



New carbide drill series

AD & ADO SERIES

Volume 4



NEW COATING • AD-ADO NEW SERIES • NEW COATING •
78
NEW DIN
SHANK SIZES
ADDED
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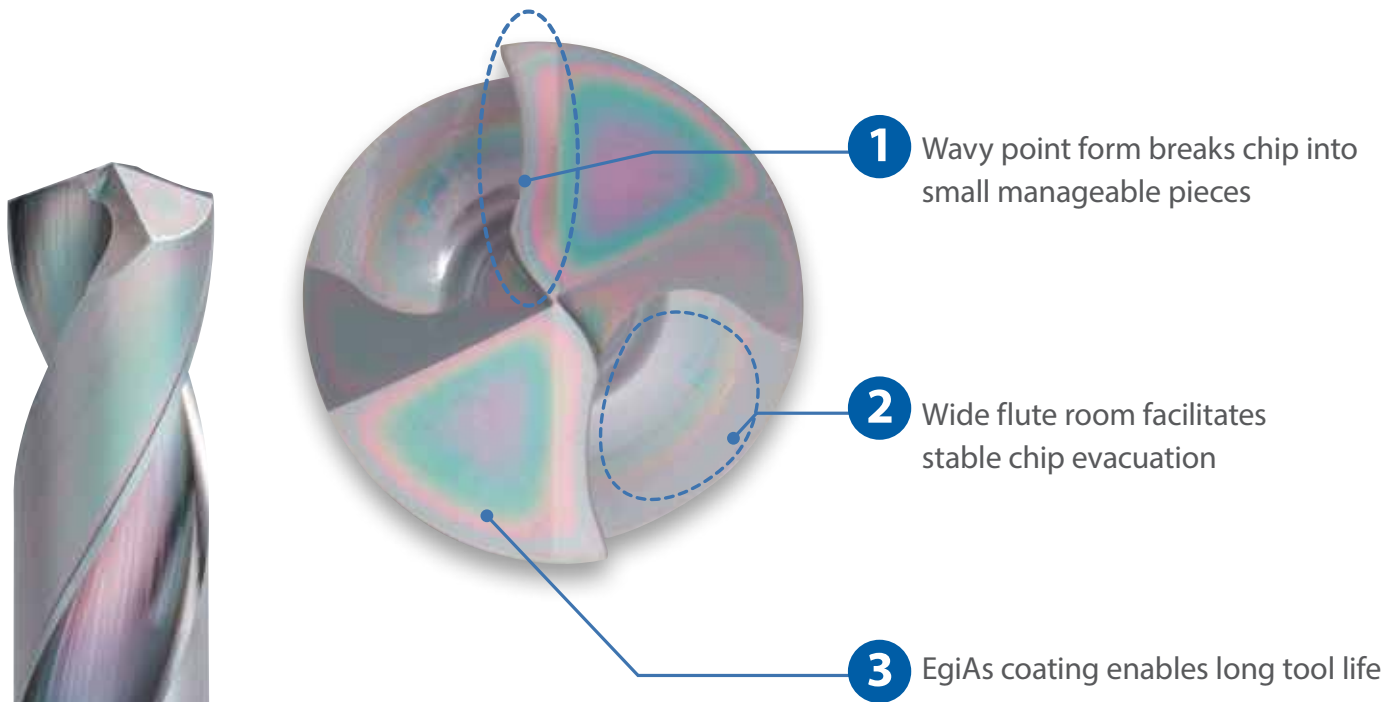
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CARBIDE DRILL (WITHOUT OIL HOLE)



EgiAs Coating

EgiAs coating with high toughness and wear resistance characteristics

Constructed with extreme toughness, high wear and heat resistance characteristics to ensure stable and consistent tool life. See figure 1.

EgiAs

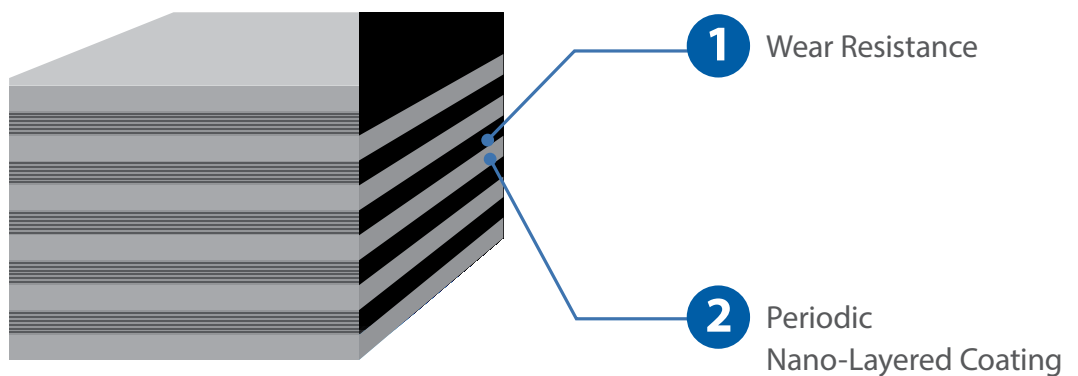


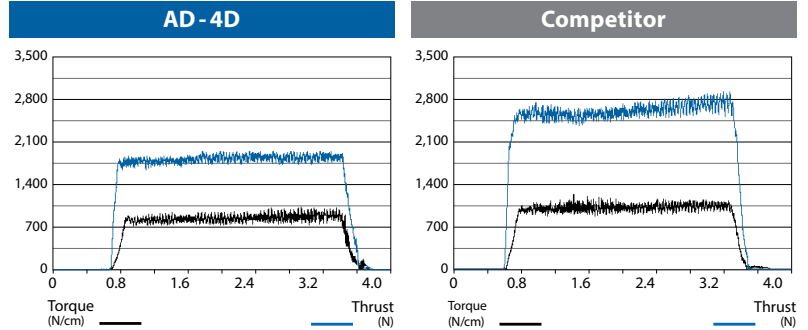
Figure 1. Coating structure

Coating Color	Coating Structure	(Hv) Hardness	(c°) Oxidation Temperature	Heat Resistance	Adhesion Strength	Wear Resistance	Welding Resistance	Toughness
Interference Color	Periodic Nano-layered and wear resistance layer	3.200	1.100	☉	☉	☉	☉	☉

EgiAs is a registered trademark of OSG Corporation.

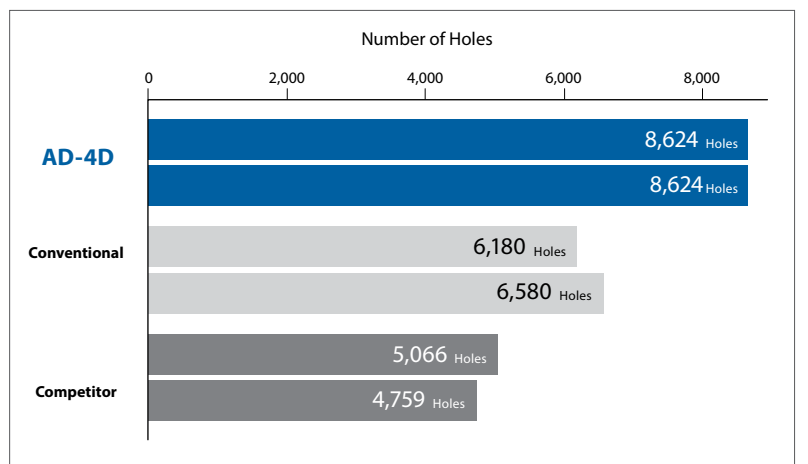
Low thrust resistance and stable torque are possible by the new wavy point form and low web thickness

Tool	AD-4D Ø10
Work Material	SCM440
Cutting Speed	70m/min (2.229 min ⁻¹)
Feed Rate	668 mm/min (0,3 mm/rev)
Depth of Hole	30 mm (Blind)
Coolant	Water Soluble (external)
Machine	Vertical Machining Center



Superior protection against friction with OSG's EgiAs coating

Tool	AD-4D Ø6
Work Material	SCM440 (30HRC)
Cutting Speed	70m/min (3.715 min ⁻¹)
Feed Rate	668 mm/min (0,18 mm/rev)
Depth of Hole	18 mm (Blind)
Coolant	Water Soluble (external)
Machine	Vertical Machining Center



CARBIDE DRILL (WITH OIL HOLE)

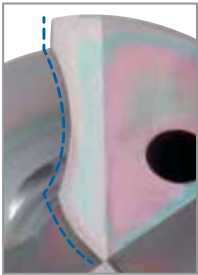
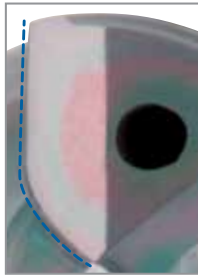
Optimum specifications for every drilling depth

