

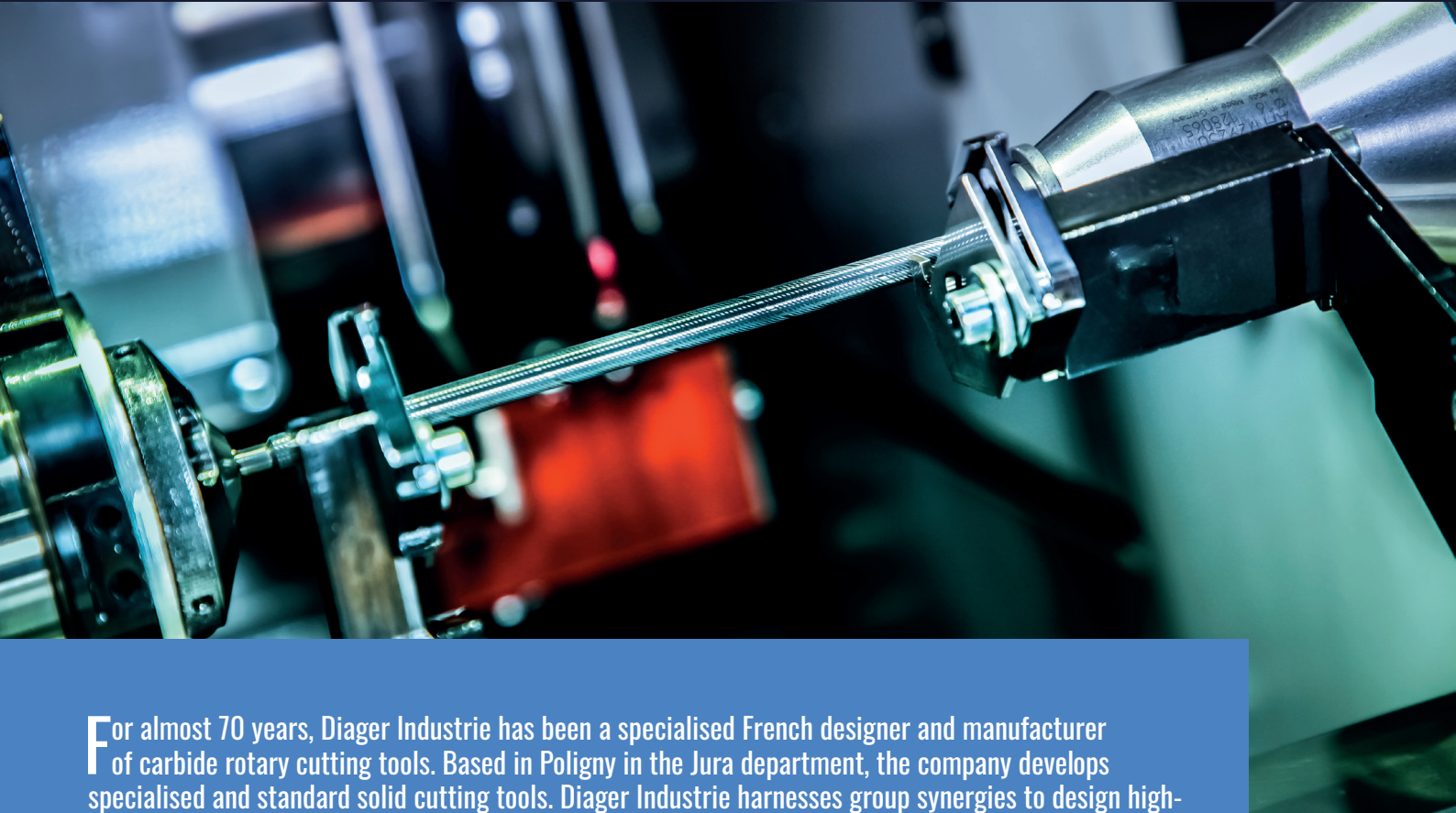


UNIVERSAL DRILLING

COMPOSITES, SHEET STEEL, CAST IRON, PLASTICS, GRAPHITE,
SILICA, TREATED STEELS, CARBON, ALUMINIUM AND FIBREGLASS



DIAGER[®]
INDUSTRIE



For almost 70 years, Diager Industrie has been a specialised French designer and manufacturer of carbide rotary cutting tools. Based in Poligny in the Jura department, the company develops specialised and standard solid cutting tools. Diager Industrie harnesses group synergies to design high-quality tools for industry players. As a true partner of major players in the mechanical, aeronautical, space and automotive industries, Diager Industrie has concentrated the best of its expertise within a range of quality products.

RESEARCH & DEVELOPMENT: THE MEANS TO GO THE EXTRA MILE

Our company therefore invests heavily in research, development and innovation. Our ambition is to respond to your machining problems. In this way, we are able to develop comprehensive and innovative solutions. For all your drilling, milling and reaming operations, our experts not only develop the cutting tools you require, but also the optimal process for your application because, above all, we provide solutions.

This is why we have not only a dedicated research team committed to optimising your strategy and your industrial logistics, but also testing

platforms in line with your resources making it possible to validate our machining processes in real conditions. This enables us to respond with extreme precision to your most demanding specifications and to guarantee the performance of our tools. We accurately measure their performance for complete control of costs and production times.

