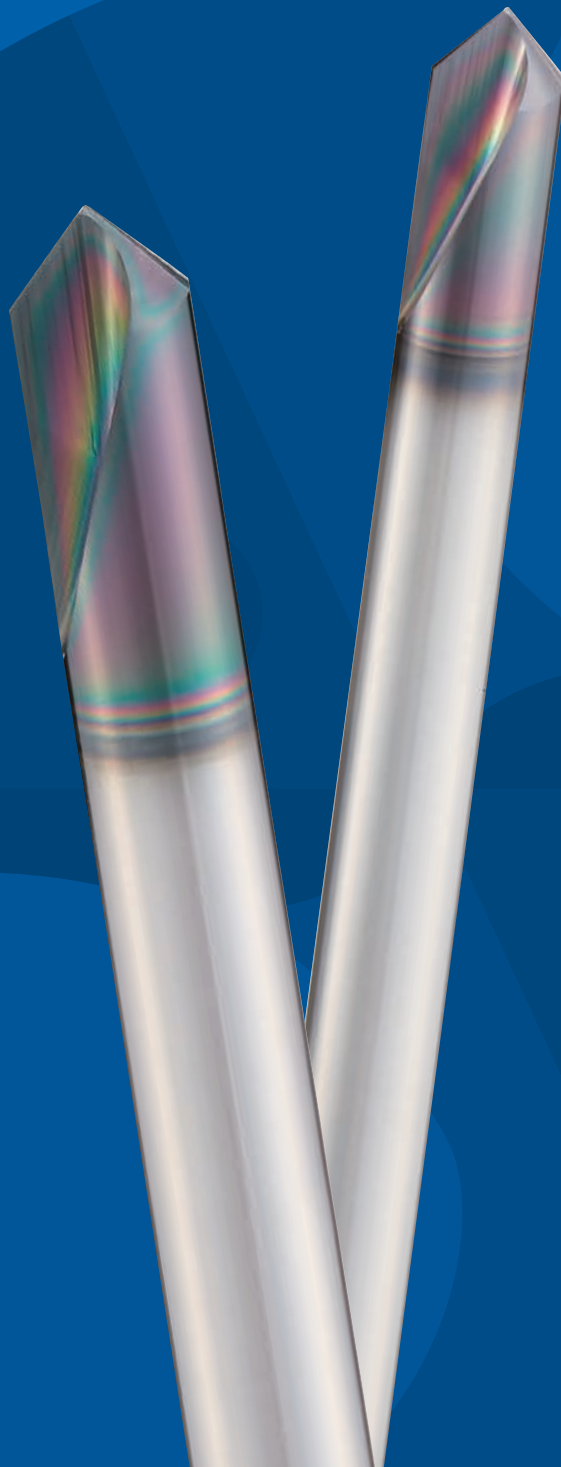




EgiAs Coated Carbide Starter Drill

AD-(LS)-LDS

Volume 2.1



FEATURES: AD-LDS • AD-LS-LDS

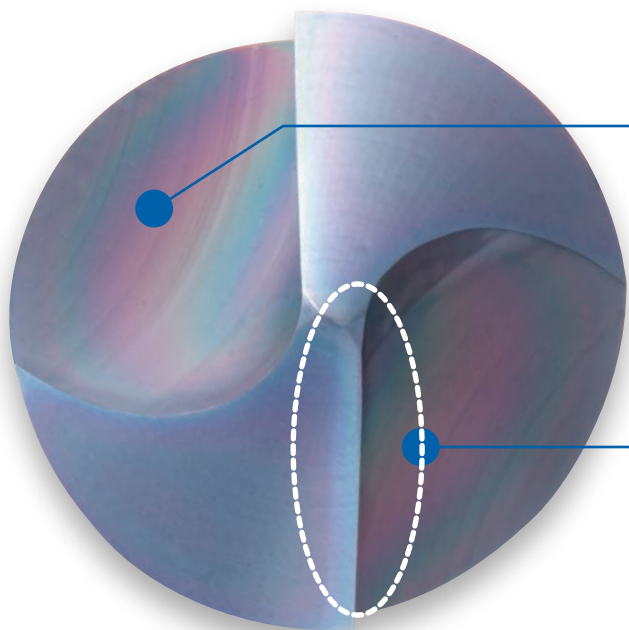
1 Designed for a wide variety of materials

2 New EgiAs Coating:
Exceptional wear resistance
& toughness

3 Unique end cut geometry
Stable cutting resistance



KEY FEATURES & BENEFITS



EgiAs coating applies only to diameter sizes above 2mm.

