Coolant-through carbide drill series for Titanium Alloys and Stainless Steel

ADO-SUS

Volume 3

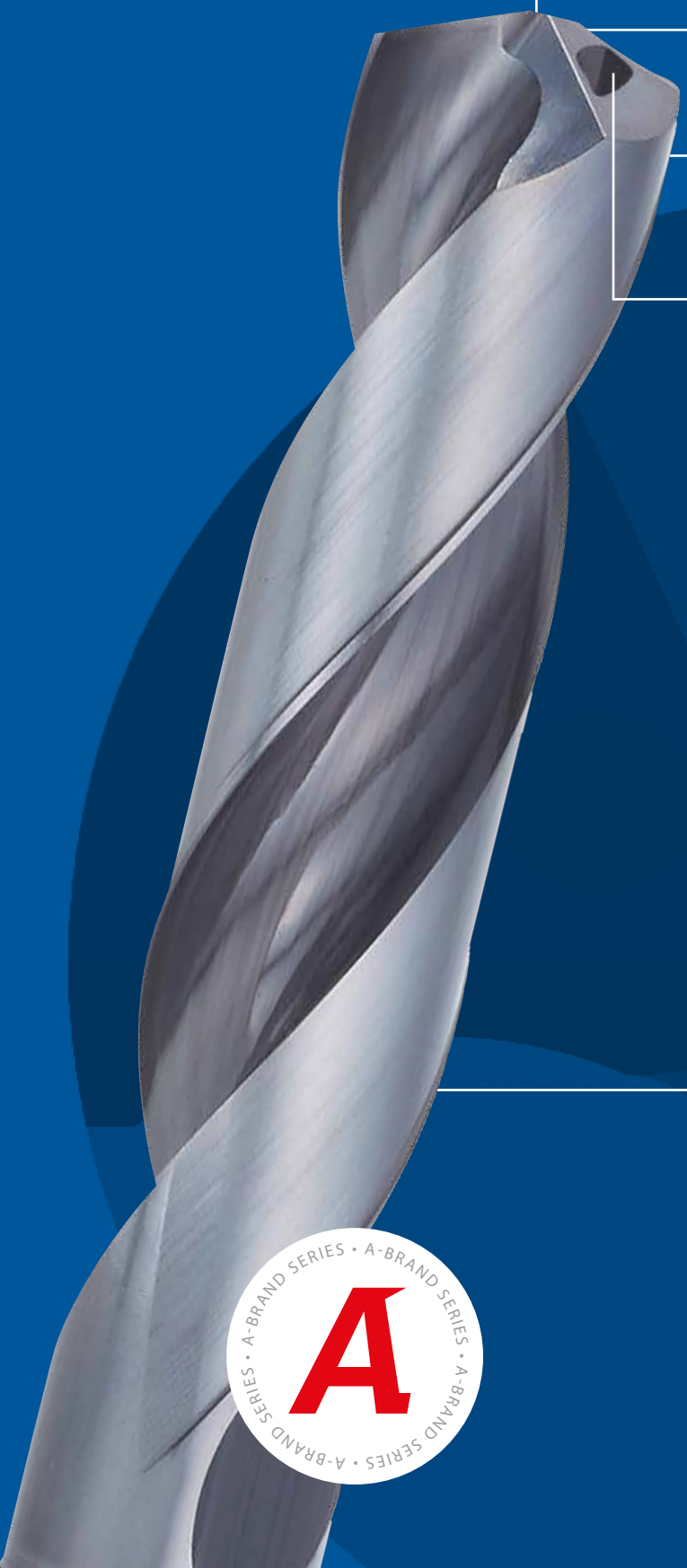
NEW SIZES • NEW SIZES • NEW SIZES • NEW SIZES • NEW SIZES • NEW SIZES

53
NEW DIN
SHANK SIZES ADDED

A-BRAND SERIES • A-BRAND SERIES • A-BRAND SERIES • A-BRAND SERIES

A

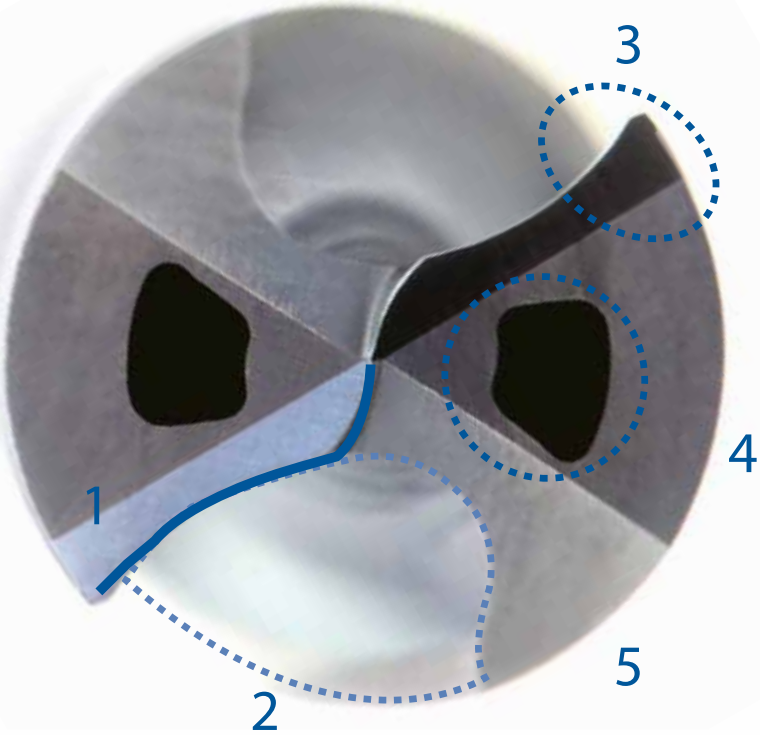
KEY FEATURES: ADO-SUS SERIES



1. Sharp cutting edge
2. New flute geometry
3. Special margin shape
4. New coolant hole shape
5. WXL® Coating

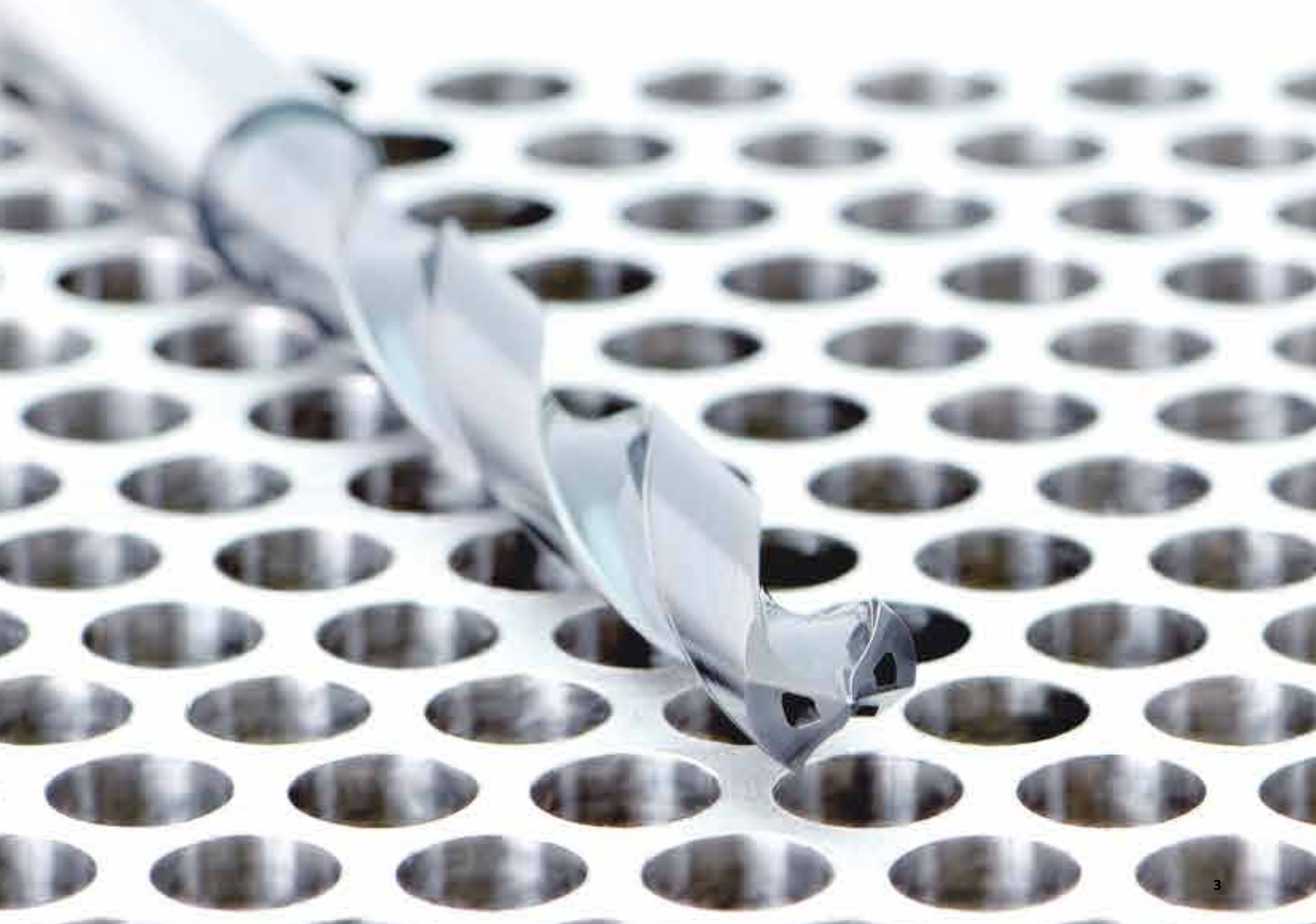
ADO-SUS DRILL FOR STAINLESS STEELS, TITANIUM ALLOYS & VARIOUS MATERIALS

OSG's next generation of carbide drills is an almighty one. Focused on the reduction of thrust and aimed at machining Stainless Steel, ADO-SUS-3D/5D