



12xd IK with Double Margin

With Coolant

Material Group:

P K



12xd



140°±1°

$d_1 : m_7$

$d_2 : h_6$

$l_1 : \pm 0.8$

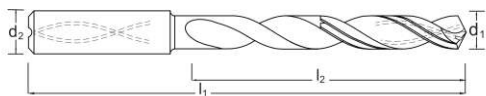
AlCrN

MG

HRC ≤38



Pg: 116



Tolerances

Diameter	d1	d2	l1
3.00	-0.010	0.000/-0.008	± 0.8
3.1-6.0	-0.012	0.000/-0.008	± 0.8
6.1-10.0	-0.015	0.000/-0.009	± 0.8
10.1-12.0	-0.018	0.000/-0.011	± 0.8

HB / HE Shank (Series: DDDA.01221/ 1222)  
Available on request.

1210- Metric

d <sub>1</sub> mm	d <sub>2</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Stock	HA Alcrona Item Code
9.40	10	95	142	<input type="checkbox"/>	DDDA 1220 0940
9.50	10	95	142	<input type="checkbox"/>	DDDA 1220 0950
9.60	10	95	142	<input type="checkbox"/>	DDDA 1220 0960
9.80	10	95	142	<input type="checkbox"/>	DDDA 1220 0980
9.90	10	95	142	<input type="checkbox"/>	DDDA 1220 0990
10.00	10	95	142	<input type="checkbox"/>	DDDA 1220 1000
10.10	12	114	162	<input type="checkbox"/>	DDDA 1220 1010
10.20	12	114	162	<input type="checkbox"/>	DDDA 1220 1020
10.30	12	114	162	<input type="checkbox"/>	DDDA 1220 1030
10.32	12	114	162	<input type="checkbox"/>	DDDA 1220 1032
10.40	12	114	162	<input type="checkbox"/>	DDDA 1220 1040
10.50	12	114	162	<input type="checkbox"/>	DDDA 1220 1050
10.60	12	114	162	<input type="checkbox"/>	DDDA 1220 1060
10.70	12	114	162	<input type="checkbox"/>	DDDA 1220 1070

d <sub>1</sub> mm	d <sub>2</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Stock	HA Alcrona Item Code
10.80	12	114	162	<input type="checkbox"/>	DDDA 1220 1080
10.90	12	114	162	<input type="checkbox"/>	DDDA 1220 1090
11.00	12	114	162	<input type="checkbox"/>	DDDA 1220 1100
11.10	12	114	162	<input type="checkbox"/>	DDDA 1220 1110
11.20	12	114	162	<input type="checkbox"/>	DDDA 1220 1120
11.30	12	114	162	<input type="checkbox"/>	DDDA 1220 1130
11.40	12	114	162	<input type="checkbox"/>	DDDA 1220 1140
11.50	12	114	162	<input type="checkbox"/>	DDDA 1220 1150
11.60	12	114	162	<input type="checkbox"/>	DDDA 1220 1160
11.70	12	114	162	<input type="checkbox"/>	DDDA 1220 1170
11.80	12	114	162	<input type="checkbox"/>	DDDA 1220 1180
11.90	12	114	162	<input type="checkbox"/>	DDDA 1220 1190
12.00	12	114	162	<input type="checkbox"/>	DDDA 1220 1200



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$d_2 : h_6$

$l_1 : \pm 0.8$

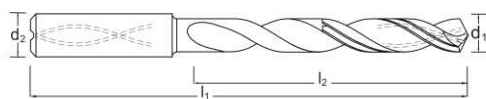
AlCrN

MG

HRC ≤38



Pg: 116



Tolerances

Diameter	d1	d2	l1
3.00	-0.010	0.000/-0.008	± 0.8
3.1-6.0	-0.012	0.000/-0.008	± 0.8
6.1-10.0	-0.015	0.000/-0.009	± 0.8
10.1-12.0	-0.018	0.000/-0.011	± 0.8

HB / HE Shank (Series: DDDA.01221/ 1222)  
Available on request.

1210- Metric

d <sub>1</sub> mm	d <sub>2</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Stock	HA Alcrona Item Code
9.40	10	95	142	<input type="checkbox"/>	DDDA 1220 0940
9.50	10	95	142	<input type="checkbox"/>	DDDA 1220 0950
9.60	10	95	142	<input type="checkbox"/>	DDDA 1220 0960
9.80	10	95	142	<input type="checkbox"/>	DDDA 1220 0980
9.90	10	95	142	<input type="checkbox"/>	DDDA 1220 0990
10.00	10	95	142	<input type="checkbox"/>	DDDA 1220 1000
10.10	12	114	162	<input type="checkbox"/>	DDDA 1220 1010
10.20	12	114	162	<input type="checkbox"/>	DDDA 1220 1020
10.30	12	114	162	<input type="checkbox"/>	DDDA 1220 1030
10.32	12	114	162	<input type="checkbox"/>	DDDA 1220 1032
10.40	12	114	162	<input type="checkbox"/>	DDDA 1220 1040
10.50	12	114	162	<input type="checkbox"/>	DDDA 1220 1050
10.60	12	114	162	<input type="checkbox"/>	DDDA 1220 1060
10.70	12	114	162	<input type="checkbox"/>	DDDA 1220 1070

