

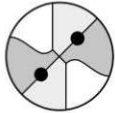
400200



Solid Carbide Deep-Hole Drill 40xD 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	130	36	170	400200030HA	0,06 – 0,14
3,17	6	153	36	193	4002000317HA	0,06 – 0,14
3,50	6	153	36	193	400200035HA	0,06 – 0,14
3,97	6	176	36	216	4002000397HA	0,06 – 0,14
4,00	6	176	36	216	400200040HA	0,08 – 0,16
4,50	6	198	36	238	400200045HA	0,08 – 0,16
4,76	6	218	36	258	4002000476HA	0,08 – 0,16
5,00	6	218	36	258	400200050HA	0,09 – 0,20
5,50	6	240	36	280	400200055HA	0,09 – 0,20
5,56	6	260	36	300	4002000556HA	0,09 – 0,20
6,00	6	260	36	300	400200060HA	0,10 – 0,23
6,35	8	282	36	322	4002000635HA	0,10 – 0,23
6,50	8	282	36	322	400200065HA	0,10 – 0,23
7,00	8	302	36	342	400200070HA	0,11 – 0,25
7,14	8	323	36	363	4002000714HA	0,11 – 0,25
7,50	8	323	36	363	400200075HA	0,11 – 0,25
8,00	8	343	36	383	400200080HA	0,11 – 0,27

- 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