Our fleet of 135 machine tools, 45 of which are numerically controlled, allows us to have total control over our processes and tools, to make them ever more efficient.

A COMMITTED COMPANY

Diager Industrie is a committed company that works every single day to offer excellent customer service and guarantee the quality of its products. Thanks to modern technologies and a significant human investment, we do everything we can to keep the impact on our environment as low as possible. Through an established environmental policy, we can guarantee control of our activities and products. This is how we think about all of our actions, making caring for the environment a top priority.



PROCEDURES AND ACCREDITATIONS:



Certified ISO
9001 and 14001



Quality



Compliant with
regulations and
environmentally
friendly



Certified CSR 26000
by AFNOR
Certification level
«CONFIRMED»



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www.societe.com

The CSR approach is a real philosophy that motivates our daily actions and drives our strategic approach. Becoming CSR Committed is a sign that our organisation is taking responsibility for the impact of its decisions and is committed to the sustainable development of its activities. We are proud of this label, which rewards our commitment to people, jobs, the environment and product quality.

By choosing Diager Industrie solutions, you also benefit from optimal support and aftercare services.

Working with you every step of the way, our teams are committed to your success.



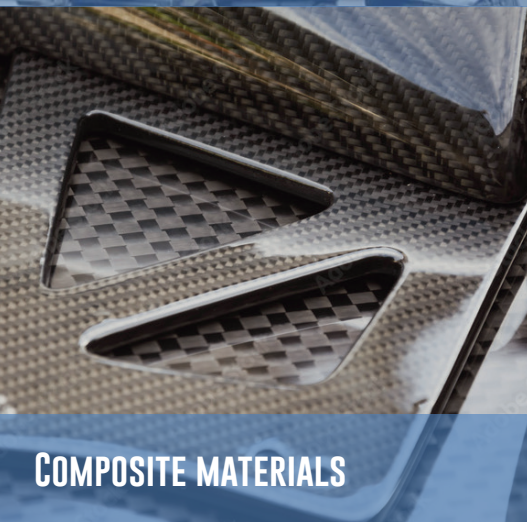
INDUSTRIAL MAINTENANCE



AERONAUTICS



LOCKSMITHING AND SAFES



COMPOSITE MATERIALS



FIREPLACES / INSERTS



CONSTRUCTION MAINTENANCE /
CONSTRUCTION EQUIPMENT

DRILL BIT 2409
SHORT SERIES PL6° 118°
DRILL BIT 2418
LONG SERIES PL6° 118°



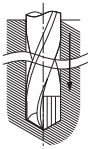
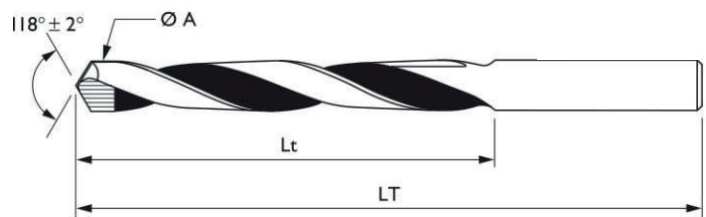
P M K N S H

Features

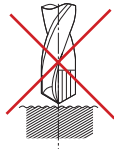
Right cutting : **6°**
 Right helix : **25°**
 Number of cutting : **2**
 Flutes : **N**
 Sharpening : **AF 1**
 Body : **High-speed steel**
 Carbide : **K 20**
 Attachment : **Cylindrical**
 Shank : **Nominal**

ØA
 1.50 à 20

LT x Lt
 Short series : DIN 338
 Long series : DIN 340



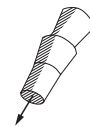
3 x ØA



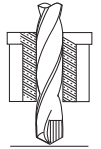
Not self-centring



Cylindrical shank



Outdoor spraying /
microspraying



Passage into drill bush
drill bit 2418

THE BENEFITS :

BRAZED CARBIDE INSERT DRILL BIT 6° CUT 118° TIP ANGLE

Universal drill bit designed for drilling :

- Abrasive materials
- Carbon fibers and plastics (references 2419 and 2429 more suitable)
- Graphite - Silica (sand moulds)
- Hard materials - Treated steel up to 55HRC - Cast iron
- Manual or column drilling in cast iron, mainly cast iron with silica e.g. - boiler
- Steel treated with other materials, manual lock drilling and other parts including brass, cast iron, steel, concrete, etc.