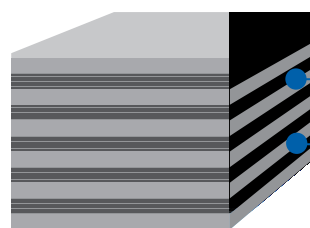
EgiAs is a registered trademark of OSG Corporation.

Cutting geometry with superior sharpness and high chipping resistance

EgiAs coating

Exceptional Wear resistance and toughness

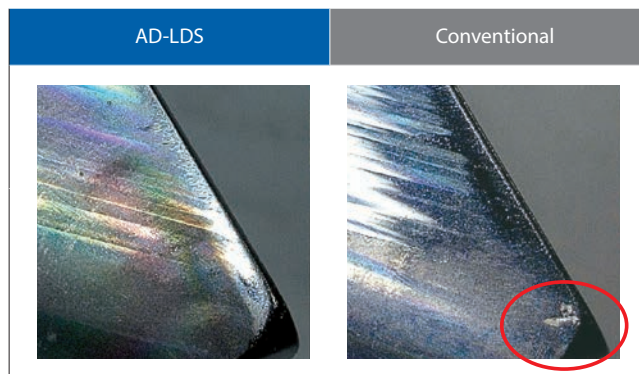
Constructed with extreme toughness, high wear and heat resistance characteristics to ensure stable and consistent tool life



Wear resistance

Periodic Nano-Layered Coating

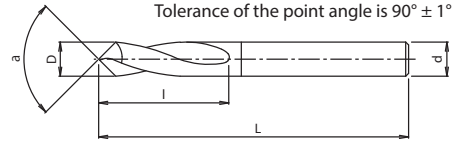
Tool	AD-LDS Ø12 X 90°
Work Material	S50C
Cutting Method	Centering
Cutting Speed	50 m/min (1.326 min ⁻¹)
Feed Rate	239 mm/min (0,18 mm/rev)
Coolant	Water Soluble
Machine	Horizontal Machining Center



EgiAs

AD-LDS NEW SIZES

Drilling | Solid carbide | Centering



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Carbide starter drill

P ● C: ≤0,2%	P ● C: 0,25-0,4%	P ● C: ≥0,45%	P ● SCM	M ○ INOX	K ● GG	K ● GGG	N ○ Al	N ● AC,ADC	S ○ Ti	S ○ Ni	H ● -35 HRC	H ● 35-45 HRC
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A	CARBIDE	EG D≥2	WXL D<2	h7	12° D≥3	25° D<3
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Solid carbide | Centering

Drilling

EDP	D	α	L	l	d	Min. Drill Hole Size*	Price
8688951	3	60	48	9	3	1,2	
8688952	4	60	54	12	4	1,5	
8688953	6	60	72	15	6	1,9	
8688954	8	60	81	20	8	2,1	
8688955	10	60	93	24	10	2,5	
8688956	12	60	108	28	12	2,5	
8688930	0,5	90	38	1	3	0,25	
8688931	1	90	38	1,8	3	0,4	
8688932	2	90	38	2,5	3	1	
8688933	3	90	48	9	3	1,2	
8688934	4	90	54	12	4	1,5	
8688935	6	90	72	15	6	1,9	
8688936	8	90	81	20	8	2,1	
8688937	10	90	93	24	10	2,5	
8688938	12	90	108	28	12	2,5	
8688957	3	120	48	9	3	-	
8688958	4	120	54	12	4	-	
8688959	6	120	72	15	6	-	
8688960	8	120	81	20	8	-	
8688961	10	120	93	24	10	-	
8688962	12	120	108	28	12	-	
8688963	0,5	140	38	1	3	-	
8688964	1	140	38	1,8	3	-	
8688965	2	140	38	2,5	3	-	
8688966	3	140	48	9	3	-	
8688967	4	140	54	12	4	-	
8688968	6	140	72	15	6	-	
8688969	8	140	81	20	8	-	
8688970	10	140	93	24	10	-	
8688971	12	140	108	28	12	-	