d <sub>1</sub> mm	d <sub>2</sub> mm	l <sub>2</sub> mm	l <sub>1</sub> mm	Stock	HA Alcrona Item Code
10.80	12	114	162	<input type="checkbox"/>	DDDA 1220 1080
10.90	12	114	162	<input type="checkbox"/>	DDDA 1220 1090
11.00	12	114	162	<input type="checkbox"/>	DDDA 1220 1100
11.10	12	114	162	<input type="checkbox"/>	DDDA 1220 1110
11.20	12	114	162	<input type="checkbox"/>	DDDA 1220 1120
11.30	12	114	162	<input type="checkbox"/>	DDDA 1220 1130
11.40	12	114	162	<input type="checkbox"/>	DDDA 1220 1140
11.50	12	114	162	<input type="checkbox"/>	DDDA 1220 1150
11.60	12	114	162	<input type="checkbox"/>	DDDA 1220 1160
11.70	12	114	162	<input type="checkbox"/>	DDDA 1220 1170
11.80	12	114	162	<input type="checkbox"/>	DDDA 1220 1180
11.90	12	114	162	<input type="checkbox"/>	DDDA 1220 1190
12.00	12	114	162	<input type="checkbox"/>	DDDA 1220 1200

# APPLICATION PARAMETERS



## Duronto Drills 8xd with Coolant

Material	Tensile Strength	Hardness	Dia	Vc (m/min)			f (mm/min)
				Min	Ideal	Max	
Steels	> 400 ≤ 750	≤ 20	3.00-5.60	80	90	100	0.14
			5.70-8.30	80	90	100	0.20
			8.40-11.5	80	90	100	0.30
			12.0-16.0	80	90	100	0.35
			16.5-20.0	80	90	100	0.37
Steels	> 750 ≤ 900	≤ 28	3.00-5.60	70	80	90	0.12
			5.70-8.30	70	80	90	0.20
			8.40-11.5	70	80	90	0.27
			12.0-16.0	70	80	90	0.32
			16.5-20.0	70	80	90	0.35
Steels	> 900 ≤ 1100	≤ 38	3.00-5.60	40	50	60	0.10
			5.70-8.30	40	50	60	0.15
			8.40-11.5	40	50	60	0.26
			12.0-16.0	40	50	60	0.31
			16.5-20.0	40	50	60	0.34
Steels	≤ 1400	≤ 45	3.00-5.60	30	35	40	0.10
			5.70-8.30	30	35	40	0.15
			8.40-11.5	30	35	40	0.15
			12.0-16.0	30	35	40	0.20
			16.5-20.0	30	35	40	0.22
Cast Irons	240 HB		3.00-5.60	60	70	80	0.18
			5.70-8.30	60	70	80	0.25
			8.40-11.5	60	70	80	0.36
			12.0-16.0	60	70	80	0.38
			16.5-20.0	60	70	80	0.38

## Duronto Drills 12xd with Coolant

Material	Tensile Strength	Hardness	Dia	Vc (m/min)			f (mm/min)
				Min	Ideal	Max	
Steels	> 400 ≤ 750	≤ 20	3.00-6.00	70	80	90	0.14
			6.1-8.50	70	80	90	0.20
			8.6-10.00	70	80	90	0.28
			10.1-12.0	70	80	90	0.36
Steels	> 750 ≤ 900	≤ 28	3.00-6.00	70	80	90	0.12
			6.1-8.50	70	80	90	0.18
			8.6-10.00	70	80	90	0.25
			10.1-12.0	70	80	90	0.32
Steels	> 900 ≤ 1100	≤ 38	3.00-6.00	40	50	60	0.10
			6.1-8.50	40	50	60	0.15
			8.6-10.00	40	50	60	0.20
			10.1-12.0	40	50	60	0.26
Steels	≤ 1400	≤ 45	3.00-6.00	25	30	35	0.10
			6.1-8.50	25	30	35	0.15
			8.6-10.00	25	30	35	0.20
			10.1-12.0	25	30	35	0.26
Cast Iron	240 HB		3.00-6.00	60	70	80	0.18
			6.1-8.50	60	70	80	0.24
			8.6-10.00	60	70	80	0.30
			10.1-12.0	60	70	80	0.35