

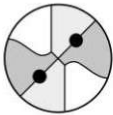
300200



Solid Carbide Deep-Hole Drill 30xD 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	100	36	140	300200030HA	0,06 – 0,14
3,50	6	136	36	176	300200035HA	0,06 – 0,14
3,97	6	136	36	176	3002000397HA	0,06 – 0,14
4,00	6	136	36	176	300200040HA	0,08 – 0,16
4,50	6	168	36	208	300200045HA	0,08 – 0,16
4,76	6	168	36	208	3002000476HA	0,08 – 0,16
5,00	6	168	36	208	300200050HA	0,09 – 0,20
5,50	6	200	36	240	300200055HA	0,09 – 0,20
5,56	6	200	36	240	3002000556HA	0,09 – 0,20
6,00	6	200	36	240	300200060HA	0,10 – 0,23
6,35	8	232	36	272	3002000635HA	0,10 – 0,23
6,50	8	232	36	272	300200065HA	0,10 – 0,23
7,00	8	232	36	272	300200070HA	0,11 – 0,25
7,14	8	263	36	303	3002000714HA	0,11 – 0,25
7,50	8	263	36	303	300200075HA	0,11 – 0,25
8,00	8	263	36	303	300200080HA	0,11 – 0,27
8,50	10	295	40	339	300200085HA	0,11 – 0,27
9,00	10	295	40	339	300200090HA	0,12 – 0,28
10,00	10	327	40	371	300200100HA	0,13 – 0,30

- 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