

MS DRILL PROMOTION

DRILLS FOR UNIVERSAL MACHINING



**POPULAR
DRILLING KITS**

*until stocks lasts



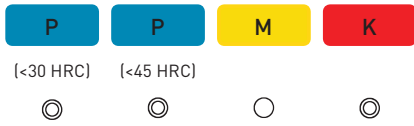
50% PRICE ADVANTAGE*
AND MORE

*based on list-prices.



MS DRILL

SOLID CARBIDE DRILL SERIES



◎ 1st Recommendation
○ 2nd Recommendation

FEATURES

- ◆ Through coolant type
- ◆ 3 x D and 5 x D drilling length
- ◆ Strong cutting edge geometry
- ◆ For a wide range of materials
- ◆ Cylindrical shank type
- ◆ Super micro grain cemented carbide
- ◆ PVD coating for long tool life



A choice of quality tooling for a superior cost performance ratio. A versatile combination of reliable carbide and coating technology for the needs of the modern metal cutting world.

Solutions to cutting problems built over decades of production knowledge enables us to provide a comprehensive and more cost effective range of tools.



Our dedication to quality and reliability is continued with this new range of MS drills that are manufactured to the exacting standards of DIN 6537.

MS DRILL PROMOTION

KIT-ORDER NUMBER	L/D	DRILL 1	DRILL 2	DRILL 3	PROMOTIONAL PRICE
PR-MS-M4-5-6-SLA	5	MS0340-SLA	MS0430-SLA	MS0510-SLA	81 €
PR-MS-M5-6-8-SLA	5	MS0430-SLA	MS0510-SLA	MS0690-SLA	84 €
PR-MS-M6-8-10-SLA	5	MS0510-SLA	MS0690-SLA	MS0870-SLA	91 €
PR-MS-M8-10-SLA	5	MS0690-SLA	MS0870-SLA		64 €
PR-MS-D3-4-5-SLA	5	MS0300-SLA	MS0400-SLA	MS0500-SLA	81 €
PR-MS-D4-5-6-SLA	5	MS0400-SLA	MS0500-SLA	MS0600-SLA	81 €
PR-MS-D5-6-7-SLA	5	MS0500-SLA	MS0600-SLA	MS0700-SLA	84 €
PR-MS-D6-7-8-SLA	5	MS0600-SLA	MS0700-SLA	MS0800-SLA	87 €
PR-MS-D7-8-9-SLA	5	MS0700-SLA	MS0800-SLA	MS0900-SLA	94 €
PR-MS-D8-9-10-SLA	5	MS0800-SLA	MS0900-SLA	MS1000-SLA	98 €
PR-MS-D35-45-55-SLA	5	MS0350-SLA	MS0450-SLA	MS0550-SLA	81 €
PR-MS-D45-55-65-SLA	5	MS0450-SLA	MS0550-SLA	MS0650-SLA	84 €
PR-MS-D55-65-75-SLA	5	MS0550-SLA	MS0650-SLA	MS0750-SLA	87 €
PR-MS-D65-75-85-SLA	5	MS0650-SLA	MS0750-SLA	MS0850-SLA	94 €
PR-MS-M4-5-6-SSA	3	MS0340-SSA	MS0430-SSA	MS0510-SSA	63 €
PR-MS-M5-6-8-SSA	3	MS0430-SSA	MS0510-SSA	MS0690-SSA	71 €
PR-MS-M6-8-10-SSA	3	MS0510-SSA	MS0690-SSA	MS0870-SSA	81 €
PR-MS-M8-10-SSA	3	MS0690-SSA	MS0870-SSA		60 €
PR-MS-D3-4-5-SSA	3	MS0300-SSA	MS0400-SSA	MS0500-SSA	63 €
PR-MS-D4-5-6-SSA	3	MS0400-SSA	MS0500-SSA	MS0600-SSA	63 €
PR-MS-D5-6-7-SSA	3	MS0500-SSA	MS0600-SSA	MS0700-SSA	71 €
PR-MS-D7-8-9-SSA	3	MS0700-SSA	MS0800-SSA	MS0900-SSA	89 €
PR-MS-D8-9-10-SSA	3	MS0800-SSA	MS0900-SSA	MS1000-SSA	92 €
PR-MS-D35-45-55-SSA	3	MS0350-SSA	MS0450-SSA	MS0550-SSA	63 €
PR-MS-D45-55-65-SSA	3	MS0450-SSA	MS0550-SSA	MS0650-SSA	71 €
PR-MS-D55-65-75-SSA	3	MS0550-SSA	MS0650-SSA	MS0750-SSA	78 €
PR-MS-D65-75-85-SSA	3	MS0650-SSA	MS0750-SSA	MS0850-SSA	89 €

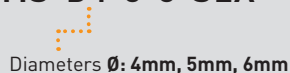
ORDER CODE DESCRIPTION

KIT DESCRIPTION

PR-MS-M4-5-6-SLA

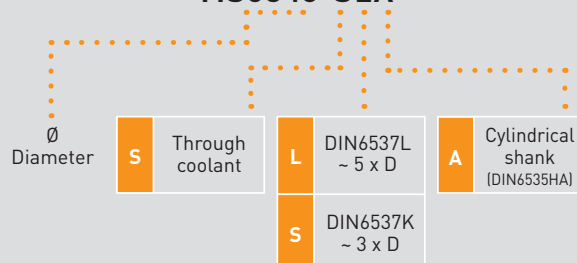


PR-MS-D4-5-6-SLA



ITEM DESCRIPTION

MS0340-SLA

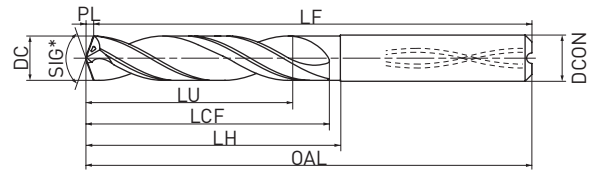


MS-DRILL



*SIG : l/d3 and 5=140°

Type 1 Cylindrical shank type



MS○○○○○-SSA/SLA

D Tolerance	D ≤ 3.0	3.0 < D ≤ 6.0	6.0 < D ≤ 10.0	10.0 < D ≤ 14.0
m7	+0.016 +0.004	+0.016 +0.004	+0.021 +0.006	+0.025 +0.007

MS○○○○○-S○○ (Internal coolant)

DC	Description	DIN 6537 (l/d)	Coolant Internal	Shank type	OAL	LU	LCF	LH	LF	PL	DCON	TYP
3.0	MS0300-SSA	-3	Int.	Cylindrical	62	9	20	26	61,5	0,5	6	1
	MS0300-SLA	-5	Int.	Cylindrical	66	15	28	30	65,5	0,5	6	1
3.4	MS0340-SSA	-3	Int.	Cylindrical	62	10,2	20	26	61,4	0,6	6	1
	MS0340-SLA	-5	Int.	Cylindrical	66	17	28	30	65,4	0,6	6	1
3.5	MS0350-SSA	-3	Int.	Cylindrical	62	10,5	20	26	61,4	0,6	6	1
	MS0350-SLA	-5	Int.	Cylindrical	66	17,5	28	30	65,4	0,6	6	1
4.0	MS0400-SSA	-3	Int.	Cylindrical	66	12	24	30	65,3	0,7	6	1
	MS0400-SLA	-5	Int.	Cylindrical	74	20	36	38	73,3	0,7	6	1
4.3	MS0430-SSA	-3	Int.	Cylindrical	66	12,9	24	30	65,2	0,8	6	1
	MS0430-SLA	-5	Int.	Cylindrical	74	21,5	36	38	73,2	0,8	6	1
4.5	MS0450-SSA	-3	Int.	Cylindrical	66	13,5	24	30	65,2	0,8	6	1
	MS0450-SLA	-5	Int.	Cylindrical	74	22,5	36	38	73,2	0,8	6	1
5.0	MS0500-SSA	-3	Int.	Cylindrical	66	15	28	30	65,1	0,9	6	1
	MS0500-SLA	-5	Int.	Cylindrical	82	25	44	46	81,1	0,9	6	1
5.1	MS0510-SSA	-3	Int.	Cylindrical	66	15,3	28	30	65,1	0,9	6	1
	MS0510-SLA	-5	Int.	Cylindrical	82	25,5	44	46	81,1	0,9	6	1
5.5	MS0550-SSA	-3	Int.	Cylindrical	66	16,5	28	30	65	1	6	1
	MS0550-SLA	-5	Int.	Cylindrical	82	27,5	44	46	81	1	6	1
6.0	MS0600-SSA	-3	Int.	Cylindrical	66	18	28	30	64,9	1,1	6	1
	MS0600-SLA	-5	Int.	Cylindrical	82	30	44	46	80,9	1,1	6	1
6.5	MS0650-SSA	-3	Int.	Cylindrical	79	19,5	34	43	77,8	1,2	8	1
	MS0650-SLA	-5	Int.	Cylindrical	91	32,5	53	55	89,8	1,2	8	1
6.9	MS0690-SSA	-3	Int.	Cylindrical	79	20,7	34	43	77,7	1,3	8	1
	MS0690-SLA	-5	Int.	Cylindrical	91	34,5	53	55	89,7	1,3	8	1
7.0	MS0700-SSA	-3	Int.	Cylindrical	79	21	34	43	77,7	1,3	8	1
	MS0700-SLA	-5	Int.	Cylindrical	91	35	53	55	89,7	1,3	8	1
7.5	MS0750-SSA	-3	Int.	Cylindrical	79	22,5	41	43	77,6	1,4	8	1
	MS0750-SLA	-5	Int.	Cylindrical	91	37,5	53	55	89,6	1,4	8	1
8.0	MS0800-SSA	-3	Int.	Cylindrical	79	24	41	43	77,5	1,5	8	1
	MS0800-SLA	-5	Int.	Cylindrical	91	40	53	55	89,5	1,5	8	1
8.5	MS0850-SSA	-3	Int.	Cylindrical	88	25,5	46	48	86,5	1,5	10	1
	MS0850-SLA	-5	Int.	Cylindrical	102	42,5	60	62	100,5	1,5	10	1
8.7	MS0870-SSA	-3	Int.	Cylindrical	88	26,1	46	48	86,4	1,6	10	1
	MS0870-SLA	-5	Int.	Cylindrical	102	43,5	60	62	100,4	1,6	10	1
9.0	MS0900-SSA	-3	Int.	Cylindrical	88	27	46	48	86,4	1,6	10	1
	MS0900-SLA	-5	Int.	Cylindrical	102	45	60	62	100,4	1,6	10	1
10.0	MS1000-SSA	-3	Int.	Cylindrical	89	30	47	49	87,2	1,8	10	1
	MS1000-SLA	-5	Int.	Cylindrical	103	50	62	63	101,2	1,8	10	1

