

SU(K) drill 3xD

General machining

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

1534SU03/1534SU03C



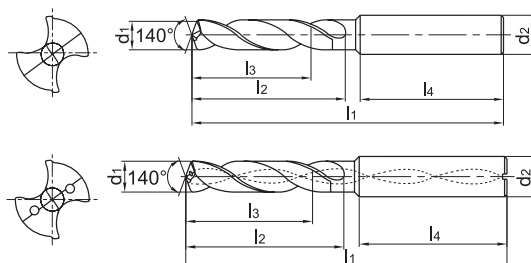
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade	
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303	
1534SU03-0090S		0.9	4	47	4.2	3.4	37.9	○	
1534SU03-0100S		1	4	47	4.7	3.8	37.6	●	
1534SU03-0105S		1.05	4	47	4.9	3.9	37.5	●	
1534SU03-0110S		1.1	4	47	5.2	4.1	37.2	○	
1534SU03-0115S		1.15	4	47	5.4	4.3	37.1	○	
1534SU03-0120S		1.2	4	47	5.6	4.5	37	●	
1534SU03-0125S		1.25	4	47	5.9	4.7	36.8	○	
1534SU03-0130S		1.3	4	47	6.1	4.9	36.6	●	
1534SU03-0135S		1.35	4	47	6.3	5.1	36.5	○	
1534SU03-0140S		1.4	4	47	6.6	5.3	36.3	○	
1534SU03-0145S		1.45	4	47	6.8	5.4	36.2	○	
1534SU03-0147S		1.47	4	47	6.9	5.5	36.1	●	
1534SU03-0150S		1.5	4	47	7.1	5.6	36	●	
1534SU03-0155S		1.55	4	47	7.3	5.8	35.8	○	
1534SU03-0160S		1.6	4	47	7.5	6	35.7	●	
1534SU03-0165S		1.65	4	47	7.8	6.2	35.5	○	
1534SU03-0170S		1.7	4	47	8	6.4	35.4	●	
1534SU03-0175S		1.75	4	47	8.2	6.6	35.2	○	
1534SU03-0180S		1.8	4	47	8.5	6.8	35	●	
1534SU03-0185S		1.85	4	47	8.7	6.9	34.9	○	
1534SU03-0190S		1.9	4	47	8.9	7.1	34.8	●	
1534SU03-0195S		1.95	4	47	9.2	7.3	34.5	○	
1534SU03-0200		2	6	62	20	14	36	●	
1534SU03-0210		2.1	6	62	20	14	36	●	
1534SU03-0220		2.2	6	62	20	14	36	●	
1534SU03-0230		2.3	3	59	13.8	14	36	●	
1534SU03-0240		2.4	6	62	20	14	36	●	
1534SU03-0250		2.5	6	62	20	14	36	●	
1534SU03-0260		2.6	6	62	20	14	36	●	
1534SU03-0270		2.7	6	62	20	14	36	●	
1534SU03-0280		2.8	6	62	20	14	36	●	

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C28

Machining instructions > C165

Cutting data > C122

Nonstandard order > C177

SU(K) drill 3xD**General machining****Add K (SUK) to the code for use on Cast Iron****1534SU03/1534SU03C**

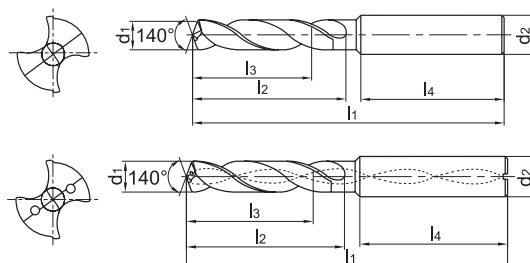
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-0290		2.9	6	62	20	14	36	●
1534SU03-0300		3	6	62	20	14	36	●
1534SU03C-0300	*	3	6	62	20	14	36	●
1534SU03-0310		3.1	6	62	20	14	36	●
1534SU03C-0310	*	3.1	6	62	20	14	36	●
1534SU03-0320		3.2	6	62	20	14	36	●
1534SU03C-0320	*	3.2	6	62	20	14	36	●
1534SU03-0325		3.25	6	62	20	14	36	●
1534SU03C-0325	*	3.25	6	62	20	14	36	●
1534SU03-0330		3.3	6	62	20	14	36	●
1534SU03C-0330	*	3.3	6	62	20	14	36	●
1534SU03-0340		3.4	6	62	20	14	36	●
1534SU03C-0340	*	3.4	6	62	20	14	36	●
1534SU03-0350		3.5	6	62	20	14	36	●
1534SU03C-0350	*	3.5	6	62	20	14	36	●
1534SU03-0360		3.6	6	62	20	14	36	●
1534SU03C-0360	*	3.6	6	62	20	14	36	●
1534SU03-0370		3.7	6	62	20	14	36	●
1534SU03C-0370	*	3.7	6	62	20	14	36	●
1534SU03-0380		3.8	6	66	24	17	36	●
1534SU03C-0380	*	3.8	6	66	24	17	36	●
1534SU03-0390		3.9	6	66	24	17	36	●
1534SU03C-0390	*	3.9	6	66	24	17	36	●
1534SU03-0400		4	6	66	24	17	36	●
1534SU03C-0400	*	4	6	66	24	17	36	●
1534SU03-0410		4.1	6	66	24	17	36	●
1534SU03C-0410	*	4.1	6	66	24	17	36	●
1534SU03-0420		4.2	6	66	24	17	36	●
1534SU03C-0420	*	4.2	6	66	24	17	36	●
1534SU03-0430		4.3	6	66	24	17	36	●
1534SU03C-0430	*	4.3	6	66	24	17	36	●

