



SG-DRILL SERIES

HIGH PERFORMANCE HSS-PM DRILLS



CELEBRATE THE POLE POSITION



**HSS-PM
UNIVERSAL
DRILL**

Universal drill of
HSS-PM with
SG-Coating.
High performance
under all conditions

SG - VYSOKO VÝKONNÉ PM-HSS VRTÁKY



Vrtáky sú vyrobené z kvalitnej práškovej ocele s viacvrstovým SG povlakovaním.

Stopky vrtákov podobné frézam, v kombinácii s vysokou presnosťou tvaru rezných hrán zabezpečujú extrémne presné polohy vrtania a stabilitu. (15 μ m)

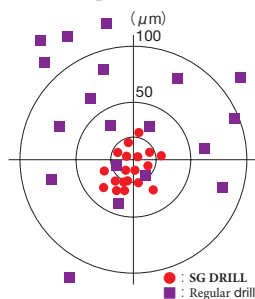
Originálny materiál, povlak a geometria konštrukcie, ktorá umožňuje široké použitie.

Vlastnosti

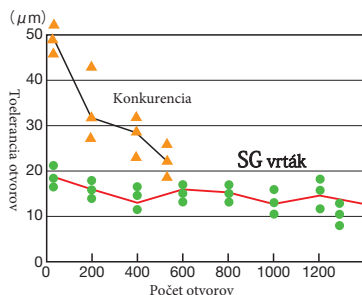
Široké aplikácie od hliníku až po tepelne odolné zliatiny

Vysoká presnosť vrtania

Presnosť polohovania otvoru

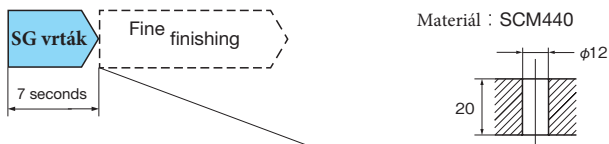


Rozšírenie otvoru

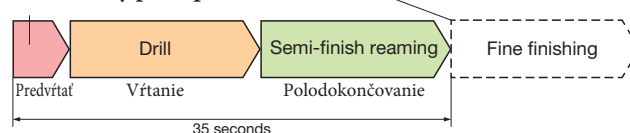


Jeden vrták zvládne centrovanie-vrtanie-polodokončovanie

Proces vrtania s SG vrtákom

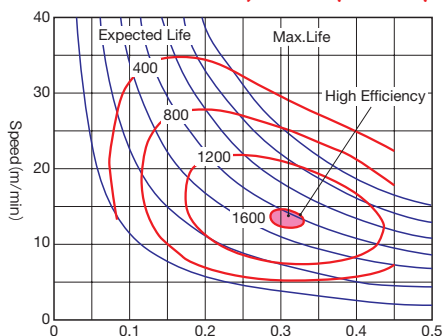


Štandardný postup vrtania



Dlhá životnosť s vysokým výkonom

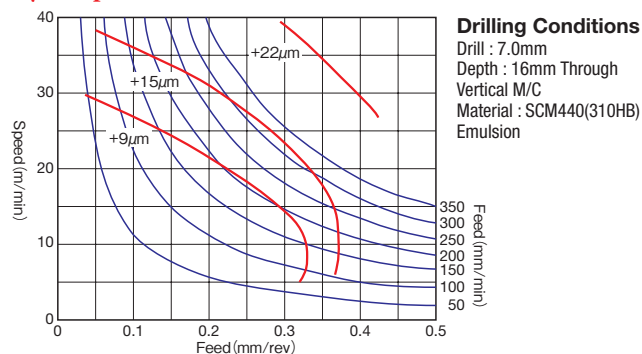
Dlhšia životnosť nástroja v rôznych rezných podmienkach



Drilling Conditions
Drill : 7.0mm
Depth : 16mm Through
Vertical M/C
Material : SCM440(310HB)
Emulsion

Je možné vysoko presné vrtanie ako aj malý prídavok otvoru!!

Vysoká presnosť otvorov



Drilling Conditions
Drill : 7.0mm
Depth : 16mm Through
Vertical M/C
Material : SCM440(310HB)
Emulsion

www.panas.sk

PANAS Tools s.r.o. Hradište 371, 95854 Hradište SK
Tel.: +421(0)38 7496764-5, +421(0)38 7491373, panas@panas.sk
Technický servis: info@panas.sk



SG 7572 VRTÁKY 3D

Obrábaný materiál	Konštrukčné ocele		Legované ocele Predkalené ocele		Ocele na formy Nerezové ocele Kalené ocele (35~45HRC)		Liatiny		Zliatiny hliníku Neželezné materiály		
	Parametre vŕtania	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)
Priemer vrtáka (mm)	2	5700	360	4600	240	2400	135	6300	490	9700	760
	3	4200	460	3400	320	1600	145	4700	640	7200	980
	5	2500	430	2000	290	960	100	2800	600	4300	920
	8	1600	370	1300	250	600	100	1800	530	2700	790
	10	1300	340	1000	230	480	100	1400	460	2200	730
	12	1100	310	850	210	400	90	1200	430	1800	670
	16	800	290	640	200	300	80	880	390	1400	610
	20	640	260	510	180	240	75	700	350	1100	550

SG 7574 VRTÁKY 5D

Obrábaný materiál	Uhlíkové ocele		Konštrukčné ocele		Legované ocele Predkalené ocele		Ocele na formy Nerezové ocele Kalené ocele (35~45HRC)		Liatiny		Zliatiny hliníku Neželezné materiály		
	Parametre vŕtania	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)	Otáčky (min ⁻¹)	Posuv (mm/min)
Priemer vrtáka (mm)	2	5700	300	5300	340	4600	200	2400	150	6300	410	9700	630
	3	4200	380	3500	340	3400	260	1600	160	4700	530	7200	820
	5	2500	360	2100	340	2000	240	960	90	2800	500	4300	770
	8	1600	310	1300	340	1300	210	600	90	1800	440	2700	660
	10	1300	280	1050	340	1000	190	480	90	1400	390	2200	610
	12	1100	260	880	300	850	180	400	80	1200	360	1800	560
	16	800	240	660	240	640	160	300	75	880	330	1400	500
	20	640	220	530	200	510	150	240	70	700	300	1100	460

7574 sa neaplikuje na austenitické nerezové ocele.

