

DORMER

New products

2017.1



SOLID CARBIDE DRILLS

- 4 • Force X
New range of versatile tools

- 5 • R6011
Carbide spotting drill

- 5 • R7131
Carbide pre-tapping drill



REPLACEABLE HEAD DRILLS

- 34 • Hydra R970
High performance drill for Cast Iron



- 43 Icon descriptions

SOLID CARBIDE DRILLS



FORCE X

SOLID CARBIDE DRILLS

INTRODUCTION

Dormer Pramet's Force X programme is a new range of versatile solid carbide drills designed to provide an excellent level of performance with outstanding economy

FEATURES AND BENEFITS

- Consistent performance and repeatability in multiple applications across diverse machines and conditions
- The family offers ranges of TiAlN coated drills available in 3D and 5D lengths in both solid and coolant feed variants and an 8D version with coolant feed
- Their design enables them to deliver high performance across a wide variety of materials, making them the ideal choice for general engineering and sub-contract environments

MATERIAL

Premium Micrograin Carbide

- Micrograin carbide provides an excellent combination of hardness and toughness, resulting in high wear resistance and longer tool life

COATING

Multi-layer Titanium Aluminium Nitride (TiAlN)

- Improved cutting edge stability
- Outstanding wear protection
- High hardness at high temperature
- Increased tool life and productivity



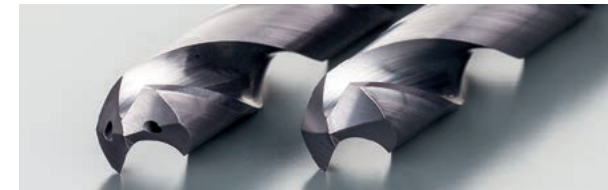
FORCE X

SOLID CARBIDE DRILLS

GEOMETRY

CTW Flute Construction

Continuously Thinned Web technology provides a very strong web design whilst at the same time reduces thrust forces during drilling



Edge Preparation

- A consistent edge preparation protects the cutting edges and prevents premature chipping and flaking

Corner Design

- A strong corner design increases stability during drilling and reduces the forces encountered during breakthrough of the exit surface in both general drilling and cross hole drilling applications

Point Geometry

- 140 degree split point geometry provides good centering capabilities and low thrust forces when drilling most materials

A COMPLETE RANGE

- Available in 3xØ, 5xØ and 8xØ lengths incorporating coolant holes to improve cutting efficiency and swarf evacuation, resulting in higher productivity
- Also available in solid versions 3xØ and 5xØ lengths
- Metric 3.00mm to 20.00mm
- Fractional 1/8inch to 3/4inch
- Gauge N1 to N30
- Letter A to Z

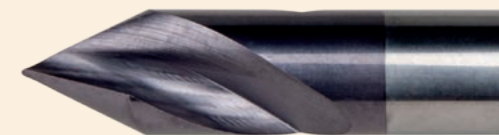
SHANK

DIN 6535 HA

- High precision shank (h6)
- Common shank to reduce tool holding costs

R6011, R7131

SOLID CARBIDE DRILLS



NEW

R6011

CARBIDE SPOTTING DRILL

- Versatile carbide spotting drill for a wide range of workpiece materials
- Accurate 90 degree self centering point geometry
- TiAlN coating for increased tool life
- h6 shank tolerance for use in hydraulic and shrink fit holders



NEW

R7131

CARBIDE PRE-TAPPING DRILL

- Drill and chamfer in one operation to reduce cycle time and tooling inventory
- Specific pre-tapping sizes for Metric threads
- Coolant feed to improve swarf control and performance
- TiAlN coating for increased tool life

6

R200 • Centre Drill - 60°

R200	▪	1.1	1.2	1.3	1.4	1.5	1.6	3.1	3.2	3.3	3.4	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4
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R200

HM

DIN 333A

1XD

118°













R200



1.00 - 5.00

d ₁ Ø mm	d ₁ decimal Inch	l ₂ max/min mm	l ₁ mm	d ₂ Ø mm	R200
1.00	0.0394	1.7 - 1.3	31	3.15	R2001.0X3.15
1.25	0.0492	2.0 - 1.6	31	3.15	R2001.25X3.15
1.60	0.0630	2.6 - 2.0	35	4.00	R2001.6X4.0
2.00	0.0787	3.1 - 2.5	40	5.00	R2002.0X5.0
2.50	0.0984	3.8 - 3.1	45	6.30	R2002.5X6.3
3.15	0.1240	4.6 - 3.9	50	8.00	R2003.15X8.0
4.00	0.1575	5.9 - 5.0	55	10.00	R2004.0X10.0
5.00	0.1969	7.2 - 6.3	63	12.50	R2005.0X12.5

R122 • Short Spotting Drill - 120° Four Facet Point upto 10,0mm

R123 • Short Spotting Drill - 90° Four Facet Point upto 10,0mm

R6011 • Spotting Drill - 90° TiAlN Coated

R122; R123; R6011	▪	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	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		

R122

HM

DORMER

1XD

120°





N



R123

HM

DORMER

1XD

90°





N



R6011

HM

DORMER

1XD

90°

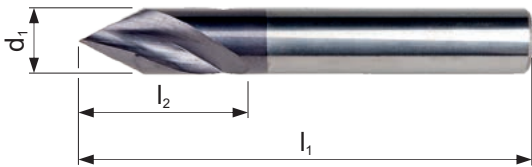




DIN 6535HA

N





R122



5.00 - 20.00

R123



5.00 - 20.00

R6011



6.00 - 16.00

NEW

d ₁ Ø mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R122	R123	R6011
5.00	0.1969	16	62	R1225.0	R1235.0	
6.00	0.2362	16	50			R60116.0
6.00	0.2362	17	66	R1226.0	R1236.0	
8.00	0.3150	22	79	R1228.0	R1238.0	
10.00	0.3937	25	70			R601110.0
10.00	0.3937	26	89	R12210.0	R12310.0	
12.00	0.4724	30	102	R12212.0	R12312.0	
16.00	0.6299	26	90			R601116.0
16.00	0.6299	34	115	R12216.0	R12316.0	
20.00	0.7874	40	131	R12220.0	R12320.0	



R7131 • Chamfer drill for pre-tapping holes

R7131	▪	1.1	1.2	1.3	1.4	1.5	2.1	2.2	2.3	3.1	3.2	3.3	3.4	6.1	6.2	6.3	6.4	7.1	7.2
		7.3	7.4																

R7131

HM

DORMER

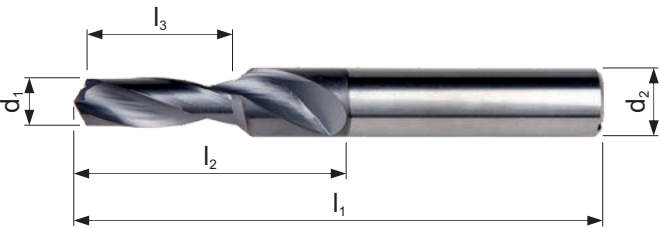
3XD

140°

TiAlN

DIN 6535 HA

N



R7131

NEW

3.30 - 10.40

d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	d ₂ Øh ₆ mm	M	R7131
3.30	0.1299	20	66	6	M4	R71313.3
4.20	0.1654	24	66	6	M5	R71314.2
5.00	0.1969	28	79	8	M6	R71315.0
6.80	0.2677	34	89	10	M8	R71316.8
8.50	0.3346	47	102	12	M10	R71318.5
10.20	0.4016	55	107	14	M12	R713110.2
10.40	0.4094	55	107	14	M12	R713110.4

R120 • Stub Drill

R120	▪	4.1	5.1	6.1	7.1	8.1	8.2															
	•	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	3.1	3.2	3.3	3.4	4.2	4.3	5.2	5.3	6.2	6.3	6.4	7.2	
		7.3	7.4																			

R120

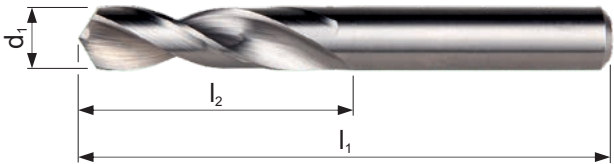
HM

DIN 6539

2.5XD

120°

N



d ₁ Øh, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R120
1.00	0.0394	6	26	R1201.0
1.10	0.0433	7	28	R1201.1
1.20	0.0472	8	30	R1201.2
1.30	0.0512	8	30	R1201.3
1.40	0.0551	9	32	R1201.4
1.50	0.0591	9	32	R1201.5
1.60	0.0630	10	34	R1201.6
1.70	0.0669	10	34	R1201.7
1.80	0.0709	11	36	R1201.8
1.90	0.0748	11	36	R1201.9
2.00	0.0787	12	38	R1202.0
2.10	0.0827	12	38	R1202.1
2.20	0.0866	13	40	R1202.2
2.30	0.0906	13	40	R1202.3
2.40	0.0945	14	43	R1202.4
2.50	0.0984	14	43	R1202.5
2.60	0.1024	14	43	R1202.6
2.70	0.1063	16	46	R1202.7
2.80	0.1102	16	46	R1202.8
2.90	0.1142	16	46	R1202.9
3.00	0.1181	16	46	R1203.0
3.10	0.1220	18	49	R1203.1
3.20	0.1260	18	49	R1203.2
3.30	0.1299	18	49	R1203.3
3.40	0.1339	20	52	R1203.4
3.50	0.1378	20	52	R1203.5
3.60	0.1417	20	52	R1203.6
3.70	0.1457	20	52	R1203.7
3.80	0.1496	22	55	R1203.8
3.90	0.1535	22	55	R1203.9
4.00	0.1575	22	55	R1204.0
4.10	0.1614	22	55	R1204.1
4.20	0.1654	22	55	R1204.2
4.30	0.1693	24	58	R1204.3
4.40	0.1732	24	58	R1204.4
4.50	0.1772	24	58	R1204.5
4.60	0.1811	24	58	R1204.6
4.70	0.1850	24	58	R1204.7
4.80	0.1890	26	62	R1204.8
4.90	0.1929	26	62	R1204.9

d ₁ Øh, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R120
5.00	0.1969	26	62	R1205.0
5.10	0.2008	26	62	R1205.1
5.20	0.2047	26	62	R1205.2
5.30	0.2087	26	62	R1205.3
5.40	0.2126	28	66	R1205.4
5.50	0.2165	28	66	R1205.5
5.60	0.2205	28	66	R1205.6
5.70	0.2244	28	66	R1205.7
5.80	0.2283	28	66	R1205.8
5.90	0.2323	28	66	R1205.9
6.00	0.2362	28	66	R1206.0
6.10	0.2402	31	70	R1206.1
6.20	0.2441	31	70	R1206.2
6.30	0.2480	31	70	R1206.3
6.40	0.2520	31	70	R1206.4
6.50	0.2559	31	70	R1206.5
6.60	0.2598	31	70	R1206.6
6.70	0.2638	31	70	R1206.7
6.80	0.2677	34	74	R1206.8
6.90	0.2717	34	74	R1206.9
7.00	0.2756	34	74	R1207.0
7.10	0.2795	34	74	R1207.1
7.20	0.2835	34	74	R1207.2
7.30	0.2874	34	74	R1207.3
7.40	0.2913	34	74	R1207.4
7.50	0.2953	34	74	R1207.5
7.60	0.2992	37	79	R1207.6
7.70	0.3031	37	79	R1207.7
7.80	0.3071	37	79	R1207.8
7.90	0.3110	37	79	R1207.9
8.00	0.3150	37	79	R1208.0
8.10	0.3189	37	79	R1208.1
8.20	0.3228	37	79	R1208.2
8.30	0.3268	37	79	R1208.3
8.40	0.3307	37	79	R1208.4
8.50	0.3346	37	79	R1208.5
8.60	0.3386	40	84	R1208.6
8.70	0.3425	40	84	R1208.7
8.80	0.3465	40	84	R1208.8
8.90	0.3504	40	84	R1208.9
9.00	0.3543	40	84	R1209.0
9.10	0.3583	40	84	R1209.1
9.20	0.3622	40	84	R1209.2
9.30	0.3661	40	84	R1209.3
9.40	0.3701	40	84	R1209.4
9.50	0.3740	40	84	R1209.5
9.60	0.3780	43	89	R1209.6
9.70	0.3819	43	89	R1209.7
9.80	0.3858	43	89	R1209.8
9.90	0.3898	43	89	R1209.9
10.00	0.3937	43	89	R12010.0
10.20	0.4016	43	89	R12010.2
10.50	0.4134	43	89	R12010.5
11.00	0.4331	47	95	R12011.0
11.50	0.4528	47	95	R12011.5
12.00	0.4724	51	102	R12012.0