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Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

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SU(K) drill 3xD

General machining

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1534SU03/1534SU03C



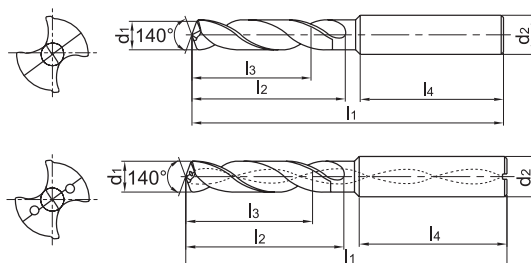
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade	
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303	
1534SU03-0440		4.4	6	66	24	17	36	●	
1534SU03C-0440	*	4.4	6	66	24	17	36	●	
1534SU03-0450		4.5	6	66	24	17	36	●	
1534SU03C-0450	*	4.5	6	66	24	17	36	●	
1534SU03-0460		4.6	6	66	24	17	36	●	
1534SU03C-0460	*	4.6	6	66	24	17	36	●	
1534SU03-0465		4.65	6	66	24	17	36	●	
1534SU03C-0465	*	4.65	6	66	24	17	36	●	
1534SU03-0470		4.7	6	66	24	17	36	●	
1534SU03C-0470	*	4.7	6	66	24	17	36	●	
1534SU03-0480		4.8	6	66	28	20	36	●	
1534SU03C-0480	*	4.8	6	66	28	20	36	●	
1534SU03-0490		4.9	6	66	28	20	36	●	
1534SU03C-0490	*	4.9	6	66	28	20	36	●	
1534SU03-0500		5	6	66	28	20	36	●	
1534SU03C-0500	*	5	6	66	28	20	36	●	
1534SU03-0510		5.1	6	66	28	20	36	●	
1534SU03C-0510	*	5.1	6	66	28	20	36	●	
1534SU03-0520		5.2	6	66	28	20	36	●	
1534SU03C-0520	*	5.2	6	66	28	20	36	●	
1534SU03-0530		5.3	6	66	28	20	36	●	
1534SU03C-0530	*	5.3	6	66	28	20	36	●	
1534SU03-0540		5.4	6	66	28	20	36	●	
1534SU03C-0540	*	5.4	6	66	28	20	36	●	
1534SU03-0550		5.5	6	66	28	20	36	●	
1534SU03C-0550	*	5.5	6	66	28	20	36	●	
1534SU03-0555		5.55	6	66	28	20	36	●	
1534SU03C-0555	*	5.55	6	66	28	20	36	●	
1534SU03-0560		5.6	6	66	28	20	36	●	
1534SU03C-0560	*	5.6	6	66	28	20	36	●	
1534SU03-0570		5.7	6	66	28	20	36	●	

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Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

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Nonstandard order > C177

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General machining
Add K (SUK) to the code for use on Cast Iron
1534SU03/1534SU03C