* These minimum drill hole sizes are used for chamfering operations.

CUTTING CONDITIONS

Drilling | Solid carbide | Cutting conditions

AD-LDS / AD-LS-LDS

Centering

Vc	Low Carbon Steel - Mild Steel SS400 ~500N/mm ²		Carbon Steel S50C 500 ~ 710N/mm ²		Alloy Steel SCM 710 ~ 900N/mm ²		Special Alloy Steel-Hardened SKD61 ~28HRC ~ 900N/mm ²	
	63~80m/min		40~63m/min		32~50m/min		20~30m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0,5	20.000	0,005 ~ 0,02	25.000	0,005 ~ 0,02	20.000	0,005 ~ 0,02	16.000	0,005 ~ 0,02
1	10.000	0,01 ~ 0,03	16.000	0,01 ~ 0,03	10.000	0,01 ~ 0,03	8.000	0,01 ~ 0,03
2	5.000	0,03 ~ 0,06	8.000	0,03 ~ 0,06	5.000	0,03 ~ 0,06	4.000	0,03 ~ 0,06
3	7.500	0,04 ~ 0,08	5.500	0,04 ~ 0,08	4.500	0,04 ~ 0,08	2.700	0,04 ~ 0,08
4	5.700	0,05 ~ 0,1	4.100	0,05 ~ 0,1	3.300	0,05 ~ 0,1	2.000	0,05 ~ 0,1
6	3.800	0,06 ~ 0,12	2.700	0,06 ~ 0,12	2.300	0,06 ~ 0,12	1.300	0,06 ~ 0,12
8	2.800	0,08 ~ 0,15	2.000	0,08 ~ 0,15	1.700	0,08 ~ 0,15	1.000	0,08 ~ 0,15
10	2.300	0,1 ~ 0,18	1.700	0,1 ~ 0,18	1.400	0,1 ~ 0,18	800	0,1 ~ 0,18
12	1.900	0,12 ~ 0,21	1.400	0,12 ~ 0,21	1.200	0,12 ~ 0,21	650	0,12 ~ 0,21

Vc	Special Alloy Steel-Hardened SKD11 ~34HRC ~ 1060N/mm ²		Tool Steel		Cast Iron - Ductile cast iron FCD250-FC400 ~ 500N/mm ²		Aluminium - Alloy Casting ADC - AC4D	
	16~22m/min		16~22m/min		63~100m/min		80~160m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0,5	12.000	0,005 ~ 0,02	12.000	0,005 ~ 0,02	Note 2.	0,005 ~ 0,015	Note 2.	0,02 ~ 0,04
1	6.000	0,01 ~ 0,03	6.000	0,01 ~ 0,03	20.000	0,01 ~ 0,03	Note 2.	0,04 ~ 0,07
2	3.000	0,03 ~ 0,06	3.000	0,03 ~ 0,06	12.000	0,03 ~ 0,06	15.000	0,06 ~ 0,14
3	2.000	0,04 ~ 0,08	2.000	0,04 ~ 0,08	8.000	0,05 ~ 0,09	12.000	0,1 ~ 0,22
4	1.500	0,05 ~ 0,1	1.500	0,05 ~ 0,1	6.500	0,07 ~ 0,12	9.500	0,12 ~ 0,25
6	1.000	0,06 ~ 0,12	1.000	0,06 ~ 0,12	4.300	0,12 ~ 0,18	6.400	0,14 ~ 0,28
8	750	0,08 ~ 0,15	750	0,08 ~ 0,15	3.200	0,13 ~ 0,2	4.800	0,18 ~ 0,32
10	600	0,1 ~ 0,18	600	0,1 ~ 0,18	2.600	0,17 ~ 0,25	3.800	0,22 ~ 0,36
12	500	0,12 ~ 0,21	500	0,12 ~ 0,21	2.200	0,21 ~ 0,3	3.200	0,25 ~ 0,4

Note1. When using AD-LS-LDS, reduce the feed rate accordingly.

