



Indexable Drills

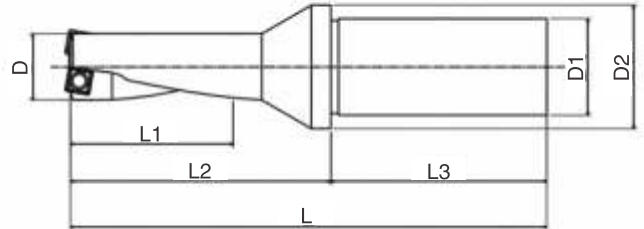
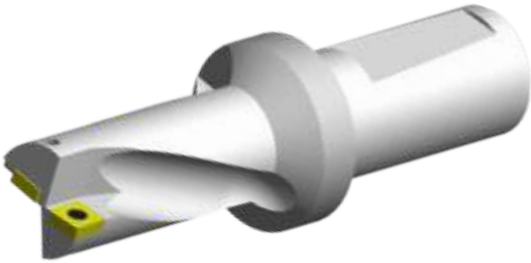


Indexable Drills

Indexable Drills L/D- 2	209
Indexable Drills L/D- 3	210
Indexable Drills L/D- 4	211
Indexable Drills L/D- 5	212
Drills Inserts	213
Recommended cutting Parameters	214

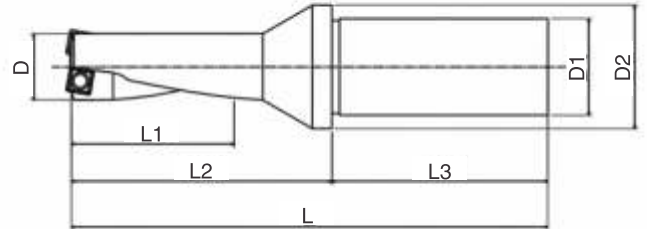
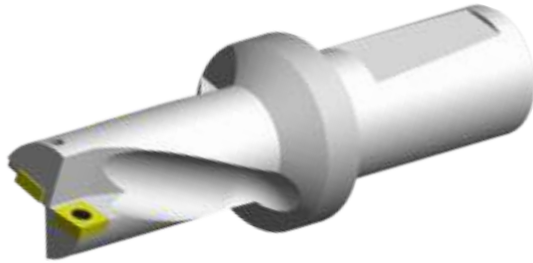
Indexable Drills

Drilling Depth 2 x Diameter



Product Code	Dimensions in (mm)							Suitable Insert
	D	D1	D2	L1	L2	L3	L	
S-2DR130-20SH-05	13,0	20	24	26	44	50	94	SPGX 050204
S-2DR135-20SH-05	13,5	20	24	27	45	50	95	
S-2DR140-20SH-05	14,0	20	24	28	46	50	96	
S-2DR145-20SH-05	14,5	20	24	29	47	50	97	
S-2DR150-20SH-05	15,0	20	24	30	48	50	98	
S-2DR155-20SH-05	15,5	20	24	31	49	50	99	
S-2DR160-25SH-06	16,0	25	31	32	53	56	109	SPGX 060204
S-2DR165-25SH-06	16,5	25	31	33	54	56	110	
S-2DR170-25SH-06	17,0	25	31	34	55	56	111	
S-2DR175-25SH-06	17,5	25	31	35	56	56	112	
S-2DR180-25SH-06	18,0	25	31	36	57	56	113	
S-2DR185-25SH-06	18,5	25	31	37	58	56	114	
S-2DR190-25SH-06	19,0	25	31	38	59	56	115	
S-2DR195-25SH-06	19,5	25	31	39	60	56	116	
S-2DR200-25SH-06	20,0	25	31	40	62	56	118	
S-2DR205-25SH-06	20,5	25	31	41	63	56	119	
S-2DR210-20SH-06	21,0	25	31	42	64	56	120	
S-2DR220-32SH-07	22,0	32	44	44	74	60	134	SPGX 070308
S-2DR230-32SH-07	23,0	32	44	46	76	60	136	
S-2DR235-32SH-07	23,5	32	44	47	77	60	137	
S-2DR240-32SH-07	24,0	32	44	48	78	60	138	
S-2DR245-32SH-07	24,5	32	44	49	79	60	139	
S-2DR250-32SH-07	25,0	32	44	50	80	60	140	
S-2DR260-32SH-07	26,0	32	44	52	82	60	142	
S-2DR265-32SH-07	26,5	32	44	53	83	60	143	
S-2DR270-32SH-07	27,0	32	44	54	84	60	144	
S-2DR280-32SH-09	28,0	32	44	56	86	60	146	SPGX 090408
S-2DR290-32SH-09	29,0	32	44	58	88	60	148	
S-2DR300-32SH-09	30,0	32	54	60	91	60	151	
S-2DR310-32SH-09	31,0	32	54	62	93	60	153	
S-2DR320-32SH-09	32,0	32	54	64	95	60	155	
S-2DR330-32SH-09	33,0	32	54	66	97	60	157	
S-2DR340-32SH-11	34,0	32	54	68	99	60	159	SPMX 110408
S-2DR350-32SH-11	35,0	32	54	70	101	60	161	
S-2DR360-32SH-11	36,0	32	54	72	103	60	163	
S-2DR370-32SH-11	37,0	32	54	74	105	60	165	
S-2DR380-32SH-11	38,0	32	54	76	107	60	167	
S-2DR390-32SH-11	39,0	32	54	78	109	60	169	
S-2DR395-32SH-11	39,5	32	54	79	110	60	170	
S-2DR400-32SH-11	40,0	32	54	80	111	60	171	

