

**HSS**



Being the best through innovation




# NC-SPOTTING DRILLS

## NC-ANBOHRER

- HSS(8% COBALT)  
Centering and Chamfering of Holes
- HSS-Co8 NC-ANBOHRER  
Zum Zentrieren und Anfasen

# SELECTION GUIDE

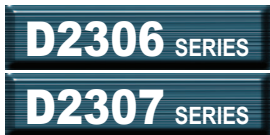
## HSS(8% Cobalt) NC-SPOTTING DRILLS Centering and Chamfering of Holes

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
<b>D2306</b> <b>D2307</b>		HSSCo8, NC-SPOTTING DRILLS HSSCo8, NC-ANBOHRER	D3.0	D20.0	<b>206</b>
		RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN			<b>207</b>

# HSS NC-SPOTTING DRILLS

◎ : Excellent  
○ : Good

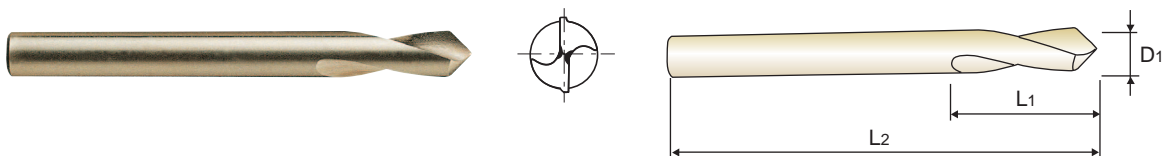
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
			HRc45~55	HRc55~							
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎					○	○		○		○



## HSSCo8, NC-SPOTTING DRILLS HSSCo8, 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** : Für positionsgenaueres und schnelles Anbohren mit NC/CNC-Maschinen und Bearbeitungszentren, die Ausführung mit Spitzenwinkel 90° ermöglicht sowohl ein Zentrieren, als auch das Vorbohren für einen nächstgrößeren Durchmesser.



### NC-Anbohrer 90° NC-Spotting drills 90°

### NC-Anbohrer 120° NC-Spotting drills 120°

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2		D1	L1	L2
D2306030	3.0	12	46	D2307030	3.0	12	46
D2306040	4.0	12	55	D2307040	4.0	12	55
D2306050	5.0	15	60	D2307050	5.0	15	60
D2306060	6.0	20	66	D2307060	6.0	20	66
D2306080	8.0	25	79	D2307080	8.0	25	79
D2306100	10.0	25	89	D2307100	10.0	25	89
D2306120	12.0	30	102	D2307120	12.0	30	102
D2306160	16.0	35	115	D2307160	16.0	35	115
D2306200	20.0	40	131	D2307200	20.0	40	131

► TiN(D4306, D4307), TiCN(D7306, D7307) and TiAlN(DQ306, DQ307) are available on your request.

◎ : Excellent ○ : Good

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

**HSSCo8, NC-SPOTTING DRILLS 90°, 120°**  
**HSSCo8, NC-ANBOHRER 90°, 120°**
**D2306, D2307** SERIES

Unit : mm

WORK MATERIAL DIAMETER	CARBON STEELS		ALLOY STEELS		ALLOY STEELS, TOOL STEELS, HARDENED STEELS		STAINLESS STEELS		ALUMINUM, ALUMINUM ALLOYS	
	N	S	N	S	N	S	N	S	N	S
3	2460	0.06	2110	0.06	1080	0.06	940	0.06	7040	0.14
4	1850	0.07	1580	0.07	800	0.07	700	0.07	5280	0.15
5	1510	0.08	1300	0.08	670	0.08	580	0.08	4400	0.17
6	1170	0.09	1030	0.09	540	0.09	460	0.09	3520	0.19
8	880	0.11	790	0.11	400	0.11	350	0.11	2640	0.22
10	700	0.12	630	0.12	320	0.12	290	0.12	2110	0.25
12	590	0.14	530	0.14	260	0.14	240	0.14	1760	0.28
16	460	0.20	400	0.20	200	0.20	180	0.20	1320	0.33
20	350	0.24	320	0.24	150	0.24	140	0.24	1060	0.45

N = R.P.M

S = Feed per Revolution (mm/rev.)