

Brazed

BTA

Deep Hole Drilling





Drill Head Categories

Brazed Drill Heads

Applications		STS (Single Tube System)					
		MBU	UTE	New BSG	New BTG	New BTL	
Brazed drill heads							
Drill diameter (mm)		ø8 - ø14.79	ø12.6 - ø20	ø15.6 - ø16.7	ø15.6 - ø65	ø15.6 - ø65	ø12.6 - ø65
Thread type	External single-start thread	○	-	-	-	-	-
	External 2-start thread	-	○ ^{*1}	-	-	-	○
	External 4-start thread	-	○ ^{*2}	○	○	○	○
Hole tolerance		IT9	IT9	IT9	IT9	IT9	IT9
Surface finish Ra (µm)		2	2	2	2	2	2
Machine	Deep hole drilling machines	○	○	○	○	○	○
	NC machines	-	-	-	-	-	-
	Lathes	-	-	-	-	-	-
	Machining centers M/C	-	-	-	-	-	-
Workpiece material	P Steel	★★★	★★★	★★★	★★★	★★★	★★
	M Stainless	★★★	★★★	★★★	★★★	★★★	★★
	K Cast iron	★★★	★★★	★★★	★★★	★★★	★★
	N Non-ferrous	★★★	★★★	★★★	★★★	★★★	★★★
	S Superalloys	★★	★★	★★	★★	★★	★★
	H Hard materials (≥40HRC)	★★	★★	★★	★★	★★	★★
Page		11	12	13	14	15	16 - 17

★★★(Excellent) ↔ ★(Standard)

*1: UTE & BTU Drill head : ø12.6 mm - ø15.59 mm, External 2-start thread

*2: UTE & BTU Drill head : ø15.6 mm - ø65 mm, External 4-start thread

Drill Head Categories

Brazed Drill Heads

Applications		DTS (Double Tube System)		
		New ETG	New ETL	ETU
Brazed drill heads				
Drill diameter (mm)		ø18.4 - ø65	ø18.4 - ø65	ø18.4 - ø65
Thread type	External single-start thread	-	-	-
	External 2-start thread	-	-	-
	External 4-start thread	○	○	○
Hole tolerance		IT9	IT9	IT9
Surface finish Ra (µm)		2	2	2
Machine	Deep hole drilling machines	○	○	○
	NC machines	○	○	○
	Lathes	○	○	○
	Machining centers M/C	○	○	○
Workpiece material	P Steel	★★★	★★★	★★
	M Stainless	★★★	★★★	★★
	K Cast iron	★★★	★★★	★★
	N Non-ferrous	★★★	★★★	★★★
	S Superalloys	★★	★★	★★
	H Hard materials (≥40HRC)	★★	★★	★★
Page		18	19	20

★★★(Excellent) ↔ ★(Standard)

Brazed drill head — Coated area

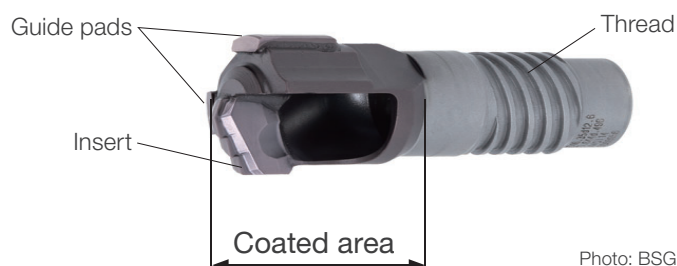
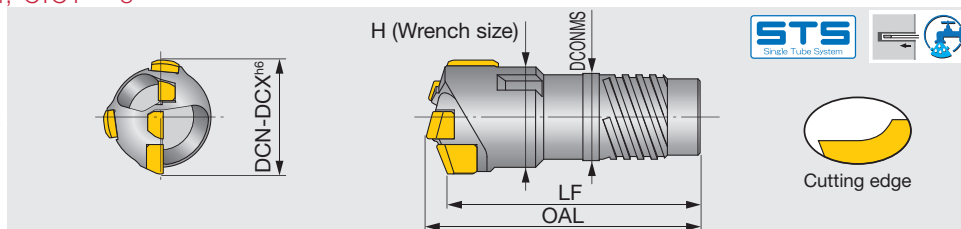


Photo: BSG



Non-standard products (to be supplied on request)

