



DRILLS

DR VA

High-performance drills suitable for P, M, S materials

Index - Drills, For 35 - 68 HRC

Suitable for Material Groups

Adapté pour les matériaux

适用于材料

Geeignet für die Materialgruppen

Adatto per il materiale

P	M	K	N
S	H	O	

EDP Number	Hardness		Type	No. Z	Helix Angle	Coating	Performance	Page Number
662	≤ 35 HRC		DR NC 60°	2	30°	UC	G	443
953			DR NC 60°	2	30°	B0819	G	443
664			DR NC 90°	2	30°	UC	G	444
955			DR NC 90°	2	30°	B0819	G	444
666			DR NC 120°	2	30°	UC	G	445
957			DR NC 120°	2	30°	B0819	G	445
D09	Non Ferrous Metal		DR ALU OF - 3 x Ø	2	30°	UC	P	449
D10			DR ALU OF - 5 x Ø	2	30°	UC	P	450
NEW W16	≤ 35 HRC		EZ Drill - 3 x Ø	2	30°	T8090	G	454
NEW W17			EZ Drill - 5 x Ø	2	30°	T8090	G	456
D07			DR NiTiCo OF - 3 x Ø	2	30°	T8090	P	459
D08			DR NiTiCo OF - 5 x Ø	2	30°	T8090	P	460
C73	≤ 45 HRC		DR VA OF- 3 x Ø	2	30°	T8090	P	464
C77			DR VA OF- 5 x Ø	2	30°	T8090	P	465
W08			DR-S - 3 x Ø	2	30°	T8090	P	469
W09			DR-S - 5 x Ø	2	30°	T8090	P	470
W10			DR-S OF - 3 x Ø	2	30°	T8090	P	471
W11			DR-S OF - 5 x Ø	2	30°	T8090	P	472
H03			DR MINI OF - 5 x Ø, 8x Ø, 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø	2	30°	T8090	P	479
NEW W05			DR-LX OF - 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø	2	30°	T8090	P	485
F33			DR 45 SB OF - 8 x Ø	2	30°	T8090	P	493
821	≤ 60 HRC		DR 60 - 5 x Ø	2	15°	D0120	P	497
823			DR 60 - 3 x Ø	2	15°	D0120	P	498

G - General P - Performance

DR NITICO OIL FEED TWIST DRILLS - DIN 6537K - 130° POINT ANGLE - 3 X Ø

 VHM DR NiTiCo Kühlkanalbohrer nach DIN 6537K 130° Spitzenwinkel, Schaft nach DIN 6535HA

 Punte elicoidali DR NiTiCo a norma DIN 6537K - 3 x Ø, con foro di lubrificazione, angolo di punta 130° codolo DIN 6535HA

 Forets hélicoïdaux DR NiTiCo à trous d'huile selon DIN 6537K - 3 x Ø angle de pointe 130°, queue selon DIN 6535HA

