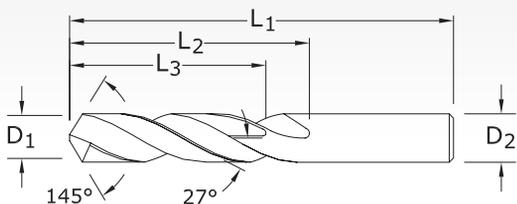


Short Length Self Centering Drills • DIN 6539



TOLERANCES h_6 (mm)

≤3 DIAMETER

$D_1 = +0,000/-0,010$

$D_2 = h_6$

>3–6 DIAMETER

$D_1 = +0,000/-0,012$

$D_2 = h_6$

>6–10 DIAMETER

$D_1 = +0,000/-0,015$

$D_2 = h_6$

>10–18 DIAMETER

$D_1 = +0,000/-0,018$

$D_2 = h_6$

>18–30 DIAMETER

$D_1 = +0,000/-0,021$

$D_2 = h_6$

108M Plus

METRIC SERIES

TECH INFO 179

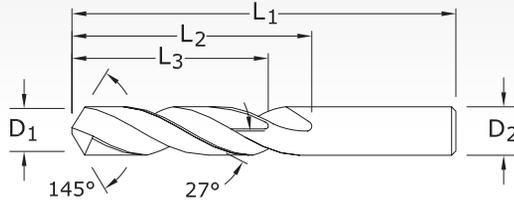
CUTTING DIAMETER D_1 / D_2	mm			EDP NO.	
	OVERALL LENGTH L_1	FLUTE LENGTH L_2	CLEARED LENGTH L_3	UNCOATED	Ti-NAMITE-A (AITIN)
0,5	20,0	3,0	2,1	62001	68643
0,55	21,0	3,5	2,5	62003	68644
0,6	21,0	3,5	2,5	62005	68645
0,65	22,0	4,0	2,9	62007	68646
0,7	23,0	4,5	3,2	62009	68647
0,75	23,0	4,5	3,2	62011	68648
0,8	24,0	5,0	3,6	62013	68649
0,85	24,0	5,0	3,6	62015	68650
0,9	25,0	5,5	4,0	62017	68651
0,95	25,0	5,5	4,0	62019	68652
1,0	26,0	6,0	4,7	62021	68653
1,05	26,0	6,0	4,7	62023	68654
1,1	28,0	7,0	5,4	62025	68655
1,15	28,0	7,0	5,4	62027	68656
1,2	30,0	8,0	6,0	62029	68657
1,25	30,0	8,0	6,0	62031	68658
1,3	30,0	8,0	6,0	62033	68659
1,35	32,0	9,0	7,0	62035	68660
1,4	32,0	9,0	7,0	62037	68661
1,45	32,0	9,0	7,0	62039	68662
1,5	32,0	9,0	7,0	62041	68663
1,6	34,0	10,0	7,0	62043	68664
1,7	34,0	10,0	7,0	62045	68665
1,8	36,0	11,0	8,0	62047	68666
1,9	36,0	11,0	8,0	62049	68667
2,0	38,0	12,0	9,0	62051	68668
2,1	38,0	12,0	9,0	62053	68669
2,2	40,0	13,0	10,0	62055	68670
2,3	40,0	13,0	10,0	62057	68671
2,4	43,0	14,0	11,0	62059	68672
2,5	43,0	14,0	11,0	62061	68673
2,6	43,0	14,0	11,0	62063	68674
2,7	46,0	16,0	12,0	62065	68675
2,8	46,0	16,0	12,0	62067	68676
2,9	46,0	16,0	12,0	62069	68677
3,0	46,0	16,0	12,0	62071	68678
3,1	49,0	18,0	14,0	62073	68679
3,2	49,0	18,0	14,0	62075	68680

