



MEGA-Drill-Reamer

The MEGA-Drill-Reamer combines two work steps in one tool: Drilling and reaming.

Bores can be machined more quickly and more efficiently without having to forego reaming quality. Optimisation and rationalisation are always in the foreground. Productive and non-productive times can be significantly reduced by using the MEGA-Drill-Reamer on machining centres.

On the MEGA-Drill-Reamers, as standard with the special TiAlN coating, two drill cutting edges initially perform the machining in the solid. Four slightly axially offset reaming cutting edges then

MEGA-Drill-Reamer

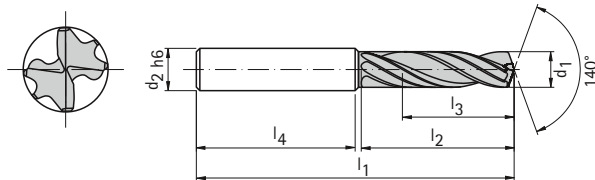
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provide fine machining and guarantee surface finishes, dimensional accuracy and circularity as obtained with reaming.

There are many applications for these tools. Some examples are position bores in cylinder heads, crankcases or gearbox housings.

MEGA-Drill-Reamer

SCD20 (3xD), external coolant supply

**Design:**

Drill diameter:	5,97 – 12,02 mm
Tool tolerance:	±0,003 Standard
Shank form:	HA (DIN 6535)
Coating:	Special TiAlN coating
Number of cutting edges:	2
Number of guiding chamfers:	4
Point geometry:	Specific lead geometry
Tip angle:	140°
Helix angle:	30°

Dimensions							Shank form HA		
d ₁ * (±0.003)	Bore diameter min. – max.	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Specification	Order No.	
5,97	5,965 - 5,980	6	79	34	24	36	SCD200-0597-2-4-140HA03-HP835	30392496	○
5,98	5,975 - 5,990	6	79	34	24	36	SCD200-0598-2-4-140HA03-HP835	30392497	○
5,99	5,985 - 6,000	6	79	34	24	36	SCD200-0599-2-4-140HA03-HP835	30392498	●
6,00	5,995 - 6,010	6	79	34	24	36	SCD200-0600-2-4-140HA03-HP835	30392499	●
6,01	6,005 - 6,020	6	79	34	24	36	SCD200-0601-2-4-140HA03-HP835	30392500	●
6,02	6,015 - 6,030	8	79	34	24	36	SCD200-0602-2-4-140HA03-HP835	30392501	●
7,97	7,965 - 7,980	8	79	34	24	36	SCD200-0797-2-4-140HA03-HP835	30392502	○
7,98	7,975 - 7,990	8	79	34	24	36	SCD200-0798-2-4-140HA03-HP835	30392503	○
7,99	7,985 - 8,000	8	79	34	24	36	SCD200-0799-2-4-140HA03-HP835	30392504	○
8,00	7,995 - 8,010	8	79	34	24	36	SCD200-0800-2-4-140HA03-HP835	30392505	●
8,01	8,005 - 8,020	8	79	34	24	36	SCD200-0801-2-4-140HA03-HP835	30392506	●
8,02	8,015 - 8,030	8	79	34	24	36	SCD200-0802-2-4-140HA03-HP835	30392507	●
9,97	9,965 - 9,980	10	89	47	35	40	SCD200-0997-2-4-140HA03-HP835	30392508	○
9,98	9,975 - 9,990	10	89	47	35	40	SCD200-0998-2-4-140HA03-HP835	30392509	●
9,99	9,985 - 10,000	10	89	47	35	40	SCD200-0999-2-4-140HA03-HP835	30392510	○
10,00	9,995 - 10,010	10	89	47	35	40	SCD200-1000-2-4-140HA03-HP835	30392511	●
10,01	10,005 - 10,020	10	89	47	35	40	SCD200-1001-2-4-140HA03-HP835	30392512	●
10,02	10,015 - 10,030	10	89	47	35	40	SCD200-1002-2-4-140HA03-HP835	30392513	●
11,97	11,964 - 11,982	12	102	55	40	45	SCD200-1197-2-4-140HA03-HP835	30392514	○
11,98	11,974 - 11,992	12	102	55	40	45	SCD200-1198-2-4-140HA03-HP835	30392515	○
11,99	11,984 - 12,002	12	102	55	40	45	SCD200-1199-2-4-140HA03-HP835	30392516	○
12,00	11,994 - 12,012	12	102	55	40	45	SCD200-1200-2-4-140HA03-HP835	30392517	●
12,01	12,004 - 12,022	12	102	55	40	45	SCD200-1201-2-4-140HA03-HP835	30392518	●
12,02	12,014 - 12,032	12	102	55	40	45	SCD200-1202-2-4-140HA03-HP835	30392519	○

