



High performance solidid earbide drills

Reliability and long lifespan
Control over the sharpness of the cuiting edge and surface finish

European carhite，coating and finishing
 Replicable technology

Drill bits can be sharpened up to 10 times


A dedicated designo ofifice to respond to your machining needs

D／AC＇
A technical sales team that analyzes your requests on site and supports you



TOOL DIMENSIONS

|  | ut | ${ }^{\text {a }}$ | mer |  |  |  | mber |  |  |  | mer |  |  |  |  |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: |
| 300 | 2200 | － | ¢ısan | 150 | 1384 | 8 | bsanusa | 30 | cread | 6 | ¢ssamean | 150 | glus | 8 | bismuen |
| 3.0 | b2a0 | － | ¢sanaso | 180 | ）sad | 8 | bsamuee | 3.0 | ${ }_{\text {crase }}$ | ． | ¢şamaio | 180 | 9xus | \％ | bssume |
| 330 | b200 | 6 | Grawe | 10 | Isam | 8 | bsamero | 330 | cised | － | ¢ร50uxa | 100 | gus | 8 | ¢ssuaum |
| ${ }^{30}$ | a2a0 | － | bsameso | ${ }_{175}$ | ）sal | B | bsxanem | 330 | ${ }_{\text {creas }}$ | － | ¢ssameso | 1．5 | gns |  | \％ssume |
| 3.0 | \％200 | － |  | 180 | psad | 8 | bsamene | ${ }_{3} 30$ | ${ }_{\text {cmase }}$ | ． | assamaso | 180 | 9xas |  | ¢5sume |
| 330 | \％200 | 6 | ¢3mase | 180 | ）sam | 8 | G3anoso | 330 | cmed | 6 | ¢ssamsio | 130 | gus | 8 | ¢5smoso |
|  | gea |  | ¢sameso | 80 | nast |  | grameno | \％0 | cmed | \％ | ¢fsamaso | 80 | 9xus |  | assameo |
| 30 | \％200 | ． | gramano | 8.0 | Bxat | 10 | ¢samaso | 30 | cosed | 6 | assamas | $8: 10$ | 11351 | 10 | ¢5smaso |
| 315 | meo | $\bigcirc$ | ¢xaneys | 820 | bxat | 10 | ¢zanasa | 315 | cras | － | O5sma35 | 820 | 11351 | 10 | Gsanuma |
| 380 | mad | 6 | $\square^{\text {asamesa }}$ | 835 | B4x | 10 | bisanes | 380 | ${ }^{1 / 486}$ | 6 | bisumaso | 825 | 11351 | 10 | 6ssanes |
| 330 | beat | 6 | Gsanasa | 830 | 8xal | 10 | ¢zamasa | 330 | ${ }^{1 / 268}$ | 6 | ¢รsamen | 830 | 11351 | 10 | 6ssmexa |
| 400 | beat | $\bigcirc$ | gramean | 8 | bxa | 10 | bsamaxa | 400 | ${ }^{17468}$ | － | ¢5sameo | 8.0 | 11351 | 10 | 6ssanamo |
|  | siou |  | gramera | ${ }_{850}$ | Baxt | ${ }^{10}$ | grameso | 400 | ${ }^{1 / 468}$ | ¢ | asmanio | 8.50 |  |  | 6ssanso |
| 420 | bax | 6 | bexamex | 850 | Bxat | 10 | bsamaman | ${ }^{420}$ | ${ }^{1786}$ | $\bigcirc$ | 6ssanemo | 800 | mas |  | bisanama |
| 425 | beat | － | ¢ззaners | 8 | batal | 1 | －sanaso | 425 | ${ }^{14 \times 68}$ | 6 | Gsanaws | $8{ }^{80}$ | 11331 | 1 | 6smane |
|  | beat |  |  | 815 | Batal | 10 | Gramaes | 480 | ${ }^{12 \times 68}$ | $\bigcirc$ | Assamaso | 815 | 11381 |  |  |
