

ECU-LINE

Quality tools with prices that stand out

D968S 3xD, 5xD

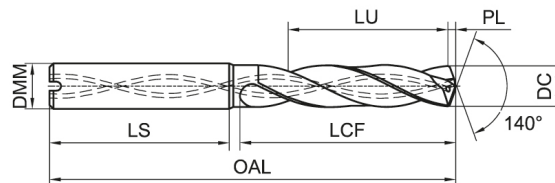
Drills for stainless steel,
carbon steel, alloy steel, heat-resistant alloy
and titanium alloy



D968S-A3N / D968S-A3C

3xD External / Internal Cooling Twist Drills

- Suitable for efficient drilling and machining of stainless steel, carbon steel, alloy steel, heat-resistant alloy and titanium alloy.
- The unique end edge design has stronger chip breaking ability and larger chip space.
- The new substrate coating combination offers super-strong toughness and wear resistance.
- The super-large geometry design features excellent chip removal performance.



Dimensions						Art.nr	Stock	Net price SEK	Net price DKK	Art.nr	Stock	Net price SEK	Net price DKK
DC (m7)	LCF	OAL	DMM (h6)	LS	LU								
1.00	7	45	4	30	5.5	D968S-A3N-0100	●	254	181				
1.10	7	45	4	30	5.4	D968S-A3N-0110	●	256	183				
1.20	7	45	4	30	5.2	D968S-A3N-0120	●	256	183				
1.30	7	45	4	30	5.1	D968S-A3N-0130	●	256	183				
1.40	7	45	4	30	4.9	D968S-A3N-0140	●	256	183				
1.50	9	55	4	38	6.8	D968S-A3N-0150	●	256	183				
1.60	9	55	4	38	6.6	D968S-A3N-0160	●	256	183				
1.70	9	55	4	38	6.5	D968S-A3N-0170	●	256	183				
1.80	9	55	4	38	6.3	D968S-A3N-0180	●	256	183				
1.90	9	55	4	38	6.2	D968S-A3N-0190	●	256	183				
2.00	13	55	4	36	10.0	D968S-A3N-0200	●	257	183	D968S-A3C-0200	●	328	234
2.10	13	55	4	36	9.9	D968S-A3N-0210	○	257	183	D968S-A3C-0210	○	328	234
2.20	13	55	4	36	9.7	D968S-A3N-0220	○	257	183	D968S-A3C-0220	○	328	234
2.30	13	55	4	36	9.6	D968S-A3N-0230	○	257	183	D968S-A3C-0230	○	328	234
2.40	17	55	4	33	13.4	D968S-A3N-0240	○	257	183	D968S-A3C-0240	○	328	234
2.50	17	55	4	33	13.3	D968S-A3N-0250	●	257	183	D968S-A3C-0250	●	328	234
2.60	17	55	4	33	13.1	D968S-A3N-0260	●	257	183	D968S-A3C-0260	○	328	234
2.70	17	55	4	33	13.0	D968S-A3N-0270	○	257	183	D968S-A3C-0270	○	328	234
2.80	17	55	4	33	12.8	D968S-A3N-0280	●	257	183	D968S-A3C-0280	○	328	234
2.90	17	55	4	33	12.7	D968S-A3N-0290	○	257	183	D968S-A3C-0290	○	328	234
3.00	20	62	6	36	15.5	D968S-A3N-0300	●	304	217	D968S-A3C-0300	●	349	249
3.05	20	62	6	36	15.4	D968S-A3N-0305	○	304	217				
3.10	20	62	6	36	15.4	D968S-A3N-0310	○	304	217	D968S-A3C-0310	●	349	249
3.20	20	62	6	36	15.2	D968S-A3N-0320	○	304	217	D968S-A3C-0320	●	349	249
3.25	20	62	6	36	15.1	D968S-A3N-0325	○	304	217	D968S-A3C-0325	○	349	249
3.30	20	62	6	36	15.1	D968S-A3N-0330	●	304	217	D968S-A3C-0330	●	349	249
3.40	20	62	6	36	14.9	D968S-A3N-0340	○	304	217	D968S-A3C-0340	●	349	249
3.50	20	62	6	36	14.8	D968S-A3N-0350	●	304	217	D968S-A3C-0350	●	349	249
3.60	20	62	6	36	14.6	D968S-A3N-0360	○	304	217	D968S-A3C-0360	○	349	249
3.70	20	62	6	36	14.5	D968S-A3N-0370	○	304	217	D968S-A3C-0370	○	349	249
3.80	24	66	6	36	18.3	D968S-A3N-0380	○	305	218	D968S-A3C-0380	○	349	249
3.90	24	66	6	36	18.2	D968S-A3N-0390	○	305	218	D968S-A3C-0390	○	349	249
4.00	24	66	6	36	18.0	D968S-A3N-0400	●	305	218	D968S-A3C-0400	●	349	249
4.10	24	66	6	36	17.9	D968S-A3N-0410	○	305	218	D968S-A3C-0410	○	349	249
4.15	24	66	6	36	17.8	D968S-A3N-0415	○	305	218				
4.20	24	66	6	36	17.7	D968S-A3N-0420	●	305	218	D968S-A3C-0420	●	349	249
4.30	24	66	6	36	17.6	D968S-A3N-0430	●	305	218	D968S-A3C-0430	●	349	249
4.40	24	66	6	36	17.4	D968S-A3N-0440	○	305	218	D968S-A3C-0440	○	349	249
4.50	24	66	6	36	17.3	D968S-A3N-0450	●	305	218	D968S-A3C-0450	●	349	249
4.60	24	66	6	36	17.1	D968S-A3N-0460	○	305	218	D968S-A3C-0460	●	349	249