When ordering

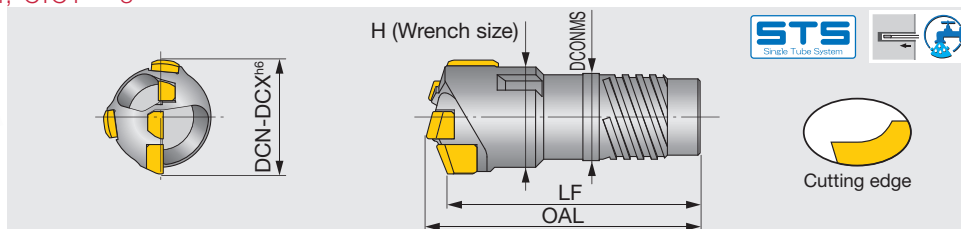
BTG00971-	xx.xx	AHM930
Drill head	Diameter (mm)	Grade

e.g. Designation for tool diameter $\varnothing 16.2$ mm: **BTG00971-16.20 AHM930**

ISO classifications for grades

	Grade	ISO area							
		5	10	15	20	25	30	35	40
P	AHM930								
M	AHM930								
K	AHM930								
N	AHM930								
S	AHM930								
H	AHM930								

Designation	DCN	DCX	Drill tube		OAL	LF	DCONMS	H
			Designation	Dia. (mm)				
BTG00971-xx.xx	15.6	16.2	ST0097	14	43	40.3	12.6	-
BTG00972-xx.xx	16.21	16.7	ST0097	14	43	40.3	12.6	14
BTG00981-xx.xx	16.71	17.2	ST0098	15	43	40.3	13.6	15
BTG00982-xx.xx	17.21	17.7	ST0098	15	43	40.3	13.6	15
BTG00991-xx.xx	17.71	18.4	ST0099	16	47	44.2	14.5	15
BTG00992-xx.xx	18.41	18.9	ST0099	16	47	44.1	14.5	-
BTG001-xx.xx	18.91	19.2	ST0000	17	47	44.1	15.5	17
BTG002-xx.xx	19.21	20	ST0000	17	47	44	15.5	18
BTG011-xx.xx	20.01	20.9	ST00	18	52.5	49.4	16	18
BTG012-xx.xx	20.91	21.8	ST00	18	52.5	49.4	16	19
BTG021-xx.xx	21.81	22.9	ST01	20	56	52.8	18	20
BTG022-xx.xx	22.91	24.1	ST01	20	56	52.6	18	21
BTG031-xx.xx	24.11	25.2	ST02	22	57.5	54	19.5	23
BTG032-xx.xx	25.21	26.4	ST02	22	57.5	54	19.5	24
BTG041-xx.xx	26.41	27.5	ST03	24	57.5	53.8	21	25
BTG042-xx.xx	27.51	28.7	ST03	24	57.5	53.8	21	26
BTG051-xx.xx	28.71	29.8	ST04	26	63.5	59.5	23.5	27
BTG052-xx.xx	29.81	31	ST04	26	63.5	59.3	23.5	28
BTG061-xx.xx	31.01	32.1	ST05	28	63.5	59.4	25.5	29
BTG062-xx.xx	32.11	33.3	ST05	28	63.5	59.1	25.5	30
BTG071-xx.xx	33.31	34.8	ST06	30	63.5	59	28	32
BTG072-xx.xx	34.81	36.2	ST06	30	63.5	58.9	28	33
BTG081-xx.xx	36.21	37.3	ST07	33	73.5	68.7	30	34
BTG082-xx.xx	37.31	38.4	ST07	33	73.5	68.5	30	35
BTG083-xx.xx	38.41	39.6	ST07	33	73.5	68.3	30	36
BTG091-xx.xx	39.61	40.6	ST08	36	73.5	68.2	33	37
BTG092-xx.xx	40.61	41.8	ST08	36	73.5	68	33	38
BTG093-xx.xx	41.81	43	ST08	36	73.5	67.8	33	39
BTG101-xx.xx	43.01	44.3	ST09	39	75	69.5	36	41
BTG102-xx.xx	44.31	45.6	ST09	39	75	69.3	36	42
BTG103-xx.xx	45.61	47	ST09	39	75	69.1	36	43
BTG111-xx.xx	47.01	48.5	ST10	43	75	68.8	39	44
BTG112-xx.xx	48.51	50.1	ST10	43	75	68.7	39	46
BTG113-xx.xx	50.11	51.7	ST10	43	75	68.5	39	47
BTG121-xx.xx	51.71	53.2	ST11	47	82	75.2	43	49
BTG122-xx.xx	53.21	54.7	ST11	47	82	75.2	43	50
BTG123-xx.xx	54.71	56.2	ST11	47	82	75.2	43	51
BTG131-xx.xx	56.21	58.4	ST12	51	84	77.4	47	54
BTG132-xx.xx	58.41	60.6	ST12	51	84	76.9	47	55
BTG133-xx.xx	60.61	62.8	ST12	51	84	76.8	47	57
BTG134-xx.xx	62.81	65	ST12	51	84	76.5	47	59
BTG133L-xx.xx	60.61	62.8	ST13	56	84	76.8	51	57
BTG134L-xx.xx	62.81	65	ST13	56	84	76.5	51	59



