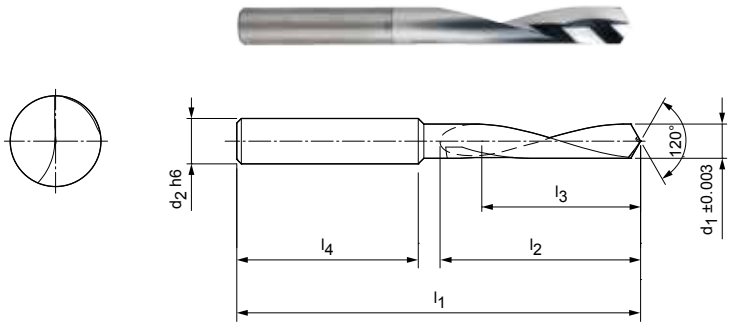
Mono-Drill-Plastic

5xD, external cooling
M2955

Design:

Drill diameter:	0,97 – 13,03 mm
Bore tolerance:	≥ IT 7
Coating:	Uncoated
Number of cutting edges:	1
Number of guiding chamfers:	1
Point geometry:	Specific geometry
Point angle:	120°



P 1 2 3 4 5 6 M 1 2 3 K 1 2 3 N 1 2 3 4 S 1 2 3 4 5 H 1 2 C 1 2 3 4 5

Expert LINE | HA DIN 6535 | 5xD

Dimensions						Specification	Order No.
d_1 (±0,003)	d_2 h6	l_1	l_2	l_3	l_4		
0,97	3	45	7	6	31	M2955-0097AU	30658297
0,98	3	45	7	6	31	M2955-0098AU	30658298
0,99	3	45	7	6	31	M2955-0099AU	30658299
1,00	3	45	7	6	31	M2955-0100AU	30658300
1,01	3	45	7	6	31	M2955-0101AU	30658301
1,02	3	45	7	6	31	M2955-0102AU	30658302
1,03	3	45	7	6	31	M2955-0103AU	30658303
1,97	3	50	14	11	31	M2955-0197AU	30658304
1,98	3	50	14	11	31	M2955-0198AU	30658305
1,99	3	50	14	11	31	M2955-0199AU	30658306
2,00	3	50	14	11	31	M2955-0200AU	30658307
2,01	3	50	14	11	31	M2955-0201AU	30658308
2,02	3	50	14	11	31	M2955-0202AU	30658309
2,03	3	50	14	11	31	M2955-0203AU	30658310
2,97	4	66	28	23	36	M2955-0297AU	30658311
2,98	4	66	28	23	36	M2955-0298AU	30658312
2,99	4	66	28	23	36	M2955-0299AU	30658313
3,00	4	66	28	23	36	M2955-0300AU	30658314
3,01	4	66	28	23	36	M2955-0301AU	30658315
3,02	4	66	28	23	36	M2955-0302AU	30658316
3,03	4	66	28	23	36	M2955-0303AU	30658317
3,97	4	74	36	29	36	M2955-0397AU	30658318
3,98	4	74	36	29	36	M2955-0398AU	30658319
3,99	4	74	36	29	36	M2955-0399AU	30658320
4,00	4	74	36	29	36	M2955-0400AU	30658321
4,01	4	74	36	29	36	M2955-0401AU	30658322
4,02	4	74	36	29	36	M2955-0402AU	30658323
4,03	4	74	36	29	36	M2955-0403AU	30658324
4,97	6	82	44	35	36	M2955-0497AU	30658325
4,98	6	82	44	35	36	M2955-0498AU	30658326
4,99	6	82	44	35	36	M2955-0499AU	30658327
5,00	6	82	44	35	36	M2955-0500AU	30658328
5,01	6	82	44	35	36	M2955-0501AU	30658329
5,02	6	82	44	35	36	M2955-0502AU	30658330
5,03	6	82	44	35	36	M2955-0503AU	30658331
5,97	6	82	44	35	36	M2955-0597AU	30658332