*The tool tolerances can only be guaranteed in perfect application conditions and with radial run-out errors < 10 µm.

Workpiece, material and cooling lubricant can also have an effect on the bore ø.

Further special designs can be manufactured on request with a minimum order quantity of 3 pieces.

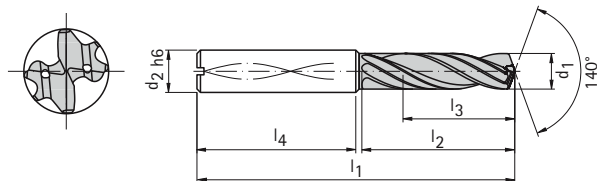
Dimensions in mm.

For machining values see technical notes.
Special designs and other coatings on request.

● Available from stock in Germany
○ No stockage of standard tool (delivery time on request)

MEGA-Drill-Reamer

SCD20 (3xD), internal coolant supply

**Design:**

Drill diameter:	5,97 – 12,72 mm
Tool tolerance:	±0,003 Standard
Shank form:	HA (DIN 6535)
Coating:	Special TiAlN coating
Number of cutting edges:	2
Number of guiding chamfers:	4
Point geometry:	Specific lead geometry
Tip angle:	140°
Helix angle:	30°

Dimensions							Shank form HA		
d ₁ * (±0.003)	Bore diameter min. – max.	d ₂ h6	l ₁	l ₂	l ₃	l ₄	Specification	Order No.	
5,97	5,965 - 5,980	6	79	34	24	36	SCD201-0597-2-4-140HA03-HP835	30392520	●
5,98	5,975 - 5,990	6	79	34	24	36	SCD201-0598-2-4-140HA03-HP835	30392521	○
5,99	5,985 - 6,000	6	79	34	24	36	SCD201-0599-2-4-140HA03-HP835	30392522	●
6,00	5,995 - 6,010	6	79	34	24	36	SCD201-0600-2-4-140HA03-HP835	30392523	●
6,01	6,005 - 6,020	6	79	34	24	36	SCD201-0601-2-4-140HA03-HP835	30392524	●
6,02	6,015 - 6,030	6	79	34	24	36	SCD201-0602-2-4-140HA03-HP835	30392525	●
6,32	6,315 - 6,330	8	79	34	24	36	SCD201-0632-2-4-140HA03-HP835	30392526	○
6,33	6,325 - 6,340	8	79	34	24	36	SCD201-0633-2-4-140HA03-HP835	30392527	○
6,34	6,335 - 6,350	8	79	34	24	36	SCD201-0634-2-4-140HA03-HP835	30392528	○
6,35	6,345 - 6,360	8	79	34	24	36	SCD201-0635-2-4-140HA03-HP835	30392529	○
6,36	6,355 - 6,370	8	79	34	24	36	SCD201-0636-2-4-140HA03-HP835	30392530	○
6,37	6,365 - 6,380	8	79	34	24	36	SCD201-0637-2-4-140HA03-HP835	30392531	●
7,97	7,965 - 7,980	8	79	34	24	36	SCD201-0797-2-4-140HA03-HP835	30392532	●
7,98	7,975 - 7,990	8	79	34	24	36	SCD201-0798-2-4-140HA03-HP835	30392533	●
7,99	7,985 - 8,000	8	79	34	24	36	SCD201-0799-2-4-140HA03-HP835	30392534	●
8,00	7,995 - 8,010	8	79	34	24	36	SCD201-0800-2-4-140HA03-HP835	30392535	●
8,01	8,005 - 8,020	8	79	34	24	36	SCD201-0801-2-4-140HA03-HP835	30392536	●
8,02	8,015 - 8,030	8	79	34	24	36	SCD201-0802-2-4-140HA03-HP835	30392537	●
9,48	9,475 - 9,490	10	89	47	35	40	SCD201-0948-2-4-140HA03-HP835	30392538	○
9,49	9,485 - 9,500	10	89	47	35	40	SCD201-0949-2-4-140HA03-HP835	30392539	○
9,50	9,495 - 9,510	10	89	47	35	40	SCD201-0950-2-4-140HA03-HP835	30392540	○
9,52	9,515 - 9,530	10	89	47	35	40	SCD201-0952-2-4-140HA03-HP835	30392541	○
9,53	9,525 - 9,540	10	89	47	35	40	SCD201-0953-2-4-140HA03-HP835	30392542	○
9,54	9,535 - 9,550	10	89	47	35	40	SCD201-0954-2-4-140HA03-HP835	30392543	○