is the perfect drill to use for your machine. The flute design produces optimal chip shape, thereby realizing smooth chip evacuation.
The margin form is designed to realize low resistance and low cutting temperature.



Common machining problems associated with these materials :

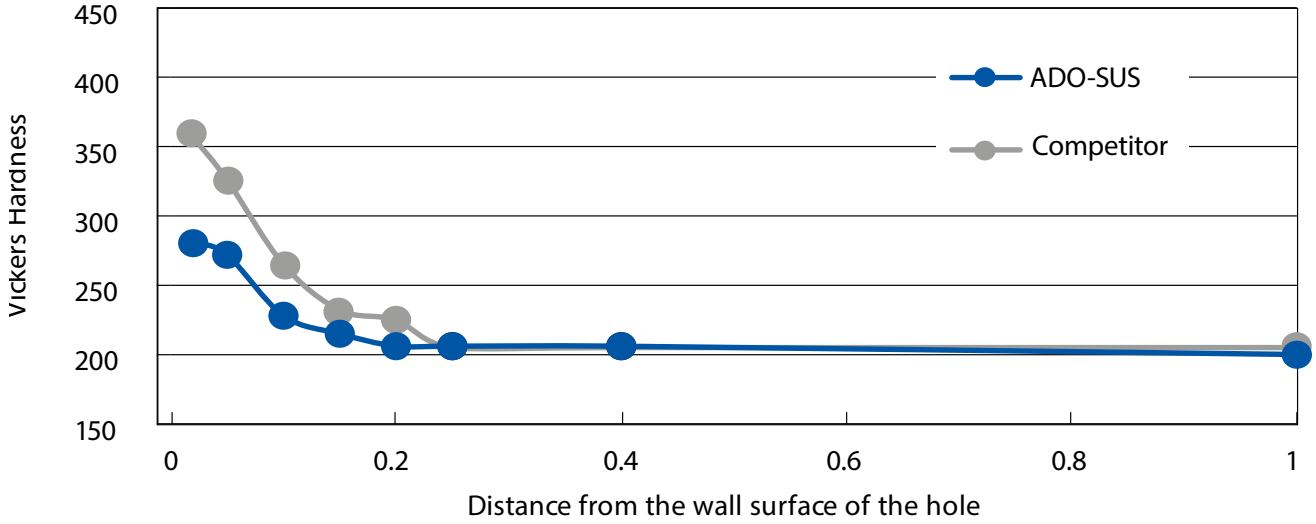
- Work hardening tendency
- Elongation of chips
- Low thermal conductivity
- Welding on cutting tool



1 Solution for work hardening - Sharp cutting edge

Reduces work hardening, which leads to longer tool life during tapping and reaming

Tool	ADO-SUS-5D φ10	Speed	70m/min (2,229min^{-1})	Coolant	1.5MPa Water Soluble Internal
Work Material	SUS3040C	Feed Rate	446mm/min(0.2mm/rev)	Machine	Horizontal Machining Center

