

Drilling With ISCAR
FLASHDRILL
ECO SOLID LINE



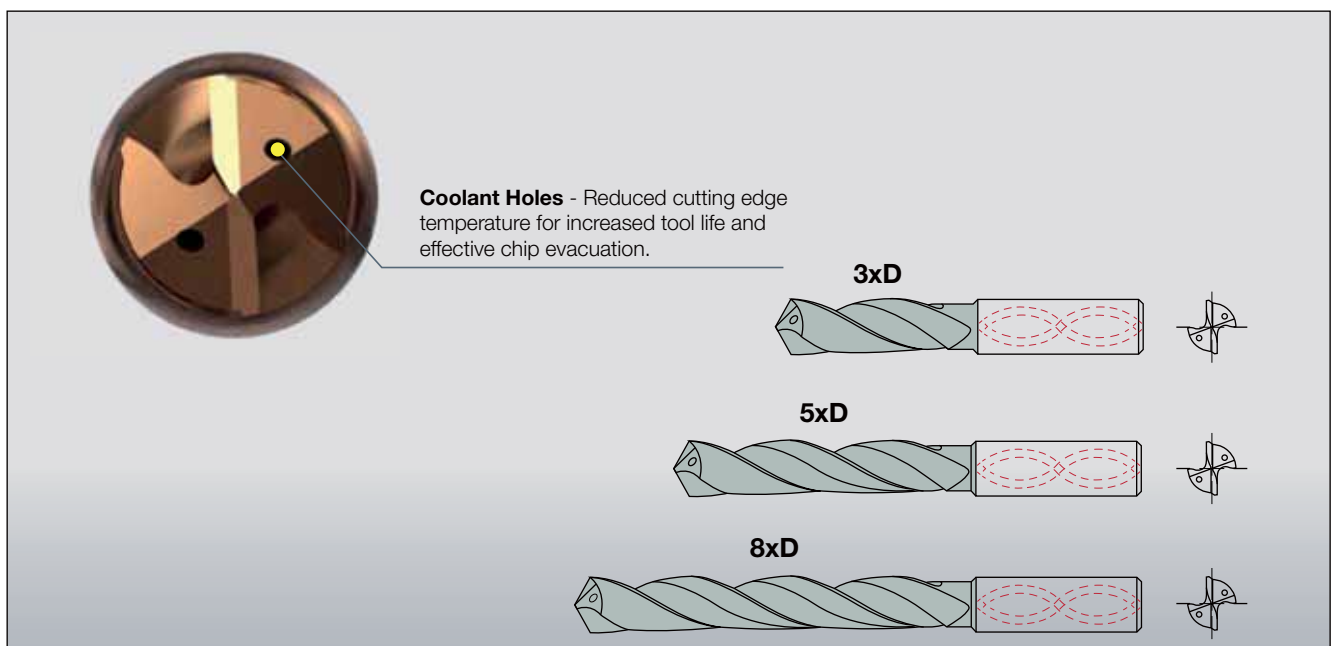
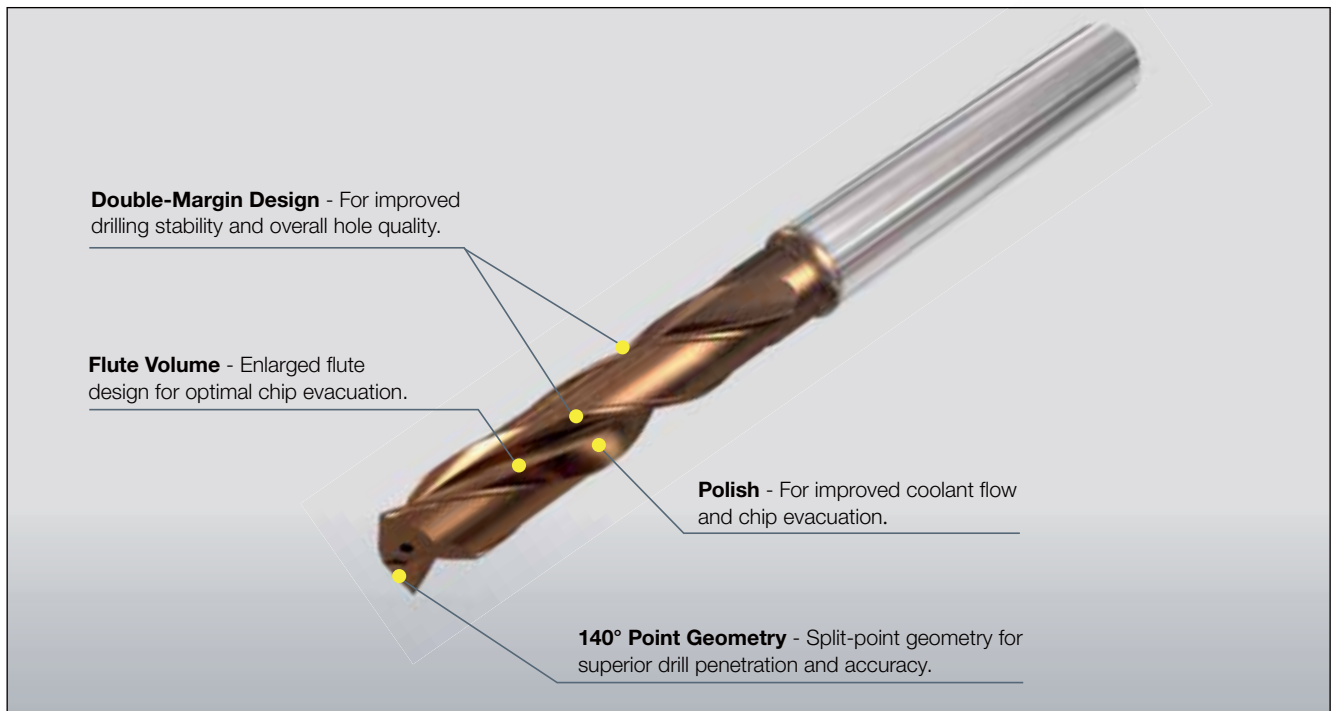
ekaKlingseisen
Werkzeuge & Maschinen



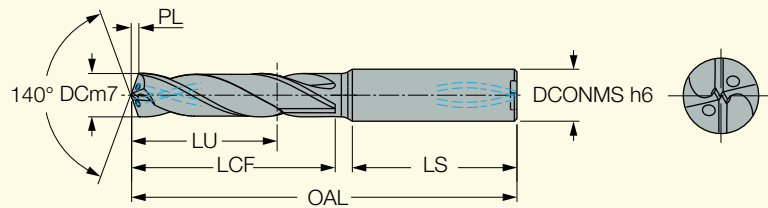
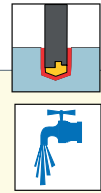
ISCAR introduces a new Flash solid carbide drill line in the diameter range of .118-.787" or 3-20 mm in 3xD, 5xD and 8xD drill lengths with internal coolant channels for general applications.

Drill Features

- 140° point geometry.
- **Double-Margin Design** – For improved drilling stability and overall hole quality.
- **Polished Flutes** – Improved chip evacuation process and prolonged tool life.
- **Coolant Holes** – Improved cutting edge tool life and chip evacuation.
- **Coating** – A multi-layer IC608 (AlTiCrSiN) coating enables drilling at high speeds.



SCD-ACP3FL (3XD)

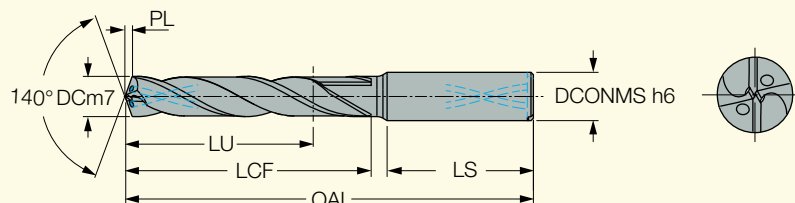
 Solid Carbide Drills with Coolant Holes,
 Drilling Depth 3xD (Available in North America Only)


I N C H									
Item No..	Designation	DC	DCONMS	LU	PL	LCF	LS	OAL	IC608
3411410	SCD0125-0600-0236 ACP3FL	.125	.236	.6000	.02000	.79	1.65	2.441	●
3411411	SCD0141-0577-0236 ACP3FL	.141	.236	.5770	.02250	.79	1.65	2.441	●
3411412	SCD0156-0711-0236 ACP3FL	.156	.236	.7110	.02500	.95	1.65	2.598	●
3411413	SCD0172-0687-0236 ACP3FL	.172	.236	.6870	.02750	.95	1.65	2.598	●
3411414	SCD0185-0667-0236 ACP3FL	.185	.236	.6670	.02960	.95	1.65	2.598	●
3411415	SCD0188-0821-0236 ACP3FL	.188	.236	.8210	.03000	1.10	1.50	2.598	●
3411416	SCD0189-0819-0236 ACP3FL	.189	.236	.8190	.03020	1.10	1.50	2.598	●
3411417	SCD0203-0798-0236 ACP3FL	.203	.236	.7980	.03250	1.10	1.50	2.598	●
3411418	SCD0204-0796-0236 ACP3FL	.204	.236	.7960	.03260	1.10	1.50	2.598	●
3411419	SCD0219-0774-0236 ACP3FL	.219	.236	.7740	.03500	1.10	1.50	2.598	●
3411420	SCD0234-0751-0236 ACP3FL	.234	.236	.7510	.03750	1.10	1.50	2.598	●
3411421	SCD0250-0964-0315 ACP3FL	.250	.315	.9640	.04000	1.34	1.77	3.110	●
3411422	SCD0266-0940-0315 ACP3FL	.266	.315	.9400	.04250	1.34	1.77	3.110	●
3411423	SCD0281-1192-0315 ACP3FL	.281	.315	1.1920	.04500	1.61	1.50	3.110	●
3411424	SCD0297-1169-0315 ACP3FL	.297	.315	1.1690	.04750	1.61	1.50	3.110	●
3411425	SCD0313-1146-0315 ACP3FL	.313	.315	1.1460	.05000	1.61	1.50	3.110	●
3411426	SCD0328-1358-0394 ACP3FL	.328	.394	1.3580	.05250	1.85	1.65	3.504	●
3411427	SCD0344-1335-0394 ACP3FL	.344	.394	1.3350	.05500	1.85	1.65	3.504	●
3411428	SCD0359-1311-0394 ACP3FL	.359	.394	1.3110	.05750	1.85	1.65	3.504	●
3411429	SCD0375-1288-0394 ACP3FL	.375	.394	1.2880	.06000	1.85	1.65	3.504	●
3411430	SCD0391-1265-0394 ACP3FL	.391	.394	1.2650	.06250	1.85	1.65	3.504	●
3411431	SCD0406-1556-0472 ACP3FL	.406	.472	1.5560	.06500	2.17	1.85	4.016	●
3411432	SCD0422-1533-0472 ACP3FL	.422	.472	1.5330	.06750	2.17	1.85	4.016	●
3411433	SCD0438-1509-0472 ACP3FL	.438	.472	1.5090	.07000	2.17	1.85	4.016	●
3411434	SCD0453-1486-0472 ACP3FL	.453	.472	1.4860	.07250	2.17	1.85	4.016	●
3411435	SCD0469-1462-0472 ACP3FL	.469	.472	1.4620	.07500	2.17	1.85	4.016	●
3411436	SCD0484-1636-0551 ACP3FL	.484	.551	1.6360	.07750	2.36	1.85	4.213	●
3411437	SCD0500-1612-0551 ACP3FL	.500	.551	1.6120	.08000	2.36	1.85	4.213	●
3411438	SCD0531-1565-0551 ACP3FL	.531	.551	1.5650	.08500	2.36	1.85	4.213	●
3411439	SCD0563-1715-0630 ACP3FL	.563	.630	1.7150	.09000	2.56	1.97	4.528	●
3411440	SCD0625-1622-0630 ACP3FL	.625	.630	1.6220	.10000	2.56	1.97	4.528	●
3420714	SCD0688-1772-0709 ACP3FL	.688	.709	1.7720	.09800	2.87	1.97	4.843	●
3411441	SCD0750-1985-0787 ACP3FL	.750	.787	1.9850	.12000	3.11	2.05	5.157	●

