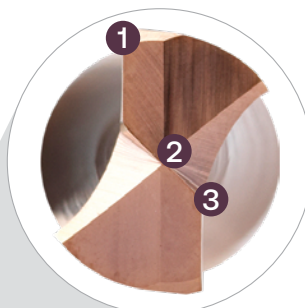


FEATURES & BENEFITS

DR 60



1 Corner Chamfer Edge

Edge protection when machining on hardened material

2 Thinning

Special Thinning for hardened material

3 Bigger Web Thickness

Increases the tool rigidity

4 Tough PVD Silicon Based Coating

- Prolong the tool life
- Enables higher cutting speeds
- Increases heat resistance

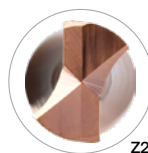
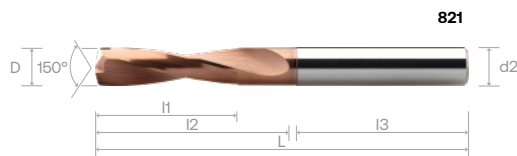
5 Suitable for Material Group

H



DR 60 TWIST DRILLS - DIN 6537L - 150° POINT ANGLE - 5 X Ø

- VHM Spiralbohrer nach DIN 6537L, 150° Spitzenwinkel, Schaft nach DIN 6535HA
- Punte elicoidali a norma DIN 6537L, 5 x ø, con angolo di punta 150°, codolo DIN 6535HA
- Forets hélicoïdaux selon DIN 6537L - 5 x Ø, angle de pointe 150°, queue selon DIN 6535HA
- 整体硬质合金钻头-相等于DIN 6537L 2刃-加工深度3xD, 柄部标准DIN 6535HA, 顶角150°



Order Number DIN 6535	Dimension (mm)						D0120
	D (m7)	I1	I2	I3	L	d2 (h6)	
821 0300 *	3.0	23	28	36	66	6	°
821 0330 *	3.3		28	36	66	6	°
821 0350 *	3.5		28	36	66	6	°
821 0380 *	3.8	29	36	36	74	6	°
821 0400 *	4.0		36	36	74	6	°
821 0420 *	4.2		36	36	74	6	°
821 0450 *	4.5	35	36	36	82	6	°
821 0480 *	4.8		44	36	82	6	°
821 0500 *	5.0		44	36	82	6	°
821 0550 *	5.5	43	44	36	82	6	°
821 0580 *	5.8		44	36	82	6	°
821 0600 *	6.0		44	36	82	6	°
821 0650 *	6.5	49	53	36	91	8	°
821 0680 *	6.8		53	36	91	8	°
821 0700 *	7.0		53	36	91	8	°
821 0750 *	7.5	56	53	36	91	8	°
821 0780 *	7.8		53	36	91	8	°
821 0800 *	8.0		53	36	91	8	°
821 0850 *	8.5	60	61	40	103	10	°
821 0880 *	8.8		61	40	103	10	°
821 0900 *	9.0		61	40	103	10	°
821 0950 *	9.5	66	61	40	103	10	°
821 0980 *	9.8		61	40	103	10	°
821 1000 *	10.0		61	40	103	10	°
821 1020 *	10.2	72	71	45	118	12	°
821 1050 *	10.5		71	45	118	12	°
821 1080 *	10.8		71	45	118	12	°
821 1100 *	11.0	78	71	45	118	12	°
821 1150 *	11.5		71	45	118	12	°
821 1180 *	11.8		71	45	118	12	°
821 1200 *	12.0	84	71	45	118	12	°
821 1250 *	12.5		77	45	124	14	°
821 1280 *	12.8		77	45	124	14	°
821 1300 *	13.0		77	45	124	14	°

