

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



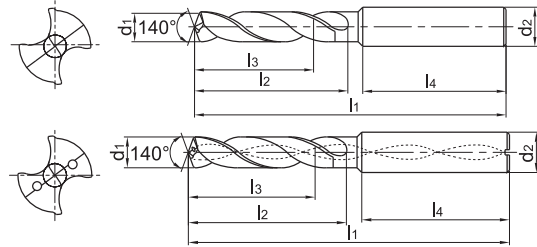
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-0200		2	6	66	28	23	36	●
1536SU05-0210		2.1	6	66	28	23	36	●
1536SU05-0220		2.2	6	66	28	23	36	●
1536SU05-0230		2.3	6	66	28	23	36	●
1536SU05-0240		2.4	6	66	28	23	36	●
1536SU05-0250		2.5	6	66	28	23	36	●
1536SU05-0260		2.6	6	66	28	23	36	●
1536SU05-0270		2.7	6	66	28	23	36	●
1536SU05-0280		2.8	6	66	28	23	36	●
1536SU05-0290		2.9	6	66	28	23	36	●
1536SU05-0300		3	6	66	28	23	36	●
1536SU05C-0300	*	3	6	66	28	23	36	●
1536SU05-0310		3.1	6	66	28	23	36	●
1536SU05C-0310	*	3.1	6	66	28	23	36	●
1536SU05-0320		3.2	6	66	28	23	36	●
1536SU05C-0320	*	3.2	6	66	28	23	36	●
1536SU05-0325		3.25	6	66	28	23	36	●
1536SU05C-0325	*	3.25	6	66	28	23	36	●
1536SU05-0330		3.3	6	66	28	23	36	●
1536SU05C-0330	*	3.3	6	66	28	23	36	●
1536SU05-0340		3.4	6	66	28	23	36	●
1536SU05C-0340	*	3.4	6	66	28	23	36	●
1536SU05-0350		3.5	6	66	28	23	36	●
1536SU05C-0350	*	3.5	6	66	28	23	36	●
1536SU05-0360		3.6	6	66	28	23	36	●
1536SU05C-0360	*	3.6	6	66	28	23	36	●
1536SU05-0370		3.7	6	66	28	23	36	●
1536SU05C-0370	*	3.7	6	66	28	23	36	●
1536SU05-0380		3.8	6	74	36	29	36	●
1536SU05C-0380	*	3.8	6	74	36	29	36	●
1536SU05-0390		3.9	6	74	36	29	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

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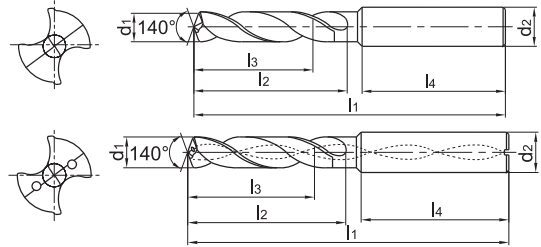
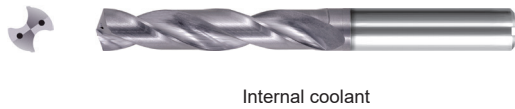
Solid carbide drills SU series

SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05C-0390	*	3.9	6	74	36	29	36	●
1536SU05-0400		4	6	74	36	29	36	●
1536SU05C-0400	*	4	6	74	36	29	36	●
1536SU05-0410		4.1	6	74	36	29	36	●
1536SU05C-0410	*	4.1	6	74	36	29	36	●
1536SU05-0420		4.2	6	74	36	29	36	●
1536SU05C-0420	*	4.2	6	74	36	29	36	●
1536SU05-0430		4.3	6	74	36	29	36	●
1536SU05C-0430	*	4.3	6	74	36	29	36	●
1536SU05-0440		4.4	6	74	36	29	36	●
1536SU05C-0440	*	4.4	6	74	36	29	36	●
1536SU05-0450		4.5	6	74	36	29	36	●
1536SU05C-0450	*	4.5	6	74	36	29	36	●
1536SU05-0460		4.6	6	74	36	29	36	●
1536SU05C-0460	*	4.6	6	74	36	29	36	●
1536SU05-0465		4.65	6	74	36	29	36	●
1536SU05C-0465	*	4.65	6	74	36	29	36	●
1536SU05-0470		4.7	6	74	36	29	36	●
1536SU05C-0470	*	4.7	6	74	36	29	36	●
1536SU05-0480		4.8	6	82	44	35	36	●
1536SU05C-0480	*	4.8	6	82	44	35	36	●
1536SU05-0490		4.9	6	82	44	35	36	●
1536SU05C-0490	*	4.9	6	82	44	35	36	●
1536SU05-0500		5	6	82	44	35	36	●
1536SU05C-0500	*	5	6	82	44	35	36	●
1536SU05-0510		5.1	6	82	44	35	36	●
1536SU05C-0510	*	5.1	6	82	44	35	36	●
1536SU05-0520		5.2	6	82	44	35	36	●
1536SU05C-0520	*	5.2	6	82	44	35	36	●
1536SU05-0530		5.3	6	82	44	35	36	●
1536SU05C-0530	*	5.3	6	82	44	35	36	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



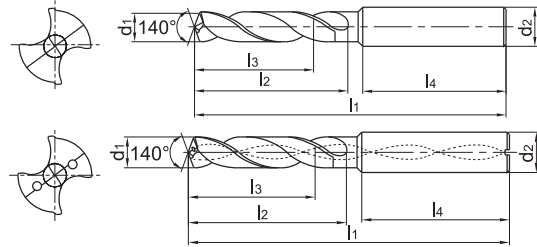
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-0540		5.4	6	82	44	35	36	●
1536SU05C-0540	*	5.4	6	82	44	35	36	●
1536SU05-0550		5.5	6	82	44	35	36	●
1536SU05C-0550	*	5.5	6	82	44	35	36	●
1536SU05-0555		5.55	6	82	44	35	36	●
1536SU05C-0555	*	5.55	6	82	44	35	36	●
1536SU05-0560		5.6	6	82	44	35	36	●
1536SU05C-0560	*	5.6	6	82	44	35	36	●
1536SU05-0570		5.7	6	82	44	35	36	●
1536SU05C-0570	*	5.7	6	82	44	35	36	●
1536SU05-0580		5.8	6	82	44	35	36	●
1536SU05C-0580	*	5.8	6	82	44	35	36	●
1536SU05-0590		5.9	6	82	44	35	36	●
1536SU05C-0590	*	5.9	6	82	44	35	36	●
1536SU05-0600		6	6	82	44	35	36	●
1536SU05C-0600	*	6	6	82	44	35	36	●
1536SU05-0610		6.1	8	91	53	43	36	●
1536SU05C-0610	*	6.1	8	91	53	43	36	●
1536SU05-0620		6.2	8	91	53	43	36	●
1536SU05C-0620	*	6.2	8	91	53	43	36	●
1536SU05-0630		6.3	8	91	53	43	36	●
1536SU05C-0630	*	6.3	8	91	53	43	36	●
1536SU05-0640		6.4	8	91	53	43	36	●
1536SU05C-0640	*	6.4	8	91	53	43	36	●
1536SU05-0650		6.5	8	91	53	43	36	●
1536SU05C-0650	*	6.5	8	91	53	43	36	●
1536SU05-0660		6.6	8	91	53	43	36	●
1536SU05C-0660	*	6.6	8	91	53	43	36	●
1536SU05-0670		6.7	8	91	53	43	36	●
1536SU05C-0670	*	6.7	8	91	53	43	36	●
1536SU05-0675		6.75	8	91	53	43	36	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

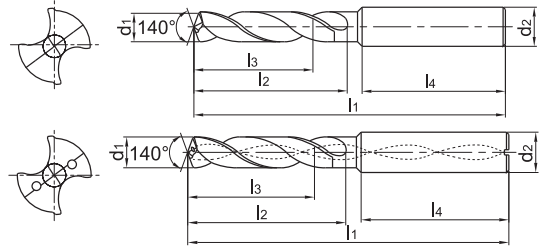
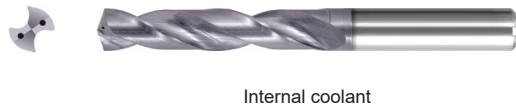
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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05C-0675	*	6.75	8	91	53	43	36	●
1536SU05-0680		6.8	8	91	53	43	36	●
1536SU05C-0680	*	6.8	8	91	53	43	36	●
1536SU05-0690		6.9	8	91	53	43	36	●
1536SU05C-0690	*	6.9	8	91	53	43	36	●
1536SU05-0700		7	8	91	53	43	36	●
1536SU05C-0700	*	7	8	91	53	43	36	●
1536SU05-0710		7.1	8	91	53	43	36	●
1536SU05C-0710	*	7.1	8	91	53	43	36	●
1536SU05-0720		7.2	8	91	53	43	36	●
1536SU05C-0720	*	7.2	8	91	53	43	36	●
1536SU05-0730		7.3	8	91	53	43	36	●
1536SU05C-0730	*	7.3	8	91	53	43	36	●
1536SU05-0740		7.4	8	91	53	43	36	●
1536SU05C-0740	*	7.4	8	91	53	43	36	●
1536SU05-0745		7.45	8	91	53	43	36	●
1536SU05C-0745	*	7.45	8	91	53	43	36	●
1536SU05-0750		7.5	8	91	53	43	36	●
1536SU05C-0750	*	7.5	8	91	53	43	36	●
1536SU05-0760		7.6	8	91	53	43	36	●
1536SU05C-0760	*	7.6	8	91	53	43	36	●
1536SU05-0770		7.7	8	91	53	43	36	●
1536SU05C-0770	*	7.7	8	91	53	43	36	●
1536SU05-0780		7.8	8	91	53	43	36	●
1536SU05C-0780	*	7.8	8	91	53	43	36	●
1536SU05-0790		7.9	8	91	53	43	36	●
1536SU05C-0790	*	7.9	8	91	53	43	36	●
1536SU05-0800		8	8	91	53	43	36	●
1536SU05C-0800	*	8	8	91	53	43	36	●
1536SU05-0810		8.1	10	103	61	49	40	●
1536SU05C-0810	*	8.1	10	103	61	49	40	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



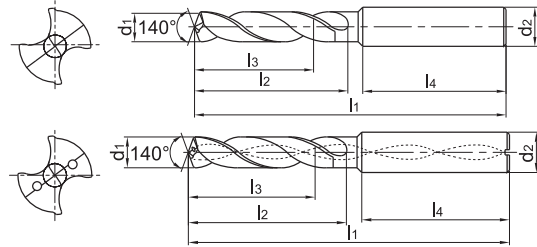
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-0820		8.2	10	103	61	49	40	●
1536SU05C-0820	*	8.2	10	103	61	49	40	●
1536SU05-0830		8.3	10	103	61	49	40	●
1536SU05C-0830	*	8.3	10	103	61	49	40	●
1536SU05-0840		8.4	10	103	61	49	40	●
1536SU05C-0840	*	8.4	10	103	61	49	40	●
1536SU05-0850		8.5	10	103	61	49	40	●
1536SU05C-0850	*	8.5	10	103	61	49	40	●
1536SU05-0860		8.6	10	103	61	49	40	●
1536SU05C-0860	*	8.6	10	103	61	49	40	●
1536SU05-0870		8.7	10	103	61	49	40	●
1536SU05C-0870	*	8.7	10	103	61	49	40	●
1536SU05-0880		8.8	10	103	61	49	40	●
1536SU05C-0880	*	8.8	10	103	61	49	40	●
1536SU05-0890		8.9	10	103	61	49	40	●
1536SU05C-0890	*	8.9	10	103	61	49	40	●
1536SU05-0900		9	10	103	61	49	40	●
1536SU05C-0900	*	9	10	103	61	49	40	●
1536SU05-0910		9.1	10	103	61	49	40	●
1536SU05C-0910	*	9.1	10	103	61	49	40	●
1536SU05-0920		9.2	10	103	61	49	40	●
1536SU05C-0920	*	9.2	10	103	61	49	40	●
1536SU05-0930		9.3	10	103	61	49	40	●
1536SU05C-0930	*	9.3	10	103	61	49	40	●
1536SU05-0935		9.35	10	103	61	49	40	●
1536SU05C-0935	*	9.35	10	103	61	49	40	○
1536SU05-0940		9.4	10	103	61	49	40	●
1536SU05C-0940	*	9.4	10	103	61	49	40	●
1536SU05-0945		9.45	10	103	61	49	40	●
1536SU05C-0945	*	9.45	10	103	61	49	40	○
1536SU05-0950		9.5	10	103	61	49	40	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