• Based on DIN 6537 standard

SCD-ACP5FL (5XD)

Solid Carbide Drills with Coolant Holes,
Drilling Depth 5xD (Available in North America Only)

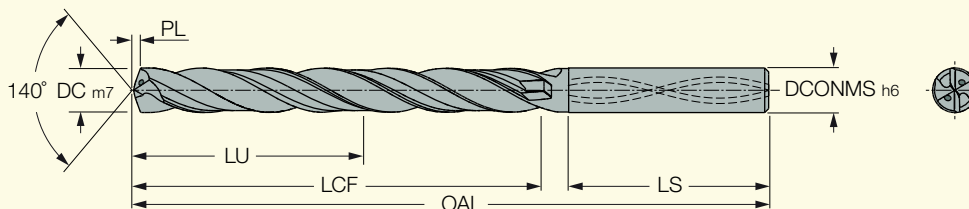


I N C H									
Item No..	Designation	DC	DCONMS	LU	PL	LCF	LS	OAL	IC608
3411442	SCD0125-0915-0236 ACP5FL	.125	.236	.9150	.02000	1.10	1.50	2.598	●
3411443	SCD0141-0892-0236 ACP5FL	.141	.236	.8920	.02250	1.10	1.50	2.598	●
3411444	SCD0156-1183-0236 ACP5FL	.156	.236	1.1830	.02500	1.42	1.50	2.913	●
3411445	SCD0172-1160-0236 ACP5FL	.172	.236	1.1600	.02750	1.42	1.50	2.913	●
3411446	SCD0185-1140-0236 ACP5FL	.185	.236	1.1400	.02960	1.42	1.50	2.913	●
3411447	SCD0188-1451-0236 ACP5FL	.188	.236	1.4510	.03000	1.73	1.50	3.228	●
3411448	SCD0189-1449-0236 ACP5FL	.189	.236	1.4490	.03020	1.73	1.50	3.228	●
3411449	SCD0203-1428-0236 ACP5FL	.203	.236	1.4280	.03250	1.73	1.50	3.228	●
3411450	SCD0204-1426-0236 ACP5FL	.204	.236	1.4260	.03260	1.73	1.50	3.228	●
3411451	SCD0219-1404-0236 ACP5FL	.219	.236	1.4040	.03500	1.73	1.50	3.228	●
3411452	SCD0234-1381-0236 ACP5FL	.234	.236	1.3810	.03750	1.73	1.50	3.228	●
3411453	SCD0250-1712-0315 ACP5FL	.250	.315	1.7120	.04000	2.09	1.50	3.583	●
3411454	SCD0266-1688-0315 ACP5FL	.266	.315	1.6880	.04250	2.09	1.50	3.583	●
3411455	SCD0281-1665-0315 ACP5FL	.281	.315	1.6650	.04500	2.09	1.50	3.583	●
3411456	SCD0297-1641-0315 ACP5FL	.297	.315	1.6410	.04750	2.09	1.50	3.583	●
3411457	SCD0313-1618-0315 ACP5FL	.313	.315	1.6180	.05000	2.09	1.50	3.583	●
3411458	SCD0328-1910-0394 ACP5FL	.328	.394	1.9100	.05250	2.40	1.65	4.055	●
3411459	SCD0344-1886-0394 ACP5FL	.344	.394	1.8860	.05500	2.40	1.65	4.055	●
3411460	SCD0359-1863-0394 ACP5FL	.359	.394	1.8630	.05750	2.40	1.65	4.055	●
3411461	SCD0375-1839-0394 ACP5FL	.375	.394	1.8390	.06000	2.40	1.65	4.055	●
3411462	SCD0391-1816-0394 ACP5FL	.391	.394	1.8160	.06250	2.40	1.65	4.055	●
3411463	SCD0406-2186-0472 ACP5FL	.406	.472	2.1860	.06500	2.80	1.85	4.646	●
3411464	SCD0422-2163-0472 ACP5FL	.422	.472	2.1630	.06750	2.80	1.85	4.646	●
3411465	SCD0438-2139-0472 ACP5FL	.438	.472	2.1390	.07000	2.80	1.85	4.646	●
3411466	SCD0453-2116-0472 ACP5FL	.453	.472	2.1160	.07250	2.80	1.85	4.646	●
3411467	SCD0469-2092-0472 ACP5FL	.469	.472	2.0920	.07500	2.80	1.85	4.646	●
3411468	SCD0484-2305-0551 ACP5FL	.484	.551	2.3050	.07750	3.03	1.85	4.882	●
3411469	SCD0500-2282-0551 ACP5FL	.500	.551	2.2820	.08000	3.03	1.85	4.882	●
3411470	SCD0531-2235-0551 ACP5FL	.531	.551	2.2350	.08500	3.03	1.85	4.882	●
3411471	SCD0563-2424-0630 ACP5FL	.563	.630	2.4240	.09000	3.27	1.97	5.236	●
3411472	SCD0625-2330-0630 ACP5FL	.625	.630	2.3300	.10000	3.27	1.97	5.236	●
3420735	SCD0688-2598-0709 ACP5FL	.688	.709	2.5980	.10000	3.66	1.97	5.630	●
3411473	SCD0750-2851-0787 ACP5FL	.750	.787	2.8510	.12000	3.98	2.05	6.024	●

● Based on DIN 6537 standard

SCD-ACP8FL (8XD)

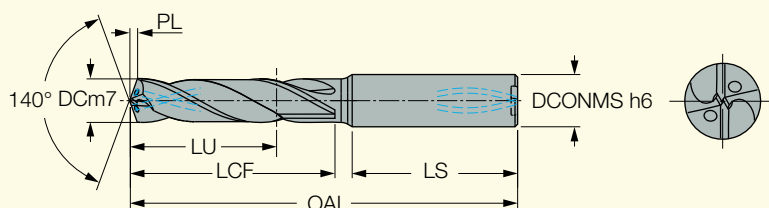
Solid Carbide Drills with Coolant Holes, Drilling Depth 8xD (Available in North America Only)



I N C H								
Designation	Dimensions							IC608
	DC	DCONMS	LU	PL	LCF	LS	OAL	
SCD0125-1151-0236 ACP8FL	.125	.236	1.1511	.02300	1.34	1.420	2.835	●
SCD0141-1128-0236 ACP8FL	.141	.236	1.1277	.02600	1.34	1.420	2.835	●
SCD0156-1459-0236 ACP8FL	.156	.236	1.4585	.02800	1.69	1.420	3.189	●
SCD0172-1435-0236 ACP8FL	.172	.236	1.4351	.03100	1.69	1.420	3.189	●
SCD0188-1963-0236 ACP8FL	.188	.236	1.9628	.03400	2.24	1.420	3.740	●
SCD0203-1939-0236 ACP8FL	.203	.236	1.9394	.03700	2.24	1.420	3.740	●
SCD0204-1938-0236 ACP8FL	.204	.236	1.9381	.03700	2.24	1.420	3.740	●
SCD0219-1916-0236 ACP8FL	.219	.236	1.9160	.04000	2.24	1.420	3.740	●
SCD0234-1893-0236 ACP8FL	.234	.236	1.8925	.04300	2.24	1.420	3.740	●
SCD0250-2617-0315 ACP8FL	.250	.315	2.6171	.04500	2.99	1.420	4.488	●
SCD0266-2594-0315 ACP8FL	.266	.315	2.5937	.04800	2.99	1.420	4.488	●
SCD0281-2570-0315 ACP8FL	.281	.315	2.5702	.05100	2.99	1.420	4.488	●
SCD0297-2547-0315 ACP8FL	.297	.315	2.5468	.05400	2.99	1.420	4.488	●
SCD0313-2523-0315 ACP8FL	.313	.315	2.5234	.05700	2.99	1.420	4.488	●
SCD0328-3248-0394 ACP8FL	.328	.394	3.2480	.06000	3.74	1.570	5.591	●
SCD0344-3225-0394 ACP8FL	.344	.394	3.2246	.06300	3.74	1.570	5.591	●
SCD0359-3201-0394 ACP8FL	.359	.394	3.2011	.06500	3.74	1.570	5.591	●
SCD0375-3178-0394 ACP8FL	.375	.394	3.1777	.06800	3.74	1.570	5.591	●
SCD0391-3154-0394 ACP8FL	.391	.394	3.1543	.07100	3.74	1.570	5.591	●
SCD0406-3879-0472 ACP8FL	.406	.472	3.8788	.07400	4.49	1.570	6.378	●
SCD0422-3855-0472 ACP8FL	.422	.472	3.8554	.07700	4.49	1.570	6.378	●
SCD0438-3832-0472 ACP8FL	.438	.472	3.8320	.08000	4.49	1.570	6.378	●
SCD0453-3809-0472 ACP8FL	.453	.472	3.8086	.08200	4.49	1.570	6.378	●
SCD0469-3785-0472 ACP8FL	.469	.472	3.7852	.08500	4.49	1.570	6.378	●
SCD0484-4431-0551 ACP8FL	.484	.551	4.4309	.08800	5.16	1.570	7.008	●
SCD0500-4408-0551 ACP8FL	.500	.551	4.4075	.09100	5.16	1.570	7.008	●
SCD0531-4361-0551 ACP8FL	.531	.551	4.3606	.09700	5.16	1.570	7.008	●
SCD0563-5141-0630 ACP8FL	.563	.630	5.1406	.10200	5.98	1.770	7.992	●
SCD0625-5047-0630 ACP8FL	.625	.630	5.0468	.11400	5.98	1.770	7.992	●
SCD0688-5699-0709 ACP8FL	.688	.709	5.6989	.12500	6.73	1.770	8.740	●
SCD0750-6355-0787 ACP8FL	.750	.787	6.3553	.13600	7.48	1.770	9.567	●