TOOL DIMENSIONS

Ø A	LT x Lt	Item code	Ø A	LT x Lt	Item code	Ø A	LT x Lt	Item code	Ø A	LT x Lt	Item code	Ø A	LT x Lt	Item code
1,50	40 x 18	2409-0150	5,80	93 x 57	2409-0580	10,20	133 x 87	2409-1020	1,80	80 x 53	2418-0180	6,10	148 x 97	2418-0610
1,60	43 x 20	2409-0160	5,90	93 x 57	2409-0590	10,50	133 x 87	2409-1050	1,90	80 x 53	2418-0190	6,20	148 x 97	2418-0620
1,70	43 x 20	2409-0170	6,00	93 x 57	2409-0600	11,00	142 x 94	2409-1100	2,00	85 x 56	2418-0200	6,30	148 x 97	2418-0630
1,80	46 x 22	2409-0180	6,10	101 x 63	2409-0610	11,20	142 x 94	2409-1120	2,10	85 x 56	2418-0210	6,40	148 x 97	2418-0640
1,90	46 x 22	2409-0190	6,20	101 x 63	2409-0620	11,50	142 x 94	2409-1150	2,20	90 x 59	2418-0220	6,50	148 x 97	2418-0650
2,00	49 x 24	2409-0200	6,30	101 x 63	2409-0630	12,00	151 x 101	2409-1200	2,30	90 x 59	2418-0230	6,60	148 x 97	2418-0660
2,10	49 x 24	2409-0210	6,40	101 x 63	2409-0640	12,20	151 x 101	2409-1220	2,40	95 x 62	2418-0240	6,70	148 x 97	2418-0670
2,20	53 x 27	2409-0220	6,50	101 x 63	2409-0650	12,50	151 x 101	2409-1250	2,50	95 x 62	2418-0250	6,80	156 x 102	2418-0680
2,30	53 x 27	2409-0230	6,60	109 x 69	2409-0660	13,00	151 x 101	2409-1300	2,60	95 x 62	2418-0260	6,90	156 x 102	2418-0690
2,40	57 x 30	2409-0240	6,70	109 x 69	2409-0670	13,50	160 x 108	2409-1350	2,70	100 x 66	2418-0270	7,00	156 x 102	2418-0700
2,50	57 x 30	2409-0250	6,80	109 x 69	2409-0680	14,00	160 x 108	2409-1400	2,80	100 x 66	2418-0280	7,10	156 x 102	2418-0710
2,60	57 x 30	2409-0260	6,90	109 x 69	2409-0690	14,50	169 x 114	2409-1450	2,90	100 x 66	2418-0290	7,20	156 x 102	2418-0720
2,70	61 x 33	2409-0270	7,00	109 x 69	2409-0700	15,00	169 x 114	2409-1500	3,00	100 x 66	2418-0300	7,30	156 x 102	2418-0730
2,80	61 x 33	2409-0280	7,10	109 x 69	2409-0710	15,50	178 x 120	2409-1550	3,10	106 x 69	2418-0310	7,40	156 x 102	2418-0740
2,90	61 x 33	2409-0290	7,20	109 x 69	2409-0720	16,00	178 x 120	2409-1600	3,20	106 x 69	2418-0320	7,50	156 x 102	2418-0750
3,00	61 x 33	2409-0300	7,30	109 x 69	2409-0730	16,50	184 x 125	2409-1650	3,30	106 x 69	2418-0330	7,60	165 x 109	2418-0760
3,10	65 x 36	2409-0310	7,40	109 x 69	2409-0740	17,00	184 x 125	2409-1700	3,40	112 x 73	2418-0340	7,70	165 x 109	2418-0770
3,20	65 x 36	2409-0320	7,50	109 x 69	2409-0750	17,50	191 x 130	2409-1750	3,50	112 x 73	2418-0350	7,80	165 x 109	2418-0780
3,30	65 x 36	2409-0330	7,60	117 x 75	2409-0760	18,00	191 x 130	2409-1800	3,60	112 x 73	2418-0360	7,90	165 x 109	2418-0790
3,40	70 x 39	2409-0340	7,70	117 x 75	2409-0770	18,50	198 x 135	2409-1850	3,70	112 x 73	2418-0370	8,00	165 x 109	2418-0800
3,50	70 x 39	2409-0350	7,80	117 x 75	2409-0780	19,00	198 x 135	2409-1900	3,80	119 x 78	2418-0380	8,10	165 x 109	2418-0810
3,60	70 x 39	2409-0360	7,90	117 x 75	2409-0790	19,50	205 x 140	2409-1950	3,90	119 x 78	2418-0390	8,20	165 x 109	2418-0820
3,70	70 x 39	2409-0370	8,00	117 x 75	2409-0800	20,00	205 x 140	2409-2000	4,00	119 x 78	2418-0400	8,30	165 x 109	2418-0830
3,80	75 x 43	2409-0380	8,10	117 x 75	2409-0810				4,10	119 x 78	2418-0410	8,40	165 x 109	2418-0840
3,90	75 x 43	2409-0390	8,20	117 x 75	2409-0820				4,20	119 x 78	2418-0420	8,50	165 x 109	2418-0850
4,00	75 x 43	2409-0400	8,30	117 x 75	2409-0830				4,30	126 x 82	2418-0430	9,00	175 x 115	2418-0900
4,10	75 x 43	2409-0410	8,40	117 x 75	2409-0840				4,40	126 x 82	2418-0440	9,50	175 x 115	2418-0950
4,20	75 x 43	2409-0420	8,50	117 x 75	2409-0850				4,50	126 x 82	2418-0450	10,00	184 x 121	2418-1000
4,30	80 x 47	2409-0430	8,60	125 x 81	2409-0860				4,60	126 x 82	2418-0460	10,50	184 x 121	2418-1050
4,40	80 x 47	2409-0440	8,70	125 x 81	2409-0870				4,70	126 x 82	2418-0470	11,00	195 x 128	2418-1100
4,50	80 x 47	2409-0450	8,80	125 x 81	2409-0880				4,80	132 x 87	2418-0480	11,50	195 x 128	2418-1150
4,60	80 x 47	2409-0460	8,90	125 x 81	2409-0890				4,90	132 x 87	2418-0490	12,00	205 x 134	2418-1200
4,70	80 x 47	2409-0470	9,00	125 x 81	2409-0900				5,00	132 x 87	2418-0500	12,50	205 x 134	2418-1250
4,80	86 x 52	2409-0480	9,10	125 x 81	2409-0910				5,10	132 x 87	2418-0510	13,00	205 x 134	2418-1300
4,90	86 x 52	2409-0490	9,20	125 x 81	2409-0920				5,20	132 x 87	2418-0520	13,50	214 x 140	2418-1350
5,00	86 x 52	2409-0500	9,30	125 x 81	2409-0930				5,30	132 x 87	2418-0530	14,00	214 x 140	2418-1400
5,10	86 x 52	2409-0510	9,40	125 x 81	2409-0940				5,40	139 x 91	2418-0540	14,50	220 x 144	2418-1450
5,20	86 x 52	2409-0520	9,50	125 x 81	2409-0950				5,50	139 x 91	2418-0550	15,00	220 x 144	2418-1500
5,30	86 x 52	2409-0530	9,60	133 x 87	2409-0960				5,60	139 x 91	2418-0560	16,00	227 x 149	2418-1600
5,40	93 x 57	2409-0540	9,70	133 x 87	2409-0970				5,70	139 x 91	2418-0570	17,00	235 x 154	2418-1700
5,50	93 x 57	2409-0550	9,80	133 x 87	2409-0980				5,80	139 x 91	2418-0580	18,00	241 x 158	2418-1800
5,60	93 x 57	2409-0560	9,90	133 x 87	2409-0990				5,90	139 x 91	2418-0590	19,00	247 x 162	2418-1900
5,70	93 x 57	2409-0570	10,00	133 x 87	2409-1000				6,00	139 x 91	2418-0600	20,00	254 x 166	2418-2000