Tabuľka výberu nástroja pre rôzne typy materiálov

Tool	Structural Steel	Carbon Steels	Pre-Hardened Steels Alloy Steels	Hardened Steels Mold Steels	Hardened Steels		Stainless Steels		Titanium Alloys Nickel Alloys	Cast Irons	Aluminium Alloys	Copper Alloys
	ST-37-2	C45/ C50	SCR/ NAK	30-40 HRC	40- 50HRC	50- 65HRC	Austenitic SUS304/316	Martensitic SUS420		GG/ GGG	Al/ ADC	Cu
SG - 7572	●	●	●	●	X	X	●	●	●	●	○	○
SG - 7574	●	●	●	○	X	X	●	●	○	●	○	○

● Excellent | ○ Good | X Not Applicable

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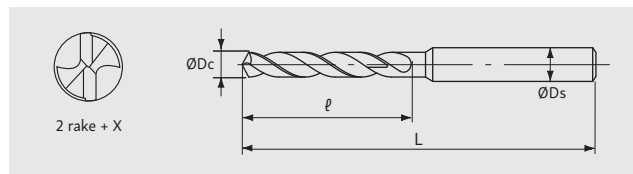
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Technický servis: info@panas.sk,



SGESR 5D



FAX
SG
h7
135°
31°-32°
h7
2.0 32.0

TOOL MATERIAL
POINT ANGLE
HELIX ANGLE

LIST: 7574

Code	Dc	ℓ	L	Ds	Stock
SGESR2.0	2.0	24	56	3	●
SGESR2.1	2.1	24	56	3	●
SGESR2.2	2.2	25	56	3	●
SGESR2.3	2.3	25	56	3	●
SGESR2.4	2.4	30	61	3	●
SGESR2.5	2.5	30	61	3	●
SGESR2.6	2.6	30	61	3	●
SGESR2.7	2.7	33	64	3	●
SGESR2.8	2.8	33	64	3	●
SGESR2.9	2.9	33	64	3	●
SGESR3.0	3.0	33	64	3	●
SGESR3.1	3.1	36	68	4	●
SGESR3.2	3.2	36	68	4	●
SGESR3.3	3.3	36	68	4	●
SGESR3.4	3.4	39	71	4	●
SGESR3.5	3.5	39	71	4	●
SGESR3.6	3.6	39	71	4	●
SGESR3.7	3.7	39	71	4	●
SGESR3.8	3.8	43	75	4	●
SGESR3.9	3.9	43	75	4	●
SGESR4.0	4.0	43	75	4	●
SGESR4.1	4.1	43	85	6	●
SGESR4.2	4.2	43	85	6	●
SGESR4.3	4.3	47	89	6	●
SGESR4.4	4.4	47	89	6	●
SGESR4.5	4.5	47	89	6	●
SGESR4.6	4.6	47	89	6	●
SGESR4.7	4.7	47	89	6	●
SGESR4.8	4.8	52	94	6	●
SGESR4.9	4.9	52	94	6	●
SGESR5.0	5.0	52	94	6	●
SGESR5.1	5.1	52	94	6	●
SGESR5.2	5.2	52	94	6	●
SGESR5.3	5.3	52	94	6	●
SGESR5.4	5.4	57	99	6	●
SGESR5.5	5.5	57	99	6	●
SGESR5.6	5.6	57	99	6	●
SGESR5.7	5.7	57	99	6	●
SGESR5.8	5.8	57	99	6	●
SGESR5.9	5.9	57	99	6	●
SGESR6.0	6.0	57	99	6	●
SGESR6.1	6.1	63	107	8	●
SGESR6.2	6.2	63	107	8	●
SGESR6.3	6.3	63	107	8	●
SGESR6.4	6.4	63	107	8	●
SGESR6.5	6.5	63	107	8	●

Code	Dc	ℓ	L	Ds	Stock
SGESR6.6	6.6	63	107	8	●
SGESR6.7	6.7	63	107	8	●
SGESR6.8	6.8	69	113	8	●
SGESR6.9	6.9	69	113	8	●
SGESR7.0	7.0	69	113	8	●
SGESR7.1	7.1	69	113	8	●
SGESR7.2	7.2	69	113	8	●
SGESR7.3	7.3	69	113	8	●
SGESR7.4	7.4	69	113	8	●
SGESR7.5	7.5	69	113	8	●
SGESR7.6	7.6	75	119	8	●
SGESR7.7	7.7	75	119	8	●
SGESR7.8	7.8	75	119	8	●
SGESR7.9	7.9	75	119	8	●
SGESR8.0	8.0	75	119	8	●
SGESR8.1	8.1	75	125	10	●
SGESR8.2	8.2	75	125	10	●
SGESR8.3	8.3	75	125	10	●
SGESR8.4	8.4	75	125	10	●
SGESR8.5	8.5	75	125	10	●
SGESR8.6	8.6	81	131	10	●
SGESR8.7	8.7	81	131	10	●
SGESR8.8	8.8	81	131	10	●
SGESR8.9	8.9	81	131	10	●
SGESR9.0	9.0	81	131	10	●
SGESR9.1	9.1	81	131	10	●
SGESR9.2	9.2	81	131	10	●
SGESR9.3	9.3	81	131	10	●
SGESR9.4	9.4	81	131	10	●
SGESR9.5	9.5	81	131	10	●
SGESR9.6	9.6	87	137	10	●
SGESR9.7	9.7	87	137	10	●
SGESR9.8	9.8	87	137	10	●
SGESR9.9	9.9	87	137	10	●
SGESR10.0	10.0	87	137	10	●
SGESR10.1	10.1	87	144	12	●
SGESR10.2	10.2	87	144	12	●
SGESR10.3	10.3	87	144	12	●
SGESR10.4	10.4	87	144	12	●
SGESR10.5	10.5	87	144	12	●
SGESR10.6	10.6	87	144	12	●
SGESR10.7	10.7	94	151	12	●
SGESR10.8	10.8	94	151	12	●
SGESR10.9	10.9	94	151	12	●
SGESR11.0	11.0	94	151	12	●
SGESR11.1	11.1	94	151	12	●

LIST: 7574

Code	Dc	ℓ	L	Ds	Stock
SGESR11.2	11.2	94	151	12	●
SGESR11.3	11.3	94	151	12	●
SGESR11.4	11.4	94	151	12	●
SGESR11.5	11.5	94	151	12	●
SGESR11.6	11.6	94	151	12	●
SGESR11.7	11.7	94	151	12	●
SGESR11.8	11.8	94	151	12	●
SGESR11.9	11.9	101	158	12	●
SGESR12.0	12.0	101	158	12	●
SGESR12.1	12.1	101	158	12	●
SGESR12.2	12.2	101	158	12	●
SGESR12.3	12.3	101	158	12	●
SGESR12.4	12.4	101	158	12	●
SGESR12.5	12.5	101	158	12	●
SGESR12.6	12.6	101	158	12	●
SGESR12.7	12.7	101	158	12	●
SGESR12.8	12.8	101	158	12	●
SGESR12.9	12.9	101	158	12	●
SGESR13.0	13.0	101	158	12	●
SGESR13.5	13.5	108	168	16	●
SGESR14.0	14.0	108	168	16	●
SGESR14.5	14.5	114	173	16	●
SGESR15.0	15.0	114	180	20	●
SGESR15.5	15.5	120	185	20	●
SGESR16.0	16.0	120	185	20	●
SGESR16.5	16.5	125	189	20	●
SGESR17.0	17.0	125	189	20	●
SGESR17.5	17.5	130	194	20	●
SGESR18.0	18.0	130	194	20	●