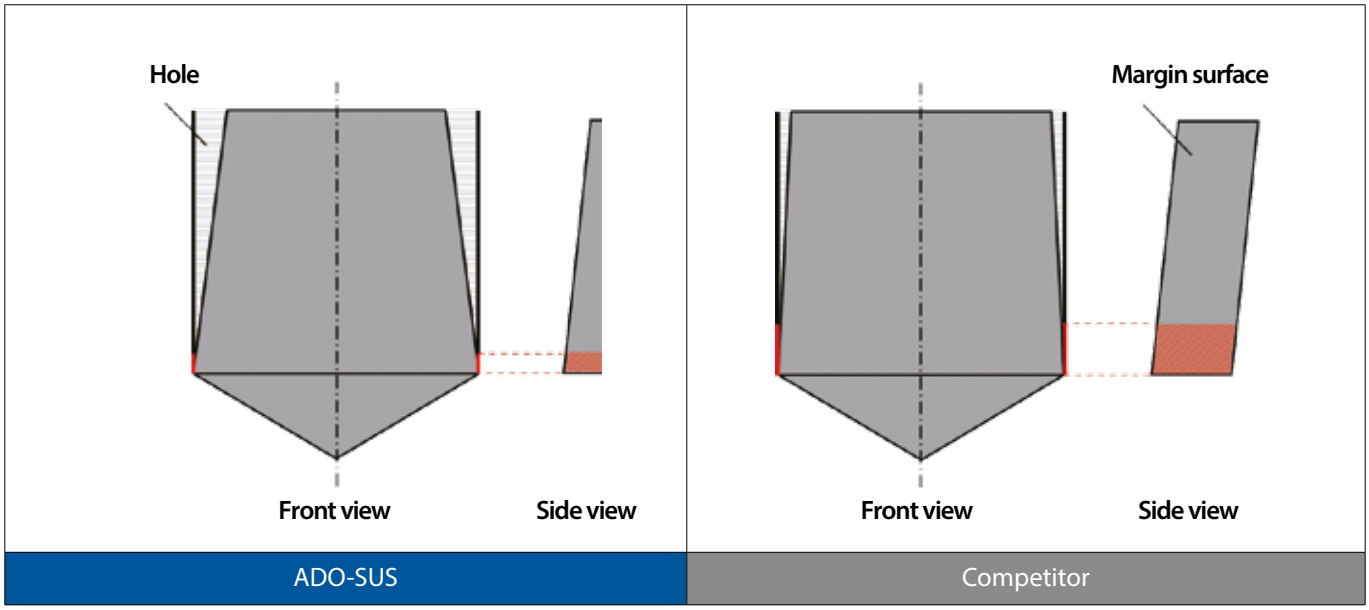


2 Solution for elongation of chips - New flute geometry

Enables the creation of compact cutting chips

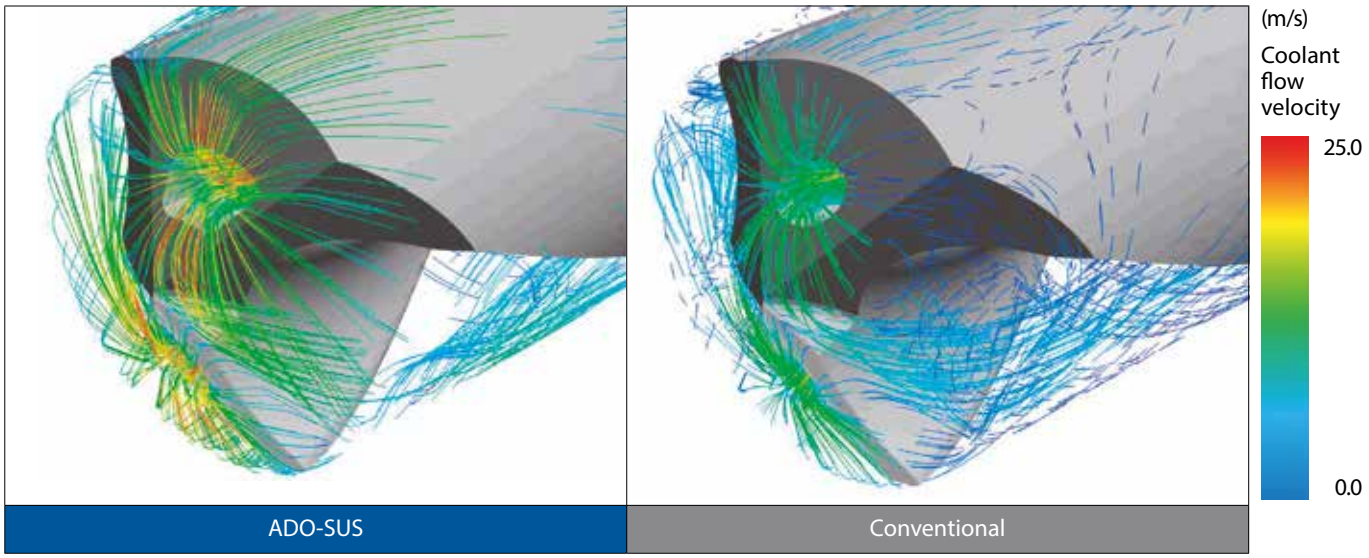
3 Solution for high machining heat - Special margin shape

Reduces friction and heat generation



4 Solution for high machining heat - New coolant hole shape

Improves coolant flow, chip evacuation and cutting heat generation



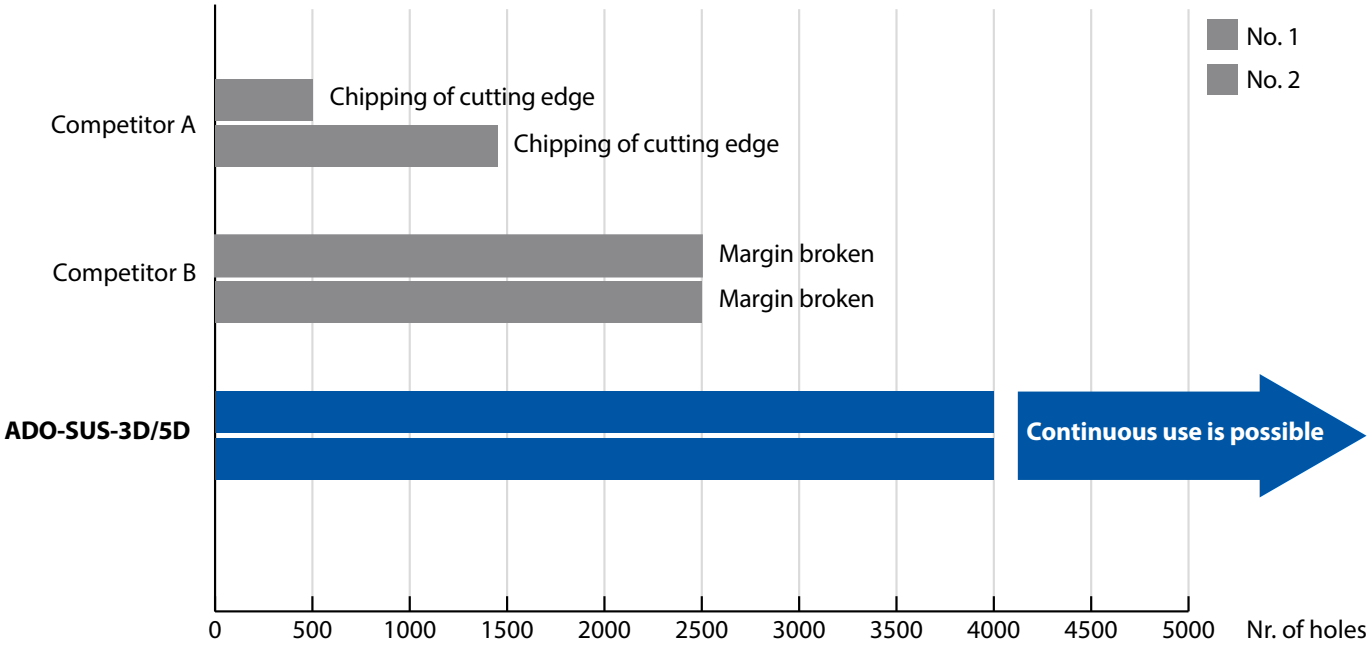
Analysis of coolant flow with spindle speed of 2,200min^{-1}

5 Solution for welding - WXL® coating

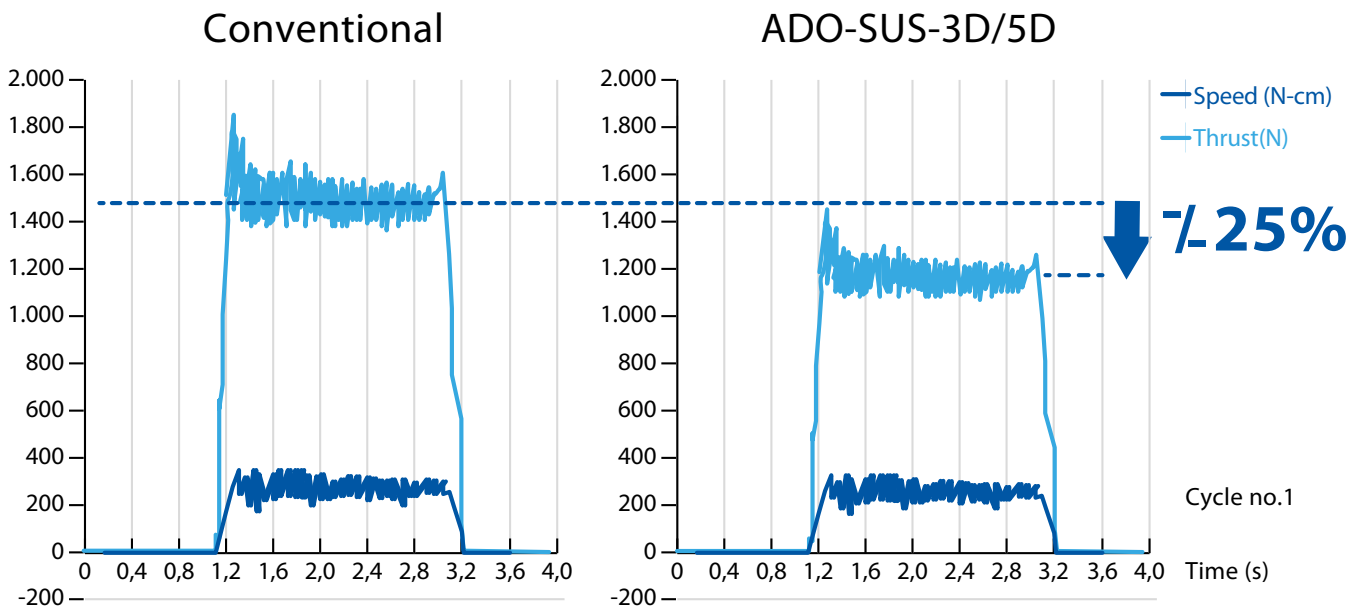
High adhesion strength, which minimizes the possibility of chipping

PERFORMANCE ADO-SUS-3D/5D VERSUS CONVENTIONAL TYPE IN STAINLESS STEEL

Cutting Dia	Ø6	Speed	80m/min	Depth of Hole	25mm (Through hole)
Material	SUS304 (1.4301)	Feed Rate	0,18mm/rev (3% x D)	Coolant	Internal - Emulsion - 1,5Mpa

