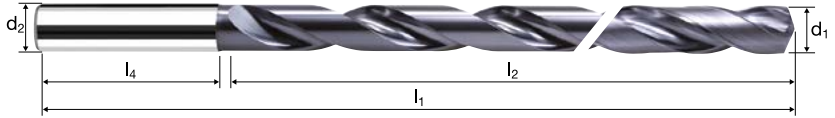
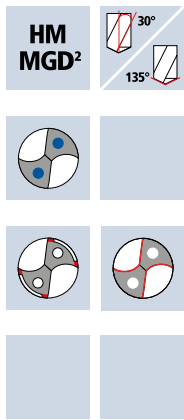


Deep hole drills

20xd

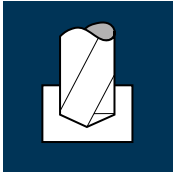


Rm < 850	Rm 850-1100	Rm 1100-1300								GG(G)
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Example: Order-N°.		Article-N°.		σ-Code							DURO-D ²	
		B52920		0300							B52920	
∅ Code	d ₁ h7	d ₂ h6	l ₁	l ₂	l ₄	L _{max}						
0300	3.00	4.0	110.0	74.0	32	69.5						●
0350	3.50	4.0	120.0	86.0	32	81.0						●
0400	4.00	4.0	120.0	86.0	32	80.0						●
0450	4.50	5.0	135.0	98.0	34	91.5						●
0500	5.00	5.0	145.0	109.0	34	101.5						●
0550	5.50	6.0	160.0	120.0	36	112.0						●
0600	6.00	6.0	170.0	130.0	36	121.0						●
0700	7.00	7.0	190.0	150.0	38	139.5						●
0800	8.00	8.0	215.0	173.0	40	161.0						●
0900	9.00	9.0	240.0	196.0	40	182.5						●
1000	10.00	10.0	260.0	218.0	40	203.0						●
1100	11.00	11.0	285.0	238.0	45	221.5						●
1200	12.00	12.0	305.0	258.0	45	240.0						●
1300	13.00	13.0	330.0	283.0	45	263.5						●
1400	14.00	14.0	355.0	303.0	50	282.0						●
1500	15.00	15.0	375.0	323.0	50	300.5						●
1600	16.00	16.0	400.0	348.0	50	324.0						●
See page «Technical notes regarding use of deep hole drills»												
A pilot hole is required!												

Application

Material



Steel
< 500 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



Cast iron
(lamellar / spheroidal)



d ₁ [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
3.00	100	0.1200	10610	1273	9.0
4.00	100	0.1200	7960	955	12.0
5.00	100	0.1200	6365	764	15.0
6.00	100	0.1500	5305	796	22.5
8.00	100	0.1500	3980	597	30.0
10.00	100	0.2000	3185	637	50.0
12.00	100	0.2000	2655	531	60.1
14.00	100	0.2400	2275	546	84.1
16.00	100	0.2400	1990	478	96.0
3.00	75	0.1150	7960	915	6.5
4.00	75	0.1150	5970	687	8.6
5.00	75	0.1150	4775	549	10.8
6.00	75	0.1450	3980	577	16.3
8.00	75	0.1450	2985	433	21.8
10.00	75	0.1900	2385	453	35.6
12.00	75	0.1900	1990	378	42.8
14.00	75	0.2300	1705	392	60.4
16.00	75	0.2300	1490	343	68.9
3.00	50	0.1000	5305	531	3.7
4.00	50	0.1000	3980	398	5.0
5.00	50	0.1000	3185	319	6.3
6.00	50	0.1400	2655	372	10.5
8.00	50	0.1400	1990	279	14.0
10.00	50	0.1800	1590	286	22.5
12.00	50	0.1800	1325	239	27.0
14.00	50	0.2200	1135	250	38.4
16.00	50	0.2200	995	219	44.0
3.00	35	0.0900	3715	334	2.4
4.00	35	0.0900	2785	251	3.2
5.00	35	0.0900	2230	201	3.9
6.00	35	0.1250	1855	232	6.6
8.00	35	0.1250	1395	174	8.8
10.00	35	0.1600	1115	178	14.0
12.00	35	0.1600	930	149	16.8
14.00	35	0.2000	795	159	24.5
16.00	35	0.2000	695	139	27.9
3.00	40	0.1000	4245	425	3.0
4.00	40	0.1000	3185	319	4.0
5.00	40	0.1000	2545	255	5.0
6.00	40	0.1400	2120	297	8.4
8.00	40	0.1400	1590	223	11.2
10.00	40	0.1800	1275	230	18.0
12.00	40	0.1800	1060	191	21.6
14.00	40	0.2200	910	200	30.8
16.00	40	0.2200	795	175	35.2
3.00	80	0.1600	8490	1358	9.6
4.00	80	0.1600	6365	1018	12.8
5.00	80	0.1600	5095	815	16.0
6.00	80	0.2100	4245	892	25.2
8.00	80	0.2100	3185	669	33.6
10.00	80	0.2600	2545	662	52.0
12.00	80	0.2600	2120	551	62.3
14.00	80	0.3200	1820	582	89.7
16.00	80	0.3200	1590	509	102.3