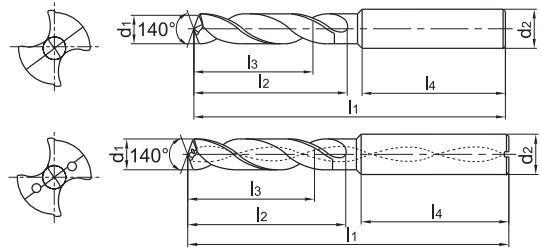
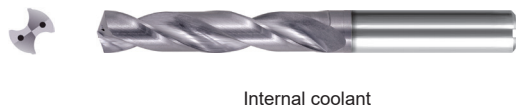
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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05C-0950	*	9.5	10	103	61	49	40	●
1536SU05-0960		9.6	10	103	61	49	40	●
1536SU05C-0960	*	9.6	10	103	61	49	40	●
1536SU05-0970		9.7	10	103	61	49	40	●
1536SU05C-0970	*	9.7	10	103	61	49	40	●
1536SU05-0980		9.8	10	103	61	49	40	●
1536SU05C-0980	*	9.8	10	103	61	49	40	●
1536SU05-0990		9.9	10	103	61	49	40	●
1536SU05C-0990	*	9.9	10	103	61	49	40	●
1536SU05-1000		10	10	103	61	49	40	●
1536SU05C-1000	*	10	10	103	61	49	40	●
1536SU05-1010		10.1	12	118	71	56	45	●
1536SU05C-1010	*	10.1	12	118	71	56	45	●
1536SU05-1020		10.2	12	118	71	56	45	●
1536SU05C-1020	*	10.2	12	118	71	56	45	●
1536SU05-1025		10.25	12	118	71	56	45	●
1536SU05C-1025	*	10.25	12	118	71	56	45	●
1536SU05-1030		10.3	12	118	71	56	45	●
1536SU05C-1030	*	10.3	12	118	71	56	45	●
1536SU05-1040		10.4	12	118	71	56	45	●
1536SU05C-1040	*	10.4	12	118	71	56	45	●
1536SU05-1050		10.5	12	118	71	56	45	●
1536SU05C-1050	*	10.5	12	118	71	56	45	●
1536SU05-1060		10.6	12	118	71	56	45	●
1536SU05C-1060	*	10.6	12	118	71	56	45	●
1536SU05-1070		10.7	12	118	71	56	45	●
1536SU05C-1070	*	10.7	12	118	71	56	45	●
1536SU05-1080		10.8	12	118	71	56	45	●
1536SU05C-1080	*	10.8	12	118	71	56	45	●
1536SU05-1090		10.9	12	118	71	56	45	●
1536SU05C-1090	*	10.9	12	118	71	56	45	●

- Ex stock ○ On demand
- All articles SUK on demand
- * With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