• Based on DIN 6537 standard • For user guide and cutting conditions, see pages • For regrinding instructions, see pages

SCD-ACP3FL (3XD)

 Solid Carbide Drills with Coolant Holes,
 Drilling Depth 3xD (Available in North America Only)


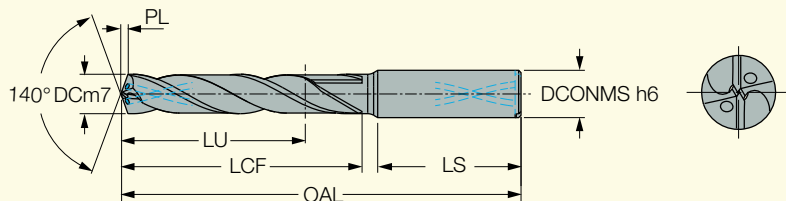
M E T R I C									
Item No..	Designation	Dimensions							IC608
		DC	DCONMS	OAL	LU	LCF	PL	LS	
3411474	SCD 030-014-060 ACP3FL	3.00	6.00	62.00	14.00	20.0	0.430	42.0	●
3411475	SCD 031-014-060 ACP3FL	3.10	6.00	62.00	14.00	20.0	0.440	42.0	●
3411476	SCD 032-014-060 ACP3FL	3.20	6.00	62.00	14.00	20.0	0.460	42.0	●
3411477	SCD 033-014-060 ACP3FL	3.30	6.00	62.00	14.00	20.0	0.470	42.0	●
3411478	SCD 034-014-060 ACP3FL	3.40	6.00	62.00	14.00	20.0	0.490	42.0	●
3411479	SCD 035-014-060 ACP3FL	3.50	6.00	62.00	14.00	20.0	0.500	42.0	●
3411480	SCD 036-014-060 ACP3FL	3.60	6.00	62.00	14.00	20.0	0.510	42.0	●
3411481	SCD 037-014-060 ACP3FL	3.70	6.00	62.00	14.00	20.0	0.530	42.0	●
3411482	SCD 038-017-060 ACP3FL	3.80	6.00	66.00	17.00	24.0	0.540	42.0	●
3411483	SCD 039-017-060 ACP3FL	3.90	6.00	66.00	17.00	24.0	0.560	42.0	●
3411484	SCD 040-017-060 ACP3FL	4.00	6.00	66.00	17.00	24.0	0.570	42.0	●
3411485	SCD 041-017-060 ACP3FL	4.10	6.00	66.00	17.00	24.0	0.590	42.0	●
3411486	SCD 042-017-060 ACP3FL	4.20	6.00	66.00	17.00	24.0	0.600	42.0	●
3411487	SCD 043-017-060 ACP3FL	4.30	6.00	66.00	17.00	24.0	0.610	42.0	●
3411488	SCD 044-017-060 ACP3FL	4.40	6.00	66.00	17.00	24.0	0.630	42.0	●
3411489	SCD 045-017-060 ACP3FL	4.50	6.00	66.00	17.00	24.0	0.640	42.0	●
3411490	SCD 046-017-060 ACP3FL	4.60	6.00	66.00	17.00	24.0	0.660	42.0	●
3420695	SCD 047-017-060 ACP3FL	4.70	6.00	66.00	17.00	28.0	0.670	38.0	●
3420696	SCD 048-019-060 ACP3FL	4.80	6.00	66.00	19.00	28.0	0.690	38.0	●
3411491	SCD 049-019-060 ACP3FL	4.90	6.00	66.00	19.00	28.0	0.700	38.0	●
3411492	SCD 050-019-060 ACP3FL	5.00	6.00	66.00	19.00	28.0	0.720	38.0	●
3411493	SCD 051-019-060 ACP3FL	5.10	6.00	66.00	19.00	28.0	0.730	38.0	●
3411494	SCD 052-019-060 ACP3FL	5.20	6.00	66.00	19.00	28.0	0.740	38.0	●
3411495	SCD 053-019-060 ACP3FL	5.30	6.00	66.00	19.00	28.0	0.760	38.0	●
3411496	SCD 054-019-060 ACP3FL	5.40	6.00	66.00	19.00	28.0	0.770	38.0	●
3411497	SCD 055-019-060 ACP3FL	5.50	6.00	66.00	19.00	28.0	0.790	38.0	●
3411498	SCD 056-019-060 ACP3FL	5.60	6.00	66.00	19.00	28.0	0.800	38.0	●
3411499	SCD 057-019-060 ACP3FL	5.70	6.00	66.00	19.00	28.0	0.820	38.0	●
3411500	SCD 058-019-060 ACP3FL	5.80	6.00	66.00	19.00	28.0	0.830	38.0	●
3411501	SCD 059-019-060 ACP3FL	5.90	6.00	66.00	19.00	28.0	0.840	38.0	●
3411502	SCD 060-019-060 ACP3FL	6.00	6.00	66.00	19.00	28.0	0.860	38.0	●
3411503	SCD 061-023-080 ACP3FL	6.10	8.00	79.00	23.00	34.0	0.870	45.0	●
3411504	SCD 062-023-080 ACP3FL	6.20	8.00	79.00	23.00	34.0	0.890	45.0	●
3411505	SCD 063-023-080 ACP3FL	6.30	8.00	79.00	23.00	34.0	0.900	45.0	●
3411506	SCD 064-023-080 ACP3FL	6.40	8.00	79.00	23.00	34.0	0.920	45.0	●
3411507	SCD 065-023-080 ACP3FL	6.50	8.00	79.00	23.00	34.0	0.930	45.0	●
3411508	SCD 066-023-080 ACP3FL	6.60	8.00	79.00	23.00	34.0	0.940	45.0	●
3411509	SCD 067-023-080 ACP3FL	6.70	8.00	79.00	23.00	34.0	0.960	45.0	●
3411510	SCD 068-023-080 ACP3FL	6.80	8.00	79.00	23.00	34.0	0.970	45.0	●
3411511	SCD 069-028-080 ACP3FL	6.90	8.00	79.00	28.00	41.0	0.990	38.0	●
3411512	SCD 070-028-080 ACP3FL	7.00	8.00	79.00	28.00	41.0	1.000	38.0	●
3411513	SCD 071-028-080 ACP3FL	7.10	8.00	79.00	28.00	41.0	1.020	38.0	●
3411514	SCD 072-028-080 ACP3FL	7.20	8.00	79.00	28.00	41.0	1.030	38.0	●
3411515	SCD 073-028-080 ACP3FL	7.30	8.00	79.00	28.00	41.0	1.040	38.0	●
3411516	SCD 074-028-080 ACP3FL	7.40	8.00	79.00	28.00	41.0	1.060	38.0	●
3411517	SCD 075-028-080 ACP3FL	7.50	8.00	79.00	28.00	41.0	1.070	38.0	●
3420697	SCD 076-028-080 ACP3FL	7.60	8.00	79.00	28.00	41.0	1.090	38.0	●
3411518	SCD 077-028-080 ACP3FL	7.70	8.00	79.00	28.00	41.0	1.100	38.0	●
3411519	SCD 078-028-080 ACP3FL	7.80	8.00	79.00	28.00	41.0	1.120	38.0	●
3411520	SCD 079-028-080 ACP3FL	7.90	8.00	79.00	28.00	41.0	1.130	38.0	●
3411521	SCD 080-028-080 ACP3FL	8.00	8.00	79.00	28.00	41.0	1.140	38.0	●
3411522	SCD 081-032-100 ACP3FL	8.10	10.00	89.00	32.00	47.0	1.160	42.0	●
3411523	SCD 082-032-100 ACP3FL	8.20	10.00	89.00	32.00	47.0	1.170	42.0	●
3411524	SCD 083-032-100 ACP3FL	8.30	10.00	89.00	32.00	47.0	1.190	42.0	●