- STEELS
- STAINLESS STEELS
- CAST IRON
- HIGH TEMP ALLOYS
- TITANIUM
- NON-FERROUS
- PLASTICS/COMPOSITES

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108M Plus

METRIC SERIES

TECH INFO 179

- STEELS
- STAINLESS STEELS
- CAST IRON
- HIGH TEMP ALLOYS
- TITANIUM
- NON-FERROUS
- PLASTICS/COMPOSITES

CUTTING DIAMETER D ₁ / D ₂	mm			EDP NO.	
	OVERALL LENGTH L ₁	FLUTE LENGTH L ₂	CLEARED LENGTH L ₃	UNCOATED	TI-NAMITE-A (AlTiN)
3,3	49,0	18,0	14,0	62077	68681
3,4	52,0	20,0	15,0	62079	68682
3,5	52,0	20,0	15,0	62081	68683
3,6	52,0	20,0	15,0	62083	68684
3,7	52,0	20,0	15,0	62085	68685
3,8	55,0	22,0	17,0	62087	68686
3,9	55,0	22,0	17,0	62089	68687
4,0	55,0	22,0	17,0	62091	68688
4,1	55,0	22,0	17,0	62093	68689
4,2	55,0	22,0	17,0	62095	68690
4,3	58,0	24,0	18,0	62097	68691
4,4	58,0	24,0	18,0	62099	68692
4,5	58,0	24,0	18,0	62101	68693
4,6	58,0	24,0	18,0	62103	68694
4,7	58,0	24,0	18,0	62105	68695
4,8	62,0	26,0	20,0	62107	68696
4,9	62,0	26,0	20,0	62109	68697
5,0	62,0	26,0	20,0	62111	68698
5,1	62,0	26,0	20,0	62113	68699
5,2	62,0	26,0	20,0	62115	68700
5,3	62,0	26,0	20,0	62117	68701
5,4	66,0	28,0	21,0	62119	68702
5,5	66,0	28,0	21,0	62121	68703
5,6	66,0	28,0	21,0	62123	68704
5,7	66,0	28,0	21,0	62125	68705
5,8	66,0	28,0	21,0	62127	68706
5,9	66,0	28,0	21,0	62129	68707
6,0	66,0	28,0	21,0	62131	68708
6,1	70,0	31,0	23,0	62133	68709
6,2	70,0	31,0	23,0	62135	68710
6,3	70,0	31,0	23,0	62137	68711
6,4	70,0	31,0	23,0	62139	68712
6,5	70,0	31,0	23,0	62141	68713
6,8	70,0	31,0	23,0	62142	68603
7,0	74,0	34,0	25,0	62143	68718
7,5	74,0	34,0	25,0	62145	68723
7,8	79,0	37,0	27,0	62146	68604
8,0	79,0	37,0	27,0	62147	68728

TOLERANCES h₆ (mm)

≤3 DIAMETER

D₁ = +0,000/-0,010

D₂ = h₆

>3-6 DIAMETER

D₁ = +0,000/-0,012

D₂ = h₆

>6-10 DIAMETER

D₁ = +0,000/-0,015

D₂ = h₆

>10-18 DIAMETER

D₁ = +0,000/-0,018

D₂ = h₆

>18-30 DIAMETER

D₁ = +0,000/-0,021

D₂ = h₆

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Short Length Self Centering Drills • DIN 6539



108M Plus

METRIC SERIES

CUTTING DIAMETER D ₁ / D ₂	mm			EDP NO.		CONTINUED
	OVERALL LENGTH L ₁	FLUTE LENGTH L ₂	CLEARED LENGTH L ₃	UNCOATED	TI-NAMITE-A (AITIN)	
8,5	79,0	37,0	27,0	62149	68733	
9,0	84,0	40,0	29,0	62151	68738	
9,5	84,0	40,0	29,0	62153	68743	
9,8	89,0	43,0	31,0	62154	68606	
10,0	89,0	43,0	31,0	62155	68748	
10,2	89,0	43,0	31,0	62156	68607	
10,5	89,0	43,0	31,0	62066	68753	
11,0	95,0	47,0	33,0	62157	68758	
11,5	95,0	47,0	33,0	62084	68763	
11,8	102,0	51,0	35,0	62158	68608	
12,0	102,0	51,0	35,0	62159	68768	
12,5	102,0	51,0	35,0	62102	68773	
13,0	102,0	51,0	35,0	62112	68778	
13,8	107,0	54,0	37,0	62164	68609	
14,0	107,0	54,0	37,0	62116	68780	
14,5	111,0	56,0	38,0	62166	68611	
14,8	111,0	56,0	38,0	62167	68612	
15,0	111,0	56,0	38,0	62168	68613	
15,8	115,0	58,0	38,0	62170	68614	
16,0	115,0	58,0	38,0	62171	68616	