R100 • Jobber Drill

R100	▪	6.2	6.3	8.1	8.2													
	•	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	3.1	3.2	3.3	3.4	7.1	7.2	7.3	7.4	

R100

HM

DIN
338

4XD

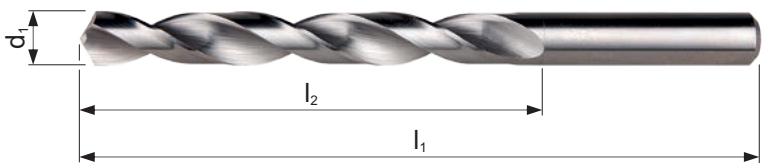
120°





N





d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R100
1.00	0.0394	12	34	R1001.0
1.10	0.0433	14	36	R1001.1
1.20	0.0472	16	38	R1001.2
1.30	0.0512	16	38	R1001.3
1.40	0.0551	18	40	R1001.4
1.50	0.0591	18	40	R1001.5
1.60	0.0630	20	43	R1001.6
1.70	0.0669	20	43	R1001.7
1.80	0.0709	22	46	R1001.8
1.90	0.0748	22	46	R1001.9
2.00	0.0787	24	49	R1002.0
2.10	0.0827	24	49	R1002.1
2.20	0.0866	27	53	R1002.2
2.30	0.0906	27	53	R1002.3
2.40	0.0945	30	57	R1002.4
2.50	0.0984	30	57	R1002.5
2.60	0.1024	30	57	R1002.6
2.70	0.1063	33	61	R1002.7
2.80	0.1102	33	61	R1002.8
2.90	0.1142	33	61	R1002.9
3.00	0.1181	33	61	R1003.0
3.10	0.1220	36	65	R1003.1
3.20	0.1260	36	65	R1003.2
3.30	0.1299	36	65	R1003.3
3.40	0.1339	39	70	R1003.4
3.50	0.1378	39	70	R1003.5
3.60	0.1417	39	70	R1003.6
3.70	0.1457	39	70	R1003.7
3.80	0.1496	43	75	R1003.8
3.90	0.1535	43	75	R1003.9
4.00	0.1575	43	75	R1004.0
4.10	0.1614	43	75	R1004.1
4.20	0.1654	43	75	R1004.2
4.30	0.1693	47	80	R1004.3
4.40	0.1732	47	80	R1004.4
4.50	0.1772	47	80	R1004.5
4.60	0.1811	47	80	R1004.6
4.70	0.1850	47	80	R1004.7
4.80	0.1890	52	86	R1004.8
4.90	0.1929	52	86	R1004.9

d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R100
5.00	0.1969	52	86	R1005.0
5.10	0.2008	52	86	R1005.1
5.20	0.2047	52	86	R1005.2
5.30	0.2087	52	86	R1005.3
5.40	0.2126	57	93	R1005.4
5.50	0.2165	57	93	R1005.5
5.60	0.2205	57	93	R1005.6
5.70	0.2244	57	93	R1005.7
5.80	0.2283	57	93	R1005.8
5.90	0.2323	57	93	R1005.9
6.00	0.2362	57	93	R1006.0
6.10	0.2402	63	101	R1006.1
6.20	0.2441	63	101	R1006.2
6.30	0.2480	63	101	R1006.3
6.40	0.2520	63	101	R1006.4
6.50	0.2559	63	101	R1006.5
6.60	0.2598	63	101	R1006.6
6.70	0.2638	63	101	R1006.7
6.80	0.2677	69	109	R1006.8
6.90	0.2717	69	109	R1006.9
7.00	0.2756	69	109	R1007.0
7.10	0.2795	69	109	R1007.1
7.20	0.2835	69	109	R1007.2
7.30	0.2874	69	109	R1007.3
7.40	0.2913	69	109	R1007.4
7.50	0.2953	69	109	R1007.5
7.60	0.2992	75	117	R1007.6
7.70	0.3031	75	117	R1007.7
7.80	0.3071	75	117	R1007.8
7.90	0.3110	75	117	R1007.9
8.00	0.3150	75	117	R1008.0
8.10	0.3189	75	117	R1008.1
8.20	0.3228	75	117	R1008.2
8.30	0.3268	75	117	R1008.3
8.40	0.3307	75	117	R1008.4
8.50	0.3346	75	117	R1008.5
8.60	0.3386	81	125	R1008.6
8.70	0.3425	81	125	R1008.7
8.80	0.3465	81	125	R1008.8
8.90	0.3504	81	125	R1008.9
9.00	0.3543	81	125	R1009.0
9.10	0.3583	81	125	R1009.1
9.20	0.3622	81	125	R1009.2
9.30	0.3661	81	125	R1009.3
9.40	0.3701	81	125	R1009.4
9.50	0.3740	81	125	R1009.5
9.60	0.3780	87	133	R1009.6
9.70	0.3819	87	133	R1009.7
9.80	0.3858	87	133	R1009.8
9.90	0.3898	87	133	R1009.9
10.00	0.3937	87	133	R10010.0
10.20	0.4016	87	133	R10010.2
10.50	0.4134	87	133	R10010.5
11.00	0.4331	94	142	R10011.0
11.50	0.4528	94	142	R10011.5
12.00	0.4724	101	151	R10012.0
13.00	0.5118	101	151	R10013.0
14.00	0.5512	108	160	R10014.0

R520 • CDX Stub Drill

R520	■	1.1	1.2	1.3	1.4	1.5	1.6	3.1	3.2	3.3	3.4	5.1	7.1	7.2	7.3	7.4	8.1	8.2
		1.7	1.8	2.1	4.1	4.2	4.3											

R520

HM

DIN 6539

2.5XD

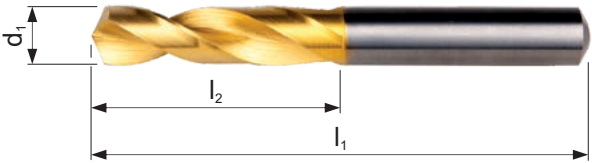
130°

TIN



N





d ₁ Øh, Inch	d ₁ Øh, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R520
1/8	3.00	0.1181	16	46	R5203.0
	3.10	0.1220	18	49	R5203.1
	3.18	0.1252	18	49	R5201/8
	3.20	0.1260	18	49	R5203.2
	3.30	0.1299	18	49	R5203.3
	3.40	0.1339	20	52	R5203.4
	3.50	0.1378	20	52	R5203.5
	3.60	0.1417	20	52	R5203.6
	3.70	0.1457	20	52	R5203.7
	3.80	0.1496	22	55	R5203.8
	3.90	0.1535	22	55	R5203.9
	4.00	0.1575	22	55	R5204.0
	4.10	0.1614	22	55	R5204.1
	4.20	0.1654	22	55	R5204.2
	4.30	0.1693	24	58	R5204.3
	4.40	0.1732	24	58	R5204.4
1/4	4.50	0.1772	24	58	R5204.5
	4.60	0.1811	24	58	R5204.6
	4.70	0.1850	24	58	R5204.7
	4.80	0.1890	26	62	R5204.8
	4.90	0.1929	26	62	R5204.9
	5.00	0.1969	26	62	R5205.0
	5.10	0.2008	26	62	R5205.1
	5.20	0.2047	26	62	R5205.2
	5.30	0.2087	26	62	R5205.3
	5.40	0.2126	28	66	R5205.4
	5.50	0.2165	28	66	R5205.5
	5.60	0.2205	28	66	R5205.6
	5.70	0.2244	28	66	R5205.7
	5.80	0.2283	28	66	R5205.8
	5.90	0.2323	28	66	R5205.9
	6.00	0.2362	28	66	R5206.0
1/4	6.10	0.2402	31	70	R5206.1
	6.20	0.2441	31	70	R5206.2
	6.30	0.2480	31	70	R5206.3
	6.35	0.2500	31	70	R5201/4
	6.40	0.2520	31	70	R5206.4
	6.50	0.2559	31	70	R5206.5
	6.60	0.2598	31	70	R5206.6
	6.70	0.2638	31	70	R5206.7
	6.80	0.2677	34	74	R5206.8
	6.90	0.2717	34	74	R5206.9

d ₁ Øh, Inch	d ₁ Øh, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R520
5/16	7.00	0.2756	34	74	R5207.0
	7.10	0.2795	34	74	R5207.1
	7.20	0.2835	34	74	R5207.2
	7.30	0.2874	34	74	R5207.3
	7.40	0.2913	34	74	R5207.4
	7.50	0.2953	34	74	R5207.5
	7.60	0.2992	37	79	R5207.6
	7.70	0.3031	37	79	R5207.7
	7.80	0.3071	37	79	R5207.8
	7.90	0.3110	37	79	R5207.9
	7.94	0.3126	37	79	R5205/16
	8.00	0.3150	37	79	R5208.0
	8.10	0.3189	37	79	R5208.1
	8.20	0.3228	37	79	R5208.2
	8.30	0.3268	37	79	R5208.3
	8.40	0.3307	37	79	R5208.4
3/8	8.50	0.3346	37	79	R5208.5
	8.60	0.3386	40	84	R5208.6
	8.70	0.3425	40	84	R5208.7
	8.80	0.3465	40	84	R5208.8
	8.90	0.3504	40	84	R5208.9
	9.00	0.3543	40	84	R5209.0
	9.10	0.3583	40	84	R5209.1
	9.20	0.3622	40	84	R5209.2
	9.30	0.3661	40	84	R5209.3
	9.40	0.3701	40	84	R5209.4
	9.50	0.3740	40	84	R5209.5
	9.52	0.3748	43	89	R5203/8
	9.60	0.3780	43	89	R5209.6
	9.70	0.3819	43	89	R5209.7
	9.80	0.3858	43	89	R5209.8
	9.90	0.3898	43	89	R5209.9
7/16	10.00	0.3937	43	89	R52010.0
	10.10	0.3976	43	89	R52010.1
	10.20	0.4016	43	89	R52010.2
	10.30	0.4055	43	89	R52010.3
	10.40	0.4094	43	89	R52010.4
	10.50	0.4134	43	89	R52010.5
	11.00	0.4331	47	95	R52011.0
	11.11	0.4374	47	95	R5207/16
	11.20	0.4409	47	95	R52011.2
	11.50	0.4528	47	95	R52011.5
	12.00	0.4724	51	102	R52012.0
	12.50	0.4921	51	102	R52012.5
	12.70	0.5000	51	102	R5201/2
	13.00	0.5118	51	102	R52013.0
	13.50	0.5315	54	107	R52013.5
	14.00	0.5512	54	107	R52014.0
1/2	14.20	0.5591	56	111	R52014.2
	14.25	0.5610	56	111	R52014.25
	14.50	0.5709	56	111	R52014.5
	15.00	0.5906	56	111	R52015.0
	15.10	0.5945	58	115	R52015.1
	15.88	0.6252	58	115	R5205/8
	16.00	0.6299	58	115	R52016.0
	16.50	0.6496	60	119	R52016.5

R510 • CDX Jobber Drill

R510	▪	1.1	1.2	1.3	1.4	1.5	1.6	3.1	3.2	3.3	3.4	7.1	7.2	7.3	7.4	8.1	8.2
	•	1.7	1.8	2.1	4.1	5.1											

R510

HM

DIN
338

4XD

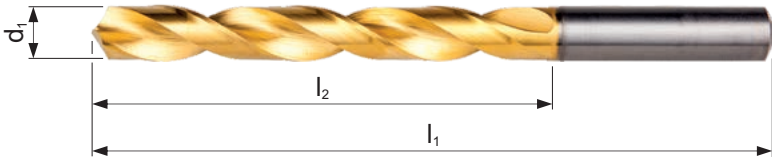
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TiN