*The tool tolerances can only be guaranteed in perfect application conditions and with radial run-out errors < 10 µm.

Workpiece, material and cooling lubricant can also have an effect on the bore ø.

Further special designs can be manufactured on request with a minimum order quantity of 3 pieces.

Dimensions in mm.

For machining values see technical notes.
Special designs and other coatings on request.

- Available from stock in Germany
- No stockage of standard tool (delivery time on request)

MEGA-Drill-Reamer

SCD20 (3xD), internal coolant supply

Dimensions							Shank form HA		
d_1^* (± 0.003)	Bore diameter min. – max.	d_2 h6	l_1	l_2	l_3	l_4	Specification	Order No.	
9,97	9,965 - 9,980	10	89	47	35	40	SCD201-0997-2-4-140HA03-HP835	30392544	○
9,98	9,975 - 9,990	10	89	47	35	40	SCD201-0998-2-4-140HA03-HP835	30392545	●
9,99	9,985 - 10,000	10	89	47	35	40	SCD201-0999-2-4-140HA03-HP835	30392546	●
10,00	9,995 - 10,010	10	89	47	35	40	SCD201-1000-2-4-140HA03-HP835	30392547	●
10,01	10,005 - 10,020	10	89	47	35	40	SCD201-1001-2-4-140HA03-HP835	30392548	●
10,02	10,015 - 10,030	10	89	47	35	40	SCD201-1002-2-4-140HA03-HP835	30392549	●
11,97	11,964 - 11,982	12	102	55	40	45	SCD201-1197-2-4-140HA03-HP835	30392550	○
11,98	11,974 - 11,992	12	102	55	40	45	SCD201-1198-2-4-140HA03-HP835	30392551	○
11,99	11,984 - 12,002	12	102	55	40	45	SCD201-1199-2-4-140HA03-HP835	30392552	○
12,00	11,994 - 12,012	12	102	55	40	45	SCD201-1200-2-4-140HA03-HP835	30392553	●
12,01	12,004 - 12,022	12	102	55	40	45	SCD201-1201-2-4-140HA03-HP835	30392554	●
12,02	12,014 - 12,032	12	102	55	40	45	SCD201-1202-2-4-140HA03-HP835	30392555	●
12,67	12,664 - 12,682	14	107	60	43	45	SCD201-1267-2-4-140HA03-HP835	30392556	○
12,68	12,674 - 12,692	14	107	60	43	45	SCD201-1268-2-4-140HA03-HP835	30392557	○
12,69	12,684 - 12,702	14	107	60	43	45	SCD201-1269-2-4-140HA03-HP835	30392558	○
12,70	12,694 - 12,712	14	107	60	43	45	SCD201-1270-2-4-140HA03-HP835	30392559	○
12,71	12,704 - 12,722	14	107	60	43	45	SCD201-1271-2-4-140HA03-HP835	30392560	○
12,72	12,714 - 12,732	14	107	60	43	45	SCD201-1272-2-4-140HA03-HP835	30392561	○

*The tool tolerances can only be guaranteed in perfect application conditions and with radial run-out errors < 10 μm .

