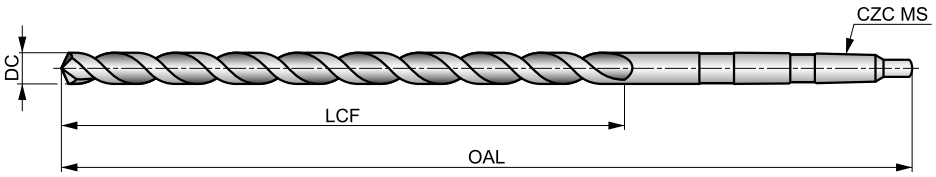
# A952

DORMER



## HSS PFX Extra Long Series Taper Shank Drill (DIN 1870 Series 2), Bright Finish

A versatile drill with a special parabolic flute design for drilling deep holes in a single pass. The drill has a self-centering 130° point (centering with a short PFX Drill is recommended) so the force needed to drill the hole is reduced. Suitable for drilling many materials.




| | | |
|---|---|---|
| HSS | DIN 1870(2) | 20×D |
| 130° | Bright ST | |
| λ>35° | R | DC h8 |

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page 175.

| P1.1 | P1.2 | P1.3 | P2.1 | P2.2 | P2.3 | P3.1 | P3.2 | P3.3 | P4.1 | P4.2 | P4.3 | M1.1 | M1.2 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| ■25 G | ■28 G | ■29 G | ■22 G | ■19 E | ◪17 C | ◪12 D | ◪9 D | ◪8 C | ◪7 D | ◪6 C | ◪5 B | ◪16 C | ◪14 C |
| **M2.1** | **M2.2** | **M3.1** | **M3.2** | **M3.3** | **M4.1** | **K1.1** | **K1.2** | **K1.3** | **K2.1** | **K2.2** | **K2.3** | **K3.1** | **K3.2** |
| ◪15 C | ◪12 C | ◪7 E | ◪6 E | ◪5 E | ◪12 A | ◪22 G | ◪16 D | ◪12 D | ◪16 C | ◪13 C | ◪10 C | ◪14 C | ◪11 C |
| **K3.3** | **K4.1** | **K4.2** | **K4.3** | **K4.4** | **K4.5** | **K5.1** | **K5.2** | **K5.3** | **N1.1** | **N1.2** | **N1.3** | **N2.1** | **N2.2** |
| ◪9 C | ◪13 C | ◪10 C | ◪7 C | ◪6 C | ◪5 C | ◪15 C | ◪11 C | ◪9 C | ◪30 H | ◪23 H | ◪15 G | ◪37 F | ◪33 F |
| **N2.3** | **N3.1** | **N3.2** | **N3.3** | **N4.1** | **N4.2** | **N4.3** | **S1.1** | **S1.2** | **S1.3** | **S2.1** | **S2.2** | **S3.1** | **S3.2** |
| ◪24 F | ◪56 F | ◪33 G | ◪17 D | ◪30 J | ◪30 H | ◪10 F | ◪18 D | ◪10 B | ◪6 A | ◪7 C | ◪4 A | ◪5 C | ◪3 A |
| **S4.1** | **S4.2** | | | | | | | | | | | | |
| ◪4 C | ◪2 A | | | | | | | | | | | | |

DC >= 14.5mm less than 20xD; DC > 23mm Bright.