| 4.0 | max | 6 | $\operatorname{cisana40}^{0}$ | 880 | bext | 10 | Gixameno | 4.0 | ${ }^{1486}$ | $\bigcirc$ | 6ร50040 | 880 | 11351 |  | maxo |
| 450 | bax | $\bigcirc$ | bsamast | 880 | batd | 10 | bsamase | 450 | ${ }^{1486}$ | － | 6ssumeso | 880 | 11351 | 10 | bismanem |
| 460 | beat | 6 | ¢צ30040 | ${ }^{\text {son }}$ | bxat | 10 | bsamame | 480 | ${ }^{12 \times 6}$ | 6 | gismase | 900 | 11351 | 10 | gisanem |
| 4.0 | saxt | 6 | grameal | 9.10 | bxat | 10 | grame | 40 | ${ }_{1}^{14 \times 6}$ | 6 | assan | 9.0 | 11351 | 10 | bssmaso |
| 45 | smat | ${ }^{6}$ | gizamen | 920 | Bax | 10 |  | 4.5 | ${ }^{1 / 206}$ | － | $\square$ | 920 | 11381 | 10 | 6sanuen |
| 480 | max | $\bigcirc$ | grameso | ${ }^{230}$ | 8xal | 10 | bismasa | 480 | ${ }_{\text {bex }}$ | 6 |  | 930 | 11351 | 10 | 6ismasa |
| 480 | suen | 5 | Gsamaso | 9：0 | 894 | 10 | Granasa | 480 | beat | \％ | $\square$ | 3：00 | 11381 |  |  |
| 500 | brees | 6 | ¢3xama | ${ }^{3} 50$ | batd | 10 | axamaso | 500 | ${ }_{\text {bux }}$ | 6 | gismous | ${ }^{3} 50$ | 11351 |  | 6sanasan |
| 5.0 | sum | 6 | ¢xanasio | ${ }^{980}$ | batd | 10 | gramasa | 510 | bext | 6 | ossmasio | ${ }^{1000}$ | 11351 | 10 | ¢53Mu00 |
| 520 | Smas | 5 | Asacose | 1000 | Batal | 10 | Gramamo | ${ }^{520}$ | bext | $\bigcirc$ | ${ }^{\text {bsamama }}$ | 1120 | ｜1as | 12 | ¢зsameo |
| 525 | smes | － | ${ }^{\text {bjumaz3 }}$ | 1200 | 1 12as5 | 1 |  | 525 | bext | 6 | ${ }^{\text {assamas }}$ | ${ }^{10} 50$ | пй |  | bssmuso |
| 530 | maxe | $\bigcirc$ | bsamaso | 1025 | 11235 | 1 |  | 530 | ${ }_{\text {Bxa }}$ | ¢ | 6ssumso | ${ }^{1080}$ | пия | 12 | 65smue |
| 5.0 | bsae | 6 | ģamasio | 10.50 | $1{ }^{1} 205$ | 1 | ¢zanusa | 5.0 | ${ }_{\text {bext }}$ | ¢ | gisamaso | n100 | нвя | 1 | gssameo |
| 550 | sume |  | bsane | 11880 | ${ }^{12035}$ | 1 | ¢ร3xama | 550 | ${ }_{\text {bex }}$ | $\bigcirc$ | bsan | 1550 | пиan |  |  |
| 550 | smed | 6 | gramuso | neo | ${ }^{12025}$ | 12 | gramue | S50 | ${ }_{\text {gex }}$ | 。 | gisauso | ${ }^{180}$ | н⿺夂卜 | 12 | ตssame |
| 50 | broes | $\bigcirc$ | 6samasio | 150 | 11245 | 1 | ¢צzanco | 50 | bext | 6 | assomso | 1200 | пй | 12 | ¢క5Mx |
|  | bues | 6 | ¢צxambs | ${ }^{180}$ | 11235 | 12 | ¢зมaneo | 8，5 | ${ }^{3} \mathrm{xax}$ | $\bigcirc$ |  | 12.50 | 1240 |  |  |
| 580 | smes | 6 | 6з30050 | 1200 | 1 I 235 | 12 | ¢зzaneo | 580 | ${ }_{\text {axat }}$ | － | 6s5unso | 120 | 12407 | 14 |  |
| 530 | sum | － | gramess | 1230 | 10100 | 14 | ¢ззмй00 | 500 | bext | 6 | bisamso | ${ }^{1300}$ | ${ }^{12} 240$ | ${ }^{14}$ |  |
|  | sime | 6 |  | 12.0 | Hexa | 14 |  | 600 | bext | $\bigcirc$ |  | ${ }^{13} 5$ | 1247 | 14 | Muso |
