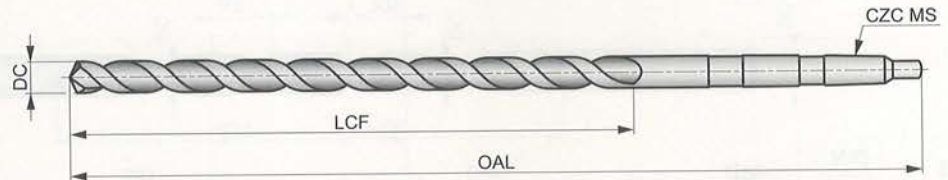


A952

HSS PFX Extra Long Series Taper Shank Drill (DIN 1870 Series 2), Bright Finish

A versatile drill with a special parabolic flute design for drilling deep holes in a single pass. The drill has a self-centering 130° point (centering with a short PFX Drill is recommended) so the force needed to drill the hole is reduced. Suitable for drilling many materials.



HSS	DIN 1870(2)	20xD
130°	Bright ST	
λ>35°	R	DC h8

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

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 25 G	■ 28 G	■ 29 G	■ 22 G	■ 19 E	■ 17 C	■ 12 D	■ 9 D	■ 8 C	■ 7 D	■ 6 C	■ 5 B	■ 16 C	■ 14 C
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 15 C	■ 12 C	■ 7 E	■ 6 E	■ 5 E	■ 12 A	■ 22 G	■ 16 D	■ 12 D	■ 16 C	■ 13 C	■ 10 C	■ 14 C	■ 11 C
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■ 9 C	■ 13 C	■ 10 C	■ 7 C	■ 6 C	■ 5 C	■ 15 C	■ 11 C	■ 9 C	■ 30 H	■ 23 H	■ 15 G	■ 37 F	■ 33 F
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■ 24 F	■ 56 F	■ 33 G	■ 17 D	■ 30 J	■ 30 H	■ 10 F	■ 18 D	■ 10 B	■ 6 A	■ 7 C	■ 4 A	■ 5 C	■ 3 A
S4.1	S4.2												
■ 4 C	■ 2 A												

DC >= 14.5mm less than 20xD; DC > 23mm Bright.

Product	DC	DC	LCF	OAL	CZC MS	Product	DC	DC	LCF	OAL	CZC MS
	(mm)	(inch)					(mm)	(mm)			
A9528.0	8.00	0.3150	210.0	330.0	MK 1	A95219.0	19.00	0.7480	310.0	465.0	MK 2
A9528.5	8.50	0.3346	210.0	330.0	MK 1	A95219.5	19.50	0.7677	325.0	490.0	MK 2
A9529.0	9.00	0.3543	220.0	345.0	MK 1	A95220.0	20.00	0.7874	325.0	490.0	MK 2
A95210.0	10.00	0.3937	235.0	360.0	MK 1	A95221.0	21.00	0.8268	325.0	490.0	MK 2
A95210.5	10.50	0.4134	235.0	360.0	MK 1	A95222.0	22.00	0.8661	345.0	515.0	MK 2
A95211.0	11.00	0.4331	250.0	375.0	MK 1	A95223.0	23.00	0.9055	345.0	515.0	MK 2
A95211.5	11.50	0.4528	250.0	375.0	MK 1	A95224.0	24.00	0.9449	365.0	555.0	MK 3
A95212.0	12.00	0.4724	260.0	395.0	MK 1	A95225.0	25.00	0.9843	365.0	555.0	MK 3
A95212.5	12.50	0.4921	260.0	395.0	MK 1	A95226.0	26.00	1.0236	365.0	555.0	MK 3
A95213.0	13.00	0.5118	260.0	395.0	MK 1	A95227.0	27.00	1.0630	385.0	580.0	MK 3
A95213.5	13.50	0.5315	275.0	410.0	MK 1	A95228.0	28.00	1.1024	385.0	580.0	MK 3
A95214.0	14.00	0.5512	275.0	410.0	MK 1	A95229.0	29.00	1.1417	385.0	580.0	MK 3
A95214.5	14.50	0.5709	275.0	425.0	MK 2	A95230.0	30.00	1.1811	385.0	580.0	MK 3
A95215.0	15.00	0.5906	275.0	425.0	MK 2	A95231.0	31.00	1.2205	410.0	610.0	MK 3
A95215.5	15.50	0.6102	295.0	445.0	MK 2	A95232.0	32.00	1.2598	410.0	635.0	MK 4
A95216.0	16.00	0.6299	295.0	445.0	MK 2	A95233.0	33.00	1.2992	410.0	635.0	MK 4
A95216.5	16.50	0.6496	295.0	445.0	MK 2	A95234.0	34.00	1.3386	430.0	665.0	MK 4
A95217.0	17.00	0.6693	295.0	445.0	MK 2	A95235.0	35.00	1.3780	430.0	665.0	MK 4
A95217.5	17.50	0.6890	310.0	465.0	MK 2	A95238.0	38.00	1.4961	460.0	695.0	MK 4
A95218.0	18.00	0.7087	310.0	465.0	MK 2	A95240.0	40.00	1.5748	460.0	695.0	MK 4
A95218.5	18.50	0.7283	310.0	465.0	MK 2						