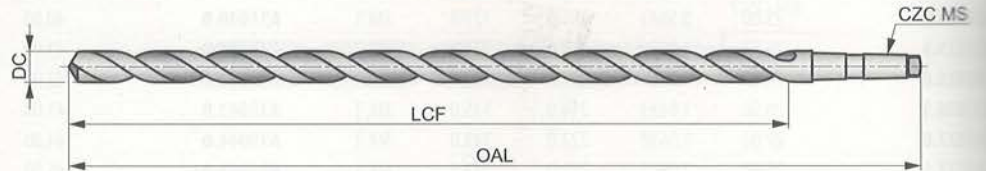


A345



HSS Long Series Taper Shank Drill (DIN 1870 Series 1), Steam Tempered Finish

Recommended for drilling very deep holes or for applications where increased reach is required. A 118° point angle is easy to regrind and provides strength. Steam tempered finish retains cutting fluid and prevents chip to tool welding. Suitable for drilling many materials.



HSS	DIN 1870(1)	10xD
118°	ST	
λ 20-35°	R	DC h8

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

P1.1 ■ 23 G	P1.2 ■ 25 G	P1.3 ■ 26 G	P2.1 ■ 19 G	P2.2 ■ 17 E	P2.3 ■ 15 C	P3.1 ■ 9 D	P3.2 ■ 7 D	P3.3 ■ 6 C	P4.1 ■ 5 D	P4.2 ■ 4 C	P4.3 ■ 4 B	M1.1 ■ 16 C	M1.2 ■ 14 C
M2.1 ■ 15 C	M2.2 ■ 12 C	M3.1 ■ 5 E	M3.2 ■ 4 E	M3.3 ■ 4 E	M4.1 ■ 8 A	K1.1 ■ 22 G	K1.2 ■ 16 D	K1.3 ■ 12 D	K2.1 ■ 16 C	K2.2 ■ 13 C	K2.3 ■ 10 C	K3.1 ■ 14 C	K3.2 ■ 11 C
K3.3 ■ 9 C	K4.1 ■ 13 C	K4.2 ■ 10 C	K4.3 ■ 7 C	K4.4 ■ 6 C	K4.5 ■ 5 C	K5.1 ■ 15 C	K5.2 ■ 11 C	K5.3 ■ 9 C	N1.1 ■ 33 H	N1.2 ■ 25 H	N1.3 ■ 17 G	N2.1 ■ 42 F	N2.2 ■ 37 F
N2.3 ■ 27 F	N3.1 ■ 56 F	N3.2 ■ 33 G	N3.3 ■ 17 D	N4.1 ■ 30 J	N4.2 ■ 30 H	N4.3 ■ 10 F	S1.1 ■ 15 D	S1.2 ■ 9 B	S1.3 ■ 5 A	S2.1 ■ 5 C	S2.2 ■ 4 A	S3.1 ■ 4 C	S3.2 ■ 3 A
S4.1 ■ 3 C	S4.2 ■ 2 A												

DC > 25.4mm less than 10xD.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A3458.0	—	8.00	0.3150	165.0	265.0	MK 1
A3458.5	—	8.50	0.3346	165.0	265.0	MK 1
A3459.0	—	9.00	0.3543	175.0	275.0	MK 1
A3459.5	—	9.50	0.3740	175.0	275.0	MK 1
A3453/8	3/8	9.52	0.3750	185.0	285.0	MK 1
A34510.0	—	10.00	0.3937	185.0	285.0	MK 1
A34513/32	13/32	10.32	0.4063	185.0	285.0	MK 1
A34510.5	—	10.50	0.4134	185.0	285.0	MK 1
A34511.0	—	11.00	0.4331	195.0	300.0	MK 1
A3457/16	7/16	11.11	0.4375	195.0	300.0	MK 1
A34511.5	—	11.50	0.4528	195.0	300.0	MK 1
A34529/64	29/64	11.51	0.4531	205.0	310.0	MK 1
A34512.0	—	12.00	0.4724	205.0	310.0	MK 1
A34512.5	—	12.50	0.4921	205.0	310.0	MK 1
A3451/2	1/2	12.70	0.5000	205.0	310.0	MK 1
A34513.0	—	13.00	0.5118	205.0	310.0	MK 1
A34517/32	17/32	13.49	0.5313	220.0	325.0	MK 1
A34513.5	—	13.50	0.5315	220.0	325.0	MK 1
A34514.0	—	14.00	0.5512	220.0	325.0	MK 1
A3459/16	9/16	14.29	0.5625	220.0	340.0	MK 2
A34537/64	37/64	14.68	0.5781	220.0	340.0	MK 2
A34515.0	—	15.00	0.5906	220.0	340.0	MK 2
A34539/64	39/64	15.48	0.6094	230.0	355.0	MK 2

