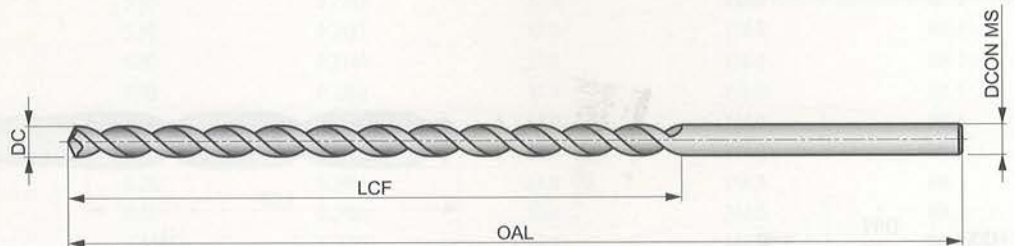


A978

PFX HSS-E (5% Cobalt) Extra Long Drill (DIN 1869 Series 3), Bright Finish

Recommended for extra deep holes and in applications where extra reach is needed. Specially designed parabolic flutes eliminate the need to drill deep holes in short steps (pecking). A 130° point. Centering with a short 3xD PFX drill is recommended (to keep same DC tolerance). Suitable for drilling many materials.

PFX



HSS-E	DIN 1869-3	25xD
130°	Bright	
>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
29 A	33 A	34 A	25 A	22 A	19 A	18 A	14 A	12 A	11 A	9 A	7 A	16 A	14 A
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2
15 A	12 A	8 A	7 A	6 A	8 A	20 A	16 A	13 A	17 A	13 A	11 A	16 A	12 A
K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N3.1	S1.1	S1.2	S1.3				
9 A	8 A	6 A	18 A	14 A	11 A	30 B	15 A	11 A	5 A				

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
HS783.0 ¹⁾	—	3.00	0.1181	160.0	240.0	3.00
HS783.5X265	—	3.50	0.1378	180.0	265.0	3.50
HS784.0X280	—	4.00	0.1575	190.0	280.0	4.00
HS784.5X295	—	4.50	0.1772	200.0	295.0	4.50
HS785.0X315	—	5.00	0.1969	210.0	315.0	5.00
HS785.5X330	—	5.50	0.2165	225.0	330.0	5.50
HS786.0X330	—	6.00	0.2362	225.0	330.0	6.00
HS781/4	1/4	6.35	0.2500	235.0	350.0	6.35
HS786.5X350	—	6.50	0.2559	235.0	350.0	6.50
HS787.0X370	—	7.00	0.2756	250.0	370.0	7.00
HS787.5X370	—	7.50	0.2953	250.0	370.0	7.50
HS788.0X390	—	8.00	0.3150	265.0	390.0	8.00
HS788.5X390	—	8.50	0.3346	265.0	390.0	8.50
HS789.0X410	—	9.00	0.3543	280.0	410.0	9.00
HS789.5X410	—	9.50	0.3740	280.0	410.0	9.50
HS7810.0X430	—	10.00	0.3937	295.0	430.0	10.00

¹⁾Dormer Standard.