Several intermediate diameters than above are standard

● Stock ○ =2 weeks

D968S A3N external cooling / A3C internal cooling

Dimensions						Art.nr 	Stock	Net price SEK	Net price DKK	Art.nr 	Stock	Net price SEK	Net price DKK
DC (m7)	LCF	OAL	DMM (h6)	LS	LU								
4.65	24	66	6	36	17.0	D968S-A3N-0465	○	305	218	D968S-A3C-0465	○	349	249
4.70	24	66	6	36	17.0	D968S-A3N-0470	○	305	218	D968S-A3C-0470	○	349	249
4.80	28	66	6	36	20.8	D968S-A3N-0480	○	314	225	D968S-A3C-0480	●	360	257
4.90	28	66	6	36	20.7	D968S-A3N-0490	○	314	225	D968S-A3C-0490	○	360	257
5.00	28	66	6	36	20.5	D968S-A3N-0500	●	314	225	D968S-A3C-0500	●	360	257
5.10	28	66	6	36	20.4	D968S-A3N-0510	○	314	225	D968S-A3C-0510	●	360	257
5.20	28	66	6	36	20.2	D968S-A3N-0520	●	314	225	D968S-A3C-0520	●	360	257
5.30	28	66	6	36	20.1	D968S-A3N-0530	●	314	225	D968S-A3C-0530	●	360	257
5.40	28	66	6	36	19.9	D968S-A3N-0540	○	314	225	D968S-A3C-0540	●	360	257
5.50	28	66	6	36	19.8	D968S-A3N-0550	●	314	225	D968S-A3C-0550	●	360	257
5.55	28	66	6	36	19.7	D968S-A3N-0555	●	314	225	D968S-A3C-0555	●	360	257
5.60	28	66	6	36	19.6	D968S-A3N-0560	○	314	225	D968S-A3C-0560	●	360	257
5.70	28	66	6	36	19.5	D968S-A3N-0570	○	314	225	D968S-A3C-0570	○	360	257
5.80	28	66	6	36	19.3	D968S-A3N-0580	●	314	225	D968S-A3C-0580	●	360	257
5.90	28	66	6	36	19.2	D968S-A3N-0590	○	314	225	D968S-A3C-0590	○	360	257
6.00	28	66	6	36	19.0	D968S-A3N-0600	●	314	225	D968S-A3C-0600	●	360	257
6.05	34	79	8	36	24.9					D968S-A3C-0605	○	360	257
6.10	34	79	8	36	24.9	D968S-A3N-0610	○	406	290	D968S-A3C-0610	○	525	376
6.20	34	79	8	36	24.7	D968S-A3N-0620	○	406	290	D968S-A3C-0620	●	525	376
6.30	34	79	8	36	24.6	D968S-A3N-0630	○	406	290	D968S-A3C-0630	○	525	376
6.40	34	79	8	36	24.4	D968S-A3N-0640	○	406	290	D968S-A3C-0640	●	525	376
6.50	34	79	8	36	24.3	D968S-A3N-0650	●	406	290	D968S-A3C-0650	●	525	376
6.60	34	79	8	36	24.1	D968S-A3N-0660	○	406	290	D968S-A3C-0660	○	525	376
6.70	34	79	8	36	24.0	D968S-A3N-0670	○	406	290	D968S-A3C-0670	○	525	376
6.80	34	79	8	36	23.8	D968S-A3N-0680	●	406	290	D968S-A3C-0680	●	525	376
6.90	34	79	8	36	23.7	D968S-A3N-0690	●	406	290	D968S-A3C-0690	●	525	376
7.00	34	79	8	36	23.5	D968S-A3N-0700	●	406	290	D968S-A3C-0700	●	525	376
7.10	41	79	8	36	30.4	D968S-A3N-0710	○	410	293	D968S-A3C-0710	●	525	376
7.20	41	79	8	36	30.2	D968S-A3N-0720	○	410	293	D968S-A3C-0720	○	525	376
7.30	41	79	8	36	30.1	D968S-A3N-0730	○	410	293	D968S-A3C-0730	○	525	376
7.40	41	79	8	36	29.9	D968S-A3N-0740	●	410	293	D968S-A3C-0740	●	525	376
7.45	41	79	8	36	29.8	D968S-A3N-0745	○	410	293	D968S-A3C-0745	○	525	376
7.50	41	79	8	36	29.8	D968S-A3N-0750	●	410	293	D968S-A3C-0750	●	525	376
7.55	41	79	8	36	29.7	D968S-A3N-0755	○	410	293	D968S-A3C-0755	○	525	376
7.60	41	79	8	36	29.6	D968S-A3N-0760	○	410	293	D968S-A3C-0760	○	525	376
7.70	41	79	8	36	29.5	D968S-A3N-0770	○	410	293	D968S-A3C-0770	○	525	376
7.75	41	79	8	36	29.4					D968S-A3C-0775	○	525	376
7.80	41	79	8	36	29.3	D968S-A3N-0780	○	410	293	D968S-A3C-0780	○	525	376
7.90	41	79	8	36	29.2	D968S-A3N-0790	○	410	293	D968S-A3C-0790	●	525	376
8.00	41	79	8	36	29.0	D968S-A3N-0800	●	410	293	D968S-A3C-0800	●	525	376
8.10	47	89	10	40	34.9	D968S-A3N-0810	○	550	393	D968S-A3C-0810	○	705	505
8.20	47	89	10	40	34.7	D968S-A3N-0820	○	550	393	D968S-A3C-0820	●	705	505
8.25	47	89	10	40	34.6					D968S-A3C-0825	○	705	505
8.30	47	89	10	40	34.6	D968S-A3N-0830	○	550	393	D968S-A3C-0830	●	705	505
8.40	47	89	10	40	34.4	D968S-A3N-0840	○	550	393	D968S-A3C-0840	●	705	505
8.50	47	89	10	40	34.3	D968S-A3N-0850	●	550	393	D968S-A3C-0850	●	705	505
8.60	47	89	10	40	34.1	D968S-A3N-0860	●	550	393	D968S-A3C-0860	●	705	505
8.70	47	89	10	40	34.0	D968S-A3N-0870	○	550	393	D968S-A3C-0870	●	705	505
8.80	47	89	10	40	33.8	D968S-A3N-0880	○	550	393	D968S-A3C-0880	●	705	505
8.90	47	89	10	40	33.7	D968S-A3N-0890	○	550	393	D968S-A3C-0890	○	705	505
9.00	47	89	10	40	33.5	D968S-A3N-0900	●	550	393	D968S-A3C-0900	●	705	505
9.10	47	89	10	40	33.4	D968S-A3N-0910	○	550	393	D968S-A3C-0910	○	705	505
9.20	47	89	10	40	33.2	D968S-A3N-0920	○	550	393	D968S-A3C-0920	○	705	505
9.25	47	89	10	40	33.1	D968S-A3N-0925	○	550	393	D968S-A3C-0925	○	705	505

