

CARBIDE



Being the best through innovation



NC-SPOTTING DRILLS


NC-ANBOHRER

- CENTERING and CHAMFERING
- Zentrier & Abfasen

SELECTION GUIDE

SOLID CARBIDE NC-SPOTTING DRILLS

For General materials, Cast steels, Cast iron, Non-ferrous materials

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
D5306 D5307		CARBIDE, NC-SPOTTING DRILLS VOLLHARTMETALL NC-ANBOHRER	D6.0	D20.0	96
		RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN			97

SOLID CARBIDE NC-SPOTTING DRILLS

◎ : Excellent
○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
			HRc45~55	HRc55~							
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	◎			○	○	○	○	○		



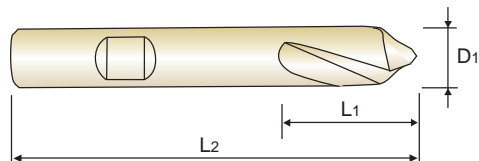
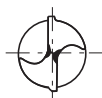
D5306 SERIES

D5307 SERIES

CARBIDE, NC-SPOTTING DRILLS VOLLHARTMETALL NC-ANBOHRER

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

► **Verwendung** : Auf NC-Maschinen, Lehrenbohrwerken u.a. kapitalintensiven Bohrwerken, zum Zentrieren und Anfasen von Gewindebohrungen in einem Arbeitsgang. Besonders geeignet zum Anbohren von hochfesten Stählen, Stahlguß, Grauguß, Hartguß, Mangan-Hartstahl, CrNi-Stählen, Bronze, Leicht- und Buntmetallen.



NC-Spotting drills 90° NC-Anbohrer 90°

EDP No.	Drill Diameter	Flute Length	Overall Length
	D ₁	L ₁	L ₂
D5306060	6.0	13	50
D5306080	8.0	23	60
D5306100	10.0	24	70
D5306120	12.0	24	70
D5306160	16.0	29	75
D5306200	20.0	35	100

NC-Spotting drills 120° NC-Anbohrer 120°

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D ₁	L ₁	L ₂
D5307060	6.0	13	50
D5307080	8.0	23	60
D5307100	10.0	24	70
D5307120	12.0	24	70
D5307160	16.0	29	75
D5307200	20.0	35	100

► TiN(D6407), TiCN(DG407) and TiAlN(DH407) are available on your request.

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
			HRc45~55	HRc55~							
-HB225	HB225~325	HRc30~45									
◎	◎	◎			○	○	○	○	○		

◎ : Excellent ○ : Good

CARBIDE NC - SPOTTING DRILLS 90°, 120° with FLATTED SHANK
VOLLHARTMETALL NC-ANBOHRER 90°, 120° mit MITNAHME FLÄCHE
D5306, D5307 SERIES

Unit : mm

WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON		STAINLESS STEELS		Al-Si ALLOYS, Si<10%		Al-Si ALLOYS, Si>10%		Ti, Ni ALLOY STEELS	
	< 700 N/mm ²		< 1000 N/mm ²		< HB240, GG25		< HB300, GG40									
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S	N	S
6	3900	0.08	2850	0.08	5200	0.09	3800	0.09	2000	0.07	8800	0.11	7100	0.11	1950	0.07
8	2900	0.10	2150	0.10	3900	0.12	2850	0.12	1500	0.09	6600	0.15	5350	0.15	1450	0.09
10	2350	0.12	1700	0.12	3100	0.16	2300	0.16	1200	0.11	5300	0.19	4250	0.19	1200	0.11
12	1950	0.14	1450	0.14	2600	0.20	1900	0.20	1000	0.13	4450	0.23	3550	0.23	980	0.13
16	1450	0.17	1100	0.17	1950	0.24	1450	0.24	755	0.17	3300	0.27	2650	0.27	735	0.17
20	1150	0.19	850	0.19	1550	0.28	1150	0.28	590	0.20	2650	0.31	2150	0.31	590	0.20

N = R.P.M

S = Feed per Revolution (mm/rev.)