

**DORMER**

The Right Tool at the Right Time



# A002 Goes Solo

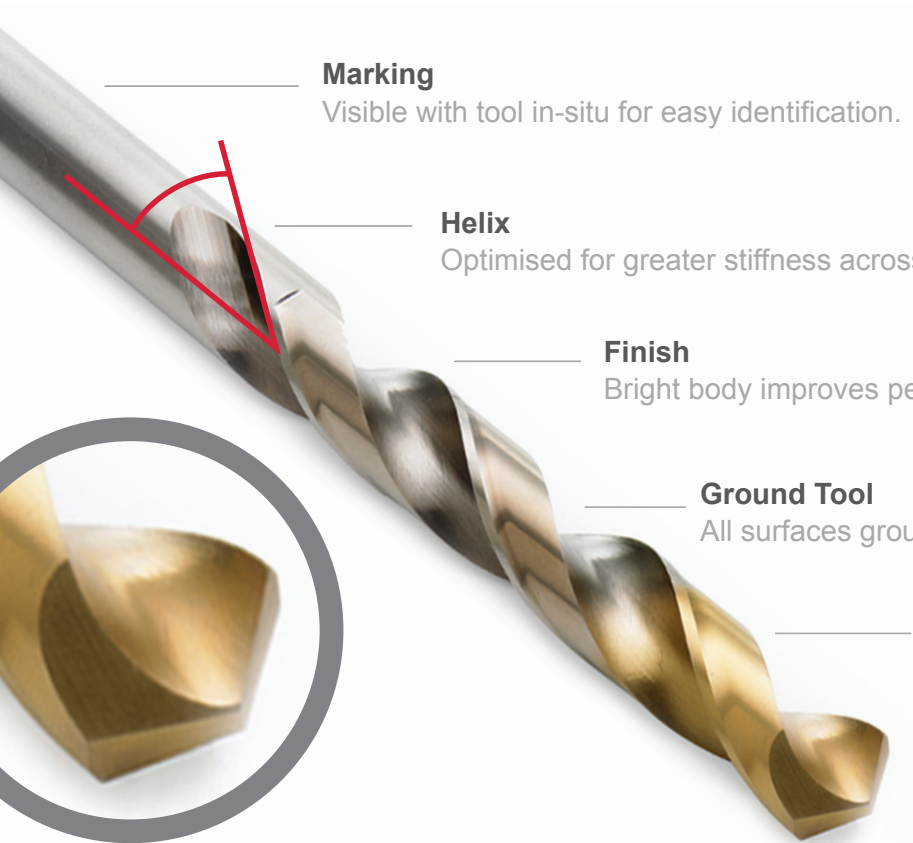
*Multi-purpose HSS drills to DIN 338  
now available in pouch packs*

# A002S Pouch Pack

Dormer's renowned A002 TiN tipped jobber drill is now available to purchase in a pouch pack. Shown below, this provides protection for the drill whilst also enabling easy display and stand mounting via the incorporated euro-slot.

Each pouch pack details key features of the drill, including depth capability, point geometry, material suitability and thread size (if used as a tapping drill).

## Features & Benefits



### Marking

Visible with tool in-situ for easy identification.

### Helix

Optimised for greater stiffness across diameter range.

### Finish

Bright body improves performance on ductile materials.

### Ground Tool

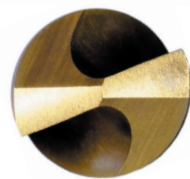
All surfaces ground for consistent precision.

### Coating

Titanium nitride resists flank and crater wear and has low friction, promoting increased cutting speeds

### Point Design

Efficient cutting action, reduced axial force, accurate centering



### Web Design

Optimised strength and rigidity, easy to feed.

### Range

2.0-5.0mm, 1/8-3/16 Inch: 2 drills/pack  
5.5-13.0mm, 13/64-1/2 Inch: 1 drill/pack

### Flutes

Improved flute geometry for efficient chip form and evacuation.