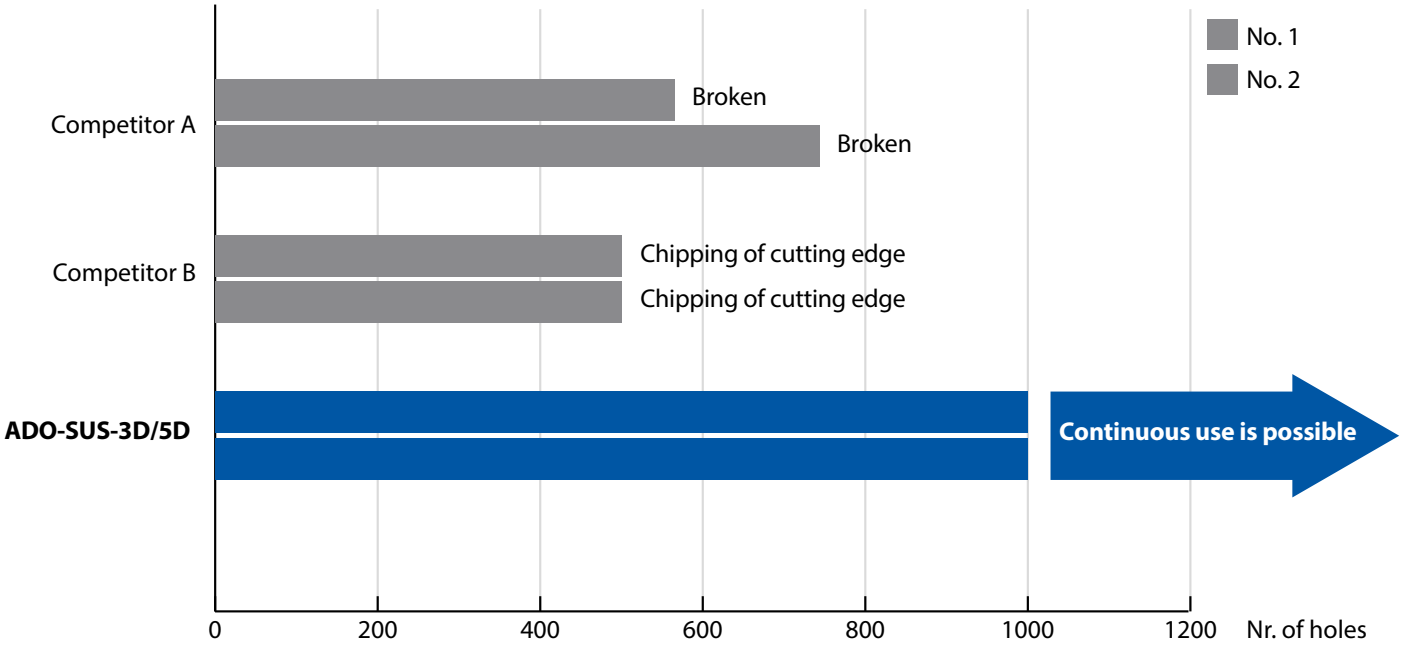


CONVENTIONAL TYPE VERSUS ADO-SUS-3D/5D



PERFORMANCE ADO-SUS-3D/5D VERSUS CONVENTIONAL TYPE IN CARBON STEEL

Cutting Dia	Ø10	Speed	100m/min	Depth of Hole	50mm (Through hole)
Material	S50C (1.1213)	Feed Rate	0,30mm/rev (3% x D)	Coolant	Internal - Emulsion - 1,5Mpa

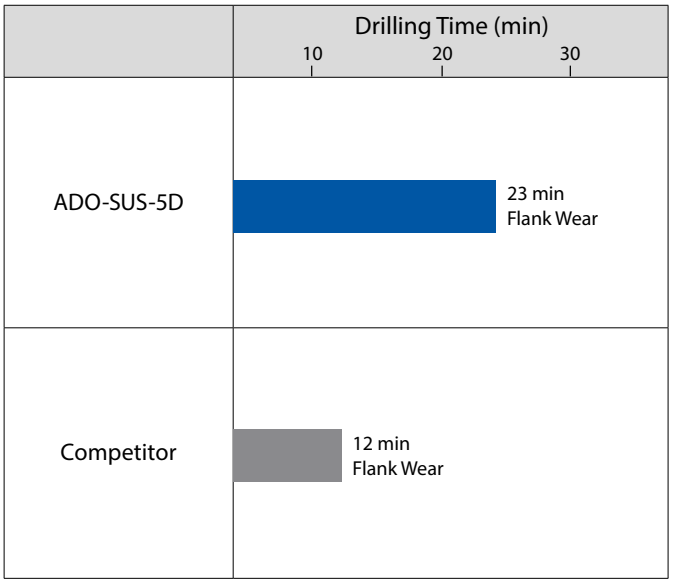


CUTTING CONDITIONS ADO-SUS-3D/5D/8D

	Carbon Steel S50C		Alloy Steel SCM440		Alloy Steel SCM440 • 30HRC		Stainless Steel SUS304 - SUS316		Super Duplex SUS630 • 17-4PH • 15-5PH		Ti Alloy	
Vc	80 ~ 120 m/min		80 ~ 120 m/min		60 ~ 90 m/min		60 ~ 100 m/min		30 ~ 60 m/min		20 ~ 50 m/min	
Ø	S (min^{-1})	F (mm/rev.)	S (min^{-1})	F (mm/rev.)	S (min^{-1})	F (mm/rev.)	S (min^{-1})	F (mm/rev.)	S (min^{-1})	F (mm/rev.)	S (min^{-1})	F (mm/rev.)
3	10.600	0,06~0,12	10.600	0,06~0,12	7.400	0,06~0,12	8.500	0,06~0,12	4.800	0,06~0,09	3.700	0,05~0,09
4	8.000	0,08~0,16	8.000	0,08~0,16	5.600	0,08~0,16	6.400	0,08~0,16	3.600	0,08~0,12	2.800	0,06~0,12
5	6.400	0,10~0,20	6.400	0,10~0,20	4.500	0,10~0,20	5.100	0,10~0,20	2.900	0,10~0,15	2.200	0,08~0,15
6	5.300	0,12~0,24	5.300	0,12~0,24	3.700	0,12~0,24	4.200	0,12~0,24	2.400	0,12~0,18	1.900	0,09~0,18
7	4.500	0,14~0,26	4.500	0,14~0,26	3.200	0,14~0,26	3.600	0,14~0,26	2.000	0,14~0,21	1.600	0,11~0,21
8	4.000	0,16~0,28	4.000	0,16~0,28	2.800	0,16~0,28	3.200	0,16~0,28	1.800	0,16~0,24	1.400	0,12~0,24
9	3.500	0,18~0,30	3.500	0,18~0,30	2.500	0,18~0,30	2.800	0,18~0,30	1.600	0,18~0,27	1.200	0,14~0,27
10	3.200	0,20~0,30	3.200	0,20~0,30	2.200	0,20~0,30	2.500	0,20~0,30	1.400	0,20~0,30	1.100	0,15~0,30
11	2.900	0,20~0,30	2.900	0,20~0,30	2.000	0,20~0,30	2.300	0,20~0,30	1.300	0,20~0,30	1.000	0,15~0,30
12	2.700	0,21~0,30	2.700	0,21~0,30	1.900	0,21~0,30	2.100	0,21~0,30	1.200	0,21~0,30	900	0,16~0,30
13	2.400	0,21~0,33	2.400	0,21~0,33	1.700	0,21~0,33	2.000	0,21~0,33	1.100	0,21~0,33	900	0,18~0,33
14	2.300	0,22~0,35	2.300	0,22~0,35	1.600	0,22~0,35	1.800	0,22~0,35	1.000	0,22~0,35	800	0,19~0,35
16	2.000	0,25~0,36	2.000	0,25~0,36	1.400	0,25~0,36	1.600	0,25~0,36	900	0,25~0,36	700	0,22~0,36
18	1.800	0,28~0,38	1.800	0,28~0,38	1.200	0,28~0,38	1.400	0,28~0,38	800	0,28~0,38	600	0,24~0,38
20	1.600	0,30~0,40	1.600	0,30~0,40	1.100	0,30~0,40	1.300	0,30~0,40	700	0,30~0,40	600	0,27~0,40