Non-standard products (to be supplied on request)

When ordering

BTL00971-

Drill head

xx.xx

Diameter (mm)

AHM930

Grade

e.g. Designation for tool diameter $\varnothing 16.2$ mm: **BTL00971-16.20 AHM930**

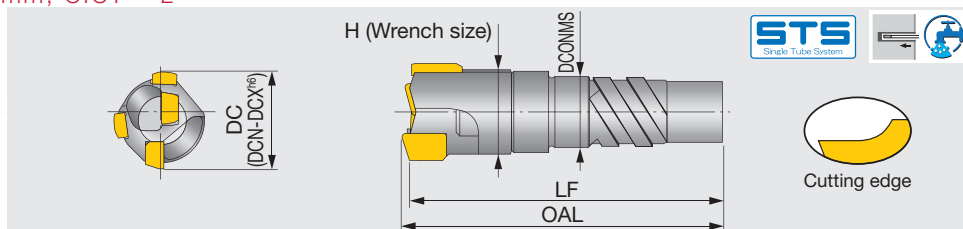
ISO classifications for grades

	Grade	ISO area							
		5	10	15	20	25	30	35	40
P	AHM930								
M	AHM930								
K	AHM930								
N	AHM930								
S	AHM930								
H	AHM930								

Designation	DCN	DCX	Drill tube		OAL	LF	DCONMS	H
			Designation	Dia. (mm)				
BTL00971-xx.xx	15.6	16.2	ST0097	14	43	40.3	12.6	-
BTL00972-xx.xx	16.21	16.7	ST0097	14	43	40.3	12.6	14
BTL00981-xx.xx	16.71	17.2	ST0098	15	43	40.3	13.6	15
BTL00982-xx.xx	17.21	17.7	ST0098	15	43	40.3	13.6	15
BTL00991-xx.xx	17.71	18.4	ST0099	16	47	44.2	14.5	15
BTL00992-xx.xx	18.41	18.9	ST0099	16	47	44.1	14.5	-
BTL001-xx.xx	18.91	19.2	ST0000	17	47	44.1	15.5	17
BTL002-xx.xx	19.21	20	ST0000	17	47	44	15.5	18
BTL011-xx.xx	20.01	20.9	ST00	18	52.5	49.4	16	18
BTL012-xx.xx	20.91	21.8	ST00	18	52.5	49.4	16	19
BTL021-xx.xx	21.81	22.9	ST01	20	56	52.8	18	20
BTL022-xx.xx	22.91	24.1	ST01	20	56	52.6	18	21
BTL031-xx.xx	24.11	25.2	ST02	22	57.5	54	19.5	23
BTL032-xx.xx	25.21	26.4	ST02	22	57.5	54	19.5	24
BTL041-xx.xx	26.41	27.5	ST03	24	57.5	53.8	21	25
BTL042-xx.xx	27.51	28.7	ST03	24	57.5	53.8	21	26
BTL051-xx.xx	28.71	29.8	ST04	26	63.5	59.5	23.5	27
BTL052-xx.xx	29.81	31	ST04	26	63.5	59.3	23.5	28
BTL061-xx.xx	31.01	32.1	ST05	28	63.5	59.4	25.5	29
BTL062-xx.xx	32.11	33.3	ST05	28	63.5	59.1	25.5	30
BTL071-xx.xx	33.31	34.8	ST06	30	63.5	59	28	32
BTL072-xx.xx	34.81	36.2	ST06	30	63.5	58.9	28	33
BTL081-xx.xx	36.21	37.3	ST07	33	73.5	68.7	30	34
BTL082-xx.xx	37.31	38.4	ST07	33	73.5	68.5	30	35
BTL083-xx.xx	38.41	39.6	ST07	33	73.5	68.3	30	36
BTL091-xx.xx	39.61	40.6	ST08	36	73.5	68.2	33	37
BTL092-xx.xx	40.61	41.8	ST08	36	73.5	68	33	38
BTL093-xx.xx	41.81	43	ST08	36	73.5	67.8	33	39
BTL101-xx.xx	43.01	44.3	ST09	39	75	69.5	36	41
BTL102-xx.xx	44.31	45.6	ST09	39	75	69.3	36	42
BTL103-xx.xx	45.61	47	ST09	39	75	69.1	36	43
BTL111-xx.xx	47.01	48.5	ST10	43	75	68.8	39	44
BTL112-xx.xx	48.51	50.1	ST10	43	75	68.7	39	46
BTL113-xx.xx	50.11	51.7	ST10	43	75	68.5	39	47
BTL121-xx.xx	51.71	53.2	ST11	47	82	75.2	43	49
BTL122-xx.xx	53.21	54.7	ST11	47	82	75.2	43	50
BTL123-xx.xx	54.71	56.2	ST11	47	82	75.2	43	51
BTL131-xx.xx	56.21	58.4	ST12	51	84	77.4	47	54
BTL132-xx.xx	58.41	60.6	ST12	51	84	76.9	47	55
BTL133-xx.xx	60.61	62.8	ST12	51	84	76.8	47	57
BTL134-xx.xx	62.81	65	ST12	51	84	76.5	47	59
BTL133L-xx.xx	60.61	62.8	ST13	56	84	76.8	51	57
BTL134L-xx.xx	62.81	65	ST13	56	84	76.5	51	59