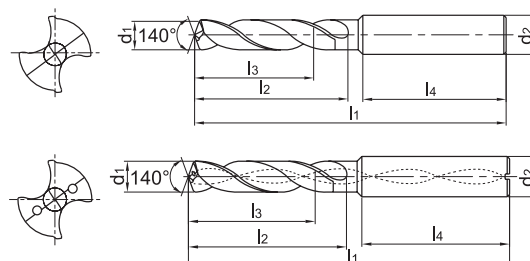

- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	
1534SU03C-0570	*	5.7	6	66	28	20	36	●
1534SU03-0580		5.8	6	66	28	20	36	●
1534SU03C-0580	*	5.8	6	66	28	20	36	●
1534SU03-0590		5.9	6	66	28	20	36	●
1534SU03C-0590	*	5.9	6	66	28	20	36	●
1534SU03-0600		6	6	66	28	20	36	●
1534SU03C-0600	*	6	6	66	28	20	36	●
1534SU03-0610		6.1	8	79	34	24	36	●
1534SU03C-0610	*	6.1	8	79	34	24	36	●
1534SU03-0620		6.2	8	79	34	24	36	●
1534SU03C-0620	*	6.2	8	79	34	24	36	●
1534SU03-0630		6.3	8	79	34	24	36	●
1534SU03C-0630	*	6.3	8	79	34	24	36	●
1534SU03-0640		6.4	8	79	34	24	36	●
1534SU03C-0640	*	6.4	8	79	34	24	36	●
1534SU03-0650		6.5	8	79	34	24	36	●
1534SU03C-0650	*	6.5	8	79	34	24	36	●
1534SU03-0660		6.6	8	79	34	24	36	●
1534SU03C-0660	*	6.6	8	79	34	24	36	●
1534SU03-0670		6.7	8	79	34	24	36	●
1534SU03C-0670	*	6.7	8	79	34	24	36	●
1534SU03-0675		6.75	8	79	34	24	36	●
1534SU03C-0675	*	6.75	8	79	34	24	36	●
1534SU03-0680		6.8	8	79	34	24	36	●
1534SU03C-0680	*	6.8	8	79	34	24	36	●
1534SU03-0690		6.9	8	79	34	24	36	●
1534SU03C-0690	*	6.9	8	79	34	24	36	●
1534SU03-0700		7	8	79	34	24	36	●
1534SU03C-0700	*	7	8	79	34	24	36	●
1534SU03-0710		7.1	8	79	41	29	36	●
1534SU03C-0710	*	7.1	8	79	41	29	36	●

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* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

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Machining instructions > C165

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SU(K) drill 3xD

General machining

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1534SU03/1534SU03C



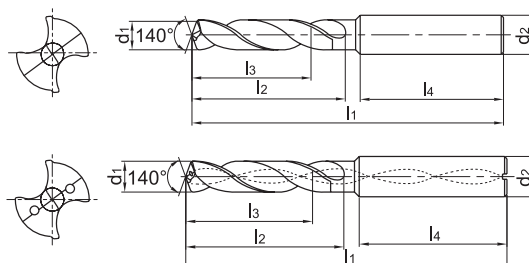
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade	
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303	
1534SU03-0720		7.2	8	79	41	29	36	●	
1534SU03C-0720	*	7.2	8	79	41	29	36	●	
1534SU03-0730		7.3	8	79	41	29	36	●	
1534SU03C-0730	*	7.3	8	79	41	29	36	●	
1534SU03-0740		7.4	8	79	41	29	36	●	
1534SU03C-0740	*	7.4	8	79	41	29	36	●	
1534SU03-0745		7.45	8	79	41	29	36	○	
1534SU03C-0745	*	7.45	8	79	41	29	36	○	
1534SU03-0750		7.5	8	79	41	29	36	●	
1534SU03C-0750	*	7.5	8	79	41	29	36	●	
1534SU03-0760		7.6	8	79	41	29	36	●	
1534SU03C-0760	*	7.6	8	79	41	29	36	●	
1534SU03-0770		7.7	8	79	41	29	36	●	
1534SU03C-0770	*	7.7	8	79	41	29	36	●	
1534SU03-0780		7.8	8	79	41	29	36	●	
1534SU03C-0780	*	7.8	8	79	41	29	36	●	
1534SU03-0790		7.9	8	79	41	29	36	●	
1534SU03C-0790	*	7.9	8	79	41	29	36	●	
1534SU03-0800		8	8	79	41	29	36	●	
1534SU03C-0800	*	8	8	79	41	29	36	●	
1534SU03-0810		8.1	10	89	47	35	40	●	
1534SU03C-0810	*	8.1	10	89	47	35	40	●	
1534SU03-0820		8.2	10	89	47	35	40	●	
1534SU03C-0820	*	8.2	10	89	47	35	40	●	
1534SU03-0830		8.3	10	89	47	35	40	●	
1534SU03C-0830	*	8.3	10	89	47	35	40	●	
1534SU03-0840		8.4	10	89	47	35	40	●	
1534SU03C-0840	*	8.4	10	89	47	35	40	●	
1534SU03-0850		8.5	10	89	47	35	40	●	
1534SU03C-0850	*	8.5	10	89	47	35	40	●	
1534SU03-0860		8.6	10	89	47	35	40	●	