Several intermediate diameters than above are standard

● Stock ○ =2 weeks

D968S A3N external cooling / A3C internal cooling

Dimensions						Art.nr 	Stock	Net price SEK	Net price DKK	Art.nr 	Stock	Net price SEK	Net price DKK
DC (m7)	LCF	OAL	DMM (h6)	LS	LU								
9.30	47	89	10	40	33.1	D968S-A3N-0930	●	550	393	D968S-A3C-0930	●	705	505
9.35	47	89	10	40	33.0	D968S-A3N-0935	○	550	393	D968S-A3C-0935	○	705	505
9.40	47	89	10	40	32.9	D968S-A3N-0940	○	550	393	D968S-A3C-0940	○	705	505
9.50	47	89	10	40	32.8	D968S-A3N-0950	○	550	393	D968S-A3C-0950	●	705	505
9.55	47	89	10	40	32.7	D968S-A3N-0955	○	550	393	D968S-A3C-0955	○	705	505
9.60	47	89	10	40	32.6	D968S-A3N-0960	○	550	393	D968S-A3C-0960	○	705	505
9.70	47	89	10	40	32.5	D968S-A3N-0970	○	550	393	D968S-A3C-0970	○	705	505
9.80	47	89	10	40	32.3	D968S-A3N-0980	○	550	393	D968S-A3C-0980	○	705	505
9.90	47	89	10	40	32.2	D968S-A3N-0990	○	550	393	D968S-A3C-0990	○	705	505
10.00	47	89	10	40	32.0	D968S-A3N-1000	●	550	393	D968S-A3C-1000	●	705	505
10.10	55	102	12	45	39.9	D968S-A3N-1010	○	800	570	D968S-A3C-1010	○	1020	725
10.20	55	102	12	45	39.7	D968S-A3N-1020	●	800	570	D968S-A3C-1020	●	1020	725
10.25	55	102	12	45	39.6	D968S-A3N-1025	○	800	570	D968S-A3C-1025	○	1020	725
10.30	55	102	12	45	39.6	D968S-A3N-1030	●	800	570	D968S-A3C-1030	●	1020	725
10.35	55	102	12	45	39.5	D968S-A3N-1035	○	800	570				
10.40	55	102	12	45	39.4	D968S-A3N-1040	○	800	570	D968S-A3C-1040	○	1020	725
10.50	55	102	12	45	39.3	D968S-A3N-1050	●	800	570	D968S-A3C-1050	●	1020	725
10.60	55	102	12	45	39.1	D968S-A3N-1060	○	800	570	D968S-A3C-1060	○	1020	725
10.70	55	102	12	45	39.0	D968S-A3N-1070	○	800	570	D968S-A3C-1070	○	1020	725
10.80	55	102	12	45	38.8	D968S-A3N-1080	○	800	570	D968S-A3C-1080	○	1020	725
10.85	55	102	12	45	38.7	D968S-A3N-1085	○	800	570	D968S-A3C-1085	○	1020	725
10.90	55	102	12	45	38.7	D968S-A3N-1090	○	800	570	D968S-A3C-1090	○	1020	725
11.00	55	102	12	45	38.5	D968S-A3N-1100	●	800	570	D968S-A3C-1100	●	1020	725
11.10	55	102	12	45	38.4	D968S-A3N-1110	○	800	570	D968S-A3C-1110	●	1020	725
11.20	55	102	12	45	38.2	D968S-A3N-1120	●	800	570	D968S-A3C-1120	●	1020	725
11.30	55	102	12	45	38.1	D968S-A3N-1130	○	800	570	D968S-A3C-1130	○	1020	725
11.40	55	102	12	45	37.9	D968S-A3N-1140	○	800	570	D968S-A3C-1140	○	1020	725
11.50	55	102	12	45	37.8	D968S-A3N-1150	○	800	570	D968S-A3C-1150	●	1020	725
11.60	55	102	12	45	37.6	D968S-A3N-1160	○	800	570	D968S-A3C-1160	○	1020	725
11.70	55	102	12	45	37.5	D968S-A3N-1170	○	800	570	D968S-A3C-1170	○	1020	725
11.80	55	102	12	45	37.3	D968S-A3N-1180	○	800	570	D968S-A3C-1180	●	1020	725
11.90	55	102	12	45	37.2	D968S-A3N-1190	○	800	570	D968S-A3C-1190	○	1020	725
12.00	55	102	12	45	37.0	D968S-A3N-1200	●	800	570	D968S-A3C-1200	●	1020	725
12.10	60	107	14	45	41.9	D968S-A3N-1210	○	1150	820	D968S-A3C-1210	○	1460	1040
12.15	60	107	14	45	41.8	D968S-A3N-1215	○	1150	820				
12.20	60	107	14	45	41.7	D968S-A3N-1220	○	1150	820	D968S-A3C-1220	○	1460	1040
12.25	60	107	14	45	41.6	D968S-A3N-1225	○	1150	820				
12.30	60	107	14	45	41.6	D968S-A3N-1230	○	1150	820	D968S-A3C-1230	○	1460	1040
12.40	60	107	14	45	41.4	D968S-A3N-1240	○	1150	820				
12.50	60	107	14	45	41.3	D968S-A3N-1250	○	1150	820	D968S-A3C-1250	○	1460	1040
12.60	60	107	14	45	41.1	D968S-A3N-1260	○	1150	820	D968S-A3C-1260	○	1460	1040
12.70	60	107	14	45	41.0	D968S-A3N-1270	○	1150	820	D968S-A3C-1270	○	1460	1040
12.80	60	107	14	45	40.8	D968S-A3N-1280	○	1150	820	D968S-A3C-1280	○	1460	1040
12.90	60	107	14	45	40.7	D968S-A3N-1290	○	1150	820	D968S-A3C-1285	○	1460	1040
13.00	60	107	14	45	40.5	D968S-A3N-1300	○	1150	820	D968S-A3C-1300	○	1460	1040
13.10	60	107	14	45	40.4	D968S-A3N-1310	○	1150	820	D968S-A3C-1310	○	1460	1040
13.20	60	107	14	45	40.2	D968S-A3N-1320	○	1150	820				
13.25	60	107	14	45	40.1	D968S-A3N-1325	○	1150	820				
13.30	60	107	14	45	40.1	D968S-A3N-1330	○	1150	820				
13.40	60	107	14	45	39.9	D968S-A3N-1340	○	1150	820	D968S-A3C-1340	○	1460	1040
13.50	60	107	14	45	39.8	D968S-A3N-1350	○	1150	820	D968S-A3C-1350	○	1460	1040
13.70	60	107	14	45	39.5	D968S-A3N-1370	○	1150	820	D968S-A3C-1370	○	1460	1040
13.80	60	107	14	45	39.3	D968S-A3N-1380	○	1150	820	D968S-A3C-1380	○	1460	1040
14.00	60	107	14	45	39.0	D968S-A3N-1400	○	1150	820	D968S-A3C-1400	○	1460	1040

Several intermediate diameters than above are standard

● Stock ○ =2 weeks

D968S A3N external cooling / A3C internal cooling

Dimensions						Art.nr 	Stock	Net price SEK	Net price DKK	Art.nr 	Stock	Net price SEK	Net price DKK
DC (m7)	LCF	OAL	DMM (h6)	LS	LU								
14.05	60	107	14	45	38.9					D968S-A3C-1405	○	1460	1040
14.10	65	115	16	48	43.9	D968S-A3N-1410	○	1560	1110				
14.20	65	115	16	48	43.7	D968S-A3N-1420	○	1560	1110	D968S-A3C-1420	○	1930	1380
14.30	65	115	16	48	43.6	D968S-A3N-1430	○	1560	1110	D968S-A3C-1430	○	1930	1380
14.40	65	115	16	48	43.4	D968S-A3N-1440	○	1560	1110				
14.50	65	115	16	48	43.3	D968S-A3N-1450	○	1560	1110	D968S-A3C-1450	○	1930	1380
14.60	65	115	16	48	43.1	D968S-A3N-1460	○	1560	1110	D968S-A3C-1460	○	1930	1380
14.70	65	115	16	48	43.0	D968S-A3N-1470	○	1560	1110	D968S-A3C-1470	○	1930	1380
14.80	65	115	16	48	42.8	D968S-A3N-1480	○	1560	1110	D968S-A3C-1480	○	1930	1380
14.90	65	115	16	48	42.7	D968S-A3N-1490	○	1560	1110				
15.00	65	115	16	48	42.5	D968S-A3N-1500	○	1560	1110	D968S-A3C-1500	○	1930	1380
15.10	65	115	16	48	42.4	D968S-A3N-1510	○	1560	1110				
15.20	65	115	16	48	42.2	D968S-A3N-1520	○	1560	1110	D968S-A3C-1520	○	1930	1380
15.25	65	115	16	48	42.1	D968S-A3N-1525	○	1560	1110				
15.30	65	115	16	48	42.1	D968S-A3N-1530	○	1560	1110	D968S-A3C-1530	○	1930	1380
15.40	65	115	16	48	41.9	D968S-A3N-1540	○	1560	1110				
15.50	65	115	16	48	41.8	D968S-A3N-1550	○	1560	1110	D968S-A3C-1550	○	1930	1380
15.70	65	115	16	48	41.5	D968S-A3N-1570	○	1560	1110	D968S-A3C-1570	○	1930	1380
15.80	65	115	16	48	41.3	D968S-A3N-1580	○	1560	1110	D968S-A3C-1580	○	1930	1380
15.90	65	115	16	48	41.2	D968S-A3N-1590	○	1560	1110				
16.00	65	115	16	48	41.0	D968S-A3N-1600	○	1560	1110	D968S-A3C-1600	○	1930	1380
16.10	73	123	18	48	48.9	D968S-A3N-1610	○	2330	1660				
16.20	73	123	18	48	48.7	D968S-A3N-1620	○	2330	1660				
16.30	73	123	18	48	48.6	D968S-A3N-1630	○	2330	1660				
16.40	73	123	18	48	48.4	D968S-A3N-1640	○	2330	1660				
16.50	73	123	18	48	48.3	D968S-A3N-1650	○	2330	1660	D968S-A3C-1650	○	2620	1870
16.60	73	123	18	48	48.1	D968S-A3N-1660	○	2330	1660				
16.70	73	123	18	48	48.0	D968S-A3N-1670	○	2330	1660				
16.80	73	123	18	48	47.8	D968S-A3N-1680	○	2330	1660	D968S-A3C-1680	○	2620	1870
16.90	73	123	18	48	47.7	D968S-A3N-1690	○	2330	1660	D968S-A3C-1690	○		
17.00	73	123	18	48	47.5	D968S-A3N-1700	○	2330	1660	D968S-A3C-1700	○	2620	1870
17.20	73	123	18	48	47.2	D968S-A3N-1720	○	2330	1660				
17.30	73	123	18	48	47.1	D968S-A3N-1730	○	2330	1660				
17.40	73	123	18	48	46.9	D968S-A3N-1740	○	2330	1660				
17.50	73	123	18	48	46.8	D968S-A3N-1750	○	2330	1660	D968S-A3C-1750	○	2620	1870
17.60	73	123	18	48	46.6	D968S-A3N-1760	○	2330	1660				
17.70	73	123	18	48	46.5	D968S-A3N-1770	○	2330	1660	D968S-A3C-1770	○	2620	1870
17.80	73	123	18	48	46.3	D968S-A3N-1780	○	2330	1660	D968S-A3C-1780	○	2620	1870
18.00	73	123	18	48	46.0	D968S-A3N-1800	○	2330	1660	D968S-A3C-1800	○	2620	1870
18.20	79	131	20	50	51.7	D968S-A3N-1820	○	2780	1980				
18.30	79	131	20	50	51.6					D968S-A3C-1830	○		
18.40	79	131	20	50	51.4	D968S-A3N-1840	○	2780	1980				
18.50	79	131	20	50	51.3	D968S-A3N-1850	○	2780	1980	D968S-A3C-1850	○	3320	2370
18.60	79	131	20	50	51.1	D968S-A3N-1860	○	2780	1980				
18.80	79	131	20	50	50.8	D968S-A3N-1880	○	2780	1980	D968S-A3C-1880	○	3320	2370
19.00	79	131	20	50	50.5	D968S-A3N-1900	○	2780	1980	D968S-A3C-1900	○	3320	2370
19.10	79	131	20	50	50.4	D968S-A3N-1910	○	2780	1980				
19.30	79	131	20	50	50.1					D968S-A3C-1930	○	3320	2370
19.50	79	131	20	50	49.8	D968S-A3N-1950	○	2780	1980	D968S-A3C-1950	○	3320	2370
19.60	79	131	20	50	49.6					D968S-A3C-1960	○	3320	2370
19.70	79	131	20	50	49.5					D968S-A3C-1970	○		
19.80	79	131	20	50	49.3	D968S-A3N-1980	○	2780	1980	D968S-A3C-1980	○	3320	2370
19.90	79	131	20	50	49.2	D968S-A3N-1990	○	2780	1980				
20.00	79	131	20	50	49.0	D968S-A3N-2000	○	2780	1980	D968S-A3C-2000	○	3320	2370

