

**EXTENDED PRODUCT RANGE**

# SOLID CARBIDE DRILLS 2017



Improving Quality Through Innovation  
Product of Holland







**SOLID CARBIDE DRILL | 12XD | SCT NORM | TiAIN COATED**


|             |    |     |    |    |     |   |   | Without internal coolant holes | With internal coolant holes |
|-------------|----|-----|----|----|-----|---|---|--------------------------------|-----------------------------|
| Dc          | Ds | Ls  | Ln | Dn | Lt  | r | z | Price                          | Price                       |
| 3,0 - 3,7   | 6  | 50  | -  | -  | 90  | - | 2 | -                              | € 146,25                    |
| 3,8 - 4,7   | 6  | 64  | -  | -  | 102 | - | 2 | -                              | € 146,25                    |
| 4,8 - 6,0   | 6  | 78  | -  | -  | 116 | - | 2 | -                              | € 146,25                    |
| 6,1 - 8,0   | 8  | 108 | -  | -  | 146 | - | 2 | -                              | € 180,30                    |
| 8,1 - 10,0  | 10 | 120 | -  | -  | 162 | - | 2 | -                              | € 227,30                    |
| 10,2 - 12,0 | 12 | 156 | -  | -  | 204 | - | 2 | -                              | € 301,60                    |
| 12,5 - 14,0 | 14 | 182 | -  | -  | 230 | - | 2 | -                              | € 373,70                    |
| 14,5 - 16,0 | 16 | 208 | -  | -  | 260 | - | 2 | -                              | € 528,85                    |
| 16,5 - 18,0 | 18 | 234 | -  | -  | 285 | - | 2 | -                              | € 590,00                    |
| 18,5 - 20,0 | 20 | 258 | -  | -  | 310 | - | 2 | -                              | € 841,30                    |


**Workpiece material groups and cutting speed**

| Material                                       | Tensile strength Rm [N/mm <sup>2</sup> ] | Hardness [HB/HRC] | Cutting speed Vc [m/min] |     |     |
|--|--|-------------------|--------------------------|-----|-----|
|  |  |                   | min                      | opt | max |
| P1 Plain carbon steel                          | < 600                                    | < 230             | 80                       | 90  | 100 |
| P2 Alloy Steel                                 | < 1200                                   | < 350             | 70                       | 80  | 90  |
| P3 High alloy steel and tool steel             | < 1400                                   | < 380             | 40                       | 50  | 60  |
| M1 Aust. and Ferr. Stainless steel             | < 680                                    | < 220             | 30                       | 40  | 50  |
| M2 Mart. Stainless steel                       | < 820                                    | < 240             | 30                       | 40  | 50  |
| K1 Grey cast iron                              | -  | < 280             | 100                      | 120 | 140 |
| K2 Ductile cast iron                           | -  | < 320             | 70                       | 80  | 90  |
| N1 Non-ferrous alloys                          | < 250                                    | < 110             | -                        | -   | -   |
| N2 Aluminium alloys                            | < 530                                    | < 130             | -                        | -   | -   |
| S1 High temperature alloys Fe, Ni and Co based | < 3300                                   | < 350             | 30                       | 40  | 50  |
| S2 Titanium alloys; Alpha and Beta             | < 2100                                   | < 400             | -                        | -   | -   |
| H1 Hardened steel                              | -  | < 54 HRC          | -                        | -   | -   |
| H2 Hardened steel                              | -  | 52-60 HRC         | -                        | -   | -   |
| H3 Hardened steel                              | -  | > 58 HRC          | -                        | -   | -   |
| G1 Graphite                                    | -  | -                 | -                        | -   | -   |

**Cutting conditions**

| Material | f Feed per revolution [mm] |           |           |         |         |         |         |          |           |           |           |
|----------|----------------------------|-----------|-----------|---------|---------|---------|---------|----------|-----------|-----------|-----------|
|          | Ø 0 - 2                    | Ø 2 - 2,5 | Ø 2,5 - 3 | Ø 3 - 4 | Ø 4 - 5 | Ø 5 - 6 | Ø 6 - 8 | Ø 8 - 10 | Ø 10 - 12 | Ø 12 - 16 | Ø 16 - 20 |
| P1       | 0,080                      | 0,100     | 0,125     | 0,160   | 0,160   | 0,200   | 0,250   | 0,315    | 0,315     | 0,400     | 0,500     |
| P2       | 0,063                      | 0,080     | 0,100     | 0,125   | 0,125   | 0,160   | 0,200   | 0,250    | 0,250     | 0,315     | 0,400     |
| P3       | 0,050                      | 0,063     | 0,080     | 0,100   | 0,100   | 0,125   | 0,160   | 0,200    | 0,200     | 0,250     | 0,315     |
| M1       | 0,040                      | 0,050     | 0,063     | 0,080   | 0,080   | 0,100   | 0,125   | 0,160    | 0,160     | 0,200     | 0,250     |
| M2       | 0,032                      | 0,040     | 0,050     | 0,063   | 0,063   | 0,080   | 0,100   | 0,125    | 0,125     | 0,160     | 0,200     |
| K1       | 0,125                      | 0,160     | 0,160     | 0,200   | 0,250   | 0,315   | 0,315   | 0,400    | 0,500     | 0,630     | 0,630     |
| K2       | 0,100                      | 0,125     | 0,160     | 0,200   | 0,200   | 0,250   | 0,315   | 0,400    | 0,400     | 0,500     | 0,630     |
| N1       | 0,100                      | 0,125     | 0,160     | 0,200   | 0,200   | 0,250   | 0,315   | 0,400    | 0,400     | 0,500     | 0,630     |
| N2       | 0,125                      | 0,160     | 0,160     | 0,200   | 0,250   | 0,315   | 0,315   | 0,400    | 0,500     | 0,630     | 0,630     |
| S1       | 0,040                      | 0,050     | 0,063     | 0,080   | 0,080   | 0,100   | 0,125   | 0,160    | 0,160     | 0,200     | 0,250     |
| S2       | 0,032                      | 0,040     | 0,050     | 0,063   | 0,063   | 0,080   | 0,100   | 0,125    | 0,125     | 0,160     | 0,200     |
| H1       | 0,032                      | 0,040     | 0,050     | 0,063   | 0,063   | 0,080   | 0,100   | 0,125    | 0,125     | 0,160     | 0,200     |
| H2       | 0,025                      | 0,032     | 0,040     | 0,050   | 0,050   | 0,063   | 0,080   | 0,100    | 0,100     | 0,125     | 0,160     |
| H3       | -                          | -         | -         | -       | -       | -       | -       | -        | -         | -         | -         |
| G1       | -                          | -         | -         | -       | -       | -       | -       | -        | -         | -         | -         |





SCT has a global network of professional dealers



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