

Twist drill type UNI/VA HSSE-V3 TiAlN 3xD
for universal use up to 1300 N/mm²

ATORN®



Application

Universal use in all material groups up to a strength of 1300 N/mm²

Version

- Twist drill with unified shaft
- Diameter 1.00 mm–1.90 mm = tip angle 140°
- Diameter 2.00 mm–4.00 mm = tip angle 130°
- Diameter 4.10 mm–20.0 mm = tip angle 120°
- 2 drill heels
- 38° to 40° spiral angle
- Straight main cutting edge

Advantage

- Drilling without centring
- Problem solver in low-performance machines without internal cooling in high-strength steels and stainless steels
- Extremely hard, low-friction and temperature-resistant TiAlN coating for longer life
- Very high feed rates can be achieved

| Application | Steel (N/mm ²) | | | Stainless steel | | Alu | | Brass | | Bronze | | Plastics | 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 |
| | 55 | 35 | 25 | 20 | 15 | 55 | 85 | 70 | 45 | 40 | 30 | 40 | | 40 | 10 | 10 | 10 | | |

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|---|-------------------|
| Art. No. | 11036 274 |
| Cutting edge diameter | 7.4 mm |
| Tolerance of cutting edge diameter | h8 |
| Cutting material | HSSE V3 |
| Surface | TiAlN |
| Max. drilling depth (D) | 3xD |
| Type | VA |
| Coolant supply | External |
| Tool holding device | HA parallel shank |
| Angle of the tip | 120 Degree |
| Shaft diameter | 8 mm |
| Chip flute length | 34 mm |
| Length | 74 mm |
| f steel 1000 | 0.18 mm/U |

EAN-Code

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