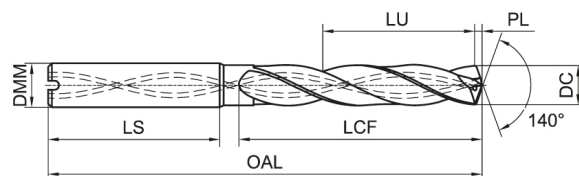
Several intermediate diameters than above are standard

● Stock ○ =2 weeks

D968S-A5N / D968S-A5C

5xD External / Internal Cooling Twist Drills

- Suitable for efficient drilling and machining of stainless steel, carbon steel, alloy steel, heat-resistant alloy and titanium alloy.
- The unique end edge design has stronger chip breaking ability and larger chip space.
- The new substrate coating combination offers super-strong toughness and wear resistance.
- The super-large geometry design features excellent chip removal performance.



Dimensions						Art.nr	Stock	Net price SEK	Net price DKK	Art.nr	Stock	Net price SEK	Net price DKK
DC (m7)	LCF	OAL	DMM (h6)	LS	LU								
1.00	9	45	4	28	7.5	D968S-A5N-0100	○	294	210				
1.10	12	55	4	35	9.6	D968S-A5N-0110	○	294	210				
1.20	12	55	4	35	9.6	D968S-A5N-0120	○	294	210				
1.30	12	55	4	35	9.6	D968S-A5N-0130	○	294	210				
1.40	12	55	4	35	9.6	D968S-A5N-0140	○	294	210				
1.50	12	55	4	35	9.6	D968S-A5N-0150	○	294	210				
1.60	12	55	4	35	9.6	D968S-A5N-0160	○	294	210				
1.65	12	55	4	35	9.5	D968S-A5N-0165	○	294	210				
1.70	12	55	4	35	9.3	D968S-A5N-0170	○	294	210				
1.80	12	55	4	35	9.2	D968S-A5N-0180	○	294	210				
1.90	12	55	4	35	9.2	D968S-A5N-0190	○	294	210				
2.00	18	62	4	38	15.0	D968S-A5N-0200	○	307	220	D968S-A5C-0200	○	490	350
2.10	18	62	4	38	14.9	D968S-A5N-0210	○	307	220				
2.20	18	62	4	38	14.7	D968S-A5N-0220	○	307	220				
2.30	18	62	4	38	14.6	D968S-A5N-0230	○	307	220	D968S-A5C-0230	○	490	350
2.35	18	62	4	38	14.5	D968S-A5N-0235	○	307	220				
2.40	22	62	4	35	18.4	D968S-A5N-0240	○	307	220	D968S-A5C-0240	○	490	350
2.50	22	62	4	35	18.3	D968S-A5N-0250	○	307	220	D968S-A5C-0250	○	490	350
2.60	22	62	4	35	18.1	D968S-A5N-0260	○	307	220	D968S-A5C-0260	○	490	350
2.70	22	62	4	35	18.0	D968S-A5N-0270	○	307	220				
2.80	22	62	4	35	17.8	D968S-A5N-0280	○	307	220	D968S-A5C-0280	○	490	350
2.90	22	62	4	35	17.7	D968S-A5N-0290	○	307	220	D968S-A5C-0290	○	490	350
3.00	28	66	6	36	23.5	D968S-A5N-0300	○	340	243	D968S-A5C-0300	●	432	309
3.05	28	66	6	36	23.4					D968S-A5C-0305	○	432	309
3.10	28	66	6	36	23.4	D968S-A5N-0310	○	340	243	D968S-A5C-0310	○	432	309
3.15	28	66	6	36	23.3	D968S-A5N-0315	○	340	243				
3.20	28	66	6	36	23.2	D968S-A5N-0320	○	340	243	D968S-A5C-0320	○	432	309
3.25	28	66	6	36	23.1	D968S-A5N-0325	○	340	243	D968S-A5C-0325	○	432	309
3.30	28	66	6	36	23.1	D968S-A5N-0330	○	340	243	D968S-A5C-0330	●	432	309
3.40	28	66	6	36	22.9	D968S-A5N-0340	○	340	243	D968S-A5C-0340	○	432	309
3.50	28	66	6	36	22.8	D968S-A5N-0350	○	340	243	D968S-A5C-0350	●	432	309
3.60	28	66	6	36	22.6	D968S-A5N-0360	○	340	243	D968S-A5C-0360	○	432	309
3.65	28	66	6	36	22.5	D968S-A5N-0365	○	340	243	D968S-A5C-0365	○	432	309
3.70	28	66	6	36	22.5	D968S-A5N-0370	○	340	243	D968S-A5C-0370	○	432	309
3.80	36	74	6	36	30.3	D968S-A5N-0380	○	342	244	D968S-A5C-0380	○	434	310
3.90	36	74	6	36	30.2	D968S-A5N-0390	○	342	244	D968S-A5C-0390	○	434	310
4.00	36	74	6	36	30.0	D968S-A5N-0400	○	342	244	D968S-A5C-0400	●	434	310
4.05	36	74	6	36	29.9	D968S-A5N-0405	○	342	244	D968S-A5C-0405	○	434	310
4.10	36	74	6	36	29.9	D968S-A5N-0410	○	342	244	D968S-A5C-0410	○	434	310
4.20	36	74	6	36	29.7	D968S-A5N-0420	○	342	244	D968S-A5C-0420	●	434	310

