A976

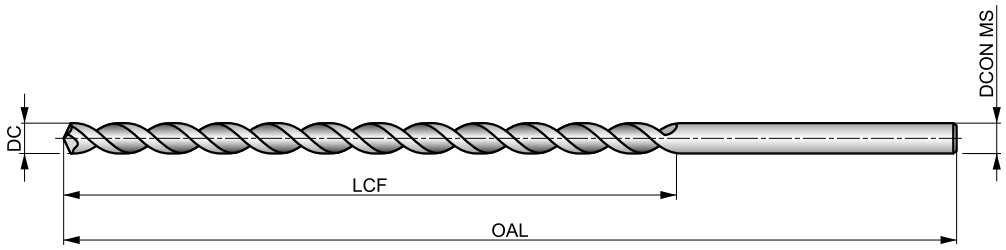
DORMER



PFX HSS-E (5% Cobalt) Extra Long Series Drill (DIN 1869 Series 1), Bright Finish

Recommended for drilling very deep holes or for applications where extra reach is needed. Specially designed parabolic flutes eliminate the need to drill deep holes in short steps (pecking). A 130° point. Centering with a short 3xD PFX drill is recommended (to keep same DC tolerance). Suitable for drilling many materials.

PFX



HSS-E	DIN 1869-1	15×D
130°	Bright	
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
◪29 C	◪33 C	◪34 C	◪25 C	■22 C	■19 A	■18 C	■14 C	■12 A	■11 C	■9 A	■7 A	◪16 B	◪14 B
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**
◪15 B	◪12 B	◪8 C	◪7 C	◪6 C	◪8 A	◪20 C	◪16 C	◪13 A	◪17 C	◪13 C	◪11 A	◪16 C	◪12 C
K4.3	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N3.1**	**S1.1**	**S1.2**	**S1.3**				
◪9 A	◪8 A	◪6 A	◪18 C	◪14 C	◪11 A	◪30 D	◪15 C	◪11 A	◪5 A				

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9761.5	–	1.50	0.0591	75.0	115.0	1.50
A9762.0X125	–	2.00	0.0787	85.0	125.0	2.00
A9762.1X125	–	2.10	0.0827	85.0	125.0	2.10
A9762.2X135	–	2.20	0.0866	90.0	135.0	2.20
A9762.3X135	–	2.30	0.0906	90.0	135.0	2.30
A9762.4X140	–	2.40	0.0945	95.0	140.0	2.40
A9762.5X140	–	2.50	0.0984	95.0	140.0	2.50
A9762.6X140	–	2.60	0.1024	95.0	140.0	2.60
A9762.7X150	–	2.70	0.1063	100.0	150.0	2.70
A9762.8X150	–	2.80	0.1102	100.0	150.0	2.80
A9762.9X150	–	2.90	0.1142	100.0	150.0	2.90
A9763.0X150	–	3.00	0.1181	100.0	150.0	3.00
A9763.1X155	–	3.10	0.1220	105.0	155.0	3.10
A9761/8	1/8	3.18	0.1252	105.0	155.0	3.18
A9763.2X155	–	3.20	0.1260	105.0	155.0	3.20
A9763.3X155	–	3.30	0.1299	105.0	155.0	3.30
A9763.4X165	–	3.40	0.1339	115.0	165.0	3.40
A9763.5X165	–	3.50	0.1378	115.0	165.0	3.50
A9763.6X165	–	3.60	0.1417	115.0	165.0	3.60
A9763.7X165	–	3.70	0.1457	115.0	165.0	3.70
A9763.8X175	–	3.80	0.1496	120.0	175.0	3.80
A9763.9X175	–	3.90	0.1535	120.0	175.0	3.90
A9765/32	5/32	3.97	0.1563	120.0	175.0	3.97
A9764.0X175	–	4.00	0.1575	120.0	175.0	4.00
A9764.1X175	–	4.10	0.1614	120.0	175.0	4.10
A9764.2X175	–	4.20	0.1654	120.0	175.0	4.20
A9764.3X185	–	4.30	0.1693	125.0	185.0	4.30
A9764.4X185	–	4.40	0.1732	125.0	185.0	4.40