BTU type drill head (Small diameter, 2 tip)

Brazed drill head with external 2-start thread for single tube system (STS),
tool diameter $\varnothing 12.6 - \varnothing 15.59$ mm, CICT = 2



Non-standard products (to be supplied on request)

When ordering

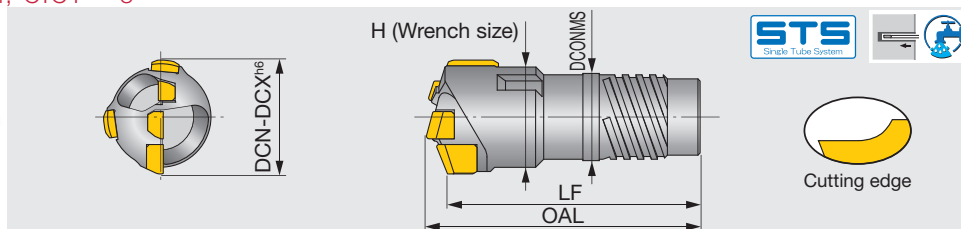
BTU-00941	xx.xx	1122
Drill head	Diameter (mm)	Grade

e.g. Designation for tool diameter $\varnothing 13.1$ mm: BTU-00941 13.10 1122

ISO classifications for grades

	Grade	ISO area							
		5	10	15	20	25	30	35	40
P	1122								
M	1122								
K	1122								
N	1122								
S	1122								
H	1122								

Designation	DCN	DCX	Drill tube		OAL	LF	DCONMS	H
			Designation	Dia. (mm)				
BTU-00941 xx.xx	12.6	13.1	ST0094	11	43	41.9	9.6	10
BTU-00942 xx.xx	13.11	13.6	ST0094	11	43	41.9	9.6	10
BTU-00951 xx.xx	13.61	14.1	ST0095	12	43	41.8	10.6	11
BTU-00952 xx.xx	14.11	14.6	ST0095	12	43	41.8	10.6	11
BTU-00961 xx.xx	14.61	15.1	ST0096	13	43	41.7	11.6	12
BTU-00962 xx.xx	15.11	15.59	ST0096	13	43	41.7	11.6	12



Non-standard products (to be supplied on request)

When ordering

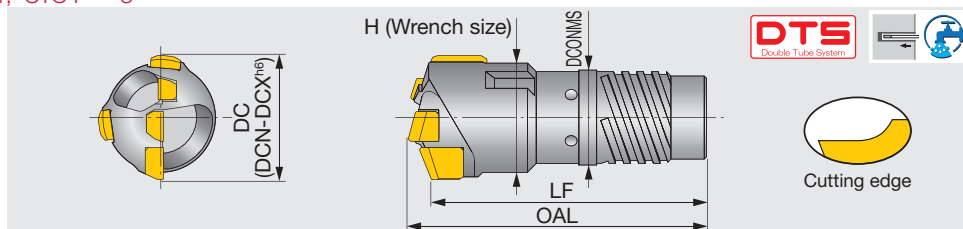
BTU-00971	xx.xx	1122
Drill head	Diameter (mm)	Grade

e.g. Designation for tool diameter $\varnothing 16.2$ mm: **BTU-00971 16.20 1122**