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

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System code > C28

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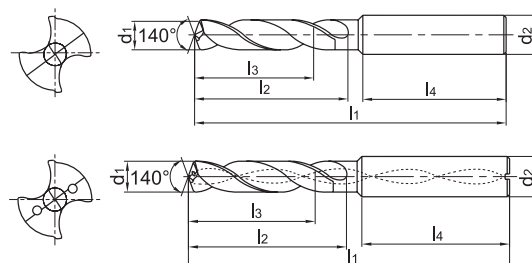

- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	
1534SU03C-0860	*	8.6	10	89	47	35	40	●
1534SU03-0870		8.7	10	89	47	35	40	●
1534SU03C-0870	*	8.7	10	89	47	35	40	●
1534SU03-0880		8.8	10	89	47	35	40	●
1534SU03C-0880	*	8.8	10	89	47	35	40	●
1534SU03-0890		8.9	10	89	47	35	40	●
1534SU03C-0890	*	8.9	10	89	47	35	40	●
1534SU03-0900		9	10	89	47	35	40	●
1534SU03C-0900	*	9	10	89	47	35	40	●
1534SU03-0910		9.1	10	89	47	35	40	●
1534SU03C-0910	*	9.1	10	89	47	35	40	●
1534SU03-0920		9.2	10	89	47	35	40	●
1534SU03C-0920	*	9.2	10	89	47	35	40	●
1534SU03-0930		9.3	10	89	47	35	40	●
1534SU03C-0930	*	9.3	10	89	47	35	40	●
1534SU03-0935		9.35	10	89	47	35	40	○
1534SU03C-0935	*	9.35	10	89	47	35	40	○
1534SU03-0940		9.4	10	89	47	35	40	●
1534SU03C-0940	*	9.4	10	89	47	35	40	●
1534SU03-0945		9.45	10	89	47	35	40	○
1534SU03C-0945	*	9.45	10	89	47	35	40	○
1534SU03-0950		9.5	10	89	47	35	40	●
1534SU03C-0950	*	9.5	10	89	47	35	40	●
1534SU03-0960		9.6	10	89	47	35	40	●
1534SU03C-0960	*	9.6	10	89	47	35	40	●
1534SU03-0970		9.7	10	89	47	35	40	●
1534SU03C-0970	*	9.7	10	89	47	35	40	●
1534SU03-0980		9.8	10	89	47	35	40	●
1534SU03C-0980	*	9.8	10	89	47	35	40	●
1534SU03-0990		9.9	10	89	47	35	40	●
1534SU03C-0990	*	9.9	10	89	47	35	40	●

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* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

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1534SU03/1534SU03C



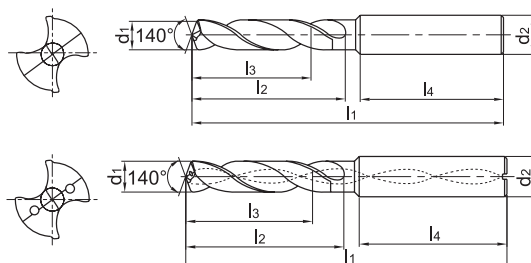
- Type of shank DIN 6535HA
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External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade	
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303	
1534SU03-1000		10	10	89	47	35	40	●	
1534SU03C-1000	*	10	10	89	47	35	40	●	
1534SU03-1010		10.1	12	102	55	40	45	●	
1534SU03C-1010	*	10.1	12	102	55	40	45	●	
1534SU03-1020		10.2	12	102	55	40	45	●	
1534SU03C-1020	*	10.2	12	102	55	40	45	●	
1534SU03-1025		10.25	12	102	55	40	45	●	
1534SU03C-1025	*	10.25	12	102	55	40	45	●	
1534SU03-1030		10.3	12	102	55	40	45	●	
1534SU03C-1030	*	10.3	12	102	55	40	45	●	
1534SU03-1040		10.4	12	102	55	40	45	●	
1534SU03C-1040	*	10.4	12	102	55	40	45	●	
1534SU03-1050		10.5	12	102	55	40	45	●	
1534SU03C-1050	*	10.5	12	102	55	40	45	●	
1534SU03-1060		10.6	12	102	55	40	45	●	
1534SU03C-1060	*	10.6	12	102	55	40	45	●	
1534SU03-1070		10.7	12	102	55	40	45	●	
1534SU03C-1070	*	10.7	12	102	55	40	45	●	
1534SU03-1080		10.8	12	102	55	40	45	●	
1534SU03C-1080	*	10.8	12	102	55	40	45	●	
1534SU03-1090		10.9	12	102	55	40	45	●	
1534SU03C-1090	*	10.9	12	102	55	40	45	●	
1534SU03-1100		11	12	102	55	40	45	●	
1534SU03C-1100	*	11	12	102	55	40	45	●	
1534SU03-1110		11.1	12	102	55	40	45	●	
1534SU03C-1110	*	11.1	12	102	55	40	45	●	
1534SU03-1120		11.2	12	102	55	40	45	●	
1534SU03C-1120	*	11.2	12	102	55	40	45	●	
1534SU03-1125		11.25	12	102	55	40	45	○	
1534SU03C-1125	*	11.25	12	102	55	40	45	○	
1534SU03-1130		11.3	12	102	55	40	45	●	

