German Head Quarter
NACHI EUROPE GmbH
Bischofstraße 99
47809 Krefeld, Germany
Phone: +49 2151-65046-0
Fax: +49 2151-65046-90
http://www.nachi.de/

South Office Germany
NACHI EUROPE GmbH
Pleidelsheimer Straße 47
74321 Bietigheim-Bissingen, Germany
Phone: +49 7142-77418-0
Fax: +49 7142-77418-20

UK Branch
NACHI EUROPE GmbH
Unit 3, 92, Kettles Wood Drive,
Woodgate Business Park,
BIRMINGHAM, B32 3DB, UK
Phone: +44 121 423 2922
Fax: +44 121 421 7520
http://www.nachi.co.uk/

Spain Main Office
NACHI EUROPE GmbH
P.I. El Montalvo IIIC/Segunda, 6. Portal 1-2ª,
Oficina 537188 Carbajosa de la Sagrada
SALAMANCA (Spain)
Phone: +34 923 197 837
Fax: +34 923 197 758

CZ-Office
NACHI EUROPE GmbH
Sezemicka 2757/2
VGP Park – A1
Prague 9,
193 00, Czech Republic
Phone: +420-255 734 000
Fax: +420-255 734 001

Factories
NACHI CZECH S.R.O.
PRUMYSLOVA 2732
44001 Louny, Czech Republic
Phone: +420 415 930930
Fax: +420 415 930940
http://cz.nachi.de/czech
e-mail: info@nachi.de

Turkey Office
NACHI EUROPE GmbH
TURKEY REPRESENTATIVE OFFICE
Karaman Ciftligi Mevkii, Agaoglu My Prestige,
k:13 D:110 Atasehir 34746 Istanbul
Phone: +90 216 688 4457
Fax: +90 216 688 4458

NACHI-FUJIKOSHI CORP.

Tokyo Head Office
Shiodome Sumitomo Bldg., 1-9-2 Higashi-shinbashi, Minato-ku Toko, JAPAN
Phone: +81-3-5568-5240 Fax: +81-3-5568-5236
Web Site URL http://www.nachi-fujikoshi.co.jp/

Toyama Head Office
1-1-1 Fujikoshi-Honmachi, Toyama, JAPAN
Phone: +81-76-423-5111 Fax: +81-76-493-5211

Purchased These Fine Products From:

CATALOG NO.	2012.06.EN

CS-GE

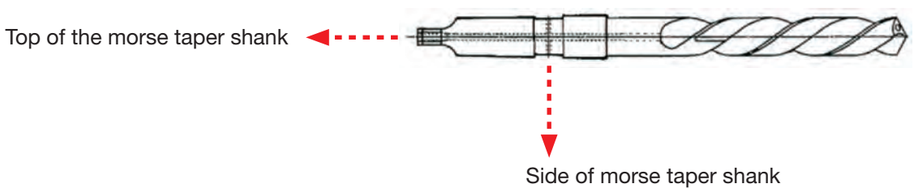
Symbio

List 6682

Taper Shank Oil Hole Drills
For Steel Fabrication Industry

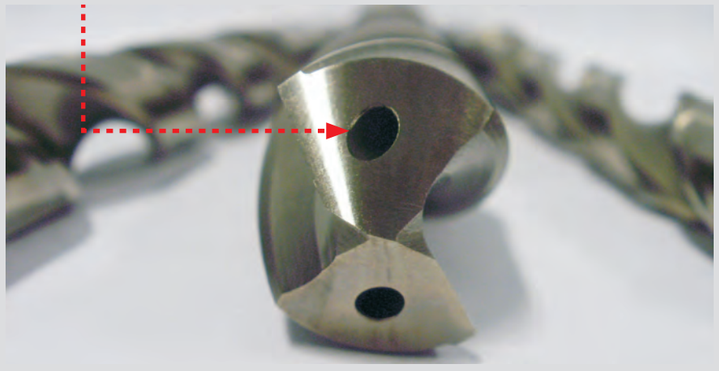
Taper Shank Oil Hole Drills
For Steel Fabrication Industry

1. **Made by HSS Co material with high cobalt content for long lasting operation**
2. **Specially designed for use in heavy duty industries like constructional metals (H beam, I beam, L beam, U beam etc.)**
3. **Point Angle 118°**
4. **Thick web reduces thrust force substantially, making it conducive for heavy duty deep hole drilling**
5. **Internal coolant: Type II**



6. **High Performance**

Deliver coolant to the point permit higher speeds and feeds and reduce heat and friction.