N





d ₁ Øh, Inch	d ₁ Øh, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R510
1/8	3.00	0.1181	33	61	R5103.0
	3.18	0.1252	36	65	R5101/8
	3.20	0.1260	36	65	R5103.2
	3.30	0.1299	36	65	R5103.3
	3.40	0.1339	39	70	R5103.4
	3.50	0.1378	39	70	R5103.5
	3.70	0.1457	39	70	R5103.7
	3.90	0.1535	43	75	R5103.9
	4.00	0.1575	43	75	R5104.0
	4.10	0.1614	43	75	R5104.1
3/16	4.20	0.1654	43	75	R5104.2
	4.30	0.1693	47	80	R5104.3
	4.50	0.1772	47	80	R5104.5
	4.60	0.1811	47	80	R5104.6
	4.70	0.1850	47	80	R5104.7
	4.76	0.1874	52	86	R5103/16
	4.90	0.1929	52	86	R5104.9
	5.00	0.1969	52	86	R5105.0
	5.10	0.2008	52	86	R5105.1
	5.50	0.2165	57	93	R5105.5
1/4	5.60	0.2205	57	93	R5105.6
	5.70	0.2244	57	93	R5105.7
	6.00	0.2362	57	93	R5106.0
	6.35	0.2500	63	101	R5101/4
	6.50	0.2559	63	101	R5106.5
	6.60	0.2598	63	101	R5106.6
	6.80	0.2677	69	109	R5106.8
	6.90	0.2717	69	109	R5106.9
	7.00	0.2756	69	109	R5107.0
	7.30	0.2874	69	109	R5107.3
5/16	7.40	0.2913	69	109	R5107.4
	7.50	0.2953	69	109	R5107.5
	7.80	0.3071	75	117	R5107.8
	7.90	0.3110	75	117	R5107.9
	7.94	0.3126	75	117	R5105/16
	8.00	0.3150	75	117	R5108.0
	8.50	0.3346	75	117	R5108.5
	8.70	0.3425	81	125	R5108.7
	8.80	0.3465	81	125	R5108.8
	9.00	0.3543	81	125	R5109.0

d ₁ Øh, Inch	d ₁ Øh, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	R510
3/8	9.20	0.3622	81	125	R5109.2
	9.30	0.3661	81	125	R5109.3
	9.40	0.3701	81	125	R5109.4
	9.50	0.3740	81	125	R5109.5
	9.52	0.3748	87	133	R5103/8
	9.90	0.3898	87	133	R5109.9
	10.00	0.3937	87	133	R51010.0
	10.20	0.4016	87	133	R51010.2
	10.30	0.4055	87	133	R51010.3
	10.40	0.4094	87	133	R51010.4
7/16	10.50	0.4134	87	133	R51010.5
	10.80	0.4252	94	142	R51010.8
	11.00	0.4331	94	142	R51011.0
	11.11	0.4374	94	142	R5107/16
	11.20	0.4409	94	142	R51011.2
	11.50	0.4528	94	142	R51011.5
	12.00	0.4724	101	151	R51012.0
	12.70	0.5000	101	151	R5101/2
	13.00	0.5118	101	151	R51013.0
	14.00	0.5512	108	160	R51014.0
1/2	14.25	0.5610	114	169	R51014.25

R458
R457

- Force X Drill 3xD
- Force X Drill Oil Feed 3xD

R458	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	3.1	3.2	3.3	3.4	6.1	6.1	6.2
		7.1	7.2	7.3	7.4														
	•	2.4	4.1	4.2	4.3	6.4													
R457	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	3.1	3.2	3.3	3.4	4.1	4.2	4.3
		6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4										

R458

HM

DIN 6537 K

3XD

140°

TiAlN

DIN 6535 HA

CTW

R457

HM

DIN 6537 K

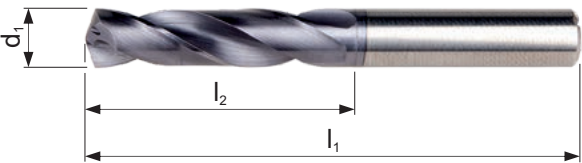
3XD

140°

TiAlN

DIN 6535 HA

CTW



d ₁ Ø "/Nr.	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R458	R457
	3.00	0.1181	20	62	36	6	R4583.0	R4573.0
	3.10	0.1220	20	62	36	6	R4583.1	R4573.1
1/8	3.18	0.1252	20	62	36	6	R4581/8	R4571/8
	3.20	0.1260	20	62	36	6	R4583.2	R4573.2
30	3.26	0.1283	20	62	36	6	R458N30	R457N30
	3.30	0.1299	20	62	36	6	R4583.3	R4573.3
	3.40	0.1339	20	62	36	6	R4583.4	R4573.4
29	3.45	0.1358	20	62	36	6	R458N29	R457N29
	3.50	0.1378	20	62	36	6	R4583.5	R4573.5
28	3.57	0.1406	20	62	36	6	R458N28	R457N28
9/64	3.57	0.1406	20	62	36	6	R4589/64	R4579/64
	3.60	0.1417	20	62	36	6	R4583.6	R4573.6
27	3.66	0.1441	20	62	36	6	R458N27	R457N27
	3.70	0.1457	20	62	36	6	R4583.7	R4573.7
26	3.73	0.1469	24	66	36	6	R4583.73	R457N26
25	3.80	0.1496	24	66	36	6	R4583.8	R457N25
24	3.86	0.1520	24	66	36	6	R458N24	R457N24
	3.90	0.1535	24	66	36	6	R4583.9	R4573.9
23	3.91	0.1539	24	66	36	6	R458N23	R457N23
5/32	3.97	0.1563	24	66	36	6	R4585/32	R4575/32
22	3.99	0.1571	24	66	36	6	R458N22	R457N22
	4.00	0.1575	24	66	36	6	R4584.0	R4574.0
21	4.04	0.1591	24	66	36	6	R458N21	R457N21
	4.05	0.1594	24	66	36	6		R4574.05
20	4.09	0.1610	24	66	36	6	R458N20	R457N20
	4.10	0.1614	24	66	36	6	R4584.1	R4574.1
	4.20	0.1654	24	66	36	6	R4584.2	R4574.2
19	4.22	0.1661	24	66	36	6	R458N19	R457N19
	4.30	0.1693	24	66	36	6	R4584.3	R4574.3
18	4.31	0.1697	24	66	36	6	R458N18	R457N18

d ₁ Ø "/Nr.	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R458	R457
11/64	4.37	0.1720	24	66	36	6	R45811/64	R45711/64
17	4.39	0.1728	24	66	36	6	R458N17	R457N17
	4.40	0.1732	24	66	36	6	R4584.4	R4574.4
16	4.50	0.1772	24	66	36	6	R4584.5	R457N16
15	4.57	0.1799	24	66	36	6	R458N15	R457N15
	4.60	0.1811	24	66	36	6	R4584.6	R4574.6
14	4.62	0.1819	24	66	36	6	R458N14	R457N14
13	4.70	0.1850	24	66	36	6	R4584.7	R457N13
3/16	4.76	0.1874	28	66	36	6	R4583/16	R4573/16
12	4.80	0.1890	28	66	36	6	R4584.8	R457N12
11	4.85	0.1909	28	66	36	6	R458N11	R457N11
	4.90	0.1929	28	66	36	6	R4584.9	R4574.9
10	4.92	0.1937	28	66	36	6	R458N10	R457N10
9	4.98	0.1961	28	66	36	6	R458N9	R457N9
	5.00	0.1969	28	66	36	6	R4585.0	R4575.0
	5.05	0.1988	28	66	36	6		R4575.05
8	5.06	0.1992	28	66	36	6	R458N8	R457N8
	5.10	0.2008	28	66	36	6	R4585.1	R4575.1
7	5.11	0.2012	28	66	36	6	R458N7	R457N7
13/64	5.16	0.2031	28	66	36	6	R45813/64	R45713/64
6	5.18	0.2039	28	66	36	6	R458N6	R457N6
	5.20	0.2047	28	66	36	6	R4585.2	R4575.2
5	5.22	0.2055	28	66	36	6	R458N5	R457N5
	5.30	0.2087	28	66	36	6	R4585.3	R4575.3
4	5.31	0.2091	28	66	36	6	R458N4	R457N4
	5.40	0.2126	28	66	36	6	R4585.4	R4575.4
3	5.41	0.2130	28	66	36	6	R458N3	R457N3
	5.50	0.2165	28	66	36	6	R4585.5	R4575.5
7/32	5.56	0.2189	28	66	36	6	R4587/32	R4577/32
	5.60	0.2205	28	66	36	6	R4585.6	R4575.6
2	5.61	0.2209	28	66	36	6	R458N2	R457N2
	5.70	0.2244	28	66	36	6	R4585.7	R4575.7
1	5.79	0.2280	28	66	36	6	R458N1	R457N1
	5.80	0.2283	28	66	36	6	R4585.8	R4575.8
	5.90	0.2323	28	66	36	6	R4585.9	R4575.9
A	5.94	0.2339	28	66	36	6	R458A	R457A
15/64	5.95	0.2343	28	66	36	6	R45815/64	R45715/64
	6.00	0.2362	28	66	36	6	R4586.0	R4576.0
B	6.03	0.2374	34	79	36	8	R458B	R457B
	6.05	0.2382	34	79	36	8		R4576.05
	6.10	0.2402	34	79	36	8	R4586.1	R4576.1
C	6.15	0.2421	34	79	36	8	R458C	R457C
	6.20	0.2441	34	79	36	8	R4586.2	R4576.2
D	6.25	0.2461	34	79	36	8	R458D	R457D
	6.30	0.2480	34	79	36	8	R4586.3	R4576.3
1/4	6.35	0.2500	34	79	36	8	R4581/4	R4571/4
E	6.35	0.2500	34	79	36	8	R458E	R457E
	6.40	0.2520	34	79	36	8	R4586.4	R4576.4
	6.50	0.2559	34	79	36	8	R4586.5	R4576.5
F	6.53	0.2571	34	79	36	8	R458F	R457F
	6.60	0.2598	34	79	36	8	R4586.6	R4576.6
G	6.63	0.2610	34	79	36	8	R458G	R457G
	6.70	0.2638	34	79	36	8	R4586.7	R4576.7
17/64	6.75	0.2657	34	79	36	8	R45817/64	R45717/64
H	6.76	0.2661	34	79	36	8	R458H	R457H
	6.80	0.2677	34	79	36	8	R4586.8	R4576.8
	6.90	0.2717	34	79	36	8	R4586.9	R4576.9
I	6.91	0.2720	34	79	36	8	R458I	R457I
	7.00	0.2756	34	79	36	8	R4587.0	R4577.0
J	7.04	0.2772	41	79	36	8	R458J	R457J
	7.10	0.2795	41	79	36	8	R4587.1	R4577.1
K	7.14	0.2811	41	79	36	8	R458K	R457K
9/32	7.14	0.2811	41	79	36	8	R4589/32	R4579/32
	7.20	0.2835	41	79	36	8	R4587.2	R4577.2
	7.30	0.2874	41	79	36	8	R4587.3	R4577.3
L	7.37	0.2902	41	79	36	8	R458L	R457L
	7.40	0.2913	41	79	36	8	R4587.4	R4577.4
M	7.49	0.2949	41	79	36	8	R458M	R457M