ISO classifications for grades

	Grade	ISO area							
		5	10	15	20	25	30	35	40
P	1122								
M	1122								
K	3132								
N	3132								
S	3132								
H	3132								

Designation	DCN	DCX	Drill tube		OAL	LF	DCONMS	H
			Designation	Dia. (mm)				
BTU-00971 xx.xx	15.6	16.2	ST0097	14	43	40.3	12.6	-
BTU-00972 xx.xx	16.21	16.7	ST0097	14	43	40.3	12.6	14
BTU-00981 xx.xx	16.71	17.2	ST0098	15	43	40.3	13.6	15
BTU-00982 xx.xx	17.21	17.7	ST0098	15	43	40.3	13.6	15
BTU-00991 xx.xx	17.71	18.4	ST0099	16	47	44.2	14.5	15
BTU-00992 xx.xx	18.41	18.9	ST0099	16	47	44.1	14.5	-
BTU-001 xx.xx	18.91	19.2	ST0000	17	47	44.1	15.5	17
BTU-002 xx.xx	19.21	20	ST0000	17	47	44	15.5	18
BTU-011 xx.xx	20.01	20.9	ST00	18	52.5	49.4	16	18
BTU-012 xx.xx	20.91	21.8	ST00	18	52.5	49.4	16	19
BTU-021 xx.xx	21.81	22.9	ST01	20	56	52.8	18	20
BTU-022 xx.xx	22.91	24.1	ST01	20	56	52.6	18	21
BTU-031 xx.xx	24.11	25.2	ST02	22	57.5	54	19.5	23
BTU-032 xx.xx	25.21	26.4	ST02	22	57.5	54	19.5	24
BTU-041 xx.xx	26.41	27.5	ST03	24	57.5	53.8	21	25
BTU-042 xx.xx	27.51	28.7	ST03	24	57.5	53.8	21	26
BTU-051 xx.xx	28.71	29.8	ST04	26	63.5	59.5	23.5	27
BTU-052 xx.xx	29.81	31	ST04	26	63.5	59.3	23.5	28
BTU-061 xx.xx	31.01	32.1	ST05	28	63.5	59.4	25.5	29
BTU-062 xx.xx	32.11	33.3	ST05	28	63.5	59.1	25.5	30
BTU-071 xx.xx	33.31	34.8	ST06	30	63.5	59	28	32
BTU-072 xx.xx	34.81	36.2	ST06	30	63.5	58.9	28	33
BTU-081 xx.xx	36.21	37.3	ST07	33	73.5	68.7	30	34
BTU-082 xx.xx	37.31	38.4	ST07	33	73.5	68.5	30	35
BTU-083 xx.xx	38.41	39.6	ST07	33	73.5	68.3	30	36
BTU-091 xx.xx	39.61	40.6	ST08	36	73.5	68.2	33	37
BTU-092 xx.xx	40.61	41.8	ST08	36	73.5	68	33	38
BTU-093 xx.xx	41.81	43	ST08	36	73.5	67.8	33	39
BTU-101 xx.xx	43.01	44.3	ST09	39	75	69.5	36	41
BTU-102 xx.xx	44.31	45.6	ST09	39	75	69.3	36	42
BTU-103 xx.xx	45.61	47	ST09	39	75	69.1	36	43
BTU-111 xx.xx	47.01	48.5	ST10	43	75	68.8	39	44
BTU-112 xx.xx	48.51	50.1	ST10	43	75	68.7	39	46
BTU-113 xx.xx	50.11	51.7	ST10	43	75	68.5	39	47
BTU-121 xx.xx	51.71	53.2	ST11	47	82	75.2	43	49
BTU-122 xx.xx	53.21	54.7	ST11	47	82	75.2	43	50
BTU-123 xx.xx	54.71	56.2	ST11	47	82	75.2	43	51
BTU-131 xx.xx	56.21	58.4	ST12	51	84	77.4	47	54
BTU-132 xx.xx	58.41	60.6	ST12	51	84	76.9	47	55
BTU-133 xx.xx	60.61	62.8	ST12	51	84	76.8	47	57
BTU-134 xx.xx	62.81	65	ST12	51	84	76.5	47	59
BTU-133L xx.xx	60.61	62.8	ST13	56	84	76.8	51	57
BTU-134L xx.xx	62.81	65	ST13	56	84	76.5	51	59