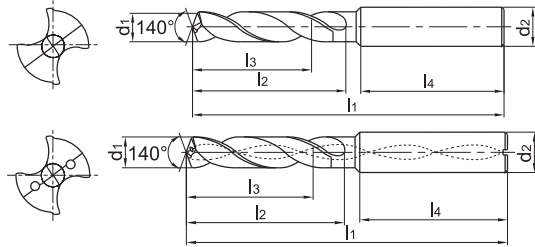
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-1100		11	12	118	71	56	45	●
1536SU05C-1100	*	11	12	118	71	56	45	●
1536SU05-1110		11.1	12	118	71	56	45	●
1536SU05C-1110	*	11.1	12	118	71	56	45	●
1536SU05-1120		11.2	12	118	71	56	45	●
1536SU05C-1120	*	11.2	12	118	71	56	45	●
1536SU05-1125		11.25	12	118	71	56	45	●
1536SU05C-1125	*	11.25	12	118	71	56	45	○
1536SU05-1130		11.3	12	118	71	56	45	●
1536SU05C-1130	*	11.3	12	118	71	56	45	●
1536SU05-1135		11.35	12	118	71	56	45	●
1536SU05C-1135	*	11.35	12	118	71	56	45	○
1536SU05-1140		11.4	12	118	71	56	45	●
1536SU05C-1140	*	11.4	12	118	71	56	45	●
1536SU05-1145		11.45	12	118	71	56	45	○
1536SU05C-1145	*	11.45	12	118	71	56	45	○
1536SU05-1150		11.5	12	118	71	56	45	●
1536SU05C-1150	*	11.5	12	118	71	56	45	●
1536SU05-1160		11.6	12	118	71	56	45	●
1536SU05C-1160	*	11.6	12	118	71	56	45	●
1536SU05-1170		11.7	12	118	71	56	45	●
1536SU05C-1170	*	11.7	12	118	71	56	45	●
1536SU05-1180		11.8	12	118	71	56	45	●
1536SU05C-1180	*	11.8	12	118	71	56	45	●
1536SU05-1190		11.9	12	118	71	56	45	●
1536SU05C-1190	*	11.9	12	118	71	56	45	●
1536SU05-1200		12	12	118	71	56	45	●
1536SU05C-1200	*	12	12	118	71	56	45	●
1536SU05-1210		12.1	14	124	77	60	45	●
1536SU05C-1210	*	12.1	14	124	77	60	45	●
1536SU05-1220		12.2	14	124	77	60	45	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

- ✓ Very suitable
- ✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



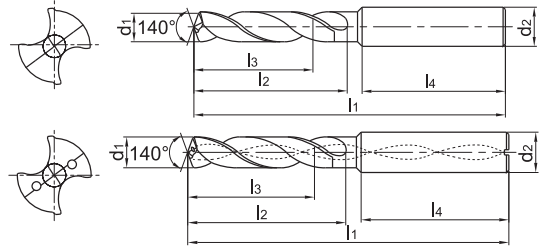
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05C-1220	*	12.2	14	124	77	60	45	●
1536SU05-1225		12.25	14	124	77	60	45	●
1536SU05C-1225	*	12.25	14	124	77	60	45	●
1536SU05-1230		12.3	14	124	77	60	45	●
1536SU05C-1230	*	12.3	14	124	77	60	45	●
1536SU05-1250		12.5	14	124	77	60	45	●
1536SU05C-1250	*	12.5	14	124	77	60	45	●
1536SU05-1270		12.7	14	124	77	60	45	●
1536SU05C-1270	*	12.7	14	124	77	60	45	●
1536SU05-1275		12.75	14	124	77	60	45	●
1536SU05C-1275	*	12.75	14	124	77	60	45	●
1536SU05-1280		12.8	14	124	77	60	45	●
1536SU05C-1280	*	12.8	14	124	77	60	45	●
1536SU05-1300		13	14	124	77	60	45	●
1536SU05C-1300	*	13	14	124	77	60	45	●
1536SU05-1310		13.1	14	124	77	60	45	●
1536SU05C-1310	*	13.1	14	124	77	60	45	●
1536SU05-1335		13.35	14	124	77	60	56	○
1536SU05C-1335	*	13.35	14	124	77	60	56	○
1536SU05-1350		13.5	14	124	77	60	45	●
1536SU05C-1350	*	13.5	14	124	77	60	45	●
1536SU05-1380		13.8	14	124	77	60	45	●
1536SU05C-1380	*	13.8	14	124	77	60	45	●
1536SU05-1400		14	14	124	77	60	45	●
1536SU05C-1400	*	14	14	124	77	60	45	●
1536SU05-1420		14.2	16	124	77	60	45	●
1536SU05C-1420	*	14.2	16	124	77	60	45	●
1536SU05-1425		14.25	16	133	83	63	48	●
1536SU05C-1425	*	14.25	16	133	83	63	48	●
1536SU05-1430		14.3	16	133	83	63	48	●
1536SU05C-1430	*	14.3	16	133	83	63	48	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