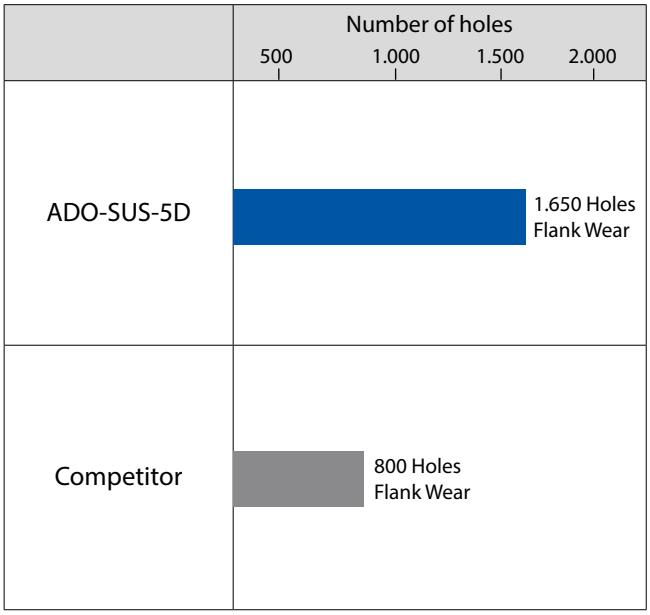
Machining precipitation hardening Stainless Steel

Tool	ADO-SUS-5D	Competitor
Size	Ø 6,7	
Work Material	15-5 PH	
Cutting Speed	50m/min (2.377 min^{-1})	
Feed Rate	357 mm/min (0,15 mm/rev)	
Depth of Hole	45 mm (Blind)	
Coolant	Water Soluble (Internal)	
Machine	Horizontal Machining Center	



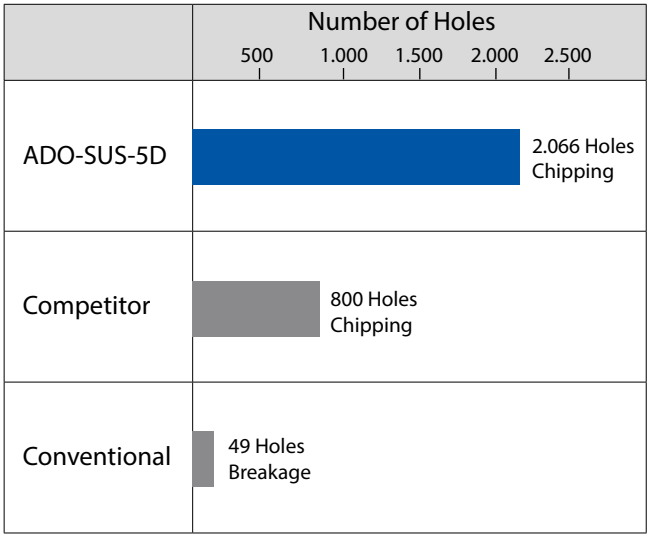
Machining Duplex Stainless Steel

Tool	ADO-SUS-5D	Competitor
Size	Ø 10,3	
Work Material	SUS329J3L	
Cutting Speed	65m/min (2.010 min^{-1})	
Feed Rate	462 mm/min (0,23 mm/rev)	
Depth of Hole	48 mm (Through)	
Coolant	Water Soluble (Internal)	
Machine	Multifunction Lathe	



ADO-SUS-3D in Titanium Alloy

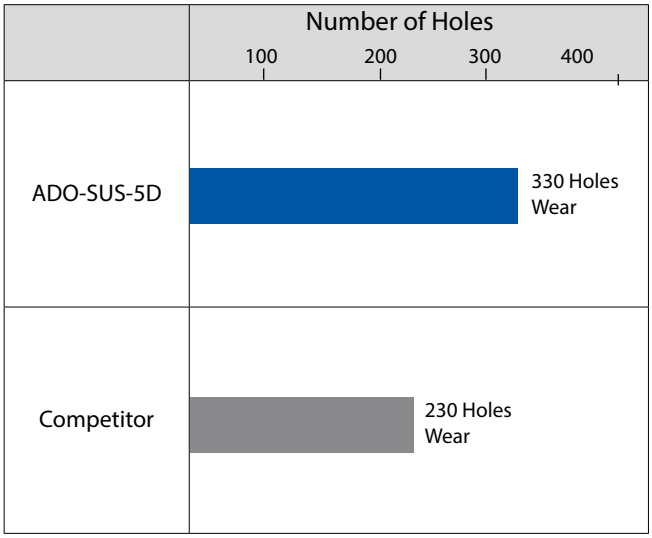
Tool	ADO-SUS-3D Ø 5,1
Work Material	Ti-6Al-4V (34~36 HRC) (After aging treatment)
Cutting Speed	40m/min (2.498 min^{-1})
Feed Rate	300 mm/min (0,12 mm/rev)
Depth of Hole	17 mm (Through)
Coolant	Water Soluble (Internal)
Machine	Horizontal Machining Center



Cutting chips

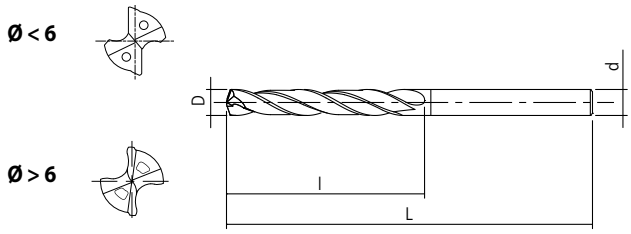
ADO-SUS-5D in Titanium Alloy

Tool	ADO-SUS-5D Ø 10,5
Work Material	Ti-6Al-4V
Cutting Speed	45m/min (1.365 min^{-1})
Feed Rate	177,5 mm/min (0,13 mm/rev)
Depth of Hole	29 mm (Blind)
Coolant	Water Soluble (Internal)
Machine	Horizontal Machining Center



ADO-SUS-3D NEW

Drilling | Solid carbide | 3xD



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- Up to 3xD
- Designed for stainless steel and titanium alloys
- 165 sizes

P	P	P	P	M	K	K	N	S	H	H	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	AC,ADC	Ti	25-35 HRC	35-45 HRC	45-52 HRC

A | CARBIDE | WXL | 30° | SHRINK FIT | 140° | h8

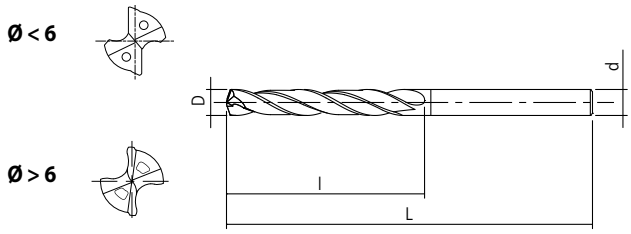
page 7

EDP	D	L	l	d	Price
8665200	2	66	12	3	
8665210	2,1	66	13	3	
8665220	2,2	66	14	3	
8665230	2,3	66	14	3	
8665240	2,4	66	15	3	
8665250	2,5	66	15	3	
8665260	2,6	66	16	3	
8665270	2,7	66	17	3	
8665280	2,8	66	17	3	
8665283	2,83	66	17	3	
8665287	2,87	66	18	3	
8665290	2,9	66	18	3	
8665300	3	66	18	3	
8665310	3,1	74	19	4	
8665315 NEW	3,15	74	19	4	
8665320	3,2	74	20	4	
8665326 NEW	3,26	74	20	4	
8665330	3,3	74	20	4	
8665340	3,4	74	21	4	
8665350	3,5	74	21	4	
8665360	3,6	74	22	4	
8665370	3,7	74	23	4	
8665373	3,73	74	23	4	
8665375 NEW	3,75	74	23	4	
8665380	3,8	74	23	4	
8665390	3,9	74	24	4	
8665400	4	74	24	4	
8680410	4,1	80	25	6	
8680420	4,2	80	26	6	
8680430	4,3	80	26	6	
8680440	4,4	80	27	6	
8680445	4,45	80	27	6	
8680450	4,5	80	27	6	
8680460	4,6	80	28	6	
8680465	4,65	80	28	6	
8680470	4,7	80	29	6	
8680480	4,8	80	29	6	
8665485 NEW	4,85	80	29	6	
8680490	4,9	80	30	6	
8680500	5	80	25	6	
8665510	5,1	82	26	6	
8665520	5,2	82	26	6	
8665525 NEW	5,25	82	27	6	
8665530	5,3	82	27	6	
8665540	5,4	82	27	6	

