

CARBIDE

HSS

STRAIGHT SHANK DRILLS

D2107 SERIES

HSSCo8, STRAIGHT SHANK TWIST DRILLS

HSSCo8, SPIRALBOHRER mit ZYLINDERSCHAFT

Forets HSSCo8, queue cylindrique, Forme C, série extra-courte

PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

STUB

EXTRA KURZ

EXTRA-COURTE

EXTRA CORTA

►Surface treatment : Coloring(Gold color)

►Application : Suitable for drilling thin materials with portable electric drills.
Special twist drills for automatic and turret lathes

►Oberflächenbehandlung : Coloring(Goldfarbe)

►Verwendung : Sonderbohrer zum Einsatz auf Automaten und Revolverdrehbänken.
Geeignet für den Einsatz in Handbohrmaschinen zum Bohren von dünnwandigem Material.

under 1.6mm

1.6mm & over

DIN 1897

HSS Co8

33°

h8

135°

Gold Coloring

p.A262

Recommended ToolHolder

ER COLLET CHUCK

Page D73 - 115

EDP No.

Drill Diameter

Flute Length

Overall Length

D1

L1

L2

D2107010	1.0	6	26
D2107011	1.1	7	28
D2107012	1.2	8	30
D2107912	1.25	8	30
D2107013	1.3	8	30
D2107014	1.4	9	32
D2107015	1.5	9	32
D2107016	1.6	10	34
D2107017	1.7	10	34
D2107917	1.75	11	36
D2107018	1.8	11	36
D2107019	1.9	11	36
D2107020	2.0	12	38
D2107021	2.1	12	38
D2107022	2.2	13	40
D2107922	2.25	13	40
D2107023	2.3	13	40
D2107024	2.4	14	43
D2107025	2.5	14	43
D2107026	2.6	14	43
D2107027	2.7	16	46
D2107927	2.75	16	46
D2107028	2.8	16	46
D2107029	2.9	16	46
D2107030	3.0	16	46
D2107031	3.1	18	49

EDP No.

Drill Diameter

Flute Length

Overall Length

D1

L1

L2

D2107032	3.2	18	49
D2107932	3.25	18	49
D2107033	3.3	18	49
D2107034	3.4	20	52
D2107035	3.5	20	52
D2107036	3.6	20	52
D2107037	3.7	20	52
D2107937	3.75	20	52
D2107038	3.8	22	55
D2107039	3.9	22	55
D2107040	4.0	22	55
D2107041	4.1	22	55
D2107042	4.2	22	55
D2107942	4.25	22	55
D2107043	4.3	24	58
D2107044	4.4	24	58
D2107045	4.5	24	58
D2107046	4.6	24	58
D2107946	4.65	24	58
D2107047	4.7	24	58
D2107947	4.75	24	58
D2107048	4.8	26	62
D2107049	4.9	26	62
D2107050	5.0	26	62
D2107051	5.1	26	62
D2107052	5.2	26	62

► HSS-E(DL107) is available on your request.

► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

◎ : Excellent ○ : Good

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

ISO	N										S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc																				
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	42
Recommended	○	○	○													○				

A220

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EDP No.

Drill Diameter

Flute Length

Overall Length

D1

L1

L2

D2107952	5.25	26	62
D2107053	5.3	26	62
D2107054	5.4	28	66
D2107055	5.5	28	66
D2107955	5.55	28	66
D2107056	5.6	28	66
D2107057	5.7	28	66
D2107957	5.75	28	66
D2107058	5.8	28	66
D2107059	5.9	28	66
D2107060	6.0	28	66
D2107061	6.1	31	70
D2107062	6.2	31	70
D2107962	6.25	31	70
D2107063	6.3	31	70
D2107064	6.4	31	70
D2107065	6.5	31	70
D2107066	6.6	31	70
D2107067	6.7	31	70
D2107967	6.75	34	74
D2107068	6.8	34	74
D2107069	6.9	34	74
D2107070	7.0	34	74
D2107071	7.1	34	74
D2107072	7.2	34	74
D2107972	7.25	34	74

EDP No.