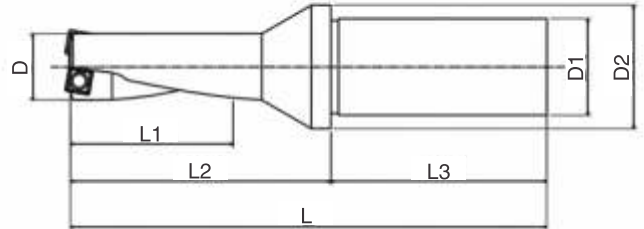
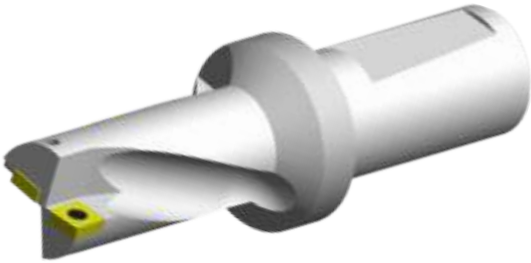
Drilling Depth 3 x Diameter



Product Code	Dimensions in (mm)							Suitable Insert
	D	D1	D2	L1	L2	L3	L	
S-3DR130-20SH-05	13,0	20	25	39	57	50	107	SPGX 050204
S-3DR135-20SH-05	13,5	20	25	40,5	58,5	50	109	
S-3DR140-20SH-05	14,0	20	25	42	60	50	110	
S-3DR145-20SH-05	14,5	20	25	43,5	61,5	50	111,5	
S-3DR150-20SH-05	15,0	20	25	45	63	50	113	
S-3DR155-20SH-05	15,5	20	25	46,5	64,5	50	114,5	
S-3DR160-25SH-06	16,0	25	32	48	69	56	125	SPGX 060204
S-3DR165-25SH-06	16,5	25	32	50	70,5	56	126,5	
S-3DR170-25SH-06	17,0	25	32	51	72	56	128	
S-3DR175-25SH-06	17,5	25	32	52,5	73,5	56	129,5	
S-3DR180-25SH-06	18,0	25	32	54	75	56	131	
S-3DR185-25SH-06	18,5	25	32	55,5	76,5	56	132,5	
S-3DR190-25SH-06	19,0	25	32	57	78	56	134	
S-3DR195-25SH-06	19,5	25	32	58,5	79,5	56	135,5	
S-3DR200-25SH-06	20,0	25	32	60	82	56	138	
S-3DR205-25SH-06	20,5	25	32	61,5	83,5	56	139,5	
S-3DR210-20SH-06	21,0	25	32	63	85	56	141	
S-3DR220-32SH-07	22,0	32	44	66	96	60	156	SPGX 070308
S-3DR225-32SH-07	22,5	32	44	67,5	97,5	60	157,5	
S-3DR230-32SH-07	23,0	32	44	69	99	60	159	
S-3DR235-32SH-07	23,5	32	44	71	101	60	160	
S-3DR240-32SH-07	24,0	32	44	72	102	60	162	
S-3DR245-32SH-07	24,5	32	44	73,5	103,5	60	163,5	
S-3DR250-32SH-07	25,0	32	44	75	105	60	165	
S-3DR260-32SH-07	26,0	32	44	78	108	60	168	
S-3DR265-32SH-07	26,5	32	44	79,5	109,5	60	169,5	
S-3DR270-32SH-07	27,0	32	44	81	111	60	171	
S-3DR280-32SH-09	28,0	32	44	84	114	60	174	SPGX 090408
S-3DR290-32SH-09	29,0	32	44	87	117	60	177	
S-3DR295-32SH-09	29,5	32	54	88,5	118,5	60	178,5	
S-3DR300-32SH-09	30,0	32	54	90	121	60	181	
S-3DR310-32SH-09	31,0	32	54	93	124	60	184	
S-3DR320-32SH-09	32,0	32	54	96	127	60	187	
S-3DR330-32SH-09	33,0	32	54	99	130	60	190	
S-3DR340-32SH-11	34,0	32	54	102	136	60	196	SPGX 110408
S-3DR350-32SH-11	35,0	32	54	105	140	60	200	
S-3DR360-32SH-11	36,0	32	54	108	144	60	204	
S-3DR370-32SH-11	37,0	40	54	111	148	70	218	
S-3DR380-32SH-11	38,0	40	54	114	152	70	222	
S-3DR390-32SH-11	39,0	40	54	117	156	70	226	
S-3DR395-32SH-11	39,5	40	54	118,5	158,0	70	230	
S-3DR400-32SH-11	40,0	40	54	120	160	70	230	

