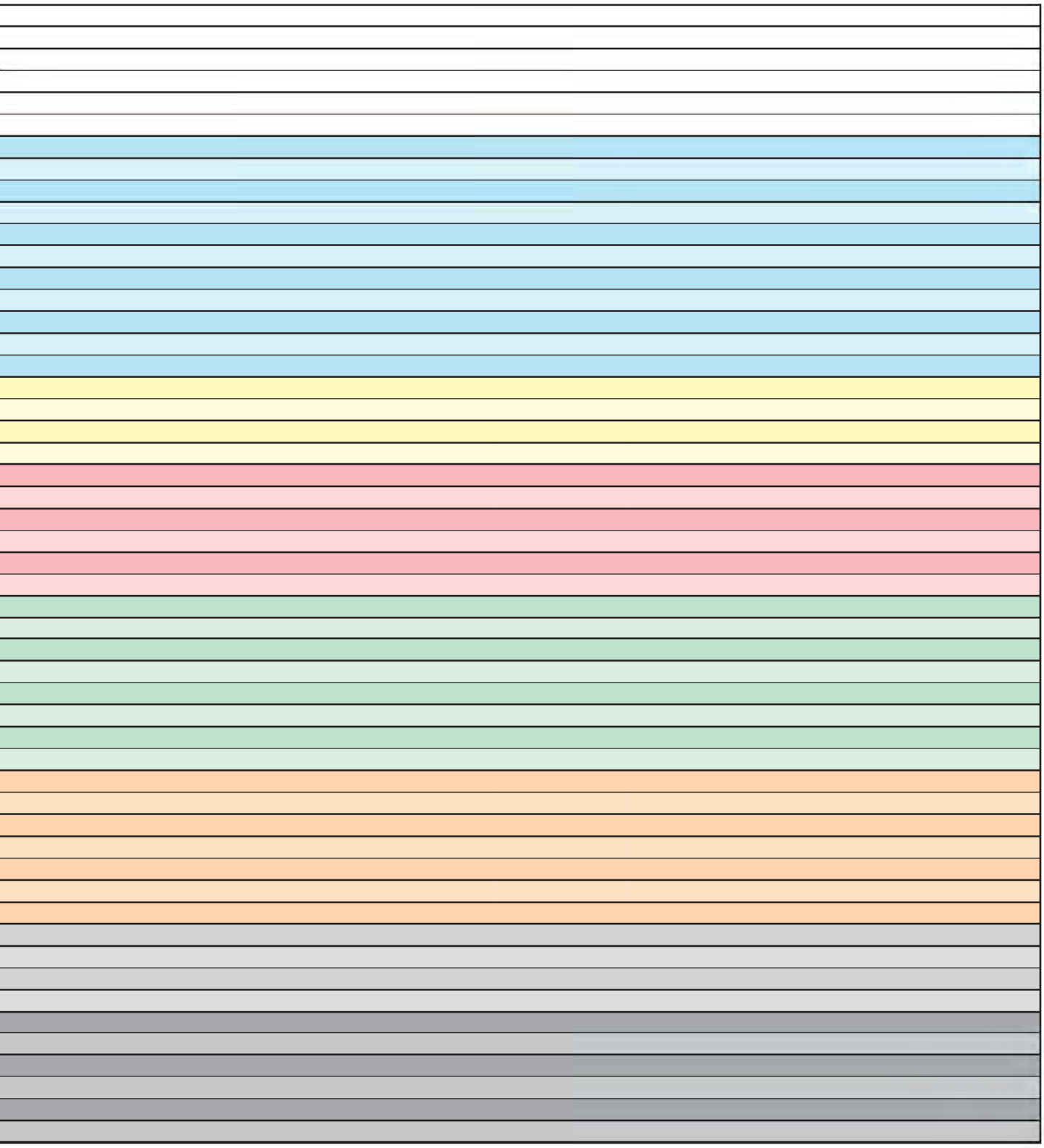
Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

1. Select the appropriate product series.
2. Determine the immersion.
3. Select the used material and read the cutting speed.
4. Determine the feed rate group and have a look at the appropriate feed rate recommendations.
5. Select the diameter of tool and determine the immersion.

Solid carbide reamers

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]							
						3101H7		3102H7		3112H7		3103H7	
						YK10F		YK10F		KRG102		YK10F	
						Coolant							
						Ext.	f-group	Ext.	f-group	Int.	f-group	Ext.	f-group
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1					85	5		
		approx. 0,45 % C	annealed	190	2					75	5		
		approx. 0,45 % C	tempered	250	3					70	5		
		approx. 0,75 % C	annealed	270	4					60	5		
		approx. 0,75 % C	tempered	300	5					55	5		
	Low-alloyed steel		annealed	180	6					75	5		
			tempered	275	7					60	5		
			tempered	300	8					55	5		
			tempered	350	9					55	5		
	High-alloyed steel and high-alloyed tool steel		annealed	200	10					70	5		
			hardened and tempered	325	11					55	5		
M	Stainless steel	ferritic/martensitic	annealed	200	12								
		martensitic	tempered	240	13								
		austenitic	quench hardened	180	14								
		austenitic-ferritic		230	15								
K	Grey cast iron	perlitic/ferritic		180	16	23	5	23	5	75	5	23	5
		perlitic (martensitic)		260	17	19	5	19	5	60	5	19	5
	Cast iron with spheroidal graphite	ferritic		160	18	19	5	19	5	60	5	19	5
		perlitic		250	19	17	5	17	5	50	5	17	5
	Malleable cast iron	ferritic		130	20	23	5	23	5	75	5	23	5
		perlitic		230	21	14	5	14	5	55	5	14	5
N	Aluminium wrought alloys	cannot be hardened		60	22	45	6	45	6			45	6
		hardenable	hardened	100	23	40	6	40	6			40	6
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24	37	6	37	6			37	6
		≤ 12 % Si, hardenable	hardened	90	25	35	6	35	6			35	6
		> 12 % Si, cannot be hardened		130	26	32	6	32	6			32	6
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27	37	6	37	6			37	6
		CuZn, CuSnZn		90	28	34	6	34	6			34	6
		CuSn, Pb-free copper, electrolytic copper		100	29	37	6	37	6			37	6
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30								
			hardened	280	31								
		Ni or Co bass	annealed	250	32								
			hardened	350	33								
			cast	320	34								
	Titanium alloys	pure titanium		R_m 400	35								
		α and β alloys	hardened	R_m 1050	36								
H	Hardened steel		hardened and tempered	55 HRC	37								
			hardened and tempered	60 HRC	38								
	Hard cast iron		cast	400	39								
	Hardened cast iron		hardened and tempered	55 HRC	40								
X	Non-metallic materials	Thermoplasts			41								
		Thermosetting plastics			42								
		Plastic, glass-fibre reinforced GFRP			43								
		Plastic, carbon fibre reinforced CFRP			44								
		Graphite			45								
		Wood			46								

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
With hole depths of 5xD adjust the cutting data accordingly to the application.
f-group = feed rate recommendations on page C140.
For examples of material for cutting tool groups view page D22.



Recommended feed rate

Solid carbide reamers

f-group	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10
2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,09	0,10	0,10	0,10	0,11	0,11	0,11
3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15	0,15
5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

Solid carbide threading tools

Product overview	**C142**
Grade overview	**C143**
System code – solid carbide threading tools	**C144**
Solid carbide thread formers	**C145-C150**
Solid carbide taps	**C151-C158**
Solid carbide thread milling cutters	**C159**
Recommended cutting data	**C160-C164**
Technical information	**C175-C177**
Form nonstandard order	**C182**

Solid carbide threading tools Product overview

Products	Solid carbide threading tools	Ø	Application						Type	Page
			P	M	K	N	S	H		
4122A		M1-M2.5				✔			Solid carbide thread formers	C145
4222A		M3-M16				✔			Solid carbide thread formers	C146
4122M		M1-M2.5	✔	✔					Solid carbide thread formers	C148
4222M		M3-M16	✔	✔					Solid carbide thread formers	C149
4201C		M3-M16			✔				Solid carbide tap, right-hand twist	C151
4202C		M3-M16			✔				Solid carbide tap, straight flute	C153
4201A		M3-M16				✔			Solid carbide tap, right-hand twist	C155
4202A		M3-M16				✔			Solid carbide tap, straight flute	C157
4111		M3-M20	✔		✔	✔			Solid carbide thread milling cutters	C159

✔ Very suitable ✔ Suitable

Coated cemented carbide PVD

Grade	Grade description
KTG402	PVD coated P20–P30/M20–M30 carbide substrate for steel and stainless steel. Especially for thread forming tools.
KTG4015	PVD coated P20–P30/K20–K30 carbide substrate for steel and cast iron. Especially for thread forming tools.