EDP	D	L	l	d	Price
8665550	5,5	82	28	6	
8680555	5,55	82	28	6	
8665560	5,6	82	28	6	
8665570	5,7	82	29	6	
8665580	5,8	82	29	6	
8665590	5,9	82	30	6	
8665600	6	82	30	6	
8680610	6,1	88	31	8	
8680620	6,2	88	31	8	
8680630	6,3	88	32	8	
8680640	6,4	88	32	8	
8680650	6,5	88	33	8	
8680660	6,6	88	33	8	
8680670	6,7	88	34	8	
8680680	6,8	88	34	8	
8680690	6,9	88	35	8	
8680700	7	88	35	8	
8665710	7,1	94	36	8	
8665720	7,2	94	36	8	
8665725 NEW	7,25	94	37	8	
8665730	7,3	94	37	8	
8665740	7,4	94	37	8	
8680745	7,45	94	38	8	
8665750	7,5	94	38	8	
8680755	7,55	94	38	8	
8665760	7,6	94	38	8	
8665770	7,7	94	39	8	
8665775 NEW	7,75	94	39	8	
8665780	7,8	94	39	8	
8665790	7,9	94	40	8	
8665800	8	94	40	8	
8680810	8,1	101	41	10	
8680820	8,2	101	41	10	
8680830	8,3	101	42	10	
8680840	8,4	101	42	10	
8680850	8,5	101	43	10	
8680860	8,6	101	43	10	
8680870	8,7	101	44	10	
8680880	8,8	101	44	10	
8680890	8,9	101	45	10	
8680900	9	101	45	10	
8665910	9,1	106	46	10	
8665920	9,2	106	46	10	
8665925 NEW	9,25	106	47	10	
8665930	9,3	106	47	10	

ADO-SUS-3D NEW

Drilling | Solid carbide | 3xD



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P ◉ C: ≤0,2% | P ◉ C: 0,25-0,4% | P ◉ C: ≥0,45% | P ◉ SCM | M ◉ INOX | K ◉ GG | K ◉ GGG | N ○ AC,ADC | S ◉ Ti | H ◉ 25-35 HRC | H ○ 35-45 HRC | H ○ 45-52 HRC

A | CARBIDE | WXL | 30° | SHRINK FIT | 140° | h8

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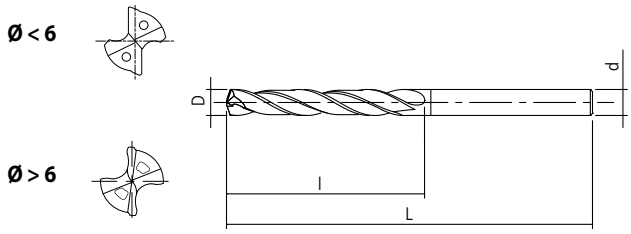
EDP	D	L	l	d	Price
8665940	9,4	106	47	10	
8665950	9,5	106	48	10	
8680955	9,55	106	48	10	
8665960	9,6	106	48	10	
8665970	9,7	106	49	10	
8665975 NEW	9,75	106	49	10	
8665980	9,8	106	49	10	
8665990	9,9	106	50	10	
8666000	10	106	50	10	
8681010	10,1	113	51	12	
8681020	10,2	113	51	12	
8681030	10,3	113	52	12	
8681040	10,4	113	52	12	
8681050	10,5	113	53	12	
8681060	10,6	113	53	12	
8681070	10,7	113	54	12	
8681080	10,8	113	54	12	
8681090	10,9	113	55	12	
8681100	11	113	55	12	
8666110	11,1	120	56	12	
8666120	11,2	120	56	12	
8666130	11,3	120	57	12	
8666140	11,4	120	57	12	
8666150	11,5	120	58	12	
8666160	11,6	120	58	12	
8666170	11,7	120	59	12	
8666180	11,8	120	59	12	
8666190	11,9	120	60	12	
8666200	12	120	60	12	
8681210	12,1	128	61	14	
8681220 NEW	12,2	128	61	14	
8681230 NEW	12,3	128	62	14	
8681240 NEW	12,4	128	62	14	
8681250	12,5	128	63	14	
8681260 NEW	12,6	128	63	14	
8681280	12,8	128	64	14	
8681290 NEW	12,9	128	65	14	
8681300	13	128	65	14	
8666310	13,1	134	66	14	
8666320	13,2	134	67	14	
8666330	13,3	134	68	14	
8666340	13,4	134	67	14	
8681343	13,43	134	68	14	
8666350	13,5	134	68	14	
8681355	13,55	134	68	14	

EDP	D	L	l	d	Price
8666360	13,6	134	68	14	
8666370	13,7	134	69	14	
8666380	13,8	134	69	14	
8666390	13,9	134	70	14	
8666400	14	134	70	14	
8681410 NEW	14,1	140	71	16	
8681420 NEW	14,2	140	71	16	
8681430 NEW	14,3	140	72	16	
8681440 NEW	14,4	140	72	16	
8681450	14,5	140	73	16	
8681460 NEW	14,6	140	73	16	
8681470 NEW	14,7	140	74	16	
8681480 NEW	14,8	140	74	16	
8681490 NEW	14,9	140	75	16	
8681500	15	140	75	16	
8666510	15,1	145	76	16	
8666520	15,2	145	76	16	
8666530	15,3	145	77	16	
8666540	15,4	145	77	16	
8666550	15,5	145	78	16	
8681555	15,55	145	78	16	
8666560	15,6	145	78	16	
8666570	15,7	145	79	16	
8666580	15,8	145	79	16	
8666590	15,9	145	80	16	
8666600	16	145	80	16	
8681650	16,5	150	83	18	
8681670	16,7	150	84	18	
8681700	17	150	85	18	
8681730	17,3	155	87	18	
8666750	17,5	155	88	18	
8681755	17,55	155	88	18	
8666800	18	155	90	18	
8681850	18,5	160	93	20	
8681870	18,7	160	94	20	
8681900	19	160	95	20	
8681930	19,3	165	97	20	
8666950	19,5	165	98	20	
8681955	19,55	165	98	20	
8667000	20	165	100	20	

ADO-SUS-5D NEW

Drilling | Solid carbide | 5xD



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P ◉ C: ≤0,2% | P ◉ C: 0,25-0,4% | P ◉ C: ≥0,45% | P ◉ SCM | M ◉ INOX | K ◉ GG | K ◉ GGG | N ○ AC,ADC | S ◉ Ti | H ◉ 25-35 HRC | H ○ 35-45 HRC | H ○ 45-52 HRC

A | CARBIDE | WXL | 30° | SHRINK FIT | 140° | h8

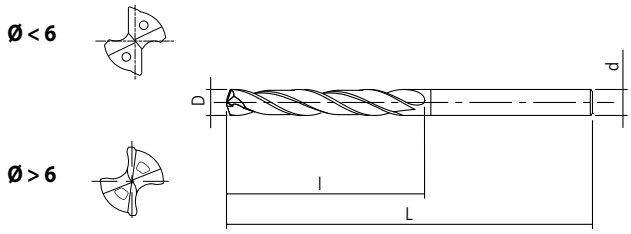
page 7

EDP	D	L	l	d	Price
8667200	2	70	18	3	
8667210	2,1	70	19	3	
8667220	2,2	70	20	3	
8667230	2,3	70	21	3	
8667240	2,4	70	22	3	
8667250	2,5	70	23	3	
8667260	2,6	78	24	3	
8667270	2,7	78	25	3	
8667276 NEW	2,76	78	25	3	
8667278	2,78	78	26	3	
8667280	2,8	78	26	3	
8667283	2,83	78	26	3	
8667287	2,87	78	26	3	
8667290	2,9	78	27	3	
8667300	3	78	27	3	
8667310	3,1	86	28	4	
8667315 NEW	3,15	86	29	4	
8667320	3,2	86	29	4	
8667326 NEW	3,26	86	29	4	
8667330	3,3	86	30	4	
8667340	3,4	86	31	4	
8667350	3,5	86	32	4	
8667360	3,6	86	33	4	
8667366 NEW	3,66	86	33	4	
8667368	3,68	86	34	4	
8667370	3,7	86	34	4	
8667373	3,73	86	34	4	
8667375 NEW	3,75	86	34	4	
8667380	3,8	86	35	4	
8667390	3,9	86	36	4	
8667400	4	86	36	4	
8682410	4,1	95	37	6	
8682420	4,2	95	38	6	
8682430	4,3	95	39	6	
8682440	4,4	95	40	6	
8682445	4,45	95	41	6	
8682450	4,5	95	41	6	
8682460	4,6	95	42	6	
8682464	4,64	95	42	6	
8682470	4,7	95	43	6	
8667480	4,8	95	44	6	
8667490	4,9	95	45	6	
8682500	5	95	45	6	
8667510	5,1	100	41	6	
8667520	5,2	100	42	6	