Code	Dc	ℓ	L	Ds	Stock
SGESR18.5	18.5	135	198	20	●
SGESR19.0	19.0	135	206	25	●
SGESR19.5	19.5	140	210	25	●
SGESR20.0	20.0	140	210	25	●
SGESR20.5	20.5	145	214	25	●
SGESR21.0	21.0	145	214	25	●
SGESR21.5	21.5	150	218	25	●
SGESR22.0	22.0	150	218	25	●
SGESR22.5	22.5	155	223	25	●
SGESR23.0	23.0	155	223	25	●
SGESR23.5	23.5	155	223	25	●
SGESR24.0	24.0	160	237	32	●
SGESR24.5	24.5	160	237	32	●
SGESR25.0	25.0	165	241	32	●
SGESR25.5	25.5	165	241	32	●
SGESR26.0	26.0	165	241	32	●
SGESR26.5	26.5	165	241	32	●
SGESR27.0	27.0	170	245	32	●
SGESR27.5	27.5	170	245	32	●
SGESR28.0	28.0	170	245	32	●
SGESR28.5	28.5	175	248	32	●
SGESR29.0	29.0	175	248	32	●
SGESR29.5	29.5	175	248	32	●
SGESR30.0	30.0	175	248	32	●
SGESR30.5	30.5	180	252	32	●
SGESR31.0	31.0	180	252	32	●
SGESR31.5	31.5	180	252	32	●
SGESR32.0	32.0	185	255	32	●

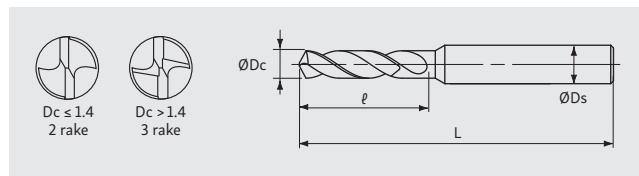
●: Standard stock item

Standard Drilling Conditions														
Work material	Structural Steels Carbon Steels ST-37-2, C50		Alloy Steels Pre-Hardened Steels 42CrMo4, NAK, HPM		Mold Steels Hardened Steels X40MoV51, NAK, HPM		Stainless Steels SUS304, SUS316, 1.4301, 1.4401		Cast Irons GG/GGG		Aluminium Alloys Copper Alloys Al5052, C1100		Nickel Alloys Titanium Alloys 30~40HRC	
	mm	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹
2	5700	300	4600	200	3200	120	1600	55	6300	410	9700	630	800	23
3	4200	380	3400	260	2100	120	1100	60	4700	530	7200	820	530	25
5	2500	360	2000	240	1250	120	760	75	2800	500	4300	770	320	23
8	1600	310	1300	210	800	115	480	80	1800	440	2700	660	200	22
10	1300	280	1000	190	650	110	380	80	1400	390	2200	610	160	22
12	1100	260	850	180	530	105	320	80	1200	360	1800	560	130	21
16	800	240	640	160	400	100	240	70	880	330	1400	500	100	20
20	640	220	510	150	320	90	190	60	700	300	1100	460	80	19
25	510	200	410	140	250	80	150	50	560	270	870	420	64	18
32	400	150	320	110	200	65	120	45	440	210	680	330	50	15

Warnings on using the drilling condition tables

- 1) Adjust the drilling condition according to the rigidity of the machine, work clamping situation and shape of the workpiece.
- 2) The table values are for drilling with water-soluble cutting fluid.
- 3) Provide sufficient amount of cutting fluid to the cutting point and in the flute.
- 4) Reduce 20% of the RPM and Feed, when drilling over 3D depth.
- 5) When drilling over 3D depth, add step feed. However, up to the work material and drilling condition, the chip evacuation may be worse. In this case, even when the cutting depth is under 3D, add step feed.
- 6) Add step feeding for stainless steel.
- 7) When step feeding, return to the entrance of the hole each step.
- 8) Step feed interval is around 0.5-1D. Small diameters are around 0.2-0.5D.
- 9) Use collet chuck or milling chuck.

SGESS 3D



TOOL MATERIAL

POINT ANGLE
DC ≤ 1,4

POINT ANGLE
DC > 1,4

POINT ANGLE

LIST: 7572P

Code	Dc	ℓ	L	Ds	Stock
SGESS0.5	0.50	3	38	3	●
SGESS0.51	0.51	3	38	3	●
SGESS0.52	0.52	3	38	3	●
SGESS0.53	0.53	3	38	3	●
SGESS0.54	0.54	3	38	3	●
SGESS0.55	0.55	3	38	3	●
SGESS0.56	0.56	3	38	3	●
SGESS0.57	0.57	3	38	3	●
SGESS0.58	0.58	3	38	3	●
SGESS0.59	0.59	3	38	3	●
SGESS0.6	0.60	3.5	38	3	●
SGESS0.61	0.61	3.5	38	3	●
SGESS0.62	0.62	3.5	38	3	●
SGESS0.63	0.63	3.5	38	3	●
SGESS0.64	0.64	3.5	38	3	●
SGESS0.65	0.65	3.5	38	3	●
SGESS0.66	0.66	3.5	38	3	●
SGESS0.67	0.67	3.5	38	3	●
SGESS0.68	0.68	3.5	38	3	●
SGESS0.69	0.69	3.5	38	3	●
SGESS0.7	0.70	4.5	38	3	●
SGESS0.71	0.71	4.5	38	3	●
SGESS0.72	0.72	4.5	38	3	●
SGESS0.73	0.73	4.5	38	3	●
SGESS0.74	0.74	4.5	38	3	●
SGESS0.75	0.75	4.5	38	3	●
SGESS0.76	0.76	4.5	38	3	●
SGESS0.77	0.77	4.5	38	3	●
SGESS0.78	0.78	4.5	38	3	●
SGESS0.79	0.79	4.5	38	3	●
SGESS0.8	0.80	5	38	3	●
SGESS0.81	0.81	5	38	3	●
SGESS0.82	0.82	5	38	3	●
SGESS0.83	0.83	5	38	3	●
SGESS0.84	0.84	5	38	3	●
SGESS0.85	0.85	5	38	3	●
SGESS0.86	0.86	5	38	3	●
SGESS0.87	0.87	5	38	3	●
SGESS0.88	0.88	5	38	3	●
SGESS0.89	0.89	5	38	3	●
SGESS0.9	0.90	5.5	38	3	●
SGESS0.91	0.91	5.5	38	3	●
SGESS0.92	0.92	5.5	38	3	●

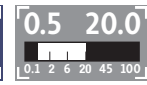
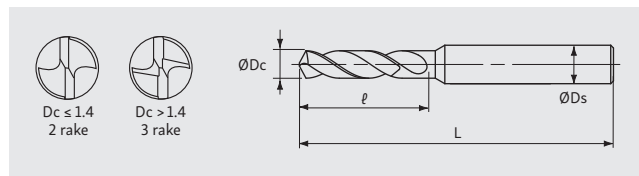
Code	Dc	ℓ	L	Ds	Stock
SGESS0.93	0.93	5.5	38	3	●
SGESS0.94	0.94	5.5	38	3	●
SGESS0.95	0.95	5.5	38	3	●
SGESS0.96	0.96	5.5	38	3	●
SGESS0.97	0.97	5.5	38	3	●
SGESS0.98	0.98	5.5	38	3	●
SGESS0.99	0.99	5.5	38	3	●
SGESS1.0	1.00	6	38	3	●
SGESS1.01	1.01	6	38	3	●
SGESS1.02	1.02	6	38	3	●
SGESS1.03	1.03	6	38	3	●
SGESS1.04	1.04	6	38	3	●
SGESS1.05	1.05	6	38	3	●
SGESS1.06	1.06	6	38	3	●
SGESS1.07	1.07	7	39	3	●
SGESS1.08	1.08	7	39	3	●
SGESS1.09	1.09	7	39	3	●
SGESS1.1	1.10	7	39	3	●
SGESS1.11	1.11	7	39	3	●
SGESS1.12	1.12	7	39	3	●
SGESS1.13	1.13	7	39	3	●
SGESS1.14	1.14	7	39	3	●
SGESS1.15	1.15	7	39	3	●
SGESS1.16	1.16	7	39	3	●
SGESS1.17	1.17	7	39	3	●
SGESS1.18	1.18	7	39	3	●
SGESS1.19	1.19	8	40	3	●
SGESS1.2	1.2	8	40	3	●
SGESS1.21	1.21	8	40	3	●
SGESS1.22	1.22	8	40	3	●
SGESS1.23	1.23	8	40	3	●
SGESS1.24	1.24	8	40	3	●
SGESS1.25	1.25	8	40	3	●
SGESS1.26	1.26	8	40	3	●
SGESS1.27	1.27	8	40	3	●
SGESS1.28	1.28	8	40	3	●
SGESS1.29	1.29	8	40	3	●
SGESS1.3	1.3	8	40	3	●
SGESS1.31	1.31	8	40	3	●
SGESS1.32	1.32	8	40	3	●
SGESS1.33	1.33	9	41	3	●
SGESS1.34	1.34	9	41	3	●
SGESS1.35	1.35	9	41	3	●