• Based on DIN 6537 standard

M E T R I C									
Item No..	Designation	Dimensions							IC608
		DC	DCONMS	OAL	LU	LCF	PL	LS	
3411525	SCD 084-032-100 ACP3FL	8.40	10.00	89.00	32.00	47.0	1.200	42.0	●
3411526	SCD 085-032-100 ACP3FL	8.50	10.00	89.00	32.00	47.0	1.220	42.0	●
3411527	SCD 086-032-100 ACP3FL	8.60	10.00	89.00	32.00	47.0	1.230	42.0	●
3411528	SCD 087-032-100 ACP3FL	8.70	10.00	89.00	32.00	47.0	1.240	42.0	●
3411529	SCD 088-032-100 ACP3FL	8.80	10.00	89.00	32.00	47.0	1.260	42.0	●
3420698	SCD 089-032-100 ACP3FL	8.90	10.00	89.00	32.00	47.0	1.270	42.0	●
3411530	SCD 090-032-100 ACP3FL	9.00	10.00	89.00	32.00	47.0	1.290	42.0	●
3420699	SCD 091-032-100 ACP3FL	9.10	10.00	89.00	32.00	47.0	1.300	42.0	●
3411531	SCD 092-032-100 ACP3FL	9.20	10.00	89.00	32.00	47.0	1.320	42.0	●
3420700	SCD 093-032-100 ACP3FL	9.30	10.00	89.00	32.00	47.0	1.330	42.0	●
3420701	SCD 094-032-100 ACP3FL	9.40	10.00	89.00	32.00	47.0	1.340	42.0	●
3411532	SCD 095-032-100 ACP3FL	9.50	10.00	89.00	32.00	47.0	1.360	42.0	●
3411533	SCD 096-032-100 ACP3FL	9.60	10.00	89.00	32.00	47.0	1.370	42.0	●
3420702	SCD 097-032-100 ACP3FL	9.70	10.00	89.00	32.00	47.0	1.390	45.0	●
3411534	SCD 098-032-100 ACP3FL	9.80	10.00	89.00	32.00	47.0	1.400	42.0	●
3411535	SCD 099-032-100 ACP3FL	9.90	10.00	89.00	32.00	47.0	1.420	42.0	●
3411536	SCD 100-032-100 ACP3FL	10.00	10.00	89.00	32.00	47.0	1.430	42.0	●
3411537	SCD 101-037-120 ACP3FL	10.10	12.00	102.00	37.00	55.0	1.440	47.0	●
3411538	SCD 102-037-120 ACP3FL	10.20	12.00	102.00	37.00	55.0	1.460	47.0	●
3411539	SCD 103-037-120 ACP3FL	10.30	12.00	102.00	37.00	55.0	1.470	47.0	●
3411540	SCD 104-037-120 ACP3FL	10.40	12.00	102.00	37.00	55.0	1.490	47.0	●
3411541	SCD 105-037-120 ACP3FL	10.50	12.00	102.00	37.00	55.0	1.500	47.0	●
3420703	SCD 106-037-120 ACP3FL	10.60	12.00	102.00	37.00	55.0	1.520	47.0	●
3420704	SCD 107-037-120 ACP3FL	10.70	12.00	102.00	37.00	55.0	1.530	47.0	●
3411542	SCD 108-037-120 ACP3FL	10.80	12.00	102.00	37.00	55.0	1.540	47.0	●
3420705	SCD 109-037-120 ACP3FL	10.90	12.00	102.00	37.00	55.0	1.560	47.0	●
3411543	SCD 110-037-120 ACP3FL	11.00	12.00	102.00	37.00	55.0	1.570	47.0	●
3411544	SCD 111-037-120 ACP3FL	11.10	12.00	102.00	37.00	55.0	1.590	47.0	●
3411545	SCD 112-037-120 ACP3FL	11.20	12.00	102.00	37.00	55.0	1.600	47.0	●
3420706	SCD 113-037-120 ACP3FL	11.30	12.00	102.00	37.00	55.0	1.620	47.0	●
3420707	SCD 114-037-120 ACP3FL	11.40	12.00	102.00	37.00	55.0	1.630	47.0	●
3411546	SCD 115-037-120 ACP3FL	11.50	12.00	102.00	37.00	55.0	1.640	47.0	●
3420708	SCD 116-037-120 ACP3FL	11.60	12.00	102.00	37.00	55.0	1.660	47.0	●
3411547	SCD 117-037-120 ACP3FL	11.70	12.00	102.00	37.00	55.0	1.670	47.0	●
3411548	SCD 118-037-120 ACP3FL	11.80	12.00	102.00	37.00	55.0	1.690	47.0	●
3420709	SCD 119-037-120 ACP3FL	11.90	12.00	102.00	37.00	55.0	1.700	47.0	●
3411549	SCD 120-037-120 ACP3FL	12.00	12.00	102.00	37.00	55.0	1.720	47.0	●
3411550	SCD 121-039-140 ACP3FL	12.10	14.00	107.00	39.00	60.0	1.730	47.0	●
3411551	SCD 122-039-140 ACP3FL	12.20	14.00	107.00	39.00	60.0	1.740	47.0	●
3411552	SCD 123-039-140 ACP3FL	12.30	14.00	107.00	39.00	60.0	1.760	47.0	●
3420710	SCD 124-039-140 ACP3FL	12.40	14.00	107.00	39.00	60.0	1.770	47.0	●
3411553	SCD 125-039-140 ACP3FL	12.50	14.00	107.00	39.00	60.0	1.790	47.0	●
3411554	SCD 126-039-140 ACP3FL	12.60	14.00	107.00	39.00	60.0	1.800	47.0	●
3420711	SCD 127-039-140 ACP3FL	12.70	14.00	107.00	39.00	60.0	1.820	47.0	●
3420712	SCD 128-039-140 ACP3FL	12.80	14.00	107.00	39.00	60.0	1.830	47.0	●
3420713	SCD 129-039-140 ACP3FL	12.90	14.00	107.00	39.00	60.0	1.840	47.0	●
3411555	SCD 130-039-140 ACP3FL	13.00	14.00	107.00	39.00	60.0	1.860	47.0	●
3411556	SCD 133-039-140 ACP3FL	13.30	14.00	107.00	39.00	60.0	1.900	47.0	●
3411557	SCD 135-039-140 ACP3FL	13.50	14.00	107.00	39.00	60.0	1.930	47.0	●
3411558	SCD 140-039-140 ACP3FL	14.00	14.00	107.00	39.00	60.0	2.000	47.0	●
3411559	SCD 145-041-160 ACP3FL	14.50	16.00	115.00	41.00	65.0	2.070	50.0	●
3411560	SCD 150-041-160 ACP3FL	15.00	16.00	115.00	41.00	65.0	2.150	50.0	●
3411561	SCD 155-041-160 ACP3FL	15.50	16.00	115.00	41.00	65.0	2.220	50.0	●
3411562	SCD 160-041-160 ACP3FL	16.00	16.00	115.00	41.00	65.0	2.290	50.0	●
3411563	SCD 165-045-180 ACP3FL	16.50	18.00	123.00	45.00	73.0	2.360	50.0	●
3411564	SCD 170-045-180 ACP3FL	17.00	18.00	123.00	45.00	73.0	2.430	50.0	●
3411565	SCD 175-045-180 ACP3FL	17.50	18.00	123.00	45.00	73.0	2.500	50.0	●
3411566	SCD 180-045-180 ACP3FL	18.00	18.00	123.00	45.00	73.0	2.570	50.0	●
3411567	SCD 185-048-200 ACP3FL	18.50	20.00	131.00	48.00	79.0	2.650	52.0	●
3420715	SCD 190-048-200 ACP3FL	19.00	20.00	131.00	48.00	79.0	2.720	52.0	●
3411568	SCD 195-048-200 ACP3FL	19.50	20.00	131.00	48.00	79.0	2.790	52.0	●
3411569	SCD 200-048-200 ACP3FL	20.00	20.00	131.00	48.00	79.0	2.860	52.0	●

• Based on DIN 6537 standard

SCD-ACP5FL (5XD)

 Solid Carbide Drills with Coolant Holes,
 Drilling Depth 5xD (Available in North America Only)