Several intermediate diameters than above are standard

● Stock ○ =2 weeks

D968S A5N external cooling / A5C internal cooling

Dimensions						Art.nr 	Stock	Net price SEK	Net price DKK	Art.nr 	Stock	Net price SEK	Net price DKK
DC (m7)	LCF	OAL	DMM (h6)	LS	LU								
4.30	36	74	6	36	29.6	D968S-A5N-0430	○	342	244	D968S-A5C-0430	●	434	310
4.40	36	74	6	36	29.4	D968S-A5N-0440	○	342	244	D968S-A5C-0440	○	434	310
4.50	36	74	6	36	29.3	D968S-A5N-0450	○	342	244	D968S-A5C-0450	●	434	310
4.60	36	74	6	36	29.1	D968S-A5N-0460	○	342	244	D968S-A5C-0460	○	434	310
4.65	36	74	6	36	29.0	D968S-A5N-0465	○	342	244	D968S-A5C-0465	○	434	310
4.70	36	74	6	36	29.0	D968S-A5N-0470	○	342	244	D968S-A5C-0470	○	434	310
4.80	44	82	6	36	36.8	D968S-A5N-0480	○	358	256	D968S-A5C-0480	●	454	324
4.90	44	82	6	36	36.7	D968S-A5N-0490	○	358	256	D968S-A5C-0490	○	454	324
5.00	44	82	6	36	36.5	D968S-A5N-0500	○	358	256	D968S-A5C-0500	●	454	324
5.05	44	82	6	36	36.4	D968S-A5N-0505	○	358	256	D968S-A5C-0505	○	454	324
5.10	44	82	6	36	36.4	D968S-A5N-0510	○	358	256	D968S-A5C-0510	●	454	324
5.20	44	82	6	36	36.2	D968S-A5N-0520	○	358	256	D968S-A5C-0520	○	454	324
5.30	44	82	6	36	36.1	D968S-A5N-0530	○	358	256	D968S-A5C-0530	○	454	324
5.40	44	82	6	36	35.9	D968S-A5N-0540	○	358	256	D968S-A5C-0540	○	454	324
5.50	44	82	6	36	35.8	D968S-A5N-0550	○	358	256	D968S-A5C-0550	●	454	324
5.55	44	82	6	36	35.7	D968S-A5N-0555	○	358	256	D968S-A5C-0555	○	454	324
5.60	44	82	6	36	35.6	D968S-A5N-0560	○	358	256	D968S-A5C-0560	○	454	324
5.70	44	82	6	36	35.5	D968S-A5N-0570	○	358	256	D968S-A5C-0570	○	454	324
5.80	44	82	6	36	35.3	D968S-A5N-0580	○	358	256	D968S-A5C-0580	●	454	324
5.90	44	82	6	36	35.2	D968S-A5N-0590	○	358	256	D968S-A5C-0590	○	454	324
6.00	44	82	6	36	35.0	D968S-A5N-0600	○	358	256	D968S-A5C-0600	●	454	324
6.05	44	82	6	36	34.9					D968S-A5C-0605	○	454	324
6.10	53	91	8	36	43.9	D968S-A5N-0610	○	467	334	D968S-A5C-0610	○	585	417
6.20	53	91	8	36	43.7	D968S-A5N-0620	○	467	334	D968S-A5C-0620	○	585	417
6.30	53	91	8	36	43.6	D968S-A5N-0630	○	467	334	D968S-A5C-0630	○	585	417
6.40	53	91	8	36	43.4	D968S-A5N-0640	○	467	334	D968S-A5C-0640	○	585	417
6.50	53	91	8	36	43.3	D968S-A5N-0650	○	467	334	D968S-A5C-0650	●	585	417
6.60	53	91	8	36	43.1	D968S-A5N-0660	○	467	334	D968S-A5C-0660	○	585	417
6.70	53	91	8	36	43.0	D968S-A5N-0670	○	467	334	D968S-A5C-0670	○	585	417
6.80	53	91	8	36	42.8	D968S-A5N-0680	○	467	334	D968S-A5C-0680	●	585	417
6.90	53	91	8	36	42.7	D968S-A5N-0690	○	467	334	D968S-A5C-0690	●	585	417
7.00	53	91	8	36	42.5	D968S-A5N-0700	○	467	334	D968S-A5C-0700	●	585	417
7.05	53	91	8	36	42.4					D968S-A5C-0705	○	585	417
7.10	53	91	8	36	42.4	D968S-A5N-0710	○	467	334	D968S-A5C-0710	○	585	417
7.20	53	91	8	36	42.2	D968S-A5N-0720	○	467	334	D968S-A5C-0720	○	585	417
7.30	53	91	8	36	42.1	D968S-A5N-0730	○	467	334	D968S-A5C-0730	○	585	417
7.40	53	91	8	36	41.9	D968S-A5N-0740	○	467	334	D968S-A5C-0740	●	585	417
7.45	53	91	8	36	41.8	D968S-A5N-0745	○	467	334	D968S-A5C-0745		585	417
7.50	53	91	8	36	41.8	D968S-A5N-0750	○	467	334	D968S-A5C-0750	●	585	417
7.55	53	91	8	36	41.7	D968S-A5N-0755	○	467	334	D968S-A5C-0755	○	585	417
7.60	53	91	8	36	41.6	D968S-A5N-0760	○	467	334	D968S-A5C-0760	○	585	417
7.70	53	91	8	36	41.5	D968S-A5N-0770	○	467	334	D968S-A5C-0770	○	585	417
7.80	53	91	8	36	41.3	D968S-A5N-0780	○	467	334	D968S-A5C-0780	○	585	417
7.90	53	91	8	36	41.2	D968S-A5N-0790	○	467	334	D968S-A5C-0790	○	585	417
8.00	53	91	8	36	41.0	D968S-A5N-0800	○	467	334	D968S-A5C-0800	●	585	417
8.05	53	91	8	36	40.9					D968S-A5C-0805	○	585	417
8.10	61	103	10	40	48.9	D968S-A5N-0810	○	635	453	D968S-A5C-0810	○	775	555
8.15	61	103	10	40	48.8	D968S-A5N-0815	○	635	453				
8.20	61	103	10	40	48.7	D968S-A5N-0820	○	635	453	D968S-A5C-0820	○	775	555
8.30	61	103	10	40	48.6	D968S-A5N-0830	○	635	453	D968S-A5C-0830	○	775	555
8.40	61	103	10	40	48.4	D968S-A5N-0840	○	635	453	D968S-A5C-0840	○	775	555
8.50	61	103	10	40	48.3	D968S-A5N-0850	○	635	453	D968S-A5C-0850	●	775	555
8.60	61	103	10	40	48.1	D968S-A5N-0860	○	635	453	D968S-A5C-0860	●	775	555
8.70	61	103	10	40	48.0	D968S-A5N-0870	○	635	453	D968S-A5C-0870	○	775	555

