

YG NC-SPOTTING DRILLS

D2307 SERIES

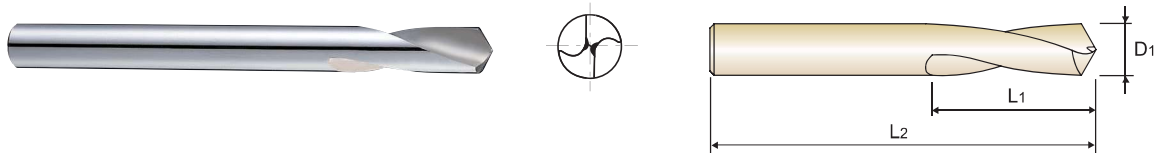
D2322 SERIES

HSSCo8, NC-SPOTTING DRILLS 120°

- HSSCo8, NC-ANBOHRER 120°
- Forets HSSCo8 à pointer NC 120°
- PUNTE A CENTRARE NC 120°, HSSCo8

► **Application** : For more precise centering work on NC/CNC Machines.
The large diameter of the tool permits chamfering work after centering continuously.

► **Verwendung** : Für positionsgenau und schnelles Anbohren mit NC/CNC-Maschinen und Bearbeitungszentren, die Ausführung mit Spitzenwinkel 90° ermöglicht sowohl ein Zentrieren, als auch das Vorbohren für einen nächstgrößeren Durchmesser.



NC
HSS Co8
h6
h6
120°
P.305-306

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2307030	3.0	12	46
D2307040	4.0	12	55
D2307050	5.0	15	60
D2307060	6.0	20	66
D2307080	8.0	25	79
D2307100	10.0	25	89
D2307120	12.0	30	102
D2307160	16.0	35	115
D2307200	20.0	40	131

LONG LENGTH

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2322060	6.0	20	140
D2322080	8.0	25	140
D2322100	10.0	25	170
D2322120	12.0	30	170

► TiN, TiCN and TiAlN are available on your request.

ISO	P										M				K								
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
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	130	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					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○																		

⊙ : Excellent ○ : Good

HSS

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA

D5306, D5307, D5320 SERIES

CARBIDE, NC-SPOTTING DRILLS

RPM = rev./min.
FEED = mm/rev.