M E T R I C

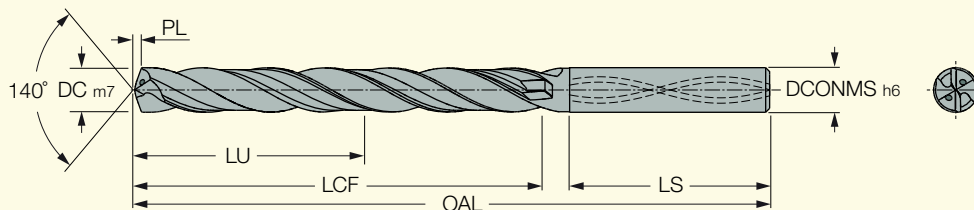
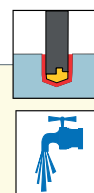
Item No..	Designation	Dimensions							IC608
		DC	DCONMS	OAL	LU	LCF	PL	LS	
3411570	SCD 030-022-060 ACP5FL	3.00	6.00	66.00	22.00	28.0	0.430	38.0	●
3411571	SCD 031-022-060 ACP5FL	3.10	6.00	66.00	22.00	28.0	0.440	38.0	●
3411572	SCD 032-022-060 ACP5FL	3.20	6.00	66.00	22.00	28.0	0.460	38.0	●
3411573	SCD 033-022-060 ACP5FL	3.30	6.00	66.00	22.00	28.0	0.470	38.0	●
3411574	SCD 034-022-060 ACP5FL	3.40	6.00	66.00	22.00	28.0	0.490	38.0	●
3411575	SCD 035-022-060 ACP5FL	3.50	6.00	66.00	22.00	28.0	0.500	38.0	●
3411576	SCD 036-022-060 ACP5FL	3.60	6.00	66.00	22.00	28.0	0.510	38.0	●
3411577	SCD 037-022-060 ACP5FL	3.70	6.00	66.00	22.00	28.0	0.530	38.0	●
3411578	SCD 038-029-060 ACP5FL	3.80	6.00	74.00	29.00	36.0	0.540	38.0	●
3411579	SCD 039-029-060 ACP5FL	3.90	6.00	74.00	29.00	36.0	0.560	38.0	●
3411580	SCD 040-029-060 ACP5FL	4.00	6.00	74.00	29.00	36.0	0.570	38.0	●
3411581	SCD 041-029-060 ACP5FL	4.10	6.00	74.00	29.00	36.0	0.590	38.0	●
3411582	SCD 042-029-060 ACP5FL	4.20	6.00	74.00	29.00	36.0	0.600	38.0	●
3411583	SCD 043-029-060 ACP5FL	4.30	6.00	74.00	29.00	36.0	0.610	38.0	●
3411584	SCD 044-029-060 ACP5FL	4.40	6.00	74.00	29.00	36.0	0.630	38.0	●
3411585	SCD 045-029-060 ACP5FL	4.50	6.00	74.00	29.00	36.0	0.640	38.0	●
3411586	SCD 046-029-060 ACP5FL	4.60	6.00	74.00	29.00	36.0	0.660	38.0	●
3420716	SCD 047-029-060 ACP5FL	4.70	6.90	82.00	29.00	44.0	0.670	38.0	●
3420717	SCD 048-035-060 ACP5FL	4.80	6.00	82.00	35.00	44.0	0.690	38.0	●
3411587	SCD 049-035-060 ACP5FL	4.90	6.00	82.00	35.00	44.0	0.700	38.0	●
3411588	SCD 050-035-060 ACP5FL	5.00	6.00	82.00	35.00	44.0	0.720	38.0	●
3411589	SCD 051-035-060 ACP5FL	5.10	6.00	82.00	35.00	44.0	0.730	38.0	●
3411590	SCD 052-035-060 ACP5FL	5.20	6.00	82.00	35.00	44.0	0.740	38.0	●
3411591	SCD 053-035-060 ACP5FL	5.30	6.00	82.00	35.00	44.0	0.760	38.0	●
3411592	SCD 054-035-060 ACP5FL	5.40	6.00	82.00	35.00	44.0	0.770	38.0	●
3411593	SCD 055-035-060 ACP5FL	5.50	6.00	82.00	35.00	44.0	0.790	38.0	●
3411594	SCD 056-035-060 ACP5FL	5.60	6.00	82.00	35.00	44.0	0.800	38.0	●
3411595	SCD 057-035-060 ACP5FL	5.70	6.00	82.00	35.00	44.0	0.820	38.0	●
3411596	SCD 058-035-060 ACP5FL	5.80	6.00	82.00	35.00	44.0	0.830	38.0	●
3411597	SCD 059-035-060 ACP5FL	5.90	6.00	82.00	35.00	44.0	0.840	38.0	●
3411598	SCD 060-035-060 ACP5FL	6.00	6.00	82.00	35.00	44.0	0.860	38.0	●
3411599	SCD 061-041-080 ACP5FL	6.10	8.00	91.00	41.00	53.0	0.870	38.0	●
3411600	SCD 062-041-080 ACP5FL	6.20	8.00	91.00	41.00	53.0	0.890	38.0	●
3411601	SCD 063-041-080 ACP5FL	6.30	8.00	91.00	41.00	53.0	0.900	38.0	●
3411602	SCD 064-041-080 ACP5FL	6.40	8.00	91.00	41.00	53.0	0.920	38.0	●
3411603	SCD 065-041-080 ACP5FL	6.50	8.00	91.00	41.00	53.0	0.930	38.0	●
3411604	SCD 066-041-080 ACP5FL	6.60	8.00	91.00	41.00	53.0	0.940	38.0	●
3411605	SCD 067-041-080 ACP5FL	6.70	8.00	91.00	41.00	53.0	0.960	38.0	●
3411606	SCD 068-041-080 ACP5FL	6.80	8.00	91.00	41.00	53.0	0.970	38.0	●
3411607	SCD 069-041-080 ACP5FL	6.90	8.00	91.00	41.00	53.0	0.990	38.0	●
3411608	SCD 070-041-080 ACP5FL	7.00	8.00	91.00	41.00	53.0	1.000	38.0	●
3411609	SCD 071-041-080 ACP5FL	7.10	8.00	91.00	41.00	53.0	1.020	38.0	●
3411610	SCD 072-041-080 ACP5FL	7.20	8.00	91.00	41.00	53.0	1.030	38.0	●
3411611	SCD 073-041-080 ACP5FL	7.30	8.00	91.00	41.00	53.0	1.040	38.0	●
3411612	SCD 074-041-080 ACP5FL	7.40	8.00	91.00	41.00	53.0	1.060	38.0	●
3411613	SCD 075-041-080 ACP5FL	7.50	8.00	91.00	41.00	53.0	1.070	38.0	●
3420718	SCD 076-041-080 ACP5FL	7.60	8.00	91.00	41.00	53.0	1.090	38.0	●
3411614	SCD 077-041-080 ACP5FL	7.70	8.00	91.00	41.00	53.0	1.100	38.0	●
3411615	SCD 078-041-080 ACP5FL	7.80	8.00	91.00	41.00	53.0	1.120	38.0	●
3411616	SCD 079-041-080 ACP5FL	7.90	8.00	91.00	41.00	53.0	1.130	38.0	●
3411617	SCD 080-041-080 ACP5FL	8.00	8.00	91.00	41.00	53.0	1.140	38.0	●
3411618	SCD 081-046-100 ACP5FL	8.10	10.00	103.00	46.00	61.0	1.160	42.0	●
3411619	SCD 082-046-100 ACP5FL	8.20	10.00	103.00	46.00	61.0	1.170	42.0	●
3411620	SCD 083-046-100 ACP5FL	8.30	10.00	103.00	46.00	61.0	1.190	42.0	●

• Based on DIN 6537 standard

M E T R I C									
Item No..	Designation	Dimensions							IC608
		DC	DCONMS	OAL	LU	LCF	PL	LS	
3411621	SCD 084-046-100 ACP5FL	8.40	10.00	103.00	46.00	61.0	1.200	42.0	●
3411622	SCD 085-046-100 ACP5FL	8.50	10.00	103.00	46.00	61.0	1.220	42.0	●
3411623	SCD 086-046-100 ACP5FL	8.60	10.00	103.00	46.00	61.0	1.230	42.0	●
3411624	SCD 087-046-100 ACP5FL	8.70	10.00	103.00	46.00	61.0	1.240	42.0	●
3411625	SCD 088-046-100 ACP5FL	8.80	10.00	103.00	46.00	61.0	1.260	42.0	●
3420719	SCD 089-046-100 ACP5FL	8.90	10.00	103.00	46.00	61.0	1.270	42.0	●
3411626	SCD 090-046-100 ACP5FL	9.00	10.00	103.00	46.00	61.0	1.290	42.0	●
3420720	SCD 091-046-100 ACP5FL	9.10	10.00	103.00	46.00	61.0	1.300	42.0	●
3411627	SCD 092-046-100 ACP5FL	9.20	10.00	103.00	46.00	61.0	1.320	42.0	●
3420721	SCD 093-046-100 ACP5FL	9.30	10.00	103.00	46.00	61.0	1.330	42.0	●
3420722	SCD 094-046-100 ACP5FL	9.40	10.00	103.00	46.00	61.0	1.340	42.0	●
3411628	SCD 095-046-100 ACP5FL	9.50	10.00	103.00	46.00	61.0	1.360	42.0	●
3411629	SCD 096-046-100 ACP5FL	9.60	10.00	103.00	46.00	61.0	1.370	42.0	●
3420723	SCD 097-046-100 ACP5FL	9.70	10.00	103.00	46.00	61.0	1.390	42.0	●
3411630	SCD 098-046-100 ACP5FL	9.80	10.00	103.00	46.00	61.0	1.400	42.0	●
3411631	SCD 099-046-100 ACP5FL	9.90	10.00	103.00	46.00	61.0	1.420	42.0	●
3411632	SCD 100-046-100 ACP5FL	10.00	10.00	103.00	46.00	61.0	1.430	42.0	●
3411633	SCD 101-053-120 ACP5FL	10.10	12.00	118.00	53.00	71.0	1.440	47.0	●
3411634	SCD 102-053-120 ACP5FL	10.20	12.00	118.00	53.00	71.0	1.460	47.0	●
3411635	SCD 103-053-120 ACP5FL	10.30	12.00	118.00	53.00	71.0	1.470	47.0	●
3411636	SCD 104-053-120 ACP5FL	10.40	12.00	118.00	53.00	71.0	1.490	47.0	●
3411637	SCD 105-053-120 ACP5FL	10.50	12.00	118.00	53.00	71.0	1.500	47.0	●
3420724	SCD 106-053-120 ACP5FL	10.60	12.00	118.00	53.00	71.0	1.520	47.0	●
3420725	SCD 107-053-120 ACP5FL	10.70	12.00	118.00	53.00	71.0	1.530	47.0	●
3411638	SCD 108-053-120 ACP5FL	10.80	12.00	118.00	53.00	71.0	1.540	47.0	●
3420726	SCD 109-053-120 ACP5FL	10.90	12.00	118.00	53.00	71.0	1.560	47.0	●
3411639	SCD 110-053-120 ACP5FL	11.00	12.00	118.00	53.00	71.0	1.570	47.0	●
3411640	SCD 111-053-120 ACP5FL	11.10	12.00	118.00	53.00	71.0	1.590	47.0	●
3411641	SCD 112-053-120 ACP5FL	11.20	12.00	118.00	53.00	71.0	1.600	47.0	●
3420727	SCD 113-053-120 ACP5FL	11.30	12.00	118.00	53.00	71.0	1.620	47.0	●
3420728	SCD 114-053-120 ACP5FL	11.40	12.00	118.00	53.00	71.0	1.630	47.0	●
3411642	SCD 115-053-120 ACP5FL	11.50	12.00	118.00	53.00	71.0	1.640	47.0	●
3420729	SCD 116-053-120 ACP5FL	11.60	12.00	118.00	53.00	71.0	1.660	47.0	●
3411643	SCD 117-053-120 ACP5FL	11.70	12.00	118.00	53.00	71.0	1.670	47.0	●
3411644	SCD 118-053-120 ACP5FL	11.80	12.00	118.00	53.00	71.0	1.690	47.0	●
3420730	SCD 119-053-120 ACP5FL	11.90	12.00	118.00	53.00	71.0	1.700	47.0	●
3411645	SCD 120-053-120 ACP5FL	12.00	12.00	118.00	53.00	71.0	1.720	47.0	●
3411646	SCD 121-056-140 ACP5FL	12.10	14.00	124.00	56.00	77.0	1.730	47.0	●
3411647	SCD 122-056-140 ACP5FL	12.20	14.00	124.00	56.00	77.0	1.740	47.0	●
3411648	SCD 123-056-140 ACP5FL	12.30	14.00	124.00	56.00	77.0	1.760	47.0	●
3420731	SCD 124-056-140 ACP5FL	12.40	12.00	124.00	56.00	77.0	1.770	47.0	●
3411649	SCD 125-056-140 ACP5FL	12.50	14.00	124.00	56.00	77.0	1.790	47.0	●
3411650	SCD 126-056-140 ACP5FL	12.60	14.00	124.00	56.00	77.0	1.800	47.0	●
3420732	SCD 127-056-140 ACP5FL	12.70	14.00	124.00	56.00	77.0	1.820	47.0	●
3420733	SCD 128-056-140 ACP5FL	12.80	14.00	124.00	56.00	77.0	1.830	47.0	●
3420734	SCD 129-056-140 ACP5FL	12.90	14.00	124.00	56.00	77.0	1.840	47.0	●
3411651	SCD 130-056-140 ACP5FL	13.00	14.00	124.00	56.00	77.0	1.860	47.0	●
3411652	SCD 133-056-140 ACP5FL	13.30	14.00	124.00	56.00	77.0	1.900	47.0	●
3411653	SCD 135-056-140 ACP5FL	13.50	14.00	124.00	56.00	77.0	1.930	47.0	●
3411654	SCD 140-056-140 ACP5FL	14.00	14.00	124.00	56.00	77.0	2.000	47.0	●
3411655	SCD 145-059-160 ACP5FL	14.50	16.00	133.00	59.00	83.0	2.070	50.0	●
3411656	SCD 150-059-160 ACP5FL	15.00	16.00	133.00	59.00	83.0	2.150	50.0	●
3411657	SCD 155-059-160 ACP5FL	15.50	16.00	133.00	59.00	83.0	2.220	50.0	●
3411658	SCD 160-059-160 ACP5FL	16.00	16.00	133.00	59.00	83.0	2.290	50.0	●
3411659	SCD 165-066-180 ACP5FL	16.50	18.00	143.00	66.00	93.0	2.360	50.0	●
3411660	SCD 170-066-180 ACP5FL	17.00	18.00	143.00	66.00	93.0	2.430	50.0	●
3411661	SCD 175-066-180 ACP5FL	17.50	18.00	143.00	66.00	93.0	2.500	50.0	●
3411662	SCD 180-066-180 ACP5FL	18.00	18.00	143.00	66.00	93.0	2.570	50.0	●
3411663	SCD 185-071-200 ACP5FL	18.50	20.00	153.00	71.00	101.0	2.650	52.0	●
3420736	SCD 190-071-200 ACP5FL	19.00	20.00	153.00	71.00	101.0	2.720	52.0	●
3411664	SCD 195-071-200 ACP5FL	19.50	20.00	153.00	71.00	101.0	2.790	52.0	●
3411665	SCD 200-071-200 ACP5FL	20.00	20.00	153.00	71.00	101.0	2.860	52.0	●