1 EgiAs coating enables long tool life

2 Wide flute room facilitates stable chip evacuation
3D 5D 8D

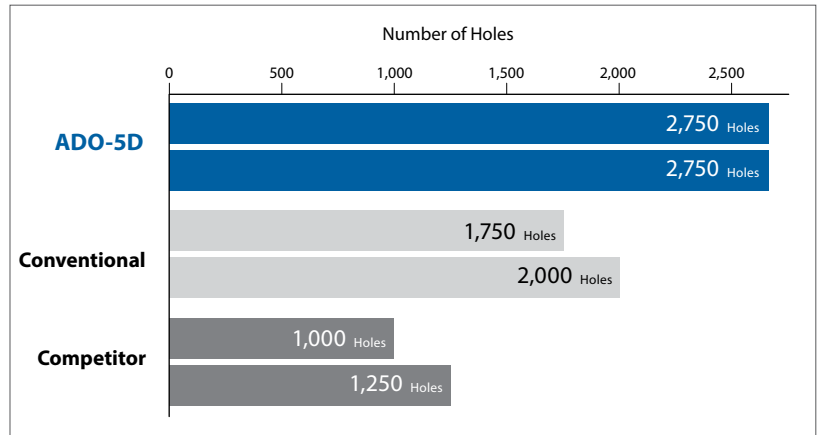
3 M (Middle) margin improves stability in deep-hole applications
8D 10D 15D 20D 30D

Two point forms based on length

Wavy Point Form	Straight Point Form
3D 5D 8D	8D 10D 15D 20D 30D
 <ul style="list-style-type: none"> • Long tool life is possible by low thrust resistance and stable torque • Breaks chip into small manageable pieces 	 <p>Superior point strength with low cutting force are achieved even for long drills with long overhang length</p>

Superior protection against friction with OSG's EgiAs coating

Tool	ADO-5D Ø10
Work Material	S50C
Cutting Speed	100m/min (3.185 min ⁻¹)
Feed Rate	796 mm/min (0,25 mm/rev)
Depth of Hole	50 mm (Blind)
Coolant	Water Soluble (internal)
Machine	Horizontal Machining Center

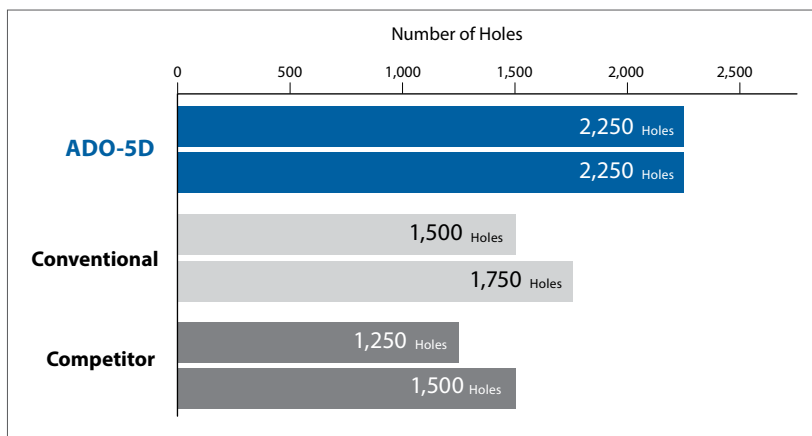


After drilling 500 holes

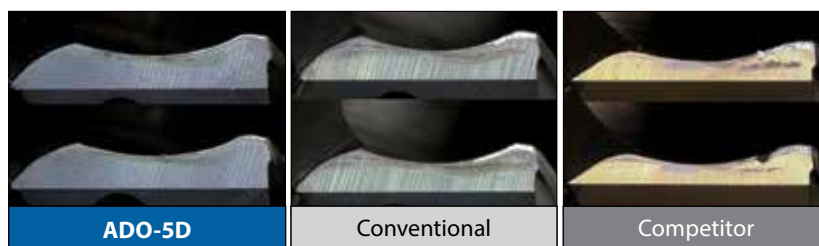


Improved machining performance in alloy steel

Tool	ADO-5D Ø10
Work Material	SCM440 (30HRC)
Cutting Speed	75m/min (2.389 min ⁻¹)
Feed Rate	597 mm/min (0,25 mm/rev)
Depth of Hole	50 mm (Blind)
Coolant	Water Soluble (internal)
Machine	Horizontal Machining Center

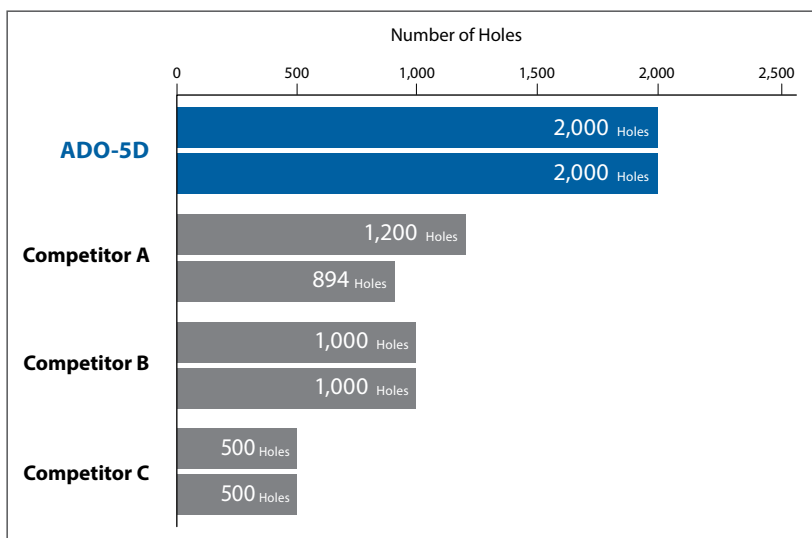


After drilling 1.250 holes



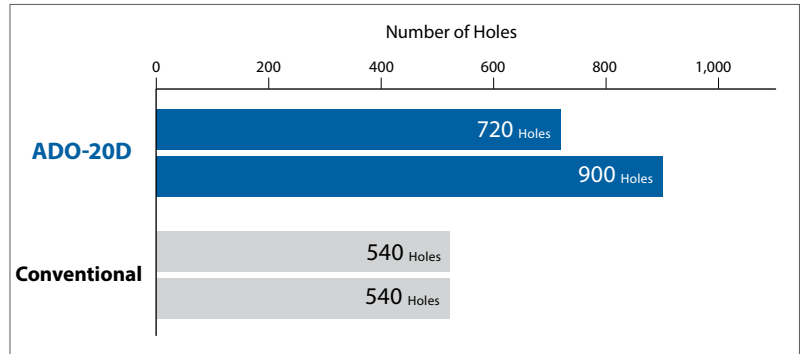
Long tool life can be achieved even at high feed rate with OSG's EgiAs coating

Tool	ADO-5D Ø10	Competitor Ø10
Work Material	S50C	
Cutting Speed	160m/min (5,096min ⁻¹)	100m/min (3,185min ⁻¹)
Feed Rate	1,273mm/min (0.25mm/rev)	796mm/min (0.25mm/rev)
Depth of Hole	50 mm (Blind)	
Coolant	Water Soluble (internal)	
Machine	Horizontal Machining Center	

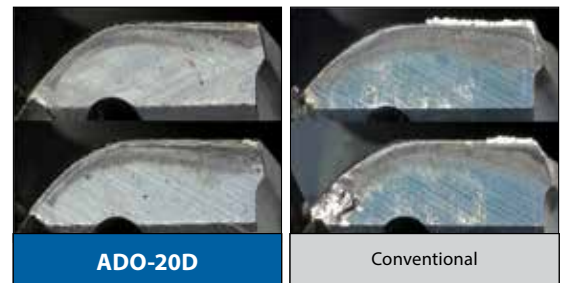


Greater efficiency even in deep-hole applications

Tool	ADO-20D Ø6
Work Material	SCM440 (30HRC)
Cutting Speed	60m/min (3.185 min ⁻¹)
Feed Rate	573 mm/min (0,18 mm/rev)
Depth of Hole	120 mm (Blind)
Coolant	Water Soluble (internal)
Machine	Horizontal Machining Center



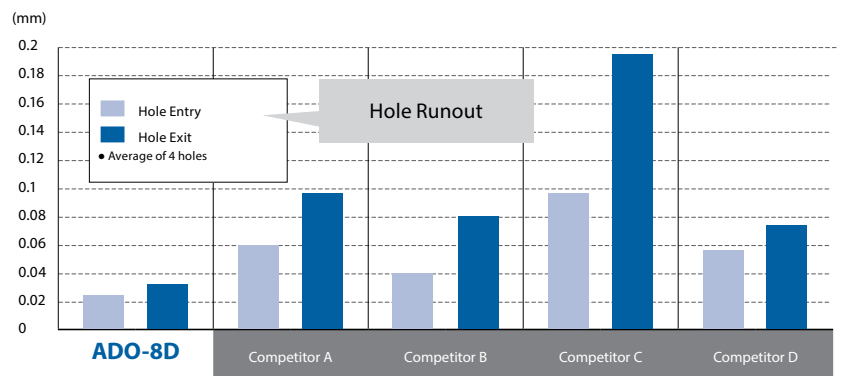
After drilling 540 holes



The most suitable specifications based on drilling depth have been adopted

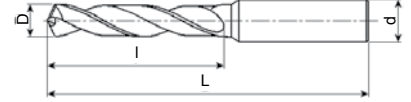
Improved hole accuracy can be achieved with the M margin and hook teeth geometry

