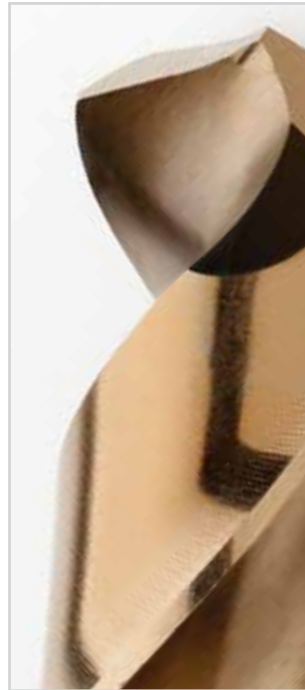


The Right Tool at the Right Time



High performance **Stub Drill**
For Stainless Steel



YOUR TRUSTED PARTNER SINCE 1913

Features & Benefits

Material

- Manufactured from a Cobalt-based HSS-E (M35), a premium grade of high speed tool steel, heat treated to surpass the hardness of other HSS materials.
- The Cobalt content helps retain hardness at increased temperatures, an ideal choice for machining stainless steel and temperature resistant alloys.
- The composition of M35 provides an excellent combination of hardness and toughness, resulting in a very strong wear resistant grade.

Geometry

- The A620 point geometry combines continuous relief grinding and chisel thinning
- This combination reduces the thrust forces when drilling and is particularly advantageous when drilling materials that resist cutting and create high temperatures, such as stainless steels
- The chisel style and geometry also provides very good centering qualities eliminating pre-centering in most drilling applications

Recommendations

Particularly suited to machine applications when drilling stainless steels and steels.

Range

DIN 1897: Available from Ø2,5 – Ø13,0 mm

Customer benefits

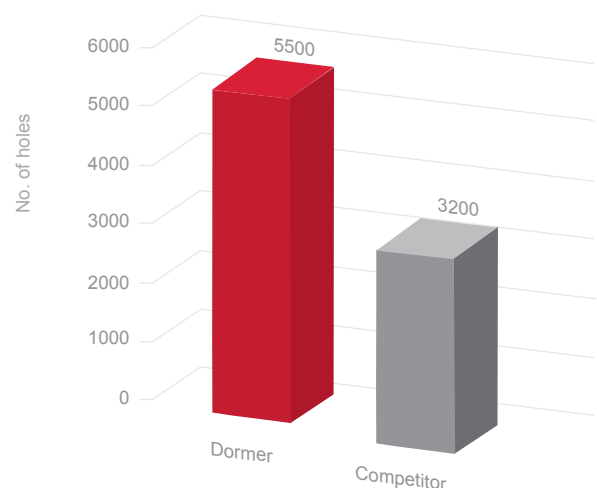
- Combination of material and geometry deliver superior performance and tool life when drilling stainless steels
- Low thrust forces promote longer tool life and reduced spindle forces
- Excellent self centering capabilities improve all aspects of hole quality and positional accuracy

Dormer A620 Point



Continuous relief grinding with thinning

A620 - Holes Drilled in 304 Stainless Steel



Application

Material Groups

- Excellent for Application
- Good for Application

Example

10 = Peripheral speed in metres/minute +/- 10%

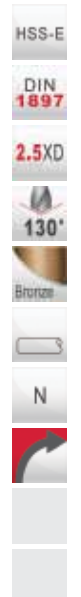


HSS-E

$$n = \frac{V_c \times 1000}{\pi \times D}$$

$$V_f = n \times f_n$$

Ø(D)	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
C	0.032	0.044	0.050	0.056	0.064	0.080	0.098	0.110
D	0.038	0.053	0.060	0.068	0.078	0.098	0.119	0.130
E	0.043	0.062	0.071	0.080	0.092	0.115	0.140	0.150
F	0.050	0.073	0.084	0.095	0.109	0.138	0.165	0.178
G	0.056	0.084	0.096	0.109	0.126	0.160	0.190	0.205
H	0.066	0.102	0.116	0.130	0.150	0.190	0.228	0.243
I	0.076	0.119	0.134	0.150	0.173	0.220	0.265	0.280
J	0.084	0.135	0.152	0.170	0.197	0.250	0.298	0.315
K	0.092	0.150	0.170	0.190	0.220	0.280	0.330	0.350
L	0.101	0.165	0.186	0.208	0.240	0.305	0.360	0.385