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9764.5X185	–	4.50	0.1772	125.0	185.0	4.50
A9764.6X185	–	4.60	0.1811	125.0	185.0	4.60
A9764.7X185	–	4.70	0.1850	125.0	185.0	4.70
A9763/16	3/16	4.76	0.1875	135.0	195.0	4.76
A9764.8X195	–	4.80	0.1890	135.0	195.0	4.80
A9764.9X195	–	4.90	0.1929	135.0	195.0	4.90
A9765.0X195	–	5.00	0.1969	135.0	195.0	5.00
A9765.1X195	–	5.10	0.2008	135.0	195.0	5.10
A9765.2X195	–	5.20	0.2047	135.0	195.0	5.20
A9765.3X195	–	5.30	0.2087	135.0	195.0	5.30
A9765.4X205	–	5.40	0.2126	140.0	205.0	5.40
A9765.5X205	–	5.50	0.2165	140.0	205.0	5.50
A9765.6X205	–	5.60	0.2205	140.0	205.0	5.60
A9765.7X205	–	5.70	0.2244	140.0	205.0	5.70
A9765.8X205	–	5.80	0.2283	140.0	205.0	5.80
A9765.9X205	–	5.90	0.2323	140.0	205.0	5.90
A9766.0X205	–	6.00	0.2362	140.0	205.0	6.00
A9766.1X215	–	6.10	0.2402	150.0	215.0	6.10
A9766.2X215	–	6.20	0.2441	150.0	215.0	6.20
A9766.3X215	–	6.30	0.2480	150.0	215.0	6.30
A9761/4	1/4	6.35	0.2500	150.0	215.0	6.35
A9766.4X215	–	6.40	0.2520	150.0	215.0	6.40
A9766.5X215	–	6.50	0.2559	150.0	215.0	6.50
A9766.6X215	–	6.60	0.2598	150.0	215.0	6.60
A9766.7X215	–	6.70	0.2638	150.0	215.0	6.70
A9766.8X225	–	6.80	0.2677	155.0	225.0	6.80
A9766.9X225	–	6.90	0.2717	155.0	225.0	6.90
A9767.0X225	–	7.00	0.2756	155.0	225.0	7.00

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9767.5X225	–	7.50	0.2953	155.0	225.0	7.50
A9765/16	5/16	7.94	0.3125	165.0	240.0	7.94
A9768.0X240	–	8.00	0.3150	165.0	240.0	8.00
A9768.5X240	–	8.50	0.3346	165.0	240.0	8.50
A97611/32	11/32	8.73	0.3438	175.0	250.0	8.73
A9769.0X250	–	9.00	0.3543	175.0	250.0	9.00
A9769.5X250	–	9.50	0.3740	175.0	250.0	9.50
A9763/8	3/8	9.52	0.3750	185.0	265.0	9.52
A97610.0X265	–	10.00	0.3937	185.0	265.0	10.00

[1] Dormer Standard.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A97610.5	–	10.50	0.4134	185.0	265.0	10.50
A97611.0	–	11.00	0.4331	195.0	280.0	11.00
A9767/16	7/16	11.11	0.4375	195.0	280.0	11.11
A97611.5	–	11.50	0.4528	195.0	280.0	11.50
A97612.0	–	12.00	0.4724	205.0	295.0	12.00
A97612.5	–	12.50	0.4921	205.0	295.0	12.50
A9761/2	1/2	12.70	0.5000	205.0	295.0	12.70
A97613.0	–	13.00	0.5118	205.0	295.0	13.00
A97614.0 [1]	–	14.00	0.5512	215.0	310.0	14.00