• Based on DIN 6537 standard

SCD-ACP8FL (8XD)

 Solid Carbide Drills with Coolant Holes,
 Drilling Depth 8xD (Available in North America Only)


M E T R I C									
Item No..	Designation	Dimensions							IC608
		DC	DCONMS	OAL	LU	LCF	PL	LS	
3450298	SCD 030-030-060 ACP8FL	3.00	6.00	72.00	30.00	34.0	0.550	36.0	●
3450299	SCD 031-029-060 ACP8FL	3.10	6.00	72.00	29.00	34.0	0.560	36.0	●
3450300	SCD 032-029-060 ACP8FL	3.20	6.00	72.00	29.00	34.0	0.580	36.0	●
3450301	SCD 033-029-060 ACP8FL	3.30	6.00	72.00	29.00	34.0	0.600	36.0	●
3450302	SCD 034-029-060 ACP8FL	3.40	6.00	72.00	29.00	34.0	0.620	36.0	●
3450303	SCD 035-029-060 ACP8FL	3.50	6.00	72.00	29.00	34.0	0.640	36.0	●
3450304	SCD 036-029-060 ACP8FL	3.60	6.00	72.00	29.00	34.0	0.660	36.0	●
3450305	SCD 037-028-060 ACP8FL	3.70	6.00	72.00	28.00	34.0	0.670	36.0	●
3450306	SCD 038-037-060 ACP8FL	3.80	6.00	81.00	37.00	43.0	0.690	36.0	●
3450307	SCD 039-037-060 ACP8FL	3.90	6.00	81.00	37.00	43.0	0.710	36.0	●
3450308	SCD 040-037-060 ACP8FL	4.00	6.00	81.00	37.00	43.0	0.730	36.0	●
3450309	SCD 041-037-060 ACP8FL	4.10	6.00	81.00	37.00	43.0	0.750	36.0	●
3450310	SCD 042-037-060 ACP8FL	4.20	6.00	81.00	37.00	43.0	0.760	36.0	●
3450311	SCD 043-037-060 ACP8FL	4.30	6.00	81.00	37.00	43.0	0.780	36.0	●
3450312	SCD 044-036-060 ACP8FL	4.40	6.00	81.00	36.00	43.0	0.800	36.0	●
3450313	SCD 045-036-060 ACP8FL	4.50	6.00	81.00	36.00	43.0	0.820	36.0	●
3450314	SCD 046-036-060 ACP8FL	4.60	6.00	81.00	36.00	43.0	0.840	36.0	●
3450315	SCD 047-036-060 ACP8FL	4.70	6.00	81.00	36.00	43.0	0.860	36.0	●
3450316	SCD 048-050-060 ACP8FL	4.80	6.00	95.00	50.00	57.0	0.870	36.0	●
3450317	SCD 049-050-060 ACP8FL	4.90	6.00	95.00	50.00	57.0	0.890	36.0	●
3450318	SCD 050-049-060 ACP8FL	5.00	6.00	95.00	49.00	57.0	0.910	36.0	●
3450319	SCD 051-049-060 ACP8FL	5.10	6.00	95.00	49.00	57.0	0.930	36.0	●
3450320	SCD 052-049-060 ACP8FL	5.20	6.00	95.00	49.00	57.0	0.950	36.0	●
3450321	SCD 053-049-060 ACP8FL	5.30	6.00	95.00	49.00	57.0	0.960	36.0	●
3450322	SCD 054-049-060 ACP8FL	5.40	6.00	95.00	49.00	57.0	0.980	36.0	●
3450323	SCD 055-049-060 ACP8FL	5.50	6.00	95.00	49.00	57.0	1.000	36.0	●
3450324	SCD 056-049-060 ACP8FL	5.60	6.00	95.00	49.00	57.0	1.020	36.0	●
3450325	SCD 057-048-060 ACP8FL	5.70	6.00	95.00	48.00	57.0	1.040	36.0	●
3450326	SCD 058-048-060 ACP8FL	5.80	6.00	95.00	48.00	57.0	1.060	36.0	●
3450327	SCD 059-048-060 ACP8FL	5.90	6.00	95.00	48.00	57.0	1.070	36.0	●
3450328	SCD 060-048-060 ACP8FL	6.00	6.00	95.00	48.00	57.0	1.090	36.0	●
3450329	SCD 061-067-080 ACP8FL	6.10	8.00	114.00	67.00	76.0	1.110	36.0	●
3450330	SCD 062-067-080 ACP8FL	6.20	8.00	114.00	67.00	76.0	1.130	36.0	●
3450331	SCD 063-067-080 ACP8FL	6.30	8.00	114.00	67.00	76.0	1.150	36.0	●
3450332	SCD 064-066-080 ACP8FL	6.40	8.00	114.00	66.00	76.0	1.160	36.0	●
3450333	SCD 065-066-080 ACP8FL	6.50	8.00	114.00	66.00	76.0	1.180	36.0	●
3450334	SCD 066-066-080 ACP8FL	6.60	8.00	114.00	66.00	76.0	1.200	36.0	●
3450335	SCD 067-066-080 ACP8FL	6.70	8.00	114.00	66.00	76.0	1.220	36.0	●
3450336	SCD 068-066-080 ACP8FL	6.80	8.00	114.00	66.00	76.0	1.240	36.0	●
3450337	SCD 069-066-080 ACP8FL	6.90	8.00	114.00	66.00	76.0	1.260	36.0	●
3450338	SCD 070-065-080 ACP8FL	7.00	8.00	114.00	65.00	76.0	1.270	36.0	●
3450339	SCD 071-065-080 ACP8FL	7.10	8.00	114.00	65.00	76.0	1.290	36.0	●
3450340	SCD 072-065-080 ACP8FL	7.20	8.00	114.00	65.00	76.0	1.310	36.0	●
3450341	SCD 073-065-080 ACP8FL	7.30	8.00	114.00	65.00	76.0	1.330	36.0	●
3450342	SCD 074-065-080 ACP8FL	7.40	8.00	114.00	65.00	76.0	1.350	36.0	●
3450343	SCD 075-065-080 ACP8FL	7.50	8.00	114.00	65.00	76.0	1.360	36.0	●