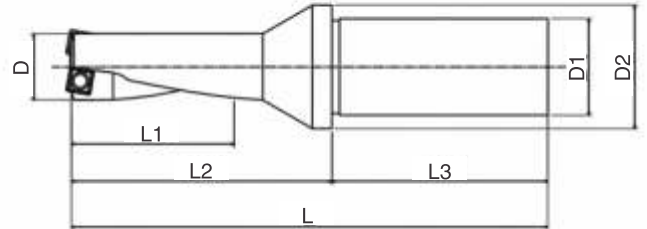
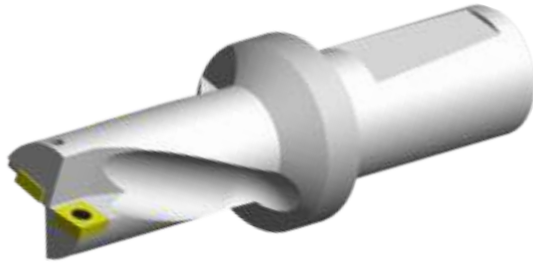
Indexable Drills

Drilling Depth 4 x Diameter



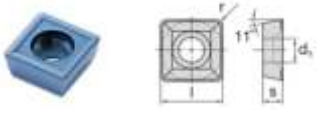
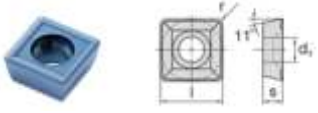
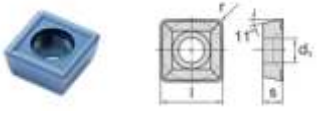
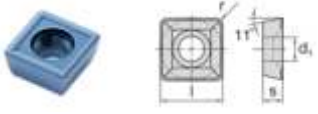
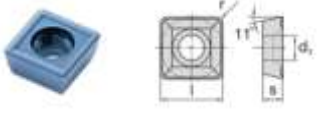
Product Code	Dimensions in (mm)							Suitable Insert
	D	D1	D2	L1	L2	L3	L	
S-4DR130-20SH-05	13,0	20	24	52	70	50	120	SPGX 050204
S-4DR135-20SH-05	13,5	20	24	54	7	50	122	
S-4DR140-20SH-05	14,0	20	24	56	74	50	124	
S-4DR145-20SH-05	14,5	20	24	58	76	50	126	
S-4DR150-20SH-05	15,0	20	24	60	78	50	128	
S-4DR155-20SH-05	15,5	20	24	62	80	50	130	
S-4DR160-25SH-06	16,0	25	31	64	85	56	141	SPGX 060204
S-4DR165-25SH-06	16,5	25	31	66	87,0	56	143,0	
S-4DR170-25SH-06	17,0	25	31	68	89	56	56	
S-4DR175-25SH-06	17,5	25	31	70	91,0	56	147,0	
S-4DR180-25SH-06	18,0	25	31	72	93	56	149	
S-4DR185-25SH-06	18,5	25	31	74	95,0	56	151,0	
S-4DR190-25SH-06	19,0	25	31	76	97	56	153	
S-4DR195-25SH-06	19,5	25	31	78	99,0	56	155,0	
S-4DR200-25SH-06	20,0	25	31	80	102	56	158	
S-4DR205-25SH-06	20,5	25	31	82	104,0	56	160,0	
S-4DR210-20SH-06	21,0	25	31	84	106	56	162	
S-4DR220-32SH-07	22,0	32	45	88	118	60	178	SPGX 07T308
S-4DR225-32SH-07	22,5	32	45	90	120	60	180	
S-4DR230-32SH-07	23,0	32	45	92	122	60	182	
S-4DR235-32SH-07	23,5	32	45	94	124,0	60	184,0	
S-4DR240-32SH-07	24,0	32	45	96	124	60	184	
S-4DR245-32SH-07	24,5	32	45	98	126	60	186	
S-4DR250-32SH-07	25,0	32	45	100	130	60	190	
S-4DR260-32SH-07	26,0	32	45	104	134	60	194	
S-4DR265-32SH-07	26,5	32	45	106	136,1	60	196	
S-4DR270-32SH-07	27,0	32	45	108	138	60	198	
S-4DR280-32SH-09	28,0	32	45	112	142	60	202	SPGX 090408
S-4DR290-32SH-09	29,0	32	45	116	146	60	206	
S-4DR295-32SH-09	29,5	32	55	118	149	60	209	
S-4DR300-32SH-09	30,0	32	55	120	151	60	211	
S-4DR310-32SH-09	31,0	32	55	124	155	60	215	
S-4DR320-32SH-09	32,0	32	55	128	159	60	219	
S-4DR330-32SH-09	33,0	32	55	132	163	60	223	
S-4DR340-32SH-11	34,0	32	54	136	170,1	60	230	SPGX 110408
S-4DR350-32SH-11	35,0	32	54	140	175	60	235	
S-4DR360-32SH-11	36,0	32	54	144	180	60	240	
S-4DR370-32SH-11	37,0	32	54	148	185	60	245	
S-4DR380-32SH-11	38,0	32	54	152	190	60	250	
S-4DR390-32SH-11	39,0	32	54	156	195	60	255	
S-4DR395-32SH-11	39,5	32	54	158	197,0	60	257,0	
S-4DR400-32SH-11	40,0	32	54	160	200	60	260	