LIST: 7572P

Code	Dc	ℓ	L	Ds	Stock
SGESS1.36	1.36	9	41	3	●
SGESS1.37	1.37	9	41	3	●
SGESS1.38	1.38	9	41	3	●
SGESS1.39	1.39	9	41	3	●
SGESS1.4	1.4	9	41	3	●
SGESS1.41	1.41	9	41	3	●
SGESS1.42	1.42	9	41	3	●
SGESS1.43	1.43	9	41	3	●
SGESS1.44	1.44	9	41	3	●
SGESS1.45	1.45	9	41	3	●
SGESS1.46	1.46	9	41	3	●
SGESS1.47	1.47	9	41	3	●
SGESS1.48	1.48	9	41	3	●
SGESS1.49	1.49	9	41	3	●
SGESS1.5	1.5	9	41	3	●
SGESS1.51	1.51	10	42	3	●
SGESS1.52	1.52	10	42	3	●
SGESS1.53	1.53	10	42	3	●
SGESS1.54	1.54	10	42	3	●
SGESS1.55	1.55	10	42	3	●
SGESS1.56	1.56	10	42	3	●
SGESS1.57	1.57	10	42	3	●
SGESS1.58	1.58	10	42	3	●
SGESS1.59	1.59	10	42	3	●
SGESS1.6	1.6	10	42	3	●
SGESS1.61	1.61	10	42	3	●
SGESS1.62	1.62	10	42	3	●
SGESS1.63	1.63	10	42	3	●
SGESS1.64	1.64	10	42	3	●
SGESS1.65	1.65	10	42	3	●
SGESS1.66	1.66	10	42	3	●
SGESS1.67	1.67	10	42	3	●
SGESS1.68	1.68	10	42	3	●
SGESS1.69	1.69	10	42	3	●
SGESS1.7	1.7	10	42	3	●
SGESS1.71	1.71	11	43	3	●
SGESS1.72	1.72	11	43	3	●
SGESS1.73	1.73	11	43	3	●
SGESS1.74	1.74	11	43	3	●
SGESS1.75	1.75	11	43	3	●
SGESS1.76	1.76	11	43	3	●
SGESS1.77	1.77	11	43	3	●
SGESS1.78	1.78	11	43	3	●
SGESS1.79	1.79	11	43	3	●
SGESS1.8	1.8	11	43	3	●
SGESS1.81	1.81	11	43	3	●
SGESS1.82	1.82	11	43	3	●
SGESS1.83	1.83	11	43	3	●
SGESS1.84	1.84	11	43	3	●
SGESS1.85	1.85	11	43	3	●

Code	Dc	ℓ	L	Ds	Stock
SGESS1.86	1.86	11	43	3	●
SGESS1.87	1.87	11	43	3	●
SGESS1.88	1.88	11	43	3	●
SGESS1.89	1.89	11	43	3	●
SGESS1.9	1.9	11	43	3	●
SGESS1.91	1.91	12	44	3	●
SGESS1.92	1.92	12	44	3	●
SGESS1.93	1.93	12	44	3	●
SGESS1.94	1.94	12	44	3	●
SGESS1.95	1.95	12	44	3	●
SGESS1.96	1.96	12	44	3	●
SGESS1.97	1.97	12	44	3	●
SGESS1.98	1.98	12	44	3	●
SGESS1.99	1.99	12	44	3	●
SGESS2.0	2.0	12	44	3	●
SGESS2.01	2.01	12	44	3	●
SGESS2.02	2.02	12	44	3	●
SGESS2.03	2.03	12	44	3	●
SGESS2.04	2.04	12	44	3	●
SGESS2.05	2.05	12	44	3	●
SGESS2.06	2.06	12	44	3	●
SGESS2.07	2.07	12	44	3	●
SGESS2.08	2.08	12	44	3	●
SGESS2.09	2.09	12	44	3	●
SGESS2.1	2.1	12	44	3	●
SGESS2.11	2.11	12	44	3	●
SGESS2.12	2.12	12	44	3	●
SGESS2.13	2.13	13	45	3	●
SGESS2.14	2.14	13	45	3	●
SGESS2.15	2.15	13	45	3	●
SGESS2.16	2.16	13	45	3	●
SGESS2.17	2.17	13	45	3	●
SGESS2.18	2.18	13	45	3	●
SGESS2.19	2.19	13	45	3	●
SGESS2.2	2.2	13	45	3	●
SGESS2.21	2.21	13	45	3	●
SGESS2.22	2.22	13	45	3	●
SGESS2.23	2.23	13	45	3	●
SGESS2.24	2.24	13	45	3	●
SGESS2.25	2.25	13	45	3	●
SGESS2.26	2.26	13	45	3	●
SGESS2.27	2.27	13	45	3	●
SGESS2.28	2.28	13	45	3	●
SGESS2.29	2.29	13	45	3	●
SGESS2.3	2.3	13	45	3	●
SGESS2.31	2.31	13	45	3	●
SGESS2.32	2.32	13	45	3	●
SGESS2.33	2.33	13	45	3	●
SGESS2.34	2.34	13	45	3	●
SGESS2.35	2.35	13	45	3	●

