2691LS-2691LSTH

LS type for deep holes, extra-long/1 (2691LS);
LS type for deep holes, PV15 coated, extra-long/1 (2691LSTH)

DIN 1869/1 | LS | HSS/Co BR | HSS/CO PV15 | 130° | 35-40°

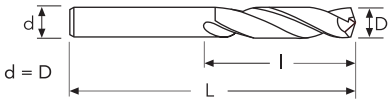
2691LS 2691LSTH

2691LS

2691LSTH

P	M	K	N	S	H
★	☆	★			

★ 1st choice ☆ suitable



						2691LS		2691LSTH	
D(h8)	D Tol.	d	l	L	PACKAGING	EDP No.	Stock	EDP No.	Stock
2.00	0/-0.014	2	85	125	10	P2691LS0200	●	P2691LSTH0200	●
2.50	0/-0.014	2.5	95	140	10	P2691LS0250	●	P2691LSTH0250	●
3.00	0/-0.014	3	100	150	10	P2691LS0300	●	P2691LSTH0300	●
3.50	0/-0.018	3.5	115	165	10	P2691LS0350	●	P2691LSTH0350	●
4.00	0/-0.018	4	120	175	10	P2691LS0400	●	P2691LSTH0400	●
4.50	0/-0.018	4.5	125	185	10	P2691LS0450	●	P2691LSTH0450	●
5.00	0/-0.018	5	135	195	10	P2691LS0500	●	P2691LSTH0500	●
5.50	0/-0.018	5.5	140	205	10	P2691LS0550	●	P2691LSTH0550	●
6.00	0/-0.018	6	140	205	10	P2691LS0600	●	P2691LSTH0600	●
6.50	0/-0.022	6.5	150	215	5	P2691LS0650	●	P2691LSTH0650	●
6.75	0/-0.022	6.75	155	225	5	P2691LS0675	●		
7.00	0/-0.022	7	155	225	5	P2691LS0700	●	P2691LSTH0700	●
7.50	0/-0.022	7.5	155	225	5	P2691LS0750	●	P2691LSTH0750	●
8.00	0/-0.022	8	165	240	5	P2691LS0800	●	P2691LSTH0800	●
8.50	0/-0.022	8.5	165	240	5	P2691LS0850	●	P2691LSTH0850	●
9.00	0/-0.022	9	175	250	5	P2691LS0900	●	P2691LSTH0900	●
9.50	0/-0.022	9.5	175	250	5	P2691LS0950	●	P2691LSTH0950	●
10.00	0/-0.022	10	185	265	5	P2691LS1000	●	P2691LSTH1000	●
10.50	0/-0.027	10.5	185	265	5	P2691LS1050	●	P2691LSTH1050	●
11.00	0/-0.027	11	195	280	5	P2691LS1100	●	P2691LSTH1100	●
11.50	0/-0.027	11.5	195	280	5	P2691LS1150	●	P2691LSTH1150	●
12.00	0/-0.027	12	205	295	5	P2691LS1200	●	P2691LSTH1200	●
12.50	0/-0.027	12.5	205	295	5	P2691LS1250	●	P2691LSTH1250	●
13.00	0/-0.027	13	205	295	5	P2691LS1300	●	P2691LSTH1300	●

● stock standard ○ non-standard stock ∇ stock exhaustion

INFO
TYPHOON TA-HTA-4HTA
TYPHOON PU-HPU
TYPHOON SUH
TYPHOON ALH
TYPHOON HRC
TYPHOON SUH MINI
TYPHOON HL
C-SD-TA
LFTA
SUTA
HSS-HSS/CO DRILLS
G2
MDTA
HF VH/UP
MEF
ALU
MEX
UH
HSS/CO-HSSP END MILLS
CARBIDE BURRS

CUTTING PARAMETERS

2691LS

Material Group ISO 513	P1 P2			P3 P4			M1 M2			K1 K2		
Hardness/Rm	500-700 N/mm²			600-1000 N/mm²			< 750 N/mm²			150-350 HB		
Vc (m/min)	20-24			16-20			8-12			20-24		
D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
2	3500	0.032	110	2870	0.027	80	1590	0.022	36	3500	0.035	125
2.5	2800	0.040	110	2290	0.034	80	1270	0.028	36	2800	0.044	125
3	2340	0.048	110	1910	0.041	80	1060	0.034	36	2340	0.053	125
3.5	2000	0.056	110	1640	0.048	80	910	0.039	36	2000	0.062	125
4	1750	0.064	110	1430	0.054	80	800	0.045	36	1750	0.070	125
5	1400	0.072	100	1150	0.061	70	640	0.050	32	1400	0.079	110
6	1170	0.080	95	960	0.068	65	530	0.056	30	1170	0.088	105
7	1000	0.088	90	820	0.075	60	450	0.062	28	1000	0.097	95
8	880	0.096	85	720	0.082	60	400	0.067	27	880	0.106	95
9	780	0.104	80	640	0.088	55	350	0.073	25	780	0.114	90
10	700	0.112	80	570	0.095	55	320	0.078	25	700	0.123	85
11	640	0.120	75	520	0.102	55	290	0.084	24	640	0.132	85
12	580	0.128	75	480	0.109	50	270	0.090	24	580	0.141	80
13	540	0.136	75	440	0.116	50	240	0.095	23	540	0.150	80

2691LSTH

Material Group ISO 513	P1 P2			P3 P4			M1 M2			K1 K2		
Hardness/Rm	500-700 N/mm²			600-1000 N/mm²			< 750 N/mm²			150-350 HB		
Vc (m/min)	24-28			20-24			10-14			24-28		
D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
2	4140	0.032	132	3503	0.027	95	1911	0.022	43	4140	0.035	146
2.5	3312	0.040	132	2803	0.034	95	1529	0.028	43	3312	0.044	146
3	2760	0.048	132	2335	0.041	95	1274	0.034	43	2760	0.053	146
3.5	2366	0.056	132	2002	0.048	95	1092	0.039	43	2366	0.062	146
4	2070	0.064	132	1752	0.054	95	955	0.045	43	2070	0.070	146
5	1656	0.072	119	1401	0.061	86	764	0.050	39	1656	0.079	131
6	1380	0.080	110	1168	0.068	79	637	0.056	36	1380	0.088	121
7	1183	0.088	104	1001	0.075	75	546	0.062	34	1183	0.097	115
8	1035	0.096	99	876	0.082	71	478	0.067	32	1035	0.106	109
9	920	0.104	96	778	0.088	69	425	0.073	31	920	0.114	105
10	828	0.112	93	701	0.095	67	382	0.078	30	828	0.123	102
11	753	0.120	90	637	0.102	65	347	0.084	29	753	0.132	99
12	690	0.128	88	584	0.109	64	318	0.090	29	690	0.141	97
13	637	0.136	87	539	0.116	62	294	0.095	28	637	0.150	95