Selection Table

Drilling Depth				Workpiece Material															
				Carbon Steel		Alloy Steel	Mold Steel	Temperate Steel			Stainless Steel		Titanium Alloy	Nickel Alloy	Cast Iron		Aluminum			Cooper Alloy
≤3D	≤5D	≤7D	>7D	Low Carbon	High Carbon			HRC			Austenitic 300	Martensitic 400			Soft <200HB	Hard >200HB	6061, 7075	Casted Si ≤ 12 %	High Si Si > 13 %	
				1010, 1018	1045, 1065	4140, 4330	D2	≤35	35~45	45~65										
●	●	○			●	●	●	●	○		△	○	○	△	○	△	△	△		△

● Excellat ○ Good △ Ok

List 6682

h8 | HSS Co | HELIX N | 118° | X-type | OIL HOLE

Sizes: 12.0 a 50.0 mm

Suitable for heavy duty applications.

Dia.	Flute Length	OAL	MT No.
10,0	108	211	2
10,5	108	211	2
11,0	115	219	2
11,5	121	224	2
12,0	124	247	2
12,5	124	247	3
13,0	127	250	3
13,5	127	250	3
14,0	131	253	3
14,5	137	259	3
15,0	137	259	3
15,5	140	263	3
16,0	143	266	3
16,5	143	266	3
17,0	146	269	3
17,5	153	275	3
18,0	153	275	3
18,5	156	278	3
19,0	156	278	3
19,5	159	282	3
20,0	162	285	3
20,5	162	285	3
21,0	165	288	3
21,5	172	294	3
22,0	172	294	3
22,5	172	294	3
23,0	172	294	3
23,5	172	294	3
24,0	175	297	3
24,5	175	297	3
25,0	178	301	3
25,5	178	301	3

Dia	Flute Length	OAL	MT No.
26,0	178	301	3
26,5	178	301	3
27,0	181	329	4
27,5	181	329	4
28,0	194	342	4
28,5	194	342	4
29,0	194	342	4
29,5	200	348	4
30,0	200	348	4
30,5	200	348	4
31,0	200	348	4
31,5	207	355	4
32,0	229	377	4
32,5	229	377	4
33,0	229	377	4
34,0	235	383	4
35,0	235	383	4
36,0	239	386	4
37,0	239	386	4
38,0	245	393	4
39,0	245	428	4
40,0	251	434	4
41,0	261	444	4
42,0	264	447	4
43,0	264	447	4
44,0	264	447	4
45,0	264	447	4
46,0	264	447	4
47,0	264	447	4
48,0	270	453	4
49,0	270	453	4
50,0	270	453	4

Work piece Material	Carbon Steel		Alloy Steels, Hardened Steels		Mold Steels, Stainless Steels		Cast Iron		Aluminum, Non Ferrous Metals	
Cutting Speed	17~20 (m/min)		15~18 (m/min)		11~14 (m/min)		20~27 (m/min)		30~43 (m/min)	
Drill Dia. (mm)	RPM (min^{-1})	Feed (mm/min)	RPM (min^{-1})	Feed (mm/min)	RPM (min^{-1})	Feed (mm/min)	RPM (min^{-1})	Feed (mm/min)	RPM (min^{-1})	Feed (mm/min)
10	680	138	620	110	460	70	820	208	1200	305
11	580	133	530	94	400	61	700	196	970	271
13	510	117	460	93	350	62	620	189	850	259
16	410	115	370	94	280	57	490	174	680	242
19	340	112	310	87	230	53	410	156	570	217
22	290	96	270	75	200	51	350	151	490	212
25	260	92	230	70	180	50	310	142	430	197
32	210	85	190	63	140	39	250	121	340	164
38	170	73	160	57	120	37	210	112	290	155

1) The above values apply when coolant is used in vertical machine. In horizontal machine or deep hole, use pecking.
2) Adjust drilling condition when unusal vibration or different sound occurs.