* - DIN 6535

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

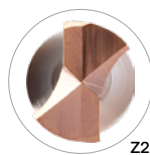
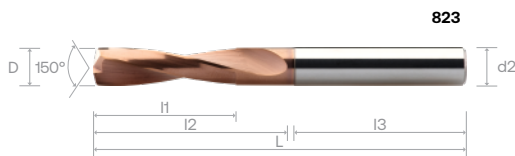
Cutting Parameter

N01 N02 N03 K01 K02 P01 P02 P03 M01 M02 S01 S02 S03 H01 H02 O01 O02

499

DR 60 TWIST DRILLS - DIN 6537K - 150° POINT ANGLE - 3 X Ø

- VHM Spiralbohrer nach DIN 6537K, 150° Spitzenwinkel, Schaft nach DIN 6535HA
- Punte elicoidali a norma DIN 6537K, 3 x Ø, con angolo di punta 150°, codolo DIN 6535HA
- Forets hélicoïdaux selon DIN 6537K - 3 x Ø, angle de pointe 150°, queue selon DIN 6535HA
- 整体硬质合金钻头-相等于DIN 6537K 2刃-加工深度3xD, 顶角150°



Order Number DIN 6535	Dimension (mm)						D0120
	D (m7)	I1	I2	I3	L	d2 (h6)	
823 0300 *	3.0	14	20	36	62	6	°
823 0330 *	3.3		20	36	62	6	•
823 0350 *	3.5	17	20	36	62	6	•
823 0380 *	3.8		24	36	66	6	•
823 0400 *	4.0	20	24	36	66	6	•
823 0420 *	4.2		24	36	66	6	•
823 0450 *	4.5	29	24	36	66	6	•
823 0480 *	4.8		28	36	66	6	°
823 0500 *	5.0	35	28	36	66	6	°
823 0550 *	5.5		28	36	66	6	•
823 0580 *	5.8	40	28	36	66	6	•
823 0600 *	6.0		34	36	79	8	•
823 0650 *	6.5	43	41	36	79	8	•
823 0680 *	6.8		41	36	79	8	•
823 0700 *	7.0	40	41	36	79	8	•
823 0750 *	7.5		41	36	79	8	•
823 0780 *	7.8	43	41	36	79	8	°
823 0800 *	8.0		41	36	79	8	•
823 0850 *	8.5	40	47	40	89	10	•
823 0880 *	8.8		47	40	89	10	°
823 0900 *	9.0	43	47	40	89	10	°
823 0950 *	9.5		47	40	89	10	°
823 0980 *	9.8	40	47	40	89	10	°
823 1000 *	10.0		47	40	89	10	•
823 1020 *	10.2	43	55	45	102	12	°
823 1050 *	10.5		55	45	102	12	°
823 1080 *	10.8	40	55	45	102	12	•
823 1100 *	11.0		55	45	102	12	°
823 1150 *	11.5	43	55	45	102	12	°
823 1180 *	11.8		55	45	102	12	•
823 1200 *	12.0	40	55	45	102	12	•
823 1250 *	12.5		60	45	107	14	°
823 1280 *	12.8	43	60	45	107	14	°
823 1300 *	13.0		60	45	107	14	°

* - DIN 6535

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

N01 N02 N03 K01 K02 P01 P02 P03 M01 M02 S01 S02 S03 H01 H02 O01 O02

Cutting Parameter

499

Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

**H**

DR 60 Twist Drills, 3xD & 5xD, 2 Flutes - 821, 823

Drilling	H			
Working Material	Hardened Steel		Hardened Steel	
Properties	45 ≤ HRC < 52		52 ≤ HRC < 68	
D	Vc	fn	Vc	fn
3	30	0.024	20	0.018
4		0.050		0.025
5		0.065		0.029
6		0.080		0.032
7		0.090		0.036
8		0.100		0.039
9		0.110		0.043
10		0.120		0.046
11		0.130		0.050
12		0.140		0.053
13		0.150		0.059

NC SPOT

DR ALU

EZ LINE -
DRILL

DR NITCo

DR VA

DR-S

DR MINI

DR-LX

DR 45 SB

DR 60