Tool	ADO-8D Ø10
Work Material	S50C
Cutting Speed	100m/min (3.185 min ⁻¹)
Feed Rate	956 mm/min (0,3 mm/rev)
Depth of Hole	80 mm (Through)
Coolant	Water Soluble (internal)
Machine	Vertical Machining Center



AD-2D NEW

Drilling | Solid carbide | 2xD



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Up to 2xD
- For general purpose steels and cast iron
- 160 sizes



EDP	D	L	l	d	Price
8670200	2	62	14	4	
8670210	2,1	62	14	4	
8670220	2,2	62	14	4	
8670230	2,3	62	14	4	
8670240	2,4	62	14	4	
8670250	2,5	62	14	4	
8670260	2,6	62	14	4	
8670270	2,7	62	14	4	
8670276	2,76	62	14	4	
8670278	2,78	62	14	4	
8670280	2,8	62	14	4	
8670290	2,9	62	14	4	
8670300	3	66	20	4	
8670310	3,1	66	20	4	
8670320	3,2	66	20	4	
8670330	3,3	66	20	4	
8670340	3,4	66	20	4	
8670350	3,5	66	20	4	
8670360	3,6	66	20	4	
8670366	3,66	66	20	4	
8670368	3,68	66	20	4	
8670370	3,7	66	20	4	
8670380	3,8	66	24	4	
8670390	3,9	66	24	4	
8670400	4	66	24	4	
8670410	4,1	66	24	6	
8670420	4,2	66	24	6	
8670430	4,3	66	24	6	
8670440	4,4	66	24	6	
8670450	4,5	66	24	6	
8670460	4,6	66	24	6	
8670462	4,62	66	24	6	
8670464	4,64	66	24	6	
8670470	4,7	66	24	6	
8670480	4,8	66	28	6	
8670490	4,9	66	28	6	
8670500	5	66	28	6	
8670510	5,1	66	28	6	
8670520	5,2	66	28	6	
8670530	5,3	66	28	6	
8670540	5,4	66	28	6	
8670550	5,5	66	28	6	
8670552	5,52	66	28	6	
8670554	5,54	66	28	6	
8670560	5,6	66	28	6	

EDP	D	L	l	d	Price
8670570	5,7	66	28	6	
8670580	5,8	66	28	6	
8670590	5,9	66	28	6	
8670600	6	66	28	6	
8670610	6,1	79	34	8	
8670620	6,2	79	34	8	
8670630	6,3	79	34	8	
8670640	6,4	79	34	8	
8670650	6,5	79	34	8	
8670660	6,6	79	34	8	
8670670	6,7	79	34	8	
8670680	6,8	79	34	8	
8670690	6,9	79	34	8	
8670700	7	79	34	8	
8670710	7,1	79	41	8	
8670720	7,2	79	41	8	
8670730	7,3	79	41	8	
8670736	7,36	79	41	8	
8670738	7,38	79	41	8	
8670740	7,4	79	41	8	
8670750	7,5	79	41	8	
8670754	7,54	79	41	8	
8670760	7,6	79	41	8	
8670770	7,7	79	41	8	
8670780	7,8	79	41	8	
8670790	7,9	79	41	8	
8670800	8	79	41	8	
8670810	8,1	89	47	10	
8670820	8,2	89	47	10	
8670830	8,3	89	47	10	
8670840	8,4	89	47	10	
8670850	8,5	89	47	10	
8670860	8,6	89	47	10	
8670870	8,7	89	47	10	
8670880	8,8	89	47	10	
8670890	8,9	89	47	10	
8670900	9	89	47	10	
8670910	9,1	89	47	10	
8670920	9,2	89	47	10	
8670930	9,3	89	47	10	
8670940	9,4	89	47	10	
8670950	9,5	89	47	10	
8670960	9,6	89	47	10	
8670970	9,7	89	47	10	
8670980	9,8	89	47	10	

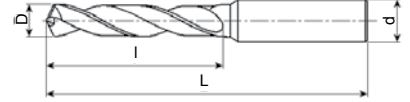
Drilling | Solid carbide

2xD



AD-2D NEW

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- 160 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	K GG	K GGG	H 25-35 HRC	H 35-45 HRC	H 45-52 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	h8
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Drilling | Solid carbide

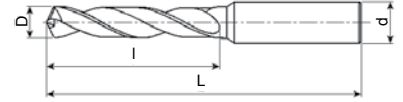
2xD

EDP	D	L	l	d	Price
8670990	9,9	89	47	10	
8671000	10	89	47	10	
8671010	10,1	102	55	12	
8671020	10,2	102	55	12	
8671030	10,3	102	55	12	
8671040	10,4	102	55	12	
8671050	10,5	102	55	12	
8671060	10,6	102	55	12	
8671070	10,7	102	55	12	
8671080	10,8	102	55	12	
8671090	10,9	102	55	12	
8671100	11	102	55	12	
8671110	11,1	102	55	12	
8671120	11,2	102	55	12	
8671130	11,3	102	55	12	
8671140	11,4	102	55	12	
8671150	11,5	102	55	12	
8671160	11,6	102	55	12	
8671170	11,7	102	55	12	
8671180	11,8	102	55	12	
8671190	11,9	102	55	12	
8671200	12	102	55	12	
8671210 <small>NEW</small>	12,1	107	60	14	
8671220 <small>NEW</small>	12,2	107	60	14	
8671230 <small>NEW</small>	12,3	107	60	14	
8671240 <small>NEW</small>	12,4	107	60	14	
8671250 <small>NEW</small>	12,5	107	60	14	
8671260 <small>NEW</small>	12,6	107	60	14	
8671270 <small>NEW</small>	12,7	107	60	14	
8671280 <small>NEW</small>	12,8	107	60	14	
8671290 <small>NEW</small>	12,9	107	60	14	
8671300 <small>NEW</small>	13	107	60	14	
8671310 <small>NEW</small>	13,1	107	60	14	
8671320 <small>NEW</small>	13,2	107	60	14	
8671330 <small>NEW</small>	13,3	107	60	14	
8671340 <small>NEW</small>	13,4	107	60	14	
8671350 <small>NEW</small>	13,5	107	60	14	
8671360 <small>NEW</small>	13,6	107	60	14	
8671370 <small>NEW</small>	13,7	107	60	14	
8671380 <small>NEW</small>	13,8	107	60	14	
8671390 <small>NEW</small>	13,9	107	60	14	
8671400 <small>NEW</small>	14	107	60	14	
8671410 <small>NEW</small>	14,1	115	65	16	
8671420 <small>NEW</small>	14,2	115	65	16	
8671430 <small>NEW</small>	14,3	115	65	16	

EDP	D	L	l	d	Price
8671440 <small>NEW</small>	14,4	115	65	16	
8671450 <small>NEW</small>	14,5	115	65	16	
8671460 <small>NEW</small>	14,6	115	65	16	
8671470 <small>NEW</small>	14,7	115	65	16	
8671480 <small>NEW</small>	14,8	115	65	16	
8671490 <small>NEW</small>	14,9	115	65	16	
8671500 <small>NEW</small>	15	115	65	16	
8671510 <small>NEW</small>	15,1	115	65	16	
8671520 <small>NEW</small>	15,2	115	65	16	
8671530 <small>NEW</small>	15,3	115	65	16	
8671540 <small>NEW</small>	15,4	115	65	16	
8671550 <small>NEW</small>	15,5	115	65	16	
8671560 <small>NEW</small>	15,6	115	65	16	
8671570 <small>NEW</small>	15,7	115	65	16	
8671580 <small>NEW</small>	15,8	115	65	16	
8671590 <small>NEW</small>	15,9	115	65	16	
8671600 <small>NEW</small>	16	115	65	16	
8671650 <small>NEW</small>	16,5	123	73	18	
8671700 <small>NEW</small>	17	123	73	18	
8671750 <small>NEW</small>	17,5	123	73	18	
8671800 <small>NEW</small>	18	123	73	18	
8671850 <small>NEW</small>	18,5	131	79	20	
8671900 <small>NEW</small>	19	131	79	20	
8671950 <small>NEW</small>	19,5	131	79	20	
8672000 <small>NEW</small>	20	131	79	20	