Note2. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.

1. The indicated speeds and feeds are for drilling with [water-soluble coolant](#).
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When centering on a curved or inclined surface, reduce the feed rate accordingly.
4. Centering on [Austenitic Stainless Steels](#) is not recommended. For these procedures, use the TIN-NC-LDS or the NC-LDS.

CUTTING CONDITIONS

Drilling | Solid carbide | Cutting conditions

AD-LDS / AD-LS-LDS

Counter Sinking

Vc	Low Carbon Steel - Mild Steel SS400 ~500N/mm ²		Carbon Steel S50C 500 ~ 710N/mm ²		Alloy Steel SCM 710 ~ 900N/mm ²		Special Alloy Steel-Hardened SKD61 ~28HRC ~ 900N/mm ²	
	63~80m/min		40~63m/min		32~50m/min		20~30m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0,5	20.000	0,005 ~ 0,05	25.000	0,005 ~ 0,05	20.000	0,005 ~ 0,05	16.000	0,005 ~ 0,05
1	10.000	0,01 ~ 0,1	16.000	0,01 ~ 0,1	10.000	0,01 ~ 0,1	8.000	0,01 ~ 0,01
2	5.000	0,02 ~ 0,18	8.000	0,02 ~ 0,18	5.000	0,02 ~ 0,18	4.000	0,02 ~ 0,18
3	7.500	0,04 ~ 0,24	5.500	0,04 ~ 0,24	4.500	0,04 ~ 0,24	2.700	0,04 ~ 0,24
4	5.700	0,04 ~ 0,24	4.100	0,04 ~ 0,24	3.300	0,04 ~ 0,24	2.000	0,04 ~ 0,24
6	3.800	0,06 ~ 0,36	2.700	0,06 ~ 0,36	2.300	0,06 ~ 0,36	1.300	0,06 ~ 0,36
8	2.800	0,08 ~ 0,38	2.000	0,08 ~ 0,38	1.700	0,08 ~ 0,38	1.000	0,08 ~ 0,38
10	2.300	0,1 ~ 0,4	1.700	0,1 ~ 0,4	1.400	0,1 ~ 0,4	800	0,1 ~ 0,4
12	1.900	0,12 ~ 0,42	1.400	0,12 ~ 0,42	1.200	0,12 ~ 0,42	650	0,12 ~ 0,42

Vc	Special Alloy Steel-Hardened SKD11 ~34HRC ~ 1060N/mm ²		Quenched and Tempered Steel 45~50HRC		Cast Iron - Ductile cast iron FCD250-FC400 ~ 500N/mm ²		Aluminium - Alloy Casting ADC - AC4D	
	20~30m/min		20~30m/min		63~100m/min		80~160m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0,5	16.000	0,005 ~ 0,05	16.000	0,005 ~ 0,02	Note 2.	0,005 ~ 0,05	Note 2.	0,005 ~ 0,05
1	8.000	0,01 ~ 0,1	8.000	0,01 ~ 0,03	20.000	0,01 ~ 0,1	Note 2.	0,01 ~ 0,1
2	4.000	0,02 ~ 0,18	4.000	0,03 ~ 0,06	12.000	0,02 ~ 0,18	15.000	0,02 ~ 0,18
3	2.700	0,04 ~ 0,24	2.700	0,04 ~ 0,08	8.000	0,04 ~ 0,24	12.000	0,04 ~ 0,24
4	2.000	0,04 ~ 0,24	2.000	0,05 ~ 0,1	6.500	0,04 ~ 0,24	9.500	0,04 ~ 0,24
6	1.300	0,06 ~ 0,36	1.300	0,06 ~ 0,12	4.300	0,06 ~ 0,36	6.400	0,06 ~ 0,36
8	1.000	0,08 ~ 0,38	1.000	0,08 ~ 0,15	3.200	0,08 ~ 0,38	4.800	0,08 ~ 0,38
10	800	0,1 ~ 0,4	800	0,1 ~ 0,18	2.600	0,1 ~ 0,4	3.800	0,1 ~ 0,4
12	650	0,12 ~ 0,42	650	0,12 ~ 0,21	2.200	0,12 ~ 0,42	3.200	0,12 ~ 0,42

