

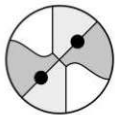
250200



Solid Carbide Deep-Hole Drill 25xD with Internal Coolant



$t_{max} = l_2 - 1.5 \times d_1$



d_1
h7

d ₁ mm	d ₂ mm	l ₂ mm	l ₃ mm	l ₁ mm	HA Part No.	Feed mm/rev
3,00	6	85	36	125	250200030HA	0,06 – 0,14
3,50	6	116	36	156	250200035HA	0,06 – 0,14
3,97	6	116	36	156	2502000397HA	0,06 – 0,14
4,00	6	116	36	156	250200040HA	0,08 – 0,16
4,50	6	143	36	183	250200045HA	0,08 – 0,16
4,76	6	143	36	183	2502000476HA	0,08 – 0,16
5,00	6	143	36	183	250200050HA	0,09 – 0,20
5,50	6	170	36	210	250200055HA	0,09 – 0,20
5,56	6	170	36	210	2502000556HA	0,09 – 0,20
6,00	6	170	36	210	250200060HA	0,10 – 0,23
6,35	8	197	36	237	2502000635HA	0,10 – 0,23
6,50	8	197	36	237	250200065HA	0,10 – 0,23
7,00	8	197	36	237	250200070HA	0,11 – 0,25
7,14	8	223	36	263	2502000714HA	0,11 – 0,25
7,50	8	223	36	263	250200075HA	0,11 – 0,25
8,00	8	223	36	263	250200080HA	0,11 – 0,27
8,50	10	250	40	294	250200085HA	0,11 – 0,27
9,00	10	250	40	294	250200090HA	0,12 – 0,28
10,00	10	277	40	321	250200100HA	0,13 – 0,30
12,00	12	337	45	386	250200120HA	0,15 – 0,32

- Deep-hole drill for universal applications
- Ultra-micro grain solid carbide with TiAlN coating
- 4 margins for concentricity and alignment accuracy
- Optimized geometry for an optimum chip breaking and a high level of process reliability.

Material	Alu & Al Alloys	Alu & Al alloys <10% Si	Alu & Al alloys >10% Si
Tensile strength/ Hardness	< 450 N/mm ²	< 600 N/mm ²	> 600 N/mm ²
V _c (m/min)	140	150	120

Material	General structural steels	Free machining steels	Non-alloy Q & T steels	Steel	Tool steels	Alloy case-hardened steels	Stainless steels	Cast iron	Cast iron (gray, ductile, malleable)
Tensile strength/ Hardness	< 850 N/mm ²	< 1000 N/mm ²	< 1000 N/mm ²	< 1200 N/mm ²	< 1400 N/mm ²	< 1200 N/mm ²	< 750 N/mm ²	< 650 N/mm ²	> 260 HB
V _c (m/min)	120	110	105	105	45	85	75	120	60