Non-standard products (to be supplied on request)

When ordering

ETG001-

Drill head

xx.xx

Diameter (mm)

AHM930

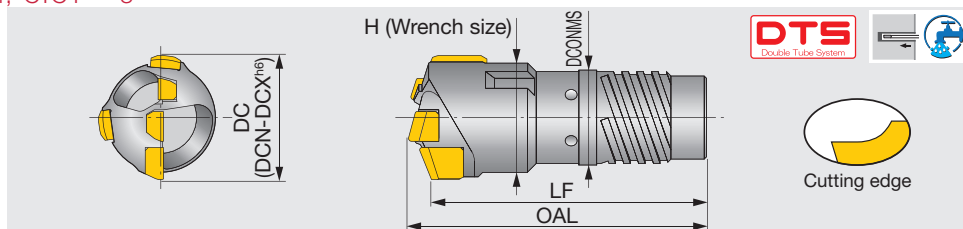
Grade

e.g. Designation for tool diameter $\varnothing 19.2$ mm: **ETG001-19.20 AHM930**

ISO classifications for grades

	Grade	ISO area							
		5	10	15	20	25	30	35	40
P	AHM930								
M	AHM930								
K	AHM930								
N	AHM930								
S	AHM930								
H	AHM930								

Designation	DCN	DCX	Drill tube		OAL	LF	DCONMS	H
			Designation	Dia. (mm)				
ETG001-xx.xx	18.4	19.2	OT00	18	50	47.1	16	17
ETG002-xx.xx	19.21	20	OT00	18	50	47	16	18
ETG011-xx.xx	20.01	20.9	OT01	19.5	56	52.8	18	18
ETG012-xx.xx	20.91	21.8	OT01	19.5	56	52.7	18	19
ETG021-xx.xx	21.81	22.9	OT02	21.5	56	52.8	19.5	20
ETG022-xx.xx	22.91	24.1	OT02	21.5	56	52.6	19.5	21
ETG031-xx.xx	24.11	25.2	OT03	23.5	57.5	54	21	23
ETG032-xx.xx	25.21	26.4	OT03	23.5	57.5	54	21	24
ETG041-xx.xx	26.41	27.5	OT04	26	60.5	56.8	23.5	25
ETG042-xx.xx	27.51	28.7	OT04	26	60.5	56.8	23.5	26
ETG051-xx.xx	28.71	29.8	OT05	28	63.5	59.5	25.5	27
ETG052-xx.xx	29.81	31	OT05	28	63.5	59.3	25.5	28
ETG061-xx.xx	31.01	32.1	OT06	30.5	63.5	59.4	28	29
ETG062-xx.xx	32.11	33.3	OT06	30.5	63.5	59.2	28	30
ETG071-xx.xx	33.31	34.8	OT07	33	70.5	66	30	32
ETG072-xx.xx	34.81	36.2	OT07	33	70.5	65.8	30	33
ETG081-xx.xx	36.21	37.3	OT08	35.5	73.5	68.7	33	34
ETG082-xx.xx	37.31	38.4	OT08	35.5	73.5	68.5	33	35
ETG083-xx.xx	38.41	39.6	OT08	35.5	73.5	68.3	33	36
ETG091-xx.xx	39.61	40.6	OT09	39	73.5	68.2	36	37
ETG092-xx.xx	40.61	41.8	OT09	39	73.5	68	36	38
ETG093-xx.xx	41.81	43	OT09	39	73.5	67.9	36	39
ETG101-xx.xx	43.01	44.3	OT10	42.5	75	69.5	39	41
ETG102-xx.xx	44.31	45.6	OT10	42.5	75	69.3	39	42
ETG103-xx.xx	45.61	47	OT10	42.5	75	69.1	39	43
ETG111-xx.xx	47.01	48.5	OT11	46.5	79	72.9	43	44
ETG112-xx.xx	48.51	50.1	OT11	46.5	79	72.8	43	46
ETG113-xx.xx	50.11	51.7	OT11	46.5	79	72.5	43	47
ETG121-xx.xx	51.71	53.2	OT12	51	82	75.3	47	49
ETG122-xx.xx	53.21	54.7	OT12	51	82	75.5	47	50
ETG123-xx.xx	54.71	56.2	OT12	51	82	75.3	47	51
ETG131-xx.xx	56.21	58.4	OT13	55.5	84	77.4	51	54
ETG132-xx.xx	58.41	60.6	OT13	55.5	84	76.9	51	55
ETG133-xx.xx	60.61	62.8	OT13	55.5	84	77	51	57
ETG134-xx.xx	62.81	65	OT13	55.5	84	76.6	51	59