Uncoated cemented carbide

Grade	Grade description
YK40F	Uncoated K20–K30/N20–N30 carbide substrate for cast iron and non ferrous materials.

Solid carbide threading tools

System code – solid carbide threading tools

4	2	0	1	A	(C)	(S)	– M5x0.8 –	6H
1	2	3	4	5	6	7	8	9

1 Type

Code	Description
4	Threading tool

2 Shank type

Code	Description
1	Straight shank
2	Straight shank DIN10
5	Straight shank DIN 6535 HA
9	Conical shank

3 Tool type

Code	Description
0	Tap
1	Thread milling cutter
2	Thread former

4 Flute

Code	Description
1	Right-hand twist
2	Straight
3	Left-hand twist

5 Material

Code	Description
A	Aluminum alloy
C	Cast iron
M	Stainless steel
P	Steel
H	Hardened steel

6 Coolant supply

Code	Description
C	Internal

7 Blind hole

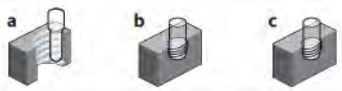
Code	Description
S	Blind hole

8 Thread type

Code	Description
M5x0.8	Standard production tolerance
...	Fine production tolerance

9 Precision class

Code	Description
6H	Nominal diameter x pitch
6HX	Fine production tolerance

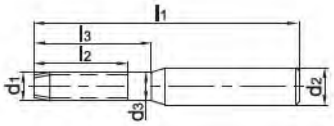


a Thread milling b Thread drilling c Thread forming

Thread former — Non-ferrous metals

4122A

– Factory standard



Article	*	Dimensions [mm]								Teeth	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3		d	YK40F
4122A-M1*0.25-6H		3P	M1	0.25	3		40	5	6	3	0.9	●
4122AS-M1*0.25-6H		1.5P	M1	0.25	3		40	5	6	3	0.9	○
4122A-M1.2*0.25-6H		3P	M1.2	0.25	3		40	5	6	3	1.1	●
4122AS-M1.2*0.25-6H		1.5P	M1.2	0.25	3		40	5	6	3	1.1	○
4122A-M1.6*0.35-6H		3P	M1.6	0.35	3	1.1	40	5	11	3	1.47	●
4122AS-M1.6*0.35-6H		1.5P	M1.6	0.35	3	1.1	40	5	11	3	1.47	●
4122A-M2*0.4-6H		3P	M2	0.4	3	1.5	45	6	12	3	1.85	●
4122AS-M2*0.4-6H		1.5P	M2	0.4	3	1.5	45	6	12	3	1.85	●
4122A-M2.5*0.45-6H		3P	M2.5	0.45	3	1.9	50	6	14	3	2.33	○
4122AS-M2.5*0.45-6H		1.5P	M2.5	0.45	3	1.9	50	6	14	3	2.33	●

● Ex stock ○ On demand

✻ With internal cooling

Application field

P	M	K	N	S	H
			✔		

✔ Very suitable

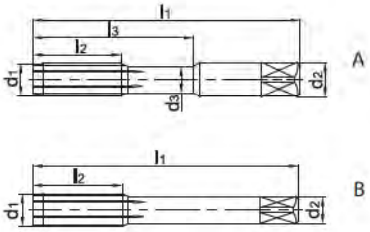
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Thread former — Non-ferrous metals

4222A

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4222A-M3*0.5-6H		3P	M3	0.5	3.5	2.3	56	6	18	4	A	2.8	○
4222AS-M3*0.5-6H		1.5P	M3	0.5	3.5	2.3	56	6	18	4	A	2.8	●
4222A-M4*0.5-6H		3P	M4	0.5	4.5	3.1	63	8	21	4	A	3.8	○
4222AS-M4*0.5-6H		1.5P	M4	0.5	4.5	3.1	63	8	21	4	A	3.8	○
4222A-M4*0.7-6H		3P	M4	0.7	4.5	3.1	63	8	21	4	A	3.7	○
4222AS-M4*0.7-6H		1.5P	M4	0.7	4.5	3.1	63	8	21	4	A	3.7	○
4222A-M5*0.5-6H		3P	M5	0.5	6	4.3	70	10	25	4	A	4.8	○
4222AS-M5*0.5-6H		1.5P	M5	0.5	6	4.3	70	10	25	4	A	4.8	○
4222A-M5*0.8-6H		3P	M5	0.8	6	4	70	10	25	4	A	4.65	○
4222AS-M5*0.8-6H		1.5P	M5	0.8	6	4	70	10	25	4	A	4.65	○
4222A-M6*0.75-6H		3P	M6	0.75	6	5	80	12	30	4	A	5.7	○
4222AS-M6*0.75-6H		1.5P	M6	0.75	6	5	80	12	30	4	A	5.7	○
4222A-M6*1-6H		3P	M6	1	6	4.7	80	12	30	4	A	5.6	○
4222AS-M6*1-6H		1.5P	M6	1	6	4.7	80	12	30	4	A	5.6	○
4222A-M7*1-6H		3P	M7	1	7	5.7	80	14	30	4	A	6.6	○
4222AS-M7*1-6H		1.5P	M7	1	7	5.7	80	14	30	4	A	6.6	○
4222A-M8*1-6H		3P	M8	1	8	6.7	90	16	35	4	A	7.6	○
4222AS-M8*1-6H		1.5P	M8	1	8	6.7	90	16	35	4	A	7.6	○
4222A-M8*1.25-6H		3P	M8	1.25	8	6.4	90	16	35	4	A	7.45	○
4222AS-M8*1.25-6H		1.5P	M8	1.25	8	6.4	90	16	35	4	A	7.45	○
4222A-M10*1-6H		3P	M10	1	10	8.7	100	20	39	5	A	9.6	○
4222AS-M10*1-6H		1.5P	M10	1	10	8.7	100	20	39	5	A	9.6	○
4222A-M10*1.25-6H		3P	M10	1.25	10	8.4	100	20	39	5	A	9.45	○
4222AS-M10*1.25-6H		1.5P	M10	1.25	10	8.4	100	20	39	5	A	9.45	○
4222A-M10*1.5-6H		3P	M10	1.5	10	8.1	100	20	39	5	A	9.35	○
4222AC-M10*1.5-6H	*	3P	M10	1.5	10	8.1	100	20	39	5	A	9.35	○
4222AS-M10*1.5-6H		1.5P	M10	1.5	10	8.1	100	20	39	5	A	9.35	○
4222ACS-M10*1.5-6H	*	1.5P	M10	1.5	10	8.1	100	20	39	5	A	9.35	○
4222A-M12*1.25-6H		3P	M12	1.25	9		110	24		5	B	11.45	○
4222AS-M12*1.25-6H		1.5P	M12	1.25	9		110	24		5	B	11.45	○
4222A-M12*1.5-6H		3P	M12	1.5	9		110	24		5	B	11.35	○
4222AS-M12*1.5-6H		1.5P	M12	1.5	9		110	24		5	B	11.35	○
4222A-M12*1.75-6H		3P	M12	1.75	9		110	24		5	B	11.25	○

● Ex stock ○ On demand
* With internal cooling

Application field

P	M	K	N	S	H
			✔		

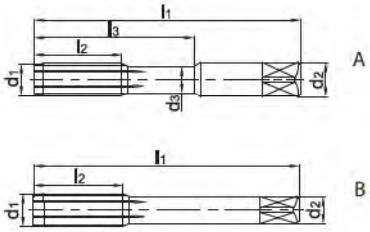
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Thread former — Non-ferrous metals