A620

2.50 - 13.00

Application Material Group			Hardness HB	Tensile strength N/mm ²	NEW
1. Steel	1.1	Magnetic soft steel	< 120	< 400	■ 38K
	1.2	Structural steel, case carburizing steel	< 200	< 700	■ 33H
	1.3	Plain Carbon steel	< 250	< 850	■ 30G
	1.4	Alloy steel	< 250	< 850	■ 27G
	1.5	Alloy steel, Hardened and tempered steel	> 250 < 350	> 850 < 1200	■ 18F
	1.6	Alloy steel, Hardened and tempered steel	> 350	> 1200 < 1620	■ 11E
	1.7	Alloy steel, Heat treated	49-55 HRc	> 1620	
	1.8	Alloy steel, Hardened & Wear resistant steel	55-63 HRc	> 1980	
2. Stainless Steel	2.1	Free machining, Stainless Steel	< 250	< 850	■ 22F
	2.2	Austenitic	< 250	< 850	■ 11H
	2.3	Ferritic + Austenitic, Ferritic, Martensitic	< 300	< 1000	■ 15D
	2.4	Precipitation Hardened	< 320 < 410	> 1100 < 1400	
3. Cast Iron	3.1	Lamellar graphite	> 150	> 500	■ 34K
	3.2	Lamellar graphite	> 150 ≤ 300	> 500 < 1000	■ 30F
	3.3	Nodular graphite, Malleable Cast Iron	< 200	< 700	■ 22F
	3.4	Nodular graphite, Malleable Cast Iron	> 200 < 300	> 700 < 1000	■ 17F
4. Titanium	4.1	Titanium, unalloyed	< 200	< 700	■ 30G
	4.2	Titanium, alloyed	< 270	< 900	■ 18F
	4.3	Titanium, alloyed	> 270 < 350	> 900 ≤ 1250	■ 10C
5. Nickel	5.1	Nickel, unalloyed	< 150	< 500	■ 15H
	5.2	Nickel, alloyed	> 270	> 900	■ 9F
	5.3	Nickel, alloyed	> 270 < 350	> 900 < 1200	■ 6C
6. Copper	6.1	Copper	< 100	< 350	■ 38I
	6.2	β-Brass, Bronze	< 200	< 700	■ 40K
	6.3	α-Brass	< 200	< 700	■ 27J
	6.4	High Strength Bronze	< 470	< 1500	■ 16I
7. Aluminium Magnesium	7.1	Al, Mg, unalloyed	< 100	< 350	■ 40K
	7.2	Al alloyed, Si < 0.5%	< 150	< 500	■ 35J
	7.3	Al alloyed, Si > 0.5% < 10%	< 120	< 400	■ 32I
	7.4	Al alloyed, Si > 10% Whisker reinforced Al-alloys Mg-alloys	< 120	< 400	■ 30G
8. Synthetic materials	8.1	Thermoplastics	---	---	■ 40L
	8.2	Thermosetting plastics	---	---	■ 32K
	8.3	Reinforced plastic materials	---	---	■ 18I
9. Hard material	9.1	Cermets (metals-ceramics)	< 550	< 1700	
10. Graphite	10.1	Graphite	---	< 100	

A620



- Stub Drill
- Spiralbohrer, kurz
- Extra korte spiraalboor
- Foret extra-court
- Broca extra corta
- Broca Extra Curta