DRILL BIT BOX

**25 DRILL BITS,
REFERENCE 2409**

Short series : DIN 338
from Ø1 to Ø13 every 0.5mm

DRILL BIT 2419
SHORT SERIES PL6° 90°
DRILL BIT 2429
LONG SERIES PL6° 90°

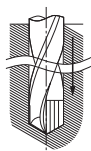
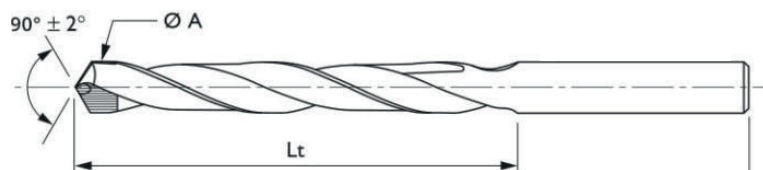


Features

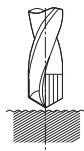
Right cutting : **6°**
 Right helix : **25°**
 Number of cutting : **2**
 Flutes : **N**
 Sharpening : **AF 1**
 Body : **High-speed steel**
 Carbide : **K 20**
 Attachment : **Cylindrical**
 Shank : **Nominal**

ØA
 2,00 à 20

LT x Lt
 Short series : DIN 338
 Long series : DIN 340



3 x ØA



Not self-centring



Cylindrical shank



Outdoor spraying /
microspraying



Passage into drill bush
drill bit 2418

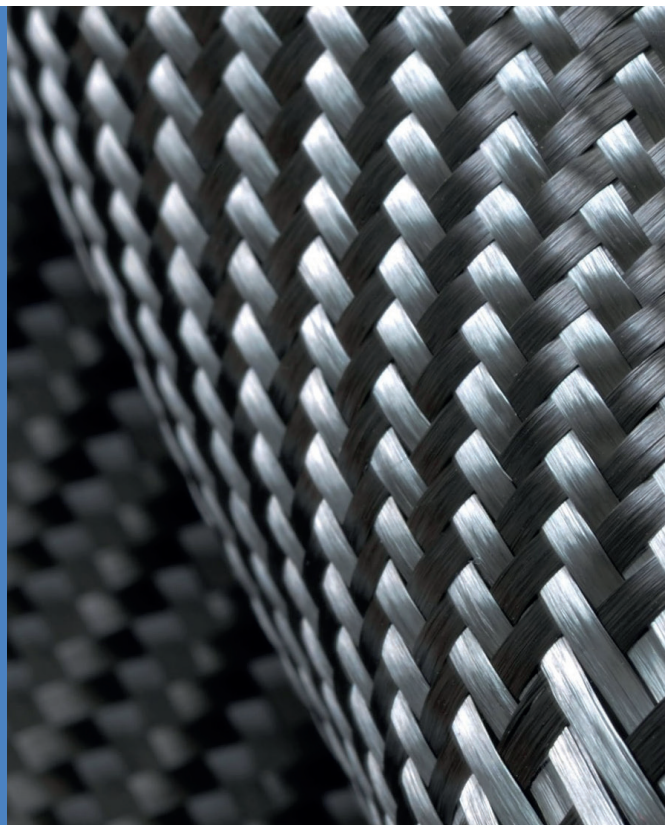
THE BENEFITS :

BRAZED CARBIDE INSERT DRILL BIT 6° CUT 90° TIP ANGLE

The 90° sharpening is designed for drilling glass and carbon fibers materials.

The 90° tip prevents the fibers from delaminating.

This tool is recommended for manually drilling composites.