d ₁ Ø “/Nr.	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R458	R457
	7.50	0.2953	41	79	36	8	R4587.5	R4577.5
19/64	7.54	0.2969	41	79	36	8	R45819/64	R45719/64
	7.60	0.2992	41	79	36	8	R4587.6	R4577.6
N	7.67	0.3020	41	79	36	8	R458N	R457N
	7.70	0.3031	41	79	36	8	R4587.7	R4577.7
	7.80	0.3071	41	79	36	8	R4587.8	R4577.8
	7.90	0.3110	41	79	36	8	R4587.9	R4577.9
5/16	7.94	0.3126	41	79	36	8	R4585/16	R4575/16
	8.00	0.3150	41	79	36	8	R4588.0	R4578.0
O	8.03	0.3161	47	89	40	10	R458O	R457O
	8.05	0.3169	47	89	40	10		R4578.05
	8.10	0.3189	47	89	40	10	R4588.1	R4578.1
	8.20	0.3228	47	89	40	10	R4588.2	R4578.2
P	8.20	0.3228	47	89	40	10	R458P	R457P
	8.30	0.3268	47	89	40	10	R4588.3	R4578.3
21/64	8.33	0.3280	47	89	40	10	R45821/64	R45721/64
	8.40	0.3307	47	89	40	10	R4588.4	R4578.4
Q	8.43	0.3319	47	89	40	10	R458Q	R457Q
	8.50	0.3346	47	89	40	10	R4588.5	R4578.5
	8.60	0.3386	47	89	40	10	R4588.6	R4578.6
R	8.61	0.3390	47	89	40	10	R458R	R457R
	8.70	0.3425	47	89	40	10	R4588.7	R4578.7
11/32	8.73	0.3437	47	89	40	10	R45811/32	R45711/32
	8.80	0.3465	47	89	40	10	R4588.8	R4578.8
S	8.84	0.3480	47	89	40	10	R458S	R457S
	8.90	0.3504	47	89	40	10	R4588.9	R4578.9
	9.00	0.3543	47	89	40	10	R4589.0	R4579.0
T	9.09	0.3579	47	89	40	10	R458T	R457T
	9.10	0.3583	47	89	40	10	R4589.1	R4579.1
23/64	9.13	0.3594	47	89	40	10	R45823/64	R45723/64
	9.20	0.3622	47	89	40	10	R4589.2	R4579.2
	9.30	0.3661	47	89	40	10	R4589.3	R4579.3
U	9.35	0.3681	47	89	40	10	R458U	R457U
	9.40	0.3701	47	89	40	10	R4589.4	R4579.4
	9.50	0.3740	47	89	40	10	R4589.5	R4579.5
3/8	9.52	0.3748	47	89	40	10	R4583/8	R4573/8
V	9.58	0.3772	47	89	40	10	R458V	R457V
	9.60	0.3780	47	89	40	10	R4589.6	R4579.6
	9.70	0.3819	47	89	40	10	R4589.7	R4579.7
	9.80	0.3858	47	89	40	10	R4589.8	R4579.8
W	9.80	0.3858	47	89	40	10	R458W	R457W
	9.90	0.3898	47	89	40	10	R4589.9	R4579.9
25/64	9.92	0.3906	47	89	40	10	R45825/64	R45725/64
	10.00	0.3937	47	89	40	10	R45810.0	R45710.0
	10.05	0.3957	55	102	45	12		R45710.05
X	10.08	0.3969	55	102	45	12	R458X	R457X
	10.10	0.3976	55	102	45	12	R45810.1	R45710.1
	10.20	0.4016	55	102	45	12	R45810.2	R45710.2
Y	10.26	0.4039	55	102	45	12	R458Y	R457Y
	10.30	0.4055	55	102	45	12	R45810.3	R45710.3
13/32	10.32	0.4063	55	102	45	12	R45813/32	R45713/32
	10.40	0.4094	55	102	45	12	R45810.4	R45710.4
Z	10.49	0.4130	55	102	45	12	R458Z	R457Z
	10.50	0.4134	55	102	45	12	R45810.5	R45710.5
	10.60	0.4173	55	102	45	12	R45810.6	R45710.6
	10.70	0.4213	55	102	45	12	R45810.7	
27/64	10.72	0.4220	55	102	45	12	R45827/64	R45727/64
	10.80	0.4252	55	102	45	12	R45810.8	R45710.8
	10.90	0.4291	55	102	45	12	R45810.9	
	11.00	0.4331	55	102	45	12	R45811.0	R45711.0
	11.10	0.4370	55	102	45	12	R45811.1	
7/16	11.11	0.4374	55	102	45	12	R4587/16	R4577/16
	11.20	0.4409	55	102	45	12	R45811.2	R45711.2
	11.30	0.4449	55	102	45	12	R45811.3	R45711.3
	11.40	0.4488	55	102	45	12	R45811.4	R45711.4
	11.50	0.4528	55	102	45	12	R45811.5	R45711.5
29/64	11.51	0.4531	55	102	45	12	R45829/64	R45729/64
	11.60	0.4567	55	102	45	12	R45811.6	R45711.6

d ₁ Ø “/Nr.	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R458	R457
	11.70	0.4606	55	102	45	12	R45811.7	
	11.80	0.4646	55	102	45	12	R45811.8	R45711.8
	11.90	0.4685	55	102	45	12	R45811.9	
15/32	11.91	0.4689	55	102	45	12	R45815/32	R45715/32
	12.00	0.4724	55	102	45	12	R45812.0	R45712.0
	12.05	0.4744	60	107	45	14		R45712.05
	12.10	0.4764	60	107	45	14	R45812.1	R45712.1
	12.20	0.4803	60	107	45	14	R45812.2	R45712.2
31/64	12.30	0.4843	60	107	45	14	R45831/64	R45731/64
	12.50	0.4921	60	107	45	14	R45812.5	R45712.5
1/2	12.70	0.5000	60	107	45	14	R45812.7	R45712.7
	12.80	0.5039	60	107	45	14	R45812.8	R45712.8
	13.00	0.5118	60	107	45	14	R45813.0	R45713.0
33/64	13.10	0.5157	60	107	45	14	R45833/64	R45733/64
	13.30	0.5236	60	107	45	14	R45813.3	R45713.3
17/32	13.49	0.5311	60	107	45	14	R45817/32	R45717/32
	13.50	0.5315	60	107	45	14	R45813.5	R45713.5
	13.80	0.5433	60	107	45	14	R45813.8	R45713.8
35/64	13.89	0.5469	60	107	45	14	R45835/64	R45735/64
	14.00	0.5512	60	107	45	14	R45814.0	R45714.0
	14.25	0.5610	65	115	48	16	R45814.25	R45714.25
9/16	14.29	0.5626	65	115	48	16	R4589/16	R4579/16
	14.50	0.5709	65	115	48	16	R45814.5	R45714.5
37/64	14.68	0.5780	65	115	48	16	R45837/64	R45737/64
	14.80	0.5827	65	115	48	16	R45814.8	R45714.8
	15.00	0.5906	65	115	48	16	R45815.0	R45715.0
19/32	15.08	0.5937	65	115	48	16	R45819/32	R45719/32
	15.10	0.5945	65	115	48	16	R45815.1	R45715.1
	15.30	0.6024	65	115	48	16	R45815.3	R45715.3
39/64	15.48	0.6094	65	115	48	16	R45839/64	R45739/64
	15.50	0.6102	65	115	48	16	R45815.5	R45715.5
	15.80	0.6220	65	115	48	16	R45815.8	R45715.8
5/8	15.88	0.6252	65	115	48	16	R4585/8	R4575/8
	16.00	0.6299	65	115	48	16	R45816.0	R45716.0
41/64	16.27	0.6406	73	123	48	18	R45841/64	R45741/64
	16.50	0.6496	73	123	48	18	R45816.5	R45716.5
21/32	16.67	0.6563	73	123	48	18	R45821/32	R45721/32
	17.00	0.6693	73	123	48	18	R45817.0	R45717.0
43/64	17.07	0.6720	73	123	48	18	R45843/64	R45743/64
11/16	17.46	0.6874	73	123	48	18	R45811/16	R45711/16
	17.50	0.6890	73	123	48	18	R45817.5	R45717.5
	17.80	0.7008	73	123	48	18	R45817.8	
45/64	17.86	0.7031	73	123	48	18	R45845/64	R45745/64
	18.00	0.7087	73	123	48	18	R45818.0	R45718.0
23/32	18.26	0.7189	79	131	50	20	R45823/32	R45723/32
	18.50	0.7283	79	131	50	20	R45818.5	R45718.5
47/64	18.65	0.7343	79	131	50	20	R45847/64	R45747/64
	18.80	0.7402	79	131	50	20		R45718.8
	19.00	0.7480	79	131	50	20	R45819.0	R45719.0
3/4	19.05	0.7500	79	131	50	20	R4583/4	R4573/4
	19.50	0.7677	79	131	50	20	R45819.5	R45719.5
	19.80	0.7795	79	131	50	20	R45819.8	R45719.8
	20.00	0.7874	79	131	50	20	R45820.0	R45720.0

R454
R453

- Force X Drill 5xD
- Force X Drill Oil Feed 5xD

R454	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	3.1	3.2	3.3	3.4	6.1	6.1	6.2
		7.1	7.2	7.3	7.4														
	•	2.4	4.1	4.2	4.3	6.4													
R453	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	3.1	3.2	3.3	3.4	4.1	4.2	4.3
		6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4										

R454

HM

DIN 6537 L

5XD

140°

TiAlN

DIN 6535HA

CTW

R453

HM

DIN 6537 L

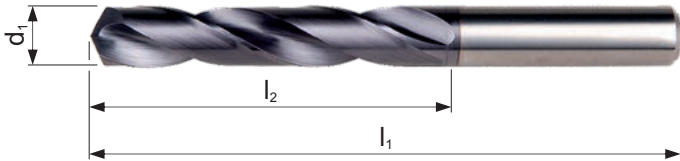
5XD

140°

TiAlN

DIN 6535HA

CTW



d ₁ Ø Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R454	R453
1/8	3.00	0.1181	28	66	36	6	R4543.0	R4533.0
	3.10	0.1220	28	66	36	6	R4543.1	R4533.1
	3.18	0.1252	28	66	36	6	R4541/8	R4531/8
30	3.20	0.1260	28	66	36	6	R4543.2	R4533.2
	3.26	0.1283	28	66	36	6	R454N30	R453N30
	3.30	0.1299	28	66	36	6	R4543.3	R4533.3
29	3.40	0.1339	28	66	36	6	R4543.4	R4533.4
	3.45	0.1358	28	66	36	6	R454N29	R453N29
	3.50	0.1378	28	66	36	6	R4543.5	R4533.5
28	3.57	0.1406	28	66	36	6	R454N28	R453N28
	9/64	3.57	0.1406	28	66	6	R4549/64	R4539/64
	3.60	0.1417	28	66	36	6	R4543.6	R4533.6
27	3.66	0.1441	28	66	36	6	R454N27	R453N27
	3.70	0.1457	28	66	36	6	R4543.7	R4533.7
	3.73	0.1469	36	74	36	6	R454N26	R453N26
25	3.80	0.1496	36	74	36	6	R4543.8	R4533.8
24	3.86	0.1520	36	74	36	6	R454N24	R453N24
	3.90	0.1535	36	74	36	6	R4543.9	R4533.9
	23	3.91	0.1539	36	74	36	R454N23	R453N23
5/32	3.97	0.1563	36	74	36	6	R4545/32	R4535/32
	22	3.99	0.1571	36	74	36	R454N22	R453N22
	4.00	0.1575	36	74	36	6	R4544.0	R4534.0
21	4.04	0.1591	36	74	36	6	R454N21	R453N21
	4.05	0.1594	36	74	36	6		R4534.05
	4.09	0.1610	36	74	36	6	R454N20	R453N20
20	4.10	0.1614	36	74	36	6	R4544.1	R4534.1

d ₁ Ø Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R454	R453
19	4.20	0.1654	36	74	36	6	R4544.2	R4534.2
	4.22	0.1661	36	74	36	6	R454N19	R453N19
	4.30	0.1693	36	74	36	6	R4544.3	R4534.3
18	4.31	0.1697	36	74	36	6	R454N18	R453N18
11/64	4.37	0.1720	36	74	36	6	R45411/64	R45311/64
17	4.39	0.1728	36	74	36	6	R454N17	R453N17
	4.40	0.1732	36	74	36	6	R4544.4	R4534.4
	4.50	0.1772	36	74	36	6	R4544.5	R4534.5
16	4.50	0.1772	36	74	36	6	R454N16	R453N16
	15	4.57	0.1799	36	74	36	R454N15	R453N15
	4.60	0.1811	36	74	36	6	R4544.6	R4534.6
14	4.62	0.1819	36	74	36	6	R454N14	R453N14
	13	4.70	0.1850	36	74	36	R4544.7	R4534.7
	3/16	4.76	0.1874	44	82	36	R4543/16	R4533/16
12	4.80	0.1890	44	82	36	6	R4544.8	R4534.8
11	4.85	0.1909	44	82	36	6	R454N11	R453N11
	4.90	0.1929	44	82	36	6	R4544.9	R4534.9
	10	4.92	0.1937	44	82	36	R454N10	R453N10
9	4.98	0.1961	44	82	36	6	R454N9	R453N9
	5.00	0.1969	44	82	36	6	R4545.0	R4535.0
	5.05	0.1988	44	82	36	6		R4535.05
8	5.06	0.1992	44	82	36	6	R454N8	R453N8
	5.10	0.2008	44	82	36	6	R4545.1	R4535.1
	7	5.11	0.2012	44	82	36	R454N7	R453N7
13/64	5.16	0.2031	44	82	36	6	R45413/64	R45313/64
6	5.18	0.2039	44	82	36	6	R454N6	R453N6
	5.20	0.2047	44	82	36	6	R4545.2	R4535.2
	5	5.22	0.2055	44	82	36	R454N5	R453N5
4	5.30	0.2087	44	82	36	6		R4535.3
	5.31	0.2091	44	82	36	6	R454N4	R453N4
	5.40	0.2126	44	82	36	6		R4535.4
3	5.41	0.2130	44	82	36	6	R454N3	R453N3
	5.50	0.2165	44	82	36	6	R4545.5	R4535.5
	7/32	5.56	0.2189	44	82	36	R4547/32	R4537/32
2	5.60	0.2205	44	82	36	6	R4545.6	R4535.6
	5.61	0.2209	44	82	36	6	R454N2	R453N2
	5.70	0.2244	44	82	36	6	R4545.7	R4535.7
1	5.79	0.2280	44	82	36	6	R454N1	R453N1
	5.80	0.2283	44	82	36	6	R4545.8	R4535.8
	5.90	0.2323	44	82	36	6		R4535.9
A	5.94	0.2339	44	82	36	6	R454A	R453A
15/64	5.95	0.2343	44	82	36	6	R45415/64	R45315/64
	6.00	0.2362	44	82	36	6	R4546.0	R4536.0
	B	6.03	0.2374	53	91	36	R454B	R453B
C	6.05	0.2382	53	91	36	8		R4536.05
	6.10	0.2402	53	91	36	8	R4546.1	R4536.1
	6.15	0.2421	53	91	36	8	R454C	R453C
D	6.20	0.2441	53	91	36	8	R4546.2	R4536.2
	6.25	0.2461	53	91	36	8	R454D	R453D
	6.30	0.2480	53	91	36	8	R4546.3	R4536.3
1/4	6.35	0.2500	53	91	36	8	R4541/4	R4531/4
E	6.35	0.2500	53	91	36	8	R454E	R453E
	6.40	0.2520	53	91	36	8	R4546.4	R4536.4
	6.50	0.2559	53	91	36	8	R4546.5	R4536.5
F	6.53	0.2571	53	91	36	8	R454F	R453F
	6.60	0.2598	53	91	36	8	R4546.6	R4536.6
	G	6.63	0.2610	53	91	36	R454G	R453G
17/64	6.70	0.2638	53	91	36	8	R4546.7	R4536.7
	6.75	0.2657	53	91	36	8	R45417/64	R45317/64
	H	6.76	0.2661	53	91	36	R454H	R453H
I	6.80	0.2677	53	91	36	8	R4546.8	R4536.8
	6.90	0.2717	53	91	36	8	R4546.9	R4536.9
	6.91	0.2720	53	91	36	8	R454I	R453I
J	7.00	0.2756	53	91	36	8	R4547.0	R4537.0
	7.04	0.2772	53	91	36	8	R454J	R453J
	7.10	0.2795	53	91	36	8	R4547.1	R4537.1
K	7.14	0.2811	53	91	36	8	R454K	R453K
	9/32	7.14	0.2811	53	91	36	R4549/32	R4539/32

