

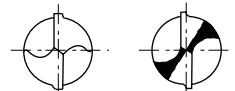


### HSSCo8, STRAIGHT SHANK TWIST DRILLS PUNTE ELICOIDALI, GAMBO CILINDRICO, HSSCo8

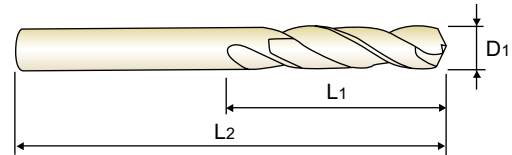
**STUB  
EXTRA CORTA**

► **Surface treatment:** Bright  
► **Application:** Suitable for drilling thin materials with portable electric drills.  
Special twist drills for automatic and turret lathes

► **Tratt. Superf.:** Lucido  
► **Applicazioni:** Adatte alla foratura di spessori sottili con trapani portatili.  
Adatte per lavorazioni su macchine automatiche.



fino 1.6mm      oltre 1.6mm



Unità: mm

CODICE	Diametro punta	Lunghezza elica	Lunghezza totale	CODICE	Diametro punta	Lunghezza elica	Lunghezza totale
	D1	L1	L2		D1	L1	L2
D2107010	1.0	6	26	D2107031	3.1	18	49
D2107011	1.1	7	28	D2107032	3.2	18	49
D2107012	1.2	8	30	D2107932	3.25	18	49
D2107912	1.25	8	30	D2107033	3.3	18	49
D2107013	1.3	8	30	D2107034	3.4	20	52
D2107014	1.4	9	32	D2107035	3.5	20	52
D2107015	1.5	9	32	D2107036	3.6	20	52
D2107016	1.6	10	34	D2107037	3.7	20	52
D2107017	1.7	10	34	D2107937	3.75	20	52
D2107917	1.75	11	36	D2107038	3.8	22	55
D2107018	1.8	11	36	D2107039	3.9	22	55
D2107019	1.9	11	36	D2107040	4.0	22	55
D2107020	2.0	12	38	D2107041	4.1	22	55
D2107021	2.1	12	38	D2107042	4.2	22	55
D2107022	2.2	13	40	D2107942	4.25	22	55
D2107922	2.25	13	40	D2107043	4.3	24	58
D2107023	2.3	13	40	D2107044	4.4	24	58
D2107024	2.4	14	43	D2107045	4.5	24	58
D2107025	2.5	14	43	D2107046	4.6	24	58
D2107925	2.55	14	43	D2107946	4.65	24	58
D2107026	2.6	14	43	D2107047	4.7	24	58
D2107027	2.7	16	46	D2107947	4.75	24	58
D2107927	2.75	16	46	D2107048	4.8	26	62
D2107028	2.8	16	46	D2107049	4.9	26	62
D2107029	2.9	16	46	D2107050	5.0	26	62
D2107030	3.0	16	46	D2107051	5.1	26	62

► SEGUE

©: Specifico ○: Adatto

ISO	P										M				K						
	Acciai non legati					Acciai basso legati					Acciai inox				Ghisa grigia		Ghisa nodulare		Ghisa malleabile		
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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Consigliato	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
ISO	N										S					H					
	Leghe di alluminio		Alluminio fuso, legato			Rame e leghe di rame (Bronzo / Ottone)			Materiali non ferrosi		Super leghe resistenti al calore					Leghe di titanio		Acciai temprati		Fusione di ghisa	Ghisa indurita
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
Consigliato	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○