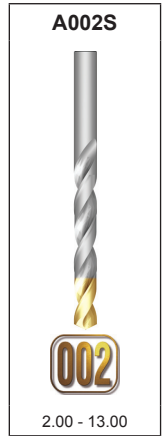
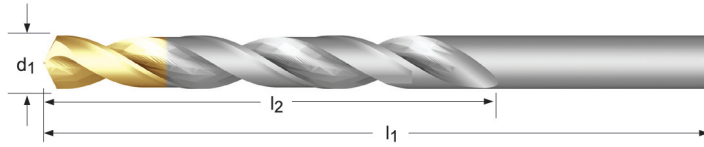


A002S

A002S

- 002 Jobber Drill - Pouch Pack
- 002 Spiralbohrer - Einzelverpackung
- 002 Korte spiraalboren in DHZ blisterverpakking
- 002 Foret court en Blister
- Broca 002, serie corta en blister
- Broca 002, Curta, em embalagem

- TiN Tipped and Split Point
- TiN-Tip beschichtet mit Kreuzanschliff
- TiN-Tip gecoat met Kruijslijping
- TiN en pointe et affutage en croix
- Punta de TiN y rectificado de la punta
- Ponta TiN e afiamento em cruz



d <sub>1</sub> Ø <sub>h</sub> Inch	d <sub>1</sub> Ø <sub>h</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	A002S	d <sub>1</sub> Ø <sub>h</sub> Inch	d <sub>1</sub> Ø <sub>h</sub> mm	d <sub>1</sub> decimal Inch	l <sub>2</sub> mm	l <sub>1</sub> mm	A002S
	2.00	0.0787	24	49	A002S2.0 *	17/64	6.75	0.2657	69	109	A002S17/64
	2.50	0.0984	30	57	A002S2.5 *		6.80	0.2677	69	109	A002S6.8
	3.00	0.1181	33	61	A002S3.0 *		7.00	0.2756	69	109	A002S7.0
1/8	3.18	0.1252	36	65	A002S1/8 *		7.50	0.2953	69	109	A002S7.5
	3.20	0.1260	36	65	A002S3.2 *	5/16	7.94	0.3126	75	117	A002S5/16
	3.30	0.1299	36	65	A002S3.3 *		8.00	0.3150	75	117	A002S8.0
	3.50	0.1378	39	70	A002S3.5 *		8.20	0.3228	75	117	A002S8.2
5/32	3.97	0.1563	43	75	A002S5/32 *		8.50	0.3346	75	117	A002S8.5
	4.00	0.1575	43	75	A002S4.0 *		9.00	0.3543	81	125	A002S9.0
	4.10	0.1614	43	75	A002S4.1 *		9.50	0.3740	81	125	A002S9.5
	4.20	0.1654	43	75	A002S4.2 *	3/8	9.52	0.3748	87	133	A002S3/8
	4.50	0.1772	47	80	A002S4.5 *		10.00	0.3937	87	133	A002S10.0
3/16	4.76	0.1874	52	86	A002S3/16 *		10.20	0.4016	87	133	A002S10.2
	5.00	0.1969	52	86	A002S5.0 *		10.50	0.4134	87	133	A002S10.5
13/64	5.16	0.2031	52	86	A002S13/64		11.00	0.4331	94	142	A002S11.0
	5.50	0.2165	57	93	A002S5.5		11.50	0.4528	94	142	A002S11.5
7/32	5.56	0.2189	57	93	A002S7/32		12.00	0.4724	101	151	A002S12.0
	6.00	0.2362	57	93	A002S6.0		12.50	0.4921	101	151	A002S12.5
1/4	6.35	0.2500	63	101	A002S1/4	1/2	12.70	0.5000	101	151	A002S1/2
	6.50	0.2559	63	101	A002S6.5		13.00	0.5118	101	151	A002S13.0

\* Two per pack; 2 Stück pro Packung; Twee in DHZ blisterverpakking; Deux par blister; 2 por blister; Duas por embalagem