Non-standard products (to be supplied on request)

When ordering

ETL001-

Drill head

xx.xx

Diameter (mm)

AHM930

Grade

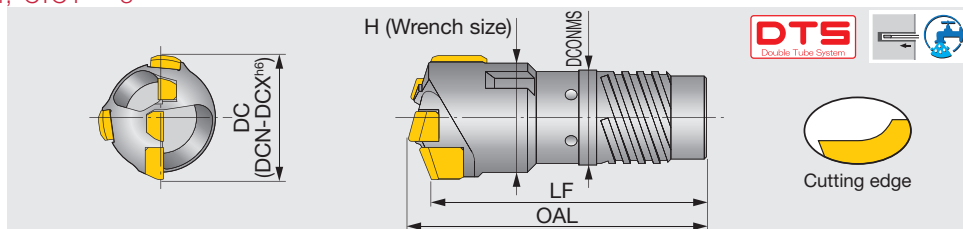
e.g. Designation for tool diameter $\varnothing 19.2$ mm: **ETL001-19.20 AHM930**

ISO classifications for grades

	Grade	ISO area							
		5	10	15	20	25	30	35	40
P	AHM930								
M	AHM930								
K	AHM930								
N	AHM930								
S	AHM930								
H	AHM930								

Designation	DCN	DCX	Drill tube		OAL	LF	DCONMS	H
			Designation	Dia. (mm)				
ETL001-xx.xx	18.4	19.2	OT00	18	50	47.1	16	17
ETL002-xx.xx	19.21	20	OT00	18	50	47	16	18
ETL011-xx.xx	20.01	20.9	OT01	19.5	56	52.8	18	18
ETL012-xx.xx	20.91	21.8	OT01	19.5	56	52.7	18	19
ETL021-xx.xx	21.81	22.9	OT02	21.5	56	52.8	19.5	20
ETL022-xx.xx	22.91	24.1	OT02	21.5	56	52.6	19.5	21
ETL031-xx.xx	24.11	25.2	OT03	23.5	57.5	54	21	23
ETL032-xx.xx	25.21	26.4	OT03	23.5	57.5	54	21	24
ETL041-xx.xx	26.41	27.5	OT04	26	60.5	56.8	23.5	25
ETL042-xx.xx	27.51	28.7	OT04	26	60.5	56.8	23.5	26
ETL051-xx.xx	28.71	29.8	OT05	28	63.5	59.5	25.5	27
ETL052-xx.xx	29.81	31	OT05	28	63.5	59.3	25.5	28
ETL061-xx.xx	31.01	32.1	OT06	30.5	63.5	59.4	28	29
ETL062-xx.xx	32.11	33.3	OT06	30.5	63.5	59.2	28	30
ETL071-xx.xx	33.31	34.8	OT07	33	70.5	66	30	32
ETL072-xx.xx	34.81	36.2	OT07	33	70.5	65.8	30	33
ETL081-xx.xx	36.21	37.3	OT08	35.5	73.5	68.7	33	34
ETL082-xx.xx	37.31	38.4	OT08	35.5	73.5	68.5	33	35
ETL083-xx.xx	38.41	39.6	OT08	35.5	73.5	68.3	33	36
ETL091-xx.xx	39.61	40.6	OT09	39	73.5	68.2	36	37
ETL092-xx.xx	40.61	41.8	OT09	39	73.5	68	36	38
ETL093-xx.xx	41.81	43	OT09	39	73.5	67.9	36	39
ETL101-xx.xx	43.01	44.3	OT10	42.5	75	69.5	39	41
ETL102-xx.xx	44.31	45.6	OT10	42.5	75	69.3	39	42
ETL103-xx.xx	45.61	47	OT10	42.5	75	69.1	39	43
ETL111-xx.xx	47.01	48.5	OT11	46.5	79	72.9	43	44
ETL112-xx.xx	48.51	50.1	OT11	46.5	79	72.8	43	46
ETL113-xx.xx	50.11	51.7	OT11	46.5	79	72.5	43	47
ETL121-xx.xx	51.71	53.2	OT12	51	82	75.3	47	49
ETL122-xx.xx	53.21	54.7	OT12	51	82	75.5	47	50
ETL123-xx.xx	54.71	56.2	OT12	51	82	75.3	47	51
ETL131-xx.xx	56.21	58.4	OT13	55.5	84	77.4	51	54
ETL132-xx.xx	58.41	60.6	OT13	55.5	84	76.9	51	55
ETL133-xx.xx	60.61	62.8	OT13	55.5	84	77	51	57
ETL134-xx.xx	62.81	65	OT13	55.5	84	76.6	51	59