Several intermediate diameters than above are standard

● Stock ○ =2 weeks

D968S A5N external cooling / A5C internal cooling

Dimensions						Art.nr 	Stock	Net price SEK	Net price DKK	Art.nr 	Stock	Net price SEK	Net price DKK
DC (m7)	LCF	OAL	DMM (h6)	LS	LU								
8.80	61	103	10	40	47.8	D968S-A5N-0880	○	635	453	D968S-A5C-0880	○	775	555
8.90	61	103	10	40	47.7	D968S-A5N-0890	○	635	453	D968S-A5C-0890	○	775	555
9.00	61	103	10	40	47.5	D968S-A5N-0900	○	635	453	D968S-A5C-0900	●	775	555
9.10	61	103	10	40	47.4	D968S-A5N-0910	○	635	453	D968S-A5C-0910	○	775	555
9.20	61	103	10	40	47.2	D968S-A5N-0920	○	635	453	D968S-A5C-0920	○	775	555
9.25	61	103	10	40	47.1	D968S-A5N-0925	○	635	453	D968S-A5C-0925	○	775	555
9.30	61	103	10	40	47.1	D968S-A5N-0930	○	635	453	D968S-A5C-0930	●	775	555
9.35	61	103	10	40	47.0	D968S-A5N-0935	○	635	453	D968S-A5C-0935	○	775	555
9.40	61	103	10	40	46.9	D968S-A5N-0940	○	635	453	D968S-A5C-0940	○	775	555
9.50	61	103	10	40	46.8	D968S-A5N-0950	○	635	453	D968S-A5C-0950	●	775	555
9.55	61	103	10	40	46.7	D968S-A5N-0955	○	635	453	D968S-A5C-0955	○	775	555
9.60	61	103	10	40	46.6	D968S-A5N-0960	○	635	453	D968S-A5C-0960	○	775	555
9.70	61	103	10	40	46.5	D968S-A5N-0970	○	635	453	D968S-A5C-0970	○	775	555
9.80	61	103	10	40	46.3	D968S-A5N-0980	○	635	453	D968S-A5C-0980	○	775	555
9.90	61	103	10	40	46.2	D968S-A5N-0990	○	635	453	D968S-A5C-0990	○	775	555
10.00	61	103	10	40	46.0	D968S-A5N-1000	○	635	453	D968S-A5C-1000	●	775	555
10.05	61	103	10	40	45.9	D968S-A5N-1005	○	635	453	D968S-A5C-1005	○	775	555
10.10	71	118	12	45	55.9	D968S-A5N-1010	○	915	655	D968S-A5C-1010	○	1120	800
10.20	71	118	12	45	55.7	D968S-A5N-1020	○	915	655	D968S-A5C-1020	●	1120	800
10.25	71	118	12	45	55.6	D968S-A5N-1025	○	915	655	D968S-A5C-1025	○	1120	800
10.30	71	118	12	45	55.6	D968S-A5N-1030	○	915	655	D968S-A5C-1030	●	1120	800
10.40	71	118	12	45	55.4	D968S-A5N-1040	○	915	655	D968S-A5C-1040	○	1120	800
10.50	71	118	12	45	55.3	D968S-A5N-1050	○	915	655	D968S-A5C-1050	●	1120	800
10.60	71	118	12	45	55.1	D968S-A5N-1060	○	915	655	D968S-A5C-1060	○	1120	800
10.70	71	118	12	45	55.0	D968S-A5N-1070	○	915	655	D968S-A5C-1070	○	1120	800
10.80	71	118	12	45	54.8	D968S-A5N-1080	○	915	655	D968S-A5C-1080	○	1120	800
10.85	71	118	12	45	54.7	D968S-A5N-1085	○	915	655	D968S-A5C-1085	○	1120	800
10.90	71	118	12	45	54.7	D968S-A5N-1090	○	915	655	D968S-A5C-1090	○	1120	800
11.00	71	118	12	45	54.5	D968S-A5N-1100	○	915	655	D968S-A5C-1100	●	1120	800
11.10	71	118	12	45	54.4	D968S-A5N-1110	○	915	655	D968S-A5C-1110	○	1120	800
11.20	71	118	12	45	54.2	D968S-A5N-1120	○	915	655	D968S-A5C-1120	●	1120	800
11.30	71	118	12	45	54.1	D968S-A5N-1130	○	915	655	D968S-A5C-1130	○	1120	800
11.40	71	118	12	45	53.9	D968S-A5N-1140	○	915	655	D968S-A5C-1140	○	1120	800
11.50	71	118	12	45	53.8	D968S-A5N-1150	○	915	655	D968S-A5C-1150	●	1120	800
11.60	71	118	12	45	53.6	D968S-A5N-1160	○	915	655	D968S-A5C-1160	○	1120	800
11.70	71	118	12	45	53.5	D968S-A5N-1170	○	915	655	D968S-A5C-1170	○	1120	800
11.80	71	118	12	45	53.3	D968S-A5N-1180	○	915	655	D968S-A5C-1180	○	1120	800
11.90	71	118	12	45	53.2	D968S-A5N-1190	○	915	655	D968S-A5C-1190	○	1120	800
12.00	71	118	12	45	53.0	D968S-A5N-1200	○	915	655	D968S-A5C-1200	●	1120	800
12.05	71	118	12	45	52.9					D968S-A5C-1205	○	1120	800
12.10	77	124	14	45	58.9	D968S-A5N-1210	○	1320	940	D968S-A5C-1210	○	1600	1140
12.20	77	124	14	45	58.7	D968S-A5N-1220	○	1320	940	D968S-A5C-1220	○	1600	1140
12.30	77	124	14	45	58.6	D968S-A5N-1230	○	1320	940	D968S-A5C-1230	○	1600	1140
12.40	77	124	14	45	58.4	D968S-A5N-1240	○	1320	940	D968S-A5C-1240	○	1600	1140
12.50	77	124	14	45	58.3	D968S-A5N-1250	○	1320	940	D968S-A5C-1250	●	1600	1140
12.60	77	124	14	45	58.1	D968S-A5N-1260	○	1320	940	D968S-A5C-1260	○	1600	1140
12.70	77	124	14	45	58.0	D968S-A5N-1270	○	1320	940	D968S-A5C-1270	○	1600	1140
12.80	77	124	14	45	57.8	D968S-A5N-1280	○	1320	940	D968S-A5C-1280	○	1600	1140
12.85	77	124	14	45	57.7					D968S-A5C-1285	○	1600	1140
12.90	77	124	14	45	57.7	D968S-A5N-1290	○	1320	940				
13.00	77	124	14	45	57.5	D968S-A5N-1300	○	1320	940	D968S-A5C-1300	●	1600	1140
13.10	77	124	14	45	57.4					D968S-A5C-1310	○	1600	1140
13.20	77	124	14	45	57.2	D968S-A5N-1320	○	1320	940	D968S-A5C-1320	○	1600	1140
13.25	77	124	14	45	57.1					D968S-A5C-1325	○	1600	1140

