

Solid carbide drills Product overview

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	Products	Solid Carbide Drills	L/D	*	Ø	Application						Type	Page
						P	M	K	N	S	H		
SU	1534SU03		3xD		0.9-20	✓	✓	✓				Twist drills	C32
	1534SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C32
	1634SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C56
	1734SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C64
	1536SU05		5xD		2-20	✓	✓	✓				Twist drills	C43
	1536SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C43
	1636SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C60
	1736SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C68
	1538SU08C		8xD	*	3-18	✓	✓	✓				Twist drills	C53
	1557SU03		3xD		M4-M16	✓	✓	✓				Step drills	C72
SL SP	1588SL10C		10xD	*	3-14	✓	✓	✓	✓	✓		Deep hole drills	C74
	1588SL12C		12xD	*	3-21	✓	✓	✓	✓	✓		Deep hole drills	C77
	1588SL15C		15xD	*	3-14	✓	✓	✓	✓	✓		Deep hole drills	C81
	1588SL20C		20xD	*	3-14	✓	✓	✓	✓	✓		Deep hole drills	C84
	1588SL30C		30xD	*	3-10	✓	✓	✓	✓	✓		Deep hole drills	C87
	1534SP03C		3xD	*	3.03-20.03	✓	✓	✓	✓	✓		Pilot drills	C89
ST	1534ST03C		3xD	*	3-20	✓	✓			✓		Twist drills	C94
	1536ST05C		5xD	*	3-20	✓	✓			✓		Twist drills	C98
	1636ST05C		5xD	*	3-20	✓	✓			✓		Twist drills	C102
SH	1534SH03		3xD		3-16						✓	Twist drills	C106
SC	1105SC03		3xD		2-16				✓			Twist drills	C107
	1101SC05		5xD		2-16				✓			Twist drills	C110
PA	1165PA03		3xD		3-20				✓			Three-lips drills	C111
PC	1576PC05		5xD		4-20			✓				Straight flute drills	C116
	1576PC05C		5xD	*	4-20			✓				Straight flute drills	C116
	1579PC15C		15xD	*	5-14			✓				Straight flute drills	C118
SC*	1143SC90		-		5-20	✓	✓	✓	✓			Centuring drills	C119
	1143SC120		-	*	5-20	✓	✓	✓	✓			Centuring drills	C120

✓ Very suitable ✓ Suitable
* With internal cooling SC*: Centuring drills

Coated cemented carbide PVD

Grade	Grade description
KDG303	PVD coated P10–P20/M10–M20/K10–K20 carbide grade for steel, stainless steel and cast iron. Good wear resistance and toughness for a wide application field.

Uncoated cemented carbide

Grade	Grade description
YK20F	Uncoated K20 carbide substrate for steel, cast iron and non ferrous materials.
YK30F	Uncoated K30 carbide substrate for steel, stainless steel, cast iron and non ferrous materials.

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A

Turning

Type	
Code	Description
1	Forets

1

Shank type	
Code	Description
1	Straight shank
2	Square shank DIN 10
3	Double flattened straight shank DIN 1809
5	Straight shank DIN 6535 HA
6	Weldon shank DIN 6535 HB
7	Whistle Notch shank DIN 6535 HE
9	Morse taper shank

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B

Milling

Drill type	
Code	Description
0	Twist drill
3	Universal twist drill
4	NC tapping device
5	Step drill
6	Three-lips drill
7	Straight flute drill
8	Deep hole drill

3

Tool length	
Code	Description
1	DIN 338
2	DIN 1897
3	QJ/ZZQ(TO)01.001.002
4	DIN 6537 K
5	DIN 6539
6	DIN 6537 L
7	Factory standard ZCC-C
8	Factory standard ZCC-D
9	Factory standard ZCC-E

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Drilling

Application	
Code	Description
SU	Twist drill for general machining
SUK	Twist drill for cast iron
SL	Twist drill for deep hole drilling
SLK	Deep hole drill for cast iron
SP	Pilot drill
ST	Twist drill for soft steel and stainless steel
SH	Twist drill for hardened materials
SC	Twist drill for non-ferrous metals and cast iron
PA	Three-lips drill for non-ferrous metals and cast iron
PC	Straight flute drill for non-ferrous metals and cast iron

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L/D relation		Angle	
Drill		NC tapping device	
Code	Description	Code	Description
03	3xD	90	90°
05	5xD	120	120°
08	8xD		
10	10xD		
12	12xD		
15	15xD		
20	20xD		
30	30xD		

With inner cooling

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Bore diameter [mm]	
Code	Description
0200	2,0
0850	8,5
1800	18,0
...	

Shank diameter [mm]	
Code	Description
S	4,0

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