Note1) When using AD-LS-LDS, reduce the feed rate accordingly.

Note2) For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.
4. For high-speed machining, double the median value of the above cutting condition to use as upper limit.



shaping your dreams

OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 07
Fax: +32 10 23 05 51
info@osgeurope.com

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 11
Fax: +32 10 23 05 31
info@osg-belgium.com

OSG FRANCE

Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte - France
Tel: +33 1 49 90 10 10
Fax: +33 1 49 90 10 15
sales@osg-france.com

OSG NETHERLANDS

Bedrijfsweg 5 - 3481 MG Harmelen
Tel: +31 348 44 2764
Fax: +31 348 44 2144
info@osg-nl.com

OSG UK

Shelton house, 5 Bentalls
Pipps Hill Ind Est, Basildon Essex SS14 3BY
Tel: +44 1268 567 660
Fax: +44 1268 567 661
sales@osg-uk.com

CZECH, SLOVAKIA, HUNGARY

OSG Europe Logistics S.A.
Slovakia organizacna zlozka
Racianská 22/A, SK-83102 Bratislava
Slovakia
Tel. +421 24 32 91 295
Orders-osgsvk@osgeurope.com

OSG POLAND Sp. z.o.o.

Spółdzielcza 57
05-074 Halinów - Poland
Tel: +22 760 82 71
Fax: +22 760 82 71
osg@osg-poland.com

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen - Germany
Tel: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde - Denmark
Tel: +45 46 75 65 55
Fax: +45 46 75 67 00
osg@osg-scandinavia.com

SWEDEN

Branch office of OSG SCANDINAVIA
Abrahams Gränd 8
295 35 Bromölla - Sweden
Tel: +46 40 41 22 55
Fax: +46 40 41 32 55
osg@osg-scandinavia.com

OSG IBERICA

Bekolarra 4
E - 01010 Vitoria-Gasteiz - Spain
Tel: +34 945 242 400
Fax: +34 945 228 883
osg.iberica@osg-ib.com

RUSSIA

Butlerova street, 17B, office 5069
117342 Moscow - Russia
Tel: +7 (495) 150 41 54
info@osg-russia.com

OSG TURKEY

Rami Kişla Cad.No:56 Eyüp
Istanbul 34056 - Turkey
Tel:+90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

ROMSAN INTERNATIONAL CO. SRL

Reprezentant Exclusiv OSG
25C, Bucuresti-Magurele Street
051431 Bucuresti - România
Tel: +40 21 322 07 47
Fax: +40 21 321 56 00
romsan.int@romsan.ro

AUSTRIA

Branch office of OSG GERMANY
Messestraße 11
A-6850 Dornbirn
Tel: +49 7161 6064-0
Fax: +49 7161 6064-444
info@osg-germany.de

OSG ITALIA

Via Cirenaiica n. 52 int. 61/63
I - 10142 Torino - Italy
Tel: +39 0117705211
Fax: +39 0117705215
info@osg-italia.it

Vischer & Bolli AG

Machining and Workholding
Im Schossacher 17
CH-8600 Dübendorf
T +41 44 802 15 15
F +41 44 802 15 95
info@vb-tools.com

OSG EUROPE LOGISTICS S.A.

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