TOOL DIMENSIONS

Ø A	LT x Lt	Item code
2,00	49 x 24	2419-0200
2,10	49 x 24	2419-0210
2,20	53 x 27	2419-0220
2,30	53 x 27	2419-0230
2,40	57 x 30	2419-0240
2,50	57 x 30	2419-0250
2,60	57 x 30	2419-0260
2,70	61 x 33	2419-0270
2,80	61 x 33	2419-0280
2,90	61 x 33	2419-0290
3,00	61 x 33	2419-0300
3,10	65 x 36	2419-0310
3,20	65 x 36	2419-0320
3,30	65 x 36	2419-0330
3,40	70 x 39	2419-0340
3,50	70 x 39	2419-0350
3,60	70 x 39	2419-0360
3,70	70 x 39	2419-0370
3,80	75 x 43	2419-0380
3,90	75 x 43	2419-0390
4,00	75 x 43	2419-0400
4,10	75 x 43	2419-0410
4,20	75 x 43	2419-0420
4,30	80 x 47	2419-0430
4,40	80 x 47	2419-0440
4,50	80 x 47	2419-0450
4,60	80 x 47	2419-0460
4,70	80 x 47	2419-0470
4,80	86 x 52	2419-0480
4,90	86 x 52	2419-0490
5,00	86 x 52	2419-0500
5,10	86 x 52	2419-0510
5,20	86 x 52	2419-0520
5,30	86 x 52	2419-0530
5,40	93 x 57	2419-0540
5,50	93 x 57	2419-0550
5,60	93 x 57	2419-0560
5,70	93 x 57	2419-0570
5,80	93 x 57	2419-0580
5,90	93 x 57	2419-0590
6,00	93 x 57	2419-0600
6,10	101 x 63	2419-0610
6,20	101 x 63	2419-0620
6,30	101 x 63	2419-0630
6,40	101 x 63	2419-0640
6,50	101 x 63	2419-0650
6,60	109 x 69	2419-0660
6,70	109 x 69	2419-0670
6,80	109 x 69	2419-0680
6,90	109 x 69	2419-0690
7,00	109 x 69	2419-0700
7,10	109 x 69	2419-0710

Ø A	LT x Lt	Item code
7,20	109 x 69	2419-0720
7,30	109 x 69	2419-0730
7,40	109 x 69	2419-0740
7,50	109 x 69	2419-0750
7,60	117 x 75	2419-0760
7,70	117 x 75	2419-0770
7,80	117 x 75	2419-0780
7,90	117 x 75	2419-0790
8,00	117 x 75	2419-0800
8,10	117 x 75	2419-0810
8,20	117 x 75	2419-0820
8,30	117 x 75	2419-0830
8,40	117 x 75	2419-0840
8,50	117 x 75	2419-0850
8,60	125 x 81	2419-0860
8,70	125 x 81	2419-0870
8,80	125 x 81	2419-0880
8,90	125 x 81	2419-0890
9,00	125 x 81	2419-0900
9,10	125 x 81	2419-0910
9,20	125 x 81	2419-0920
9,30	125 x 81	2419-0930
9,40	125 x 81	2419-0940
9,50	125 x 81	2419-0950
9,60	133 x 87	2419-0960
9,70	133 x 87	2419-0970
9,80	133 x 87	2419-0980
9,90	133 x 87	2419-0990
10,00	133 x 87	2419-1000
10,20	133 x 87	2419-1020
10,50	133 x 87	2419-1050
11,00	142 x 94	2419-1100
11,20	142 x 94	2419-1120
11,50	142 x 94	2419-1150
12,00	151 x 101	2419-1200
12,20	151 x 101	2419-1220
12,50	151 x 101	2419-1250
13,00	151 x 101	2419-1300
13,50	160 x 108	2419-1350
14,00	160 x 108	2419-1400
14,50	169 x 114	2419-1450
15,00	169 x 114	2419-1500
15,50	178 x 120	2419-1550
16,00	178 x 120	2419-1600
16,50	184 x 125	2419-1650
17,00	184 x 125	2419-1700
17,50	191 x 130	2419-1750
18,00	191 x 130	2419-1800
18,50	198 x 135	2419-1850
19,00	198 x 135	2419-1900
19,50	205 x 140	2419-1950
20,00	205 x 140	2419-2000

Ø A	LT x Lt	Item code
2,00	85 x 56	2429-0200
2,10	85 x 56	2429-0210
2,20	90 x 59	2429-0220
2,30	90 x 59	2429-0230
2,40	95 x 62	2429-0240
2,50	95 x 62	2429-0250
2,60	95 x 62	2429-0260
2,70	100 x 66	2429-0270
2,80	100 x 66	2429-0280
2,90	100 x 66	2429-0290
3,00	100 x 66	2429-0300
3,10	106 x 69	2429-0310
3,20	106 x 69	2429-0320
3,30	106 x 69	2429-0330
3,40	112 x 73	2429-0340
3,50	112 x 73	2429-0350
3,60	112 x 73	2429-0360
3,70	112 x 73	2429-0370
3,80	119 x 78	2429-0380
3,90	119 x 78	2429-0390
4,00	119 x 78	2429-0400
4,10	119 x 78	2429-0410
4,20	119 x 78	2429-0420
4,30	126 x 82	2429-0430
4,40	126 x 82	2429-0440
4,50	126 x 82	2429-0450
4,60	126 x 82	2429-0460
4,70	126 x 82	2429-0470
4,80	132 x 87	2429-0480
4,90	132 x 87	2429-0490
5,00	132 x 87	2429-0500
5,10	132 x 87	2429-0510
5,20	132 x 87	2429-0520
5,30	132 x 87	2429-0530
5,40	139 x 91	2429-0540
5,50	139 x 91	2429-0550
5,60	139 x 91	2429-0560
5,70	139 x 91	2429-0570
5,80	139 x 91	2429-0580
5,90	139 x 91	2429-0590
6,00	139 x 91	2429-0600
6,10	148 x 97	2429-0610
6,20	148 x 97	2429-0620
6,30	148 x 97	2429-0630
6,40	148 x 97	2429-0640
6,50	148 x 97	2429-0650
6,60	148 x 97	2429-0660
6,70	148 x 97	2429-0670
6,80	156 x 102	2429-0680
6,90	156 x 102	2429-0690
7,00	156 x 102	2429-0700
7,10	156 x 102	2429-0710