A620

A620	■	2.1	2.2	2.3																	
	■	1.1	1.2	1.3	1.4	1.5	1.6	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4
		7.1	7.2	7.3	7.4	8.1	8.2	8.3													



d ₁ Ø mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	A620
2.50	0.0984	14	43	A6202.5
2.60	0.1024	14	43	A6202.6
2.70	0.1063	16	46	A6202.7
2.80	0.1102	16	46	A6202.8
2.90	0.1142	16	46	A6202.9
3.00	0.1181	16	46	A6203.0
3.10	0.1220	18	49	A6203.1
3.20	0.1260	18	49	A6203.2
3.30	0.1299	18	49	A6203.3
3.40	0.1339	20	52	A6203.4
3.50	0.1378	20	52	A6203.5
3.60	0.1417	20	52	A6203.6
3.70	0.1457	20	52	A6203.7
3.80	0.1496	22	55	A6203.8
3.90	0.1535	22	55	A6203.9
4.00	0.1575	22	55	A6204.0
4.10	0.1614	22	55	A6204.1
4.20	0.1654	22	55	A6204.2
4.30	0.1693	24	58	A6204.3
4.40	0.1732	24	58	A6204.4
4.50	0.1772	24	58	A6204.5
4.60	0.1811	24	58	A6204.6
4.70	0.1850	24	58	A6204.7
4.80	0.1890	26	62	A6204.8
4.90	0.1929	26	62	A6204.9
5.00	0.1969	26	62	A6205.0
5.10	0.2008	26	62	A6205.1
5.20	0.2047	26	62	A6205.2
5.30	0.2087	26	62	A6205.3
5.40	0.2126	28	66	A6205.4
5.50	0.2165	28	66	A6205.5
5.60	0.2205	28	66	A6205.6
5.70	0.2244	28	66	A6205.7
5.80	0.2283	28	66	A6205.8
5.90	0.2323	28	66	A6205.9
6.00	0.2362	28	66	A6206.0

d₁ ∅ mm	d₁ decimal Inch	l₂ mm	l₁ mm	A620
6.10	0.2402	31	70	A6206.1
6.20	0.2441	31	70	A6206.2
6.30	0.2480	31	70	A6206.3
6.40	0.2520	31	70	A6206.4
6.50	0.2559	31	70	A6206.5
6.60	0.2598	31	70	A6206.6
6.70	0.2638	31	70	A6206.7
6.80	0.2677	34	74	A6206.8
6.90	0.2717	34	74	A6206.9
7.00	0.2756	34	74	A6207.0
7.10	0.2795	34	74	A6207.1
7.20	0.2835	34	74	A6207.2
7.30	0.2874	34	74	A6207.3
7.40	0.2913	34	74	A6207.4
7.50	0.2953	34	74	A6207.5
7.60	0.2992	37	79	A6207.6
7.70	0.3031	37	79	A6207.7
7.80	0.3071	37	79	A6207.8
7.90	0.3110	37	79	A6207.9
8.00	0.3150	37	79	A6208.0
8.10	0.3189	37	79	A6208.1
8.20	0.3228	37	79	A6208.2
8.30	0.3268	37	79	A6208.3
8.40	0.3307	37	79	A6208.4
8.50	0.3346	37	79	A6208.5
8.60	0.3386	40	84	A6208.6
8.70	0.3425	40	84	A6208.7
8.80	0.3465	40	84	A6208.8
8.90	0.3504	40	84	A6208.9
9.00	0.3543	40	84	A6209.0
9.10	0.3583	40	84	A6209.1
9.20	0.3622	40	84	A6209.2
9.30	0.3661	40	84	A6209.3
9.40	0.3701	40	84	A6209.4
9.50	0.3740	40	84	A6209.5
9.60	0.3780	43	89	A6209.6
9.70	0.3819	43	89	A6209.7
9.80	0.3858	43	89	A6209.8
9.90	0.3898	43	89	A6209.9
10.00	0.3937	43	89	A62010.0
10.20	0.4016	43	89	A62010.2
10.50	0.4134	43	89	A62010.5
10.80	0.4252	47	95	A62010.8
11.00	0.4331	47	95	A62011.0
11.50	0.4528	47	95	A62011.5
12.00	0.4724	51	102	A62012.0
12.20	0.4803	51	102	A62012.2
12.50	0.4921	51	102	A62012.5
12.80	0.5039	51	102	A62012.8
13.00	0.5118	51	102	A62013.0



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