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C28

Machining instructions > C165

Cutting data > C122

Nonstandard order > C177

SU(K) drill 3xD**General machining****Add K (SUK) to the code for use on Cast Iron****1534SU03/1534SU03C**

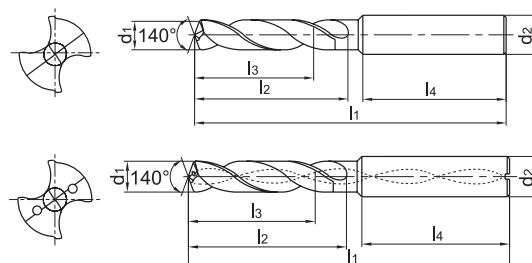
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade	
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303	
1534SU03C-1130	*	11.3	12	102	55	40	45	●	
1534SU03-1135		11.35	12	102	55	40	45	○	
1534SU03C-1135	*	11.35	12	102	55	40	45	○	
1534SU03-1140		11.4	12	102	55	40	45	●	
1534SU03C-1140	*	11.4	12	102	55	40	45	●	
1534SU03-1145		11.45	12	102	55	40	45	○	
1534SU03C-1145	*	11.45	12	102	55	40	45	○	
1534SU03-1150		11.5	12	102	55	40	45	●	
1534SU03C-1150	*	11.5	12	102	55	40	45	●	
1534SU03-1160		11.6	12	102	55	40	45	●	
1534SU03C-1160	*	11.6	12	102	55	40	45	●	
1534SU03-1170		11.7	12	102	55	40	45	●	
1534SU03C-1170	*	11.7	12	102	55	40	45	●	
1534SU03-1180		11.8	12	102	55	40	45	●	
1534SU03C-1180	*	11.8	12	102	55	40	45	●	
1534SU03-1190		11.9	12	102	55	40	45	●	
1534SU03C-1190	*	11.9	12	102	55	40	45	●	
1534SU03-1200		12	12	102	55	40	45	●	
1534SU03C-1200	*	12	12	102	55	40	45	●	
1534SU03-1210		12.1	14	107	60	43	45	●	
1534SU03C-1210	*	12.1	14	107	60	43	45	●	
1534SU03-1220		12.2	14	107	60	43	45	●	
1534SU03C-1220	*	12.2	14	107	60	43	45	●	
1534SU03-1225		12.25	14	107	60	43	45	●	
1534SU03C-1225	*	12.25	14	107	60	43	45	●	
1534SU03-1230		12.3	14	107	60	43	45	●	
1534SU03C-1230	*	12.3	14	107	60	43	45	●	
1534SU03-1250		12.5	14	107	60	43	45	●	
1534SU03C-1250	*	12.5	14	107	60	43	45	●	
1534SU03-1270		12.7	14	107	60	43	45	●	
1534SU03C-1270	*	12.7	14	107	60	43	45	●	