• Based on DIN 6537 standard

M E T R I C									
Item No..	Designation	Dimensions							IC608
		DC	DCONMS	OAL	LU	LCF	PL	LS	
3450344	SCD 076-065-080 ACP8FL	7.60	8.00	114.00	65.00	76.0	1.380	36.0	●
3450345	SCD 077-064-080 ACP8FL	7.70	8.00	114.00	64.00	76.0	1.400	36.0	●
3450346	SCD 078-064-080 ACP8FL	7.80	8.00	114.00	64.00	76.0	1.420	36.0	●
3450347	SCD 079-064-080 ACP8FL	7.90	8.00	114.00	64.00	76.0	1.440	36.0	●
3450348	SCD 080-064-080 ACP8FL	8.00	8.00	114.00	64.00	76.0	1.460	36.0	●
3450349	SCD 081-083-100 ACP8FL	8.10	10.00	142.00	83.00	95.0	1.470	40.0	●
3450350	SCD 082-083-100 ACP8FL	8.20	10.00	142.00	83.00	95.0	1.490	40.0	●
3450351	SCD 083-083-100 ACP8FL	8.30	10.00	142.00	83.00	95.0	1.510	40.0	●
3450352	SCD 084-082-100 ACP8FL	8.40	10.00	142.00	82.00	95.0	1.530	40.0	●
3450353	SCD 085-082-100 ACP8FL	8.50	10.00	142.00	82.00	95.0	1.550	40.0	●
3450354	SCD 086-082-100 ACP8FL	8.60	10.00	142.00	82.00	95.0	1.570	40.0	●
3450355	SCD 087-082-100 ACP8FL	8.70	10.00	142.00	82.00	95.0	1.580	40.0	●
3450356	SCD 088-082-100 ACP8FL	8.80	10.00	142.00	82.00	95.0	1.600	40.0	●
3450357	SCD 089-082-100 ACP8FL	8.90	10.00	142.00	82.00	95.0	1.620	40.0	●
3450358	SCD 090-082-100 ACP8FL	9.00	10.00	142.00	82.00	95.0	1.640	40.0	●
3450359	SCD 091-081-100 ACP8FL	9.10	10.00	142.00	81.00	95.0	1.660	40.0	●
3450360	SCD 092-081-100 ACP8FL	9.20	10.00	142.00	81.00	95.0	1.670	40.0	●
3450361	SCD 093-081-100 ACP8FL	9.30	10.00	142.00	81.00	95.0	1.690	40.0	●
3450362	SCD 094-081-100 ACP8FL	9.40	10.00	142.00	81.00	95.0	1.710	40.0	●
3450363	SCD 095-081-100 ACP8FL	9.50	10.00	142.00	81.00	95.0	1.730	40.0	●
3450364	SCD 096-081-100 ACP8FL	9.60	10.00	142.00	81.00	95.0	1.750	40.0	●
3450365	SCD 097-080-100 ACP8FL	9.70	10.00	142.00	80.00	95.0	1.770	40.0	●
3450366	SCD 098-080-100 ACP8FL	9.80	10.00	142.00	80.00	95.0	1.780	40.0	●
3450367	SCD 099-080-100 ACP8FL	9.90	10.00	142.00	80.00	95.0	1.800	40.0	●
3450368	SCD 100-080-100 ACP8FL	10.00	10.00	142.00	80.00	95.0	1.820	40.0	●
3450369	SCD 101-099-120 ACP8FL	10.10	12.00	162.00	99.00	114.0	1.840	40.0	●
3450370	SCD 102-099-120 ACP8FL	10.20	12.00	162.00	99.00	114.0	1.860	40.0	●
3450371	SCD 103-099-120 ACP8FL	10.30	12.00	162.00	99.00	114.0	1.870	40.0	●
3450372	SCD 104-098-120 ACP8FL	10.40	12.00	162.00	98.00	114.0	1.890	40.0	●
3450373	SCD 105-098-120 ACP8FL	10.50	12.00	162.00	98.00	114.0	1.910	40.0	●
3450374	SCD 106-098-120 ACP8FL	10.60	12.00	162.00	98.00	114.0	1.930	40.0	●
3450375	SCD 107-098-120 ACP8FL	10.70	12.00	162.00	98.00	114.0	1.950	40.0	●
3450376	SCD 108-098-120 ACP8FL	10.80	12.00	162.00	98.00	114.0	1.970	40.0	●
3450377	SCD 109-098-120 ACP8FL	10.90	12.00	162.00	98.00	114.0	1.980	40.0	●
3450378	SCD 110-098-120 ACP8FL	11.00	12.00	162.00	98.00	114.0	2.000	40.0	●
3450379	SCD 111-097-120 ACP8FL	11.10	12.00	162.00	97.00	114.0	2.020	40.0	●
3450380	SCD 112-097-120 ACP8FL	11.20	12.00	162.00	97.00	114.0	2.040	40.0	●
3450381	SCD 113-097-120 ACP8FL	11.30	12.00	162.00	97.00	114.0	2.060	40.0	●
3450382	SCD 114-097-120 ACP8FL	11.40	12.00	162.00	97.00	114.0	2.070	40.0	●
3450383	SCD 115-097-120 ACP8FL	11.50	12.00	162.00	97.00	114.0	2.090	40.0	●
3450384	SCD 116-097-120 ACP8FL	11.60	12.00	162.00	97.00	114.0	2.110	40.0	●
3450385	SCD 117-096-120 ACP8FL	11.70	12.00	162.00	96.00	114.0	2.130	40.0	●
3450386	SCD 118-096-120 ACP8FL	11.80	12.00	162.00	96.00	114.0	2.150	40.0	●
3450387	SCD 119-096-120 ACP8FL	11.90	12.00	162.00	96.00	114.0	2.170	40.0	●
3450388	SCD 120-096-120 ACP8FL	12.00	12.00	162.00	96.00	114.0	2.180	40.0	●
3450389	SCD 121-113-140 ACP8FL	12.10	14.00	178.00	113.00	131.0	2.200	40.0	●
3450390	SCD 122-113-140 ACP8FL	12.20	14.00	178.00	113.00	131.0	2.220	40.0	●
3450391	SCD 123-113-140 ACP8FL	12.30	14.00	178.00	113.00	131.0	2.240	40.0	●
3450392	SCD 124-112-140 ACP8FL	12.40	14.00	178.00	112.00	131.0	2.260	40.0	●
3450393	SCD 125-112-140 ACP8FL	12.50	14.00	178.00	112.00	131.0	2.270	40.0	●
3450394	SCD 126-112-140 ACP8FL	12.60	14.00	178.00	112.00	131.0	2.290	40.0	●
3450395	SCD 127-112-140 ACP8FL	12.70	14.00	178.00	112.00	131.0	2.310	40.0	●
3450396	SCD 128-112-140 ACP8FL	12.80	14.00	178.00	112.00	131.0	2.330	40.0	●
3450397	SCD 129-112-140 ACP8FL	12.90	14.00	178.00	112.00	131.0	2.350	40.0	●
3450398	SCD 130-112-140 ACP8FL	13.00	14.00	178.00	112.00	131.0	2.370	40.0	●
3450399	SCD 133-111-140 ACP8FL	13.30	14.00	178.00	111.00	131.0	2.420	40.0	●
3450400	SCD 135-111-140 ACP8FL	13.50	14.00	178.00	111.00	131.0	2.460	40.0	●
3450401	SCD 140-110-140 ACP8FL	14.00	14.00	178.00	110.00	131.0	2.550	40.0	●
3450402	SCD 145-130-160 ACP8FL	14.50	16.00	203.00	130.00	152.0	2.640	45.0	●

● Based on DIN 6537 standard

M E T R I C									
Item No..	Designation	Dimensions							IC608
		DC	DCONMS	OAL	LU	LCF	PL	LS	
3450403	SCD 150-129-160 ACP8FL	15.00	16.00	203.00	129.00	152.0	2.730	45.0	●
3450404	SCD 155-129-160 ACP8FL	15.50	16.00	203.00	129.00	152.0	2.820	45.0	●
3450405	SCD 160-128-160 ACP8FL	16.00	16.00	203.00	128.00	152.0	2.910	45.0	●
3450406	SCD 165-146-180 ACP8FL	16.50	18.00	222.00	146.00	171.0	3.000	45.0	●
3450407	SCD 170-146-180 ACP8FL	17.00	18.00	222.00	146.00	171.0	3.090	45.0	●
3450408	SCD 175-145-180 ACP8FL	17.50	18.00	222.00	145.00	171.0	3.180	45.0	●
3450409	SCD 180-144-180 ACP8FL	18.00	18.00	222.00	144.00	171.0	3.280	45.0	●
3450410	SCD 185-162-200 ACP8FL	18.50	20.00	243.00	162.00	190.0	3.370	45.0	●
3450411	SCD 190-161-200 ACP8FL	19.00	20.00	243.00	161.00	190.0	3.460	45.0	●
3450412	SCD 195-161-200 ACP8FL	19.50	20.00	243.00	161.00	190.0	3.550	45.0	●
3450413	SCD 200-160-200 ACP8FL	20.00	20.00	243.00	160.00	190.0	3.640	45.0	●

- Based on DIN 6537 standard

Tool Performance

Ø 7mm






























D.O.C – 25mm

Machining material – Alloy steel AISI 4340

Machine power – 22KW

Tool Tested - SCD 070-028-080 ACP3FL

VC (m/min)	80	80	80	80	80	100	100	100	100	100
f (mm/rev)	0.12	0.16	0.2	0.24	0.26	0.12	0.16	0.2	0.24	0.26
Top Diameter (mm)	7.01	7.009	7.01	7.012	7.014	7.011	7.014	7.014	7.012	7.016
Bottom Diameter (mm)	7.007	7.008	7.01	7.012	7.016	7.011	7.013	7.016	7.016	7.019
Cone Value (mm)	0.003	0.001	0	0	0.002	0	0.001	0.002	0.004	0.003
Roughness (Ra)	0.327	0.325	0.389	0.558	0.565	0.388	0.307	0.373	0.41	0.572
Roughness (Rz)	2.06	2.6	2.12	3.81	3.61	2.54	3.23	2.01	2.32	3.12
Hole Roundness (mm)	0.002	0.001	0.001	0.002	0.002	0.001	0.002	0.002	0.001	0.001
Min. Machine Power	18	20	23	26	27	26	28	32	34	37
Max. Machine Power	19	22	24	27	28	27	31	33	36	39
Noise	None	None	None	None	None	None	None	None	None	None
Vibration	None	None	None	None	None	None	None	None	None	None
Chip Evacuation	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
Chip Formation	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good
Penetration	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good

F mm/rev (IPR)					
VC m/min (SFM)	0.12 (0.0047)	0.16 (0.0062)	0.20 (0.0078)	0.24 (0.0094)	0.26 (0.0102)
80 (264)					
					
					
100 (330)					
					
					

The tool performs well in all recommended cutting parameters

Machining Data for Solid Carbide Drills - IC608 D=.118"-.787"

I N C H						
ISI	Material		Condition	Tensile Strength [ksi]	Hardness HB	Material Group No.
P	non-alloy steel and cast steel, free cutting steel	<0.25% C	annealed	61	125	1
		≥0.25% C	annealed	94	190	2
		<0.55% C	quenched and tempered	123	250	3
		≥0.55% C	annealed	109	220	4
			quenched and tempered	145	300	5
	low alloy and cast steel (less than 5% of alloying elements)		annealed	87	200	6
			quenched and tempered	135	275	7
			quenched and tempered	145	300	8
			quenched and tempered	174	350	9
	high alloyed steel, cast steel and tool steel		annealed	99	200	10
			quenched and tempered	160	325	11
	stainless steel and cast steel		ferritic / martensitic	99	200	12
			martensitic	119	240	13
M	stainless steel and cast steel		austenitic, duplex	87	180	14
K	gray cast iron (GG)		ferritic / pearlitic		180	15
			pearlitic / martensitic		260	16
	nodular cast iron (GGG)		ferritic		160	17
			pearlitic		250	18
	malleable cast iron		ferritic		130	19
			pearlitic		230	20
N	aluminum-wrought alloys		not hardenable		60	21
			hardenable		100	22
	aluminum-cast alloys	≤12% Si	not hardenable		75	23
			hardenable		90	24
		>12% Si	high temperature		130	25
	copper alloys	>1% Pb	free cutting		110	26
			brass		90	27
			electrolytic copper		100	28
	non metallic		duroplastics, fiber plastics		70 Shore D	29
			hard rubber		55 Shore D	30
S	high temperature alloys	Fe based	annealed		200	31
			hardened		280	32
		Ni or Co based	annealed		250	33
			hardened		350	34
			cast		320	35
	titanium alloys		pure	58	190	36
			alpha+beta alloys, hardened	152	310	37
H	hardened steel		hardened		55 HRC	38
			hardened		60 HRC	39
	chilled cast iron		cast		400	40
	cast iron		hardened		55 HRC	41