 整体硬质合金 DR NiTiCo 系列 内冷孔钻头-相等于DIN6537K 2刃-加工深度3xD, 柄部标准DIN6535HA, 顶角130°



Order Number	DIN 6535	Dimension (mm)						T8090	Order Number	DIN 6535	Dimension (mm)						T8090
		D (m7)	I 1	I 2	I 3	L	d2 (h6)				D (m7)	I 1	I 2	I 3	L	d2 (h6)	
D07 0300 062 03		3	14	20	36	62	3	◦	D07 0790	*	7.9	29	41	36	79	8	●
D07 0300	*	3		20	36	62	6	◦	D07 0800		8		41	36	79	8	◦
D07 0310 062 03		3.1		20	36	62	3	◦	D07 0810 079 08	*	8.1		41	36	79	8	◦
D07 0310	*	3.1		20	36	62	6	◦	D07 0810	*	8.1		47	40	89	10	◦
D07 0320 062 03		3.2		20	36	62	3	◦	D07 0820	*	8.2		47	40	89	10	◦
D07 0320	*	3.2		20	36	62	6	◦	D07 0830	*	8.3		47	40	89	10	◦
D07 0330	*	3.3		20	36	62	6	◦	D07 0840	*	8.4		47	40	89	10	●
D07 0340	*	3.4		20	36	62	6	◦	D07 0850	*	8.5		47	40	89	10	◦
D07 0350	*	3.5		20	36	62	6	◦	D07 0860	*	8.6		47	40	89	10	●
D07 0360	*	3.6		20	36	62	6	◦	D07 0870	*	8.7		47	40	89	10	◦
D07 0370	*	3.7	20	36	62	6	◦	D07 0880	*	8.8	47	40	89	10	◦		
D07 0380	*	3.8	17	24	36	66	6	●	D07 0890	*	8.9	35	47	40	89	10	◦
D07 0390	*	3.9		24	36	66	6	◦	D07 0900	*	9		47	40	89	10	◦
D07 0400 066 04		4		24	36	66	4	●	D07 0910	*	9.1		47	40	89	10	◦
D07 0400	*	4		24	36	66	6	◦	D07 0920	*	9.2		47	40	89	10	◦
D07 0410 066 04		4.1		24	36	66	4	●	D07 0930	*	9.3		47	40	89	10	◦
D07 0410	*	4.1		24	36	66	6	◦	D07 0940	*	9.4		47	40	89	10	◦
D07 0420 066 04		4.2		24	36	66	4	●	D07 0950	*	9.5		47	40	89	10	◦
D07 0420	*	4.2		24	36	66	6	◦	D07 0960	*	9.6		47	40	89	10	◦
D07 0430	*	4.3		24	36	66	6	●	D07 0970	*	9.7		47	40	89	10	◦
D07 0440	*	4.4		24	36	66	6	◦	D07 0980	*	9.8		47	40	89	10	◦
D07 0450	*	4.5	24	36	66	6	◦	D07 0990	*	9.9	47	40	89	10	●		
D07 0460	*	4.6	24	36	66	6	◦	D07 1000	*	10	47	40	89	10	◦		
D07 0470	*	4.7	24	36	66	6	◦	D07 1020	*	10.2	55	45	102	12	◦		
D07 0480	*	4.8	28	36	66	6	◦	D07 1050	*	10.5	55	45	102	12	◦		
D07 0490	*	4.9	28	36	66	6	◦	D07 1080	*	10.8	55	45	102	12	●		
D07 0500	*	5	28	36	66	6	●	D07 1100	*	11	55	45	102	12	◦		
D07 0510	*	5.1	28	36	66	6	●	D07 1120	*	11.2	55	45	102	12	●		
D07 0520	*	5.2	28	36	66	6	◦	D07 1130	*	11.3	55	45	102	12	◦		
D07 0530	*	5.3	20	28	36	66	6	●	D07 1150	*	11.5	40	55	45	102	12	◦
D07 0540	*	5.4		28	36	66	6	◦	D07 1180	*	11.8		55	45	102	12	◦
D07 0550	*	5.5		28	36	66	6	◦	D07 1200	*	12		55	45	102	12	◦
D07 0560	*	5.6		28	36	66	6	◦	D07 1220	*	12.2		60	45	107	14	◦
D07 0570	*	5.7		28	36	66	6	◦	D07 1250	*	12.5		60	45	107	14	◦
D07 0580	*	5.8		28	36	66	6	◦	D07 1270	*	12.7		60	45	107	14	◦
D07 0590	*	5.9		28	36	66	6	●	D07 1280	*	12.8		60	45	107	14	◦
D07 0600	*	6		28	36	66	6	◦	D07 1300	*	13		60	45	107	14	◦
D07 0610 066 06	*	6.1		28	36	66	6	◦	D07 1330	*	13.3		60	45	107	14	◦
D07 0610	*	6.1		34	36	79	8	◦	D07 1350	*	13.5		60	45	107	14	◦
D07 0620	*	6.2	24	34	36	79	8	◦	D07 1370	*	13.7	45	60	45	107	14	◦
D07 0630	*	6.3		34	36	79	8	◦	D07 1380	*	13.8		60	45	107	14	●
D07 0640	*	6.4		34	36	79	8	●	D07 1400	*	14		60	45	107	14	◦
D07 0650	*	6.5		34	36	79	8	◦	D07 1450	*	14.5		65	48	115	16	◦
D07 0660	*	6.6		34	36	79	8	◦	D07 1500	*	15		65	48	115	16	◦
D07 0670	*	6.7		34	36	79	8	●	D07 1530	*	15.3		65	48	115	16	◦
D07 0680	*	6.8		34	36	79	8	●	D07 1550	*	15.5		65	48	115	16	◦
D07 0690	*	6.9		34	36	79	8	●	D07 1580	*	15.8		65	48	115	16	◦
D07 0700	*	7		34	36	79	8	◦	D07 1600	*	16		65	48	115	16	◦
D07 0710	*	7.1		41	36	79	8	◦	D07 1650	*	16.5		73	48	123	18	◦
D07 0720	*	7.2	29	41	36	79	8	◦	D07 1700	*	17	51	73	48	123	18	◦
D07 0730	*	7.3		41	36	79	8	◦	D07 1750	*	17.5		73	48	123	18	◦
D07 0740	*	7.4		41	36	79	8	●	D07 1800	*	18		73	48	123	18	◦
D07 0750	*	7.5		41	36	79	8	◦	D07 1850	*	18.5		79	50	131	20	◦
D07 0760	*	7.6		41	36	79	8	●	D07 1900	*	19		79	50	131	20	◦
D07 0770	*	7.7		41	36	79	8	◦	D07 1950	*	19.5		79	50	131	20	◦
D07 0780	*	7.8		41	36	79	8	◦	D07 2000	*	20		79	50	131	20	◦