AD-4D NEW

Drilling | Solid carbide | 4xD



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Up to 4xD
- For general purpose steels and cast iron
- 149 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	K GG	K GGG	H 25-35 HRC	H 35-45 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	h8
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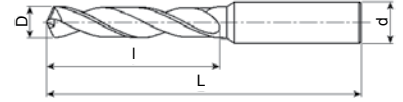
EDP	D	L	l	d	Price
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8672210	2,1	66	20	4	
8672220	2,2	66	20	4	
8672230	2,3	66	20	4	
8672240	2,4	66	20	4	
8672250	2,5	66	20	4	
8672260	2,6	66	20	4	
8672270	2,7	66	20	4	
8672280	2,8	66	20	4	
8672290	2,9	66	20	4	
8672300	3	74	28	4	
8672310	3,1	74	28	4	
8672320	3,2	74	28	4	
8672330	3,3	74	28	4	
8672340	3,4	74	28	4	
8672350	3,5	74	28	4	
8672360	3,6	74	28	4	
8672370	3,7	74	28	4	
8672380	3,8	74	36	4	
8672390	3,9	74	36	4	
8672400	4	74	36	4	
8672410	4,1	74	36	6	
8672420	4,2	74	36	6	
8672430	4,3	74	36	6	
8672440	4,4	74	36	6	
8672450	4,5	74	36	6	
8672460	4,6	74	36	6	
8672470	4,7	74	36	6	
8672480	4,8	82	44	6	
8672490	4,9	82	44	6	
8672500	5	82	44	6	
8672510	5,1	82	44	6	
8672520	5,2	82	44	6	
8672530	5,3	82	44	6	
8672540	5,4	82	44	6	
8672550	5,5	82	44	6	
8672560	5,6	82	44	6	
8672570	5,7	82	44	6	
8672580	5,8	82	44	6	
8672590	5,9	82	44	6	
8672600	6	82	44	6	
8672610	6,1	91	53	8	
8672620	6,2	91	53	8	
8672630	6,3	91	53	8	
8672640	6,4	91	53	8	

EDP	D	L	l	d	Price
8672650	6,5	91	53	8	
8672660	6,6	91	53	8	
8672670	6,7	91	53	8	
8672680	6,8	91	53	8	
8672690	6,9	91	53	8	
8672700	7	91	53	8	
8672710	7,1	91	53	8	
8672720	7,2	91	53	8	
8672730	7,3	91	53	8	
8672740	7,4	91	53	8	
8672750	7,5	91	53	8	
8672760	7,6	91	53	8	
8672770	7,7	91	53	8	
8672780	7,8	91	53	8	
8672790	7,9	91	53	8	
8672800	8	91	53	8	
8672810	8,1	103	61	10	
8672820	8,2	103	61	10	
8672830	8,3	103	61	10	
8672840	8,4	103	61	10	
8672850	8,5	103	61	10	
8672860	8,6	103	61	10	
8672870	8,7	103	61	10	
8672880	8,8	103	61	10	
8672890	8,9	103	61	10	
8672900	9	103	61	10	
8672910	9,1	103	61	10	
8672920	9,2	103	61	10	
8672930	9,3	103	61	10	
8672940	9,4	103	61	10	
8672950	9,5	103	61	10	
8672960	9,6	103	61	10	
8672970	9,7	103	61	10	
8672980	9,8	103	61	10	
8672990	9,9	103	61	10	
8673000	10	103	61	10	
8673010	10,1	118	71	12	
8673020	10,2	118	71	12	
8673030	10,3	118	71	12	
8673040	10,4	118	71	12	
8673050	10,5	118	71	12	
8673060	10,6	118	71	12	
8673070	10,7	118	71	12	
8673080	10,8	118	71	12	
8673090	10,9	118	71	12	



AD-4D NEW

Drilling | Solid carbide | 4xD



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P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	K GG	K GGG	H 25-35 HRC	H 35-45 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	h8
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page 26

Drilling | Solid carbide

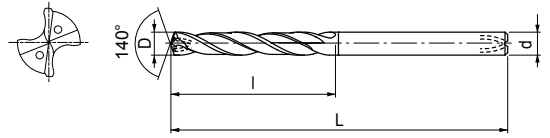
4xD

EDP	D	L	l	d	Price
8673100	11	118	71	12	
8673110	11,1	118	71	12	
8673120	11,2	118	71	12	
8673130	11,3	118	71	12	
8673140	11,4	118	71	12	
8673150	11,5	118	71	12	
8673160	11,6	118	71	12	
8673170	11,7	118	71	12	
8673180	11,8	118	71	12	
8673190	11,9	118	71	12	
8673200	12	118	71	12	
8673210	12,1	124	77	14	
8673220	12,2	124	77	14	
8673230	12,3	124	77	14	
8673240	12,4	124	77	14	
8673250	12,5	124	77	14	
8673260	12,6	124	77	14	
8673270	12,7	124	77	14	
8673280	12,8	124	77	14	
8673290	12,9	124	77	14	
8673300	13	124	77	14	
8673310	13,1	124	77	14	
8673320	13,2	124	77	14	
8673330	13,3	124	77	14	
8673340	13,4	124	77	14	
8673350	13,5	124	77	14	
8673360	13,6	124	77	14	
8673370	13,7	124	77	14	
8673380	13,8	124	77	14	
8673390	13,9	124	77	14	
8673400	14	124	77	14	
8673410	14,1	133	83	16	
8673420	14,2	133	83	16	
8673430	14,3	133	83	16	
8673440	14,4	133	83	16	
8673450	14,5	133	83	16	
8673460	14,6	133	83	16	
8673470	14,7	133	83	16	
8673480	14,8	133	83	16	
8673490	14,9	133	83	16	
8673500	15	133	83	16	
8673510	15,1	133	83	16	
8673520	15,2	133	83	16	
8673530	15,3	133	83	16	
8673540	15,4	133	83	16	

EDP	D	L	l	d	Price
8673550	15,5	133	83	16	
8673560	15,6	133	83	16	
8673570	15,7	133	83	16	
8673580	15,8	133	83	16	
8673590	15,9	133	83	16	
8673600	16	133	83	16	
8673650	16,5	143	93	18	
8673700	17	143	93	18	
8673750	17,5	143	93	18	
8673800	18	143	93	18	
8673850	18,5	153	101	20	
8673900	19	153	101	20	
8673950	19,5	153	101	20	
8674000	20	153	101	20	

ADO-3D NEW

Drilling | Solid carbide | 3xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Up to 3xD
- For general purpose steels and cast iron
- 109 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K GG	K GGG	N AC,ADC	S Ti	H 25-35 HRC	H 35-45 HRC	H 45-52 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	h8	page 26
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EDP	D	L	l	d	Price
8690200	2	66	12	3	
8690210	2,1	66	13	3	
8690220	2,2	66	14	3	
8690230	2,3	66	14	3	
8690240	2,4	66	15	3	
8690250	2,5	66	15	3	
8690260	2,6	66	16	3	
8690265	2,65	66	16	3	
8690270	2,7	66	17	3	
8690280	2,8	66	17	3	
8690290	2,9	66	18	3	
8690300	3	66	18	3	
8690310	3,1	74	19	4	
8690315	3,15	74	19	4	
8690320	3,2	74	20	4	
8690330	3,3	74	20	4	
8690340	3,4	74	21	4	
8690350	3,5	74	21	4	
8690360	3,6	74	22	4	
8690370	3,7	74	23	4	
8690375	3,75	74	23	4	
8690380	3,8	74	23	4	
8690390	3,9	74	24	4	
8690400	4	74	24	4	
8690410	4,1	80	25	5	
8700410	4,1	80	25	6	
8690420	4,2	80	26	5	
8700420	4,2	80	26	6	
8690430	4,3	80	26	5	
8700430	4,3	80	26	6	
8690440	4,4	80	27	5	
8700440	4,4	80	27	6	
8690450	4,5	80	27	5	
8700450	4,5	80	27	6	
8690460	4,6	80	28	5	
8700460	4,6	80	28	6	
8690470	4,7	80	29	5	
8700470	4,7	80	29	6	
8690480	4,8	80	29	5	
8700480	4,8	80	29	6	
8690490	4,9	80	30	5	
8700490	4,9	80	30	6	
8690500	5	80	25	5	
8700500	5	80	25	6	
8690510	5,1	82	26	6	

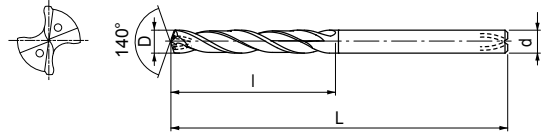
EDP	D	L	l	d	Price
8690520	5,2	82	26	6	
8690525	5,25	82	27	6	
8690530	5,3	82	27	6	
8690540	5,4	82	27	6	
8690550	5,5	82	28	6	
8690560	5,6	82	28	6	
8690570	5,7	82	29	6	
8690580	5,8	82	29	6	
8690590	5,9	82	30	6	
8690600	6	82	30	6	
8700610	6,1	88	31	8	
8700620	6,2	88	31	8	
8700630	6,3	88	32	8	
8700640	6,4	88	32	8	
8700650	6,5	88	33	8	
8700660	6,6	88	33	8	
8700670	6,7	88	34	8	
8700680	6,8	88	34	8	
8700690	6,9	88	35	8	
8700700	7	88	35	8	
8690710	7,1	94	36	8	
8690720	7,2	94	36	8	
8690725	7,25	94	37	8	
8690730	7,3	94	37	8	
8690740	7,4	94	37	8	
8690750	7,5	94	38	8	
8690760	7,6	94	38	8	
8690770	7,7	94	39	8	
8690775	7,75	94	39	8	
8690780	7,8	94	39	8	
8690790	7,9	94	40	8	
8690800	8	94	40	8	
8700810	8,1	101	41	10	
8700820	8,2	101	41	10	
8700830	8,3	101	42	10	
8700840	8,4	101	42	10	
8700850	8,5	101	43	10	
8700860	8,6	101	43	10	
8700870	8,7	101	43	10	
8700880	8,8	101	44	10	
8700890	8,9	101	45	10	
8700900	9	101	45	10	
8690910	9,1	106	46	10	
8690920	9,2	106	46	10	
8690925	9,25	106	47	10	