d ₁ Ø Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R454	R453
	7.20	0.2835	53	91	36	8		R4537.2
	7.30	0.2874	53	91	36	8	R4547.3	R4537.3
L	7.37	0.2902	53	91	36	8	R454L	R453L
	7.40	0.2913	53	91	36	8	R4547.4	R4537.4
M	7.49	0.2949	53	91	36	8	R454M	R453M
	7.50	0.2953	53	91	36	8	R4547.5	R4537.5
19/64	7.54	0.2969	53	91	36	8	R45419/64	R45319/64
	7.60	0.2992	53	91	36	8	R4547.6	R4537.6
N	7.67	0.3020	53	91	36	8	R454N	R453N
	7.70	0.3031	53	91	36	8	R4547.7	R4537.7
	7.80	0.3071	53	91	36	8	R4547.8	R4537.8
	7.90	0.3110	53	91	36	8	R4547.9	R4537.9
5/16	7.94	0.3126	53	91	36	8	R4545/16	R4535/16
	8.00	0.3150	53	91	36	8	R4548.0	R4538.0
O	8.03	0.3161	61	103	40	10	R454O	R453O
	8.05	0.3169	61	103	40	10		R4538.05
	8.10	0.3189	61	103	40	10	R4548.1	R4538.1
	8.20	0.3228	61	103	40	10	R4548.2	R4538.2
P	8.20	0.3228	61	103	40	10	R454P	R453P
	8.30	0.3268	61	103	40	10		R4538.3
21/64	8.33	0.3280	61	103	40	10	R45421/64	R45321/64
	8.40	0.3307	61	103	40	10	R4548.4	R4538.4
Q	8.43	0.3319	61	103	40	10	R454Q	R453Q
	8.50	0.3346	61	103	40	10	R4548.5	R4538.5
	8.60	0.3386	61	103	40	10	R4548.6	R4538.6
R	8.61	0.3390	61	103	40	10	R454R	R453R
	8.70	0.3425	61	103	40	10	R4548.7	R4538.7
11/32	8.73	0.3437	61	103	40	10	R45411/32	R45311/32
	8.80	0.3465	61	103	40	10	R4548.8	R4538.8
S	8.84	0.3480	61	103	40	10	R454S	R453S
	8.90	0.3504	61	103	40	10	R4548.9	R4538.9
	9.00	0.3543	61	103	40	10	R4549.0	R4539.0
T	9.09	0.3579	61	103	40	10	R454T	R453T
	9.10	0.3583	61	103	40	10	R4549.1	R4539.1
23/64	9.13	0.3594	61	103	40	10	R45423/64	R45323/64
	9.20	0.3622	61	103	40	10		R4539.2
	9.30	0.3661	61	103	40	10	R4549.3	R4539.3
U	9.35	0.3681	61	103	40	10	R454U	R453U
	9.40	0.3701	61	103	40	10	R4549.4	R4539.4
	9.50	0.3740	61	103	40	10	R4549.5	R4539.5
3/8	9.52	0.3748	61	103	40	10	R4543/8	R4533/8
V	9.58	0.3772	61	103	40	10	R454V	R453V
	9.60	0.3780	61	103	40	10	R4549.6	R4539.6
	9.70	0.3819	61	103	40	10	R4549.7	R4539.7
	9.80	0.3858	61	103	40	10	R4549.8	R4539.8
W	9.80	0.3858	61	103	40	10	R454W	R453W
	9.90	0.3898	61	103	40	10	R4549.9	R4539.9
25/64	9.92	0.3906	61	103	40	10	R45425/64	R45325/64
	10.00	0.3937	61	103	40	10	R45410.0	R45310.0
	10.05	0.3957	70	118	45	12		R45310.05
X	10.08	0.3969	70	118	45	12	R454X	R453X
	10.10	0.3976	70	118	45	12	R45410.1	R45310.1
	10.20	0.4016	70	118	45	12	R45410.2	R45310.2
Y	10.26	0.4039	70	118	45	12	R454Y	R453Y
	10.30	0.4055	70	118	45	12	R45410.3	R45310.3
13/32	10.32	0.4063	70	118	45	12	R45413/32	R45313/32
	10.40	0.4094	70	118	45	12	R45410.4	R45310.4
Z	10.49	0.4130	70	118	45	12	R454Z	R453Z
	10.50	0.4134	70	118	45	12	R45410.5	R45310.5
	10.60	0.4173	70	118	45	12	R45410.6	R45310.6
27/64	10.72	0.4220	70	118	45	12	R45427/64	R45327/64
	10.80	0.4252	70	118	45	12		R45310.8
	11.00	0.4331	70	118	45	12	R45411.0	R45311.0
7/16	11.11	0.4374	70	118	45	12	R4547/16	R4537/16
	11.20	0.4409	70	118	45	12	R45411.2	R45311.2
	11.30	0.4449	70	118	45	12		R45311.3
	11.40	0.4488	70	118	45	12	R45411.4	R45311.4
	11.50	0.4528	70	118	45	12	R45411.5	R45311.5

d ₁ Ø Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R454	R453
29/64	11.51	0.4531	70	118	45	12	R45429/64	R45329/64
	11.60	0.4567	70	118	45	12	R45411.6	R45311.6
	11.80	0.4646	70	118	45	12	R45411.8	R45311.8
15/32	11.91	0.4689	70	118	45	12	R45415/32	R45315/32
	12.00	0.4724	70	118	45	12	R45412.0	R45312.0
	12.05	0.4744	76	124	45	14		R45312.05
	12.10	0.4764	76	124	45	14	R45412.1	
	12.20	0.4803	76	124	45	14	R45412.2	R45312.2
31/64	12.30	0.4843	76	124	45	14	R45431/64	R45331/64
	12.50	0.4921	76	124	45	14	R45412.5	R45312.5
	12.70	0.5000	76	124	45	14	R45412.7	R45312.7
1/2	12.70	0.5000	76	124	45	14	R4541/2	R4531/2
	12.80	0.5039	76	124	45	14	R45412.8	R45312.8
	13.00	0.5118	76	124	45	14	R45413.0	R45313.0
33/64	13.10	0.5157	76	124	45	14	R45433/64	R45333/64
	13.30	0.5236	76	124	45	14		R45313.3
17/32	13.49	0.5311	76	124	45	14	R45417/32	R45317/32
	13.50	0.5315	76	124	45	14	R45413.5	R45313.5
	13.80	0.5433	76	124	45	14	R45413.8	R45313.8
35/64	13.89	0.5469	76	124	45	14	R45435/64	R45335/64
	14.00	0.5512	76	124	45	14	R45414.0	R45314.0
	14.25	0.5610	82	133	48	16	R45414.25	R45314.25
9/16	14.29	0.5626	82	133	48	16	R4549/16	R4539/16
	14.50	0.5709	82	133	48	16	R45414.5	R45314.5
37/64	14.68	0.5780	82	133	48	16	R45437/64	R45337/64
	14.80	0.5827	82	133	48	16	R45414.8	R45314.8
	15.00	0.5906	82	133	48	16	R45415.0	R45315.0
19/32	15.08	0.5937	82	133	48	16	R45419/32	R45319/32
	15.10	0.5945	82	133	48	16	R45415.1	R45315.1
	15.30	0.6024	82	133	48	16		R45315.3
39/64	15.48	0.6094	82	133	48	16	R45439/64	R45339/64
	15.50	0.6102	82	133	48	16	R45415.5	R45315.5
	15.80	0.6220	82	133	48	16	R45415.8	R45315.8
5/8	15.88	0.6252	82	133	48	16	R4545/8	R4535/8
	16.00	0.6299	82	133	48	16	R45416.0	R45316.0
41/64	16.27	0.6406	91	143	48	18	R45441/64	R45341/64
	16.50	0.6496	91	143	48	18	R45416.5	R45316.5
21/32	16.67	0.6563	91	143	48	18	R45421/32	R45321/32
	17.00	0.6693	91	143	48	18	R45417.0	R45317.0
43/64	17.07	0.6720	91	143	48	18	R45443/64	R45343/64
11/16	17.46	0.6874	91	143	48	18	R45411/16	R45311/16
	17.50	0.6890	91	143	48	18	R45417.5	R45317.5
	17.80	0.7008	91	143	48	18	R45417.8	R45317.8
45/64	17.86	0.7031	91	143	48	18	R45445/64	R45345/64
	18.00	0.7087	91	143	48	18	R45418.0	R45318.0
23/32	18.26	0.7189	99	153	50	20	R45423/32	R45323/32
	18.50	0.7283	99	153	50	20	R45418.5	R45318.5
47/64	18.65	0.7343	99	153	50	20	R45447/64	R45347/64
	19.00	0.7480	99	153	50	20	R45419.0	R45319.0
3/4	19.05	0.7500	99	153	50	20	R4543/4	R4533/4
	19.50	0.7677	99	153	50	20	R45419.5	R45319.5
	19.80	0.7795	99	153	50	20	R45419.8	R45319.8
	20.00	0.7874	99	153	50	20	R45420.0	R45320.0

R459 • Force X Drill Oil Feed 8xD

R459	▪	1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	3.1	3.2	3.3	3.4	7.2	7.3	7.4
		2.3	6.1	6.2	6.3	6.4	7.1									