* - DIN 6535

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

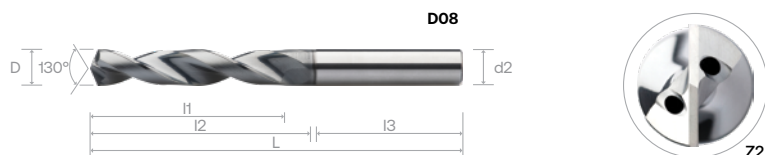
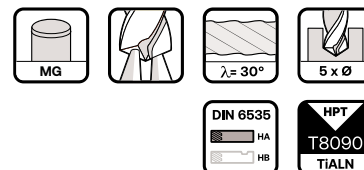
Cutting Parameter

N01 N02 N03 K01 K02 P01 P02 P03 M01 M02 S01 S02 S03 H01 H02 O01 O02

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DR NITICO OIL FEED TWIST DRILLS - DIN 6537L - 130° POINT ANGLE - 5 X Ø

- | | |
|--|---|
|  | VHM DR ALU Kühlkanalbohrer nach DIN 6537L, 130° Spitzenwinkel, Schaft nach DIN 6535HA |
|  | Punte elicoidali DR ALU a norma DIN 6537L- 5 x Ø, con foro di lubrificazione, angolo di punta 130°, codolo DIN 6535HA |
|  | Forets hélicoïdaux DR ALU à trous d'huile selon DIN 6537L - 5 x Ø, angle de pointe 130°, queue selon DIN 6535HA |
|  | 整体硬质合金 DR ALU 系列 内冷孔钻头-相等于DIN6537L 2刃-加工深度5xD, 柄部标准DIN6535HA, 顶角130° |