SGESS 3D



LIST: 7572P

Code	Dc	ℓ	L	Ds	Stock
SGESS2.36	2.36	13	45	3	●
SGESS2.37	2.37	14	46	3	●
SGESS2.38	2.38	14	46	3	●
SGESS2.39	2.39	14	46	3	●
SGESS2.4	2.4	14	46	3	●
SGESS2.41	2.41	14	46	3	●
SGESS2.42	2.42	14	46	3	●
SGESS2.43	2.43	14	46	3	●
SGESS2.44	2.44	14	46	3	●
SGESS2.45	2.45	14	46	3	●
SGESS2.46	2.46	14	46	3	●
SGESS2.47	2.47	14	46	3	●
SGESS2.48	2.48	14	46	3	●
SGESS2.49	2.49	14	46	3	●
SGESS2.5	2.5	14	46	3	●
SGESS2.51	2.51	14	46	3	●
SGESS2.52	2.52	14	46	3	●
SGESS2.53	2.53	14	46	3	●
SGESS2.54	2.54	14	46	3	●
SGESS2.55	2.55	14	46	3	●
SGESS2.56	2.56	14	46	3	●
SGESS2.57	2.57	14	46	3	●
SGESS2.58	2.58	14	46	3	●
SGESS2.59	2.59	14	46	3	●
SGESS2.6	2.6	14	46	3	●
SGESS2.61	2.61	14	46	3	●
SGESS2.62	2.62	14	46	3	●
SGESS2.63	2.63	14	46	3	●
SGESS2.64	2.64	14	46	3	●
SGESS2.65	2.65	14	46	3	●
SGESS2.66	2.66	16	48	3	●
SGESS2.67	2.67	16	48	3	●
SGESS2.68	2.68	16	48	3	●
SGESS2.69	2.69	16	48	3	●
SGESS2.7	2.7	16	48	3	●
SGESS2.71	2.71	16	48	3	●
SGESS2.72	2.72	16	48	3	●
SGESS2.73	2.73	16	48	3	●
SGESS2.74	2.74	16	48	3	●
SGESS2.75	2.75	16	48	3	●
SGESS2.76	2.76	16	48	3	●
SGESS2.77	2.77	16	48	3	●
SGESS2.78	2.78	16	48	3	●

TOOL MATERIAL

POINT ANGLE
DC ≤ 1,4

POINT ANGLE
DC > 1,4

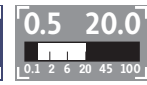
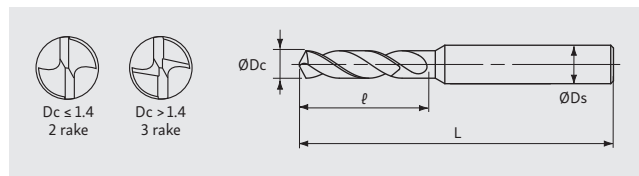
Code	Dc	ℓ	L	Ds	Stock
SGESS2.79	2.79	16	48	3	●
SGESS2.8	2.8	16	48	3	●
SGESS2.81	2.81	16	48	3	●
SGESS2.82	2.82	16	48	3	●
SGESS2.83	2.83	16	48	3	●
SGESS2.84	2.84	16	48	3	●
SGESS2.85	2.85	16	48	3	●
SGESS2.86	2.86	16	48	3	●
SGESS2.87	2.87	16	48	3	●
SGESS2.88	2.88	16	48	3	●
SGESS2.89	2.89	16	48	3	●
SGESS2.9	2.9	16	48	3	●
SGESS2.91	2.91	16	48	3	●
SGESS2.92	2.92	16	48	3	●
SGESS2.93	2.93	16	48	3	●
SGESS2.94	2.94	16	48	3	●
SGESS2.95	2.95	16	48	3	●
SGESS2.96	2.96	16	48	3	●
SGESS2.97	2.97	16	48	3	●
SGESS2.98	2.98	16	48	3	●
SGESS2.99	2.99	16	48	3	●
SGESS3.0	3.0	16	48	3	●
SGESS3.01	3.01	18	50	4	●
SGESS3.02	3.02	18	50	4	●
SGESS3.03	3.03	18	50	4	●
SGESS3.04	3.04	18	50	4	●
SGESS3.05	3.05	18	50	4	●
SGESS3.06	3.06	18	50	4	●
SGESS3.07	3.07	18	50	4	●
SGESS3.08	3.08	18	50	4	●
SGESS3.09	3.09	18	50	4	●
SGESS3.1	3.1	18	50	4	●
SGESS3.11	3.11	18	50	4	●
SGESS3.12	3.12	18	50	4	●
SGESS3.13	3.13	18	50	4	●
SGESS3.14	3.14	18	50	4	●
SGESS3.15	3.15	18	50	4	●
SGESS3.16	3.16	18	50	4	●
SGESS3.17	3.17	18	50	4	●
SGESS3.18	3.18	18	50	4	●
SGESS3.19	3.19	18	50	4	●
SGESS3.2	3.2	18	50	4	●
SGESS3.21	3.21	18	50	4	●

LIST: 7572P

Code	Dc	ℓ	L	Ds	Stock
SGESS3.22	3.22	18	50	4	●
SGESS3.23	3.23	18	50	4	●
SGESS3.24	3.24	18	50	4	●
SGESS3.25	3.25	18	50	4	●
SGESS3.26	3.26	18	50	4	●
SGESS3.27	3.27	18	50	4	●
SGESS3.28	3.28	18	50	4	●
SGESS3.29	3.29	18	50	4	●
SGESS3.3	3.3	18	50	4	●
SGESS3.31	3.31	18	50	4	●
SGESS3.32	3.32	18	50	4	●
SGESS3.33	3.33	18	50	4	●
SGESS3.34	3.34	18	50	4	●
SGESS3.35	3.35	18	50	4	●
SGESS3.36	3.36	20	52	4	●
SGESS3.37	3.37	20	52	4	●
SGESS3.38	3.38	20	52	4	●
SGESS3.39	3.39	20	52	4	●
SGESS3.4	3.4	20	52	4	●
SGESS3.41	3.41	20	52	4	●
SGESS3.42	3.42	20	52	4	●
SGESS3.43	3.43	20	52	4	●
SGESS3.44	3.44	20	52	4	●
SGESS3.45	3.45	20	52	4	●
SGESS3.46	3.46	20	52	4	●
SGESS3.47	3.47	20	52	4	●
SGESS3.48	3.48	20	52	4	●
SGESS3.49	3.49	20	52	4	●
SGESS3.5	3.5	20	52	4	●
SGESS3.51	3.51	20	52	4	●
SGESS3.52	3.52	20	52	4	●
SGESS3.53	3.53	20	52	4	●
SGESS3.54	3.54	20	52	4	●
SGESS3.55	3.55	20	52	4	●
SGESS3.56	3.56	20	52	4	●
SGESS3.57	3.57	20	52	4	●
SGESS3.58	3.58	20	52	4	●
SGESS3.59	3.59	20	52	4	●
SGESS3.6	3.6	20	52	4	●
SGESS3.61	3.61	20	52	4	●
SGESS3.62	3.62	20	52	4	●
SGESS3.63	3.63	20	52	4	●
SGESS3.64	3.64	20	52	4	●
SGESS3.65	3.65	20	52	4	●
SGESS3.66	3.66	20	52	4	●
SGESS3.67	3.67	20	52	4	●
SGESS3.68	3.68	20	52	4	●
SGESS3.69	3.69	20	52	4	●
SGESS3.7	3.7	20	52	4	●
SGESS3.71	3.71	20	52	4	●