4222A

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	✻	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4222AC-M12*1.75-6H	✻	3P	M12	1.75	9		110	24		5	B	11.25	○
4222AS-M12*1.75-6H		1.5P	M12	1.75	9		110	24		5	B	11.25	○
4222ACS-M12*1.75-6H	✻	1.5P	M12	1.75	9		110	24		5	B	11.25	○
4222A-M14*1.5-6H		3P	M14	1.5	11		110	26		6	B	13.35	○
4222AS-M14*1.5-6H		1.5P	M14	1.5	11		110	26		6	B	13.35	○
4222A-M14*2-6H		3P	M14	2	11		110	26		6	B	13.1	○
4222AS-M14*2-6H		1.5P	M14	2	11		110	26		6	B	13.1	○
4222A-M16*1.5-6H		3P	M16	1.5	12		110	27		6	B	15.35	○
4222AS-M16*1.5-6H		1.5P	M16	1.5	12		110	27		6	B	15.35	○
4222A-M16*2-6H		3P	M16	2	12		110	27		6	B	15.1	○
4222AC-M16*2-6H	✻	3P	M16	2	12		110	27		6	B	15.1	○
4222AS-M16*2-6H		1.5P	M16	2	12		110	27		6	B	15.1	○
4222ACS-M16*2-6H	✻	1.5P	M16	2	12		110	27		6	B	15.1	○

● Ex stock ○ On demand
✻ With internal cooling

Application field

P	M	K	N	S	H
			✔		

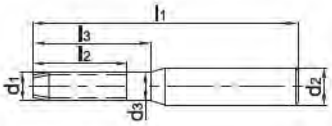
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Thread former Steel, stainless steel

4122M

– Factory standard



Article	*	Dimensions [mm]								Teeth	Coredrill	Grade	
			d_1	P	d_2	d_3	l_1	l_2	l_3		d	KTG402	YK40F
4122M-M1*0.25-6H		3P	M1	0.25	3		40	5	6	4	0.9	●	○
4122MS-M1*0.25-6H		2P	M1	0.25	3		40	5	6	4	0.9	●	○
4122M-M1.2*0.25-6H		3P	M1.2	0.25	3		40	5	6	4	1.1	○	○
4122MS-M1.2*0.25-6H		2P	M1.2	0.25	3		40	5	6	4	1.1	○	○
4122M-M1.6*0.35-6H		3P	M1.6	0.35	3	1.1	40	5	11	4	1.47	○	○
4122MS-M1.6*0.35-6H		2P	M1.6	0.35	3	1.1	40	5	11	4	1.47	○	○
4122M-M2*0.4-6H		3P	M2	0.4	3	1.5	45	6	12	4	1.85	●	○
4122MS-M2*0.4-6H		2P	M2	0.4	3	1.5	45	6	12	4	1.85	●	○
4122M-M2.5*0.45-6H		3P	M2.5	0.45	3	1.9	50	6	14	4	2.33	○	○
4122MS-M2.5*0.45-6H		2P	M2.5	0.45	3	1.9	50	6	14	4	2.33	●	○

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✔	✔				

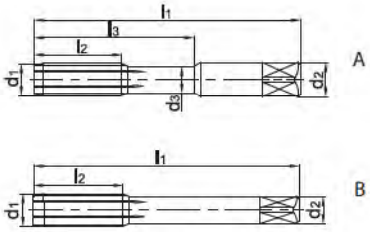
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Thread former — Steel, stainless steel

4222M

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade	
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	KTG402	YK40F
4222M-M3*0.5-6H		3P	M3	0.5	3.5	2.3	56	6	18	4	A	2.8	●	○
4222MS-M3*0.5-6H		2P	M3	0.5	3.5	2.3	56	6	18	4	A	2.8	○	○
4222M-M4*0.5-6H		3P	M4	0.5	4.5	3.1	63	8	21	4	A	3.8	●	○
4222MS-M4*0.5-6H		2P	M4	0.5	4.5	3.1	63	8	21	4	A	3.8	○	○
4222M-M4*0.7-6H		3P	M4	0.7	4.5	3.1	63	8	21	4	A	3.7	●	○
4222MS-M4*0.7-6H		2P	M4	0.7	4.5	3.1	63	8	21	4	A	3.7	●	○
4222M-M5*0.5-6H		3P	M5	0.5	6	4.3	70	10	25	4	A	4.8	●	○
4222MS-M5*0.5-6H		2P	M5	0.5	6	4.3	70	10	25	4	A	4.8	●	○
4222M-M5*0.8-6H		3P	M5	0.8	6	4	70	10	25	4	A	4.65	●	○
4222MS-M5*0.8-6H		2P	M5	0.8	6	4	70	10	25	4	A	4.65	●	○
4222M-M6*0.75-6H		3P	M6	0.75	6	5	80	12	30	4	A	5.7	●	○
4222MS-M6*0.75-6H		2P	M6	0.75	6	5	80	12	30	4	A	5.7	●	○
4222M-M6*1-6H		3P	M6	1	6	4.7	80	12	30	4	A	5.6	○	○
4222MS-M6*1-6H		2P	M6	1	6	4.7	80	12	30	4	A	5.6	○	○
4222M-M7*1-6H		3P	M7	1	7	5.7	80	14	30	4	A	6.6	○	○
4222MS-M7*1-6H		2P	M7	1	7	5.7	80	14	30	4	A	6.6	○	○
4222M-M8*1-6H		3P	M8	1	8	6.7	90	16	35	4	A	7.6	○	○
4222MS-M8*1-6H		2P	M8	1	8	6.7	90	16	35	4	A	7.6	○	○
4222M-M8*1.25-6H		3P	M8	1.25	8	6.4	90	16	35	4	A	7.45	●	○
4222MS-M8*1.25-6H		2P	M8	1.25	8	6.4	90	16	35	4	A	7.45	●	○
4222M-M10*1-6H		3P	M10	1	10	8.7	100	20	39	5	A	9.6	○	○
4222MS-M10*1-6H		2P	M10	1	10	8.7	100	20	39	5	A	9.6	○	○
4222M-M10*1.25-6H		3P	M10	1.25	10	8.4	100	20	39	5	A	9.45	○	○
4222MS-M10*1.25-6H		2P	M10	1.25	10	8.4	100	20	39	5	A	9.45	●	○
4222M-M10*1.5-6H		3P	M10	1.5	10	8.1	100	20	39	5	A	9.35	○	○
4222MC-M10*1.5-6H	*	3P	M10	1.5	10	8.1	100	20	39	5	A	9.35	●	○
4222MS-M10*1.5-6H		2P	M10	1.5	10	8.1	100	20	39	5	A	9.35	●	○
4222MCS-M10*1.5-6H	*	2P	M10	1.5	10	8.1	100	20	39	5	A	9.35	●	○
4222M-M12*1.25-6H		3P	M12	1.25	9		110	24		5	B	11.45	●	○
4222MS-M12*1.25-6H		2P	M12	1.25	9		110	24		5	B	11.45	●	○
4222M-M12*1.5-6H		3P	M12	1.5	9		110	24		5	B	11.35	○	○
4222MS-M12*1.5-6H		2P	M12	1.5	9		110	24		5	B	11.35	○	○
4222M-M12*1.75-6H		3P	M12	1.75	9		110	24		5	B	11.25	○	○

● Ex stock ○ On demand
* With internal cooling

Application field

P	M	K	N	S	H
✔	✔				

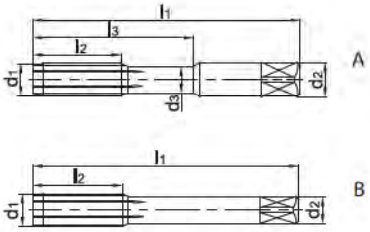
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Thread former Steel, stainless steel