Workpiece, material and cooling lubricant can also have an effect on the bore ϕ .

Further special designs can be manufactured on request with a minimum order quantity of 3 pieces.

Drill reamers for basic holes with tolerance H7

Dimensions							Shank form HA		
d_1	Bore diameter min. – max.	d_2 h6	l_1	l_2	l_3	l_4	Specification	Order No.	
4 ^{H7}	4,000 - 4,012	6	66	24	17	36	SCD201C-0400-2-4-140HA03-HP835 H7	30457927	●
5 ^{H7}	5,000 - 5,012	6	79	34	24	36	SCD201C-0500-2-4-140HA03-HP835 H7	30405369	●
6 ^{H7}	6,000 - 6,012	6	79	34	24	36	SCD201C-0600-2-4-140HA03-HP835 H7	30393870	●
7 ^{H7}	7,000 - 7,015	8	79	34	24	36	SCD201C-0700-2-4-140HA03-HP835 H7	30455340	●
8 ^{H7}	8,000 - 8,015	8	79	34	24	36	SCD201C-0800-2-4-140HA03-HP835 H7	30393871	●
9 ^{H7}	9,000 - 9,015	10	89	47	35	40	SCD201C-0900-2-4-140HA03-HP835 H7	30435050	●
10 ^{H7}	10,000 - 10,015	10	89	47	35	40	SCD201C-1000-2-4-140HA03-HP835 H7	30393872	●
12 ^{H7}	12,000 - 12,018	12	102	55	40	45	SCD201C-1200-2-4-140HA03-HP835 H7	30393873	●
14 ^{H7}	14,000 - 14,018	14	107	60	43	45	SCD201C-1400-2-4-140HA03-HP835 H7	30393874	●
16 ^{H7}	16,000 - 16,018	16	115	65	45	48	SCD201C-1600-2-4-140HA03-HP835 H7	30393875	●

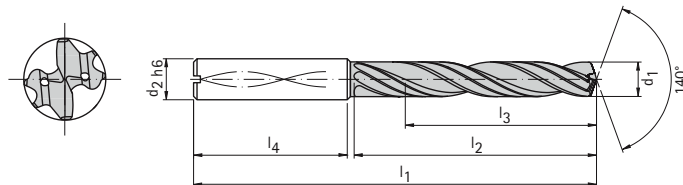
Dimensions in mm.

For machining values see technical notes.
Special designs and other coatings on request.

● Available from stock in Germany
○ No stockage of standard tool (delivery time on request)

MEGA-Drill-Reamer

SCD20 (5xD), internal coolant supply

**Design:**

Drill diameter:	5,97 – 12,72 mm
Tool tolerance:	±0,003 Standard
Shank form:	HA (DIN 6535)
Coating:	Special TiAlN coating
Number of cutting edges:	2
Number of guiding chamfers:	4
Point geometry:	Specific lead geometry
Tip angle:	140°
Helix angle:	30°