Several intermediate diameters than above are standard

● Stock ○ =2 weeks

D968S A5N external cooling / A5C internal cooling

Dimensions						Art.nr 	Stock	Net price SEK	Net price DKK	Art.nr 	Stock	Net price SEK	Net price DKK
DC (m7)	LCF	OAL	DMM (h6)	LS	LU								
13.30	77	124	14	45	57.1					D968S-A5C-1330	○	1600	1140
13.50	77	124	14	45	56.8	D968S-A5N-1350	○	1320	940	D968S-A5C-1350	○	1600	1140
13.55	77	124	14	45	56.7	D968S-A5N-1355	○	1320	940				
13.60	77	124	14	45	56.6					D968S-A5C-1360	○	1600	1140
13.70	77	124	14	45	56.5	D968S-A5N-1370	○	1320	940	D968S-A5C-1370	○	1600	1140
13.75	77	124	14	45	56.4	D968S-A5N-1375	○	1320	940				
13.80	77	124	14	45	56.3	D968S-A5N-1380	○	1320	940	D968S-A5C-1380	○	1600	1140
13.90	77	124	14	45	56.2	D968S-A5N-1390	○	1320	940	D968S-A5C-1390	○	1600	1140
14.00	77	124	14	45	56.0	D968S-A5N-1400	○	1320	940	D968S-A5C-1400	●	1600	1140
14.10	83	133	16	48	61.9	D968S-A5N-1410	○	1790	1280	D968S-A5C-1410	○	2110	1510
14.20	83	133	16	48	61.7	D968S-A5N-1420	○	1790	1280	D968S-A5C-1420	○	2110	1510
14.30	83	133	16	48	61.6	D968S-A5N-1430	○	1790	1280	D968S-A5C-1430	○	2110	1510
14.40	83	133	16	48	61.4					D968S-A5C-1440	○	2110	1510
14.50	83	133	16	48	61.3	D968S-A5N-1450	○	1790	1280	D968S-A5C-1450	○	2110	1510
14.60	83	133	16	48	61.1	D968S-A5N-1460	○	1790	1280	D968S-A5C-1460	○	2110	1510
14.70	83	133	16	48	61.0					D968S-A5C-1470	○	2110	1510
14.80	83	133	16	48	60.8	D968S-A5N-1480	○	1790	1280	D968S-A5C-1480	○	2110	1510
15.00	83	133	16	48	60.5	D968S-A5N-1500	○	1790	1280	D968S-A5C-1500	○	2110	1510
15.10	83	133	16	48	60.4	D968S-A5N-1510	○	1790	1280	D968S-A5C-1510	○	2110	1510
15.20	83	133	16	48	60.2					D968S-A5C-1520	○	2110	1510
15.25	83	133	16	48	60.1	D968S-A5N-1525	○	1790	1280				
15.30	83	133	16	48	60.1					D968S-A5C-1530	○	2110	1510
15.50	83	133	16	48	59.8	D968S-A5N-1550	○	1790	1280	D968S-A5C-1550	○	2110	1510
15.70	83	133	16	48	59.5	D968S-A5N-1570	○	1790	1280	D968S-A5C-1570	○	2110	1510
15.80	83	133	16	48	59.3	D968S-A5N-1580	○	1790	1280	D968S-A5C-1580	○	2110	1510
16.00	83	133	16	48	59.0	D968S-A5N-1600	○	1790	1280	D968S-A5C-1600	○	2110	1510
16.10	93	143	18	48	68.3					D968S-A5C-1610	○	3000	2140
16.30	93	143	18	48	68.3					D968S-A5C-1630	○		
16.50	93	143	18	48	68.3	D968S-A5N-1650	○	2710	1940	D968S-A5C-1650	○	3000	2140
16.60	93	143	18	48	68.1	D968S-A5N-1660	○	2710	1940				
16.70	93	143	18	48	68.0					D968S-A5C-1670	○	3000	2140
16.80	93	143	18	48	67.8	D968S-A5N-1680	○	2710	1940	D968S-A5C-1680	○	3000	2140
16.90	93	143	18	48	67.7					D968S-A5C-1690	○	3000	2140
16.95	93	143	18	48	67.6	D968S-A5N-1695	○	2710	1940				
17.00	93	143	18	48	67.5	D968S-A5N-1700	○	2710	1940	D968S-A5C-1700	○	3000	2140
17.20	93	143	18	48	67.2					D968S-A5C-1720	○	3000	2140
17.30	93	143	18	48	67.1	D968S-A5N-1730	○	2710	1940	D968S-A5C-1730	○		
17.50	93	143	18	48	66.8	D968S-A5N-1750	○	2710	1940	D968S-A5C-1750	○	3000	2140
17.70	93	143	18	48	66.5					D968S-A5C-1770	○	3000	2140
17.80	93	143	18	48	66.3	D968S-A5N-1780	○	2710	1940	D968S-A5C-1780	○	3000	2140
17.95	93	143	18	48	66.1	D968S-A5N-1795	○	2710	1940				
18.00	93	143	18	48	66.0	D968S-A5N-1800	○	2710	1940	D968S-A5C-1800	○	3000	2140
18.50	101	153	20	50	73.3	D968S-A5N-1850	○	3050	2180	D968S-A5C-1850	○	3810	2720
18.60	101	153	20	50	73.1	D968S-A5N-1860	○	3050	2180	D968S-A5C-1860	○	3810	2720
19.00	101	153	20	50	72.5	D968S-A5N-1900	○	3050	2180	D968S-A5C-1900	○	3810	2720
19.50	101	153	20	50	71.8	D968S-A5N-1950	○	3050	2180	D968S-A5C-1950	○	3810	2720
20.00	101	153	20	50	71.0	D968S-A5N-2000	○	3050	2180	D968S-A5C-2000	○	3810	2720

Several intermediate diameters than above are standard

● Stock ○ =2 weeks

Recommended Cutting Data

D968S Stainless Steel Machining Twist Drill

Workpiece Material		Cutting Speed Vc (m/min)		Feed Fn (mm/rev)			
				Φ1	Φ1.5	Φ2	Φ2.5
P	Low-carbon Steel, Long Chips (<125HB)	100-80-50	140-100-60	0.06-0.10-0.13	0.08-0.12-14	0.09-0.13-0.16	0.09-0.13-0.16
	Low-carbon Steel, Short Chips, Free Cutting Steel (<125HB)	100-75-50	140-100-60	0.06-0.10-0.13	0.08-0.12-14	0.09-0.13-0.16	0.09-0.13-0.16
	High-carbon Steel and Medium-carbon Steel (<25HRC)	90-70-45	120-80-60	0.06-0.10-0.13	0.08-0.12-14	0.09-0.13-0.16	0.09-0.13-0.16
	Alloy Steel, Tool Steel (<35HRC)	90-70-45	110-80-50	0.06-0.10-0.13	0.08-0.12-14	0.09-0.13-0.16	0.09-0.13-0.16
M	Austenitic Stainless Steels (130-200HB)	40-30-20	80-60-40	0.02-0.04-0.06	0.03-0.05-0.07	0.03-0.06-0.08	0.03-0.06-0.08
	High Strength Austenitic and Cast Stainless Steel (<25HRC)	40-30-20	80-60-40	0.02-0.04-0.06	0.03-0.05-0.07	0.03-0.06-0.08	0.03-0.06-0.08
	Duplex Stainless Steel (<30HRC)	35-25-20	60-45-30	0.02-0.04-0.06	0.03-0.05-0.07	0.03-0.06-0.08	0.03-0.06-0.08
S	Iron-based High-temperature Alloy (160-260HB)	25-15-10	35-25-15	0.02-0.03-0.05	0.03-0.04-0.06	0.03-0.04-0.06	0.03-0.04-0.06
	Cobalt-based High-temperature Alloy (250-450HB)	25-15-10	35-25-15	0.02-0.03-0.05	0.03-0.04-0.06	0.03-0.04-0.06	0.03-0.04-0.06
	Nickel-based High-temperature Alloy (160-450HB)	25-15-10	35-25-15	0.02-0.03-0.05	0.03-0.04-0.06	0.03-0.04-0.06	0.03-0.04-0.06
	Titanium-based Titanium Alloy (300-400HB)	40-30-15	50-40-25	0.02-0.03-0.05	0.03-0.04-0.06	0.03-0.04-0.06	0.03-0.05-0.08

Notes: The 5D external cooling drill bit is not suitable for machining Workpiece Materials of type S.