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A34515.5	—	15.50	0.6102	230.0	355.0	MK 2
A3455/8	5/8	15.88	0.6250	230.0	355.0	MK 2
A34516.0	—	16.00	0.6299	230.0	355.0	MK 2
A34541/64	41/64	16.27	0.6406	230.0	355.0	MK 2
A34516.5	—	16.50	0.6496	230.0	355.0	MK 2
A34521/32	21/32	16.67	0.6563	230.0	355.0	MK 2
A34517.0	—	17.00	0.6693	230.0	355.0	MK 2
A34511/16	11/16	17.46	0.6875	245.0	370.0	MK 2
A34517.5	—	17.50	0.6890	245.0	370.0	MK 2
A34518.0	—	18.00	0.7087	245.0	370.0	MK 2
A34518.5	—	18.50	0.7283	245.0	370.0	MK 2
A34519.0	—	19.00	0.7480	245.0	370.0	MK 2
A3453/4	3/4	19.05	0.7500	260.0	385.0	MK 2
A34519.5	—	19.50	0.7677	260.0	385.0	MK 2
A34520.0	—	20.00	0.7874	260.0	385.0	MK 2
A34520.5	—	20.50	0.8071	260.0	385.0	MK 2
A34521.0	—	21.00	0.8268	260.0	385.0	MK 2
A34521.5	—	21.50	0.8465	270.0	405.0	MK 2
A34522.0	—	22.00	0.8661	270.0	405.0	MK 2
A3457/8	7/8	22.22	0.8750	270.0	405.0	MK 2
A34522.5	—	22.50	0.8858	270.0	405.0	MK 3
A34523.0	—	23.00	0.9055	270.0	405.0	MK 3
A34523.5	—	23.50	0.9252	270.0	425.0	MK 3

Product	DC	DC	DC	LCF	OAL	CZC MS
	(inch)	(mm)	(inch)	(mm)	(mm)	
B34524.0	—	24.00	0.9449	290.0	440.0	MK 3
B34524.5	—	24.50	0.9646	290.0	440.0	MK 3
B34525.0	—	25.00	0.9843	290.0	440.0	MK 3
B3451	1"	25.40	1.0000	290.0	440.0	MK 3
B34525.5	—	25.50	1.0039	290.0	440.0	MK 3
B34526.0	—	26.00	1.0236	290.0	440.0	MK 3
B34526.5	—	26.50	1.0433	290.0	440.0	MK 3
B34527.0	—	27.00	1.0630	305.0	460.0	MK 3
B34528.0	—	28.00	1.1024	305.0	460.0	MK 3
B34529.0	—	29.00	1.1417	305.0	460.0	MK 3
B34530.0	—	30.00	1.1811	305.0	460.0	MK 3
B3451.1/4	1.1/4	31.75	1.2500	320.0	480.0	MK 3

Product	DC	DC	DC	LCF	OAL	CZC MS
	(inch)	(mm)	(inch)	(mm)	(mm)	
A34531.0	—	31.00	1.2205	320.0	480.0	MK 3
A34532.0	—	32.00	1.2598	320.0	505.0	MK 4
A34533.0	—	33.00	1.2992	320.0	505.0	MK 4
A34534.0	—	34.00	1.3386	340.0	530.0	MK 4
A34535.0	—	35.00	1.3780	340.0	530.0	MK 4
A34536.0	—	36.00	1.4173	340.0	530.0	MK 4
A34537.0	—	37.00	1.4567	340.0	530.0	MK 4
A34538.0	—	38.00	1.4961	360.0	555.0	MK 4
A3451.1/2	1.1/2	38.10	1.5000	360.0	555.0	MK 4
A34539.0	—	39.00	1.5354	360.0	555.0	MK 4
A34540.0	—	40.00	1.5748	360.0	555.0	MK 4