Drilling | Solid carbide
3xD



ADO-3D NEW

Drilling | Solid carbide | 3xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Up to 3xD
- For general purpose steels and cast iron
- 109 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K GG	K GGG	N AC,ADC	S Ti	H 25-35 HRC	H 35-45 HRC	H 45-52 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	h8	page 26
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Drilling | Solid carbide

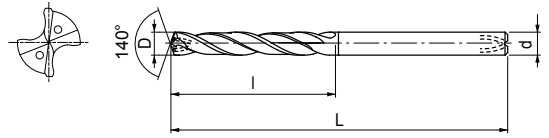
3xD

EDP	D	L	l	d	Price
8690930	9,3	106	47	10	
8690940	9,4	106	47	10	
8690950	9,5	106	48	10	
8690960	9,6	106	48	10	
8690970	9,7	106	49	10	
8690975	9,75	106	49	10	
8690980	9,8	106	49	10	
8690990	9,9	106	50	10	
8691000	10	106	50	10	
8701010	10,1	113	51	12	
8701020	10,2	113	51	12	
8701030	10,3	113	52	12	
8701040	10,4	113	52	12	
8701050	10,5	113	53	12	
8701060	10,6	113	53	12	
8701070	10,7	113	54	12	
8701080	10,8	113	54	12	
8701090	10,9	113	55	12	
8701100	11	113	55	12	
8691110	11,1	120	56	12	
8691120	11,2	120	56	12	
8691130	11,3	120	57	12	
8691140	11,4	120	57	12	
8691150	11,5	120	58	12	
8691160	11,6	120	58	12	
8691170	11,7	120	59	12	
8691180	11,8	120	59	12	
8691190	11,9	120	60	12	
8691200	12	120	60	12	
8701210	12,1	128	61	14	
8701220	12,2	128	61	14	
8701230	12,3	128	62	14	
8701240	12,4	128	62	14	
8701250	12,5	128	63	14	
8701260	12,6	128	63	14	
8701270	12,7	128	64	14	
8701280	12,8	128	64	14	
8701290	12,9	128	65	14	
8701300	13	128	65	14	
8691310	13,1	134	66	14	
8691320	13,2	134	66	14	
8691330	13,3	134	67	14	
8691340	13,4	134	67	14	
8691350	13,5	134	68	14	
8691360	13,6	134	68	14	

EDP	D	L	l	d	Price
8691370	13,7	134	69	14	
8691380	13,8	134	69	14	
8691390	13,9	134	70	14	
8691400	14	134	70	14	
8701410	14,1	140	71	16	
8701420	14,2	140	71	16	
8701430	14,3	140	72	16	
8701440	14,4	140	72	16	
8701450	14,5	140	73	16	
8701460	14,6	140	73	16	
8701470	14,7	140	74	16	
8701480	14,8	140	74	16	
8701490	14,9	140	75	16	
8701500	15	140	75	16	
8691510	15,1	145	76	16	
8691520	15,2	145	76	16	
8691530	15,3	145	77	16	
8691540	15,4	145	77	16	
8691550	15,5	145	78	16	
8691560	15,6	145	78	16	
8691570	15,7	145	79	16	
8691580	15,8	145	79	16	
8691590	15,9	145	80	16	
8691600	16	145	80	16	
8701650	16,5	150	83	18	
8701700	17	150	85	18	
8691750	17,5	155	88	18	
8691800	18	155	90	18	
8701850	18,5	160	93	20	
8701900	19	160	95	20	
8691950	19,5	165	98	20	
8692000	20	165	100	20	

ADO-5D NEW

Drilling | Solid carbide | 5xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Up to 5xD
- For general purpose steels and cast iron
- 191 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K GG	K GGG	N AC,ADC	S Ti	H 25-35 HRC	H 35-45 HRC	H 45-52 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	h8	page 26
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EDP	D	L	l	d	Price
8692200	2	70	18	3	
8692210	2,1	70	19	3	
8692220	2,2	70	20	3	
8692230	2,3	70	21	3	
8692240	2,4	70	22	3	
8692250	2,5	70	23	3	
8692260	2,6	78	24	3	
8692265	2,65	78	24	3	
8692270	2,7	78	25	3	
8692276	2,76	78	25	3	
8692278	2,78	78	26	3	
8692280	2,8	78	26	3	
8692290	2,9	78	27	3	
8692300	3	78	27	3	
8692310	3,1	86	28	4	
8692315	3,15	86	29	4	
8692320	3,2	86	29	4	
8692330	3,3	86	30	4	
8692340	3,4	86	31	4	
8692350	3,5	86	32	4	
8692360	3,6	86	33	4	
8692366	3,66	86	33	4	
8692368	3,68	86	34	4	
8692370	3,7	86	34	4	
8692375	3,75	86	34	4	
8692380	3,8	86	35	4	
8692390	3,9	86	36	4	
8692400	4	86	36	4	
8692410	4,1	95	37	5	
8702410	4,1	95	37	6	
8692420	4,2	95	38	5	
8702420	4,2	95	38	6	
8692430	4,3	95	39	5	
8702430	4,3	95	39	6	
8692440	4,4	95	40	5	
8702440	4,4	95	40	6	
8692450	4,5	95	41	5	
8702450	4,5	95	41	6	
8692460	4,6	95	42	5	
8702460	4,6	95	42	6	
8692462	4,62	95	42	5	
8692464	4,64	95	42	5	
8692470	4,7	95	43	5	
8702470	4,7	95	43	6	
8692480	4,8	95	44	5	

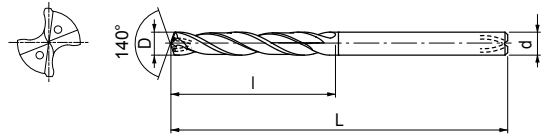
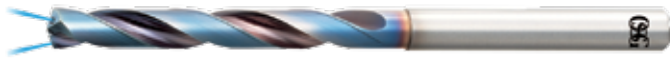
EDP	D	L	l	d	Price
8702480	4,8	95	44	6	
8692490	4,9	95	45	5	
8702490	4,9	95	45	6	
8692500	5	95	45	5	
8702500	5	95	45	6	
8692510	5,1	100	41	6	
8692520	5,2	100	42	6	
8692525	5,25	100	42	6	
8692530	5,3	100	43	6	
8692540	5,4	100	44	6	
8692550	5,5	100	44	6	
8692552	5,52	100	45	6	
8692554	5,54	100	45	6	
8692560	5,6	100	45	6	
8692570	5,7	100	46	6	
8692580	5,8	100	47	6	
8692590	5,9	100	48	6	
8692600	6	100	48	6	
8702610	6,1	109	49	8	
8702620	6,2	109	50	8	
8702630	6,3	109	51	8	
8702640	6,4	109	52	8	
8702650	6,5	109	52	8	
8702660	6,6	109	53	8	
8702670	6,7	109	54	8	
8702680	6,8	109	55	8	
8702690	6,9	109	56	8	
8702700	7	109	56	8	
8692710	7,1	118	57	8	
8692720	7,2	118	58	8	
8692725	7,25	118	58	8	
8692730	7,3	118	59	8	
8692736	7,36	118	59	8	
8692738	7,38	118	60	8	
8692740	7,4	118	60	8	
8692750	7,5	118	60	8	
8692752	7,52	118	61	8	
8692754	7,54	118	61	8	
8692760	7,6	118	61	8	
8692770	7,7	118	62	8	
8692775	7,75	118	62	8	
8692780	7,8	118	63	8	
8692790	7,9	118	64	8	
8692800	8	118	64	8	
8702810	8,1	128	65	10	

Drilling | Solid carbide
5xD



ADO-5D NEW

Drilling | Solid carbide | 5xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Up to 5xD
- For general purpose steels and cast iron
- 191 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K GG	K GGG	N AC,ADC	S Ti	H 25-35 HRC	H 35-45 HRC	H 45-52 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	h8	page 26
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Drilling | Solid carbide