Drilling Depth 5 x Diameter



Product Code	Dimensions in (mm)							Suitable Insert
	D	D1	D2	L1	L2	L3	L	
S-5DR130-20SH-05	13,0	20	24	65	83	50	133	SPGX 050204
S-5DR135-20SH-05	13,5	20	24	67,5	85,5	50	135,5	
S-5DR140-20SH-05	14,0	20	24	70	88	50	138	
S-5DR145-20SH-05	14,5	20	24	72,5	90,5	50	140,5	
S-5DR150-20SH-05	15,0	20	24	75	93	50	143	
S-5DR155-20SH-05	15,5	20	24	77,5	95,5	50	145,5	
S-5DR160-25SH-06	16,0	25	31	80	101	56	157	SPGX 060204
S-5DR165-25SH-06	16,5	25	31	82,5	103,5	56	159,5	
S-5DR170-25SH-06	17,0	25	31	85	106	56	162	
S-5DR175-25SH-06	17,5	25	31	87,5	108,5	56	164,5	
S-5DR180-25SH-06	18,0	25	31	90	111	56	167	
S-5DR185-25SH-06	18,5	25	31	82,5	112,5	56	168,5	
S-5DR190-25SH-06	19,0	25	31	95	116	56	172	
S-5DR195-25SH-06	19,5	25	31	97,5	118,5	56	174,5	
S-5DR200-25SH-06	20,0	25	31	100	122	56	178	
S-5DR205-25SH-06	20,5	25	31	102,5	124,5	56	180,5	
S-5DR210-20SH-06	21,0	25	31	105	127	56	183	
S-5DR220-32SH-07	22,0	32	44	110	140	60	200	SPGX 07T308
S-5DR225-32SH-07	22,5	32	44	113	143	60	203	
S-5DR230-32SH-07	23,0	32	44	115	145	60	205	
S-5DR235-32SH-07	35,5	32	44	117,5	147,5	60	207,5	
S-5DR240-32SH-07	24,0	32	44	120	150	60	210	
S-5DR245-32SH-07	24,5	32	44	123	158	60	218	
S-5DR250-32SH-07	25,0	32	44	125	155	60	215	
S-5DR260-32SH-07	26,0	32	44	130	160	60	220	
S-5DR265-32SH-07	26,5	32	44	133	163	60	223	
S-5DR270-32SH-07	27,0	32	44	135	165	60	225	
S-5DR280-32SH-09	28,0	32	44	140	170	60	230	SPGX 090408
S-5DR290-32SH-09	29,0	32	44	145	175	60	235	
S-5DR295-32SH-09	29,5	32	54	147,5	178	60	238	
S-5DR300-32SH-09	30,0	32	54	150	181	60	241	
S-5DR310-32SH-09	31,0	32	54	155	186	60	246	
S-5DR320-32SH-09	32,0	32	54	160	191	60	251	
S-5DR330-32SH-09	33,0	32	54	165	196	60	256	
S-5DR340-32SH-11	34,0	40	54	170	204	60	274	SPGX 110408
S-5DR350-32SH-11	35,0	40	54	175	210	60	280	