Ø A	LT x Lt	Item code
7,20	156 x 102	2429-0720
7,30	156 x 102	2429-0730
7,40	156 x 102	2429-0740
7,50	156 x 102	2429-0750
7,60	165 x 109	2429-0760
7,70	165 x 109	2429-0770
7,80	165 x 109	2429-0780
7,90	165 x 109	2429-0790
8,00	165 x 109	2429-0800
8,10	165 x 109	2429-0810
8,20	165 x 109	2429-0820
8,30	165 x 109	2429-0830
8,40	165 x 109	2429-0840
8,50	165 x 109	2429-0850
9,00	175 x 115	2429-0900
9,50	175 x 115	2429-0950
10,00	184 x 121	2429-1000
10,50	184 x 121	2429-1050
11,00	195 x 128	2429-1100
11,50	195 x 128	2429-1150
12,00	205 x 134	2429-1200
12,50	205 x 134	2429-1250
13,00	205 x 134	2429-1300
13,50	214 x 140	2429-1350
14,00	214 x 140	2429-1400
14,50	220 x 144	2429-1450
15,00	220 x 144	2429-1500
16,00	227 x 149	2429-1600
17,00	235 x 154	2429-1700
18,00	241 x 158	2429-1800
19,00	247 x 162	2429-1900
20,00	254 x 166	2429-2000

DRILL BIT 2439
SHORT SERIES PL16° 118°
DRILL BIT 2436
LONG SERIES PL16° 118°

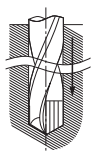
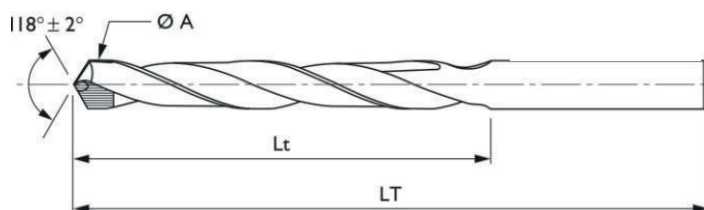


P M K N S H

Features

Right cutting : **16°**
 Right helix : **25°**
 Number of cutting : **2**
 Flutes : **N**
 Sharpening : **AF 20**
 Body : **High-speed steel**
 Carbide : **K 20**
 Attachment : **Cylindrical**
 Shank : **Nominal**

ØA
 2,50 à 16
LT x Lt
 Short series : DIN 338
 Long series : DIN 340



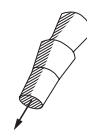
3 x Ø A



Not self-centring



Cylindrical shank



Outdoor spraying /
microspraying



Passage into drill bush
drill bit 2418

THE BENEFITS :

BRAZED CARBIDE INSERT DRILL BIT 16° CUT 118° TIP ANGLE

The 16° insert profile is ideal for drilling carbon fibers/aluminium material stacks.

This drill bit is used for rough drilling of aircraft assemblies with a guide.

In order to avoid the management of several references, this type of geometry is also used by OEMs for carbon fibers drilling alone.

TOOL DIMENSIONS

Ø A	LT x Lt	Item code
2,50	57 x 30	2439--0250
2,60	57 x 30	2439--0260
2,70	61 x 33	2439--0270
2,80	61 x 33	2439--0280
2,90	61 x 33	2439--0290
3,00	61 x 33	2439--0300
3,10	65 x 36	2439--0310
3,20	65 x 36	2439--0320
3,30	65 x 36	2439--0330
3,40	70 x 39	2439--0340
3,50	70 x 39	2439--0350
3,60	70 x 39	2439--0360
3,70	70 x 39	2439--0370
3,80	75 x 43	2439--0380
3,90	75 x 43	2439--0390
4,00	75 x 43	2439--0400
4,10	75 x 43	2439--0410
4,20	75 x 43	2439--0420
4,30	80 x 47	2439--0430
4,40	80 x 47	2439--0440
4,50	80 x 47	2439--0450
4,60	80 x 47	2439--0460
4,70	80 x 47	2439--0470
4,80	86 x 52	2439--0480
4,90	86 x 52	2439--0490
5,00	86 x 52	2439--0500
5,10	86 x 52	2439--0510
5,20	86 x 52	2439--0520
5,30	86 x 52	2439--0530
5,40	93 x 57	2439--0540
5,50	93 x 57	2439--0550
5,60	93 x 57	2439--0560
5,70	93 x 57	2439--0570
5,80	93 x 57	2439--0580
5,90	93 x 57	2439--0590
6,00	93 x 57	2439--0600
6,10	101 x 63	2439--0610
6,20	101 x 63	2439--0620
6,30	101 x 63	2439--0630
6,40	101 x 63	2439--0640