EDP	D	L	l	d	Price
8667530	5,3	100	43	6	
8667540	5,4	100	44	6	
8667550	5,5	100	44	6	
8667552 NEW	5,52	100	45	6	
8667554	5,54	100	45	6	
8667560	5,6	100	45	6	
8667570	5,7	100	46	6	
8667580	5,8	100	47	6	
8667590	5,9	100	48	6	
8667600	6	100	48	6	
8682610	6,1	109	49	8	
8682620	6,2	109	50	8	
8682630	6,3	109	51	8	
8682640	6,4	109	52	8	
8682650	6,5	109	52	8	
8682660	6,6	109	53	8	
8682670	6,7	109	54	8	
8682680	6,8	109	55	8	
8682690	6,9	109	56	8	
8682700	7	109	56	8	
8667710	7,1	118	57	8	
8667720	7,2	118	58	8	
8667725 NEW	7,25	118	58	8	
8667730	7,3	118	59	8	
8667736 NEW	7,36	118	59	8	
8667738	7,38	118	60	8	
8667740	7,4	118	60	8	
8682745	7,45	118	60	8	
8667750	7,5	118	60	8	
8667752 NEW	7,52	118	61	8	
8667754	7,54	118	61	8	
8667760	7,6	118	61	8	
8667770	7,7	118	62	8	
8667775 NEW	7,75	118	62	8	
8667780	7,8	118	63	8	
8667790	7,9	118	64	8	
8667800	8	118	64	8	
8682810	8,1	128	65	10	
8682820	8,2	128	66	10	
8682830	8,3	128	67	10	
8682840	8,4	128	68	10	
8682850	8,5	128	68	10	
8682860	8,6	128	69	10	
8682870	8,7	128	70	10	
8682880	8,8	128	71	10	

ADO-SUS-5D NEW

Drilling | Solid carbide | 5xD



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- Carbide drill with internal coolant, WXL coating
- Up to 5xD
- Designed for stainless steel and titanium alloys
- 181 sizes

P ●	P ●	P ●	P ●	M ●	K ●	K ●	N ○	S ●	H ●	H ○	H ○
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	AC,ADC	Ti	25-35 HRC	35-45 HRC	45-52 HRC

A | CARBIDE | WXL | 30° | SHRINK FIT | 140° | h8

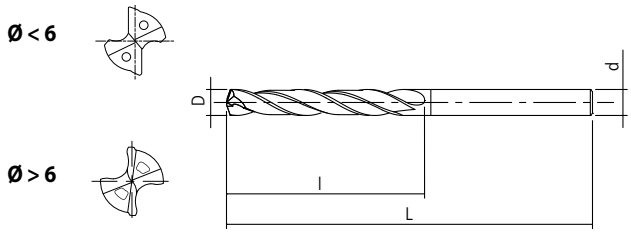
page 7

EDP	D	L	l	d	Price
8682890	8,9	128	72	10	
8682900	9	128	72	10	
8667910	9,1	136	73	10	
8667920	9,2	136	74	10	
8667924 NEW	9,24	136	74	10	
8667925 NEW	9,25	136	74	10	
8667926	9,26	136	75	10	
8667930	9,3	136	75	10	
8667936 NEW	9,36	136	75	10	
8667938	9,38	136	76	10	
8667940	9,4	136	76	10	
8667950	9,5	136	76	10	
8667952 NEW	9,52	136	77	10	
8667954	9,54	136	77	10	
8667960	9,6	136	77	10	
8667970	9,7	136	78	10	
8667975 NEW	9,75	136	78	10	
8667980	9,8	136	79	10	
8667990	9,9	136	80	10	
8668000	10	136	80	10	
8683010	10,1	146	81	12	
8683020	10,2	146	82	12	
8683030	10,3	146	83	12	
8683040	10,4	146	84	12	
8683050	10,5	146	84	12	
8683060	10,6	146	85	12	
8683070	10,7	146	86	12	
8683080	10,8	146	87	12	
8683090	10,9	146	88	12	
8683100	11	146	88	12	
8668110	11,1	156	89	12	
8668120	11,2	156	90	12	
8668122 NEW	11,22	156	90	12	
8668124	11,24	156	90	12	
8668130	11,3	156	91	12	
8668136 NEW	11,36	156	91	12	
8668138	11,38	156	92	12	
8668140	11,4	156	92	12	
8668150	11,5	156	92	12	
8668160	11,6	156	93	12	
8668170	11,7	156	94	12	
8668180	11,8	156	95	12	
8668190	11,9	156	96	12	
8668200	12	156	96	12	
8683210	12,1	167	97	14	

EDP	D	L	l	d	Price
8683220 NEW	12,2	167	98	14	
8683230 NEW	12,3	167	99	14	
8683240 NEW	12,4	167	100	14	
8683250	12,5	167	100	14	
8683260 NEW	12,6	167	101	14	
8683270 NEW	12,7	167	102	14	
8683280	12,8	167	103	14	
8683290 NEW	12,9	167	104	14	
8683300	13	167	104	14	
8668310	13,1	176	105	14	
8668320	13,2	176	106	14	
8668325	13,25	176	106	14	
8668330	13,3	176	107	14	
8668340	13,4	176	108	14	
8683343	13,43	176	108	14	
8668350	13,5	176	108	14	
8683355	13,55	176	109	14	
8668360	13,6	176	109	14	
8668370	13,7	176	110	14	
8668380	13,8	176	111	14	
8668390	13,9	176	112	14	
8668400	14	176	112	14	
8683410 NEW	14,1	185	113	16	
8683420 NEW	14,2	185	114	16	
8683430 NEW	14,3	185	115	16	
8683440 NEW	14,4	185	116	16	
8683450	14,5	185	116	16	
8683460 NEW	14,6	185	117	16	
8683470 NEW	14,7	185	118	16	
8683480 NEW	14,8	185	119	16	
8683490 NEW	14,9	185	120	16	
8683500	15	185	120	16	
8668510	15,1	193	121	16	
8668520	15,2	193	122	16	
8668525	15,25	193	122	16	
8668530	15,3	193	123	16	
8668540	15,4	193	124	16	
8668550	15,5	193	124	16	
8683555	15,55	193	125	16	
8668560	15,6	193	125	16	
8668570	15,7	193	126	16	
8668580	15,8	193	127	16	
8668590	15,9	193	128	16	
8668600	16	193	128	16	
8683650	16,5	184	113	18	

ADO-SUS-5D NEW

Drilling | Solid carbide | 5xD



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P ● C: ≤0,2% | P ● C: 0,25-0,4% | P ● C: ≥0,45% | P ● SCM | M ● INOX | K ● GG | K ● GGG | N ○ AC,ADC | S ● Ti | H ● 25-35 HRC | H ○ 35-45 HRC | H ○ 45-52 HRC

A | CARBIDE | WXL | 30° | SHRINK FIT | 140° | h8

page 7

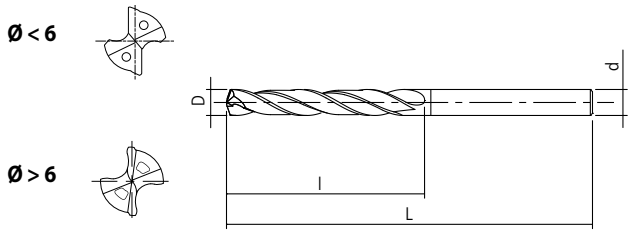
EDP	D	L	l	d	Price
8683670	16,7	184	117	18	
8683700	17	184	114	18	
8683730	17,3	191	122	18	
8668750	17,5	191	123	18	
8683755	17,55	191	123	18	
8668800	18	191	126	18	
8683850	18,5	198	130	20	
8683870	18,7	198	131	20	
8683900	19	198	133	20	
8683930	19,3	205	136	20	
8668950	19,5	205	137	20	
8683955	19,55	205	137	20	
8669000	20	205	140	20	

EDP	D	L	l	d	Price

ADO-SUS-8D NEW

Available from December 2017

Drilling | Solid carbide | 8xD



- First choice in quality and performance
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- 101 sizes