Order Number	DIN 6535	Dimension (mm)						T8090	Order Number	DIN 6535	Dimension (mm)						T8090
		D (m7)	I1	I2	I3	L	d2 (h6)				D (m7)	I1	I2	I3	L	d2 (h6)	
D08 0300 062 03		3	23	28	36	66	3	◦	D08 0790	*	7.9	43	53	36	91	8	◦
D08 0300	*	3		28	36	66	6	●	D08 0800	*	8		53	36	91	8	●
D08 0310 062 03		3.1		28	36	66	3	◦	D08 0810 079 08	*	8.1		53	36	91	8	◦
D08 0310	*	3.1		28	36	66	6	●	D08 0810	*	8.1		61	40	103	10	◦
D08 0320 062 03		3.2		28	36	66	3	◦	D08 0820	*	8.2		61	40	103	10	◦
D08 0320	*	3.2		28	36	66	6	◦	D08 0830	*	8.3		61	40	103	10	◦
D08 0330	*	3.3		28	36	66	6	●	D08 0840	*	8.4		61	40	103	10	◦
D08 0340	*	3.4		28	36	66	6	●	D08 0850	*	8.5		61	40	103	10	◦
D08 0350	*	3.5		28	36	66	6	●	D08 0860	*	8.6		61	40	103	10	●
D08 0360	*	3.6		28	36	66	6	◦	D08 0870	*	8.7		61	40	103	10	◦
D08 0370	*	3.7	28	36	66	6	◦	D08 0880	*	8.8	61	40	103	10	◦		
D08 0380	*	3.8	29	36	36	74	6	◦	D08 0890	*	8.9	49	61	40	103	10	◦
D08 0390	*	3.9		36	36	74	6	◦	D08 0900	*	9		61	40	103	10	●
D08 0400 066 04		4		36	36	74	4	◦	D08 0910	*	9.1		61	40	103	10	◦
D08 0400	*	4		36	36	74	6	●	D08 0920	*	9.2		61	40	103	10	◦
D08 0410 066 04		4.1		36	36	74	4	◦	D08 0930	*	9.3		61	40	103	10	◦
D08 0410	*	4.1		36	36	74	6	●	D08 0940	*	9.4		61	40	103	10	◦
D08 0420 066 04		4.2		36	36	74	4	◦	D08 0950	*	9.5		61	40	103	10	●
D08 0420	*	4.2		36	36	74	6	◦	D08 0960	*	9.6		61	40	103	10	●
D08 0430	*	4.3		36	36	74	6	●	D08 0970	*	9.7		61	40	103	10	◦
D08 0440	*	4.4		36	36	74	6	◦	D08 0980	*	9.8		61	40	103	10	◦
D08 0450	*	4.5	36	36	74	6	◦	D08 0990	*	9.9	61	40	103	10	◦		
D08 0460	*	4.6	36	36	74	6	●	D08 1000	*	10	61	40	103	10	●		
D08 0470	*	4.7	36	36	74	6	●	D08 1020	*	10.2	71	45	118	12	◦		
D08 0480	*	4.8	44	36	82	6	◦	D08 1050	*	10.5	71	45	118	12	◦		
D08 0490	*	4.9	44	36	82	6	◦	D08 1080	*	10.8	71	45	118	12	◦		
D08 0500	*	5	44	36	82	6	●	D08 1100	*	11	71	45	118	12	◦		
D08 0510	*	5.1	44	36	82	6	●	D08 1120	*	11.2	71	45	118	12	●		
D08 0520	*	5.2	44	36	82	6	●	D08 1130	*	11.3	71	45	118	12	●		
D08 0530	*	5.3	44	36	82	6	●	D08 1150	*	11.5	71	45	118	12	●		
D08 0540	*	5.4	44	36	82	6	◦	D08 1180	*	11.8	71	45	118	12	◦		
D08 0550	*	5.5	44	36	82	6	◦	D08 1200	*	12	71	45	118	12	●		
D08 0560	*	5.6	44	36	82	6	●	D08 1220	*	12.2	77	45	124	14	◦		
D08 0570	*	5.7	44	36	82	6	◦	D08 1250	*	12.5	77	45	124	14	◦		
D08 0580	*	5.8	44	36	82	6	◦	D08 1270	*	12.7	77	45	124	14	◦		
D08 0590	*	5.9	44	36	82	6	◦	D08 1280	*	12.8	77	45	124	14	◦		
D08 0600	*	6	44	36	82	6	●	D08 1300	*	13	77	45	124	14	●		
D08 0610 066 06	*	6.1	44	36	82	6	◦	D08 1330	*	13.3	77	45	124	14	◦		
D08 0610	*	6.1	53	36	91	8	◦	D08 1350	*	13.5	77	45	124	14	●		
D08 0620	*	6.2	53	36	91	8	●	D08 1370	*	13.7	77	45	124	14	◦		
D08 0630	*	6.3	53	36	91	8	◦	D08 1380	*	13.8	77	45	124	14	◦		
D08 0640	*	6.4	53	36	91	8	◦	D08 1400	*	14	77	45	124	14	●		
D08 0650	*	6.5	53	36	91	8	●	D08 1450	*	14.5	63	83	48	133	16	◦	
D08 0660	*	6.6	53	36	91	8	◦	D08 1500	*	15		83	48	133	16	◦	
D08 0670	*	6.7	53	36	91	8	◦	D08 1530	*	15.3		83	48	133	16	◦	
D08 0680	*	6.8	53	36	91	8	◦	D08 1550	*	15.5		83	48	133	16	◦	
D08 0690	*	6.9	53	36	91	8	●	D08 1580	*	15.8		83	48	133	16	◦	
D08 0700	*	7	53	36	91	8	◦	D08 1600	*	16	83	48	133	16	◦		
D08 0710	*	7.1	53	36	91	8	◦	D08 1650	*	16.5	71	93	48	143	18	◦	
D08 0720	*	7.2	53	36	91	8	◦	D08 1700	*	17		93	48	143	18	◦	
D08 0730	*	7.3	53	36	91	8	◦	D08 1750	*	17.5		93	48	143	18	◦	
D08 0740	*	7.4	53	36	91	8	◦	D08 1800	*	18	93	48	143	18	◦		
D08 0750	*	7.5	53	36	91	8	◦	D08 1850	*	18.5	77	101	50	153	20	◦	
D08 0760	*	7.6	53	36	91	8	◦	D08 1900	*	19		101	50	153	20	◦	
D08 0770	*	7.7	53	36	91	8	◦	D08 1950	*	19.5		101	50	153	20	◦	
D08 0780	*	7.8	53	36	91	8	◦	D08 2000	*	20		101	50	153	20	◦	

* - DIN 6535

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

N01 N02 N03 K01 K02 P01 P02 P03 M01 M02 S01 S02 S03 H01 H02 O01 O02

Cutting Parameter

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Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



DR NiTiCo Oil Feed Twist Drills, 3xD & 5xD, 2 Flutes - D07, D08

Drilling	M		S	
Working Material	Stainless Steel		Titanium Alloy	
Properties	High Machinability		-	
D	Vc	fn	Vc	fn
3	65	0.045	40	0.063
4		0.067		0.080
5		0.086		0.080
6		0.110		0.100
7		0.130		0.113
8		0.160		0.125
9		0.175		0.143
10		0.195		0.160
11		0.220		0.160
12		0.245		0.160
13		0.255		0.170
14		0.272		0.180
15		0.285		0.190
16		0.310		0.200
17		0.315		0.213
18		0.330		0.226
19		0.330		0.239
20		0.330		0.250