Drill Diameter

Flute Length

Overall Length

D1

L1

L2

D2107073	7.3	34	74
D2107074	7.4	34	74
D2107974	7.45	34	74
D2107075	7.5	34	74
D2107076	7.6	37	79
D2107077	7.7	37	79
D2107977	7.75	37	79
D2107078	7.8	37	79
D2107079	7.9	37	79
D2107080	8.0	37	79
D2107081	8.1	37	79
D2107082	8.2	37	79
D2107982	8.25	37	79
D2107083	8.3	37	79
D2107084	8.4	37	79
D2107085	8.5	37	79
D2107086	8.6	40	84
D2107087	8.7	40	84
D2107987	8.75	40	84
D2107088	8.8	40	84
D2107089	8.9	40	84
D2107090	9.0	40	84
D2107091	9.1	40	84
D2107092	9.2	40	84
D2107992	9.25	40	84
D2107093	9.3	40	84

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◎ : Excellent ○ : Good

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

ISO	N										S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc																				
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	400 Rm	1050 Rm	55	60	42
Recommended	○	○	○													○				

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under 1.6mm

1.6mm & over

L1

L2

D1

DIN 1897

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Recommended ToolHolder

ER COLLET CHUCK

Page D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2107993	9.35	40	84
D2107094	9.4	40	84
D2107095	9.5	40	84
D2107096	9.6	43	89
D2107097	9.7	43	89
D2107997	9.75	43	89
D2107098	9.8	43	89
D2107099	9.9	43	89
D2107100	10.0	43	89
D2107102	10.2	43	89
D2107802	10.25	43	89
D2107105	10.5	43	89
D2107807	10.75	47	95
D2107110	11.0	47	95
D2107812	11.25	47	95
D2107115	11.5	47	95
D2107817	11.75	47	95
D2107118	11.8	47	95
D2107120	12.0	51	102
D2107822	12.25	51	102
D2107125	12.5	51	102
D2107827	12.75	51	102
D2107130	13.0	51	102
D2107832	13.25	54	107
D2107135	13.5	54	107
D2107837	13.75	54	107

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2107138	13.8	54	107
D2107140	14.0	54	107
D2107842	14.25	56	111
D2107145	14.5	56	111
D2107847	14.75	56	111
D2107150	15.0	56	111
D2107852	15.25	58	115
D2107155	15.5	58	115
D2107857	15.75	58	115
D2107160	16.0	58	115
D2107862	16.25	60	119
D2107165	16.5	60	119
D2107867	16.75	60	119
D2107170	17.0	60	119
D2107872	17.25	62	123
D2107175	17.5	62	123
D2107877	17.75	62	123
D2107180	18.0	62	123
D2107882	18.25	64	127
D2107185	18.5	64	127
D2107887	18.75	64	127
D2107190	19.0	64	127
D2107892	19.25	66	131
D2107195	19.5	66	131
D2107897	19.75	66	131
D2107200	20.0	66	131

Unit : mm

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► TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

◎ : Excellent ○ : Good

ISO

Material Description

VDI 3323

HRc

HB

Recommended

P

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

M

Stainless steel

Grey cast iron

Nodular cast iron

Malleable cast iron

K

N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

H

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

17

18

19

20

125

190

250

270

300

180

275

300

350

200

325

200

240

180

180

260

160

250

130

230

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Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

H

21

22

23

24

25

26

27

28

29

30

31

32

33

34

35

36

37

38

39

40

41

60

100

75

90

130

110

90

100

15

30

25

38

34

200

280

250

350

320

400 Rm

1050 Rm

55

60

42

55

550

○

○

○

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under 1.6mm

1.6mm & over

L1

L2

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ER COLLET CHUCK

Page D73 - 115

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2107205	20.5	68	136
D2107210	21.0	68	136
D2107215	21.5	70	141
D2107220	22.0	70	141
D2107225	22.5	72	146
D2107230	23.0	72	146
D2107235	23.5	72	146
D2107240	24.0	75	151

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2107245	24.5	75	151
D2107250	25.0	75	151
D2107260	26.0	78	156
D2107270	27.0	81	162
D2107280	28.0	81	162
D2107290	29.0	84	168
D2107300	30.0	84	168
D2107310	31.0	87	174

Unit : mm

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◎ : Excellent ○ : Good

ISO

Material Description

VDI 3323

HRc

HB

Recommended

P

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

M

Stainless steel

Grey cast iron

Nodular cast iron

Malleable cast iron

K

N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

H

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

17

18

19

20

125

190

250

270

300

180

275

300

350

200

325

200

240

180

180

260

160

250

130

230

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H

21

22

23

24

25

26

27

28

29

30

31

32

33

34

35

36

37

38

39

40

41

60

100

75

90

130

110

90

100

15

30

25

38

34

200

280

250

350

320

400 Rm

1050 Rm

55

60

42

55

550

○

○

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D2107235	23.5	72	146
D2107240	24.0	75	151

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Non Metallic Materials

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Heat Resistant Super Alloys

Titanium Alloys

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

H

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

17

18

19

20

125

190

250

270

300

180

275

300

350

200

325

200

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250

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230

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H

21

22

23

24

25

26

27

28

29

30

31

32

33

34

35

36

37

38

39

40

41

60

100

75

90

130

110

90

100

15

30

25

38

34

200

280

250

350

320

400 Rm

1050 Rm

55

60

42

55

550

○

○

○

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