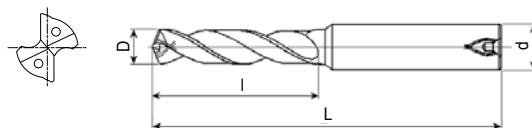
5xD

EDP	D	L	l	d	Price
8702820	8,2	128	66	10	
8702830	8,3	128	67	10	
8702840	8,4	128	68	10	
8702850	8,5	128	68	10	
8702860	8,6	128	69	10	
8702870	8,7	128	70	10	
8702880	8,8	128	71	10	
8702890	8,9	128	72	10	
8702900	9	128	72	10	
8692910	9,1	136	73	10	
8692920	9,2	136	74	10	
8692924	9,24	136	74	10	
8692925	9,25	136	74	10	
8692926	9,26	136	75	10	
8692930	9,3	136	75	10	
8692936	9,36	136	75	10	
8692938	9,38	136	76	10	
8692940	9,4	136	76	10	
8692950	9,5	136	76	10	
8692952	9,52	136	77	10	
8692954	9,54	136	77	10	
8692960	9,6	136	77	10	
8692970	9,7	136	78	10	
8692975	9,75	136	78	10	
8692980	9,8	136	79	10	
8692990	9,9	136	80	10	
8693000	10	136	80	10	
8703010	10,1	146	81	12	
8703020	10,2	146	82	12	
8703030	10,3	146	83	12	
8703040	10,4	146	84	12	
8703050	10,5	146	84	12	
8703060	10,6	146	85	12	
8703070	10,7	146	86	12	
8703080	10,8	146	87	12	
8703090	10,9	146	88	12	
8703100	11	146	88	12	
8693110	11,1	156	89	12	
8693120	11,2	156	90	12	
8693122	11,22	156	90	12	
8693124	11,24	156	90	12	
8693130	11,3	156	91	12	
8693136	11,36	156	91	12	
8693138	11,38	156	92	12	
8693140	11,4	156	92	12	

EDP	D	L	l	d	Price
8693150	11,5	156	92	12	
8693160	11,6	156	93	12	
8693170	11,7	156	94	12	
8693180	11,8	156	95	12	
8693190	11,9	156	96	12	
8693200	12	156	96	12	
8703210	12,1	167	97	14	
8703220	12,2	167	98	14	
8703230	12,3	167	99	14	
8703240	12,4	167	100	14	
8703250	12,5	167	100	14	
8703260	12,6	167	101	14	
8703270	12,7	167	102	14	
8703280	12,8	167	103	14	
8703290	12,9	167	104	14	
8703300	13	167	104	14	
8693310	13,1	176	105	14	
8693320	13,2	176	106	14	
8693325	13,25	176	106	14	
8693330	13,3	176	107	14	
8693340	13,4	176	108	14	
8693350	13,5	176	108	14	
8693360	13,6	176	109	14	
8693370	13,7	176	110	14	
8693380	13,8	176	111	14	
8693390	13,9	176	112	14	
8693400	14	176	112	14	
8703410	14,1	185	113	16	
8703420	14,2	185	114	16	
8703430	14,3	185	115	16	
8703440	14,4	185	116	16	
8703450	14,5	185	116	16	
8703460	14,6	185	117	16	
8703470	14,7	185	118	16	
8703480	14,8	185	119	16	
8703490	14,9	185	120	16	
8703500	15	185	120	16	
8693510	15,1	193	121	16	
8693520	15,2	193	122	16	
8693525	15,25	193	122	16	
8693530	15,3	193	123	16	
8693540	15,4	193	124	16	
8693550	15,5	193	124	16	
8693560	15,6	193	125	16	
8693570	15,7	193	126	16	

ADO-PLT NEW

Drilling | Solid carbide | Pilot Drill



- First choice in quality and performance
- Carbide pilot drill with internal coolant, EgiAs coating
- For general purpose steels and cast iron
- 15 sizes

P ○	P ●	P ●	P ●	M ○	K ●	K ●	H ●	H ●
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC	35-45 HRC

A	CARBIDE	EG	30°	SHRINK FIT	160°	h8	page 26
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Drilling | Solid carbide

Pilot Drill

EDP	D	L	l	d	Price
8688903	3,03	65	15	3	
8688923	3,53	70	18	4	
8688904	4,03	70	20	4	
8688924	4,53	75	23	5	
8688905	5,03	75	25	5	
8688925	5,53	80	28	6	
8688906	6,03	80	30	6	
8688926	6,53	85	33	7	
8688907	7,03	85	35	7	
8688908	8,03	90	40	8	
8688928	8,53	95	43	9	
8688909	9,03	95	45	9	
8688910	10,03	100	50	10	
8688911	11,03	115	55	11	
8688912	12,03	120	60	12	

EDP	D	L	l	d	Price

ADO-10D NEW

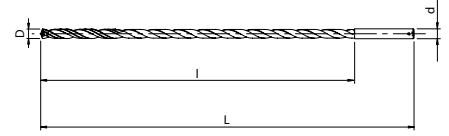
Drilling | Solid carbide | 10xD



X thinning
D<4



R thinning
D≥4



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 10xD
- For general purpose steels and cast iron
- 101 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K GG	K GGG	H 25-35 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	e8
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page 26

EDP	D	L	l	d	Price
8696200	2	75	26	3	
8696210	2,1	75	33	3	
8696220	2,2	75	33	3	
8696230	2,3	75	33	3	
8696240	2,4	75	33	3	
8696250	2,5	75	33	3	
8696260	2,6	90	40	3	
8696270	2,7	90	40	3	
8696280	2,8	90	40	3	
8696290	2,9	90	40	3	
8696300	3	90	40	3	
8696310	3,1	100	45	4	
8696320	3,2	100	45	4	
8696330	3,3	100	45	4	
8696340	3,4	100	50	4	
8696350	3,5	100	50	4	
8696360	3,6	100	50	4	
8696370	3,7	100	50	4	
8696380	3,8	100	50	4	
8696390	3,9	100	50	4	
8696400	4	100	50	4	
8710410	4,1	115	55	6	
8710420	4,2	115	55	6	
8710430	4,3	115	60	6	
8710440	4,4	115	60	6	
8710450	4,5	115	60	6	
8710460	4,6	115	60	6	
8710470	4,7	115	65	6	
8710480	4,8	115	65	6	
8710490	4,9	115	65	6	
8710500	5	115	65	6	
8710510	5,1	128	70	6	
8710520	5,2	128	70	6	
8710530	5,3	128	70	6	
8710540	5,4	128	78	6	
8696550	5,5	128	78	6	
8710560	5,6	128	78	6	
8710570	5,7	128	78	6	
8710580	5,8	128	78	6	
8710590	5,9	128	78	6	
8696600	6	128	78	6	
8710610	6,1	140	87	8	
8710620	6,2	140	87	8	
8710630	6,3	140	87	8	
8710640	6,4	140	87	8	

EDP	D	L	l	d	Price
8710650	6,5	140	87	8	
8710660	6,6	140	87	8	
8710670	6,7	140	87	8	
8710680	6,8	140	90	8	
8710690	6,9	140	90	8	
8710700	7	140	90	8	
8710710	7,1	155	100	8	
8710720	7,2	155	100	8	
8710730	7,3	155	100	8	
8710740	7,4	155	100	8	
8696750	7,5	155	100	8	
8710760	7,6	155	105	8	
8710770	7,7	155	105	8	
8710780	7,8	155	105	8	
8710790	7,9	155	105	8	
8696800	8	155	105	8	
8710810	8,1	165	110	10	
8710820	8,2	165	110	10	
8710830	8,3	165	110	10	
8710840	8,4	165	110	10	
8710850	8,5	165	110	10	
8710860	8,6	165	115	10	
8710870	8,7	165	115	10	
8710880	8,8	165	115	10	
8710890	8,9	165	115	10	
8710900	9	165	115	10	
8710910	9,1	190	125	10	
8710920	9,2	190	125	10	
8710930	9,3	190	125	10	
8710940	9,4	190	125	10	
8696950	9,5	190	125	10	
8710960	9,6	190	130	10	
8710970	9,7	190	130	10	
8710980	9,8	190	130	10	
8710990	9,9	190	130	10	
8697000	10	190	130	10	
8711010	10,1	205	140	12	
8711020	10,2	205	140	12	
8711030	10,3	205	140	12	
8711040	10,4	205	140	12	
8711050	10,5	205	140	12	
8711060	10,6	205	140	12	
8711070	10,7	205	140	12	
8711080	10,8	205	145	12	
8711090	10,9	205	145	12	

Drilling | Solid carbide

10xD



ADO-15D NEW

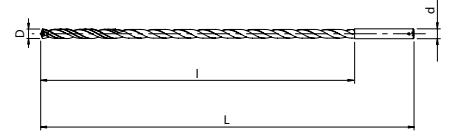
Drilling | Solid carbide | 15xD



X thinning
D<4



R thinning
D≥4



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 15xD
- For general purpose steels and cast iron
- 91 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K GG	K GGG	H 25-35 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	e8
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page 26

EDP	D	L	l	d	Price
8698300	3	105	55	3	
8698310	3,1	125	60	4	
8698320	3,2	125	60	4	
8698330	3,3	125	60	4	
8698340	3,4	125	65	4	
8698350	3,5	125	65	4	
8698360	3,6	125	65	4	
8698370	3,7	125	65	4	
8698380	3,8	125	75	4	
8698390	3,9	125	75	4	
8698400	4	125	75	4	
8712410	4,1	140	75	6	
8712420	4,2	140	75	6	
8712430	4,3	140	85	6	
8712440	4,4	140	85	6	
8712450	4,5	140	85	6	
8712460	4,6	140	85	6	
8712470	4,7	140	85	6	
8712480	4,8	140	90	6	
8712490	4,9	140	90	6	
8712500	5	140	90	6	
8712510	5,1	160	95	6	
8712520	5,2	160	95	6	
8712530	5,3	160	95	6	
8712540	5,4	160	110	6	
8698550	5,5	160	110	6	
8712560	5,6	160	110	6	
8712570	5,7	160	110	6	
8712580	5,8	160	110	6	
8712590	5,9	160	110	6	
8698600	6	160	110	6	
8712610	6,1	175	120	8	
8712620	6,2	175	120	8	
8712630	6,3	175	120	8	
8712640	6,4	175	120	8	
8712650	6,5	175	120	8	
8712660	6,6	175	120	8	
8712670	6,7	175	120	8	
8712680	6,8	175	125	8	
8712690	6,9	175	125	8	
8712700	7	175	125	8	
8712710	7,1	195	135	8	