4222M

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade	
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	KTG402	YK40F
4222MC-M12*1.75-6H	✲	3P	M12	1.75	9		110	24		5	B	11.25	○	○
4222MS-M12*1.75-6H		2P	M12	1.75	9		110	24		5	B	11.25	●	○
4222MCS-M12*1.75-6H	✲	2P	M12	1.75	9		110	24		5	B	11.25	○	○
4222M-M14*1.5-6H		3P	M14	1.5	11		110	26		6	B	13.35	●	○
4222MS-M14*1.5-6H		2P	M14	1.5	11		110	26		6	B	13.35	○	○
4222M-M14*2-6H		3P	M14	2	11		110	26		6	B	13.1	○	○
4222MS-M14*2-6H		2P	M14	2	11		110	26		6	B	13.1	○	○
4222M-M16*1.5-6H		3P	M16	1.5	12		110	27		6	B	15.35	●	○
4222MS-M16*1.5-6H		2P	M16	1.5	12		110	27		6	B	15.35	○	○
4222M-M16*2-6H		3P	M16	2	12		110	27		6	B	15.1	○	○
4222MC-M16*2-6H	✲	3P	M16	2	12		110	27		6	B	15.1	○	○
4222MS-M16*2-6H		2P	M16	2	12		110	27		6	B	15.1	○	○
4222MCS-M16*2-6H	✲	2P	M16	2	12		110	27		6	B	15.1	○	○

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
✔	✔				

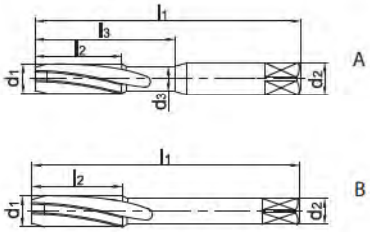
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Tap, right-hand twist — Cast iron

4201C

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4201C-M3*0.5-6H		3P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	●
4201C-M3*0.5-6HX		3P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	●
4201CS-M3*0.5-6H		1.5P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	●
4201CS-M3*0.5-6HX		1.5P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	●
4201C-M4*0.7-6H		3P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	●
4201C-M4*0.7-6HX		3P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	●
4201CS-M4*0.7-6H		1.5P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	●
4201CS-M4*0.7-6HX		1.5P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	●
4201C-M5*0.8-6H		3P	M5	0.8	6	4	70	16	25	3	A	4.2	●
4201C-M5*0.8-6HX		3P	M5	0.8	6	4	70	16	25	3	A	4.2	●
4201CS-M5*0.8-6H		1.5P	M5	0.8	6	4	70	16	25	3	A	4.2	●
4201CS-M5*0.8-6HX		1.5P	M5	0.8	6	4	70	16	25	3	A	4.2	●
4201C-M6*0.75-6H		3P	M6	0.75	6	5	80	19	30	3	A	5.25	●
4201C-M6*0.75-6HX		3P	M6	0.75	6	5	80	19	30	3	A	5.25	●
4201CS-M6*0.75-6H		1.5P	M6	0.75	6	5	80	19	30	3	A	5.25	●
4201CS-M6*0.75-6HX		1.5P	M6	0.75	6	5	80	19	30	3	A	5.25	●
4201C-M6*1-6H		3P	M6	1	6	4.7	80	19	30	3	A	5	○
4201CC-M6*1-6H	*	3P	M6	1	6	4.7	80	19	30	3	A	5	○
4201C-M6*1-6HX		3P	M6	1	6	4.7	80	19	30	3	A	5	○
4201CS-M6*1-6H		1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4201CCS-M6*1-6H	*	1.5P	M6	1	6	4.7	80	19	30	3	A	5	●
4201CS-M6*1-6HX		1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4201C-M7*1-6H		3P	M7	1	7	5.7	80	19	30	3	A	6	○
4201CS-M7*1-6H		1.5P	M7	1	7	5.7	80	19	30	3	A	6	○
4201C-M8*1-6H		3P	M8	1	8	6.7	90	20	35	3	A	7	○
4201CS-M8*1-6H		1.5P	M8	1	8	6.7	90	20	35	3	A	7	○
4201C-M8*1.25-6H		3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	●
4201CC-M8*1.25-6H	*	3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	●
4201C-M8*1.25-6HX		3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	●
4201CS-M8*1.25-6H		1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4201CCS-M8*1.25-6H	*	1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4201CS-M8*1.25-6HX		1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4201C-M10*1-6H		3P	M10	1	10	8.7	100	20	39	4	A	9	○

● Ex stock ○ On demand
* With internal cooling

Application field

P	M	K	N	S	H
		✔			

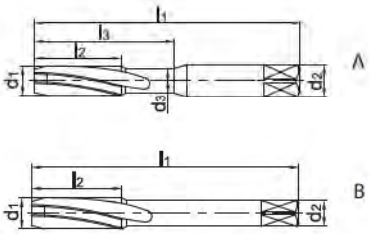
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Tap, right-hand twist — Cast iron

4201C

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4201CS-M10*1-6H		1.5P	M10	1	10	8.7	100	20	39	4	A	9	○
4201C-M10*1.25-6H		3P	M10	1.25	10	8.4	100	24	39	4	A	8.75	○
4201CS-M10*1.25-6H		1.5P	M10	1.25	10	8.4	100	24	39	4	A	8.75	○
4201C-M10*1.5-6H		3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201CC-M10*1.5-6H	*	3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201C-M10*1.5-6HX		3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201CS-M10*1.5-6H		1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201CCS-M10*1.5-6H	*	1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	●
4201CS-M10*1.5-6HX		1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201C-M12*1.25-6H		3P	M12	1.25	9		110	29		4	B	10.75	○
4201CS-M12*1.25-6H		1.5P	M12	1.25	9		110	29		4	B	10.75	○
4201C-M12*1.5-6H		3P	M12	1.5	9		110	29		4	B	10.5	○
4201CS-M12*1.5-6H		1.5P	M12	1.5	9		110	29		4	B	10.5	○
4201C-M12*1.75-6H		3P	M12	1.75	9		110	29		4	B	10.25	○
4201CC-M12*1.75-6H	*	3P	M12	1.75	9		110	29		4	B	10.25	●
4201C-M12*1.75-6HX		3P	M12	1.75	9		110	29		4	B	10.25	○
4201CS-M12*1.75-6H		1.5P	M12	1.75	9		110	29		4	B	10.25	○
4201CCS-M12*1.75-6H	*	1.5P	M12	1.75	9		110	29		4	B	10.25	○
4201CS-M12*1.75-6HX		1.5P	M12	1.75	9		110	29		4	B	10.25	○
4201C-M14*1.5-6H		3P	M14	1.5	11		110	30		4	B	12.5	○
4201CS-M14*1.5-6H		1.5P	M14	1.5	11		110	30		4	B	12.5	○
4201C-M14*2-6H		3P	M14	2	11		110	30		4	B	12	○
4201CS-M14*2-6H		1.5P	M14	2	11		110	30		4	B	12	○
4201C-M16*1.5-6H		3P	M16	1.5	12		110	32		4	B	14.5	○
4201CS-M16*1.5-6H		1.5P	M16	1.5	12		110	32		4	B	14.5	○
4201C-M16*2-6H		3P	M16	2	12		110	32		4	B	14	○
4201C-M16*2-6HX		3P	M16	2	12		110	32		4	B	14	○
4201CS-M16*2-6H		1.5P	M16	2	12		110	32		4	B	14	○
4201CS-M16*2-6HX		1.5P	M16	2	12		110	32		4	B	14	○

● Ex stock ○ On demand
* With internal cooling

Application field

P	M	K	N	S	H
		✔			

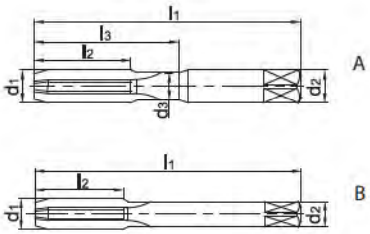
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Tap, straight flute — Cast iron