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C28

Machining instructions > C165

Cutting data > C122

Nonstandard order > C177



SU(K) drill 3xD

General machining

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

1534SU03/1534SU03C



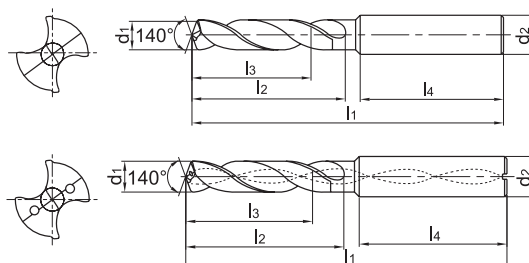
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade	
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303	
1534SU03-1275		12.75	14	107	60	43	45	●	
1534SU03C-1275	*	12.75	14	107	60	43	45	●	
1534SU03-1280		12.8	14	107	60	43	45	●	
1534SU03C-1280	*	12.8	14	107	60	43	45	●	
1534SU03-1300		13	14	107	60	43	45	●	
1534SU03C-1300	*	13	14	107	60	43	45	●	
1534SU03-1310		13.1	14	107	60	43	45	●	
1534SU03C-1310	*	13.1	14	107	60	43	45	●	
1534SU03-1335		13.35	14	107	60	43	45	○	
1534SU03C-1335	*	13.35	14	107	60	43	45	●	
1534SU03-1350		13.5	14	107	60	43	45	●	
1534SU03C-1350	*	13.5	14	107	60	43	45	●	
1534SU03-1380		13.8	14	107	60	43	45	●	
1534SU03C-1380	*	13.8	14	107	60	43	45	●	
1534SU03-1400		14	14	107	60	43	45	●	
1534SU03C-1400	*	14	14	107	60	43	45	●	
1534SU03-1420		14.2	16	107	60	43	45	●	
1534SU03C-1420	*	14.2	16	107	60	43	45	●	
1534SU03-1425		14.25	16	115	65	45	48	●	
1534SU03C-1425	*	14.25	16	115	65	45	48	●	
1534SU03-1430		14.3	16	115	65	45	48	●	
1534SU03C-1430	*	14.3	16	115	65	45	48	●	
1534SU03-1450		14.5	16	115	65	45	48	●	
1534SU03C-1450	*	14.5	16	115	65	45	48	●	
1534SU03-1475		14.75	16	115	65	45	48	●	
1534SU03C-1475	*	14.75	16	115	65	45	48	●	
1534SU03-1480		14.8	16	115	65	45	48	●	
1534SU03C-1480	*	14.8	16	115	65	45	48	●	
1534SU03-1500		15	16	115	65	45	48	●	
1534SU03C-1500	*	15	16	115	65	45	48	●	
1534SU03-1510		15.1	16	115	65	45	48	●	

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C28

Machining instructions > C165

Cutting data > C122

Nonstandard order > C177

SU(K) drill 3xD**General machining****Add K (SUK) to the code for use on Cast Iron****1534SU03/1534SU03C**

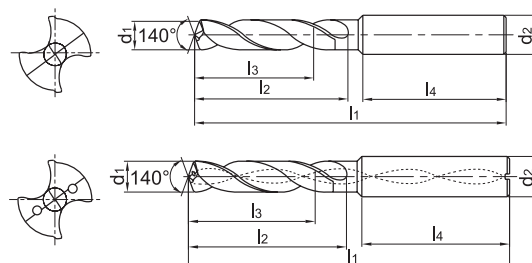
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03C-1510	*	15.1	16	115	65	45	48	●
1534SU03-1530		15.3	16	115	65	45	48	●
1534SU03-1535		15.35	16	115	65	45	48	○
1534SU03C-1535	*	15.35	16	115	65	45	48	○
1534SU03-1550		15.5	16	115	65	45	48	●
1534SU03C-1550	*	15.5	16	115	65	45	48	●
1534SU03-1580		15.8	16	115	65	45	48	●
1534SU03C-1580	*	15.8	16	115	65	45	48	●
1534SU03-1600		16	16	115	65	45	48	●
1534SU03C-1600	*	16	16	115	65	45	48	●
1534SU03-1610		16.1	18	123	73	51	48	●
1534SU03-1650		16.5	18	123	73	51	48	●
1534SU03C-1650	*	16.5	18	123	73	51	48	●
1534SU03-1675		16.75	18	123	73	51	48	●
1534SU03C-1675	*	16.75	18	123	73	51	48	●
1534SU03-1680		16.8	18	123	73	51	48	●
1534SU03C-1680	*	16.8	18	123	73	51	48	●
1534SU03-1700		17	18	123	73	51	48	●
1534SU03C-1700	*	17	18	123	73	51	48	●
1534SU03-1750		17.5	18	123	73	51	48	●
1534SU03C-1750	*	17.5	18	123	73	51	48	●
1534SU03-1780		17.8	18	123	73	51	48	●
1534SU03C-1780	*	17.8	18	123	73	51	48	●
1534SU03-1800		18	18	123	73	51	48	●
1534SU03C-1800	*	18	18	123	73	51	48	●
1534SU03-1850		18.5	20	131	79	55	50	●
1534SU03C-1850	*	18.5	20	131	79	55	50	●
1534SU03-1880		18.8	20	131	79	55	50	●
1534SU03C-1880	*	18.8	20	131	79	55	50	●
1534SU03-1900		19	20	131	79	55	50	●
1534SU03C-1900	*	19	20	131	79	55	50	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