MS...S.. TYPE SOLID CARBIDE (INTERNAL COOLANT)

Workpiece	Condition	Tensile Strength N/mm ²	Hardness HB	ø1.0 – 1.9		ø2.0 – 2.9		ø3.0 – 5.9		ø6.0 – 9.9		ø10.0 – 14.0		
				Vc (m/min)	f (mm/rev)	Vc (m/min)	f (mm/rev)	Vc (m/min)	f (mm/rev)	Vc (m/min)	f (mm/rev)	Vc (m/min)	f (mm/rev)	
P	Un-alloyed Sulphur ≤0.25%C	annealed	<500	150	70	0.20	70	0.20	100	0.18	110	0.25	130	0.30
	Phosphour Steel ≤0.25%C	annealed	<680	200	60	0.20	60	0.20	100	0.18	110	0.25	130	0.30
	Carbon Steel ≤0.55%C	tempered	>800	275	60	0.15	60	0.15	80	0.18	90	0.25	100	0.30
	Tempered Steel ≤0.55%C	annealed	<680	300	50	0.10	50	0.10	60	0.18	70	0.25	80	0.30
	Die Steel / Cast Steel	tempered	>800	350	40	0.08	40	0.08	50	0.15	60	0.20	70	0.25
	Low Alloy Steel, Die Steel	annealed	<680	<200	60	0.20	60	0.20	50	0.18	80	0.25	80	0.30
	Spring Steel, Nitrided Steel	tempered	850	250	60	0.15	60	0.15	60	0.18	70	0.25	80	0.30
	Case Hardened Steel	tempered	>850	>250	60	0.15	60	0.15	60	0.18	70	0.25	80	0.30
	Bearing Steel, Cast Steel	tempered	>1000	>300	40	0.10	40	0.10	50	0.15	60	0.20	70	0.30
	High Alloy Heat Resistent Steels	annealed	<680	<200	60	0.20	60	0.20	50	0.15	55	0.20	60	0.25
	Valve Steel	tempered	850	250	60	0.15	60	0.15	45	0.15	50	0.20	55	0.25
	Die Steel	tempered	>850	>250	50	0.12	50	0.12	50	0.18	55	0.20	60	0.25
Cast Steel	tempered	>1000	>300	40	0.10	40	0.10	45	0.15	50	0.20	55	0.25	
M	Stainless Steel	ferrit./mart.	680	200	40	0.05	40	0.08	45	0.15	50	0.20	60	0.25
	Heat Resistant Steel	martensitic	850	250	40	0.05	40	0.08	45	0.15	50	0.20	60	0.25
	Cast Steel	austenitic	<950	230	40	0.05	40	0.08	45	0.15	50	0.20	60	0.25
K	Laminated Graphite	ferritic	100 - 400	<180	70	0.15	80	0.20	100	0.20	100	0.25	110	0.30
	Cast Iron	pearlitic		220	60	0.10	70	0.15	90	0.20	90	0.25	100	0.30
	Spheroidal Cast Iron	ferritic	400 - 800	<180	40	0.10	50	0.15	80	0.20	80	0.25	90	0.30
	Ductile Cast Iron	pearlitic		250	30	0.05	40	0.10	80	0.20	80	0.25	90	0.30
	Tempered and Black	ferritic	350 - 700	<180	40	0.10	50	0.15	50	0.20	65	0.20	75	0.25
	Cast Iron	pearlitic		220	30	0.05	40	0.10	50	0.15	60	0.20	70	0.22

NOTES

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