SU(K) drill 5xD

General machining

Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



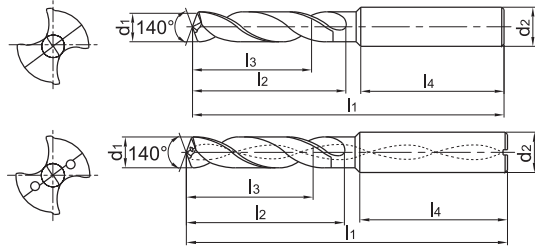
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-1450		14.5	16	133	83	63	48	●
1536SU05C-1450	*	14.5	16	133	83	63	48	●
1536SU05-1475		14.75	16	133	83	63	48	●
1536SU05C-1475	*	14.75	16	133	83	63	48	●
1536SU05-1480		14.8	16	133	83	63	48	●
1536SU05C-1480	*	14.8	16	133	83	63	48	●
1536SU05-1500		15	16	133	83	63	48	●
1536SU05C-1500	*	15	16	133	83	63	48	●
1536SU05-1510		15.1	16	133	83	63	48	●
1536SU05C-1510	*	15.1	16	133	83	63	48	●
1536SU05-1530	*	15.3	16	133	83	63	48	●
1536SU05-1535		15.35	16	133	83	63	48	○
1536SU05C-1535	*	15.35	16	133	83	63	48	○
1536SU05-1550		15.5	16	133	83	63	48	●
1536SU05C-1550	*	15.5	16	133	83	63	48	●
1536SU05-1580		15.8	16	133	83	63	48	●
1536SU05C-1580	*	15.8	16	133	83	63	48	●
1536SU05-1600		16	16	133	83	63	48	●
1536SU05C-1600	*	16	16	133	83	63	48	●
1536SU05-1650		16.5	18	143	93	71	48	●
1536SU05C-1650	*	16.5	18	143	93	71	48	●
1536SU05-1675		16.75	18	143	93	71	48	●
1536SU05C-1675	*	16.75	18	143	93	71	48	●
1536SU05-1680		16.8	18	143	93	71	48	●
1536SU05C-1680	*	16.8	18	143	93	71	48	●
1536SU05-1700		17	18	143	93	71	48	●
1536SU05C-1700	*	17	18	143	93	71	48	●
1536SU05-1750		17.5	18	143	93	71	48	●
1536SU05C-1750	*	17.5	18	143	93	71	48	●
1536SU05-1780		17.8	18	143	93	71	48	●
1536SU05C-1780	*	17.8	18	143	93	71	48	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field						
Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150



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SU(K) drill 5xD **General machining** Add K (SUK) to the code for use on Cast Iron

1536SU05/1536SU05C



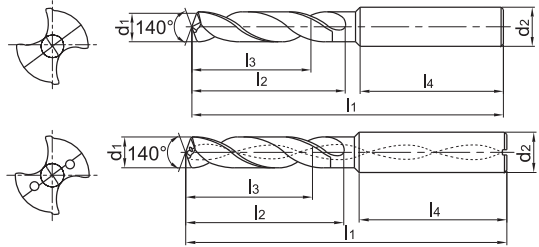
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1536SU05-1800		18	18	143	93	71	48	●
1536SU05C-1800	*	18	18	143	93	71	48	●
1536SU05-1850		18.5	20	153	101	77	50	●
1536SU05C-1850	*	18.5	20	153	101	77	50	●
1536SU05-1880		18.8	20	153	101	77	50	●
1536SU05C-1880	*	18.8	20	153	101	77	50	●
1536SU05-1900		19	20	153	101	77	50	●
1536SU05C-1900	*	19	20	153	101	77	50	●
1536SU05-1950		19.5	20	153	101	77	50	●
1536SU05C-1950	*	19.5	20	153	101	77	50	●
1536SU05-1980		19.8	20	153	101	77	50	●
1536SU05C-1980	*	19.8	20	153	101	77	50	●
1536SU05-2000		20	20	153	101	77	50	●
1536SU05C-2000	*	20	20	153	101	77	50	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1536SU*	✓	✓	✓			
1536SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

