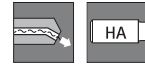
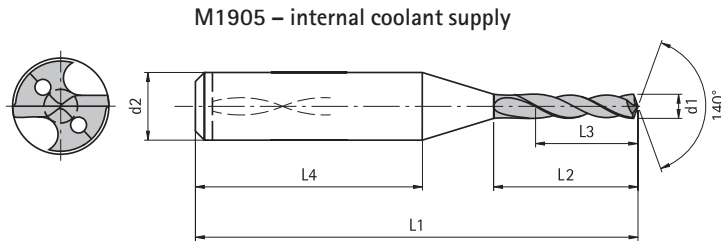


# SMART-DRILL

## Solid carbide twist drill M1905 (5 x D)



### Design:

Drill diameter:	1.00 – 2.90 mm
Bore tolerance:	IT 9 (achievable)
Coating:	MxF (standard)
No. of flutes:	2
Shank form:	HA (similar to DIN 6535)
Centre radial land:	special radial land
Centre angle:	140°
Lateral radial rake:	10° to 25° (diameter clearance)

Order example for solid carbide twist drill M1905  
with  $d1 = 1.00$  mm, MxF coated, shank form HA.  
Order No. M1905-0100-MxF-HA

Drill diameter $d1$ (+0.004)	Shank diameter $d2$ (-0.002/-0.005)	Dimensions				Form and diameter Int. coolant supply M1905
		Total length L1	Flute length L2	Maximum drilling depth L3	Shank length L4	
1,00	3	55	8	5	40	M1905-0100
1,10	3	55	12	8	34	M1905-0110
1,20	3	55	12	8	35	M1905-0120
1,30	3	55	12	8	35	M1905-0130
1,40	3	55	12	8	35	M1905-0140
1,50	3	55	12	8	35	M1905-0150
1,60	3	68	16	11	43	M1905-0160
1,70	3	68	16	11	44	M1905-0170
1,80	3	68	16	11	44	M1905-0180
1,90	3	68	16	11	44	M1905-0190
2,00	3	68	16	11	44	M1905-0200
2,10	3	74	20	14	44	M1905-0210
2,20	3	74	20	14	45	M1905-0220
2,30	3	74	20	14	45	M1905-0230
2,40	3	74	20	14	45	M1905-0240
2,50	3	74	20	14	45	M1905-0250
2,60	3	81	23	16	48	M1905-0260
2,70	3	81	23	16	48	M1905-0270
2,80	3	81	23	16	48	M1905-0280
2,90	3	81	23	16	48	M1905-0290

# SMART-DRILL

## Solid carbide twist drill M1908 (8 x D)

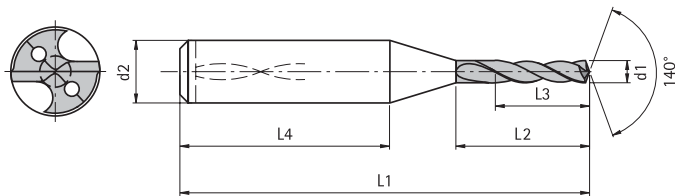


**P** **M** **K<sub>1</sub>** **K<sub>2</sub>** **N** **S**

### Design:

Drill diameter: 1.00 – 2.90 mm  
 Bore tolerance: IT 9 (achievable)  
 Coating: MxF (standard)  
 No. of flutes: 2  
 Shank form: HA (similar to DIN 6535)  
 Centre radial land: special radial land  
 Centre angle: 140°  
 Lateral radial rake: 10° to 25°  
 (diameter clearance)

M1908 – internal coolant supply

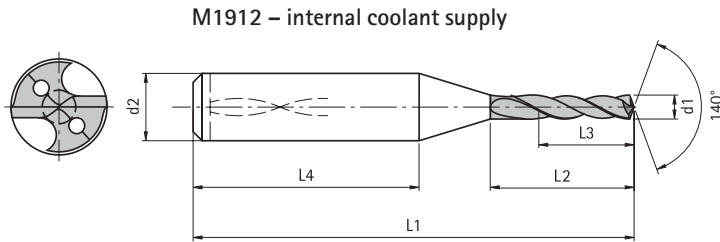


Order example for solid carbide twist drill M1908  
 with d1 = 1.00 mm, MxF coated, shank form HA.  
 Order No. M1908-0100-MxF-HA

Drill diameter d1 (+0.004)	Shank diameter d2 (-0.002/-0.005)	Dimensions				Shank length L4	Form and diameter Int. coolant supply M1908
		Total length L1	Flute length L2	Maximum drilling depth L3			
1,00	3	55	11	8	40	M1908-0100	
1,10	3	55	17	13	34	M1908-0110	
1,20	3	55	17	13	35	M1908-0120	
1,30	3	55	17	13	35	M1908-0130	
1,40	3	55	17	13	35	M1908-0140	
1,50	3	55	17	13	35	M1908-0150	
1,60	3	68	22	17	43	M1908-0160	
1,70	3	68	22	17	44	M1908-0170	
1,80	3	68	22	17	44	M1908-0180	
1,90	3	68	22	17	44	M1908-0190	
2,00	3	68	22	17	44	M1908-0200	
2,10	3	74	28	22	44	M1908-0210	
2,20	3	74	28	22	45	M1908-0220	
2,30	3	74	28	22	45	M1908-0230	
2,40	3	74	28	22	45	M1908-0240	
2,50	3	74	28	22	45	M1908-0250	
2,60	3	81	32	25	48	M1908-0260	
2,70	3	81	32	25	48	M1908-0270	
2,80	3	81	32	25	48	M1908-0280	
2,90	3	81	32	25	48	M1908-0290	

# SMART-DRILL

## Solid carbide twist drill M1912 (12 x D)



### Design:

Drill diameter:	1.00 – 2.90 mm
Bore tolerance:	IT 9 (achievable)
Coating:	MxF (standard)
No. of flutes:	2
Shank form:	HA (similar to DIN 6535)
Centre radial land:	special radial land
Centre angle:	140°
Lateral radial rake:	10° to 25° (diameter clearance)

Order example for solid carbide twist drill M1912 with  $d1 = 1.00$  mm, MxF coated, shank form HA.  
Order No. M1912-0100-MxF-HA

Drill diameter $d1$ (+0.004)	Shank diameter $d2$ (-0.002/-0.005)	Dimensions				Form and diameter Int. coolant supply M1912
		Total length L1	Flute length L2	Maximum drilling depth L3	Shank length L4	
1,00	3	55	15	12	28	M1912-0100
1,10	3	55	23	19	28	M1912-0110
1,20	3	55	23	19	29	M1912-0120
1,30	3	55	23	19	29	M1912-0130
1,40	3	55	23	19	29	M1912-0140
1,50	3	55	23	19	29	M1912-0150
1,60	3	68	30	25	35	M1912-0160
1,70	3	68	30	25	36	M1912-0170
1,80	3	68	30	25	36	M1912-0180
1,90	3	68	30	25	36	M1912-0190
2,00	3	68	30	25	36	M1912-0200
2,10	3	74	38	32	34	M1912-0210
2,20	3	74	38	32	35	M1912-0220
2,30	3	74	38	32	35	M1912-0230
2,40	3	74	38	32	35	M1912-0240
2,50	3	74	38	32	35	M1912-0250
2,60	3	81	44	37	36	M1912-0260
2,70	3	81	44	37	36	M1912-0270
2,80	3	81	44	37	36	M1912-0280
2,90	3	81	44	37	36	M1912-0290