System code > C28

Machining instructions > C165

Cutting data > C122

Nonstandard order > C177



SU(K) drill 3xD

General machining

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

1534SU03/1534SU03C



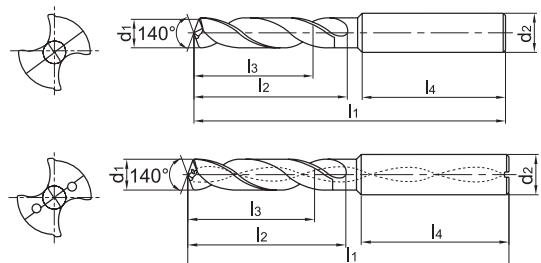
- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Internal coolant



Article		Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
1534SU03-1950		19.5	20	131	79	55	50	●
1534SU03C-1950	*	19.5	20	131	79	55	50	●
1534SU03-1980		19.8	20	131	79	55	50	●
1534SU03C-1980	*	19.8	20	131	79	55	50	●
1534SU03-2000		20	20	131	79	55	50	●
1534SU03C-2000	*	20	20	131	79	55	50	●

● Ex stock ○ On demand

All articles SUK on demand

* With internal cooling

Application field

Type	P	M	K	N	S	H
1534SU*	✓	✓	✓			
1534SUK*			✓			

✓ Very suitable

✓ Suitable

Solid carbide drills

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v _c [m/min]										
						SU Series			SU-Drill			SU Step Drill				
						3-5xD			8xD			3xD				
						KDG 303			KDG 303			KDG 303				
						Coolant										
internal	external	f-group	internal	external	f-group	internal	external	f-group								
P	Unalloyed steel	ca. 0,15 % C	annealed	125	1	150	135	8	135	125	7	150	135	8		
		ca. 0,45 % C	annealed	190	2	130	120	8	120	110	7	130	120	8		
		ca. 0,45 % C	tempered	250	3	120	110	6	110	100	5	120	110	6		
		ca. 0,75 % C	annealed	270	4	110	100	6	100	90	5	110	100	6		
		ca. 0,75 % C	tempered	300	5	100	90	6	90	85	5	100	90	6		
	Low-alloyed steel		annealed	180	6	130	120	8	120	110	7	130	120	8		
			tempered	275	7	110	100	6	100	90	5	110	100	6		
			tempered	300	8	100	90	6	90	85	5	100	90	6		
			tempered	350	9	90	85	6	85	80	5	90	85	6		
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	120	110	8	110	100	7	120	110	8		
		hardened and tempered	325	11	100	90	6	90	85	5	100	90	6			
M	Stainless steel	ferritic/martensitic	annealed	200	12	80	75	5	75	70	5	80	75	5		
		martensitic	tempered	240	13	55	50	5	50	45	5	55	50	5		
		austenitic	quench hardened	180	14	60	55	5	55	50	5	60	55	5		
		austenitic-ferritic		230	15	50	45	5	45	45	5	50	45	5		
K	Grey cast iron	perlitic/ferritic		180	16	135	125	8	125	115	7	135	125	8		
		perlitic (martensitic)		260	17	110	100	8	100	90	7	110	100	8		
	Cast iron with spheroidal graphite	ferritic		160	18	120	110	8	110	100	7	120	110	8		
		perlitic		250	19	80	75	8	75	70	7	80	75	8		
	Malleable cast iron	ferritic		130	20	130	120	8	120	110	7	130	120	8		
		perlitic		230	21	80	75	8	75	70	7	80	75	8		
N	Aluminium wrought alloys	cannot be hardened		60	22											
		hardenable	hardened	100	23											
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24											
		≤ 12 % Si, hardenable	hardened	90	25											
		> 12 % Si, cannot be hardened		130	26											
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27											
		CuZn, CuSnZn		90	28											
CuSn, Pb-free copper, electrolytic copper		100	29													
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30											
			hardened	280	31											
		Ni or Co bass	annealed	250	32											
			hardened	350	33											
			cast	320	34											
	Titanium alloys	pure titanium		R _m 400	35											
α and β alloys		hardened	R _m 1050	36												
H	Hardened steel		hardened and tempered	55 HRC	37											
			hardened and tempered	60 HRC	38											
	Hard cast iron		cast	400	39											
	Hardened cast iron		hardened and tempered	55 HRC	40											
X	Non-metallic materials	Thermoplasts			41											
		Thermosetting plastics			42											
		Plastic, glass-fibre reinforced GFRP			43											
		Plastic, carbon fibre reinforced CFRP			44											
		Graphite			45											
		Wood			46											

Note: The given cutting values are guide values, which were determined under ideal conditions.

