



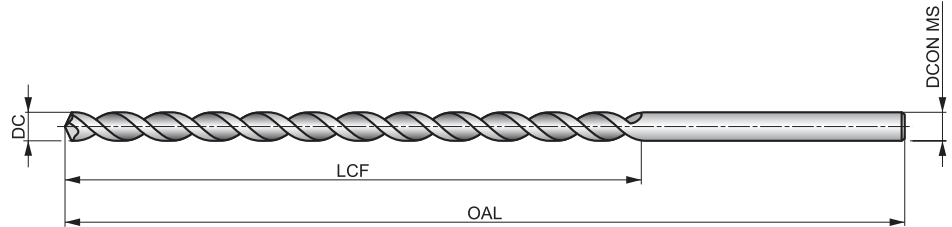
# A977



## PFX HSS-E (5% Cobalt) Extra Long Drill (DIN 1869 Series 2), Bright Finish

Recommended for drilling very deep holes and in applications where extra reach is needed. Specially designed parabolic flutes eliminate the need to drill deep holes in short steps (pecking). A 130° point. Centering with a short 3xD PFX drill is recommended (to keep same DC tolerance). Suitable for drilling many materials.

### PFX



HSS-E	DIN 1869-2	20xD
130°	Bright	
λ>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.

<b>P1.1</b>	<b>P1.2</b>	<b>P1.3</b>	<b>P2.1</b>	<b>P2.2</b>	<b>P2.3</b>	<b>P3.1</b>	<b>P3.2</b>	<b>P3.3</b>	<b>P4.1</b>	<b>P4.2</b>	<b>P4.3</b>	<b>M1.1</b>	<b>M1.2</b>
■29 B	■33 B	■34 B	■25 B	■22 B	■19 A	■18 B	■14 B	■12 A	■11 B	■9 A	■7 A	■16 B	■14 B
<b>M2.1</b>	<b>M2.2</b>	<b>M3.1</b>	<b>M3.2</b>	<b>M3.3</b>	<b>M4.1</b>	<b>K2.1</b>	<b>K2.2</b>	<b>K2.3</b>	<b>K3.1</b>	<b>K3.2</b>	<b>K3.3</b>	<b>K4.1</b>	<b>K4.2</b>
■15 B	■12 B	■8 B	■7 B	■6 B	■8 A	■20 B	■16 B	■13 A	■17 B	■13 B	■11 A	■16 B	■12 B
<b>K4.3</b>	<b>K4.4</b>	<b>K4.5</b>	<b>K5.1</b>	<b>K5.2</b>	<b>K5.3</b>	<b>N3.1</b>	<b>S1.1</b>	<b>S1.2</b>	<b>S1.3</b>				
■9 A	■8 A	■6 A	■18 B	■14 B	■11 A	■30 C	■15 B	■11 A	■5 A				

Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A9771.5 <sup>1)</sup>	–	1.50	0.0591	100.0	150.0	1.50
A9771/16 <sup>1)</sup>	1/16	1.59	0.0625	100.0	150.0	1.59
A9772.0 <sup>1)</sup>	–	2.00	0.0787	110.0	160.0	2.00
A9773/32 <sup>1)</sup>	3/32	2.38	0.0938	115.0	170.0	2.38
A9773.0X190	–	3.00	0.1181	130.0	190.0	3.00
A9771/8	1/8	3.18	0.1250	135.0	200.0	3.18
A9773.5X210	–	3.50	0.1378	145.0	210.0	3.50
A9774.0X220	–	4.00	0.1575	150.0	220.0	4.00
A9774.5X235	–	4.50	0.1772	160.0	235.0	4.50
A9773/16	3/16	4.76	0.1875	170.0	245.0	4.76
A9775.0X245	–	5.00	0.1969	170.0	245.0	5.00
A9775.5X260	–	5.50	0.2165	180.0	260.0	5.50
A9776.0X260	–	6.00	0.2362	180.0	260.0	6.00
A9771/4	1/4	6.35	0.2500	190.0	275.0	6.35
A9776.5X275	–	6.50	0.2559	190.0	275.0	6.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	[inch]	[mm]	[inch]	[mm]	[mm]	[mm]
A9777.0X290	–	7.00	0.2756	200.0	290.0	7.00
A9777.5X290	–	7.50	0.2953	200.0	290.0	7.50
A9778.0X305	–	8.00	0.3150	210.0	305.0	8.00
A9778.5X305	–	8.50	0.3346	210.0	305.0	8.50
A97711/32	11/32	8.73	0.3438	220.0	320.0	8.73
A9779.0X320	–	9.00	0.3543	220.0	320.0	9.00
A9779.5X320	–	9.50	0.3740	220.0	320.0	9.50
A97710.0X340	–	10.00	0.3937	235.0	340.0	10.00
A97710.5	–	10.50	0.4134	235.0	340.0	10.50
A97711.0	–	11.00	0.4331	250.0	365.0	11.00
A97711.5	–	11.50	0.4528	250.0	365.0	11.50
A97712.0	–	12.00	0.4724	260.0	375.0	12.00
A97712.5	–	12.50	0.4921	260.0	375.0	12.50
A97713.0	–	13.00	0.5118	260.0	375.0	13.00
A97714.0 <sup>1)</sup>	–	14.00	0.5512	270.0	390.0	14.00

<sup>1)</sup> Dormer Standard.