**D2107, D2105, DL105, D1105,  
D2104, D1121, DL109** SERIES

**Punte in HSS, HSS-E & HSS Co8**

 n = giri/min.  
fn = mm/giro

ISO	VDI 3323	Descrizione materiale	Vc (m/min)	Parametri	Diametro punta (mm)				
					2.0	3.0	4.0	6.0	8.0
P	1	Acciai non legati	30	n fn	4770 0.02~0.04	3180 0.03~0.05	2390 0.04~0.06	1590 0.05~0.08	1190 0.10~0.13
	2		25	n fn	3980 0.02~0.04	2650 0.03~0.05	1990 0.04~0.06	1330 0.05~0.08	990 0.10~0.13
	3		20	n fn	3180 0.02~0.04	2120 0.03~0.05	1590 0.04~0.06	1060 0.05~0.08	800 0.10~0.13
	4		20	n fn	3180 0.01~0.02	2120 0.01~0.03	1590 0.02~0.04	1060 0.02~0.05	800 0.03~0.06
	5								
	6	Acciai basso legati	25	n fn	3980 0.02~0.04	2650 0.03~0.05	1990 0.04~0.06	1330 0.05~0.08	990 0.10~0.13
	7		20	n fn	3180 0.02~0.04	2120 0.03~0.05	1590 0.04~0.06	1060 0.05~0.08	800 0.10~0.13
	8		20	n fn	3180 0.01~0.02	2120 0.01~0.03	1590 0.02~0.04	1060 0.02~0.05	800 0.03~0.06
	9								
	10	Acciai alto legati Acciai da utensili	15	n fn	2390 0.02~0.04	1590 0.03~0.05	1190 0.04~0.06	800 0.05~0.08	600 0.10~0.13
	11								
M	12	Acciai inox	20	n fn	3180 0.02~0.04	2120 0.03~0.05	1590 0.04~0.06	1060 0.05~0.08	800 0.10~0.13
	13		15	n fn	2390 0.02~0.04	1590 0.03~0.05	1190 0.04~0.06	800 0.05~0.08	600 0.10~0.13
	14		10	n fn	1590 0.01~0.02	1060 0.01~0.03	800 0.02~0.04	530 0.02~0.05	400 0.03~0.06
K	15	Ghisa grigia	30	n fn	4770 0.02~0.04	3180 0.03~0.05	2390 0.04~0.06	1590 0.05~0.08	1190 0.10~0.13
	16		25	n fn	3980 0.01~0.02	2650 0.01~0.03	1990 0.02~0.04	1330 0.02~0.05	990 0.03~0.06
	17	Ghisa nodulare	30	n fn	4770 0.02~0.04	3180 0.03~0.05	2390 0.04~0.06	1590 0.05~0.08	1190 0.10~0.13
	18								
	19	Ghisa malleabile	25	n fn	3980 0.02~0.04	2650 0.03~0.05	1990 0.04~0.06	1330 0.05~0.08	990 0.10~0.13
20									
N	21	Leghe di alluminio	55	n fn	8750 0.03~0.06	5840 0.05~0.09	4380 0.07~0.11	2920 0.12~0.16	2190 0.12~0.18
	22		55	n fn	8750 0.03~0.06	5840 0.05~0.09	4380 0.07~0.11	2920 0.12~0.16	2190 0.12~0.18
	23	Alluminio fuso, legato	40	n fn	6370 0.03~0.06	4240 0.05~0.09	3180 0.07~0.11	2120 0.12~0.16	1590 0.12~0.18
	24								
	25								
	26	Rame e leghe di rame (Bronzo / Ottone)							
	27								
28									
29	Materiali non ferrosi	20	n fn	3180 0.02~0.04	2120 0.03~0.05	1590 0.04~0.06	1060 0.05~0.08	800 0.10~0.13	
30									
S	31	Super leghe resistenti al calore							
	32								
	33								
	34								
	35								
	36	Leghe di titanio	10	n fn	1590 0.01~0.03	1060 0.02~0.04	800 0.03~0.05	530 0.04~0.07	400 0.05~0.08
	37								
H	38	Acciai temprati							
	39								
	40	Fusione di ghisa							
	41	Ghisa indurita							

n = giri/min.  
 fn = mm/giro

VDI 3323	Parametri	Diametro punta (mm)					
		10.0	13.0	16.0	18.0	20.0	30.0
1	n	950	730	600	530	480	320
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
2	n	800	610	500	440	400	270
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
3	n	640	490	400	350	320	210
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
4	n	640	490	400	350	320	210
	fn	0.03~0.06	0.04~0.10	0.06~0.12	0.08~0.14	0.10~0.16	0.12~0.18
5							
6	n	800	610	500	440	400	270
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
7	n	640	490	400	350	320	210
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
8	n	640	490	400	350	320	210
	fn	0.03~0.06	0.04~0.10	0.06~0.12	0.08~0.14	0.10~0.16	0.12~0.18
9							
10	n	480	370	300	270	240	160
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
11							
12	n	640	490	400	350	320	210
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
13	n	480	370	300	270	240	160
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
14	n	320	240	200	180	160	110
	fn	0.03~0.06	0.04~0.10	0.06~0.12	0.08~0.14	0.10~0.16	0.12~0.18
15	n	950	730	600	530	480	320
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
16	n	800	610	500	440	400	270
	fn	0.03~0.06	0.04~0.10	0.06~0.12	0.08~0.14	0.10~0.16	0.12~0.18
17	n	950	730	600	530	480	320
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
18							
19	n	800	610	500	440	400	270
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
20							
21	n	1750	1350	1090	970	880	580
	fn	0.14~0.20	0.16~0.22	0.18~0.24	0.20~0.28	0.20~0.30	0.28~0.38
22	n	1750	1350	1090	970	880	580
	fn	0.14~0.20	0.16~0.22	0.18~0.24	0.20~0.28	0.20~0.30	0.28~0.38
23	n	1270	980	800	710	640	420
	fn	0.14~0.20	0.16~0.22	0.18~0.24	0.20~0.28	0.20~0.30	0.28~0.38
24							
25							
26							
27							
28							
29	n	640	490	400	350	320	210
	fn	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
30							
31							
32							
33							
34							
35							
36	n	320	240	200	180	160	110
	fn	0.05~0.09	0.06~0.10	0.05~0.11	0.06~0.12	0.09~0.13	0.12~0.18
37							
38							
39							
40							
41							