Code	Dc	ℓ	L	Ds	Stock
SGESS3.72	3.72	20	52	4	●
SGESS3.73	3.73	20	52	4	●
SGESS3.74	3.74	20	52	4	●
SGESS3.75	3.75	20	52	4	●
SGESS3.76	3.76	22	54	4	●
SGESS3.77	3.77	22	54	4	●
SGESS3.78	3.78	22	54	4	●
SGESS3.79	3.79	22	54	4	●
SGESS3.8	3.8	22	54	4	●
SGESS3.81	3.81	22	54	4	●
SGESS3.82	3.82	22	54	4	●
SGESS3.83	3.83	22	54	4	●
SGESS3.84	3.84	22	54	4	●
SGESS3.85	3.85	22	54	4	●
SGESS3.86	3.86	22	54	4	●
SGESS3.87	3.87	22	54	4	●
SGESS3.88	3.88	22	54	4	●
SGESS3.89	3.89	22	54	4	●
SGESS3.9	3.9	22	54	4	●
SGESS3.91	3.91	22	54	4	●
SGESS3.92	3.92	22	54	4	●
SGESS3.93	3.93	22	54	4	●
SGESS3.94	3.94	22	54	4	●
SGESS3.95	3.95	22	54	4	●
SGESS3.96	3.96	22	54	4	●
SGESS3.97	3.97	22	54	4	●
SGESS3.98	3.98	22	54	4	●
SGESS3.99	3.99	22	54	4	●
SGESS4.0	4.0	22	54	4	●
SGESS4.01	4.01	22	66	6	●
SGESS4.02	4.02	22	66	6	●
SGESS4.03	4.03	22	66	6	●
SGESS4.04	4.04	22	66	6	●
SGESS4.05	4.05	22	66	6	●
SGESS4.06	4.06	22	66	6	●
SGESS4.07	4.07	22	66	6	●
SGESS4.08	4.08	22	66	6	●
SGESS4.09	4.09	22	66	6	●
SGESS4.1	4.1	22	66	6	●
SGESS4.11	4.11	22	66	6	●
SGESS4.12	4.12	22	66	6	●
SGESS4.13	4.13	22	66	6	●
SGESS4.14	4.14	22	66	6	●
SGESS4.15	4.15	22	66	6	●
SGESS4.16	4.16	22	66	6	●
SGESS4.17	4.17	22	66	6	●
SGESS4.18	4.18	22	66	6	●
SGESS4.19	4.19	22	66	6	●
SGESS4.2	4.2	22	66	6	●
SGESS4.21	4.21	22	66	6	●

SGESS 3D



LIST: 7572P

Code	Dc	ℓ	L	Ds	Stock
SGESS4.22	4.22	22	66	6	●
SGESS4.23	4.23	22	66	6	●
SGESS4.24	4.24	22	66	6	●
SGESS4.25	4.25	22	66	6	●
SGESS4.26	4.26	24	68	6	●
SGESS4.27	4.27	24	68	6	●
SGESS4.28	4.28	24	68	6	●
SGESS4.29	4.29	24	68	6	●
SGESS4.3	4.3	24	68	6	●
SGESS4.31	4.31	24	68	6	●
SGESS4.32	4.32	24	68	6	●
SGESS4.33	4.33	24	68	6	●
SGESS4.34	4.34	24	68	6	●
SGESS4.35	4.35	24	68	6	●
SGESS4.36	4.36	24	68	6	●
SGESS4.37	4.37	24	68	6	●
SGESS4.38	4.38	24	68	6	●
SGESS4.39	4.39	24	68	6	●
SGESS4.4	4.4	24	68	6	●
SGESS4.41	4.41	24	68	6	●
SGESS4.42	4.42	24	68	6	●
SGESS4.43	4.43	24	68	6	●
SGESS4.44	4.44	24	68	6	●
SGESS4.45	4.45	24	68	6	●
SGESS4.46	4.46	24	68	6	●
SGESS4.47	4.47	24	68	6	●
SGESS4.48	4.48	24	68	6	●
SGESS4.49	4.49	24	68	6	●
SGESS4.5	4.5	24	68	6	●
SGESS4.51	4.51	24	68	6	●
SGESS4.52	4.52	24	68	6	●
SGESS4.53	4.53	24	68	6	●
SGESS4.54	4.54	24	68	6	●
SGESS4.55	4.55	24	68	6	●
SGESS4.56	4.56	24	68	6	●
SGESS4.57	4.57	24	68	6	●
SGESS4.58	4.58	24	68	6	●
SGESS4.59	4.59	24	68	6	●
SGESS4.6	4.6	24	68	6	●
SGESS4.61	4.61	24	68	6	●
SGESS4.62	4.62	24	68	6	●
SGESS4.63	4.63	24	68	6	●
SGESS4.64	4.64	24	68	6	●

TOOL MATERIAL

POINT ANGLE
Dc ≤ 1,4

POINT ANGLE
Dc > 1,4

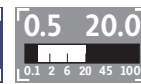
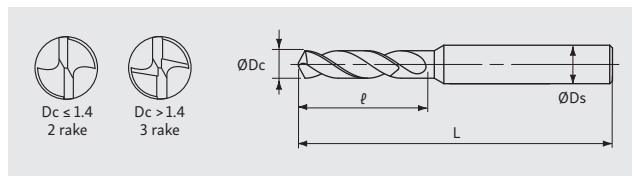
Code	Dc	ℓ	L	Ds	Stock
SGESS4.65	4.65	24	68	6	●
SGESS4.66	4.66	24	68	6	●
SGESS4.67	4.67	24	68	6	●
SGESS4.68	4.68	24	68	6	●
SGESS4.69	4.69	24	68	6	●
SGESS4.7	4.7	24	68	6	●
SGESS4.71	4.71	24	68	6	●
SGESS4.72	4.72	24	68	6	●
SGESS4.73	4.73	24	68	6	●
SGESS4.74	4.74	24	68	6	●
SGESS4.75	4.75	24	68	6	●
SGESS4.76	4.76	26	70	6	●
SGESS4.77	4.77	26	70	6	●
SGESS4.78	4.78	26	70	6	●
SGESS4.79	4.79	26	70	6	●
SGESS4.8	4.8	26	70	6	●
SGESS4.81	4.81	26	70	6	●
SGESS4.82	4.82	26	70	6	●
SGESS4.83	4.83	26	70	6	●
SGESS4.84	4.84	26	70	6	●
SGESS4.85	4.85	26	70	6	●
SGESS4.86	4.86	26	70	6	●
SGESS4.87	4.87	26	70	6	●
SGESS4.88	4.88	26	70	6	●
SGESS4.89	4.89	26	70	6	●
SGESS4.9	4.9	26	70	6	●
SGESS4.91	4.91	26	70	6	●
SGESS4.92	4.92	26	70	6	●
SGESS4.93	4.93	26	70	6	●
SGESS4.94	4.94	26	70	6	●
SGESS4.95	4.95	26	70	6	●
SGESS4.96	4.96	26	70	6	●
SGESS4.97	4.97	26	70	6	●
SGESS4.98	4.98	26	70	6	●
SGESS4.99	4.99	26	70	6	●
SGESS5.0	5.0	26	70	6	●
SGESS5.01	5.01	26	70	6	●
SGESS5.02	5.02	26	70	6	●
SGESS5.03	5.03	26	70	6	●
SGESS5.04	5.04	26	70	6	●
SGESS5.05	5.05	26	70	6	●
SGESS5.06	5.06	26	70	6	●
SGESS5.07	5.07	26	70	6	●