| Product | DC (mm) | DC (inch) | LCF (mm) | OAL (mm) | CZC MS |
|---|---|---|---|---|---|
| **A9528.0** | 8.00 | 0.3150 | 210.0 | 330.0 | MK 1 |
| **A9528.5** | 8.50 | 0.3346 | 210.0 | 330.0 | MK 1 |
| **A9529.0** | 9.00 | 0.3543 | 220.0 | 345.0 | MK 1 |
| **A95210.0** | 10.00 | 0.3937 | 235.0 | 360.0 | MK 1 |
| **A95210.5** | 10.50 | 0.4134 | 235.0 | 360.0 | MK 1 |
| **A95211.0** | 11.00 | 0.4331 | 250.0 | 375.0 | MK 1 |
| **A95211.5** | 11.50 | 0.4528 | 250.0 | 375.0 | MK 1 |
| **A95212.0** | 12.00 | 0.4724 | 260.0 | 395.0 | MK 1 |
| **A95212.5** | 12.50 | 0.4921 | 260.0 | 395.0 | MK 1 |
| **A95213.0** | 13.00 | 0.5118 | 260.0 | 395.0 | MK 1 |
| **A95213.5** | 13.50 | 0.5315 | 275.0 | 410.0 | MK 1 |
| **A95214.0** | 14.00 | 0.5512 | 275.0 | 410.0 | MK 1 |
| **A95214.5** | 14.50 | 0.5709 | 275.0 | 425.0 | MK 2 |
| **A95215.0** | 15.00 | 0.5906 | 275.0 | 425.0 | MK 2 |
| **A95215.5** | 15.50 | 0.6102 | 295.0 | 445.0 | MK 2 |
| **A95216.0** | 16.00 | 0.6299 | 295.0 | 445.0 | MK 2 |
| **A95216.5** | 16.50 | 0.6496 | 295.0 | 445.0 | MK 2 |
| **A95217.0** | 17.00 | 0.6693 | 295.0 | 445.0 | MK 2 |
| **A95217.5** | 17.50 | 0.6890 | 310.0 | 465.0 | MK 2 |
| **A95218.0** | 18.00 | 0.7087 | 310.0 | 465.0 | MK 2 |
| **A95218.5** | 18.50 | 0.7283 | 310.0 | 465.0 | MK 2 |

| Product | DC (mm) | DC (inch) | LCF (mm) | OAL (mm) | CZC MS |
|---|---|---|---|---|---|
| **A95219.0** | 19.00 | 0.7480 | 310.0 | 465.0 | MK 2 |
| **A95219.5** | 19.50 | 0.7677 | 325.0 | 490.0 | MK 2 |
| **A95220.0** | 20.00 | 0.7874 | 325.0 | 490.0 | MK 2 |
| **A95221.0** | 21.00 | 0.8268 | 325.0 | 490.0 | MK 2 |
| **A95222.0** | 22.00 | 0.8661 | 345.0 | 515.0 | MK 2 |
| **A95223.0** | 23.00 | 0.9055 | 345.0 | 515.0 | MK 2 |
| **A95224.0** | 24.00 | 0.9449 | 365.0 | 555.0 | MK 3 |
| **A95225.0** | 25.00 | 0.9843 | 365.0 | 555.0 | MK 3 |
| **A95226.0** | 26.00 | 1.0236 | 365.0 | 555.0 | MK 3 |
| **A95227.0** | 27.00 | 1.0630 | 385.0 | 580.0 | MK 3 |
| **A95228.0** | 28.00 | 1.1024 | 385.0 | 580.0 | MK 3 |
| **A95229.0** | 29.00 | 1.1417 | 385.0 | 580.0 | MK 3 |
| **A95230.0** | 30.00 | 1.1811 | 385.0 | 580.0 | MK 3 |
| **A95231.0** | 31.00 | 1.2205 | 410.0 | 610.0 | MK 3 |
| **A95232.0** | 32.00 | 1.2598 | 410.0 | 635.0 | MK 4 |
| **A95233.0** | 33.00 | 1.2992 | 410.0 | 635.0 | MK 4 |
| **A95234.0** | 34.00 | 1.3386 | 430.0 | 665.0 | MK 4 |
| **A95235.0** | 35.00 | 1.3780 | 430.0 | 665.0 | MK 4 |
| **A95238.0** | 38.00 | 1.4961 | 460.0 | 695.0 | MK 4 |
| **A95240.0** | 40.00 | 1.5748 | 460.0 | 695.0 | MK 4 |