4202C

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4202C-M3*0.5-6H		3P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4202C-M3*0.5-6HX		3P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4202CS-M3*0.5-6H		1.5P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4202CS-M3*0.5-6HX		1.5P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4202C-M4*0.7-6H		3P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4202C-M4*0.7-6HX		3P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4202CS-M4*0.7-6H		1.5P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4202CS-M4*0.7-6HX		1.5P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4202C-M5*0.8-6H		3P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4202C-M5*0.8-6HX		3P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4202CS-M5*0.8-6H		1.5P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4202CS-M5*0.8-6HX		1.5P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4202C-M6*0.75-6H		3P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4202C-M6*0.75-6HX		3P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4202CS-M6*0.75-6H		1.5P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4202CS-M6*0.75-6HX		1.5P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4202C-M6*1-6H		3P	M6	1	6	4.7	80	19	30	3	A	5	○
4202CC-M6*1-6H	✻	3P	M6	1	6	4.7	80	19	30	3	A	5	○
4202C-M6*1-6HX		3P	M6	1	6	4.7	80	19	30	3	A	5	○
4202CS-M6*1-6H		1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4202CCS-M6*1-6H	✻	1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4202CS-M6*1-6HX		1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4202C-M7*1-6H		3P	M7	1	7	5.7	80	19	30	3	A	6	○
4202CS-M7*1-6H		1.5P	M7	1	7	5.7	80	19	30	3	A	6	○
4202C-M8*1-6H		3P	M8	1	8	6.7	90	20	35	3	A	7	○
4202CS-M8*1-6H		1.5P	M8	1	8	6.7	90	20	35	3	A	7	○
4202C-M8*1.25-6H		3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202CC-M8*1.25-6H	✻	3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202C-M8*1.25-6HX		3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202CS-M8*1.25-6H		1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202CCS-M8*1.25-6H	✻	1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202CS-M8*1.25-6HX		1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202C-M10*1-6H		3P	M10	1	10	8.7	100	20	39	4	A	9	○

● Ex stock ○ On demand
✻ With internal cooling

Application field

P	M	K	N	S	H
		✔			

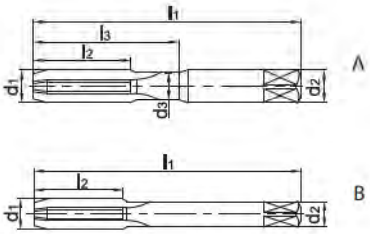
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Tap, straight flute — Cast iron

4202C

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4202CS-M10*1-6H		1.5P	M10	1	10	8.7	100	20	39	4	A	9	○
4202C-M10*1.25-6H		3P	M10	1.25	10	8.4	100	24	39	4	A	8.75	○
4202CS-M10*1.25-6H		1.5P	M10	1.25	10	8.4	100	24	39	4	A	8.75	○
4202C-M10*1.5-6H		3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202CC-M10*1.5-6H	*	3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202C-M10*1.5-6HX		3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202CS-M10*1.5-6H		1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202CCS-M10*1.5-6H	*	1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202CS-M10*1.5-6HX		1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202C-M12*1.25-6H		3P	M12	1.25	9		110	29		4	B	10.75	○
4202CS-M12*1.25-6H		1.5P	M12	1.25	9		110	29		4	B	10.75	○
4202C-M12*1.5-6H		3P	M12	1.5	9		110	29		4	B	10.5	○
4202CS-M12*1.5-6H		1.5P	M12	1.5	9		110	29		4	B	10.5	○
4202C-M12*1.75-6H		3P	M12	1.75	9		110	29		4	B	10.25	○
4202CC-M12*1.75-6H	*	3P	M12	1.75	9		110	29		4	B	10.25	○
4202C-M12*1.75-6HX		3P	M12	1.75	9		110	29		4	B	10.25	○
4202CS-M12*1.75-6H		1.5P	M12	1.75	9		110	29		4	B	10.25	○
4202CCS-M12*1.75-6H	*	1.5P	M12	1.75	9		110	29		4	B	10.25	○
4202CS-M12*1.75-6HX		1.5P	M12	1.75	9		110	29		4	B	10.25	○
4202C-M14*1.5-6H		3P	M14	1.5	11		110	30		4	B	12.5	○
4202CS-M14*1.5-6H		1.5P	M14	1.5	11		110	30		4	B	12.5	○
4202C-M14*2-6H		3P	M14	2	11		110	30		4	B	12	○
4202CS-M14*2-6H		1.5P	M14	2	11		110	30		4	B	12	○
4202C-M16*1.5-6H		3P	M16	1.5	12		110	32		4	B	14.5	○
4202CS-M16*1.5-6H		1.5P	M16	1.5	12		110	32		4	B	14.5	○
4202C-M16*2-6H		3P	M16	2	12		110	32		4	B	14	○
4202C-M16*2-6HX		3P	M16	2	12		110	32		4	B	14	○
4202CS-M16*2-6H		1.5P	M16	2	12		110	32		4	B	14	○
4202CS-M16*2-6HX		1.5P	M16	2	12		110	32		4	B	14	○

● Ex stock ○ On demand
* With internal cooling

Application field

P	M	K	N	S	H
		✔			

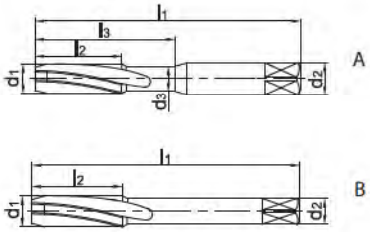
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Tap, right-hand twist — Non-ferrous metals

4201A

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4201A-M3*0.5-6H		3P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	●
4201A-M3*0.5-6HX		3P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4201AS-M3*0.5-6H		1.5P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	●
4201AS-M3*0.5-6HX		1.5P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4201A-M4*0.7-6H		3P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	●
4201A-M4*0.7-6HX		3P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4201AS-M4*0.7-6H		1.5P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	●
4201AS-M4*0.7-6HX		1.5P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4201A-M5*0.8-6H		3P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4201A-M5*0.8-6HX		3P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4201AS-M5*0.8-6H		1.5P	M5	0.8	6	4	70	16	25	3	A	4.2	●
4201AS-M5*0.8-6HX		1.5P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4201A-M6*0.75-6H		3P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4201A-M6*0.75-6HX		3P	M6	0.75	6	5	80	19	30	3	A	5.25	●
4201AS-M6*0.75-6H		1.5P	M6	0.75	6	5	80	19	30	3	A	5.25	●
4201AS-M6*0.75-6HX		1.5P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4201A-M6*1-6H		3P	M6	1	6	4.7	80	19	30	3	A	5	●
4201AC-M6*1-6H	*	3P	M6	1	6	4.7	80	19	30	3	A	5	○
4201A-M6*1-6HX		3P	M6	1	6	4.7	80	19	30	3	A	5	●
4201AS-M6*1-6H		1.5P	M6	1	6	4.7	80	19	30	3	A	5	●
4201ACS-M6*1-6H	*	1.5P	M6	1	6	4.7	80	19	30	3	A	5	●
4201AS-M6*1-6HX		1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4201A-M7*1-6H		3P	M7	1	7	5.7	80	19	30	3	A	6	○
4201AS-M7*1-6H		1.5P	M7	1	7	5.7	80	19	30	3	A	6	○
4201A-M8*1-6H		3P	M8	1	8	6.7	90	20	35	3	A	7	○
4201AS-M8*1-6H		1.5P	M8	1	8	6.7	90	20	35	3	A	7	●
4201A-M8*1.25-6H		3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4201AC-M8*1.25-6H	*	3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	●
4201A-M8*1.25-6HX		3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4201AS-M8*1.25-6H		1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	●
4201ACS-M8*1.25-6H	*	1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	●
4201AS-M8*1.25-6HX		1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4201A-M10*1-6H		3P	M10	1	10	8.7	100	20	39	4	A	9	●

● Ex stock ○ On demand
* With internal cooling

Application field

P	M	K	N	S	H
			✔		

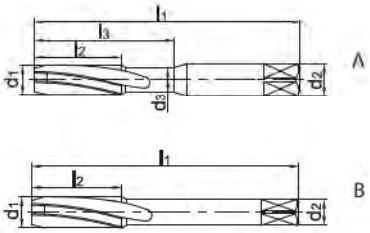
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Tap, right-hand twist — Non-ferrous metals