LIST: 7572P

Code	Dc	ℓ	L	Ds	Stock
SGESS5.08	5.08	26	70	6	●
SGESS5.09	5.09	26	70	6	●
SGESS5.1	5.1	26	70	6	●
SGESS5.11	5.11	26	70	6	●
SGESS5.12	5.12	26	70	6	●
SGESS5.13	5.13	26	70	6	●
SGESS5.14	5.14	26	70	6	●
SGESS5.15	5.15	26	70	6	●
SGESS5.16	5.16	26	70	6	●
SGESS5.17	5.17	26	70	6	●
SGESS5.18	5.18	26	70	6	●
SGESS5.19	5.19	26	70	6	●
SGESS5.2	5.2	26	70	6	●
SGESS5.21	5.21	26	70	6	●
SGESS5.22	5.22	26	70	6	●
SGESS5.23	5.23	26	70	6	●
SGESS5.24	5.24	26	70	6	●
SGESS5.25	5.25	26	70	6	●
SGESS5.26	5.26	26	70	6	●
SGESS5.27	5.27	26	70	6	●
SGESS5.28	5.28	26	70	6	●
SGESS5.29	5.29	26	70	6	●
SGESS5.3	5.3	26	70	6	●
SGESS5.31	5.31	28	72	6	●
SGESS5.32	5.32	28	72	6	●
SGESS5.33	5.33	28	72	6	●
SGESS5.34	5.34	28	72	6	●
SGESS5.35	5.35	28	72	6	●
SGESS5.36	5.36	28	72	6	●
SGESS5.37	5.37	28	72	6	●
SGESS5.38	5.38	28	72	6	●
SGESS5.39	5.39	28	72	6	●
SGESS5.4	5.4	28	72	6	●
SGESS5.41	5.41	28	72	6	●
SGESS5.42	5.42	28	72	6	●
SGESS5.43	5.43	28	72	6	●
SGESS5.44	5.44	28	72	6	●
SGESS5.45	5.45	28	72	6	●
SGESS5.46	5.46	28	72	6	●
SGESS5.47	5.47	28	72	6	●
SGESS5.48	5.48	28	72	6	●
SGESS5.49	5.49	28	72	6	●
SGESS5.5	5.5	28	72	6	●
SGESS5.51	5.51	28	72	6	●
SGESS5.52	5.52	28	72	6	●
SGESS5.53	5.53	28	72	6	●
SGESS5.54	5.54	28	72	6	●
SGESS5.55	5.55	28	72	6	●
SGESS5.56	5.56	28	72	6	●
SGESS5.57	5.57	28	72	6	●

Code	Dc	ℓ	L	Ds	Stock
SGESS5.58	5.58	28	72	6	●
SGESS5.59	5.59	28	72	6	●
SGESS5.6	5.6	28	72	6	●
SGESS5.61	5.61	28	72	6	●
SGESS5.62	5.62	28	72	6	●
SGESS5.63	5.63	28	72	6	●
SGESS5.64	5.64	28	72	6	●
SGESS5.65	5.65	28	72	6	●
SGESS5.66	5.66	28	72	6	●
SGESS5.67	5.67	28	72	6	●
SGESS5.68	5.68	28	72	6	●
SGESS5.69	5.69	28	72	6	●
SGESS5.7	5.7	28	72	6	●
SGESS5.71	5.71	28	72	6	●
SGESS5.72	5.72	28	72	6	●
SGESS5.73	5.73	28	72	6	●
SGESS5.74	5.74	28	72	6	●
SGESS5.75	5.75	28	72	6	●
SGESS5.76	5.76	28	72	6	●
SGESS5.77	5.77	28	72	6	●
SGESS5.78	5.78	28	72	6	●
SGESS5.79	5.79	28	72	6	●
SGESS5.8	5.8	28	72	6	●
SGESS5.81	5.81	28	72	6	●
SGESS5.82	5.82	28	72	6	●
SGESS5.83	5.83	28	72	6	●
SGESS5.84	5.84	28	72	6	●
SGESS5.85	5.85	28	72	6	●
SGESS5.86	5.86	28	72	6	●
SGESS5.87	5.87	28	72	6	●
SGESS5.88	5.88	28	72	6	●
SGESS5.89	5.89	28	72	6	●
SGESS5.9	5.9	28	72	6	●
SGESS5.91	5.91	28	72	6	●
SGESS5.92	5.92	28	72	6	●
SGESS5.93	5.93	28	72	6	●
SGESS5.94	5.94	28	72	6	●
SGESS5.95	5.95	28	72	6	●
SGESS5.96	5.96	28	72	6	●
SGESS5.97	5.97	28	72	6	●
SGESS5.98	5.98	28	72	6	●
SGESS5.99	5.99	28	72	6	●
SGESS6.0	6.0	28	72	6	●
SGESS6.1	6.1	31	75	8	●
SGESS6.2	6.2	31	75	8	●
SGESS6.3	6.3	31	75	8	●
SGESS6.4	6.4	31	75	8	●
SGESS6.5	6.5	31	75	8	●
SGESS6.6	6.6	31	75	8	●
SGESS6.7	6.7	31	75	8	●

SGESS 3D



TOOL MATERIAL

POINT ANGLE
Dc ≤ 1,4

POINT ANGLE
Dc > 1,4

LIST: 7572P

Code	Dc	ℓ	L	Ds	Stock
SGESS6.8	6.8	34	78	8	●
SGESS6.9	6.9	34	78	8	●
SGESS7.0	7.0	34	78	8	●
SGESS7.1	7.1	34	78	8	●
SGESS7.2	7.2	34	78	8	●
SGESS7.3	7.3	34	78	8	●
SGESS7.4	7.4	34	78	8	●
SGESS7.5	7.5	34	78	8	●
SGESS7.6	7.6	37	81	8	●
SGESS7.7	7.7	37	81	8	●
SGESS7.8	7.8	37	81	8	●
SGESS7.9	7.9	37	81	8	●
SGESS8.0	8.0	37	81	8	●
SGESS8.1	8.1	37	87	10	●
SGESS8.2	8.2	37	87	10	●
SGESS8.3	8.3	37	87	10	●
SGESS8.4	8.4	37	87	10	●
SGESS8.5	8.5	37	87	10	●
SGESS8.6	8.6	40	90	10	●
SGESS8.7	8.7	40	90	10	●
SGESS8.8	8.8	40	90	10	●
SGESS8.9	8.9	40	90	10	●
SGESS9.0	9.0	40	90	10	●
SGESS9.1	9.1	40	90	10	●
SGESS9.2	9.2	40	90	10	●
SGESS9.3	9.3	40	90	10	●
SGESS9.4	9.4	40	90	10	●
SGESS9.5	9.5	40	90	10	●
SGESS9.6	9.6	43	93	10	●
SGESS9.7	9.7	43	93	10	●
SGESS9.8	9.8	43	93	10	●
SGESS9.9	9.9	43	93	10	●
SGESS10.0	10.0	43	93	10	●
SGESS10.1	10.1	43	100	12	●
SGESS10.2	10.2	43	100	12	●
SGESS10.3	10.3	43	100	12	●
SGESS10.4	10.4	43	100	12	●
SGESS10.5	10.5	43	100	12	●
SGESS10.6	10.6	43	100	12	●