1 5 3 6 SU 05 (C) – 0850 (S)

1

2

3

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5

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7

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A

Turning

Type	
Code	Description
1	Forets

1

Shank type	
Code	Description
1	Straight shank
2	Square shank DIN 10
3	Double flattened straight shank DIN 1809
5	Straight shank DIN 6535 HA
6	Weldon shank DIN 6535 HB
7	Whistle Notch shank DIN 6535 HE
9	Morse taper shank

2

B

Milling

Drill type	
Code	Description
0	Twist drill
3	Universal twist drill
4	NC tapping device
5	Step drill
6	Three-lips drill
7	Straight flute drill
8	Deep hole drill

3

Tool length	
Code	Description
1	DIN 338
2	DIN 1897
3	QJ/ZZQ(TO)01.001.002
4	DIN 6537 K
5	DIN 6539
6	DIN 6537 L
7	Factory standard ZCC-C
8	Factory standard ZCC-D
9	Factory standard ZCC-E

4

C

Drilling

Application	
Code	Description
UD	Twist drills for tough materials
GD	Twist drills for high feeds
SU	Twist drill for general machining
SUK	Twist drill for cast iron
SL	Twist drill for deep hole drilling
SLK	Deep hole drill for cast iron
SP	Pilot drill
SH	Twist drill for hardened materials
SC	Twist drill for non-ferrous metals and cast iron
PA	Three-lips drill for non-ferrous metals and cast iron
PC	Straight flute drill for non-ferrous metals and cast iron

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L/D relation		Angle	
Drill		NC tapping device	
Code	Description	Code	Description
03	3xD	90	90°
05	5xD	120	120°
08	8xD		
10	10xD		
12	12xD		
15	15xD		
20	20xD		
30	30xD		

With inner cooling

6

7

Bore diameter [mm]	
Code	Description
0200	2,0
0850	8,5
1800	18,0
...	

Shank diameter [mm]	
Code	Description
S	4,0

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a Boring b Drilling c Profile drilling d Centering

A

Coated cemented carbide PVD

Grade	Grade description
KDG303	PVD coated P10–P20/M10–M20/K10–K20 carbide grade for steel, stainless steel and cast iron. Good wear resistance and toughness for a wide application field.

Turning

B

KDG304	PVD coated carbide substrate for machining caststeel and cast iron. Optimised toughness for high feeds.
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Milling

KDG305	PVD coated carbide substrate for machining stainless steel and HRSA. High process reliability due to improved wear resistance.
---------------	--

C

Uncoated cemented carbide

Grade	Grade description
YK20F	Uncoated K20 carbide substrate for steel, cast iron and non ferrous materials.

Drilling

D

YK30F	Uncoated K30 carbide substrate for steel, stainless steel, cast iron and non ferrous materials.
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IMPORTANT INFORMATION

Recommended applications for the **SU series**

Feed calculator

ISO group	Material	Cutting speed v_c (m/min)	Feed factor F_m
P	Low-alloy steel	180	0,015
	High-alloy steel	120	0,012
M	Stainless steels	80	0,01
K	Cast iron	250	0,018
	Cast steel	180	0,015
S	H RSA	45	0,008
N	Aluminium	400	0,02

Formula: feed per revolution (F_n) $D \times F_m$
Example: drill diameter (D) 10 mm
material high-alloy steel

$$F_n = 10 \text{ mm} \times 0,012 = 0,12 \text{ mm/rev.}$$



Fig.: 1536SU05C