R459

HM

DORMER

8XD

140°

TiAlN

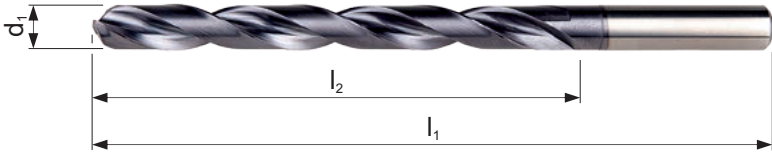
DIN 6535 HA

GTW









d ₁ Øm, Inch	d ₁ Øm, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R459
1/8	3.00	0.1181	37	79	36	6	R4593.0
	3.10	0.1220	37	79	36	6	R4593.1
	3.18	0.1252	37	79	36	6	R4591/8
	3.20	0.1260	37	79	36	6	R4593.2
	3.30	0.1299	37	79	36	6	R4593.3
9/64	3.40	0.1339	37	79	36	6	R4593.4
	3.50	0.1378	37	79	36	6	R4593.5
	3.57	0.1406	37	79	36	6	R4599/64
	3.60	0.1417	37	79	36	6	R4593.6
	3.70	0.1457	37	79	36	6	R4593.7
5/32	3.80	0.1496	48	90	36	6	R4593.8
	3.90	0.1535	48	90	36	6	R4593.9
	3.97	0.1563	48	90	36	6	R4595/32
	4.00	0.1575	48	90	36	6	R4594.0
	4.10	0.1614	48	90	36	6	R4594.1
11/64	4.20	0.1654	48	90	36	6	R4594.2
	4.30	0.1693	48	90	36	6	R4594.3
	4.37	0.1720	48	90	36	6	R45911/64
	4.40	0.1732	48	90	36	6	R4594.4
	4.50	0.1772	48	90	36	6	R4594.5
3/16	4.60	0.1811	48	90	36	6	R4594.6
	4.70	0.1850	62	104	36	6	R4594.7
	4.76	0.1874	62	104	36	6	R4593/16
	4.80	0.1890	62	104	36	6	R4594.8
	4.90	0.1929	62	104	36	6	R4594.9
13/64	5.00	0.1969	62	104	36	6	R4595.0
	5.10	0.2008	62	104	36	6	R4595.1
	5.16	0.2031	62	104	36	6	R45913/64
	5.20	0.2047	62	104	36	6	R4595.2
	5.30	0.2087	62	104	36	6	R4595.3
7/32	5.40	0.2126	62	104	36	6	R4595.4
	5.50	0.2165	62	104	36	6	R4595.5
	5.56	0.2189	62	104	36	6	R4597/32
	5.60	0.2205	62	104	36	6	R4595.6
	5.70	0.2244	62	104	36	6	R4595.7
	5.80	0.2283	62	104	36	6	R4595.8

d ₁ Øm, Inch	d ₁ Øm, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₆ mm	R459
15/64	5.90	0.2323	62	104	36	6	R4595.9
	5.95	0.2343	62	104	36	6	R45915/64
	6.00	0.2362	62	104	36	6	R4596.0
	6.10	0.2402	84	126	36	8	R4596.1
	6.20	0.2441	84	126	36	8	R4596.2
1/4	6.30	0.2480	84	126	36	8	R4596.3
	6.35	0.2500	84	126	36	8	R4591/4
	6.40	0.2520	84	126	36	8	R4596.4
	6.50	0.2559	84	126	36	8	R4596.5
	6.60	0.2598	84	126	36	8	R4596.6
17/64	6.70	0.2638	84	126	36	8	R4596.7
	6.75	0.2657	84	126	36	8	R45917/64
	6.80	0.2677	84	126	36	8	R4596.8
	6.90	0.2717	84	126	36	8	R4596.9
	7.00	0.2756	84	126	36	8	R4597.0
9/32	7.10	0.2795	84	126	36	8	R4597.1
	7.14	0.2811	84	126	36	8	R4599/32
	7.20	0.2835	84	126	36	8	R4597.2
	7.30	0.2874	84	126	36	8	R4597.3
	7.40	0.2913	84	126	36	8	R4597.4
19/64	7.50	0.2953	84	126	36	8	R4597.5
	7.54	0.2969	84	126	36	8	R45919/64
	7.60	0.2992	84	126	36	8	R4597.6
	7.70	0.3031	84	126	36	8	R4597.7
	7.80	0.3071	84	126	36	8	R4597.8
5/16	7.90	0.3110	84	126	36	8	R4597.9
	7.94	0.3126	84	126	36	8	R4595/16
	8.00	0.3150	84	126	36	8	R4598.0
	8.10	0.3189	106	152	40	10	R4598.1
	8.20	0.3228	106	152	40	10	R4598.2
21/64	8.30	0.3268	106	152	40	10	R4598.3
	8.33	0.3280	106	152	40	10	R45921/64
	8.40	0.3307	106	152	40	10	R4598.4
	8.50	0.3346	106	152	40	10	R4598.5
	8.60	0.3386	106	152	40	10	R4598.6
11/32	8.70	0.3425	106	152	40	10	R4598.7
	8.73	0.3437	106	152	40	10	R45911/32
	8.80	0.3465	106	152	40	10	R4598.8
	8.90	0.3504	106	152	40	10	R4598.9
	9.00	0.3543	106	152	40	10	R4599.0
23/64	9.10	0.3583	106	152	40	10	R4599.1
	9.13	0.3594	106	152	40	10	R45923/64
	9.20	0.3622	106	152	40	10	R4599.2
	9.30	0.3661	106	152	40	10	R4599.3
	9.40	0.3701	106	152	40	10	R4599.4
3/8	9.50	0.3740	106	152	40	10	R4599.5
	9.53	0.3748	106	152	40	10	R4593/8
	9.60	0.3780	106	152	40	10	R4599.6
	9.70	0.3819	106	152	40	10	R4599.7
	9.80	0.3858	106	152	40	10	R4599.8
25/64	9.90	0.3898	106	152	40	10	R4599.9
	9.92	0.3906	106	152	40	10	R45925/64
	10.00	0.3937	106	152	40	10	R45910.0
	10.20	0.4016	128	180	45	12	R45910.2
	10.30	0.4055	128	180	45	12	R45910.3
13/32	10.32	0.4063	128	180	45	12	R45913/32
	10.40	0.4094	128	180	45	12	R45910.4
	10.50	0.4134	128	180	45	12	R45910.5
	10.72	0.4220	128	180	45	12	R45927/64
	10.80	0.4252	128	180	45	12	R45910.8
7/16	11.00	0.4331	128	180	45	12	R45911.0
	11.11	0.4374	128	180	45	12	R4597/16
	11.20	0.4409	128	180	45	12	R45911.2
	11.30	0.4449	128	180	45	12	R45911.3
	11.50	0.4528	128	180	45	12	R45911.5
29/64	11.51	0.4531	128	180	45	12	R45929/64
	11.80	0.4646	128	180	45	12	R45911.8
	11.91	0.4689	128	180	45	12	R45915/32

d ₁ Øm, Inch	d ₁ Øm, mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Øh ₈ mm	R459
	12.00	0.4724	128	180	45	12	R45912.0
	12.20	0.4803	151	202	48	14	R45912.2
31/64	12.30	0.4843	151	202	48	14	R45931/64
	12.50	0.4921	151	202	48	14	R45912.5
1/2	12.70	0.5000	151	202	48	14	R4591/2
	12.80	0.5039	151	202	48	14	R45912.8
	13.00	0.5118	151	202	48	14	R45913.0
33/64	13.10	0.5157	151	202	48	14	R45933/64
17/32	13.49	0.5311	151	202	48	14	R45917/32
	13.50	0.5315	151	202	48	14	R45913.5
35/64	13.89	0.5469	151	202	48	14	R45935/64
	14.00	0.5512	151	202	48	14	R45914.0
	14.25	0.5610	172	227	48	16	R45914.25
9/16	14.29	0.5626	172	227	48	16	R4599/16
	14.50	0.5709	172	227	48	16	R45914.5
37/64	14.68	0.5780	172	227	48	16	R45937/64
	15.00	0.5906	172	227	48	16	R45915.0
19/32	15.08	0.5937	172	227	48	16	R45919/32
	15.10	0.5945	172	227	48	16	R45915.1
39/64	15.48	0.6094	172	227	48	16	R45939/64
	15.50	0.6102	172	227	48	16	R45915.5
5/8	15.88	0.6252	172	227	48	16	R4595/8
	16.00	0.6299	172	227	48	16	R45916.0



REPLACEABLE HEAD DRILLS



HYDRA

HIGH PERFORMANCE REPLACEABLE HEAD DRILLS

INTRODUCTION

Dormer Pramet have complemented their current Hydra drilling range by introducing a **new geometry specifically for Cast Iron materials**.

This is in addition to the current Steel and Stainless Steel geometries, and will fit existing Hydra drill bodies

FEATURES AND BENEFITS

- **Consistently high performance**, even after numerous head changes
- **Reduction in inventory costs** – one drill body fits multiple head sizes
- **Easy and quick head changes** with minimal interruptions to the production process. Heads can be changed without removing the body from the machine
- Exact fit of head to body maximises tool rigidity for **superior hole accuracy** and precise tolerances.

MATERIAL

Premium Micrograin Carbide

- Micrograin carbide provides an excellent combination of hardness and toughness, resulting in high wear resistance and longer tool life

COATING

Titanium Aluminium Nitride based coating provides:

- High toughness and oxidation resistance
- Outstanding wear protection in abrasive materials like Cast Iron
- High hardness at high temperatures created when drilling Cast Irons
- Increased tool life and productivity

HEAD TYPES



R950

STEEL



R960

STAINLESS STEEL



NEW

R970

CAST IRON

HYDRA

HIGH PERFORMANCE REPLACEABLE HEAD DRILLS

GEOMETRY

Corner Design

- A strong corner design increases stability during drilling and reduces the forces encountered during breakthrough of the exit surface
- This improves the quality of the exit surface and helps prevent “exit burst” which can occur when drilling granular materials

Point Geometry

- 140 degree split point geometry provides good centering capabilities and low thrust forces when drilling most materials

A COMPLETE RANGE

- Available in 3xØ, 5xØ and 8xØ lengths incorporating coolant holes to improve cutting efficiency and swarf evacuation, resulting in higher productivity
- Metric 12.00mm to 42.00mm
- Fractional 15/32inch to 1.5/8inch



	HM	HM	HM	HSS	HSS	HSS			
									
				3XD	5XD	8XD			
									
									
				DIN 6535HB DIN 6535HE	DIN 6535HB DIN 6535HE	DIN 6535HE			
									
									
									
									
	R950	R960	R970	H853	H855	H858	H860	H861	
	15/32 - 42.00	15/32 - 30.50	15/32 - 42.00	12.00 - 42.50	12.00 - 42.50	14.00 - 42.50	N1 - N7	N1 - N6	
									
									ISO
1.1	● 110W	■ 110W							P 1
1.2	● 100W	■ 100W							P 1
1.3	■ 100W								P 2
1.4	■ 85W								P 3
1.5	■ 85W								P 4
1.6	■ 60W								H 1
1.7									H 3
1.8									H 4
2.1		■ 60V							M 1
2.2		■ 50T							M 3
2.3		■ 40T							M 2
2.4	● 35T	● 35T							S 2
3.1		■ 120V	■ 120V						K 1
3.2		■ 116V	■ 116V						K 2
3.3	■ 88V	● 88V	■ 80V						K 3
3.4	■ 88V	● 88V	■ 80V						K 4
4.1		● 45T							S 1
4.2		● 35T							S 2
4.3		● 30S							S 3
5.1		● 35T							S 1
5.2		● 30S							S 2
5.3		● 25S							S 3
6.1									N 3
6.2									N 4
6.3									N 3
6.4									N 4
7.1									N 1
7.2									N 1
7.3									N 1
7.4									N 2
8.1									O
8.2									O
8.3									O
9.1									H
10.1									O

							
Ø(D)	12mm	15mm	16mm	20mm	25mm	30mm	40mm
S	0.100	0.123	0.130	0.150	0.170	0.190	0.220
T	0.130	0.160	0.170	0.190	0.210	0.230	0.260
U	0.200	0.223	0.230	0.240	0.270	0.300	0.360
V	0.280	0.310	0.320	0.340	0.400	0.440	0.510
W	0.380	0.418	0.430	0.450	0.470	0.490	0.520
mm/REV ± 25%							

- Hydra Drill Head for Steel

Four (4) screws and one (1) screwdriver are included with a drill body

- Hydra Drill Head for Stainless Steel

Four (4) screws and one (1) screwdriver are included with a drill body

- Hydra Drill Head for Cast Iron

Four (4) screws and one (1) screwdriver are included with a drill body

R950	▪	1.3	1.4	1.5	1.6	3.3	3.4			
	•	1.1	1.2	2.4						
R960	▪	1.1	1.2	2.1	2.2	2.3	3.1	3.2		
	•	2.4	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3
R970	▪	3.1	3.2	3.3	3.4					