Code	Dc	ℓ	L	Ds	Stock
SGESS10.7	10.7	47	104	12	●
SGESS10.8	10.8	47	104	12	●
SGESS10.9	10.9	47	104	12	●
SGESS11.0	11.0	47	104	12	●
SGESS11.1	11.1	47	104	12	●
SGESS11.2	11.2	47	104	12	●
SGESS11.3	11.3	47	104	12	●
SGESS11.4	11.4	47	104	12	●
SGESS11.5	11.5	47	104	12	●
SGESS11.6	11.6	47	104	12	●
SGESS11.7	11.7	47	104	12	●
SGESS11.8	11.8	47	104	12	●
SGESS11.9	11.9	51	108	12	●
SGESS12.0	12.0	51	108	12	●
SGESS12.1	12.1	51	108	12	●
SGESS12.2	12.2	51	108	12	●
SGESS12.3	12.3	51	108	12	●
SGESS12.4	12.4	51	108	12	●
SGESS12.5	12.5	51	108	12	●
SGESS12.6	12.6	51	108	12	●
SGESS12.7	12.7	51	108	12	●
SGESS12.8	12.8	51	108	12	●
SGESS12.9	12.9	51	108	12	●
SGESS13.0	13.0	51	108	12	●
SGESS13.5	13.5	72	132	16	●
SGESS14.0	14.0	72	132	16	●
SGESS14.5	14.5	76	136	16	●
SGESS15.0	15.0	76	142	20	●
SGESS15.5	15.5	80	146	20	●
SGESS16.0	16.0	80	146	20	●
SGESS16.5	16.5	84	150	20	●
SGESS17.0	17.0	84	150	20	●
SGESS17.5	17.5	87	153	20	●
SGESS18.0	18.0	87	153	20	●
SGESS18.5	18.5	90	156	20	●
SGESS19.0	19.0	90	164	25	●
SGESS19.5	19.5	94	168	25	●
SGESS20.0	20.0	94	168	25	●

●: Standard stock item

Standard Drilling Conditions														
Work material	Structural Steels Carbon Steels ST-37-2, C50		Alloy Steels Pre-Hardened Steels 42CrMo4, NAK, HPM		Mold Steels Hardened Steels X40MoV51, NAK, HPM		Stainless Steels SUS304, SUS316, 1.4301, 1.4401		Cast Irons GG/GGG		Aluminium Alloys Copper Alloys Al5052, C1100		Nickel Alloys Titanium Alloys	
	~200HB		20~30HRC		30~40HRC								30~40HRC	
mm	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min
0.5	16000	240	13000	150	9500	80	5100	50	20000	300	23000	300	2500	18
1	9500	280	8000	190	6400	140	3500	65	12000	400	15000	500	1600	25
2	5700	360	4600	240	3200	160	1900	80	6300	490	9700	760	800	27
3	4200	430	3400	290	2100	165	1300	85	4700	600	7200	900	530	28
5	2500	430	2000	290	1250	165	760	80	2800	600	4300	920	320	29
8	1600	370	1300	250	800	150	480	75	1800	530	2700	790	200	26
10	1300	340	1000	230	650	140	380	73	1400	460	2200	730	160	26
12	1100	310	850	210	530	130	320	70	1200	430	1800	670	130	25
16	800	290	640	200	400	120	240	63	880	390	1400	610	100	23
20	640	260	510	180	320	110	190	57	700	350	1100	550	80	21
25	510	240	410	160	250	95	150	50	560	330	870	510	64	19
32	400	180	320	120	200	70	120	40	440	250	680	380	50	16

Warnings on using the drilling condition tables

- 1) Adjust the drilling condition according to the rigidity of the machine, work clamping situation and shape of the workpiece.
- 2) The table values are for drilling with water-soluble cutting fluid
- 3) Provide sufficient amount of cutting fluid to the cutting point and in the flute.
- 4) Add step feeding for stainless steel.
- 5) Up to the work material and drilling condition, the chip evacuation may be worse. In this case, add step feed.
- 6) When step feeding, return to the entrance of the hole each step.
- 7) Step feed interval is around 0.5-1D. Small diameters are around 0.2-0.5D.
- 8) Use collet chuck or milling chuck.

NACHI EUROPE GmbH | CENTRAL OFFICE GERMANY

Bischofstr. 99 | 47809 Krefeld | Germany | Phone: +49 2151 65046-0 | Fax: +49 2151 65046-90 | E-Mail: info@nachi.de | www.nachi.de



PANAS Tools s.r.o., 958 54 Hradište,
info@panas.sk Tel.: 038/7496764, www.panas.sk

NACHI EUROPE GmbH
SOUTH OFFICE GERMANY

Pleidesheimer Str. 47
 74321 Bietigheim-Bissingen
 Germany

Phone: +49 7142 77418-0
 Fax: +49 7142 77418-20
 E-Mail: info@nachi.de
 Web: www.nachi.de

NACHI EUROPE GmbH
U.K. BRANCH

Unit 3, 92 Kettles Wood Drive
 Woodgate Business Park
 Birmingham B32 3DB
 United Kingdom

Phone: +44 121 423-5000
 Fax: +44 121 421-7520
 E-Mail: sales@nachi.co.uk
 Web: www.nachi.co.uk

NACHI EUROPE GmbH
CZECH BRANCH

Obchodní 132
 251 01 Čestlice
 Czech Republic

Phone: +420 255 734-000
 Fax: +420 255 734-001
 E-Mail: info.cz@nachi.de
 Web: www.nachi.de

NACHI EUROPE GmbH
TURKEY BRANCH

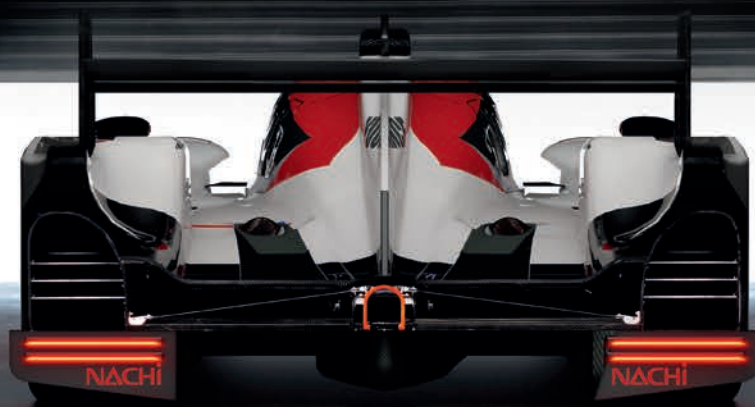
Atatürk Mah. Mustafa
 Kemal Cad. No: 10/1A
 34758 Ataşehir/Istanbul
 Turkey

Phone: +90 216 688-4457
 Fax.: +90 216 688-4458
 E-Mail: turkey@nachi.de
 Web: www.nachi.com.tr

NACHI

NACHI EUROPE GmbH

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MADE IN JAPAN

NACHI-FUJIKOSHI CORP.

TOKYO

Shiodome Sumitomo Bldg., 1-9-2 Nigashi-shinbashi, Minato-ku Tokyo, JAPAN
Phone: +81 3 5568-5240 | Fax: +81 3 5568-5236

TOYAMA

1-1-1 Fujikoshi-Honmachi, Toyama, JAPAN
Phone: +81 76 423-5111 | Fax: +81 76 493-5211

Web: www.nachi-fujikoshi.co.jp/

NACHI EUROPE GmbH

Bischofstr. 99 | DE-47809 Krefeld, Germany | Phone: +49 2151 650 46-0 | Fax: +49 2151 650 46-90 | Web: www.nachi.de | Email: info@nachi.de