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)									
					2.0	3.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0	
P	1	Non-alloy steel	75	RPM FEED	11940 0.02-0.04	7960 0.04-0.06	5970 0.05-0.08	3980 0.07-0.10	2980 0.08-0.12	2390 0.09-0.14	1990 0.11-0.17	1490 0.13-0.19	1190 0.15-0.21	
	2		70	RPM FEED	11140 0.02-0.04	7430 0.04-0.06	5570 0.05-0.08	3710 0.07-0.10	2790 0.08-0.12	2230 0.09-0.14	1860 0.11-0.17	1390 0.13-0.19	1110 0.15-0.21	
	3		65	RPM FEED	10350 0.01-0.03	6900 0.03-0.05	5170 0.04-0.07	3450 0.05-0.08	2590 0.07-0.10	2070 0.08-0.12	1720 0.09-0.14	1290 0.11-0.17	1030 0.13-0.19	
	4													
	5													
	6	Low alloy steel	70	RPM FEED	11140 0.02-0.04	7430 0.04-0.06	5570 0.05-0.08	3710 0.07-0.10	2790 0.08-0.12	2230 0.09-0.14	1860 0.11-0.17	1390 0.13-0.19	1110 0.15-0.21	
	7		55	RPM FEED	8750 0.01-0.03	5840 0.03-0.05	4380 0.04-0.07	2920 0.05-0.08	2190 0.07-0.10	1750 0.08-0.12	1460 0.09-0.14	1090 0.11-0.17	880 0.13-0.19	
	8													
	9													
	10		High alloyed steel, and tool steel											
	11													
M	12	Stainless steel	35	RPM FEED	5570 0.02-0.04	3710 0.04-0.06	2790 0.05-0.08	1860 0.07-0.10	1390 0.08-0.12	1110 0.09-0.14	930 0.11-0.17	700 0.13-0.19	560 0.15-0.21	
	13													
	14													
K	15	Grey cast iron	90	RPM FEED	14320 0.03-0.05	9550 0.05-0.07	7160 0.06-0.09	4770 0.08-0.11	3580 0.10-0.13	2860 0.12-0.16	2390 0.15-0.20	1790 0.18-0.24	1430 0.22-0.28	
	16		70	RPM FEED	11140 0.01-0.03	7430 0.03-0.05	5570 0.04-0.07	3710 0.05-0.08	2790 0.07-0.10	2230 0.08-0.12	1860 0.09-0.14	1390 0.11-0.17	1110 0.13-0.19	
	17	Nodular cast iron	90	RPM FEED	14320 0.03-0.05	9550 0.05-0.07	7160 0.06-0.09	4770 0.08-0.11	3580 0.10-0.13	2860 0.12-0.16	2390 0.15-0.20	1790 0.18-0.24	1430 0.22-0.28	
	18													
	19	Malleable cast iron	60	RPM FEED	9550 0.03-0.05	6370 0.05-0.07	4770 0.06-0.09	3180 0.08-0.11	2390 0.10-0.13	1910 0.12-0.16	1590 0.15-0.2	1190 0.18-0.24	950 0.22-0.28	
	20													
N	21	Aluminum-wrought alloy	165	RPM FEED	26260 0.04-0.06	17510 0.06-0.09	13130 0.08-0.11	8750 0.10-0.13	6570 0.12-0.15	5250 0.15-0.19	4380 0.18-0.23	3280 0.21-0.27	2630 0.25-0.31	
	22		130	RPM FEED	20690 0.04-0.06	13790 0.06-0.09	10350 0.08-0.11	6900 0.10-0.13	5170 0.12-0.15	4140 0.15-0.19	3450 0.18-0.23	2590 0.21-0.27	2070 0.25-0.31	
	23	Aluminum-cast, alloyed	110	RPM FEED	17510 0.04-0.06	11670 0.06-0.09	8750 0.08-0.11	5840 0.10-0.13	4380 0.12-0.15	3500 0.15-0.19	2920 0.18-0.23	2190 0.21-0.27	1750 0.25-0.31	
	24													
	25													
	26													
	27		Copper and Copper Alloys (Bronze / Brass)											
	28													
	29		Non Metallic Materials											
	30													
S	31	Heat Resistant Super Alloys												
	32													
	33													
	34													
	35													
	36	Titanium Alloys	35	RPM FEED	5570 0.01-0.03	3710 0.03-0.05	2790 0.04-0.06	1860 0.05-0.08	1390 0.07-0.10	1110 0.08-0.12	930 0.09-0.14	700 0.11-0.17	560 0.13-0.19	
	37													
H	38	Hardened steel												
	39													
	40	Chilled Cast Iron												
	41	Hardened Cast Iron												

HSS

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA



NC-SPOTTING DRILLS

RECOMMENDED CUTTING CONDITIONS EMPFOLHENE SCHNEIDPARAMETER

D2320, D2321, D2322, D2323, D2306, D2307 SERIES

HSSCo8, NC-SPOTTING DRILLS

RPM = rev./min.
FEED = mm/rev.

- i-ONE DRILLS
- i-DREAM DRILLS
- DREAM DRILLS -GENERAL
- DREAM DRILLS -HIGH FEED
- DREAM DRILLS -FLAT BOTTOM
- DREAM DRILLS -INOX
- DREAM DRILLS -ALU
- DREAM DRILLS -CFRP
- DREAM DRILLS -MQL
- DREAM DRILLS for HIGH HARDENED STEELS
- GENERAL CARBIDE DRILLS
- MULTI-1 DRILLS
- HPD DRILLS
- GOLD-P DRILLS
- SUPER-GP DRILLS
- STRAIGHT SHANK DRILLS
- TAPER SHANK DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- SPADE DRILLS
- REAMERS
- COUNTER SINKS
- COUNTER BORES
- TECHNICAL DATA