| 6.10 | nes | 8 | вз39 | 1300 | 1010 | 1 | ¢zzanco | ${ }_{6} 6$ | ${ }_{\text {9k3 }}$ | \％ | ดssmasio | 130 | 1247 | ${ }^{1}$ | ¢รsumbo |
| ${ }^{20}$ | 1394 | 8 | bsamene | ${ }^{13} 50$ | 1010 | 14 | ¢зsumso | 620 | 9663 | 8 | bismuen | 1400 | 1240 | ${ }^{14}$ | ¢5smanco |
|  | 1394 | 8 | grameres | ${ }^{1}$ | 10130 | 1 | ¢зsanao | ${ }^{685}$ | 9653 | \％ | gismazs | ${ }^{14} 50$ | 13838 | ${ }^{16}$ | 6ssameso |
| 80 | 1394 | 8 | gisane | 1450 | Hisas | ${ }^{16}$ | ¢з3M450 | 680 | 963 | 8 | －530meno | 140 | zzaes | ${ }^{16}$ | $\operatorname{cisamax}^{\text {a }}$ |
| 840 | 1394 | 8 | ¢冖⿰亻二aseso | \％， | ${ }_{1} 1 \mathbf{6} 5$ | 16 | өзумало | ${ }_{600}$ | ${ }^{9653}$ | 8 | bssanato | ${ }^{1500}$ | 13 ses | ${ }^{16}$ | 65smatio |
| $65_{0}$ | 1394 | 8 | bsamenso | 1500 | ${ }^{11} 505$ | ${ }^{18}$ | ¢z304500 | 650 | $9 \times 3$ | 8 | 6ร5Muso | ${ }^{15} 50$ | 13368 | ${ }^{16}$ | 6spusso |
| 660 | 1934 | \％ | brammeo | 1550 | ${ }^{15655}$ | ${ }^{16}$ | 63Mmso | 600 | ${ }^{9663}$ | \％ | bssum | ${ }_{150}$ | ${ }^{13 \times 3}$ |  | 6ssumb |
| ${ }_{8} 80$ | 1394 | 8 | gramasio | ${ }_{150}$ | ${ }^{11565}$ | ${ }^{16}$ | Esambs | ${ }_{60} 0$ | ${ }_{963}$ | \％ | assamen | ${ }_{1600}$ | $13 \times 3$ | ${ }^{16}$ |  |
| ${ }_{6} 6$ | пея | 8 | ¢zanues | ${ }^{1600}$ | ${ }^{11655}$ | 16 | ¢zanalan | ${ }_{6} 6$ | 963 | 8 | Ossmasis | 15.50 |  | ${ }^{18}$ | gisalus |
| 680 | \％es | 8 | 5umes | 1 15s0 | ${ }^{123 a s}$ | ${ }^{18}$ | 6isautso | 880 | ${ }_{963}$ | 8 | bismexe | $\square$ | ${ }^{14398}$ | 18 | ¢isammo |
| 880 | \％es | \％ | b33meno | 1000 | rase | ${ }^{18}$ |  | ${ }^{680}$ | 9653 | \％ |  | ${ }^{1180}$ | ${ }^{13} \times 3$ | ${ }^{18}$ | Gsamario |
| 100 | пе3 | 8 |  | ${ }^{13} 0$ | ${ }^{\text {rasab }}$ | ${ }^{18}$ | gisamiso | 100 | ${ }^{9653}$ | 8 | assamomo | в80 | 13598 | ${ }^{18}$ | ¢5smate |
| 2.0 | ${ }^{\text {pasa }}$ | 8 | ¢ззaño | ${ }^{1800}$ | ${ }^{\text {rasab }}$ | 18 | ¢ззateo | 2.0 | 9663 | \％ | ¢รsaumio | ${ }_{\text {B }}$ S 0 | 15900 | ${ }^{20}$ | gssune |
| ${ }^{200}$ | 1am | B | （bunozo | 1 Bs 0 | bux | 20 | ถısamso | ${ }^{120}$ | 9x63 | \％ | ตsmamo | ${ }^{180}$ | Lisal | 20 | ¢క5xamo |
| ${ }^{125}$ | 104 | B | ¢zxaums | ${ }^{1300}$ | Bux | ${ }^{20}$ | ¢зมxamo | ${ }^{125}$ | 9x63 | 8 | ¢ร30075 | ${ }^{18} 30$ | Lsame | 20 | ${ }^{\text {bismaxa }}$ |
| ${ }^{30}$ | ${ }^{194}$ |  |  | ${ }_{13} 3_{0}$ | вux9 | ${ }^{20}$ | ¢צxumso | 130 | 9663 | 8 | ตรsumo | 200 | baxa | 20 | ตssumeo |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |

CUTTING GONDITIOIS

|  |  | Reference 61330A |  | Reference 61530A |  |
| :---: | :---: | :---: | :---: | :---: | :---: |
| Material | Hatroses | Veinm／min | fimprew | Veinmmin | fimmprav |
| Steel | ＜200н | 90160 | 69 | 90150 | ${ }^{68}$ |
| Steel | 200а 300 нв | 60 110 | 0 | 601100 | ${ }^{67}$ |
| steel | 3002 400 нв | 50880 | 66 | 5080 | ${ }^{65}$ |
| Ferritic－martensiticstainless steel | ＜20 H8 | 50990 | ， | 50880 | 61 |
|  | 22 ннв 280 нв | 40770 | ${ }_{6}$ | 40860 | ${ }_{6}$ |
|  | 28 нвв з30 нв |  |  |  |  |
|  | ＜220н | 5070 | 66 | 5070 | 65 |
|  | 220 нв 280 нв | 40860 | 66 | 40860 | ${ }_{6} 6$ |
| Lamellar graphitecast ironctio | く10 HB | 50140 | 69 | 50110 | 69 |
|  | 140НВ 210 нв | 50130 | 69 | 501100 | 69 |
|  | 20ННв 220 НВ | 501100 | ${ }^{68}$ | 50990 | ${ }^{68}$ |
|  | 20 нназ 20 нв | 50390 | 68 | 50880 | ${ }^{68}$ |
| $\begin{aligned} & \text { Nodula fraphitite } \\ & \text { Fessasto. } 1 \text { FGS8800 } \end{aligned}$ | ＜220 H8 | 50130 | 68 | 501100 | 68 |
|  | 20 нв 270 нв | 50120 | ${ }^{68}$ | 50990 | ${ }_{68}$ |
|  | 270 нв 350 н в | 501100 | 61 | 50980 | 67 |
| Ammimamexas | ＜600 $\mathrm{mm}^{2}$ | 40150 | 67 | 40150 | ${ }^{67}$ |
|  | （600 Nmm² | 40150 | 61 | 40150 | 61 |
| Bone | 100н | 40150 | 68 | 40150 | ${ }_{68}$ |
| Bras | 20нв | 40150 | 68 | 40150 | ${ }^{68}$ |
| Coper | 20он | 40150 | 8 | 40150 | ${ }^{68}$ |
| Cupodulu | 20он | 40150 | 18 | 40150 | ${ }^{68}$ |
|  | ＜20 Нв | 20350 | a | 20350 | 66 |
| Refrators stel | 280 наз 230 нв | 2045 | ${ }_{6} 6$ | 2045 | ${ }_{64}$ |
|  | 320нв 42 нив | 15330 | ${ }^{64}$ | 15330 | 64 |
| Titanium／Titanium alloys | ＜60 Nmm | 30880 | ${ }_{6} 6$ | 30860 | 66 |
|  | $60031000 \mathrm{Nmm}{ }^{2}$ | 30960 | 66 | 30350 | 66 |
|  | $1000 \mathrm{a}^{1500 ~} \mathrm{Nm} \mathrm{m}^{2}$ | 3040 | ${ }^{65}$ | 2535 | 65 |
| Treated stel | 400 50 HRC | 25.50 | 66 | 25550 | 65 |
| Trated stel | 50.86 HRC |  |  |  |  |
| Stainesssteels | $\underline{0}$ Castions | lor－ter | erias $s$ | suer | H Hardm |

DRILLING FEED GROUP