EDP	D	L	l	d	Price
8712720	7,2	195	135	8	
8712730	7,3	195	135	8	
8712740	7,4	195	135	8	
8698750	7,5	195	135	8	
8712760	7,6	195	145	8	
8712770	7,7	195	145	8	
8712780	7,8	195	145	8	
8712790	7,9	195	145	8	
8698800	8	195	145	8	
8712810	8,1	210	155	10	
8712820	8,2	210	155	10	
8712830	8,3	210	155	10	
8712840	8,4	210	155	10	
8712850	8,5	210	155	10	
8712860	8,6	210	160	10	
8712870	8,7	210	160	10	
8712880	8,8	210	160	10	
8712890	8,9	210	160	10	
8712900	9	210	160	10	
8712910	9,1	240	170	10	
8712920	9,2	240	170	10	
8712930	9,3	240	170	10	
8712940	9,4	240	170	10	
8698950	9,5	240	170	10	
8712960	9,6	240	180	10	
8712970	9,7	240	180	10	
8712980	9,8	240	180	10	
8712990	9,9	240	180	10	
8699000	10	240	180	10	
8713010	10,1	260	190	12	
8713020	10,2	260	190	12	
8713030	10,3	260	190	12	
8713040	10,4	260	190	12	
8713050	10,5	260	190	12	
8713060	10,6	260	190	12	
8713070	10,7	260	200	12	
8713080	10,8	260	200	12	
8713090	10,9	260	200	12	
8713100	11	260	200	12	
8713110	11,1	280	210	12	
8713120	11,2	280	210	12	
8713130	11,3	280	210	12	

Drilling | Solid carbide

15xD



ADO-20D NEW

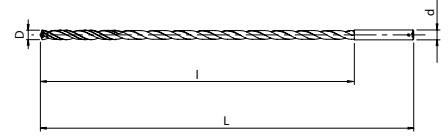
Drilling | Solid carbide | 20xD



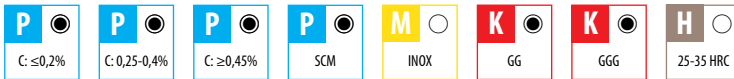
X thinning
D < 4



R thinning
D ≥ 4



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 20xD
- For general purpose steels and cast iron
- 91 sizes



EDP	D	L	l	d	Price
8706300	3	120	70	3	
8706310	3,1	140	80	4	
8706320	3,2	140	80	4	
8706330	3,3	140	80	4	
8706340	3,4	140	85	4	
8706350	3,5	140	85	4	
8706360	3,6	140	85	4	
8706370	3,7	140	85	4	
8706380	3,8	140	90	4	
8706390	3,9	140	90	4	
8706400	4	140	90	4	
8714410	4,1	165	100	6	
8714420	4,2	165	100	6	
8714430	4,3	165	110	6	
8714440	4,4	165	110	6	
8714450	4,5	165	110	6	
8714460	4,6	165	110	6	
8714470	4,7	165	110	6	
8714480	4,8	165	115	6	
8714490	4,9	165	115	6	
8714500	5	165	115	6	
8714510	5,1	190	120	6	
8714520	5,2	190	120	6	
8714530	5,3	190	120	6	
8714540	5,4	190	140	6	
8706550	5,5	190	140	6	
8714560	5,6	190	140	6	
8714570	5,7	190	140	6	
8714580	5,8	190	140	6	
8714590	5,9	190	140	6	
8706600	6	190	140	6	
8714610	6,1	210	155	8	
8714620	6,2	210	155	8	
8714630	6,3	210	155	8	
8714640	6,4	210	155	8	
8714650	6,5	210	155	8	
8714660	6,6	210	155	8	
8714670	6,7	210	155	8	
8714680	6,8	210	160	8	
8714690	6,9	210	160	8	
8714700	7	210	160	8	
8714710	7,1	230	170	8	

EDP	D	L	l	d	Price
8714720	7,2	230	170	8	
8714730	7,3	230	170	8	
8714740	7,4	230	170	8	
8706750	7,5	230	170	8	
8714760	7,6	230	180	8	
8714770	7,7	230	180	8	
8714780	7,8	230	180	8	
8714790	7,9	230	180	8	
8706800	8	230	180	8	
8714810	8,1	260	195	10	
8714820	8,2	260	195	10	
8714830	8,3	260	195	10	
8714840	8,4	260	195	10	
8714850	8,5	260	195	10	
8714860	8,6	260	210	10	
8714870	8,7	260	210	10	
8714880	8,8	260	210	10	
8714890	8,9	260	210	10	
8714900	9	260	210	10	
8714910	9,1	290	220	10	
8714920	9,2	290	220	10	
8714930	9,3	290	220	10	
8714940	9,4	290	220	10	
8706950	9,5	290	220	10	
8714960	9,6	290	230	10	
8714970	9,7	290	230	10	
8714980	9,8	290	230	10	
8714990	9,9	290	230	10	
8707000	10	290	230	10	
8715010	10,1	310	250	12	
8715020	10,2	310	250	12	
8715030	10,3	310	250	12	
8715040	10,4	310	250	12	
8715050	10,5	310	250	12	
8715060	10,6	310	250	12	
8715070	10,7	310	250	12	
8715080	10,8	310	250	12	
8715090	10,9	310	250	12	
8715100	11	310	250	12	
8715110	11,1	330	270	12	
8715120	11,2	330	270	12	
8715130	11,3	330	270	12	

ADO-30D NEW

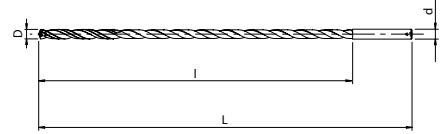
Drilling | Solid carbide | 30xD



X thinning
D<4



R thinning
D≥4



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 30xD
- For general purpose steels and cast iron
- 71 sizes

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K GG	K GGG	H 25-35 HRC
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A	CARBIDE	EG	30°	SHRINK FIT	140°	e8
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EDP	D	L	l	d	Price
8708300	3	150	100	3	
8708310	3,1	185	102	4	
8708320	3,2	185	105	4	
8708330	3,3	185	109	4	
8708340	3,4	185	112	4	
8708350	3,5	185	116	4	
8708360	3,6	185	116	4	
8708370	3,7	185	116	4	
8708380	3,8	185	132	4	
8708390	3,9	185	132	4	
8708400	4	185	132	4	
8716410	4,1	215	140	6	
8716420	4,2	215	140	6	
8716430	4,3	215	150	6	
8716440	4,4	215	150	6	
8716450	4,5	215	150	6	
8716460	4,6	215	150	6	
8716470	4,7	215	150	6	
8716480	4,8	215	165	6	
8716490	4,9	215	165	6	
8716500	5	215	165	6	
8716510	5,1	250	180	6	
8716520	5,2	250	180	6	
8716530	5,3	250	180	6	
8716540	5,4	250	200	6	
8708550	5,5	250	200	6	
8716560	5,6	250	200	6	
8716570	5,7	250	200	6	
8716580	5,8	250	200	6	
8716590	5,9	250	200	6	
8708600	6	250	200	6	
8716610	6,1	280	215	8	
8716620	6,2	280	215	8	
8716630	6,3	280	215	8	
8716640	6,4	280	215	8	
8716650	6,5	280	215	8	
8716660	6,6	280	215	8	
8716670	6,7	280	215	8	
8716680	6,8	280	230	8	
8716690	6,9	280	230	8	
8716700	7	280	230	8	
8716710	7,1	315	250	8	
8716720	7,2	315	250	8	
8716730	7,3	315	250	8	
8716740	7,4	315	250	8	

EDP	D	L	l	d	Price
8708750	7,5	315	250	8	
8716760	7,6	315	265	8	
8716770	7,7	315	265	8	
8716780	7,8	315	265	8	
8716790	7,9	315	265	8	
8708800	8	315	265	8	
8716810	8,1	350	280	10	
8716820	8,2	350	280	10	
8716830	8,3	350	280	10	
8716840	8,4	350	280	10	
8716850	8,5	350	280	10	
8716860	8,6	350	300	10	
8716870	8,7	350	300	10	
8716880	8,8	350	300	10	
8716890	8,9	350	300	10	
8716900	9	350	300	10	
8716910	9,1	390	315	10	
8716920	9,2	390	315	10	
8716930	9,3	390	315	10	
8716940	9,4	390	315	10	
8708950	9,5	390	315	10	
8716960	9,6	390	330	10	
8716970	9,7	390	330	10	
8716980	9,8	390	330	10	
8716990	9,9	390	330	10	
8709000	10	390	330	10	