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)									
					2.0	3.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0	
P	1	Non-alloy steel	25	RPM FEED	3980 0.02-0.04	2650 0.04-0.06	1990 0.05-0.08	1330 0.07-0.10	990 0.08-0.12	800 0.09-0.14	660 0.11-0.17	500 0.13-0.19	400 0.15-0.21	
	2		25	RPM FEED	3980 0.02-0.04	2650 0.04-0.06	1990 0.05-0.08	1330 0.07-0.10	990 0.08-0.12	800 0.09-0.14	660 0.11-0.17	500 0.13-0.19	400 0.15-0.21	
	3		15	RPM FEED	2390 0.01-0.03	1590 0.03-0.05	1190 0.04-0.07	800 0.05-0.08	600 0.07-0.10	480 0.08-0.12	400 0.09-0.14	300 0.11-0.17	240 0.13-0.19	
	4													
	5													
	6	Low alloy steel	20	RPM FEED	3180 0.02-0.04	2120 0.04-0.06	1590 0.05-0.08	1060 0.07-0.10	800 0.08-0.12	640 0.09-0.14	530 0.11-0.17	400 0.13-0.19	320 0.15-0.21	
	7		15	RPM FEED	2390 0.01-0.03	1590 0.03-0.05	1190 0.04-0.07	800 0.05-0.08	600 0.07-0.10	480 0.08-0.12	400 0.09-0.14	300 0.11-0.17	240 0.13-0.19	
	8													
	9													
	10		High alloyed steel, and tool steel											
	11													
M	12	Stainless steel	15	RPM FEED	2390 0.02-0.04	1590 0.04-0.06	1190 0.05-0.08	800 0.07-0.10	600 0.08-0.12	480 0.09-0.14	400 0.11-0.17	300 0.13-0.19	240 0.15-0.21	
	13													
	14													
K	15	Grey cast iron	30	RPM FEED	4770 0.03-0.05	3180 0.05-0.07	2390 0.06-0.09	1590 0.08-0.11	1190 0.10-0.13	950 0.12-0.16	800 0.15-0.20	600 0.18-0.24	480 0.22-0.28	
	16		25	RPM FEED	3980 0.01-0.03	2650 0.03-0.05	1990 0.04-0.07	1330 0.05-0.08	990 0.07-0.10	800 0.08-0.12	660 0.09-0.14	500 0.11-0.17	400 0.13-0.19	
	17	Nodular cast iron	30	RPM FEED	4770 0.03-0.05	3180 0.05-0.07	2390 0.06-0.09	1590 0.08-0.11	1190 0.10-0.13	950 0.12-0.16	800 0.15-0.20	600 0.18-0.24	480 0.22-0.28	
	18													
	19		Malleable cast iron	20	RPM FEED	3180 0.03-0.05	2120 0.05-0.07	1590 0.06-0.09	1060 0.08-0.11	800 0.10-0.13	640 0.12-0.16	530 0.15-0.20	400 0.18-0.24	320 0.22-0.28
20														
N	21	Aluminum-wrought alloy	65	RPM FEED	10350 0.04-0.06	6900 0.06-0.09	5170 0.08-0.11	3450 0.10-0.13	2590 0.12-0.15	2070 0.15-0.19	1720 0.18-0.23	1290 0.21-0.27	1030 0.25-0.31	
	22		60	RPM FEED	9550 0.04-0.06	6370 0.06-0.09	4770 0.08-0.11	3180 0.10-0.13	2390 0.12-0.15	1910 0.15-0.19	1590 0.18-0.23	1190 0.21-0.27	950 0.25-0.31	
	23	Aluminum-cast, alloyed	50	RPM FEED	7960 0.04-0.06	5310 0.06-0.09	3980 0.08-0.11	2650 0.10-0.13	1990 0.12-0.15	1590 0.15-0.19	1330 0.18-0.23	990 0.21-0.27	800 0.25-0.31	
	24													
	25													
	26		Copper and Copper Alloys (Bronze / Brass)											
	27													
	28													
	29		Non Metallic Materials											
	30													
S	31	Heat Resistant Super Alloys												
	32													
	33													
	34													
	35													
H	36	Titanium Alloys												
	37													
H	38	Hardened steel												
	39													
	40		Chilled Cast Iron											
41	Hardened Cast Iron													