

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	
D2306 D2321		HSSCo8, NC-SPOTTING DRILLS 90° HSSCo8, NC-ANBOHRER 90°	D3.0	D20.0	234
D2307 D2322		HSSCo8, NC-SPOTTING DRILLS 120° HSSCo8, NC-ANBOHRER 120°	D3.0 D6.0	D20.0 D12.0	235
D2320 D2323		HSSCo8, NC-SPOTTING DRILLS 142° HSSCo8, NC-ANBOHRER 142°	D3.0 D6.0	D20.0 D12.0	236
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN					237

HSS NC-SPOTTING DRILLS

◎ : Excellent
○ : Good

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



NC-SPOTTING DRILLS

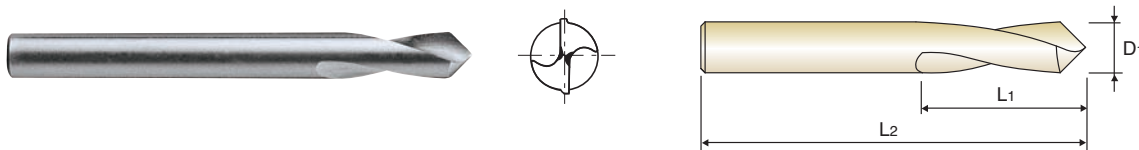
D2306 SERIES

D2321 SERIES

HSSCo8, NC-SPOTTING DRILLS 90°
HSSCo8, NC-ANBOHRER 90°

► **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.



LONG LENGTH

Unit : mm

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2	EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2306030	3.0	12	46	D2321030	3.0	12	80
D2306040	4.0	12	55	D2321040	4.0	12	100
D2306050	5.0	15	60	D2321050	5.0	15	120
D2306060	6.0	20	66	D2321060	6.0	20	140
D2306080	8.0	25	79	D2321080	8.0	25	140
D2306100	10.0	25	89	D2321100	10.0	25	170
D2306120	12.0	30	102	D2321120	12.0	30	170
D2306160	16.0	35	115	D2321160	16.0	35	200
D2306200	20.0	40	131	D2321200	20.0	40	200

► TIN, TiCN and TiAlN are available on your request.

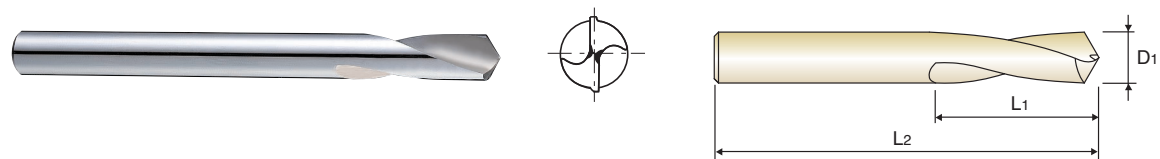
◎ : Excellent ○ : Good

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

HSSCo8, NC-SPOTTING DRILLS 120°
HSSCo8, NC-ANBOHRER 120°

► **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 HSS Co8 h6 h6 120° P.237

LONG LENGTH

Unit : mm

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

EDP No.	Drill Diameter D1	Flute Length L1	Overall Length L2
D2322060	6.0	20	140
D2322080	8.0	25	140
D2322100	10.0	25	170
D2322120	12.0	30	170

► TiN, TiCN and TiAlN are available on your request.

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

◎ : Excellent ○ : Good

- I-DREAM DRILLS
- DREAM DRILLS -GENERAL
- DREAM DRILLS -INOX
- DREAM DRILLS -ALU
- DREAM DRILLS -CFRP
- DREAM DRILLS -MQL TYPE
- DREAM DRILLS for HARDENED STEELS
- GENERAL CARBIDE DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- MULTI-1 DRILLS
- HPD DRILLS
- GOLD-P DRILLS
- STRAIGHT SHANK DRILLS
- TAPER SHANK DRILLS
- NC-SPOTTING DRILLS
- CENTER DRILLS
- SPADE DRILLS
- TECHNICAL DATA



NC-SPOTTING DRILLS

D2320 SERIES

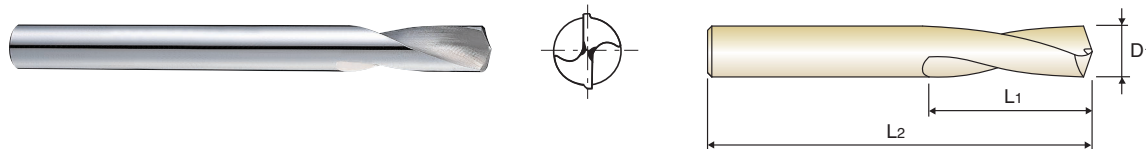
D2323 SERIES

HSSCo8, NC-SPOTTING DRILLS 142°

HSSCo8, NC-ANBOHRER 142°

► **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.



LONG LENGTH

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2320030	3.0	12	46
D2320040	4.0	12	55
D2320050	5.0	15	60
D2320060	6.0	20	66
D2320080	8.0	25	79
D2320100	10.0	25	89
D2320120	12.0	30	102
D2320160	16.0	35	115
D2320200	20.0	40	131

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
D2323060	6.0	20	140
D2323080	8.0	25	140
D2323100	10.0	25	170
D2323120	12.0	30	170

► TiN, TiCN and TiAlN are available on your request.

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

◎ : Excellent ○ : Good

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

HSSCo8, NC-SPOTTING DRILLS 90°, 120°, 142°
HSSCo8, NC-ANBOHRER 90°, 120°, 142°
D2306, D2321, D2307, D2322, D2320, D2323 SERIES

WORK MATERIAL	CARBON STEELS		ALLOY STEELS		ALLOY STEELS, TOOL STEELS, HARDENED STEELS		STAINLESS STEELS		ALUMINUM, ALUMINUM ALLOYS	
	18 ~ 23 m/min		15 ~ 20 m/min		8 ~ 12 m/min		8 ~ 12 m/min		55 ~ 65 m/min	
DRILLING SPEED										
DIAMETER	N	S	N	S	N	S	N	S	N	S
3.0	2460	0.06	2110	0.06	1080	0.06	940	0.06	7040	0.14
4.0	1850	0.07	1580	0.07	800	0.07	700	0.07	5280	0.15
5.0	1510	0.08	1300	0.08	670	0.08	580	0.08	4400	0.17
6.0	1170	0.09	1030	0.09	540	0.09	460	0.09	3520	0.19
8.0	880	0.11	790	0.11	400	0.11	350	0.11	2640	0.22
10.0	700	0.12	630	0.12	320	0.12	290	0.12	2110	0.25
12.0	590	0.14	530	0.14	260	0.14	240	0.14	1760	0.28
16.0	460	0.20	400	0.20	200	0.20	180	0.20	1320	0.33
20.0	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.)



Global Cutting Tool Leader **YG-1**

