

# High-performance drill SC TiAlNplus HPC 12xD with internal cooling HA

for universal use up to 1300 N/mm<sup>2</sup>



## Application

for HPC boring up to a strength of 1300 N/mm<sup>2</sup>

## Version

- solid carbide TiAlNplus high-performance drill
- 4 drill heels
- Four grinding faces
- 30° spiral angle
- Straight main cutting edge

## Advantage

- economic drilling in a wide variety of materials with high cutting values
- newly developed geometry in conjunction with a multi-layer coating individually tailored to drilling ensures significantly longer service lives
- Cutting edge finishing reduces micro-fractures and increases the service life
- very high alignment accuracy thanks to 4 drill heels
- high process reliability even at extreme depths

| Application | Steel (N/mm <sup>2</sup> ) |       |       | Stainless steel |         | Alu   |      | Brass |      | Bronze |      | Plas-tics | Graphite G(C)FK | GG(G) GJMW | Titan-alloy | Nickel-alloy | Super-alloy | Hard mat. |         |
|-------------|----------------------------|-------|-------|-----------------|---------|-------|------|-------|------|--------|------|-----------|-----------------|------------|-------------|--------------|-------------|-----------|---------|
|             | <700                       | <1000 | <1300 | marten.         | austen. | short | long | short | long | short  | long |           |                 |            |             |              |             | <55 HRC   | <65 HRC |
|             | 135                        | 110   | 90    | 35              | 30      | 210   | 260  | 230   | 180  | 160    | 130  | 60        |                 | 110        | 40          | 35           | 30          |           |         |

|   |                   |
|---|-------------------|
| <b>Art. No.</b>                           | <b>11110 115</b>  |
| <b>Cutting edge diameter</b>              | 11.5 mm           |
| <b>Tolerance of cutting edge diameter</b> | h7                |
| <b>Cutting material</b>                   | VHM               |
| <b>Surface</b>                            | TiAlN plus        |
| <b>Max. drilling depth (D)</b>            | 12xD              |
| <b>Type</b>                               | HPC UNI           |
| <b>Coolant supply</b>                     | Internal          |
| <b>Tool holding device</b>                | HA parallel shank |
| <b>Angle of the tip</b>                   | 135 Degree        |
| <b>Shaft diameter</b>                     | 12 mm             |
| <b>Chip flute length</b>                  | 156 mm            |
| <b>Length</b>                             | 204 mm            |
| <b>f steel 1000</b>                       | 0.2 mm/r          |

## EAN-Code

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