Mono-Drill-Plastic | M2955, 5xD, external cooling

Dimensions						Specification	Order No.
d_1 (±0,003)	d_2 h6	l_1	l_2	l_3	l_4		
5,98	6	82	44	35	36	M2955-0598AU	30658333
5,99	6	82	44	35	36	M2955-0599AU	30658334
6,00	6	82	44	35	36	M2955-0600AU	30658335
6,01	6	82	44	35	36	M2955-0601AU	30658336
6,02	6	82	44	35	36	M2955-0602AU	30658337
6,03	6	82	44	35	36	M2955-0603AU	30658338
6,97	8	91	53	43	36	M2955-0697AU	30658339
6,98	8	91	53	43	36	M2955-0698AU	30658340
6,99	8	91	53	43	36	M2955-0699AU	30658341
7,00	8	91	53	43	36	M2955-0700AU	30658342
7,01	8	91	53	43	36	M2955-0701AU	30658343
7,02	8	91	53	43	36	M2955-0702AU	30658344
7,03	8	91	53	43	36	M2955-0703AU	30658345
7,97	8	91	53	43	36	M2955-0797AU	30658346
7,98	8	91	53	43	36	M2955-0798AU	30658347
7,99	8	91	53	43	36	M2955-0799AU	30658348
8,00	8	91	53	43	36	M2955-0800AU	30658349
8,01	8	91	53	43	36	M2955-0801AU	30658350
8,02	8	91	53	43	36	M2955-0802AU	30658351
8,03	8	91	53	43	36	M2955-0803AU	30658352
8,97	10	103	61	49	40	M2955-0897AU	30658353
8,98	10	103	61	49	40	M2955-0898AU	30658354
8,99	10	103	61	49	40	M2955-0899AU	30658355
9,00	10	103	61	49	40	M2955-0900AU	30658356
9,01	10	103	61	49	40	M2955-0901AU	30658357
9,02	10	103	61	49	40	M2955-0902AU	30658358
9,03	10	103	61	49	40	M2955-0903AU	30658359
9,97	10	103	61	49	40	M2955-0997AU	30658360
9,98	10	103	61	49	40	M2955-0998AU	30658361
9,99	10	103	61	49	40	M2955-0999AU	30658362
10,00	10	103	61	49	40	M2955-1000AU	30658363
10,01	10	103	61	49	40	M2955-1001AU	30658364
10,02	10	103	61	49	40	M2955-1002AU	30658365
10,03	10	103	61	49	40	M2955-1003AU	30658366
10,97	12	118	71	56	45	M2955-1097AU	30658367
10,98	12	118	71	56	45	M2955-1098AU	30658368
10,99	12	118	71	56	45	M2955-1099AU	30658369
11,00	12	118	71	56	45	M2955-1100AU	30658370
11,01	12	118	71	56	45	M2955-1101AU	30658371
11,02	12	118	71	56	45	M2955-1102AU	30658372
11,03	12	118	71	56	45	M2955-1103AU	30658373
11,97	12	118	71	56	45	M2955-1197AU	30658374
11,98	12	118	71	56	45	M2955-1198AU	30658375
11,99	12	118	71	56	45	M2955-1199AU	30658376
12,00	12	118	71	56	45	M2955-1200AU	30658377
12,01	12	118	71	56	45	M2955-1201AU	30658378
12,02	12	118	71	56	45	M2955-1202AU	30658379
12,03	12	118	71	56	45	M2955-1203AU	30658380
12,97	14	124	77	60	45	M2955-1297AU	30658381
12,98	14	124	77	60	45	M2955-1298AU	30658382
12,99	14	124	77	60	45	M2955-1299AU	30658383
13,00	14	124	77	60	45	M2955-1300AU	30658384
13,01	14	124	77	60	45	M2955-1301AU	30658385
13,02	14	124	77	60	45	M2955-1302AU	30658386
13,03	14	124	77	60	45	M2955-1303AU	30658387

Dimensions in mm.
Cutting data recommendations from page 272.
Special designs and other coatings on request.

Cutting data recommendation for solid carbide drills

Feed and cutting speed

Mono-Drill-Plastic | M2955

MMG*			Material	Tensile strength/Hardness [N/mm²] [HRC]	
N	N1	N1.1	Aluminium, non-alloyed and alloyed <3% Si		
		N1.2	Aluminium, alloyed ≤7% Si		
		N1.3	Aluminium, alloyed > 7-12% Si		
		N1.4	Aluminium, alloyed > 12% Si		
	N2	N2.1	Copper, non-alloyed and low alloyed	< 300 N/mm²	
		N2.2	Copper, alloyed	> 300 N/mm²	
		N2.3	Brass, bronze, gun metal	< 1200 N/mm²	
	N3	N3.1	Graphite		
	N4	N4.1	Plastic, thermoplastic		
		N4.2	Plastic, thermosetting plastic (duroplast)		
		N4.3	Plastic, foam		
C	C1	C1.1	Plastic matrix, aramid fibre reinforced plastic (AFK)		
		C1.2	Plastic matrix (thermosetting), CFRP/GFRP		
		C1.3	Plastic matrix (thermoplastic), CFRP/GFRP		
	C2	C2.1	Carbon matrix, carbon fibre reinforced (CFC)		
	C3	C3.1	Metal matrix (MMC)		
	C4	C4.1	Sandwich construction, honeycomb core of paper		
		C4.2	Sandwich construction, honeycomb core of aluminium		
		C4.3	Sandwich construction, honeycomb core of plastic and fibre composite materials		
		C4.4	Sandwich construction, core of rigid foam		
	C5	C5.1	Stack (hybrid structure) CFRP-aluminium		
		C5.2	Stack (hybrid structure) CFRP-titanium/stainless steel		

* MILLER machining groups

	Cutting speed v_c [m/min]				Feed f [mm] with drill diameter					
	Internal cooling	External cooling	MQL	Air	3	4,5	6,5	9,5	14,0	20
		60		50	0,05	0,06	0,08	0,11	0,15	0,21
		65		40	0,04	0,05	0,06	0,08	0,12	0,17
				55	0,03	0,03	0,04	0,05	0,06	0,08

The cutting data recommendations shown, are guidelines.
The best data for the machining task in question should be calculated during trials or during the machining operation.