Dimensions							Shank form HA		
d1* (±0.003)	Bore diameter min. – max.	d2 h6	l1	l2	l3	l4	Specification	Order No.	
5,97	5,965 – 5,980	6	91	53	43	36	SCD201-0597-2-4-140HA05-HP835	30392562	○
5,98	5,975 – 5,990	6	91	53	43	36	SCD201-0598-2-4-140HA05-HP835	30392563	●
5,99	5,985 – 6,000	6	91	53	43	36	SCD201-0599-2-4-140HA05-HP835	30392564	●
6,00	5,995 – 6,010	6	91	53	43	36	SCD201-0600-2-4-140HA05-HP835	30392565	●
6,01	6,005 – 6,020	6	91	53	43	36	SCD201-0601-2-4-140HA05-HP835	30392566	●
6,02	6,015 – 6,030	8	91	53	43	36	SCD201-0602-2-4-140HA05-HP835	30392567	●
6,32	6,315 – 6,330	8	91	53	43	36	SCD201-0632-2-4-140HA05-HP835	30392568	○
6,33	6,325 – 6,340	8	91	53	43	36	SCD201-0633-2-4-140HA05-HP835	30392569	○
6,34	6,335 – 6,350	8	91	53	43	36	SCD201-0634-2-4-140HA05-HP835	30392570	○
6,35	6,345 – 6,360	8	91	53	43	36	SCD201-0635-2-4-140HA05-HP835	30392571	○
6,36	6,355 – 6,370	8	91	53	43	36	SCD201-0636-2-4-140HA05-HP835	30392572	○
6,37	6,365 – 6,380	8	91	53	43	36	SCD201-0637-2-4-140HA05-HP835	30392573	○
7,97	7,965 – 7,980	8	91	53	43	36	SCD201-0797-2-4-140HA05-HP835	30392574	●
7,98	7,975 – 7,990	8	91	53	43	36	SCD201-0798-2-4-140HA05-HP835	30392575	●
7,99	7,985 – 8,000	8	91	53	43	36	SCD201-0799-2-4-140HA05-HP835	30392576	○
8,00	7,995 – 8,010	8	91	53	43	36	SCD201-0800-2-4-140HA05-HP835	30392577	●
8,01	8,005 – 8,020	8	91	53	43	36	SCD201-0801-2-4-140HA05-HP835	30392578	●
8,02	8,015 – 8,030	8	91	53	43	36	SCD201-0802-2-4-140HA05-HP835	30392579	●
9,48	9,475 – 9,490	10	103	61	49	40	SCD201-0948-2-4-140HA05-HP835	30392580	○
9,49	9,485 – 9,500	10	103	61	49	40	SCD201-0949-2-4-140HA05-HP835	30392581	○
9,50	9,495 – 9,510	10	103	61	49	40	SCD201-0950-2-4-140HA05-HP835	30392582	●
9,52	9,515 – 9,530	10	103	61	49	40	SCD201-0952-2-4-140HA05-HP835	30392583	○
9,53	9,525 – 9,540	10	103	61	49	40	SCD201-0953-2-4-140HA05-HP835	30392584	○
9,54	9,535 – 9,550	10	103	61	49	40	SCD201-0954-2-4-140HA05-HP835	30392585	○

*The tool tolerances can only be guaranteed in perfect application conditions and with radial run-out errors < 10 µm.

Workpiece, material and cooling lubricant can also have an effect on the bore ø.

Further special designs can be manufactured on request with a minimum order quantity of 3 pieces.

Dimensions in mm.

For machining values see technical notes.
Special designs and other coatings on request.

- Available from stock in Germany
- No stockage of standard tool (delivery time on request)