Ø A	LT x Lt	Item code
6,50	101 x 63	2439--0650
6,60	109 x 69	2439--0660
6,70	109 x 69	2439--0670
6,80	109 x 69	2439--0680
6,90	109 x 69	2439--0690
7,00	109 x 69	2439--0700
7,10	109 x 69	2439--0710
7,20	109 x 69	2439--0720
7,30	109 x 69	2439--0730
7,40	109 x 69	2439--0740
7,50	109 x 69	2439--0750
7,60	117 x 75	2439--0760
7,70	117 x 75	2439--0770
7,80	117 x 75	2439--0780
7,90	117 x 75	2439--0790
8,00	117 x 75	2439--0800
8,10	117 x 75	2439--0810
8,20	117 x 75	2439--0820
8,30	117 x 75	2439--0830
8,40	117 x 75	2439--0840
8,50	117 x 75	2439--0850
8,60	125 x 81	2439--0860
8,70	125 x 81	2439--0870
8,80	125 x 81	2439--0880
8,90	125 x 81	2439--0890
9,00	125 x 81	2439--0900
9,50	125 x 81	2439--0950
10,00	133 x 87	2439--1000
10,50	133 x 87	2439--1050
11,00	142 x 94	2439--1100
11,50	142 x 94	2439--1150
12,00	151 x 101	2439--1200
12,50	151 x 101	2439--1250
13,00	151 x 101	2439--1300
13,50	160 x 108	2439--1350
14,00	160 x 108	2439--1400
14,50	169 x 114	2439--1450
15,00	169 x 114	2439--1500
15,50	178 x 120	2439--1550
16,00	178 x 120	2439--1600

Ø A	LT x Lt	Item code
5,00	132 x 87	2436--0500
5,10	132 x 87	2436--0510
5,20	132 x 87	2436--0520
5,30	132 x 87	2436--0530
5,40	139 x 91	2436--0540
5,50	139 x 91	2436--0550
5,60	139 x 91	2436--0560
5,70	139 x 91	2436--0570
5,80	139 x 91	2436--0580
5,90	139 x 91	2436--0590
6,00	139 x 91	2436--0600
6,10	148 x 97	2436--0610
6,20	148 x 97	2436--0620
6,30	148 x 97	2436--0630
6,40	148 x 97	2436--0640
6,50	148 x 97	2436--0650
6,60	148 x 97	2436--0660
6,70	148 x 97	2436--0670
6,80	156 x 102	2436--0680
6,90	156 x 102	2436--0690
7,00	156 x 102	2436--0700
7,10	156 x 102	2436--0710
7,20	156 x 102	2436--0720
7,30	156 x 102	2436--0730
7,40	156 x 102	2436--0740
7,50	156 x 102	2436--0750
7,60	165 x 109	2436--0760
7,70	165 x 109	2436--0770
7,80	165 x 109	2436--0780
7,90	165 x 109	2436--0790
8,00	165 x 109	2436--0800
8,10	165 x 109	2436--0810
8,20	165 x 109	2436--0820
8,30	165 x 109	2436--0830
8,40	165 x 109	2436--0840
8,50	165 x 109	2436--0850
8,60	175 x 115	2436--0850
8,70	175 x 115	2436--0850
8,80	175 x 115	2436--0850
8,90	175 x 115	2436--0850

Ø A	LT x Lt	Item code
9,00	175 x 115	2436--0900
9,50	175 x 115	2436--0950
10,00	184 x 121	2436--1000
10,50	184 x 121	2436--1050
11,00	195 x 128	2436--1100
11,50	195 x 128	2436--1150
12,00	205 x 134	2436--1200
12,50	205 x 134	2436--1250
13,00	205 x 134	2436--1300
13,50	214 x 140	2436--1350
14,00	214 x 140	2436--1400
14,50	220 x 144	2436--1450
15,00	220 x 144	2436--1500
15,50	227 x 149	2436--1500
16,00	227 x 149	2436--1600