Application Material Group		Hardness HB	Tensile strength N/mm <sup>2</sup>	NEW
1. Steel	1.1 Magnetic soft steel	< 120	< 400	■47J
	1.2 Structural steel, case carburizing steel	< 200	< 700	■40J
	1.3 Plain Carbon steel	< 250	< 850	■35F
	1.4 Alloy steel	< 250	< 850	■30F
	1.5 Alloy steel, Hardened and tempered steel	> 250 < 350	> 850 < 1200	●18F
	1.6 Alloy steel, Hardened and tempered steel	> 350	> 1200 < 1620	●10E
	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	●20F
	2.2 Austenitic	< 250	< 1100	●12G
	2.3 Ferritic + Austenitic, Ferritic, Martensitic	< 300	< 1000	●16C
	2.4 Precipitation Hardened	> 320 < 410	> 1100 < 1400	
3. Cast Iron	3.1 Lamellar graphite	< 150	< 500	■40J
	3.2 Lamellar graphite	> 150 ≤ 300	> 500 ≤ 1000	■30E
	3.3 Nodular graphite, Malleable Cast Iron	< 200	< 700	●28E
	3.4 Nodular graphite, Malleable Cast Iron	> 200 < 300	> 700 < 1000	●26E
4. Titanium	4.1 Titanium, unalloyed	< 200	< 700	●23F
	4.2 Titanium, alloyed	< 270	< 900	●13D
	4.3 Titanium, alloyed	> 270 < 350	> 900 ≤ 1250	●7B
5. Nickel	5.1 Nickel, unalloyed	< 150	< 500	●13G
	5.2 Nickel, alloyed	< 270	< 900	●7E
	5.3 Nickel, alloyed	> 270 < 350	> 900 < 1200	●3A
6. Copper	6.1 Copper	< 100	< 350	●50G
	6.2 β-Brass, Bronze	< 200	< 700	●33I
	6.3 α-Brass	< 200	< 700	●39H
	6.4 High Strength Bronze	< 470	< 1500	●30G
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	< 100	< 350	■41K
	7.2 Al alloyed, Si < 0.5%	< 150	< 500	■38J
	7.3 Al alloyed, Si > 0.5% < 10%	< 120	< 400	●33I
	7.4 Al alloyed, Si > 10% Whisker reinforced Al-alloys Mg-alloys	< 120	< 400	●33I
8. Synthetic materials	8.1 Thermoplastics	---	---	■30I
	8.2 Thermosetting plastics	---	---	■50H
	8.3 Reinforced plastic materials	---	---	●35F
9. Hard material	9.1 Cermets (metals-ceramics)	< 550	< 1700	●3B
10. Graphite	10.1 Graphite	---	< 100	

- Excellent for Application
- Good for Application

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

$$Vf = n \times f_n$$



Ø(D)	2mm	3mm	4mm	5mm
A	0.023	0.029	0.032	0.036
B	0.028	0.037	0.041	0.046
C	0.032	0.044	0.050	0.056
D	0.038	0.053	0.060	0.068
E	0.043	0.062	0.071	0.080
F	0.050	0.073	0.084	0.095
G	0.056	0.084	0.096	0.109
H	0.066	0.102	0.116	0.130
I	0.076	0.119	0.134	0.150
K	0.092	0.150	0.170	0.190

Ø(D)	6mm	8mm	10mm	12mm
A	0.042	0.054	0.062	0.069
B	0.053	0.067	0.080	0.090
C	0.064	0.080	0.098	0.110
D	0.078	0.098	0.119	0.130
E	0.092	0.115	0.140	0.150
F	0.109	0.138	0.165	0.178
G	0.126	0.160	0.190	0.205
H	0.150	0.190	0.228	0.243
I	0.173	0.220	0.265	0.280
K	0.220	0.280	0.330	0.350



## New Dormer Product Selector Now available online



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