- When using external coolant supply only, reduce cutting speed by 10%
- Use internal coolant supply when machining austenitic stainless steel

I N C H					
Cutting Speed V _c (SFM)	Feed (IPR) vs. Drill Diameter				
	Ø.118-.197	Ø.200-.315	Ø.319-.472	Ø.476-.630	Ø.633-.787
262-393	0.004-0.007	0.006-0.010	0.008-0.012	0.008-0.014	0.010-0.016
262-360	0.004-0.007	0.006-0.010	0.008-0.012	0.008-0.014	0.010-0.016
230-328	0.004-0.008	0.006-0.011	0.008-0.014	0.008-0.015	0.010-0.017
230-295	0.004-0.007	0.006-0.010	0.008-0.012	0.008-0.014	0.010-0.016
196-262	0.004-0.007	0.006-0.010	0.008-0.012	0.008-0.014	0.010-0.016
164-230	0.004-0.008	0.006-0.011	0.008-0.014	0.008-0.015	0.010-0.017
196-262	0.004-0.008	0.006-0.011	0.007-0.014	0.008-0.015	0.010-0.017
164-230	0.004-0.006	0.005-0.008	0.006-0.010	0.006-0.012	0.007-0.013
82-246	0.002-0.004	0.002-0.006	0.002-0.007	0.003-0.008	0.004-0.008
82-246	0.002-0.004	0.002-0.006	0.002-0.007	0.003-0.008	0.004-0.008
82-246	0.002-0.004	0.002-0.006	0.002-0.007	0.003-0.008	0.004-0.008
278-344	0.006-0.010	0.008-0.014	0.010-0.018	0.012-0.020	0.014-0.022
246-295	0.006-0.010	0.008-0.014	0.010-0.018	0.012-0.020	0.014-0.022
212-262	0.005-0.008	0.006-0.010	0.080-0.014	0.010-0.016	0.012-0.018
230-980	0.004-0.010	0.006-0.014	0.010-0.018	0.012-0.020	0.014-0.022
230-650					
230-980	0.003-0.007	0.005-0.010	0.008-0.014	0.010-0.018	0.012-0.020
48-115	0.001-0.003	0.002-0.004	0.002-0.005	0.003-0.006	0.003-0.007
130-230	0.002-0.004	0.003-0.005	0.004-0.006	0.005-0.006	0.006-0.007

As a starting value, the middle of the recommended machining range should be used.
Then, (according to wear results), conditions can be changed in order to optimize performance.

Machining Data for Solid Carbide Drills - IC608 D=3.0-20.0 mm

M E T R I C					
ISO	Material	Condition	Tensile Strength [N/mm ²]	Hardness HB	Material Group No.
P	non-alloy steel and cast steel, free cutting steel	<0.25% C annealed	420	125	1
		≥0.25% C annealed	650	190	2
		<0.55% C quenched and tempered	850	250	3
		≥0.55% C annealed	750	220	4
			1000	300	5
	low alloy and cast steel (less than 5% of alloying elements)	quenched and tempered	600	200	6
			930	275	7
			1000	300	8
			1200	350	9
	high alloyed steel, cast steel and tool steel	annealed	680	200	10
		quenched and tempered	1100	325	11
	stainless steel and cast steel	ferritic / martensitic	680	200	12
		martensitic	820	240	13
M	stainless steel and cast steel	austenitic, duplex	600	180	14
K	gray cast iron (GG)	ferritic / pearlitic		180	15
		pearlitic / martensitic		260	16
	nodular cast iron (GGG)	ferritic		160	17
		pearlitic		250	18
	malleable cast iron	ferritic		130	19
		pearlitic		230	20
N	aluminum-wrought alloys	not hardenable		60	21
		hardenable		100	22
	aluminum-cast alloys	≤12% Si not hardenable		75	23
		hardenable		90	24
	>12% Si	high temperature		130	25
		>1% Pb free cutting		110	26
	copper alloys	brass		90	27
		electrolytic copper		100	28
S	high temperature alloys	Fe based annealed		200	31
		hardened		280	32
		Ni or Co based annealed		250	33
		hardened		350	34
		cast		320	35
	titanium alloys	pure	400	190	36
		alpha+beta alloys, hardened	1050	310	37
	hardened steel	hardened		55 HRC	38
		hardened		60 HRC	39
	chilled cast iron	cast		400	40
H	cast iron	hardened		55 HRC	41

- When using external coolant supply only, reduce cutting speed by 10%
- Use internal coolant supply when machining austenitic stainless steel

M E T R I C					
Cutting Speed V _c (m/min)	Feed (mm/rev) vs. Drill Diameter				
	Ø3-5	Ø5.1-8	Ø8.1-12	Ø12.1-16	Ø16.1-20
80-120	0.10-0.18	0.15-0.25	0.2-0.30	0.20-0.35	0.25-0.40
80-110	0.10-0.18	0.15-0.25	0.2-0.30	0.20-0.35	0.25-0.40
70-100	0.10-0.20	0.15-0.28	0.2-0.35	0.20-0.38	0.25-0.42
70-90	0.10-0.18	0.15-0.25	0.2-0.30	0.20-0.35	0.25-0.40
60-80	0.10-0.18	0.15-0.25	0.2-0.30	0.20-0.35	0.25-0.40
50-70	0.10-0.20	0.15-0.28	0.2-0.35	0.20-0.38	0.25-0.42
60-80	0.10-0.20	0.15-0.28	0.18-0.35	0.20-0.38	0.25-0.42
50-70	0.10-0.15	0.12-0.20	0.14-0.25	0.16-0.30	0.18-0.32
25-75	0.04-0.10	0.05-0.15	0.05-0.18	0.08-0.20	0.10-0.20
25-75	0.04-0.10	0.05-0.15	0.05-0.18	0.08-0.20	0.10-0.20
25-75	0.04-0.10	0.05-0.15	0.05-0.18	0.08-0.20	0.10-0.20
85-105	0.15-0.25	0.20-0.35	0.25-0.45	0.30-0.50	0.35-0.55
75-90	0.15-0.25	0.20-0.35	0.25-0.45	0.30-0.50	0.35-0.55
65-80	0.12-0.20	0.15-0.25	0.20-0.35	0.25-0.40	0.30-0.45
70-300	0.10-0.25	0.15-0.35	0.25-0.45	0.30-0.50	0.35-0.55
70-200					
70-300	0.07-0.18	0.12-0.25	0.20-0.35	0.25-0.45	0.30-0.50
15-35	0.02-0.07	0.04-0.10	0.06-0.12	0.08-0.15	0.08-0.18
40-70	0.06-0.10	0.08-0.12	0.10-0.14	0.12-0.16	0.14-0.18

As a starting value, the middle of the recommended machining range should be used.
Then, (according to wear results), conditions can be changed in order to optimize performance.

Drilling Tool Wear

Edge Chipping



Cause

- Low wear resistance carbide grade.
- Built-up edge has been formed.
- Insufficient coolant fluid.

Remedy

- Reduce feed rate.
- Increase cutting speed.
- Increase coolant pressure.
- Improve jet direction in case of external coolant supply.
- Change to different geometry.
- Check tool and part clamping rigidity.

Land Wear



Cause

- Cutting speed too high.
- Low wear resistance carbide grade.
- Radial run-out is too high.

Remedy

- Check that the correct geometry is used.
- Check that T.I.R. run-out does not exceed 0.02 mm.
- Reduce cutting speed.
- Increase coolant pressure.
- Improve jet direction in case of external coolant supply.
- Check and improve tool and part clamping rigidity.
- Check if collet gripping forces are too low
 - if so, replace collet.

Corner Fracture



Cause

Caused by excessive edge wear before replacing the drill

- The grade and geometry could be too weak for the applications.
- Excessive load on the drill.
- Built-up edge has been formed on the cutting edge.

Remedy

- Check radial run-out.
- Reduce feed rate.
- Increase the speed.
- Check tool and part clamping rigidity.
- Check if collet gripping forces are too low
 - if so, replace collet.
- Increase coolant pressure.
- Improve jet direction in case of external coolant supply.

Corner Chipping



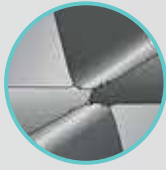
Cause

- Radial run-out is too high.
- Insufficient coolant fluid.

Remedy

- Check radial run-out.
- Reduce feed rate increase the speed.
- Check tool and part clamping rigidity.
- Check if collet gripping forces are too low
 - if so, replace collet.
- Increase coolant pressure.
- Improve jet direction in case of external coolant supply.

Chisel Chipping



Cause

- Chisel run-out is too big.
- Combination of high feed and low speed.

Remedy

- Reduce feed rate and increase the cutting speed.
- Check that chisel misalignment does not exceed 0.02 mm.
- Check tool and part clamping rigidity.
- Check if collet gripping forces are too low - if so, replace collet.

Built-up Edge



Cause

- Cutting zone temperature is too low.
- Negative cutting geometry.
- Machining of very sticky materials such as low-carbon steel, stainless steels, and aluminum.

Remedy

- Increase the feed.
- Increase cutting speed.
- Increase coolant pressure.
- Check oil percentage in the coolant fluid.

Plastic Deformation



Cause

- Cutting temperature is too high.

Remedy

- Check cutting parameters.
- Reduce cutting feed.
- Increase coolant pressure/volume.
- Use harder grade.
- Check that the correct geometry is used.

Crater Wear



Cause

- Excessive cutting temperature and pressure on the top of the drill.

Remedy

- Reduce cutting feed.
- Check that the correct geometry is used.

Thermal Cracking



Cause

- Excessive variations in surface temperature, intermittent machining, or variations in coolant supply.

Remedy

- Increase coolant pressure/volume.
- Increase oil concentration percentage.

Flank Wear



Cause

- High cutting speed.
- Low wear resistance carbide grade.

Remedy

- Check that the correct geometry is used.
- Increase coolant pressure.
- Change to harder grade.
- Increase oil concentration percentage.
- Reduce cutting speed and increase feed.

Drilling With ISCAR
FLASHDRILL
ECO SOLID LINE



Werkzeuge & Maschinen

Erich Klingseisen KG Brunnenstraße 2 78554 Aldingen

Tel. (07424) 98192-0
info@klingseisen.de

Fax. (07424) 84601
www.klingseisen.de