Brazed drill head with external 4-start thread for double tube system (DTS),
tool diameter $\varnothing 18.4 - \varnothing 65$ mm, CICT = 3



Non-standard products (to be supplied on request)

When ordering

ETU-001	xx.xx	1122
Drill head	Diameter (mm)	Grade

e.g. Designation for tool diameter $\varnothing 19.2$ mm: **ETU-001 19.20 1122**

ISO classifications for grades

	Grade	ISO area							
		5	10	15	20	25	30	35	40
P	1122								
M	1122								
K	3132								
N	3132								
S	3132								
H	3132								

Designation	DCN	DCX	Drill tube		OAL	LF	DCONMS	H
			Designation	Dia. (mm)				
ETU-001 xx.xx	18.4	19.2	OT00	18	50	47.1	16	17
ETU-002 xx.xx	19.21	20	OT00	18	50	47	16	18
ETU-011 xx.xx	20.01	20.9	OT01	19.5	56	52.8	18	18
ETU-012 xx.xx	20.91	21.8	OT01	19.5	56	52.7	18	19
ETU-021 xx.xx	21.81	22.9	OT02	21.5	56	52.8	19.5	20
ETU-022 xx.xx	22.91	24.1	OT02	21.5	56	52.6	19.5	21
ETU-031 xx.xx	24.11	25.2	OT03	23.5	57.5	54	21	23
ETU-032 xx.xx	25.21	26.4	OT03	23.5	57.5	54	21	24
ETU-041 xx.xx	26.41	27.5	OT04	26	60.5	56.8	23.5	25
ETU-042 xx.xx	27.51	28.7	OT04	26	60.5	56.8	23.5	26
ETU-051 xx.xx	28.71	29.8	OT05	28	63.5	59.5	25.5	27
ETU-052 xx.xx	29.81	31	OT05	28	63.5	59.3	25.5	28
ETU-061 xx.xx	31.01	32.1	OT06	30.5	63.5	59.4	28	29
ETU-062 xx.xx	32.11	33.3	OT06	30.5	63.5	59.2	28	30
ETU-071 xx.xx	33.31	34.8	OT07	33	70.5	66	30	32
ETU-072 xx.xx	34.81	36.2	OT07	33	70.5	65.8	30	33
ETU-081 xx.xx	36.21	37.3	OT08	35.5	73.5	68.7	33	34
ETU-082 xx.xx	37.31	38.4	OT08	35.5	73.5	68.5	33	35
ETU-083 xx.xx	38.41	39.6	OT08	35.5	73.5	68.3	33	36
ETU-091 xx.xx	39.61	40.6	OT09	39	73.5	68.2	36	37
ETU-092 xx.xx	40.61	41.8	OT09	39	73.5	68	36	38
ETU-093 xx.xx	41.81	43	OT09	39	73.5	67.9	36	39
ETU-101 xx.xx	43.01	44.3	OT10	42.5	75	69.5	39	41
ETU-102 xx.xx	44.31	45.6	OT10	42.5	75	69.3	39	42
ETU-103 xx.xx	45.61	47	OT10	42.5	75	69.1	39	43
ETU-111 xx.xx	47.01	48.5	OT11	46.5	79	72.9	43	44
ETU-112 xx.xx	48.51	50.1	OT11	46.5	79	72.8	43	46
ETU-113 xx.xx	50.11	51.7	OT11	46.5	79	72.5	43	47
ETU-121 xx.xx	51.71	53.2	OT12	51	82	75.3	47	49
ETU-122 xx.xx	53.21	54.7	OT12	51	82	75.5	47	50
ETU-123 xx.xx	54.71	56.2	OT12	51	82	75.3	47	51
ETU-131 xx.xx	56.21	58.4	OT13	55.5	84	77.4	51	54
ETU-132 xx.xx	58.41	60.6	OT13	55.5	84	76.9	51	55
ETU-133 xx.xx	60.61	62.8	OT13	55.5	84	77	51	57
ETU-134 xx.xx	62.81	65	OT13	55.5	84	76.6	51	59

Reference pages: Standard cutting conditions → 26, Drill tube (DTS) → 24