R950								
R960	HM	DORMER		140°	Ti-phon			
R970								



R950	R960	R970
		
		
15/32 - 42.00	15/32 - 30.50	15/32 - 42.00

d ₁ Øh ₇ Inch	d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₁ mm	R950	R960	R970
15/32	11.91	0.4688	9.1	R95015/32	R96015/32	R97015/32
31/64	12.00	0.4724	9.1	R95012.0	R96012.0	R97012.0
	12.10	0.4764	9.1	R95012.1	R96012.1	R97012.1
	12.20	0.4803	9.1	R95012.2	R96012.2	R97012.2
	12.30	0.4844	9.1	R95031/64	R96031/64	R97031/64
	12.50	0.4921	9.4	R95012.5	R96012.5	R97012.5
1/2	12.60	0.4961	9.4	R95012.6	R96012.6	R97012.6
	12.70	0.5000	9.4	R9501/2	R9601/2	R9701/2
	12.80	0.5039	9.4	R95012.8	R96012.8	R97012.8
33/64	12.90	0.5079	9.4	R95012.9	R96012.9	R97012.9
	13.00	0.5118	9.7	R95013.0	R96013.0	R97013.0
	13.10	0.5156	9.7	R95033/64	R96033/64	R97033/64
17/32	13.20	0.5197	9.7	R95013.2	R96013.2	R97013.2
	13.49	0.5313	9.7	R95017/32	R96017/32	R97017/32
35/64	13.50	0.5315	10.3	R95013.5	R96013.5	R97013.5
	13.60	0.5354	10.3	R95013.6	R96013.6	R97013.6
	13.70	0.5394	10.3	R95013.7	R96013.7	R97013.7
	13.80	0.5433	10.3	R95013.8	R96013.8	R97013.8
	13.89	0.5469	10.3	R95035/64	R96035/64	R97035/64
9/16	14.00	0.5512	10.3	R95014.0	R96014.0	R97014.0
	14.10	0.5551	10.3	R95014.1	R96014.1	R97014.1
	14.20	0.5591	10.3	R95014.2	R96014.2	R97014.2
	14.29	0.5625	10.3	R9509/16	R9609/16	R9709/16
37/64	14.50	0.5709	10.3	R95014.5	R96014.5	R97014.5
	14.60	0.5748	11.0	R95014.6	R96014.6	R97014.6
	14.68	0.5781	11.0	R95037/64	R96037/64	R97037/64
	14.70	0.5787	11.0	R95014.7	R96014.7	R97014.7
	14.80	0.5827	11.0	R95014.8	R96014.8	R97014.8
19/32	15.00	0.5906	11.0	R95015.0	R96015.0	R97015.0
	15.08	0.5938	11.0	R95019/32	R96019/32	R97019/32
	15.10	0.5945	11.0	R95015.1	R96015.1	R97015.1
	15.20	0.5984	11.0	R95015.2	R96015.2	R97015.2

d ₁ Øh ₇ Inch	d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₁ mm	R950	R960	R970
39/64	15.48	0.6094	11.0	R95039/64	R96039/64	R97039/64
	15.50	0.6102	11.0	R95015.5	R96015.5	R97015.5
	15.60	0.6142	11.6	R95015.6	R96015.6	R97015.6
5/8	15.70	0.6181	11.6	R95015.7	R96015.7	R97015.7
	15.88	0.6250	11.6	R9505/8	R9605/8	R9705/8
	16.00	0.6299	11.6	R95016.0	R96016.0	R97016.0
41/64	16.10	0.6339	11.6	R95016.1	R96016.1	R97016.1
	16.20	0.6378	11.6	R95016.2	R96016.2	R97016.2
	16.27	0.6406	11.6	R95041/64	R96041/64	R97041/64
21/32	16.50	0.6496	11.6	R95016.5	R96016.5	R97016.5
	16.60	0.6535	12.2	R95016.6	R96016.6	R97016.6
	16.67	0.6563	12.2	R95021/32	R96021/32	R97021/32
43/64	16.70	0.6575	12.2	R95016.7	R96016.7	R97016.7
	17.00	0.6693	12.2	R95017.0	R96017.0	R97017.0
	17.07	0.6719	12.2	R95043/64	R96043/64	R97043/64
11/16	17.10	0.6732	12.2	R95017.1	R96017.1	R97017.1
	17.20	0.6772	12.2	R95017.2	R96017.2	R97017.2
	17.46	0.6875	12.2	R95011/16	R96011/16	R97011/16
45/64	17.50	0.6890	12.2	R95017.5	R96017.5	R97017.5
	17.60	0.6929	12.9	R95017.6	R96017.6	R97017.6
	17.70	0.6969	12.9	R95017.7	R96017.7	R97017.7
23/32	17.86	0.7031	12.9	R95045/64	R96045/64	R97045/64
	18.00	0.7087	12.9	R95018.0	R96018.0	R97018.0
	18.10	0.7126	12.9	R95018.1	R96018.1	R97018.1
47/64	18.20	0.7165	12.9	R95018.2	R96018.2	R97018.2
	18.26	0.7188	12.9	R95023/32	R96023/32	R97023/32
	18.50	0.7283	12.9	R95018.5	R96018.5	R97018.5
3/4	18.60	0.7323	13.5	R95018.6	R96018.6	R97018.6
	18.65	0.7344	13.5	R95047/64	R96047/64	R97047/64
	18.70	0.7362	13.5	R95018.7	R96018.7	R97018.7
49/64	18.90	0.7441	13.5	R95018.9	R96018.9	R97018.9
	19.00	0.7480	13.5	R95019.0	R96019.0	R97019.0
	19.05	0.7500	13.5	R9503/4	R9603/4	R9703/4
25/32	19.10	0.7520	13.5	R95019.1	R96019.1	R97019.1
	19.20	0.7559	13.5	R95019.2	R96019.2	R97019.2
	19.25	0.7579	13.5	R95019.25	R96019.25	R97019.25
51/64	19.45	0.7656	13.5	R95049/64	R96049/64	R97049/64
	19.50	0.7677	13.5	R95019.5	R96019.5	R97019.5
	19.60	0.7717	14.1	R95019.6	R96019.6	R97019.6
13/16	19.70	0.7756	14.1	R95019.7	R96019.7	R97019.7
	19.84	0.7813	14.1	R95025/32	R96025/32	R97025/32
	20.00	0.7874	14.1	R95020.0	R96020.0	R97020.0
53/64	20.24	0.7969	14.1	R95051/64	R96051/64	R97051/64
	20.50	0.8071	14.1	R95020.5	R96020.5	R97020.5
	20.64	0.8125	14.8	R95013/16	R96013/16	R97013/16
27/32	21.00	0.8268	14.8	R95021.0	R96021.0	R97021.0
	21.03	0.8281	14.8	R95053/64	R96053/64	R97053/64
	21.43	0.8438	14.8	R95027/32	R96027/32	R97027/32
55/64	21.50	0.8465	14.8	R95021.5	R96021.5	R97021.5
	21.83	0.8594	15.0	R95055/64	R96055/64	R97055/64
	22.00	0.8661	15.0	R95022.0	R96022.0	R97022.0
7/8	22.22	0.8750	15.0	R9507/8	R9607/8	R9707/8
	22.50	0.8858	15.0	R95022.5	R96022.5	R97022.5
	22.62	0.8906	15.0	R95057/64	R96057/64	R97057/64
57/64	22.70	0.8937	15.0	R95022.7	R96022.7	R97022.7
	23.00	0.9055	15.1	R95023.0	R96023.0	R97023.0
	23.02	0.9063	15.1	R95029/32	R96029/32	R97029/32
29/32	23.42	0.9219	15.1	R95059/64	R96059/64	R97059/64
	23.50	0.9252	15.1	R95023.5	R96023.5	R97023.5
	23.81	0.9375	15.4	R95015/16	R96015/16	R97015/16
61/64	24.00	0.9449	15.4	R95024.0	R96024.0	R97024.0
	24.21	0.9531	15.4	R95061/64	R96061/64	R97061/64
	24.50	0.9646	15.4	R95024.5	R96024.5	R97024.5
31/32	24.61	0.9688	15.4	R95031/32	R96031/32	R97031/32
	25.00	0.9844	15.8	R95025.0	R96025.0	R97025.0
	25.00	0.9844	15.8	R95025.0	R96025.0	R97025.0
63/64	25.00	0.9844	15.8	R95025.0	R96025.0	R97025.0
	25.40	1.0000	15.8	R9501	R9601	R9701
1"	25.50	1.0039	15.8	R95025.5	R96025.5	R97025.5

d ₁ Øh ₇ Inch	d ₁ Øh ₇ mm	d ₁ decimal Inch	l ₁ mm	R950	R960	R970
1.1/64	25.65	1.0098	15.8	R95025.65	R96025.65	R97025.65
	25.80	1.0156	15.8	R9501.1/64	R9601.1/64	R9701.1/64
	26.00	1.0236	16.4	R95026.0	R96026.0	R97026.0
1.1/32	26.19	1.0313	16.4	R9501.1/32	R9601.1/32	R9701.1/32
	26.50	1.0433	16.4	R95026.5	R96026.5	R97026.5
	26.59	1.0469	16.4	R9501.3/64	R9601.3/64	R9701.3/64
1.3/64	26.99	1.0625	17.1	R9501.1/16	R9601.1/16	R9701.1/16
	27.00	1.0630	17.1	R95027.0	R96027.0	R97027.0
	27.38	1.0781	17.1	R9501.5/64	R9601.5/64	R9701.5/64
1.3/32	27.50	1.0827	17.1	R95027.5	R96027.5	R97027.5
	27.78	1.0938	17.1	R9501.3/32	R9601.3/32	R9701.3/32
	28.00	1.1024	17.7	R95028.0	R96028.0	R97028.0
1.7/64	28.18	1.1094	17.7	R9501.7/64	R9601.7/64	R9701.7/64
	28.50	1.1220	17.7	R95028.5	R96028.5	R97028.5
	28.58	1.1250	17.7	R9501.1/8	R9601.1/8	R9701.1/8
1.9/64	28.97	1.1406	18.3	R9501.9/64	R9601.9/64	R9701.9/64
	29.00	1.1417	18.3	R95029.0	R96029.0	R97029.0
	29.37	1.1563	18.3	R9501.5/32	R9601.5/32	R9701.5/32
1.5/32	29.50	1.1614	18.3	R95029.5	R96029.5	R97029.5
	29.77	1.1719	18.3	R9501.11/64	R9601.11/64	R9701.11/64
	30.00	1.1811	19.0	R95030.0	R96030.0	R97030.0
1.11/64	30.16	1.1875	19.0	R9501.3/16	R9601.3/16	R9701.3/16
	30.50	1.2008	19.0	R95030.5	R96030.5	R97030.5
	30.96	1.2188	21.0	R9501.7/32	-	R9701.7/32
1.3/16	31.00	1.2205	21.0	R95031.0	-	R97031.0
	31.75	1.2500	21.0	R9501.1/4	-	R9701.1/4
	32.00	1.2598	21.0	R95032.0	-	R97032.0
1.7/32	32.50	1.2795	21.0	R95032.5	-	R97032.5
	32.94	1.2969	21.0	R9501.19/64	-	R9701.19/64
	33.00	1.2992	21.0	R95033.0	-	R97033.0
1.19/64	33.50	1.3189	21.0	R95033.5	-	R97033.5
	34.00	1.3386	23.0	R95034.0	-	R97034.0
	34.13	1.3438	23.0	R9501.11/32	-	R9701.11/32
1.3/8	34.50	1.3583	23.0	R95034.5	-	R97034.5
	34.93	1.3750	23.0	R9501.3/8	-	R9701.3/8
	35.00	1.3780	23.0	R95035.0	-	R97035.0
1.27/64	36.00	1.4173	23.0	R95036.0	-	R97036.0
	36.12	1.4219	23.0	R9501.27/64	-	R9701.27/64
	36.50	1.4370	23.0	R95036.5	-	R97036.5
1.15/32	37.00	1.4567	25.0	R95037.0	-	R97037.0
	37.31	1.4688	25.0	R9501.15/32	-	R9701.15/32
	37.50	1.4764	25.0	R95037.5	-	R97037.5
1.1/2	38.00	1.4961	25.0	R95038.0	-	R97038.0
	38.10	1.5000	25.0	R9501.1/2	-	R9701.1/2
	38.50	1.5157	25.0	R95038.5	-	R97038.5
1.17/32	38.89	1.5313	25.0	R9501.17/32	-	R9701.17/32
	39.00	1.5354	25.0	R95039.0	-	R97039.0
	39.50	1.5551	25.0	R95039.5	-	R97039.5
1.9/16	39.69	1.5625	27.0	R9501.9/16	-	R9701.9/16
	40.00	1.5748	27.0	R95040.0	-	R97040.0
	41.00	1.6142	27.0	R95041.0	-	R97041.0
1.5/8	41.28	1.6250	27.0	R9501.5/8	-	R9701.5/8
	42.00	1.6535	27.0	R95042.0	-	R97042.0

