

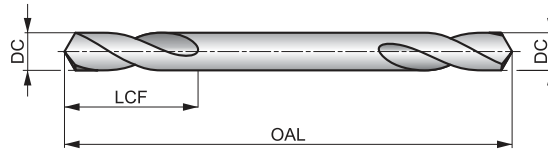


A119



HSS Double Ended Stub Drill, Steam Tempered Finish

A short double-ended drill designed for drilling holes through sheet metal. Possible to use both ends, giving twice the tool life. A 120° conventional point to aid self-centering. Suitable for drilling in many materials. Steam tempered finish retains cutting fluid and prevents chip to tool welding.



HSS	DIN 1897	1.25xD
120°	ST	
λ20-35°	R	DC h8

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page 175.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 31 C	■ 34 C	■ 35 C	■ 26 C	■ 23 C	■ 20 C	■ 12 C	■ 9 C	■ 8 C	■ 7 C	■ 6 C	■ 5 A	■ 21 A	■ 17 A
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2
■ 18 A	■ 15 A	■ 8 C	■ 7 C	■ 6 C	■ 10 A	■ 33 C	■ 25 C	■ 17 C	■ 46 C	■ 42 C	■ 30 C	■ 56 C	■ 33 C
N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2		
■ 17 A	■ 30 I	■ 35 C	■ 27 A	■ 12 A	■ 7 A	■ 5 C	■ 4 C	■ 4 C	■ 3 C	■ 3 C	■ 2 C		

Sheet Metal Drill.

Product	DC	DC	LCF	OAL	DCON MS
	[mm]	[inch]	[mm]	[mm]	[mm]
A1193.3	3.30	0.1299	11.0	49.0	3.30
A1193.6	3.60	0.1417	12.0	52.0	3.60
A1194.1	4.10	0.1614	14.0	55.0	4.10
A1194.2	4.20	0.1654	14.0	55.0	4.20
A1194.9	4.90	0.1929	17.0	62.0	4.90
A1195.1	5.10	0.2008	17.0	62.0	5.10