CUTTING CONDITIONS

Drilling | Solid | Cutting conditions

AD-2D/AD-4D

Standard drilling

Vc	C<0,35% (C<0,35%) St40 • SCM ~710 N/mm ²		C≥0,35% (C≥0,35%) CK50 ~1060 N/mm ²		Special Alloy SUJ2		SUS Serie SUS300 Serie SUS400		Hardened Steel				GG GG25 ~350 N/mm ²		GGG GGG40 ~500 N/mm ²	
	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	SKD61 43 HRC		43 ~ 48 HRC		S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
63 ~ 100 m/min	63 ~ 100 m/min		63 ~ 100 m/min		50 ~ 71 m/min		25 ~ 40 m/min		40 ~ 63 m/min		32 ~ 45 m/min		63 ~ 100 m/min		50 ~ 80 m/min	
2	11.000	0,06~0,08	11.000	0,06~0,08	9.000	0,06~0,08	4.700	0,06~0,08	7.600	0,06~0,08	6.000	0,06~0,08	12.000	0,06~0,08	10.000	0,06~0,08
3	8.000	0,09~0,12	8.000	0,09~0,12	6.000	0,09~0,12	3.200	0,09~0,12	5.000	0,09~0,12	4.000	0,09~0,12	8.000	0,09~0,12	6.900	0,09~0,12
4	6.300	0,10~0,15	6.300	0,10~0,15	4.750	0,10~0,15	2.400	0,10~0,15	3.800	0,10~0,15	3.000	0,10~0,15	6.300	0,10~0,15	5.200	0,10~0,15
5	5.000	0,12~0,18	5.000	0,12~0,18	3.800	0,12~0,18	1.900	0,12~0,18	3.000	0,12~0,18	2.450	0,12~0,18	5.000	0,12~0,18	4.100	0,12~0,18
6	4.200	0,14~0,20	4.200	0,14~0,20	3.200	0,14~0,20	1.600	0,14~0,20	2.550	0,14~0,20	2.050	0,14~0,20	4.200	0,14~0,20	3.450	0,14~0,20
8	3.200	0,16~0,24	3.200	0,16~0,24	2.400	0,16~0,24	1.200	0,16~0,24	1.900	0,16~0,24	1.550	0,16~0,24	3.200	0,16~0,24	2.600	0,16~0,24
10	2.550	0,18~0,27	2.550	0,18~0,27	1.900	0,18~0,27	950	0,18~0,27	1.550	0,18~0,27	1.250	0,18~0,27	2.600	0,18~0,27	2.100	0,18~0,27
12	2.100	0,20~0,30	2.100	0,20~0,30	1.600	0,20~0,30	800	0,20~0,30	1.300	0,20~0,30	1.050	0,20~0,30	2.200	0,20~0,30	1.750	0,20~0,30
14	1.800	0,22~0,35	1.800	0,22~0,35	1.350	0,22~0,35	700	0,22~0,35	1.100	0,22~0,35	880	0,22~0,35	1.800	0,22~0,35	1.500	0,22~0,35
16	1.600	0,25~0,36	1.600	0,25~0,36	1.200	0,25~0,36	600	0,25~0,36	950	0,25~0,36	770	0,25~0,36	1.600	0,25~0,36	1.300	0,25~0,36
18	1.400	0,28~0,38	1.400	0,28~0,38	1.050	0,28~0,38	530	0,28~0,38	850	0,28~0,38	680	0,28~0,38	1.400	0,28~0,38	1.200	0,28~0,38
20	1.300	0,30~0,40	1.300	0,30~0,40	960	0,30~0,40	480	0,30~0,40	760	0,30~0,40	610	0,30~0,40	1.300	0,30~0,40	1.050	0,30~0,40

ADO-3D/5D/ADO-PLT

Vc	Carbon Steel S50C		Alloy Steel SCM440		Alloy Steel SCM440 • 30HRC		Cast Iron FC250		Ductile Cast IRON FCD700		Stainless Steel SUS304	
	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
80 ~ 120 m/min	80 ~ 120 m/min		80 ~ 120 m/min		60 ~ 90 m/min		80 ~ 120 m/min		60 ~ 100 m/min		40 ~ 70 m/min	
3	10.600	0,06~0,12	10.600	0,06~0,12	7.400	0,06~0,12	10.600	0,06~0,12	8.500	0,06~0,12	6.400	0,06~0,12
4	8.000	0,08~0,16	8.000	0,08~0,16	5.600	0,08~0,16	8.000	0,08~0,16	6.400	0,08~0,16	4.800	0,08~0,16
5	6.400	0,10~0,20	6.400	0,10~0,20	4.500	0,10~0,20	6.400	0,10~0,20	5.100	0,10~0,20	3.800	0,10~0,20
6	5.300	0,12~0,24	5.300	0,12~0,24	3.700	0,12~0,24	5.300	0,12~0,24	4.200	0,12~0,24	3.200	0,12~0,24
7	4.500	0,14~0,26	4.500	0,14~0,26	3.200	0,14~0,26	4.500	0,14~0,26	3.600	0,14~0,26	2.700	0,14~0,26
8	4.000	0,16~0,28	4.000	0,16~0,28	2.800	0,16~0,28	4.000	0,16~0,28	3.200	0,16~0,28	2.400	0,16~0,28
9	3.500	0,18~0,30	3.500	0,18~0,30	2.500	0,18~0,30	3.500	0,18~0,30	2.800	0,18~0,30	2.100	0,18~0,30
10	3.200	0,20~0,30	3.200	0,20~0,30	2.200	0,20~0,30	3.200	0,20~0,30	2.500	0,20~0,30	1.900	0,20~0,30
11	2.900	0,20~0,30	2.900	0,20~0,30	2.000	0,20~0,30	2.900	0,20~0,30	2.300	0,20~0,30	1.700	0,20~0,30
12	2.700	0,21~0,30	2.700	0,21~0,30	1.900	0,21~0,30	2.700	0,21~0,30	2.100	0,21~0,30	1.600	0,21~0,30
13	2.400	0,21~0,33	2.400	0,21~0,33	1.700	0,21~0,33	2.400	0,21~0,33	2.000	0,21~0,33	1.500	0,21~0,33
14	2.300	0,22~0,35	2.300	0,22~0,35	1.600	0,22~0,35	2.300	0,22~0,35	1.800	0,22~0,35	1.400	0,22~0,35
16	2.000	0,25~0,36	2.000	0,25~0,36	1.400	0,25~0,36	2.000	0,25~0,36	1.600	0,25~0,36	1.200	0,25~0,36
18	1.800	0,28~0,38	1.800	0,28~0,38	1.200	0,28~0,38	1.800	0,28~0,38	1.400	0,28~0,38	1.100	0,28~0,38
20	1.600	0,30~0,40	1.600	0,30~0,40	1.100	0,30~0,40	1.600	0,30~0,40	1.300	0,30~0,40	1.000	0,30~0,40

ADO-10D/15D/20D/30D

Vc	Mild Steel - Low Carbon Steel SS400 • S10C ~150HB ~500 N/mm ²		Carbon Steel S35C • S50C ~210HB ~710 N/mm ²		Alloys Steel SCM • SCr • SNCM 16~28HRC 710~900 N/mm ²		Cast Iron FC250 ~350 N/mm ²		Ductile Cast Iron FCD450 • FCD600 400~600 N/mm ²		Stainless Steel SUS400 400 ~ 800 N/mm ²	
	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
60 ~ 125 m/min	60 ~ 125 m/min		60 ~ 125 m/min		60 ~ 125 m/min		60 ~ 125 m/min		50 ~ 80 m/min		40 ~ 80 m/min	
3	7.500	0,06~0,12	7.500	0,06~0,12	7.500	0,06~0,12	7.500	0,06~0,12	7.500	0,06~0,12	5.300	0,06~0,12
4	6.400	0,08~0,16	6.400	0,08~0,16	6.400	0,08~0,16	6.400	0,08~0,16	5.600	0,08~0,16	5.000	0,08~0,16
5	5.800	0,10~0,20	5.800	0,10~0,20	5.800	0,10~0,20	5.800	0,10~0,20	4.500	0,10~0,20	4.500	0,10~0,20
6	4.800	0,12~0,24	4.800	0,12~0,24	4.800	0,12~0,24	4.800	0,12~0,24	3.800	0,12~0,24	3.800	0,12~0,24
8	3.600	0,16~0,28	3.600	0,16~0,28	3.600	0,16~0,28	3.600	0,16~0,28	2.800	0,16~0,28	2.800	0,16~0,28
10	2.900	0,20~0,35	2.900	0,20~0,35	2.900	0,20~0,35	2.900	0,20~0,35	2.300	0,20~0,35	2.300	0,20~0,35
12	2.400	0,24~0,42	2.400	0,24~0,42	2.400	0,24~0,42	2.400	0,24~0,42	1.900	0,24~0,42	1.900	0,24~0,42

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