[Notes]

1. Please use a machine with relatively high rigidity. It is recommended to adopt hydraulic tool holders, thermal expansion tool holders and powerful handles with spring collets.
2. When installing the tool, it is necessary to ensure that the radial bounce of the drill bit tip is less than 0.02mm.
3. This standard cutting condition table is suitable for water-soluble cutting fluids
4. For the tool edge diameter specifications not listed in the table, please refer to the closest edge diameter specifications in the table to select the cutting data. Meanwhile, during the machining process, please adjust the cutting data appropriately according to the actual machining situation.

Recommended Cutting Data

D968S Stainless Steel Machining Twist Drill

Workpiece Material		Cutting Speed Vc (m/min)		Feed Fn (mm/rev)				
				Φ3	Φ4	Φ6	Φ8	Φ10
P	Low-carbon Steel, Long Chips (<125HB)	100-80-50	140-100-60	0.09-0.13-0.16	0.11-0.15-0.19	0.14-0.19-0.23	0.19-0.25-0.31	0.23-0.30-0.38
	Low-carbon Steel, Short Chips, Free Cutting Steel (<125HB)	100-75-50	140-100-60	0.09-0.13-0.16	0.11-0.15-0.19	0.14-0.19-0.23	0.19-0.25-0.31	0.23-0.30-0.38
	High-carbon Steel and medium-carbon Steel (<25HRC)	90-70-45	120-80-60	0.09-0.13-0.16	0.11-0.15-0.19	0.14-0.19-0.23	0.19-0.25-0.31	0.23-0.30-0.38
	Alloy Steel, Tool Steel (<35HRC)	90-70-45	110-80-50	0.09-0.13-0.16	0.11-0.15-0.19	0.14-0.19-0.23	0.19-0.25-0.31	0.23-0.30-0.38
M	Austenitic Stainless Steels (130-200HB)	40-30-20	80-60-40	0.05-0.08-0.10	0.06-0.10-0.12	0.07-0.12-0.14	0.08-0.13-0.18	0.09-0.15-0.20
	High Strength Austenitic and Cast Stainless Steel (<25HRC)	40-30-20	80-60-40	0.03-0.06-0.08	0.04-0.08-0.10	0.05-0.08-0.10	0.06-0.10-0.12	0.07-0.11-0.14
	Duplex Stainless Steel (<30HRC)	35-25-20	60-45-30	0.03-0.06-0.08	0.04-0.08-0.10	0.05-0.08-0.10	0.06-0.10-0.12	0.07-0.11-0.14
S	Iron-based high-Temperature Alloy (160-260HB)	25-15-10	35-25-15	0.03-0.04-0.06	0.04-0.06-0.08	0.05-0.08-0.10	0.06-0.09-0.11	0.07-0.10-0.12
	Cobalt-Based high-Temperature Alloy (250-450HB)	25-15-10	35-25-15	0.03-0.04-0.06	0.04-0.06-0.08	0.05-0.08-0.10	0.06-0.09-0.11	0.07-0.10-0.12
	Nickel-Based High-temperature Alloy (160-450HB)	25-15-10	35-25-15	0.03-0.04-0.06	0.04-0.06-0.08	0.05-0.08-0.10	0.06-0.09-0.11	0.07-0.10-0.12
	Titanium-based Titanium Alloy (300-400HB)	40-30-15	50-40-25	0.03-0.05-0.08	0.04-0.07-0.10	0.05-0.09-0.10	0.06-0.10-0.12	0.07-0.12-0.14

Notes: The 5D external cooling drill bit is not suitable for machining Workpiece Materials of type S.

[Notes]

1. Please use a machine with relatively high rigidity. It is recommended to adopt hydraulic tool holders, thermal expansion tool holders and powerful handles with spring collets.
2. When installing the tool, it is necessary to ensure that the radial bounce of the drill bit tip is less than 0.02mm.
3. This standard cutting condition table is suitable for water-soluble cutting fluids
4. For the tool edge diameter specifications not listed in the table, please refer to the closest edge diameter specifications in the table to select the cutting data. Meanwhile, during the machining process, please adjust the cutting data appropriately according to the actual machining situation.

Recommended Cutting Data

D968S Stainless Steel Machining Twist Drill

Workpiece Material		Cutting Speed Vc (m/min)		Feed Fn (mm/rev)				
				Φ12	Φ14	Φ16	Φ18	Φ20
P	Low-carbon Steel, Long Chips (<125HB)	100-80-50	140-100-60	0.24-0.33-0.41	0.28-0.38-0.45	0.30-0.42-0.50	0.33-0.42-0.50	0.34-0.43-0.51
	Low-carbon Steel, Short Chips, Free Cutting Steel (<125HB)	100-75-50	140-100-60	0.24-0.33-0.41	0.28-0.38-0.45	0.30-0.42-0.50	0.33-0.42-0.50	0.34-0.43-0.51
	High-carbon Steel and medium-carbon Steel (<25HRC)	90-70-45	120-80-60	0.24-0.33-0.41	0.28-0.38-0.45	0.30-0.42-0.50	0.33-0.42-0.50	0.34-0.43-0.51
	Alloy Steel, Tool Steel (<35HRC)	90-70-45	110-80-50	0.24-0.33-0.41	0.28-0.38-0.45	0.30-0.42-0.50	0.33-0.42-0.50	0.34-0.43-0.51
M	Austenitic Stainless Steels (130-200HB)	40-30-20	80-60-40	0.10-0.17-0.22	0.11-0.18-0.24	0.12-0.20-0.24	0.13-0.22-0.26	0.14-0.24-0.28
	High Strength Austenitic and Cast Stainless Steel (<25HRC)	40-30-20	80-60-40	0.08-0.13-0.16	0.09-0.13-0.18	0.10-0.14-0.18	0.10-0.14-0.20	0.12-0.16-0.22
	Duplex Stainless Steel (<30HRC)	35-25-20	60-45-30	0.08-0.13-0.16	0.09-0.13-0.18	0.10-0.14-0.18	0.10-0.14-0.20	0.12-0.16-0.22
S	Iron-based high-Temperature Alloy (160-260HB)	25-15-10	35-25-15	0.08-0.12-0.14	0.09-0.13-0.16	0.10-0.14-0.16	0.10-0.15-0.18	0.12-0.16-0.20
	Cobalt-Based high-Temperature Alloy (250-450HB)	25-15-10	35-25-15	0.08-0.12-0.14	0.09-0.13-0.16	0.10-0.14-0.16	0.10-0.15-0.18	0.12-0.16-0.20
	Nickel-Based High-temperature Alloy (160-450HB)	25-15-10	35-25-15	0.08-0.12-0.14	0.09-0.13-0.16	0.10-0.14-0.16	0.10-0.15-0.18	0.12-0.16-0.20
	Titanium-based Titanium Alloy (300-400HB)	40-30-15	50-40-25	0.08-0.14-0.16	0.09-0.15-0.18	0.10-0.17-0.18	0.10-0.16-0.20	0.12-0.18-0.22

Notes: The 5D external cooling drill bit is not suitable for machining Workpiece Materials of type S.

[Notes]

1. Please use a machine with relatively high rigidity. It is recommended to adopt hydraulic tool holders, thermal expansion tool holders and powerful handles with spring collets.
2. When installing the tool, it is necessary to ensure that the radial bounce of the drill bit tip is less than 0.02mm.
3. This standard cutting condition table is suitable for water-soluble cutting fluids
4. For the tool edge diameter specifications not listed in the table, please refer to the closest edge diameter specifications in the table to select the cutting data. Meanwhile, during the machining process, please adjust the cutting data appropriately according to the actual machining situation.