4201A

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	✲	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4201AS-M10*1-6H		1.5P	M10	1	10	8.7	100	20	39	4	A	9	●
4201A-M10*1.25-6H		3P	M10	1.25	10	8.4	100	24	39	4	A	8.75	○
4201AS-M10*1.25-6H		1.5P	M10	1.25	10	8.4	100	24	39	4	A	8.75	○
4201A-M10*1.5-6H		3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201AC-M10*1.5-6H	✲	3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	●
4201A-M10*1.5-6HX		3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201AS-M10*1.5-6H		1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	●
4201ACS-M10*1.5-6H	✲	1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201AS-M10*1.5-6HX		1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4201A-M12*1.25-6H		3P	M12	1.25	9		110	29		4	B	10.75	○
4201AS-M12*1.25-6H		1.5P	M12	1.25	9		110	29		4	B	10.75	○
4201A-M12*1.5-6H		3P	M12	1.5	9		110	29		4	B	10.5	○
4201AS-M12*1.5-6H		1.5P	M12	1.5	9		110	29		4	B	10.5	○
4201A-M12*1.75-6H		3P	M12	1.75	9		110	29		4	B	10.25	○
4201AC-M12*1.75-6H	✲	3P	M12	1.75	9		110	29		4	B	10.25	○
4201A-M12*1.75-6HX		3P	M12	1.75	9		110	29		4	B	10.25	○
4201AS-M12*1.75-6H		1.5P	M12	1.75	9		110	29		4	B	10.25	●
4201ACS-M12*1.75-6H	✲	1.5P	M12	1.75	9		110	29		4	B	10.25	○
4201AS-M12*1.75-6HX		1.5P	M12	1.75	9		110	29		4	B	10.25	○
4201A-M14*1.5-6H		3P	M14	1.5	11		110	30		4	B	12.5	○
4201AS-M14*1.5-6H		1.5P	M14	1.5	11		110	30		4	B	12.5	○
4201A-M14*2-6H		3P	M14	2	11		110	30		4	B	12	○
4201AS-M14*2-6H		1.5P	M14	2	11		110	30		4	B	12	○
4201A-M16*1.5-6H		3P	M16	1.5	12		110	32		4	B	14.5	○
4201AS-M16*1.5-6H		1.5P	M16	1.5	12		110	32		4	B	14.5	○
4201A-M16*2-6H		3P	M16	2	12		110	32		4	B	14	○
4201A-M16*2-6HX		3P	M16	2	12		110	32		4	B	14	○
4201AS-M16*2-6H		1.5P	M16	2	12		110	32		4	B	14	○
4201AS-M16*2-6HX		1.5P	M16	2	12		110	32		4	B	14	○

● Ex stock ○ On demand
✲ With internal cooling

Application field

P	M	K	N	S	H
			✔		

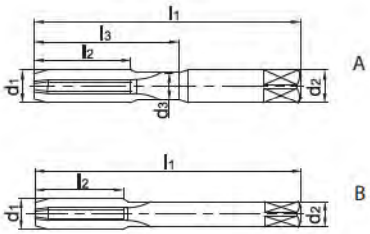
✔ Very suitable
✔ Suitable

System code C144 | Machining instructions C165 | Cutting data C160 | Nonstandard order C182

Tap, straight flute — Non-ferrous metals

4202A

– Type of shank DIN 10
– Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4202A-M3*0.5-6H		3P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4202A-M3*0.5-6HX		3P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4202AS-M3*0.5-6H		1.5P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4202AS-M3*0.5-6HX		1.5P	M3	0.5	3.5	2.3	56	11	18	3	A	2.5	○
4202A-M4*0.7-6H		3P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4202A-M4*0.7-6HX		3P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4202AS-M4*0.7-6H		1.5P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4202AS-M4*0.7-6HX		1.5P	M4	0.7	4.5	3.1	63	13	21	3	A	3.3	○
4202A-M5*0.8-6H		3P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4202A-M5*0.8-6HX		3P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4202AS-M5*0.8-6H		1.5P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4202AS-M5*0.8-6HX		1.5P	M5	0.8	6	4	70	16	25	3	A	4.2	○
4202A-M6*0.75-6H		3P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4202A-M6*0.75-6HX		3P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4202AS-M6*0.75-6H		1.5P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4202AS-M6*0.75-6HX		1.5P	M6	0.75	6	5	80	19	30	3	A	5.25	○
4202A-M6*1-6H		3P	M6	1	6	4.7	80	19	30	3	A	5	○
4202AC-M6*1-6H	✻	3P	M6	1	6	4.7	80	19	30	3	A	5	○
4202A-M6*1-6HX		3P	M6	1	6	4.7	80	19	30	3	A	5	○
4202AS-M6*1-6H		1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4202ACS-M6*1-6H	✻	1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4202AS-M6*1-6HX		1.5P	M6	1	6	4.7	80	19	30	3	A	5	○
4202A-M7*1-6H		3P	M7	1	7	5.7	80	19	30	3	A	6	○
4202AS-M7*1-6H		1.5P	M7	1	7	5.7	80	19	30	3	A	6	○
4202A-M8*1-6H		3P	M8	1	8	6.7	90	20	35	3	A	7	○
4202AS-M8*1-6H		1.5P	M8	1	8	6.7	90	20	35	3	A	7	○
4202A-M8*1.25-6H		3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202AC-M8*1.25-6H	✻	3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202A-M8*1.25-6HX		3P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202AS-M8*1.25-6H		1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202ACS-M8*1.25-6H	✻	1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202AS-M8*1.25-6HX		1.5P	M8	1.25	8	6.4	90	22	35	3	A	6.75	○
4202A-M10*1-6H		3P	M10	1	10	8.7	100	20	39	4	A	9	○

● Ex stock ○ On demand
✻ With internal cooling

Application field

P	M	K	N	S	H
			✔		

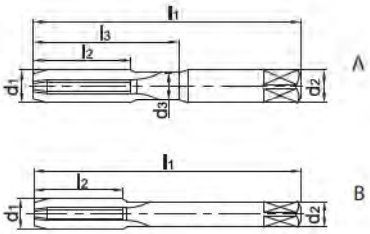
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Tap, straight flute — Non-ferrous metals

4202A

- Type of shank DIN 10
- Coolant exit, axial concentric



Article	*	Dimensions [mm]								Teeth	Geometry	Coredrill	Grade
			d_1	P	d_2	d_3	l_1	l_2	l_3			d	YK40F
4202AS-M10*1-6H		1.5P	M10	1	10	8.7	100	20	39	4	A	9	○
4202A-M10*1.25-6H		3P	M10	1.25	10	8.4	100	24	39	4	A	8.75	○
4202AS-M10*1.25-6H		1.5P	M10	1.25	10	8.4	100	24	39	4	A	8.75	○
4202A-M10*1.5-6H		3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202AC-M10*1.5-6H	*	3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202A-M10*1.5-6HX		3P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202AS-M10*1.5-6H		1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202ACS-M10*1.5-6H	*	1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202AS-M10*1.5-6HX		1.5P	M10	1.5	10	8.1	100	24	39	4	A	8.5	○
4202A-M12*1.25-6H		3P	M12	1.25	9		110	29		4	B	10.75	○
4202AS-M12*1.25-6H		1.5P	M12	1.25	9		110	29		4	B	10.75	○
4202A-M12*1.5-6H		3P	M12	1.5	9		110	29		4	B	10.5	○
4202AS-M12*1.5-6H		1.5P	M12	1.5	9		110	29		4	B	10.5	○
4202A-M12*1.75-6H		3P	M12	1.75	9		110	29		4	B	10.25	○
4202AC-M12*1.75-6H	*	3P	M12	1.75	9		110	29		4	B	10.25	○
4202A-M12*1.75-6HX		3P	M12	1.75	9		110	29		4	B	10.25	○
4202AS-M12*1.75-6H		1.5P	M12	1.75	9		110	29		4	B	10.25	●
4202ACS-M12*1.75-6H	*	1.5P	M12	1.75	9		110	29		4	B	10.25	○
4202AS-M12*1.75-6HX		1.5P	M12	1.75	9		110	29		4	B	10.25	○
4202A-M14*1.5-6H		3P	M14	1.5	11		110	30		4	B	12.5	○
4202AS-M14*1.5-6H		1.5P	M14	1.5	11		110	30		4	B	12.5	○
4202A-M14*2-6H		3P	M14	2	11		110	30		4	B	12	○
4202AS-M14*2-6H		1.5P	M14	2	11		110	30		4	B	12	○
4202A-M16*1.5-6H		3P	M16	1.5	12		110	32		4	B	14.5	○
4202AS-M16*1.5-6H		1.5P	M16	1.5	12		110	32		4	B	14.5	○
4202A-M16*2-6H		3P	M16	2	12		110	32		4	B	14	○
4202A-M16*2-6HX		3P	M16	2	12		110	32		4	B	14	○
4202AS-M16*2-6H		1.5P	M16	2	12		110	32		4	B	14	○
4202AS-M16*2-6HX		1.5P	M16	2	12		110	32		4	B	14	○