MEGA-Drill-Reamer

SCD20 (5xD), internal coolant supply

Dimensions							Shank form HA		
d_1^* (± 0.003)	Bore diameter min. – max.	d_2 h6	l_1	l_2	l_3	l_4	Specification	Order No.	
9,97	9,965 - 9,980	10	103	61	49	40	SCD201-0997-2-4-140HA05-HP835	30392586	○
9,98	9,975 - 9,990	10	103	61	49	40	SCD201-0998-2-4-140HA05-HP835	30392587	○
9,99	9,985 - 10,000	10	103	61	49	40	SCD201-0999-2-4-140HA05-HP835	30392588	○
10,00	9,995 - 10,010	10	103	61	49	40	SCD201-1000-2-4-140HA05-HP835	30392589	●
10,01	10,005 - 10,020	10	103	61	49	40	SCD201-1001-2-4-140HA05-HP835	30392590	●
10,02	10,015 - 10,030	10	103	61	49	40	SCD201-1002-2-4-140HA05-HP835	30392591	●
11,97	11,964 - 11,982	12	118	71	56	45	SCD201-1197-2-4-140HA05-HP835	30392592	○
11,98	11,974 - 11,992	12	118	71	56	45	SCD201-1198-2-4-140HA05-HP835	30392593	○
11,99	11,984 - 12,002	12	118	71	56	45	SCD201-1199-2-4-140HA05-HP835	30392594	○
12,00	11,994 - 12,012	12	118	71	56	45	SCD201-1200-2-4-140HA05-HP835	30392595	●
12,01	12,004 - 12,022	12	118	71	56	45	SCD201-1201-2-4-140HA05-HP835	30392596	○
12,02	12,014 - 12,032	12	118	71	56	45	SCD201-1202-2-4-140HA05-HP835	30392597	○
12,67	12,664 - 12,682	14	124	77	60	45	SCD201-1267-2-4-140HA05-HP835	30392598	○
12,68	12,674 - 12,692	14	124	77	60	45	SCD201-1268-2-4-140HA05-HP835	30392599	○
12,69	12,684 - 12,702	14	124	77	60	45	SCD201-1269-2-4-140HA05-HP835	30392600	○
12,70	12,694 - 12,712	14	124	77	60	45	SCD201-1270-2-4-140HA05-HP835	30392601	●
12,71	12,704 - 12,722	14	124	77	60	45	SCD201-1271-2-4-140HA05-HP835	30392602	○
12,72	12,714 - 12,732	14	124	77	60	45	SCD201-1272-2-4-140HA05-HP835	30392603	○

*The tool tolerances can only be guaranteed in perfect application conditions and with radial run-out errors < 10 μm .

Workpiece, material and cooling lubricant can also have an effect on the bore ϕ .

Further special designs can be manufactured on request with a minimum order quantity of 3 pieces.

Drill reamers for basic holes with tolerance H7

Dimensions							Shank form HA		
d_1	Bore diameter min. – max.	d_2 h6	l_1	l_2	l_3	l_4	Specification	Order No.	
4 ^{H7}	4,000 - 4,012	6	74	36	29	36	SCD201C-0400-2-4-140HA05-HP835 H7	30457977	●
5 ^{H7}	5,000 - 5,012	6	91	53	43	36	SCD201C-0500-2-4-140HA05-HP835 H7	30457985	●
6 ^{H7}	6,000 - 6,012	6	91	53	43	36	SCD201C-0600-2-4-140HA05-HP835 H7	30393876	●
7 ^{H7}	7,000 - 7,015	8	91	53	43	36	SCD201C-0700-2-4-140HA05-HP835 H7	30457987	●
8 ^{H7}	8,000 - 8,015	8	91	53	43	36	SCD201C-0800-2-4-140HA05-HP835 H7	30393877	●
9 ^{H7}	9,000 - 9,015	10	103	61	49	40	SCD201C-0900-2-4-140HA05-HP835 H7	30457992	●
10 ^{H7}	10,000 - 10,015	10	103	61	49	40	SCD201C-1000-2-4-140HA05-HP835 H7	30393878	●
12 ^{H7}	12,000 - 12,018	12	118	71	56	45	SCD201C-1200-2-4-140HA05-HP835 H7	30393879	●
14 ^{H7}	14,000 - 14,018	14	124	77	60	45	SCD201C-1400-2-4-140HA05-HP835 H7	30393880	●
16 ^{H7}	16,000 - 16,018	16	133	83	63	48	SCD201C-1600-2-4-140HA05-HP835 H7	30393881	●

Dimensions in mm.

For machining values see technical notes.
Special designs and other coatings on request.

● Available from stock in Germany
○ No stockage of standard tool (delivery time on request)