CUTTING CONDITIONS

ISO Material Group	Material	Hardness	2409 2418	2436 2439	2419 2429	Vc m/min	f en mm/tr	Vc m/min	f en mm/tr	Vc m/min	f en mm/tr
						2409 - 2418		2436 - 2439		2419 - 2429	
P	Steel	< 200 HB	..	-	-	30 à 60	G2	-	-	-	-
	Steel	200 à 300 HB	...	-	-	25 à 50	G2	-	-	-	-
	Steel	300 à 400 HB		-	-	15 à 30	G1	-	-	-	-
M	Martensitic / ferritic stainless steel	< 200 HB	..	-	-	15 à 30	G2	-	-	-	-
		220 à 280 HB	..	-	-	12 à 25	G2	-	-	-	-
		280 à 370 HB	..	-	-	10 à 15	G1	-	-	-	-
	Austenitic stainless steel	< 220 HB	..	-	-	12 à 25	G2	-	-	-	-
		220 à 280 HB	..	-	-	8 à 15	G1	-	-	-	-
K	Laminated Cast Iron Ft10...Ft40	< 140 HB	...	-	-	60 à 80	G3	-	-	-	-
		140 à 210 HB	...	-	-	50 à 70	G3	-	-	-	-
		210 à 260 HB	...	-	-	40 à 60	G2	-	-	-	-
		260 à 320 HB		-	-	30 à 50	G2	-	-	-	-
	Nodular graphite cast iron FGS400...FGS800	< 220 HB	...	-	-	40 à 60	G2	-	-	-	-
		220 à 270 HB	...	-	-	30 à 50	G2	-	-	-	-
		270 à 350 HB		-	-	20 à 40	G1	-	-	-	-
S	Refractory Steel	< 260 HB	..	-	-	8 à 15	G2	-	-	-	-
		260 à 320 HB	..	-	-	8 à 12	G1	-	-	-	-
		320 à 420 HB	...	-	-	6 à 10	G1	-	-	-	-
	Titanium / Titanium alloys	< 600 N/mm²	.	-	-	30 à 40	G3	-	-	-	-
		600 à 1000 N/mm²	.	-	-	20 à 35	G2	-	-	-	-
		1000 à 1500 N/mm²	..	-	-	18 à 25	G2	-	-	-	-
H	Steel	40 à 50 HRC		-	-	8 à 15	G1	-	-	-	-
	Steel	50 à 60 HRC		-	-	6 à 10	G1	-	-	-	-
N	Alluminium alloy < 10% Si	< 600 N/mm²	.		-	40 à 150	G6	40 à 150	G7	-	-
	Alluminium alloy > 10% Si	< 600 N/mm²	.		-						
	Bronze	100 HB	...		-	40 à 100	G8	40 à 100	G8	-	-
	Brass	200 HB	...		-						
	Copper	200 HB	...		-						
	Aluminium bronze	200 HB	.	...	-						
	Graphite	-		...		20 à 100	G5	20 à 100	G5	20 à 100	G5
	Epoxy resin	-	...								
	Duroplastic	-	..								
	Thermoplastic	-	..		-						
	Carbon fibres	-	..		...						
	Carbon fibres - Aluminium	-	.		-						
	Carbon fibres - Titanium	-	.	..	-						
						20 à 40	G4	20 à 40	G4	-	-

P Steels
 M Stainless steels
 K Cast iron
 S Refractive superalloys
 H Hard metals
 N Non-ferrous materials

DRILLING FEED GROUP

Drill bit diameter	G1	G2	G3	G4	G5	G6	G7	G8	G9	G10	G11
	feed rates in mm/drill bit revolution										
3	0,019	0,024	0,033	0,036	0,036	0,045	0,06	0,069	0,08	0,09	0,11
4	0,022	0,03	0,036	0,043	0,045	0,06	0,085	0,09	0,11	0,13	0,15
5	0,025	0,035	0,04	0,05	0,055	0,075	0,11	0,12	0,14	0,16	0,2
6	0,029	0,04	0,05	0,057	0,066	0,09	0,013	0,14	0,17	0,2	0,25
7	0,032	0,044	0,06	0,064	0,077	0,105	0,14	0,17	0,21	0,24	0,3
8	0,036	0,048	0,062	0,072	0,088	0,12	0,16	0,2	0,23	0,27	0,36
9	0,4	0,052	0,064	0,08	0,1	0,13	0,18	0,21	0,26	0,31	0,4
10	0,045	0,055	0,065	0,09	0,11	0,14	0,21	0,24	0,3	0,35	0,47
11	0,046	0,057	0,068	0,1	0,12	0,15	0,22	0,26	0,33	0,41	0,53
12	0,048	0,06	0,072	0,11	0,13	0,17	0,24	0,29	0,36	0,48	0,6
13	0,49	0,062	0,074	0,12	0,15	0,18	0,25	0,3	0,37	0,52	0,65
14	0,05	0,065	0,076	0,14	0,16	0,2	0,26	0,32	0,38	0,54	0,7
15	0,052	0,067	0,78	0,15	0,17	0,22	0,27	0,33	0,38	0,56	0,73
16	0,055	0,07	0,08	0,16	0,18	0,23	0,28	0,35	0,4	0,58	0,76
17	0,056	0,075	0,085	0,18	0,2	0,24	0,3	0,37	0,42	0,6	0,78
18	0,06	0,08	0,09	0,2	0,22	0,25	0,32	0,4	0,44	0,6	0,8
19	0,065	0,085	0,1	0,22	0,24	0,26	0,34	0,42	0,46	0,62	0,82
20	0,07	0,09	0,12	0,024	0,26	0,028	0,36	0,45	0,48	0,64	0,84
21	0,08	0,1	0,13	0,025	0,27	0,3	0,37	0,47	0,52	0,68	0,87
22	0,1	0,12	0,14	0,26	0,28	0,32	0,38	0,5	0,56	0,72	0,9
23	0,11	0,13	0,15	0,28	0,3	0,33	0,4	0,55	0,65	0,8	1
24	0,12	0,14	0,16	0,3	0,34	0,36	0,45	0,6	0,7	1	1,1



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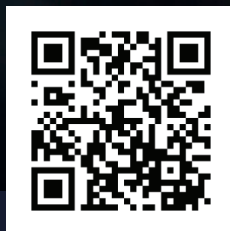
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