The values have to be adapted in individual cases.

With hole depths of 5xD adjust the cutting data accordingly to the application.

f-group = feed rate recommendations on page C126.

For examples of material for cutting tool groups view page D22.

SU series

Twist drills for general applications

- For high-speed machining of steel and stainless steel.
- Longer tool life with AlTiN coating.
- Diameter range 0.9–20.0 mm (3xD, 5xD, 8xD)



S cut

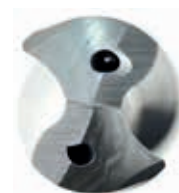
1538SU

SUK

DIN 1412 D

Twist drills for machining of cast iron

- Special cut for cast iron with ductile iron and malleable cast iron.
- Improved tool life due to impact resistant cutting edges.



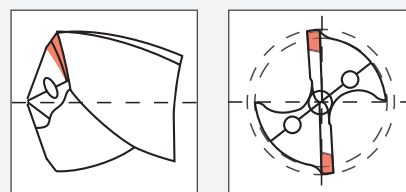
S cut

For cast iron



Twist drill

Form D: Cut for cast iron



All articles SUK on demand.

Please add K when ordering: 1534SUK03-0100

1 5 3 6 SU 05 C – 0850 (S)

1

2

3

4

5

6

7

8

9

Type

Code	Description
1	Drill

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

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

Application

Code	Description
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
ST	Twist drill for soft steel and stainless steel
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

5

L/D relation

Drill		Angle	
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		

6

With
inner
cooling

7

Bore diameter [mm]

Code	Description
0200	2.0
0850	8.5
1800	18.0
...	

8

Shank diameter [mm]

Code	Description
S	4.0

9

Machining operations

			
Boring	Drilling	Profile drilling	Centering

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.

Uncoated cemented carbide

Grade	Grade description
YK20F	Uncoated K20 carbide substrate for steel, cast iron and non ferrous materials.
YK30F	Uncoated K30 carbide substrate for steel, stainless steel, cast iron and non ferrous materials.

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

Index

	Products	Solid Carbide Drills	L/D	*	Ø	Application						Type	Page
						P	M	K	N	S	H		
SU	1534SU03		3xD		0.9-20	✓	✓	✓				Twist drills	C30
	1534SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C30
	1634SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C54
	1734SU03C		3xD	*	3-20	✓	✓	✓				Twist drills	C62
	1536SU05		5xD		2-20	✓	✓	✓				Twist drills	C41
	1536SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C41
	1636SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C58
	1736SU05C		5xD	*	3-20	✓	✓	✓				Twist drills	C66
	1538SU08C		8xD	*	3-18	✓	✓	✓				Twist drills	C51
	1557SU03		3xD		M4-M16	✓	✓	✓				Step drills	C70
SL SP	1588SL10C		10xD	*	3-14	✓	✓	✓	✓	✓		Deep hole drills	C72
	1588SL12C		12xD	*	3-21	✓	✓	✓	✓	✓		Deep hole drills	C75
	1588SL15C		15xD	*	3-12	✓	✓	✓	✓	✓		Deep hole drills	C79
	1588SL20C		20xD	*	3-14	✓	✓	✓	✓	✓		Deep hole drills	C82
	1588SL30C		30xD	*	3-10	✓	✓	✓	✓	✓		Deep hole drills	C85
	1534SP03C		3xD	*	3.03-20.03	✓	✓	✓	✓	✓		Pilot drills	C87
ST	1534ST03C		3xD	*	3-20	✓	✓			✓		Twist drills	C92
	1536ST05C		5xD	*	3-20	✓	✓			✓		Twist drills	C96
	1636ST05C		5xD	*	3-20	✓	✓			✓		Twist drills	C100
SH	1534SH03		3xD		3-16						✓	Twist drills	C106
SC	1105SC03		3xD		2-16				✓			Twist drills	C107
	1101SC05		5xD		2-16				✓			Twist drills	C110
PA	1165PA03		3xD		3-20				✓			Three-lips drills	C112
PC	1576PC05		5xD		4-20			✓				Straight flute drills	C116
	1576PC05C		5xD	*	4-20			✓				Straight flute drills	C116
	1579PC15C		15xD	*	5-14			✓				Straight flute drills	C118
SC*	1143SC90		-		5-20	✓	✓	✓	✓			Centuring drills	C119
	1143SC120		-	*	5-20	✓	✓	✓	✓			Centuring drills	C120

✓ Very suitable ✓ Suitable

* With internal cooling SC*: Centuring drills