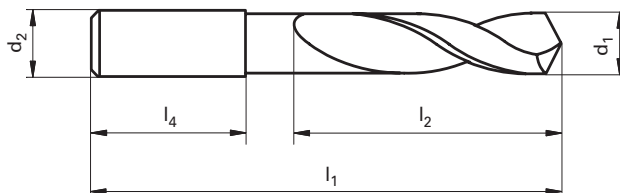


# Carbide twist drills (Ratio drills)

## Carbide twist drills (Ratio drills) DIN 6537

Applies to solid carbide twist drills with 2 or 3 cutting edges and straight shank to DIN 6535

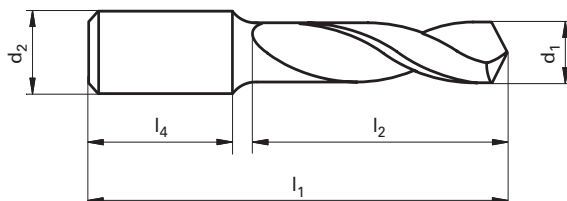


Dimensions in mm

nom. Ø-range up to d1m7	shank Ø d2h6	Ratio drills for 3 x D		Ratio drills for 5 x D		shank length l4
		overall length l1	max. flute length l2	overall length l1	max. flute length l2	
2.9...3.75	6	62	20	66	28	36
4.75	6	66	24	74	36	36
6.00	6	66	28	82	44	36
7.00	8	79	34	91	53	36
8.00	8	79	41	91	53	36
10.00	10	89	47	103	61	40
12.00	12	102	55	118	71	45
14.00	14	107	60	124	77	45
16.00	16	115	65	133	83	48
18.00	18	123	73	143	93	48
20.00	20	131	79	153	101	50

## Carbide twist drills (Ratio drills) DIN 6538

Applies to twist drills with brazed carbide tip or head with reinforced straight shank (steel) to DIN 6535. The brazed head can be a part or the complete cutting portion.



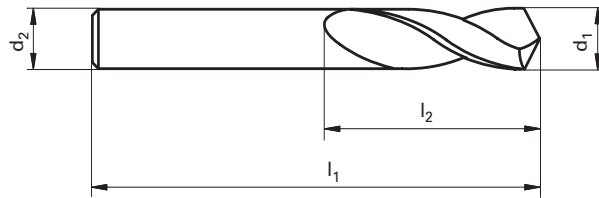
Dimensions in mm

nom. Ø-range up to d1h7	shank Ø d2h6	Ratio drills for 3 x D		Ratio drills for 5 x D		Ratio drills for 7 x D		shank length l4
		overall length l1	max. flute length l2	overall length l1	max. flute length l2	overall length l1	max. flute length l2	
9.5...12.0	16	103	51	127	75	151	99	48
14.0	16	111	59	139	87	167	115	48
16.0	20	122	68	154	100	186	132	50
18.0	20	130	76	166	112	202	148	50
20.0	25	144	84	184	124	224	164	56
22.0	25	153	93	197	137	241	181	56
24.0	25	161	101	209	149	257	197	56
26.0	32	174	110	226	162	278	214	60
28.0	32	182	118	238	174	294	230	60
30.0	32	190	126	250	186	310	246	60

# Carbide twist drills (Ratio drills)

## Carbide twist drills (Ratio drills) DIN 6539

Applies to solid carbide twist drills with parallel shank, i.e. equal nom. drill and shank diameter.



Dimensions in mm

nom. Ø-range up to (= shank Ø $d_2$ ) $d_1$	overall length		flute length	
	$l_1$	$l_2$	$l_1$	$l_2$
1.90...2.12	38	12	38	12
2.36	40	13	40	13
2.65	43	14	43	14
3.00	46	16	46	16
3.35	49	18	49	18
3.75	52	20	52	20
4.25	55	22	55	22
4.75	58	24	58	24
5.30	62	26	62	26
6.00	66	28	66	28
6.70	70	31	70	31
7.50	74	34	74	34
8.00	79	37	79	37
8.50	79	37	79	37
9.50	84	40	84	40

nom. Ø-range up to (= shank Ø $d_2$ ) $d_1$	overall length		flute length	
	$l_1$	$l_2$	$l_1$	$l_2$
10.00	89	43	89	43
10.60	89	43	89	43
11.80	95	47	95	47
12.00	102	51	102	51
13.20	102	51	102	51
14.00	107	54	107	54
15.00	111	56	111	56
16.00	115	58	115	58
17.00	119	60	119	60
18.00	123	62	123	62
19.00	127	64	127	64
20.00	131	66	131	66