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
			✔		

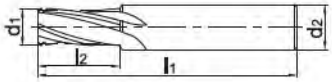
✔ Very suitable
✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Thread milling cutter, coated — Steel, cast iron, non-ferrous metals

4111

– Factory standard



Article	✲	Dimensions [mm]						Teeth	Coredrill	Grade	
		D	d_1	P	d_2	l_1	l_2		d	KTG4015	YK40F
4111-M3*0.5		M3	2.35	0.5	4	50	6	3	2.5	●	●
4111-M4*0.7		M4	3.15	0.7	4	50	8	3	3.3	●	○
4111-M5*0.8		M5	4	0.8	6	50	10	3	4.2	●	○
4111-M5*0.5		M5	4.3	0.5	6	50	10	3	4.5	●	○
4111-M6*1		M6	4.75	1	6	60	12	4	5	●	●
4111-M6*0.75		M6	5	0.75	6	60	12	4	5.25	○	○
4111-M8*1.25		M8	6.45	1.25	8	60	16	4	6.75	●	●
4111-M8*1		M8	6.65	1	8	60	16	4	7	●	○
4111-M10*1.5		M10	8.1	1.5	10	75	20	4	8.5	●	○
4111-M10*1		M10	8.55	1	10	75	20	4	9	●	○
4111-M12*1.75		M12	9.75	1.75	12	75	24	4	10.25	●	○
4111-M12*1.25		M12	10.25	1.25	12	75	24	4	10.75	●	○
4111-M14*2		M14	11.4	2	14	75	28	4	12	●	○
4111-M14*1.5		M14	11.9	1.5	14	75	28	4	12.5	●	○
4111-M14*1		M14	12.35	1	14	75	20	4	13	●	○
4111-M16*2		M16	13.3	2	16	90	32	6	14	●	○
4111-M18*2.5		M18	14.75	2.5	18	90	36	6	15.5	●	○
4111-M18*1		M18	16.15	1	18	90	20	6	17	●	○
4111-M20*2.5		M20	16.65	2.5	18	100	40	6	17.5	●	○
4111-M20*2		M20	17.1	2	18	100	40	6	18	●	○

● Ex stock ○ On demand

✲ With internal cooling

Application field

P	M	K	N	S	H
✔		✔	✔		

✔ Very suitable

✔ Suitable

System code > C144 Machining instructions > C165 Cutting data > C160 Nonstandard order > C182

Guide for recommended cutting data – Solid carbide threading tools

Solid carbide threading tools

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]							
						Thread former		Thread former				Thread former	
						4122A 4222A	4122M 4222M	4201C	4201A	4202C	4202A		
						YK40F	YK40F	YK40F	YK40F	YK40F	YK40F	KTG40115	
						Coolant							
						external	external	external	external	external	external	external	f-group
P	Unalloyed steel	ca. 0,15 % C	annealed	125	1		20					100	1
		ca. 0,45 % C	annealed	190	2		20					90	1
		ca. 0,45 % C	tempered	250	3		20					80	1
		ca. 0,75 % C	annealed	270	4		20					70	1
		ca. 0,75 % C	tempered	300	5		20					70	1
	Low-alloyed steel		annealed	180	6		20					90	1
			tempered	275	7		20					70	1
			tempered	300	8		20					60	1
			tempered	350	9		20					55	1
	High-alloyed steel and high-alloyed tool steel		annealed	200	10		20					80	1
			hardened and tempered	325	11		20					50	1
M	Stainless steel	ferritic/martensitic	annealed	200	12		20						
		martensitic	tempered	240	13		20						
		austenitic	quench hardened	180	14		20						
		austenitic-ferritic		230	15		20						
K	Grey cast iron	perlitic/ferritic		180	16			20		20		80	1
		[illegible]tic)		260	17			20		20		60	1
	Cast iron with spheroidal graphite	[illegible]		160	18			15		15		80	1
		[illegible]		250	19			15		15		60	1
	Malleable cast iron	[illegible]		130	20			20		20		60	1
		perlitic		230	21			20		20		80	1
N	Aluminium wrought alloys	cannot be hardened		60	22							180	1
		hardenable	hardened	100	23							150	1
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24	30	30		30		30	150	1
		≤ 12 % Si, hardenable	hardened	90	25	25	25		25		25	150	1
		> 12 % Si, cannot be hardened		130	26							150	1
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27							150	1
		CuZn, CuSnZn		90	28							150	1
		CuSn, Pb-free copper, electrolytic copper		100	29							150	1
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30								
			hardened	280	31								
		Ni or Co bass	annealed	250	32								
			hardened	350	33								
			cast	320	34								
	Titanium alloys	pure titanium		R_m 400	35								
		α and β alloys	hardened	R_m 1050	36								
H	Hardened steel		hardened and tempered	55 HRC	37								
			hardened and tempered	60 HRC	38								
	Hard cast iron		cast	400	39								
	Hardened cast iron		hardened and tempered	55 HRC	40								
X	Non-metallic materials	Thermoplasts			41								
		Thermosetting plastics			42								
		Plastic, glass-fibre reinforced GFRP			43								
		Plastic, carbon fibre reinforced CFRP			44								
		Graphite			45								
		Wood			46								

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
With hole depths of 5xD adjust the cutting data accordingly to the application.
f-group = feed rate recommendations on page C164.
For examples of material for cutting tool groups view page D22.

Recommend feed rate

Solid carbide threading tools

4

5

f-group	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10
2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,09	0,10	0,10	0,10	0,11	0,11	0,11
3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15	0,15
5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