S-5DR360-32SH-11	36,0	40	54	180	216	60	286	
S-5DR370-32SH-11	37,0	40	54	185	222	70	292	
S-5DR380-32SH-11	38,0	40	54	190	228	70	298	
S-5DR390-32SH-11	39,0	40	54	195	233	70	303	
S-5DR395-32SH-11	39,5	40	54	197,5	236	70	306	
S-5DR400-32SH-11	40,0	40	54	200	239	70	309	

Drill Inserts

Insert Drawing	l (mm)	s (mm)	d1 (mm)	r (mm)	Insert	Drilling Diameter (mm)
	5,00	2,38	3,00	0,4	SPGX 050204	ø 13 - 15,5
	6,00	2,38	3,60	0,40	SPGX 060204	ø 16 - 21
	7,94	3,97	4,10	0,80	SPGX 07T308	ø 22 - 27
	9,80	4,30	5,85	0,80	SPGX 090408	ø 28 - 33
	11,50	4,80	5,85	0,80	SPGX 110408	ø 34 - 40

STCK30D

Highly wear-resistant coated grade for machining stainless steel, chrome - nickel - cobalt alloy steel, heat - treatable steel, titanium alloys and plastics at medium cutting speeds.

STCK30D

Highly wear-resistant coated grade with high cutting edge stability for fine machining of alloyed and unalloyed tool steels, high-strength materials, non-ferrous metals and cast iron at high cutting speeds.

ISO	Material	Vc (m/min)	Feed per tooth in mm				
			ø13,0 - ø15,0	ø15,5 - ø21,5	ø22,0 - ø27,5	ø28,0 - ø33,0	ø34,0 - ø41,0
P	Low Carbon Steel	180 - 250	0,05 - 0,08	0,06 - 0,10	0,06 - 0,12	0,07 - 0,13	0,08 - 0,15
	Plain Carbon Steel	160 - 220	0,06 - 0,12	0,08 - 0,15	0,10 - 0,18	0,12 - 0,22	0,12 - 0,24
	Low Alloy Steel	150 - 220	0,06 - 0,12	0,08 - 0,14	0,10 - 0,18	0,12 - 0,22	0,12 - 0,23
	High Alloy Steel	130 - 180	0,06 - 0,10	0,08 - 0,15	0,10 - 0,20	0,12 - 0,23	0,12 - 0,24
M	Stainless Steel	170 - 240	0,05 - 0,10	0,06 - 0,12	0,08 - 0,15	0,09 - 0,16	0,10 - 0,17
K	Grey Cast Iron	180 - 250	0,06 - 0,12	0,08 - 0,16	0,12 - 0,20	0,15 - 0,25	0,16 - 0,28
	Nodular Cast Iron	130 - 200	0,06 - 0,10	0,08 - 0,15	0,10 - 0,18	0,12 - 0,20	0,15 - 0,23
N	Aluminium	330 - 380	0,06 - 0,14	0,08 - 0,15	0,10 - 0,20	0,12 - 0,22	0,14 - 0,23