P ● C: ≤0,2% | P ● C: 0,25-0,4% | P ● C: ≥0,45% | P ● SCM | M ● INOX | K ● GG | K ● GGG | N ○ AC,ADC | S ● Ti | H ● 25-35 HRC | H ○ 35-45 HRC | H ○ 45-52 HRC

A | CARBIDE | WXL | 30° | SHRINK FIT | 140° | h8

page 7

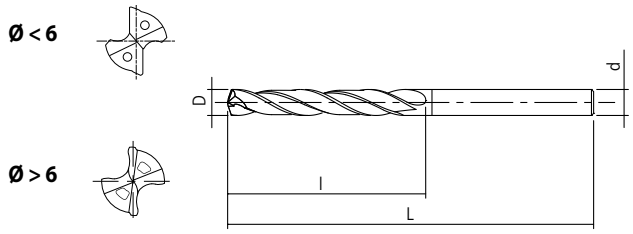
EDP	D	L	l	d	Price
8686200	2	75	22	3	
8686210	2,1	75	24	3	
8686220	2,2	75	25	3	
8686230	2,3	75	26	3	
8686240	2,4	75	27	3	
8686250	2,5	75	28	3	
8686260	2,6	80	29	3	
8686270	2,7	80	30	3	
8686280	2,8	80	31	3	
8686290	2,9	80	32	3	
8686300	3	80	33	3	
8684310	3,1	95	34	4	
8684320	3,2	95	35	4	
8684330	3,3	95	36	4	
8684340	3,4	95	37	4	
8684350	3,5	95	39	4	
8684360	3,6	95	40	4	
8684370	3,7	95	41	4	
8684380	3,8	95	42	4	
8684390	3,9	95	43	4	
8684400	4	95	44	4	
8684410	4,1	105	45	6	
8684420	4,2	105	46	6	
8684430	4,3	105	47	6	
8684440	4,4	105	48	6	
8684450	4,5	105	50	6	
8684460	4,6	105	51	6	
8684470	4,7	105	52	6	
8684480	4,8	105	53	6	
8684490	4,9	105	54	6	
8684500	5	105	55	6	
8684510	5,1	115	56	6	
8684520	5,2	115	57	6	
8684530	5,3	115	58	6	
8684540	5,4	115	59	6	
8684550	5,5	115	61	6	
8684560	5,6	115	62	6	
8684570	5,7	115	63	6	
8684580	5,8	115	64	6	
8684590	5,9	115	65	6	
8684600	6	115	66	6	
8684610	6,1	125	67	8	
8684620	6,2	125	68	8	
8684630	6,3	125	69	8	
8684640	6,4	125	70	8	

EDP	D	L	l	d	Price
8684650	6,5	125	72	8	
8684660	6,6	125	73	8	
8684670	6,7	125	74	8	
8684680	6,8	125	75	8	
8684690	6,9	125	76	8	
8684700	7	125	77	8	
8684710	7,1	140	78	8	
8684720	7,2	140	79	8	
8684730	7,3	140	80	8	
8684740	7,4	140	81	8	
8684750	7,5	140	83	8	
8684760	7,6	140	84	8	
8684770	7,7	140	85	8	
8684780	7,8	140	86	8	
8684790	7,9	140	87	8	
8684800	8	140	88	8	
8684810	8,1	150	89	10	
8684820	8,2	150	90	10	
8684830	8,3	150	91	10	
8684840	8,4	150	92	10	
8684850	8,5	150	94	10	
8684860	8,6	150	95	10	
8684870	8,7	150	96	10	
8684880	8,8	150	97	10	
8684890	8,9	150	98	10	
8684900	9	150	99	10	
8684910	9,1	160	100	10	
8684920	9,2	160	101	10	
8684930	9,3	160	102	10	
8684940	9,4	160	103	10	
8684950	9,5	160	105	10	
8684960	9,6	160	106	10	
8684970	9,7	160	107	10	
8684980	9,8	160	108	10	
8684990	9,9	160	109	10	
8685000	10	160	110	10	
8685010	10,1	182	111	12	
8685020	10,2	182	112	12	
8685030	10,3	182	113	12	
8685040	10,4	182	114	12	
8685050	10,5	182	116	12	
8685060	10,6	182	117	12	
8685070	10,7	182	118	12	
8685080	10,8	182	119	12	
8685090	10,9	182	120	12	

ADO-SUS-8D NEW

Available from December 2017

Drilling | Solid carbide | 8xD



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A | CARBIDE | WXL | 30° | SHRINK FIT | 140° | h8

page 7

EDP	D	L	l	d	Price
8685100	11	182	121	12	
8685110	11,1	194	122	12	
8685120	11,2	194	123	12	
8685130	11,3	194	124	12	
8685140	11,4	194	125	12	
8685150	11,5	194	127	12	
8685160	11,6	194	128	12	
8685170	11,7	194	129	12	
8685180	11,8	194	130	12	
8685190	11,9	194	131	12	
8685200	12	194	132	12	

EDP	D	L	l	d	Price

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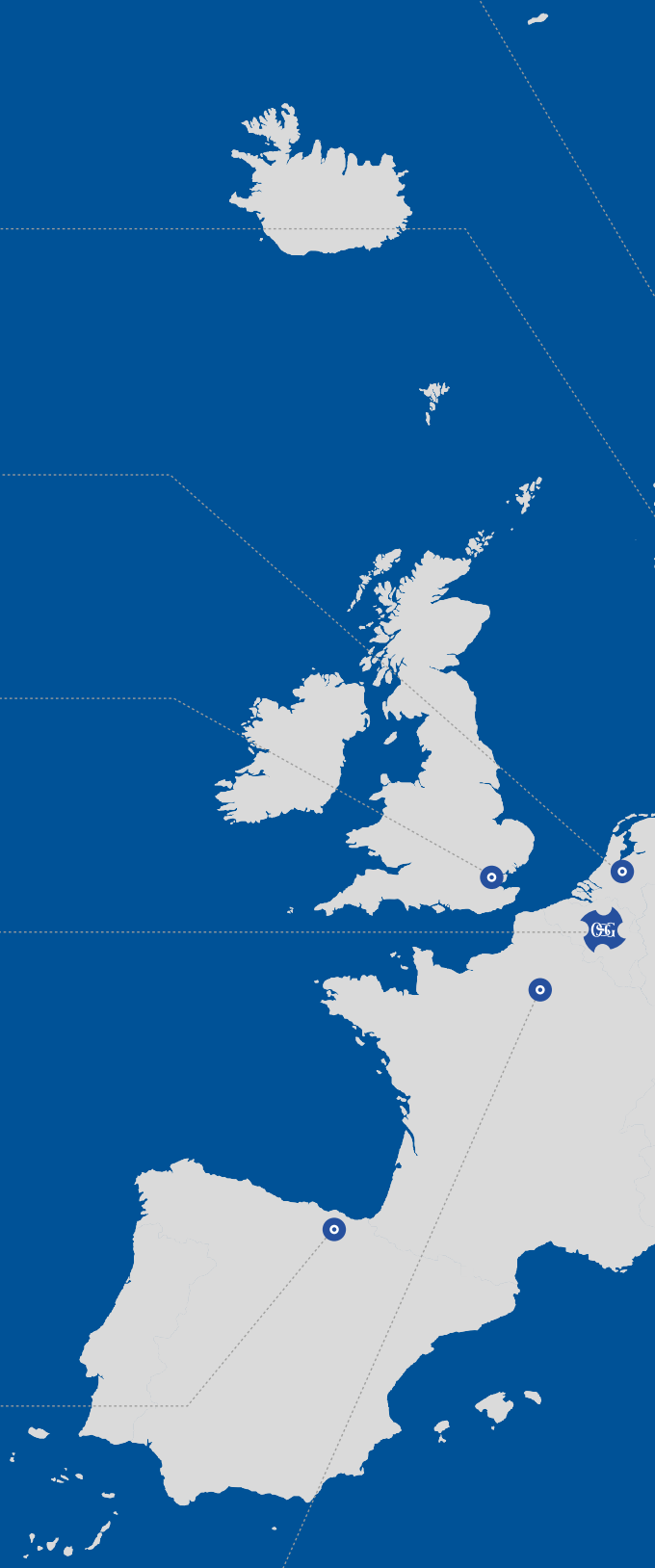

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