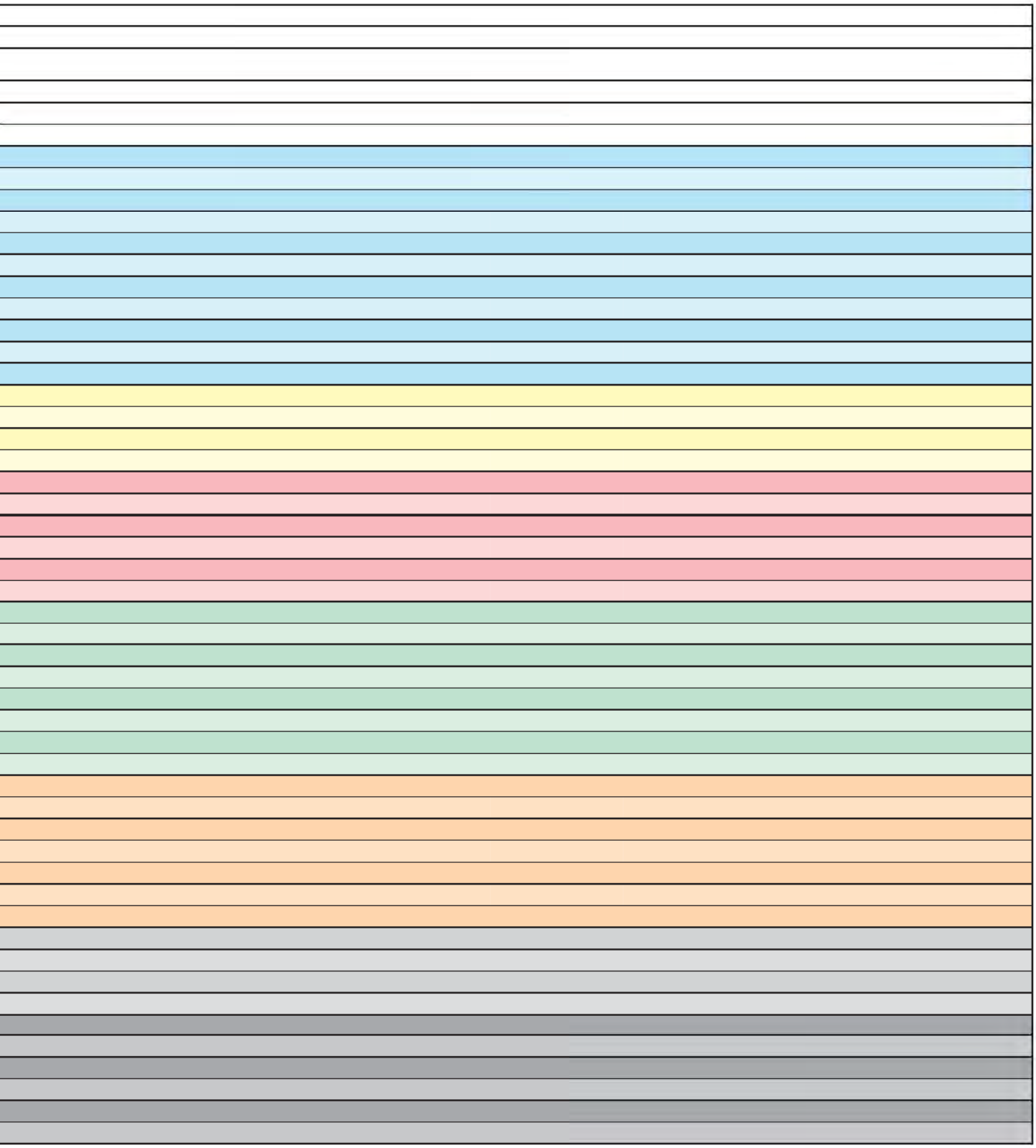
Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

1. Select the appropriate product series.
2. Determine the immersion.
3. Select the used material and read the cutting speed.
4. Determine the feed rate group and have a look at the appropriate feed rate recommendations.
5. Select the diameter of tool and determine the immersion.

Solid carbide threading tools

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]							
						Thread former		Thread tap				Thread milling	
						4122A 4222A	4122M 4222M	4201C	4201A	4202C	4202A	4111	
						YK40F	YK40F	YK40F	YK40F	YK40F	YK40F	KTG4015	
						Coolant							
						External	External	External	External	External	External	External	f-group
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1		20					100	1
		approx. 0,45 % C	annealed	190	2		20					90	1
		approx. 0,45 % C	tempered	250	3		20					80	1
		approx. 0,75 % C	annealed	270	4		20					70	1
		approx. 0,75 % C	tempered	300	5		20					70	1
	Low-alloyed steel		annealed	180	6		20					90	1
			tempered	275	7		20					70	1
			tempered	300	8		20					60	1
			tempered	350	9		20					55	1
	High-alloyed steel and high-alloyed tool steel		annealed	200	10		20					80	1
			hardened and tempered	325	11		20					50	1
M	Stainless steel	ferritic/martensitic	annealed	200	12		20						
		martensitic	tempered	240	13		20						
		austenitic	quench hardened	180	14		20						
		austenitic-ferritic		230	15		20						
K	Grey cast iron	perlitic/ferritic		180	16			20		20		80	1
		perlitic (martensitic)		260	17			20		20		60	1
	Cast iron with spheroidal graphite	ferritic		160	18			15		15		80	1
		perlitic		250	19			15		15		60	1
	Malleable cast iron	ferritic		130	20			20		20		60	1
		perlitic		230	21			20		20		80	1
N	Aluminium wrought alloys	cannot be hardened		60	22							180	1
		hardenable	hardened	100	23							150	1
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24	30	30		30		30	150	1
		≤ 12 % Si, hardenable	hardened	90	25	25	25		25		25	150	1
		> 12 % Si, cannot be hardened		130	26							150	1
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27							150	1
		CuZn, CuSnZn		90	28							150	1
		CuSn, Pb-free copper, electrolytic copper		100	29							150	1
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30								
			hardened	280	31								
		Ni or Co bass	annealed	250	32								
			hardened	350	33								
			cast	320	34								
	Titanium alloys	pure titanium		R_m 400	35								
		α and β alloys	hardened	R_m 1050	36								
H	Hardened steel		hardened and tempered	55 HRC	37								
			hardened and tempered	60 HRC	38								
	Hard cast iron		cast	400	39								
	Hardened cast iron		hardened and tempered	55 HRC	40								
X	Non-metallic materials	Thermoplasts			41								
		Thermosetting plastics			42								
		Plastic, glass-fibre reinforced GFRP			43								
		Plastic, carbon fibre reinforced CFRP			44								
		Graphite			45								
		Wood			46								

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
With hole depths of 5xD adjust the cutting data accordingly to the application.
f-group = feed rate recommendations on page C164.
For examples of material for cutting tool groups view page D22.



Recommended feed rate

Solid carbide threading tools

Groupe f	Feed rate [mm]																			
	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø11	Ø12	Ø13	Ø14	Ø15	Ø16	Ø17	Ø18	Ø19	Ø20
1	0,01	0,02	0,03	0,04	0,04	0,05	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10
2	0,01	0,02	0,03	0,04	0,05	0,06	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,09	0,10	0,10	0,10	0,11	0,11	0,11
3	0,01	0,02	0,04	0,05	0,06	0,06	0,07	0,07	0,08	0,09	0,09	0,10	0,10	0,11	0,11	0,12	0,12	0,12	0,13	0,13
4	0,02	0,03	0,04	0,06	0,06	0,07	0,08	0,09	0,09	0,10	0,11	0,11	0,12	0,12	0,13	0,13	0,14	0,14	0,15	0,15
5	0,02	0,03	0,05	0,06	0,07	0,09	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,14	0,15	0,15	0,16	0,16	0,17	0,17
6	0,02	0,04	0,06	0,07	0,09	0,10	0,11	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	0,18	0,18	0,19	0,19	0,20
7	0,02	0,04	0,06	0,09	0,10	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,18	0,19	0,20	0,20	0,21	0,22	0,22	0,23
8	0,03	0,05	0,07	0,10	0,11	0,13	0,14	0,15	0,16	0,17	0,18	0,20	0,21	0,22	0,23	0,23	0,24	0,25	0,26	0,26
9	0,03	0,06	0,08	0,11	0,13	0,15	0,16	0,17	0,18	0,20	0,21	0,23	0,24	0,25	0,26	0,27	0,28	0,29	0,29	0,30
10	0,04	0,07	0,10	0,13	0,15	0,17	0,19	0,20	0,21	0,23	0,24	0,26	0,27	0,29	0,30	0,31	0,32	0,33	0,34	0,35
11	0,04	0,07	0,11	0,15	0,17	0,20	0,21	0,23	0,24	0,26	0,28	0,30	0,32	0,33	0,35	0,36	0,37	0,38	0,39	0,40
12	0,05	0,09	0,13	0,17	0,20	0,23	0,25	0,26	0,28	0,30	0,32	0,35	0,36	0,38	0,40	0,41	0,42	0,44	0,45	0,46
13	0,05	0,10	0,15	0,20	0,23	0,26	0,28	0,30	0,32	0,35	0,37	0,40	0,42	0,44	0,46	0,47	0,49	0,50	0,52	0,53
14	0,06	0,11	0,17	0,23	0,26	0,30	0,33	0,35	0,37	0,40	0,43	0,46	0,48	0,50	0,53	0,54	0,56	0,58	0,59	0,61
15	0,07	0,13	0,20	0,26	0,30	0,35	0,37	0,40	0,43	0,46	0,49	0,53	0,55	0,58	0,61	0,62	0,64	0,66	0,68	0,70

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.