H853 • Hydra Body 3xD

H855 • Hydra Body 5xD

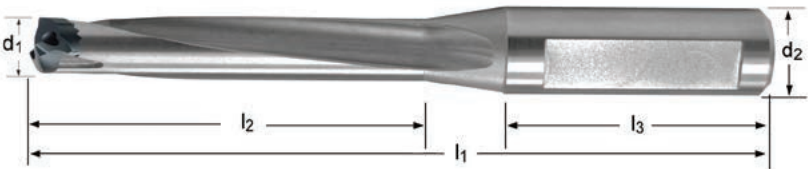
H858 • Hydra Body 8xD

Four (4) screws and one (1) screwdriver are included with a drill body

Four (4) screws and one (1) screwdriver are included with a drill body

Four (4) screws and one (1) screwdriver are included with a drill body

H853	HSS		3XD			DIN 6535HB DIN 6535HE			
H855	HSS		5XD			DIN 6535HB DIN 6535HE			
H858	HSS		8XD			DIN 6535HE			



H853	H855	H858
		
		
12.0 - 42.5	12.0 - 42.5	14.0 - 42.5

d ₂ Øh ₆ Inch	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm			H853	H855	H858
	16.00	44.0	105.0	48.0	H860N1	H861N1	H85312.0		
	16.00	69.0	130.0	48.0	H860N1	H861N1		H85512.0	
5/8	15.88	44.0	105.0	48.0	H860N1	H861N1	H85331/64		
5/8	15.88	69.0	130.0	48.0	H860N1	H861N1		H85531/64	
	16.00	44.0	105.0	48.0	H860N1	H861N1	H85312.5		
	16.00	69.0	130.0	48.0	H860N1	H861N1		H85512.5	
5/8	15.88	44.0	105.0	48.0	H860N1	H861N1	H8531/2		
5/8	15.88	69.0	130.0	48.0	H860N1	H861N1		H8551/2	
	16.00	47.0	110.0	48.0	H860N1	H861N1	H85313.0		
	16.00	74.0	140.0	48.0	H860N1	H861N1		H85513.0	
5/8	15.88	47.0	110.0	48.0	H860N1	H861N1	H85317/32		
5/8	15.88	74.0	140.0	48.0	H860N1	H861N1		H85517/32	
	16.00	52.5	116.5	48.0	H860N1	H861N1	H85314.0		
	16.00	81.5	146.5	48.0	H860N1	H861N1		H85514.0	
	16.00	124.5	191.5	48.0	H860N1	H861N1			H85814.0
3/4	19.05	52.5	116.5	48.0	H860N1	H861N1	H8539/16		
3/4	19.05	81.5	146.5	48.0	H860N1	H861N1		H8559/16	
	20.00	55.5	126.5	50.0	H860N1	H861N1	H85315.0		
	20.00	86.5	156.5	50.0	H860N1	H861N1		H85515.0	
	20.00	133.5	201.5	50.0	H860N1	H861N1			H85815.0
3/4	19.05	55.5	126.5	50.0	H860N1	H861N1	H85339/64		
3/4	19.05	86.5	156.5	50.0	H860N1	H861N1		H85539/64	
	20.00	59.5	131.5	50.0	H860N2	H861N2	H85316.0		
	20.00	92.5	166.5	50.0	H860N2	H861N2		H85516.0	
	20.00	141.5	211.5	50.0	H860N2	H861N2			H85816.0
3/4	19.05	59.5	131.5	50.0	H860N2	H861N2	H85341/64		

d ₂ Øh ₆ Inch	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm			H853	H855	H858
3/4	19.05	92.5	166.5	50.0	H860N2	H861N2		H85541/64	
	20.00	62.5	136.5	50.0	H860N2	H861N2	H85317.0		
	20.00	97.5	171.5	50.0	H860N2	H861N2		H85517.0	
	20.00	150.5	221.5	50.0	H860N2	H861N2			H85817.0
3/4	19.05	62.5	136.5	50.0	H860N2	H861N2	H85311/16		
3/4	19.05	97.5	171.5	50.0	H860N2	H861N2		H85511/16	
	20.00	66.5	141.5	50.0	H860N2	H861N2	H85318.0		
	20.00	103.5	176.5	50.0	H860N2	H861N2		H85518.0	
	20.00	158.5	226.5	50.0	H860N2	H861N2			H85818.0
3/4	19.05	66.5	141.5	50.0	H860N2	H861N2	H85323/32		
3/4	19.05	103.5	176.5	50.0	H860N2	H861N2		H85523/32	
	25.00	69.5	156.5	56.0	H860N3	H861N3	H85319.0		
	25.00	108.5	191.5	56.0	H860N3	H861N3		H85519.0	
	25.00	167.5	251.5	56.0	H860N3	H861N3			H85819.0
1"	25.40	69.5	156.5	56.0	H860N3	H861N3	H85349/64		
1"	25.40	108.5	191.5	56.0	H860N3	H861N3		H85549/64	
	25.00	73.5	156.5	56.0	H860N3	H861N3	H85320.0		
	25.00	114.5	196.5	56.0	H860N3	H861N3		H85520.0	
	25.00	175.5	264.5	56.0	H860N3	H861N3			H85820.0
1"	25.40	73.5	156.5	56.0	H860N3	H861N3	H85351/64		
1"	25.40	114.5	196.5	56.0	H860N3	H861N3		H85551/64	
	25.00	76.5	156.5	56.0	H860N3	H861N3	H85321.0		
	25.00	119.5	196.5	56.0	H860N3	H861N3		H85521.0	
	25.00	184.5	266.5	56.0	H860N3	H861N3			H85821.0
1"	25.40	76.5	156.5	56.0	H860N3	H861N3	H85327/32		
1"	25.40	119.5	196.5	56.0	H860N3	H861N3		H85527/32	
	25.00	80.1	161.5	56.0	H860N4	H861N3	H85322.0		
	25.00	125.1	201.1	56.0	H860N4	H861N3		H85522.0	
	25.00	192.1	271.1	56.0	H860N4	H861N3			H85822.0
1"	25.40	80.1	161.5	56.0	H860N4	H861N3	H85357/64		
1"	25.40	125.1	201.1	56.0	H860N4	H861N3		H85557/64	
	25.00	82.5	160.5	56.0	H860N4	H861N3	H85323.0		
	25.00	129.5	210.5	56.0	H860N4	H861N3		H85523.0	
	25.00	200.5	280.5	56.0	H860N4	H861N3			H85823.0
1"	25.40	82.5	160.5	56.0	H860N4	H861N3	H85359/64		
1"	25.40	129.5	210.5	56.0	H860N4	H861N3		H85559/64	
	32.00	86.2	170.2	60.0	H860N4	H861N3	H85324.0		
	32.00	135.2	220.2	60.0	H860N4	H861N3		H85524.0	
	32.00	208.2	295.2	60.0	H860N4	H861N3			H85824.0
1"	25.40	86.2	170.2	60.0	H860N4	H861N3	H85331/32		
1"	25.40	135.2	220.2	60.0	H860N4	H861N3		H85531/32	
	32.00	88.0	170.0	60.0	H860N5	H861N4	H85325.0		
	32.00	140.0	225.0	60.0	H860N5	H861N4		H85525.0	
	32.00	217.0	300.0	60.0	H860N5	H861N4			H85825.0
1.1/4	31.75	88.0	170.0	60.0	H860N5	H861N4	H8531.1/64		
1.1/4	31.75	140.0	225.0	60.0	H860N5	H861N4		H8551.1/64	
	32.00	92.0	175.0	60.0	H860N5	H861N4	H85326.0		
	32.00	146.0	230.0	60.0	H860N5	H861N4		H85526.0	
	32.00	225.0	310.0	60.0	H860N5	H861N4			H85826.0
1.1/4	31.75	92.0	175.0	60.0	H860N5	H861N4	H8531.3/64		
1.1/4	31.75	146.0	230.0	60.0	H860N5	H861N4		H8551.3/64	
	32.00	94.0	175.0	60.0	H860N5	H861N4	H85327.0		
	32.00	151.0	235.0	60.0	H860N5	H861N4		H85527.0	
	32.00	234.0	320.0	60.0	H860N5	H861N4			H85827.0
1.1/4	31.75	94.0	175.0	60.0	H860N5	H861N4	H8531.3/32		
1.1/4	31.75	151.0	235.0	60.0	H860N5	H861N4		H8551.3/32	
	32.00	97.0	180.0	60.0	H860N6	H861N5	H85328.0		
	32.00	157.0	240.0	60.0	H860N6	H861N5		H85528.0	
	32.00	242.0	325.0	60.0	H860N6	H861N5			H85828.0
1.1/4	31.75	97.0	180.0	60.0	H860N6	H861N5	H8531.1/8		

d ₂ Øh ₆ Inch	d ₂ Øh ₆ mm	l ₂ mm	l ₁ mm	l ₃ mm			H853	H855	H858
1.1/4	31.75	157.0	240.0	60.0	H860N6	H861N5		H8551.1/8	
	32.00	100.0	185.0	60.0	H860N6	H861N5	H85329.0		
	32.00	162.0	245.0	60.0	H860N6	H861N5		H85529.0	
	32.00	251.0	335.0	60.0	H860N6	H861N5			H85829.0
1.1/4	31.75	100.0	185.0	60.0	H860N6	H861N5	H8531.11/64		
1.1/4	31.75	162.0	245.0	60.0	H860N6	H861N5		H8551.11/64	
	32.00	104.0	185.0	60.0	H860N6	H861N5	H85330.0		
	32.00	167.0	255.0	60.0	H860N6	H861N5		H85530.0	
	32.00	259.0	345.0	60.0	H860N6	H861N5			H85830.0
1.1/4	31.75	104.0	185.0	60.0	H860N6	H861N5	H8531.3/16		
1.1/4	31.75	167.0	255.0	60.0	H860N6	H861N5		H8551.3/16	
	32.00	111.5	196.5	60.0	H860N6	H861N5	H85332.0		
	32.00	176.5	261.5	60.0	H860N6	H861N5		H85532.0	
	32.00	271.5	356.5	60.0	H860N6	H861N5			H85832.0
	40.00	116.5	201.5	60.0	H860N6	H861N5	H85333.5		
	40.00	186.5	271.5	60.0	H860N6	H861N5		H85533.5	
	40.00	286.5	371.5	60.0	H860N6	H861N5			H85833.5
	40.00	121.5	216.5	70.0	H860N7	H861N6	H85335.0		
	40.00	196.5	291.5	70.0	H860N7	H861N6		H85535.0	
	40.00	301.5	396.5	70.0	H860N7	H861N6			H85835.0
	40.00	125.5	221.5	70.0	H860N7	H861N6	H85336.5		
	40.00	201.5	296.5	70.0	H860N7	H861N6		H85536.5	
	40.00	311.5	406.5	70.0	H860N7	H861N6			H85836.5
	40.00	131.5	226.5	70.0	H860N7	H861N6	H85338.0		
	40.00	211.5	306.5	70.0	H860N7	H861N6		H85538.0	
	40.00	326.5	421.5	70.0	H860N7	H861N6			H85838.0
	40.00	136.5	231.5	70.0	H860N7	H861N6	H85339.5		
	40.00	221.5	316.5	70.0	H860N7	H861N6		H85539.5	
	40.00	336.5	431.5	70.0	H860N7	H861N6			H85839.5
	40.00	146.5	246.5	70.0	H860N7	H861N6	H85341.0		
	40.00	226.5	325.6	70.0	H860N7	H861N6		H85541.0	
	40.00	351.5	451.5	70.0	H860N7	H861N6			H85841.0
	40.00	151.6	251.6	70.0	H860N7	H861N6	H85342.5		
	40.00	236.5	336.5	70.0	H860N7	H861N6		H85542.5	
	40.00	361.5	461.5	70.0	H860N7	H861N6			H85842.5

ICON DESCRIPTIONS

Material						
	Carbide		High Speed Steel			
Coating						
	Bright		Titanium Nitride		Titanium Aluminium Nitride	
Direction						
	Right					
Rating						
	Excellent		Good			
Depth						
Point Angle						
Form						
			Continuously Thinned Web			
Standard						

Shank	 Straight Shank	 DIN 6535 HA	 DIN 6535 HE
	 DIN 6535 HB / HE		
Countersink °	 Centre 60°		
Coolant	 Internal Coolant		

SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **simply reliable**.

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