

Sales Promotion by ZCC-CT



Presenting an economical range of solid carbide drills from 3mm diameter to 12mm diameter in both 3 and 5 x diameter length ratios. The 1534 SU and 1536 SU range from ZCC CT offers through coolant facility throughout the range and has the latest KDG303 TIAIN PVD coating technology for greater performance.

The patented "waveform" cutting edge technology promotes improved chip evacuation for smoother, reduced cutting forces. Drills suitable for steel and cast iron machining.

Range size	3 x D	5 x D
3 - 6mm diameter Ø	£ 18.17	£ 21.35
6.1 - 8mm diameter Ø	£ 24.00	£ 26.31
8.1 - 10mm diameter Ø	£ 29.02	£ 32.30
10.1 - 12mm diameter Ø	£ 40.78	£ 45.01

**Introductory promotional net prices, available while stocks last.
Supplied through your local ZCC-CT Distributor.**

*If you prefer external coolant drills.
Take a further 30% discount off these promotional prices.*



Through Coolant Drilling



ZCC Cutting Tools Europe GmbH

your Partner | your Value



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Solid carbide drills Code Key

Description	
Code	Description
1	DIN338
2	DIN1897
3	QJ/ZZQ(TO)01.001.002
4	DIN6537K
5	DIN6537K
6	DIN6537K
7	ZZC-C in QJ/ZZQ(TO)01.001.002
8	ZZC-D in QJ/ZZQ(TO)01.001.002
9	ZZC-E in QJ/ZZQ(TO)01.001.002

Type of tools	
Code	Description
1	Drills

Application	
Code	Description
SU	Twist drill for general universal machining
SL	Twist drill for deep drilling
SP	Pilot drills
ST	Twist drill for soft steel, stainless steel
SH	Twist drill for high hardness steel
SC	Twist drill for aluminum, cast iron
PA	Three-lips drill for aluminum, cast iron
PC	Straight flute drill for aluminum, cast iron

Mode of cooling	
Code	Description
C	Internal Coolant

Specification	
Code	Description
0850	Nominal cutting diameter of stepless drill
M6	Step drill for standard pitch
M8×1	Step drill for fine pitch

1 5 3 6 SU 05 C -0850

Type of shank	
Code	Description
1	Straight shank
2	Square head Straight shank DIN 10
3	Double flattened Straight shank DIN1809
5	Straight shank DIN6535HA
6	Weldon shank DIN6535HB
7	Whistle notch shank DIN6535HE
9	Tapered shank

Type of drill	
Code	Description
0	Twist drill
3	Multiple functions twist drill
4	Centering drill
5	Step drill
6	Three-lips drill
7	Straight flute drill

Identification of drilling depth and point angle			
If the tool is not a centering drill, it indicate the drilling depth		If the tool is a centering drill, it indicate the point angle	
Code	Description	Code	Description
03	(2~3) d	90	Centering drill with 90° point angle
05	(4~5) d		
08	(7~8) d	120	Centering drill with 120° point angle
15	(15) d		

SU series twist drills (External coolant)

3D 5D

Workpiece material	Mild steel HB≤180	Carbon steel, alloy steel ~30HRC	Pre-hardened steel ~40HRC	Stainless steel	Cast iron	Nodular cast iron GGG	Aluminum alloy	Heat resistant alloy
Vc	60~120m/min	60~120m/min	40~70m/min	25~40m/min	60~120m/min	50~100m/min	60~140m/min	15~25m/min
Ø (mm)	n (min ⁻¹)	f (mm/r)	n (min ⁻¹)	f (mm/r)	n (min ⁻¹)	f (mm/r)	n (min ⁻¹)	f (mm/r)
3	9500	0.09~0.12	9500	0.09~0.12	6300	0.09~0.12	3700	0.03~0.07
4	7000	0.10~0.15	7000	0.10~0.15	4700	0.10~0.15	2700	0.04~0.08
5	5700	0.12~0.18	5700	0.12~0.18	3800	0.12~0.18	2200	0.05~0.10
6	4700	0.14~0.20	4700	0.14~0.20	3100	0.14~0.20	1850	0.06~0.12
8	3600	0.16~0.24	3600	0.16~0.24	2400	0.16~0.24	1400	0.08~0.16
10	2800	0.18~0.27	2800	0.18~0.27	1900	0.18~0.27	1100	0.10~0.18
12	2400	0.20~0.30	2400	0.20~0.30	1600	0.20~0.30	930	0.12~0.20

- When the tool is used for the first time, please make a test cutting with 90% of cutting speed or 85% feed rate mentioned above. If the cutting conditions remain stable, gradually increase the cutting speed and feed rate.
- The cutting conditions above are for drilling with emulsion.
- Use a collet without any defect or dust. The radial run-out of drill must be under 0.02mm.
- These conditions above are for cutting depth under 5D.

Sales center in Europe

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Distributor: