



PRECISION TOOLS CATALOGUE

FASCINATION FOR PRECISION®

A photograph of two men in a workshop setting. The man on the right is in the foreground, wearing a black polo shirt with a red 'EUKO' logo on the chest. He is looking down with a focused expression. The man on the left is partially visible, also looking in the same direction. In the background, there is a large industrial machine, possibly a lathe or mill, with a bright light reflecting off a metallic surface.

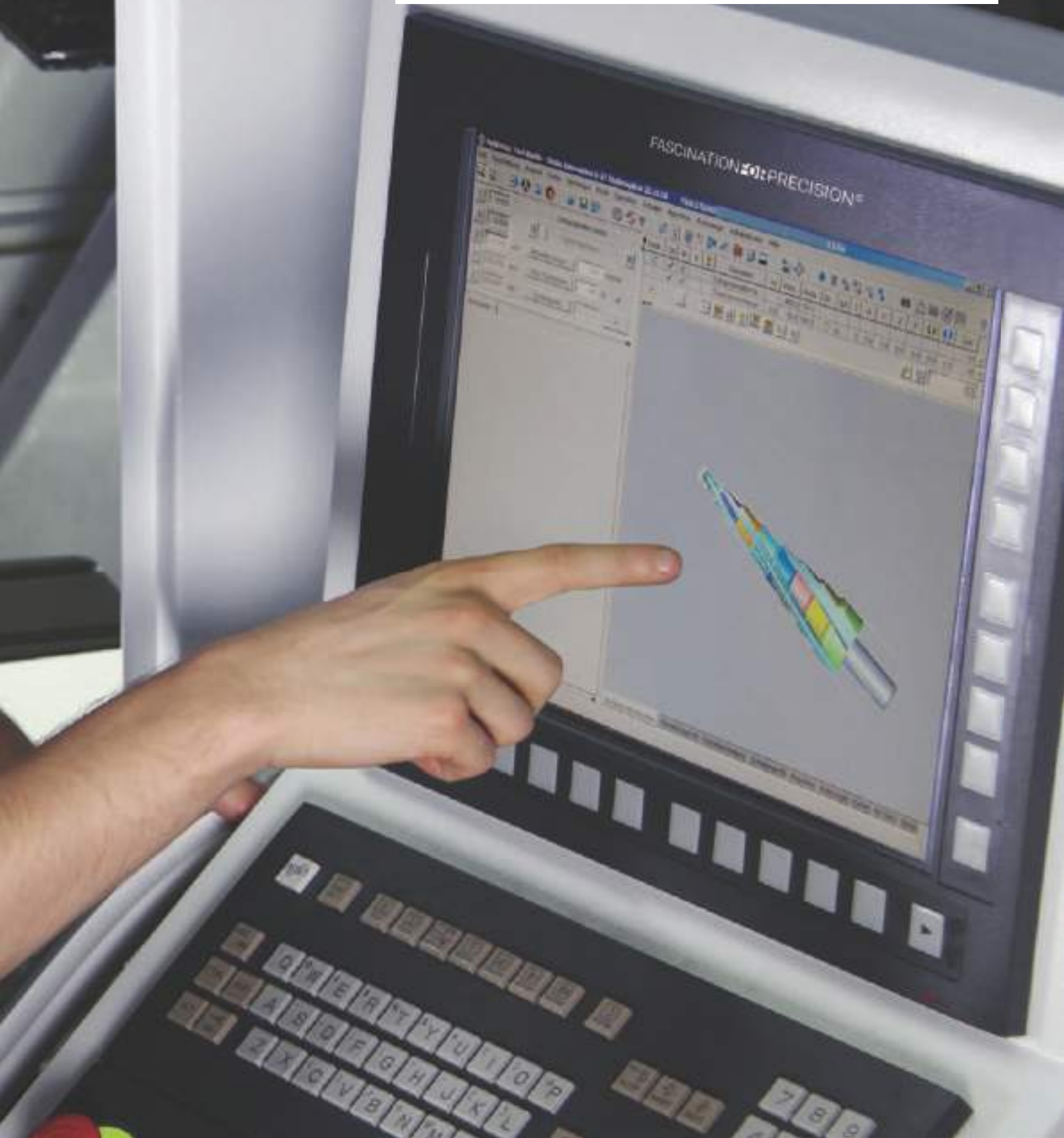
Precision Tools for Metal Cutting.

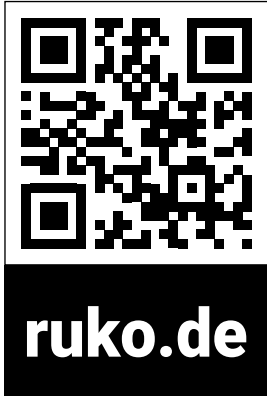
Since 1974 we specialize in the production of drilling, countersinking, and cutting tools. The high-quality precision tools from our production facility in Germany provide high-performance tools for the professional user in industry and trade.

We are your reliable partner in the field of metal cutting.
Our drive is our fascination.

Fascination for Precision.

Our fascination for solutions for metal cutting drives us.
It turns metal into not just a tool, but a precision tool
that bears the name of RUKO.





The RUKO Website.

The RUKO website focuses on our products and practical support.

Product Finder

Find the right drill for your application with our product finder.

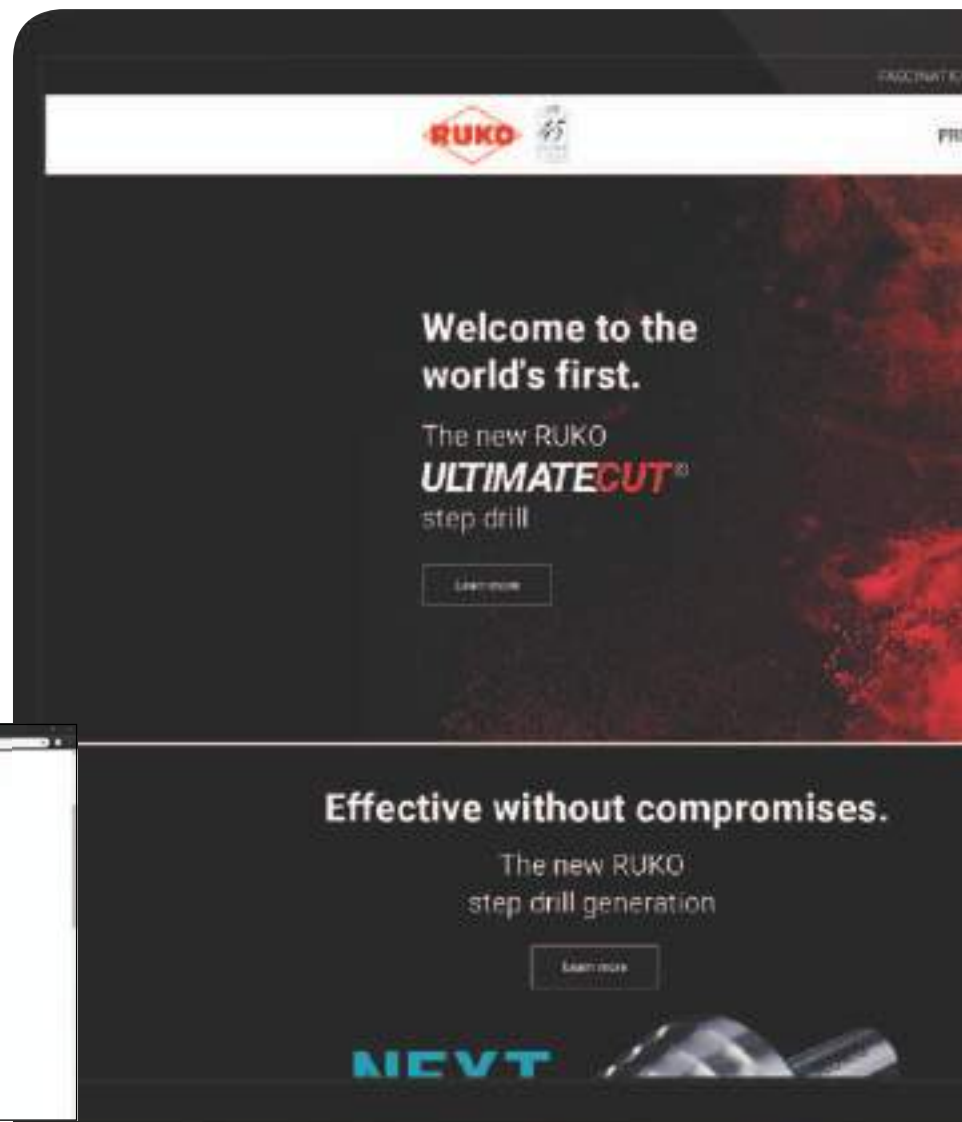


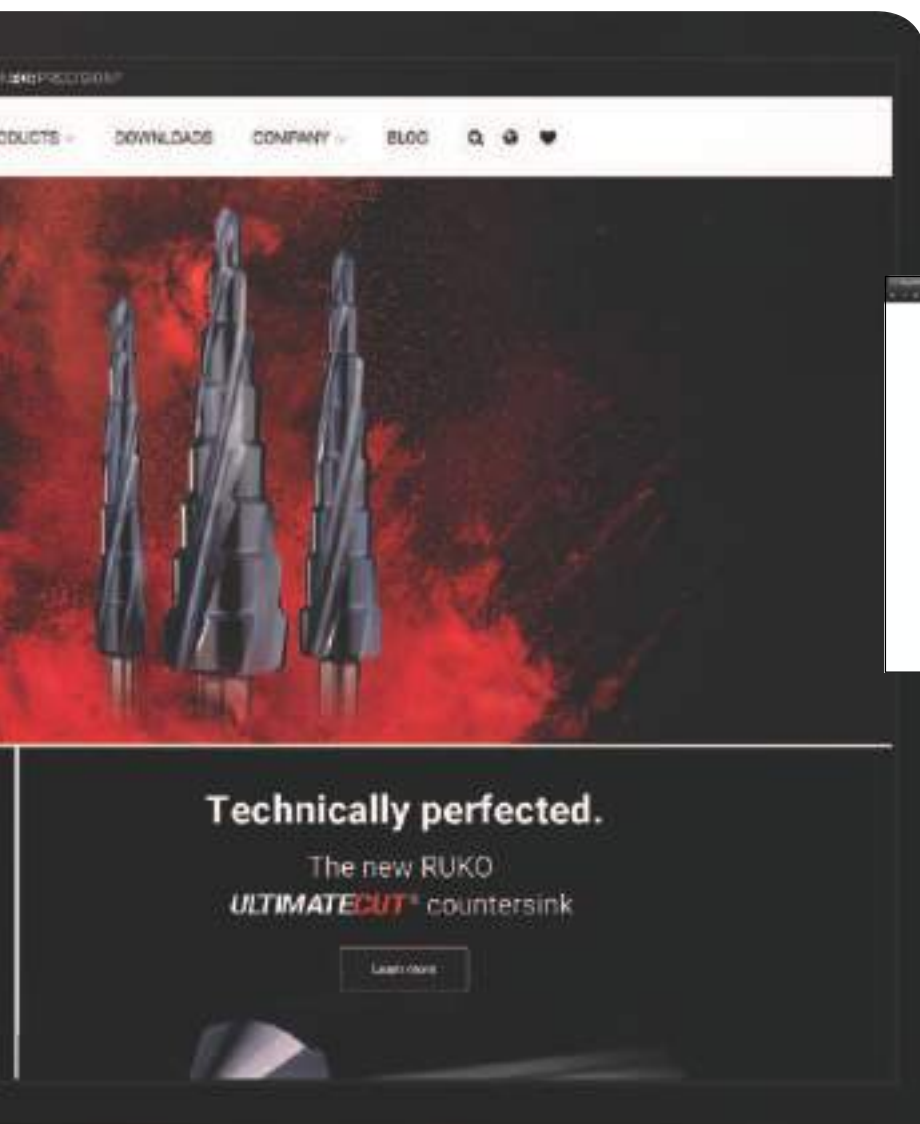
Product Comparison

Add products to the watchlist and compare them with each other.

Downloads

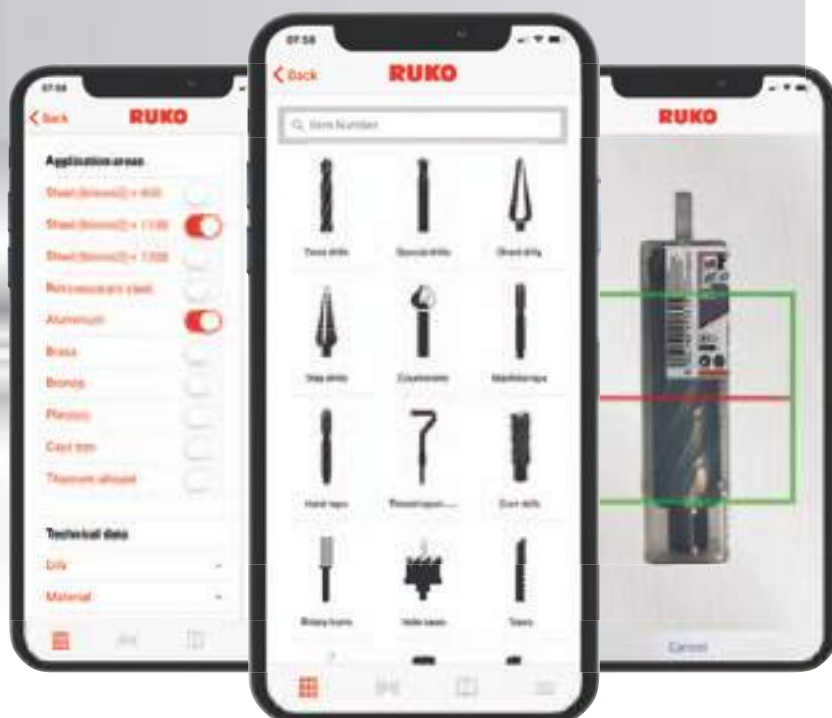
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Blog

Tips, tricks, and useful information about metal cutting.



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Welcome to the world's first.

The new RUKO
ULTIMATECUT®
step drill

from page 92

The **ULTIMATECUT** line from RUKO offers the industry and the professional user innovative and high-quality precision tools, for the most demanding applications.

OUT NOW



The image features three RUKO countersink bits of varying sizes. They are positioned vertically, with the largest bit in the center and two smaller ones on either side. The bits are made of a polished, metallic material, likely steel or titanium, and have a distinctive conical shape with a sharp point. The background is a dark, textured surface with a prominent red, almost lava-like, pattern that contrasts sharply with the metallic bits.

ULTIMATECUT[®]

**Technically
perfected.**

The new RUKO
ULTIMATECUT[®]
countersink

from page 112

RUKO nano Technology coating

pages 92 + 112

- extremely high wear resistance
 - applicable for normal and high-performance cutting
 - no material welding
- perfect and smooth surface
- extremely high nano-hardness



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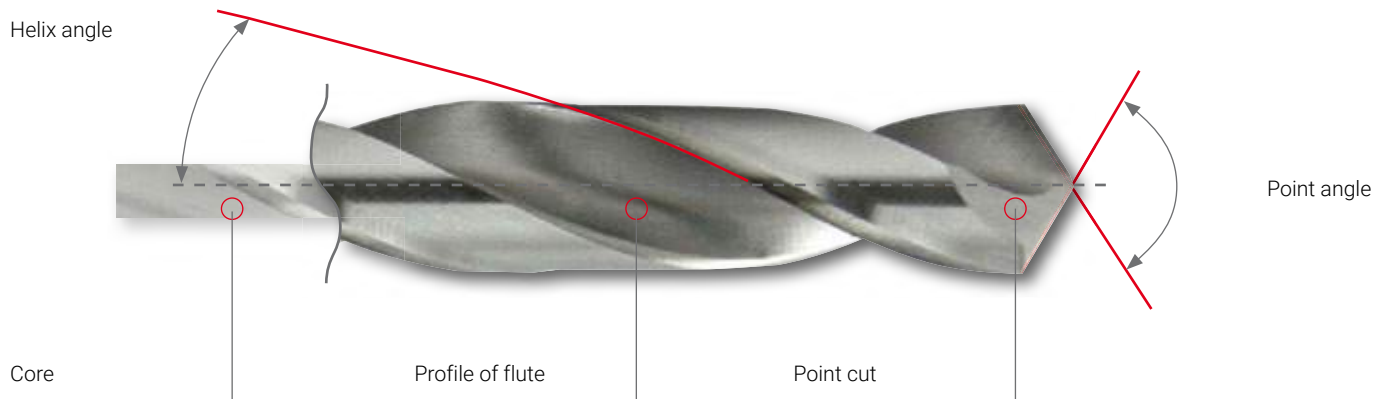


TWIST DRILLS

FASCINATION  PRECISION®

Overview of symbols

N	Helix angle: Profile of flute: Core: Point angle:	25-30° normal normal 118°	DIN 333	Centre drills 60° - shape A and R
TL 3000	Helix angle: Profile of flute: Core: Point angle: Point cut:	40° wide with rounded rear edges thick 130° shape C	DIN 345	Twist drills with morse taper shank
UTL 3000	Helix angle: Profile of flute: Core: Point angle: Point cut:	40° wide with rounded rear edges very thick 130° shape U	DIN 338	Short twist drills with straight shank
TURBO	Helix angle: Profile of flute: Core: Centre angle: Point cut:	36° normal thickened 130° shape C	DIN 1869	Extra long twist drills with straight shank
UNI	Helix angle: Profile of flute: Core: Point angle: Point cut:	40° wide, for better chip removal normal 135° shape C	DIN 340	Long twist drills with straight shank
VA	Helix angle: Profile of flute: Core: Point angle: Point cut:	36° normal thickened 130° shape C	DIN 1897	Extra short twist drills with straight shank
KV	Helix angle: Profile of flute: Core: Point angle: Point cut:	25-30° normal normal 130° shape C		



Point cuts in accordance with DIN 1412



Shape N: Helical point normal ground

Applications: for all normal drilling work in steel, non-ferrous metal and plastic. The point angles depend on the ease with which the materials can be cut. Advantages: powerful main cut, resistant to impact and lateral forces. Simple manual grinding possible. Disadvantages: broad cutting edge requires considerable pressure.



Shape A: Cut chisel edge

Applications: for all normal drilling work using drills with a strong core, for drilling into solid materials with larger drill diameters. Advantages: good centring when starting to drill, as the length of the chisel edge is reduced to 1/10 of the drill diameter, and fewer pressure is required. Disadvantages: additional regrinding work.



Shape B: Cut chisel edge with corrected major cutting edge

Applications: for drilling high-density steel, for manganese steel with over 10 % Mn, for hard spring steel and for drilling out. Advantages: resistant to impact, one-way load and lateral forces. Does not catch in thin workpieces. Disadvantages: high pressure required, tendency to slip, extra work involved in regrinding.



Shape C: Split point

Applications: for drills with very strong cores, for particularly tough, hard materials and for deep-hole drills. Advantages: good centring, little pressure required. Chip spreading improves chip removal. Disadvantages: perfect grinding only possible by machine.



Shape D: Ground for grey cast iron

Applications: for drilling grey cast iron, malleable cast iron and forgings. Advantages: wear on cutting corners is reduced by extended major cutting edges, resistant to impact, good heat conductivity, all giving improved tool life. Disadvantages: extra work involved in regrinding.



Shape E: Centre point

Applications: for drilling sheet-metal and soft materials, for blind holes with flat bottoms. Advantages: good centring, minimal formation of burrs when through-drilling, precise drilling in thin sheets and pipes, does not catch. Available in diameters of 2.5 mm upwards. Disadvantages: sensitive to impact and one-way loading. Can only be ground to perfection by machine.

Other point cuts










































































































































































Shape U: Special ground

Applications: for drills with sturdy profiles suitable for use in automated processing, with narrow grooves and strong cores. Advantages: extremely good self-centring behaviour when maximum cutting velocities are employed. Concave cutting produces short metal chips. Disadvantages: extra work involved in regrinding.

Range and applications overview:













Material	Surface	DIN	Shape	Point cuts	Point angle	Helix angle	Shank	Ø mm	Article no.	Page
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HSSE Co 8	TiAlN	DIN 338	VA					1,0 - 16,0	281 010 EF - 281 160 EF	22 - 25
HSSE Co 5		DIN 338	UTL 3000					1,0 - 16,0	229 010 - 229 160	26 - 29
HSSE Co 5	TiAlN	DIN 338	UTL 3000					1,0 - 16,0	229 010 F - 229 160 F	26 - 29
HSSE Co 5		DIN 338	VA					1,0 - 20,0	215 010 - 215 210	30 - 31
HSSE Co 5		DIN 338	VA					1,0 - 14,0	215 010 Z - 215 140 Z	32 - 33
HSSE Co 5	TiAlN	DIN 338	VA					1,0 - 14,0	215 010 F - 215 140 F	32 - 33
HSSE Co 5		DIN 338	UNI					1,0 - 13,0	228 010 - 228 130	34 - 35
HSS-G		DIN 338	TL 3000					1,0 - 16,0	258 010 - 258 160	36 - 38
HSS-G	TiN	DIN 338	TL 3000					1,0 - 16,0	258 010 T - 258 160 T	36 - 38
HSS-G	TiAlN	DIN 338	TL 3000					1,0 - 16,0	258 010 F - 258 160 F	36 - 38
HSS-G		DIN 338	TURBO					1,0 - 13,0	2146 010 - 2146 130	39 - 40
HSS-G		DIN 338	N					0,3 - 20,0	214 003 - 214 201	41 - 44
HSS-G		DIN 338	N					0,3 - 16,0	214 003 S - 214 160 S	41 - 44
HSS-G	TiN	DIN 338	N					0,3 - 16,0	250 003 T - 250 160 T	41 - 44
HSS-G		DIN 338	N					1,0 - 13,0	214 010 Li - 214 130 Li	45
HSS-G		DIN 338	N					1,0 - 13,0	2501 010 T - 2501 130 T	46
HSS-R		DIN 338	N					0,3 - 20,0	201 003 - 201 200	48 - 49
HSS-R		DIN 338	N					10,5 - 25,0	200 105 - 200 250	50
HSS-G		DIN 338	N					10,5 - 20,0	200 4 105 - 200 4 200	50
HSSE Co 5		DIN 338	N					10,5 - 20,0	200 5 105 - 200 5 200	50
TC	TiAlN	DIN 338	N					3,0 - 13,0	814 030 - 814 130	51

Steel (N/mm ²) < 900 	Steel (N/mm ²) < 1100 	Steel (N/mm ²) < 1300 	Stainless steel 	Aluminium 	Brass 	Bronze 	Plastics 	Cast iron 	Titanium alloyed 
									
									
									
									
									
									
									
									
									
									
									
									
									
									
									
									
									
									
									
									
									

Range and applications overview:



























































Material	Surface	DIN	Shape	Point cuts	Point angle	Helix angle	Shank	Ø mm	Article no.	Page
TC		DIN 338	N		120°	25-30°		2,0 - 13,0	815 020 - 815 130	52 - 53
TC	Tecrona	DIN 338	N		120°	25-30°		2,0 - 13,0	815 020 C - 815 130 C	52 - 53
HSS-G		DIN 338	TL 3000		130°	40°		1/16 - 1/2	258 801 - 258 829	54
HSS-G	TiN	DIN 338	TL 3000		130°	40°		1/16 - 1/2	258 801 T - 258 829 T	54
HSS-G	TiAlN	DIN 338	TL 3000		130°	40°		1/16 - 1/2	258 801 F - 258 829 F	54
HSSE Co 5		DIN 338	UTL 3000		130°	40°		1/16 - 1/2	229 801 - 229 829	55
HSSE Co 5		DIN 338	VA		≥ Ø 2,0 mm 130°	36°		1/16 - 1/2	215 801 - 215 829	56
HSS-G		DIN 338	N		≥ Ø 2,0 mm 118°	25-30°		1/16 - 1/2	214 801 - 214 829	57
HSS-G	TiN	DIN 338	N		≥ Ø 2,0 mm 118°	25-30°		1/16 - 1/2	250 801 T - 250 829 T	57
HSSE Co 5		DIN 340	TL 3000		130°	40°		2,5 - 13,0	253 025 - 253 130	58 - 59
HSSE Co 5	TiAlN	DIN 340	TL 3000		130°	40°		2,5 - 13,0	253 025 F - 253 130 F	58 - 59
HSS-G		DIN 340	N		118°	25-30°		2,5 - 13,0	203 025 - 203 130	60 - 61
HSS-G	TiN	DIN 340	N		118°	25-30°		2,5 - 13,0	203 025 T - 203 130 T	60 - 61
HSS-G		DIN 1869	TL 3000		130°	40°		2,0 - 13,0	254 020 - 254 130	62 - 63
HSS-G		DIN 1869	TL 3000		130°	40°		3,0 - 13,0	255 030 - 255 130	62 - 63
HSS-G		DIN 1869	TL 3000		130°	40°		3,5 - 13,0	256 035 - 256 130	62 - 63
HSS		DIN 345	N		118°	20-30°		10,0 - 60,0	204 100 - 204 600	64 - 65
HSSE Co 5		DIN 345	N		118°	20-30°		10,0 - 30,0	204 100 E - 204 300 E	64 - 65
HSSE Co 5	TiN	DIN 345	N		118°	20-30°		10,0 - 30,0	204 100 T - 204 300 T	64 - 65
HSS-G		DIN 1897	N		≥ Ø 2,5 mm 118°	25-30°		2,0 - 13,0	202 020 - 202 130	66 - 67
HSS-G	TiN	DIN 1897	N		≥ Ø 2,5 mm 118°	25-30°		2,0 - 13,0	202 020 T - 202 130 T	66 - 67
HSS		DIN 333	A		120°	60°		0,8 - 6,3	217 008 - 217 063	67

Steel (N/mm ²) < 900 	Steel (N/mm ²) < 1100 	Steel (N/mm ²) < 1300 	Stainless steel 	Aluminium für / for ALU 	Brass 	Bronze 	Plastics 	Cast iron 	Titanium alloyed Ti 
■	■	□	■	■	■	□	■	■	□
■	■	□	■	■	■	■	■	■	■
■				■	■	□	■	□	
■	□		□		■	□	■	□	
■	■		■	■	■	■	■	□	
■	■		■	■	■	□	■	□	
■	■		■	■	■	□	■	□	
■				■	■	□	■	□	
■	□		□		■	□	■	□	
■	□		■	■	■	□	■	□	
■	■	□	■	■	■	■	■	□	
■				■	■	□	■	□	
■	□		□		■	□	■	□	
■				■	■	□	■	□	
■				■	■	□	■	□	
■				■	■	□	■	□	
■				■	■	□	■	□	
■	■		■	■	■	□	■	□	
■	■	□	■		■	□	■	□	□
■				■	■	□	■	□	
■	□		□		■	□	■	□	
■				■	■	□	■	□	

Range and applications overview:



Material	Surface	DIN	Shape	Point cuts	Point angle	Helix angle	Shank	Ø mm	Article no.	Page
HSS		DIN 333	A+		120°	60°		0,8 - 6,3	217 1 008 - 217 1 063	67
HSS		DIN 333	R		120°	60°		0,8 - 6,3	217 2 008 - 217 2 063	67
HSSE Co 5		DIN 1897	N		130°	25-30°		2,0 - 13,0	202 020 E - 202 130 E	68
HSSE Co 5	TiAlN	DIN 1897	N		130°	25-30°		2,0 - 13,0	202 020 EF - 202 130 EF	68
HSS-G			N		118°	25-30°		4,9 - 5,8	257 515 - 257 583	69
HSS-G			N		130°	25-30°		2,5 - 6,5	251 025 - 251 065	70
HSS-G			KV		130°	25-30°		2,5 - 8,0	252 025 - 252 065	71

Steel (N/mm ²) < 900 	Steel (N/mm ²) < 1100 	Steel (N/mm ²) < 1300 	Stainless steel 	Aluminium für / for ALU 	Brass 	Bronze 	Plastics 	Cast iron 	Titanium alloyed Ti 
									
									
									
									
									
									
									



Twist drills DIN 338 type VA, HSSE-Co 8 ground

Powerful special drill that should ideally be used for titanium base alloys as well as stainless, acid-resistant and heat-resistant austenitic steels. It is also suitable for high strength steels with low ductility. Under certain conditions, these drills can be used for special alloys such as hastelloy, inconel and nimonic etc.




Packing unit: in plastic box

Steel (N/mm2) < 900			
Steel (N/mm2) < 1100			
Steel (N/mm2) < 1300			
Rust-resistant steel			
Aluminium			
Brass			
Bronze			
Plastics			
Cast iron			
Titanium alloyed			



Ø mm	L1 mm	L2 mm	HSSE Co 8		
1,00	34,0	12,0	281 010 E	10	
1,10	36,0	14,0	281 011 E	10	
1,20	38,0	16,0	281 012 E	10	
1,30	38,0	16,0	281 013 E	10	
1,40	40,0	18,0	281 014 E	10	
1,50	40,0	18,0	281 015 E	10	
1,60	43,0	20,0	281 016 E	10	
1,70	43,0	20,0	281 017 E	10	
1,80	46,0	22,0	281 018 E	10	
1,90	46,0	22,0	281 019 E	10	
2,00	49,0	24,0	281 020 E	10	
2,10	49,0	24,0	281 021 E	10	
2,20	53,0	27,0	281 022 E	10	
2,30	53,0	27,0	281 023 E	10	
2,40	57,0	30,0	281 024 E	10	
2,50	57,0	30,0	281 025 E	10	
2,60	57,0	30,0	281 026 E	10	
2,70	61,0	33,0	281 027 E	10	
2,80	61,0	33,0	281 028 E	10	
2,90	61,0	33,0	281 029 E	10	
3,00	61,0	33,0	281 030 E	10	
3,10	65,0	36,0	281 031 E	10	
3,20	65,0	36,0	281 032 E	10	
3,30	65,0	36,0	281 033 E	10	
3,40	70,0	39,0	281 034 E	10	
3,50	70,0	39,0	281 035 E	10	
3,60	70,0	39,0	281 036 E	10	
3,70	70,0	39,0	281 037 E	10	
3,80	75,0	43,0	281 038 E	10	
3,90	75,0	43,0	281 039 E	10	
4,00	75,0	43,0	281 040 E	10	
4,10	75,0	43,0	281 041 E	10	
4,20	75,0	43,0	281 042 E	10	
4,30	80,0	47,0	281 043 E	10	
4,40	80,0	47,0	281 044 E	10	
4,50	80,0	47,0	281 045 E	10	
4,60	80,0	47,0	281 046 E	10	
4,70	80,0	47,0	281 047 E	10	
4,80	86,0	52,0	281 048 E	10	
4,90	86,0	52,0	281 049 E	10	

HSSE Co 8	TiAIN	
281 010 EF	10	
281 011 EF	10	
281 012 EF	10	
281 013 EF	10	
281 014 EF	10	
281 015 EF	10	
281 016 EF	10	
281 017 EF	10	
281 018 EF	10	
281 019 EF	10	
281 020 EF	10	
281 021 EF	10	
281 022 EF	10	
281 023 EF	10	
281 024 EF	10	
281 025 EF	10	
281 026 EF	10	
281 027 EF	10	
281 028 EF	10	
281 029 EF	10	
281 030 EF	10	
281 031 EF	10	
281 032 EF	10	
281 033 EF	10	
281 034 EF	10	
281 035 EF	10	
281 036 EF	10	
281 037 EF	10	
281 038 EF	10	
281 039 EF	10	
281 040 EF	10	
281 041 EF	10	
281 042 EF	10	
281 043 EF	10	
281 044 EF	10	
281 045 EF	10	
281 046 EF	10	
281 047 EF	10	
281 048 EF	10	
281 049 EF	10	

Ø mm	L1 mm	L2 mm	HSSE Co 8			HSSE Co 8	TiAIN	
5,00	86,0	52,0	281 050 E	10		281 050 EF	10	
5,10	86,0	52,0	281 051 E	10		281 051 EF	10	
5,20	86,0	52,0	281 052 E	10		281 052 EF	10	
5,30	86,0	52,0	281 053 E	10		281 053 EF	10	
5,40	93,0	57,0	281 054 E	10		281 054 EF	10	
5,50	93,0	57,0	281 055 E	10		281 055 EF	10	
5,60	93,0	57,0	281 056 E	10		281 056 EF	10	
5,70	93,0	57,0	281 057 E	10		281 057 EF	10	
5,80	93,0	57,0	281 058 E	10		281 058 EF	10	
5,90	93,0	57,0	281 059 E	10		281 059 EF	10	
6,00	93,0	57,0	281 060 E	10		281 060 EF	10	
6,10	101,0	63,0	281 061 E	10		281 061 EF	10	
6,20	101,0	63,0	281 062 E	10		281 062 EF	10	
6,30	101,0	63,0	281 063 E	10		281 063 EF	10	
6,40	101,0	63,0	281 064 E	10		281 064 EF	10	
6,50	101,0	63,0	281 065 E	10		281 065 EF	10	
6,60	101,0	63,0	281 066 E	10		281 066 EF	10	
6,70	101,0	63,0	281 067 E	10		281 067 EF	10	
6,80	109,0	69,0	281 068 E	10		281 068 EF	10	
6,90	109,0	69,0	281 069 E	10		281 069 EF	10	
7,00	109,0	69,0	281 070 E	10		281 070 EF	10	
7,10	109,0	69,0	281 071 E	10		281 071 EF	10	
7,20	109,0	69,0	281 072 E	10		281 072 EF	10	
7,30	109,0	69,0	281 073 E	10		281 073 EF	10	
7,40	109,0	69,0	281 074 E	10		281 074 EF	10	
7,50	109,0	69,0	281 075 E	10		281 075 EF	10	
7,60	117,0	75,0	281 076 E	10		281 076 EF	10	
7,70	117,0	75,0	281 077 E	10		281 077 EF	10	
7,80	117,0	75,0	281 078 E	10		281 078 EF	10	
7,90	117,0	75,0	281 079 E	10		281 079 EF	10	
8,00	117,0	75,0	281 080 E	10		281 080 EF	10	
8,10	117,0	75,0	281 081 E	10		281 081 EF	10	
8,20	117,0	75,0	281 082 E	10		281 082 EF	10	
8,30	117,0	75,0	281 083 E	10		281 083 EF	10	
8,40	117,0	75,0	281 084 E	10		281 084 EF	10	
8,50	117,0	75,0	281 085 E	10		281 085 EF	10	
8,60	125,0	81,0	281 086 E	10		281 086 EF	10	
8,70	125,0	81,0	281 087 E	10		281 087 EF	10	
8,80	125,0	81,0	281 088 E	10		281 088 EF	10	
8,90	125,0	81,0	281 089 E	10		281 089 EF	10	
9,00	125,0	81,0	281 090 E	10		281 090 EF	10	
9,10	125,0	81,0	281 091 E	10		281 091 EF	10	
9,20	125,0	81,0	281 092 E	10		281 092 EF	10	
9,30	125,0	81,0	281 093 E	10		281 093 EF	10	
9,40	125,0	81,0	281 094 E	10		281 094 EF	10	
9,50	125,0	81,0	281 095 E	10		281 095 EF	10	
9,60	133,0	87,0	281 096 E	10		281 096 EF	10	
9,70	133,0	87,0	281 097 E	10		281 097 EF	10	
9,80	133,0	87,0	281 098 E	10		281 098 EF	10	
9,90	133,0	87,0	281 099 E	10		281 099 EF	10	
10,00	133,0	87,0	281 100 E	10		281 100 EF	10	
10,20	133,0	87,0	281 102 E	10		281 102 EF	10	
10,50	133,0	87,0	281 105 E	5		281 105 EF	5	
11,00	142,0	94,0	281 110 E	5		281 110 EF	5	
11,50	142,0	94,0	281 115 E	5		281 115 EF	5	
12,00	151,0	101,0	281 120 E	5		281 120 EF	5	
12,50	151,0	101,0	281 125 E	5		281 125 EF	5	
13,00	151,0	101,0	281 130 E	5		281 130 EF	5	
13,50	160,0	108,0	281 135 E	5		281 135 EF	5	
14,00	160,0	108,0	281 140 E	5		281 140 EF	5	
14,50	169,0	114,0	281 145 E	5		281 145 EF	5	
15,00	169,0	114,0	281 150 E	5		281 150 EF	5	
15,50	178,0	120,0	281 155 E	5		281 155 EF	5	
16,00	178,0	120,0	281 160 E	5		281 160 EF	5	

Twist drill sets DIN 338 type VA, HSSE-Co 8 ground

	<div>HSSE Co 8</div> <div></div>	<div>HSSE Co 8</div> <div>TiAlN</div>
19-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	281 214 E	281 214 EF
25-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	281 215 E	281 215 EF
19-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	281 214 ERO	281 214 EFRO
25-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	281 215 ERO	281 215 EFRO



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Coolants and lubricants

RUKO high performance coolants and lubricants with outstanding cooling and anti-separation qualities. Increases tool life even with hard and brittle materials. High heat resistance ensures good lubrication and cooling, even at high temperatures. Good adhesion quality improves lubrication.

For all standard metal working processes, such as drilling, thread cutting, countersinking, deburring, sawing, turning, milling, grinding.

Perfectly matched for use with RUKO metal working tools.
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DIN 338 · VA





Twist drills DIN 338 UTL 3000, HSSE-Co 5 ground

Highly stable multirange drill with outstanding heat resistance, a reinforced drill core and a parabolic flute for ideal chip removal. Ideal for drilling medium and long-chipping materials.

Thanks to its thick core and the special flute with a rounded rear edge, this drill is best suited for high-performance use. It covers types N, H and W for a wide range of applications.




Packing unit: in plastic box

Steel (N/mm2) < 900		
Steel (N/mm2) < 1100		
Steel (N/mm2) < 1300		
Rust-resistant steel		
Aluminium		
Brass		
Bronze		
Plastics		
Cast iron		
Titanium alloyed		



Ø mm	L1 mm	L2 mm	HSSE Co 5	
1,00	34,0	12,0	229 010	10
1,50	40,0	18,0	229 015	10
2,00	49,0	24,0	229 020	10
2,10	49,0	24,0	229 021	10
2,20	53,0	27,0	229 022	10
2,30	53,0	27,0	229 023	10
2,40	57,0	30,0	229 024	10
2,50	57,0	30,0	229 025	10
2,60	57,0	30,0	229 026	10
2,70	61,0	33,0	229 027	10
2,80	61,0	33,0	229 028	10
2,90	61,0	33,0	229 029	10
3,00	61,0	33,0	229 030	10
3,10	65,0	36,0	229 031	10
3,20	65,0	36,0	229 032	10
3,30	65,0	36,0	229 033	10
3,40	70,0	39,0	229 034	10
3,50	70,0	39,0	229 035	10
3,60	70,0	39,0	229 036	10
3,70	70,0	39,0	229 037	10
3,80	75,0	43,0	229 038	10
3,90	75,0	43,0	229 039	10
4,00	75,0	43,0	229 040	10
4,10	75,0	43,0	229 041	10
4,20	75,0	43,0	229 042	10
4,30	80,0	47,0	229 043	10
4,40	80,0	47,0	229 044	10
4,50	80,0	47,0	229 045	10
4,60	80,0	47,0	229 046	10
4,70	80,0	47,0	229 047	10
4,80	86,0	52,0	229 048	10
4,90	86,0	52,0	229 049	10
5,00	86,0	52,0	229 050	10
5,10	86,0	52,0	229 051	10
5,20	86,0	52,0	229 052	10
5,30	86,0	52,0	229 053	10
5,40	93,0	57,0	229 054	10
5,50	93,0	57,0	229 055	10
5,60	93,0	57,0	229 056	10
5,70	93,0	57,0	229 057	10

HSSE Co 5	TITAN	
229 010 F		10
229 015 F		10
229 020 F		10
229 021 F		10
229 022 F		10
229 023 F		10
229 024 F		10
229 025 F		10
229 026 F		10
229 027 F		10
229 028 F		10
229 029 F		10
229 030 F		10
229 031 F		10
229 032 F		10
229 033 F		10
229 034 F		10
229 035 F		10
229 036 F		10
229 037 F		10
229 038 F		10
229 039 F		10
229 040 F		10
229 041 F		10
229 042 F		10
229 043 F		10
229 044 F		10
229 045 F		10
229 046 F		10
229 047 F		10
229 048 F		10
229 049 F		10
229 050 F		10
229 051 F		10
229 052 F		10
229 053 F		10
229 054 F		10
229 055 F		10
229 056 F		10
229 057 F		10

Ø mm	L1 mm	L2 mm	HSSE Co 5			HSSE Co 5	TAIN	
5,80	93,0	57,0	229 058	10		229 058 F	10	
5,90	93,0	57,0	229 059	10		229 059 F	10	
6,00	93,0	57,0	229 060	10		229 060 F	10	
6,10	101,0	63,0	229 061	10		229 061 F	10	
6,20	101,0	63,0	229 062	10		229 062 F	10	
6,30	101,0	63,0	229 063	10		229 063 F	10	
6,40	101,0	63,0	229 064	10		229 064 F	10	
6,50	101,0	63,0	229 065	10		229 065 F	10	
6,60	101,0	63,0	229 066	10		229 066 F	10	
6,70	101,0	63,0	229 067	10		229 067 F	10	
6,80	109,0	69,0	229 068	10		229 068 F	10	
6,90	109,0	69,0	229 069	10		229 069 F	10	
7,00	109,0	69,0	229 070	10		229 070 F	10	
7,10	109,0	69,0	229 071	10		229 071 F	10	
7,20	109,0	69,0	229 072	10		229 072 F	10	
7,30	109,0	69,0	229 073	10		229 073 F	10	
7,40	109,0	69,0	229 074	10		229 074 F	10	
7,50	109,0	69,0	229 075	10		229 075 F	10	
7,60	117,0	75,0	229 076	10		229 076 F	10	
7,70	117,0	75,0	229 077	10		229 077 F	10	
7,80	117,0	75,0	229 078	10		229 078 F	10	
7,90	117,0	75,0	229 079	10		229 079 F	10	
8,00	117,0	75,0	229 080	10		229 080 F	10	
8,10	117,0	75,0	229 081	10		229 081 F	10	
8,20	117,0	75,0	229 082	10		229 082 F	10	
8,30	117,0	75,0	229 083	10		229 083 F	10	
8,40	117,0	75,0	229 084	10		229 084 F	10	
8,50	117,0	75,0	229 085	10		229 085 F	10	
8,60	125,0	81,0	229 086	10		229 086 F	10	
8,70	125,0	81,0	229 087	10		229 087 F	10	
8,80	125,0	81,0	229 088	10		229 088 F	10	
8,90	125,0	81,0	229 089	10		229 089 F	10	
9,00	125,0	81,0	229 090	10		229 090 F	10	
9,10	125,0	81,0	229 091	10		229 091 F	10	
9,20	125,0	81,0	229 092	10		229 092 F	10	
9,30	125,0	81,0	229 093	10		229 093 F	10	
9,40	125,0	81,0	229 094	10		229 094 F	10	
9,50	125,0	81,0	229 095	10		229 095 F	10	
9,60	133,0	87,0	229 096	10		229 096 F	10	
9,70	133,0	87,0	229 097	10		229 097 F	10	
9,80	133,0	87,0	229 098	10		229 098 F	10	
9,90	133,0	87,0	229 099	10		229 099 F	10	
10,00	133,0	87,0	229 100	10		229 100 F	10	
10,10	133,0	87,0	229 101	10		229 101 F	10	
10,20	133,0	87,0	229 102	10		229 102 F	10	
10,30	133,0	87,0	229 103	5		229 103 F	5	
10,40	133,0	87,0	229 104	5		229 104 F	5	
10,50	133,0	87,0	229 105	5		229 105 F	5	
10,60	133,0	87,0	229 106	5		229 106 F	5	
10,70	142,0	94,0	229 107	5		229 107 F	5	
10,80	142,0	94,0	229 108	5		229 108 F	5	
10,90	142,0	94,0	229 109	5		229 109 F	5	
11,00	142,0	94,0	229 110	5		229 110 F	5	
11,10	142,0	94,0	229 111	5		229 111 F	5	
11,20	142,0	94,0	229 112	5		229 112 F	5	
11,30	142,0	94,0	229 113	5		229 113 F	5	
11,40	142,0	94,0	229 114	5		229 114 F	5	
11,50	142,0	94,0	229 115	5		229 115 F	5	
11,60	142,0	94,0	229 116	5		229 116 F	5	
11,70	142,0	94,0	229 117	5		229 117 F	5	
11,80	142,0	94,0	229 118	5		229 118 F	5	
11,90	151,0	101,0	229 119	5		229 119 F	5	
12,00	151,0	101,0	229 120	5		229 120 F	5	
12,10	151,0	101,0	229 121	5		229 121 F	5	
12,20	151,0	101,0	229 122	5		229 122 F	5	
12,30	151,0	101,0	229 123	5		229 123 F	5	
12,40	151,0	101,0	229 124	5		229 124 F	5	
12,50	151,0	101,0	229 125	5		229 125 F	5	
12,60	151,0	101,0	229 126	5		229 126 F	5	
12,70	151,0	101,0	229 127	5		229 127 F	5	
12,80	151,0	101,0	229 128	5		229 128 F	5	
12,90	151,0	101,0	229 129	5		229 129 F	5	
13,00	151,0	101,0	229 130	5		229 130 F	5	
13,50	160,0	108,0	229 135	5		229 135 F	5	

Twist drills DIN 338 UTL 3000, HSSE-Co 5 ground

Ø mm	L1 mm	L2 mm	HSSE Co 5			HSSE Co 5	TiAIN	
14,00	160,0	108,0	229 140	5		229 140 F		5
14,50	169,0	114,0	229 145	5		229 145 F		5
15,00	169,0	114,0	229 150	5		229 150 F		5
15,50	178,0	120,0	229 155	5		229 155 F		5
16,00	178,0	120,0	229 160	5		229 160 F		5

Twist drill sets DIN 338 UTL 3000, HSSE-Co 5 ground

	HSSE Co 5		HSSE Co 5	TiAIN
19-piece set of twist drills DIN 338 type UTL 3000 Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	229 214		229 214 F	
25-piece set of twist drills DIN 338 type UTL 3000 Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	229 215		229 215 F	



	HSSE Co 5		HSSE Co 5	TiAIN
19-piece set of twist drills DIN 338 type UTL 3000 Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	229 214 RO		229 214 FRO	
25-piece set of twist drills DIN 338 type UTL 3000 Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	229 215 RO		229 215 FRO	



DIN 338 · UTL 3000





Twist drills DIN 338 type VA, HSSE-Co 5 ground

Powerful right-hand cutting high-performance drill with distinctive heat resistance.
Ideal for drilling high-strength stainless, acid-resistant and heat-resistant steel.

Packing unit: in plastic box

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100	■	Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel	■	Cast iron	□
Aluminium	■	Titanium alloyed	



Ø mm	L1 mm	L2 mm	HSSE Co 5		
1,00	34,0	12,0	215 010	10	
1,10	36,0	14,0	215 011	10	
1,20	38,0	16,0	215 012	10	
1,25	38,0	16,0	215 0125	10	
1,30	38,0	16,0	215 013	10	
1,40	40,0	18,0	215 014	10	
1,50	40,0	18,0	215 015	10	
1,60	43,0	20,0	215 016	10	
1,70	43,0	20,0	215 017	10	
1,75	46,0	22,0	215 0175	10	
1,80	46,0	22,0	215 018	10	
1,90	46,0	22,0	215 019	10	
2,00	49,0	24,0	215 020	10	
2,10	49,0	24,0	215 021	10	
2,20	53,0	27,0	215 022	10	
2,25	53,0	27,0	215 0225	10	
2,30	53,0	27,0	215 023	10	
2,40	57,0	30,0	215 024	10	
2,50	57,0	30,0	215 025	10	
2,60	57,0	30,0	215 026	10	
2,70	61,0	33,0	215 027	10	
2,75	61,0	33,0	215 0275	10	
2,80	61,0	33,0	215 028	10	
2,90	61,0	33,0	215 029	10	
3,00	61,0	33,0	215 030	10	
3,10	65,0	36,0	215 031	10	
3,20	65,0	36,0	215 032	10	
3,25	65,0	36,0	215 0325	10	
3,30	65,0	36,0	215 033	10	
3,40	70,0	39,0	215 034	10	
3,50	70,0	39,0	215 035	10	
3,60	70,0	39,0	215 036	10	
3,70	70,0	39,0	215 037	10	
3,75	70,0	39,0	215 0375	10	
3,80	75,0	43,0	215 038	10	
3,90	75,0	43,0	215 039	10	
4,00	75,0	43,0	215 040	10	
4,10	75,0	43,0	215 041	10	
4,20	75,0	43,0	215 042	10	
4,25	75,0	43,0	215 0425	10	

Ø mm	L1 mm	L2 mm	HSSE Co 5		
4,30	80,0	47,0	215 043	10	
4,40	80,0	47,0	215 044	10	
4,50	80,0	47,0	215 045	10	
4,60	80,0	47,0	215 046	10	
4,70	80,0	47,0	215 047	10	
4,75	80,0	47,0	215 0475	10	
4,80	86,0	52,0	215 048	10	
4,90	86,0	52,0	215 049	10	
5,00	86,0	52,0	215 050	10	
5,10	86,0	52,0	215 051	10	
5,20	86,0	52,0	215 052	10	
5,25	86,0	52,0	215 0525	10	
5,30	86,0	52,0	215 053	10	
5,40	93,0	57,0	215 054	10	
5,50	93,0	57,0	215 055	10	
5,60	93,0	57,0	215 056	10	
5,70	93,0	57,0	215 057	10	
5,75	93,0	57,0	215 0575	10	
5,80	93,0	57,0	215 058	10	
5,90	93,0	57,0	215 059	10	
6,00	93,0	57,0	215 060	10	
6,10	101,0	63,0	215 061	10	
6,20	101,0	63,0	215 062	10	
6,25	101,0	63,0	215 0625	10	
6,30	101,0	63,0	215 063	10	
6,40	101,0	63,0	215 064	10	
6,50	101,0	63,0	215 065	10	
6,60	101,0	63,0	215 066	10	
6,70	101,0	63,0	215 067	10	
6,75	101,0	63,0	215 0675	10	
6,80	109,0	69,0	215 068	10	
6,90	109,0	69,0	215 069	10	
7,00	109,0	69,0	215 070	10	
7,10	109,0	69,0	215 071	10	
7,20	109,0	69,0	215 072	10	
7,25	109,0	69,0	215 0725	10	
7,30	109,0	69,0	215 073	10	
7,40	109,0	69,0	215 074	10	
7,50	109,0	69,0	215 075	10	
7,60	117,0	75,0	215 076	10	



Twist drills DIN 338 type VA, HSSE-Co 5 ground

Ø mm	L1 mm	L2 mm	HSSE Co 5		Ø mm	L1 mm	L2 mm	HSSE Co 5	
7,70	117,0	75,0	215 077	10	10,90	142,0	94,0	215 109	5
7,75	117,0	75,0	215 0775	10	11,00	142,0	94,0	215 110	5
7,80	117,0	75,0	215 078	10	11,10	142,0	94,0	215 111	5
7,90	117,0	75,0	215 079	10	11,20	142,0	94,0	215 112	5
8,00	117,0	75,0	215 080	10	11,30	142,0	94,0	215 113	5
8,10	117,0	75,0	215 081	10	11,40	142,0	94,0	215 114	5
8,20	117,0	75,0	215 082	10	11,50	142,0	94,0	215 115	5
8,25	117,0	75,0	215 0825	10	11,60	142,0	94,0	215 116	5
8,30	117,0	75,0	215 083	10	11,70	142,0	94,0	215 117	5
8,40	117,0	75,0	215 084	10	11,80	142,0	94,0	215 118	5
8,50	117,0	75,0	215 085	10	11,90	151,0	101,0	215 119	5
8,60	125,0	81,0	215 086	10	12,00	151,0	101,0	215 120	5
8,70	125,0	81,0	215 087	10	12,10	151,0	101,0	215 121	5
8,75	125,0	81,0	215 0875	10	12,20	151,0	101,0	215 122	5
8,80	125,0	81,0	215 088	10	12,30	151,0	101,0	215 123	5
8,90	125,0	81,0	215 089	10	12,40	151,0	101,0	215 124	5
9,00	125,0	81,0	215 090	10	12,50	151,0	101,0	215 125	5
9,10	125,0	81,0	215 091	10	12,60	151,0	101,0	215 126	5
9,20	125,0	81,0	215 092	10	12,70	151,0	101,0	215 127	5
9,25	125,0	81,0	215 0925	10	12,80	151,0	101,0	215 128	5
9,30	125,0	81,0	215 093	10	12,90	151,0	101,0	215 129	5
9,40	125,0	81,0	215 094	10	13,00	151,0	101,0	215 130	5
9,50	125,0	81,0	215 095	10	13,50	160,0	108,0	215 135	5
9,60	133,0	87,0	215 096	10	14,00	160,0	108,0	215 140	5
9,70	133,0	87,0	215 097	10	14,50	169,0	114,0	215 145	5
9,75	133,0	87,0	215 0975	10	15,00	169,0	114,0	215 150	5
9,80	133,0	87,0	215 098	10	15,50	178,0	120,0	215 155	5
9,90	133,0	87,0	215 099	10	16,00	178,0	120,0	215 160	5
10,00	133,0	87,0	215 100	10	16,50	184,0	125,0	215 165	1
10,10	133,0	87,0	215 101	10	17,00	184,0	125,0	215 170	1
10,20	133,0	87,0	215 102	10	17,50	191,0	130,0	215 175	1
10,30	133,0	87,0	215 103	10	18,00	191,0	130,0	215 180	1
10,40	133,0	87,0	215 104	10	18,50	198,0	135,0	215 185	1
10,50	133,0	87,0	215 105	5	19,00	198,0	135,0	215 190	1
10,60	133,0	87,0	215 106	5	19,50	205,0	140,0	215 195	1
10,70	142,0	94,0	215 107	5	20,00	205,0	140,0	215 210	1
10,80	142,0	94,0	215 108	5	—	—	—	—	—

Twist drill sets DIN 338 type VA, HSSE-Co 5 ground

	HSSE Co 5
19-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	215 214
25-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	215 215
41-piece set of twist drills DIN 338 type VA Ø 6,0 mm up to 10,0 mm in increments of 0,1 mm in steel case	215 218
50-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 5,9 mm in increments of 0,1 mm in steel case	215 217
19-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	215 214 RO
25-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	215 215 RO





Twist drills DIN 338 type VA, HSSE-Co 5 ground

Powerful right-hand cutting high-performance drill with distinctive heat resistance and reinforced drill core. Ideal for drilling high-strength stainless, acid-resistant and heat-resistant steel.

Packing unit: in plastic box

Steel (N/mm ²) < 900		
Steel (N/mm ²) < 1100		
Steel (N/mm ²) < 1300		
Rust-resistant steel		
Aluminium		

Brass		
Bronze		
Plastics		
Cast iron		
Titanium alloyed		



Ø mm	L1 mm	L2 mm				
1,00	34,0	12,0	215 010 Z	10	215 010 F	10
1,50	40,0	18,0	215 015 Z	10	215 015 F	10
1,90	46,0	22,0	215 019 Z	10	215 019 F	10
2,00	49,0	24,0	215 020 Z	10	215 020 F	10
2,30	53,0	27,0	215 023 Z	10	215 023 F	10
2,50	57,0	30,0	215 025 Z	10	215 025 F	10
2,60	57,0	30,0	215 026 Z	10	215 026 F	10
3,00	61,0	33,0	215 030 Z	10	215 030 F	10
3,20	65,0	36,0	215 032 Z	10	215 032 F	10
3,30	65,0	36,0	215 033 Z	10	215 033 F	10
3,40	70,0	39,0	215 034 Z	10	215 034 F	10
3,50	70,0	39,0	215 035 Z	10	215 035 F	10
4,00	75,0	43,0	215 040 Z	10	215 040 F	10
4,20	75,0	43,0	215 042 Z	10	215 042 F	10
4,30	80,0	47,0	215 043 Z	10	215 043 F	10
4,50	80,0	47,0	215 045 Z	10	215 045 F	10
5,00	86,0	52,0	215 050 Z	10	215 050 F	10
5,10	86,0	52,0	215 051 Z	10	215 051 F	10
5,20	86,0	52,0	215 052 Z	10	215 052 F	10
5,30	86,0	52,0	215 053 Z	10	215 053 F	10
5,50	93,0	57,0	215 055 Z	10	215 055 F	10
6,00	93,0	57,0	215 060 Z	10	215 060 F	10
6,10	101,0	63,0	215 061 Z	10	215 061 F	10
6,20	101,0	63,0	215 062 Z	10	215 062 F	10
6,40	101,0	63,0	215 064 Z	10	215 064 F	10
6,50	101,0	63,0	215 065 Z	10	215 065 F	10
6,80	109,0	69,0	215 068 Z	10	215 068 F	10
7,00	109,0	69,0	215 070 Z	10	215 070 F	10
7,50	109,0	69,0	215 075 Z	10	215 075 F	10
8,00	117,0	75,0	215 080 Z	10	215 080 F	10
8,50	117,0	75,0	215 085 Z	10	215 085 F	10
9,00	125,0	81,0	215 090 Z	10	215 090 F	10
9,50	125,0	81,0	215 095 Z	10	215 095 F	10
9,80	133,0	87,0	215 098 Z	10	215 098 F	10
10,00	133,0	87,0	215 100 Z	10	215 100 F	10
10,50	133,0	87,0	215 105 Z	5	215 105 F	5
11,00	142,0	94,0	215 110 Z	5	215 110 F	5
11,50	142,0	94,0	215 115 Z	5	215 115 F	5
12,00	151,0	101,0	215 120 Z	5	215 120 F	5
12,50	151,0	101,0	215 125 Z	5	215 125 F	5
13,00	151,0	101,0	215 130 Z	5	215 130 F	5
13,50	160,0	108,0	215 135 Z	5	215 135 F	5
14,00	160,0	108,0	215 140 Z	5	215 140 F	5



Twist drill sets DIN 338 type VA, HSSE-Co 5 ground

	HSSE Co 5	HSSE Co 5 TiAIN
19-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	215 214 ZRO	215 214 FRO
25-piece set of twist drills DIN 338 type VA Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	215 215 ZRO	215 215 FRO




Twist drills DIN 338 type UNI, HSSE-Co 5 ground

- » The 3-surface-shank provides an excellent fixing within the drill chuck with little effort. In addition, the shank ensures an ideal power transmission. No spinning of the drill!
- » The 135° high performance cutting edge ensures a very high aligned preciseness, particularly when hand-operated with a cordless drilling machine. The edge prevents sliding off corrugated surfaces whilst spot-drilling.
- » Increased wear resistance of the rechargeable battery due to reduction of cutting forces.
- » The black bevel increases the wear resistance and prevents cold welding and build-up edges.
- » The 40° helix angle enables a perfect and fast chip removal and provides a high cutting speed along with increased stability and accuracy.



High performance twist drill for all-purpose use in drilling machines and cordless drills. (Materials up to 5,0 mm thickness)







	
Steel (N/mm ²) < 900	■
Steel (N/mm ²) < 1100	■
Steel (N/mm ²) < 1300	
Rust-resistant steel	■
Aluminium	■

	
Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	


Packing unit: in plastic box



Ø mm	L1 mm	L2 mm	HSSE Co 5		
1,00	34,0	12,0	228 010	10	
1,50	40,0	18,0	228 015	10	
2,00	49,0	24,0	228 020	10	
2,50	57,0	30,0	228 025	10	
3,00	61,0	33,0	228 030	10	
3,30	65,0	36,0	228 033	10	
3,50	70,0	39,0	228 035	10	
4,00	75,0	43,0	228 040	10	
4,20	75,0	43,0	228 042	10	
4,50	80,0	47,0	228 045	10	
5,00	86,0	52,0	228 050	10	
5,50	93,0	57,0	228 055	10	
6,00	93,0	57,0	228 060	10	
6,50	101,0	63,0	228 065	10	
6,80	109,0	69,0	228 068	10	

Ø mm	L1 mm	L2 mm	HSSE Co 5		
7,00	109,0	69,0	228 070	10	
7,50	109,0	69,0	228 075	10	
8,00	117,0	75,0	228 080	10	
8,50	117,0	75,0	228 085	10	
9,00	125,0	81,0	228 090	10	
9,50	125,0	81,0	228 095	10	
10,00	133,0	87,0	228 100	10	
10,20	133,0	87,0	228 102	10	
10,50	133,0	87,0	228 105	5	
11,00	142,0	94,0	228 110	5	
11,50	142,0	94,0	228 115	5	
12,00	151,0	101,0	228 120	5	
12,50	151,0	101,0	228 125	5	
13,00	151,0	101,0	228 130	5	

Twist drill sets DIN 338 type UNI, HSSE-Co 5 ground

	
19-piece set of twist drills DIN 338 type UNI Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	228 214
25-piece set of twist drills DIN 338 type UNI Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	228 215
19-piece set of twist drills DIN 338 type UNI Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	228 214 RO
25-piece set of twist drills DIN 338 type UNI Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	228 215 RO





DIN 338 • UNI





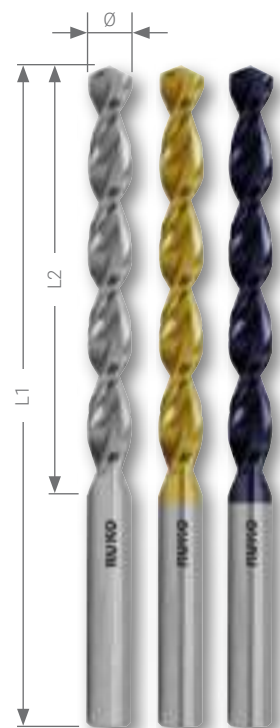
Twist drills DIN 338 TL 3000, HSS ground

Stable multirange drill with reinforced drill core and parabolic flute for ideal chip removal. Ideal for drilling medium and long-chipping materials. Thanks to its thick core and the special flute with a rounded rear edge, this drill is best suited for high-performance use. It covers types N, H and W for a wide range of applications.









Packing unit: in plastic box

Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100		□	■
Steel (N/mm2) < 1300			
Rust-resistant steel		□	■
Aluminium	■		■

Brass	■	■	■
Bronze	□	□	■
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			



Ø mm	L1 mm	L2 mm	HSS-G		HSS-G	TIN		HSS-G	TITAN	
1,00	34,0	12,0	258 010	10	258 010 T	10		258 010 F	10	
1,10	36,0	14,0	258 011	10	258 011 T	10		258 011 F	10	
1,20	38,0	16,0	258 012	10	258 012 T	10		258 012 F	10	
1,30	38,0	16,0	258 013	10	258 013 T	10		258 013 F	10	
1,40	40,0	18,0	258 014	10	258 014 T	10		258 014 F	10	
1,50	40,0	18,0	258 015	10	258 015 T	10		258 015 F	10	
1,60	43,0	20,0	258 016	10	258 016 T	10		258 016 F	10	
1,70	43,0	20,0	258 017	10	258 017 T	10		258 017 F	10	
1,80	46,0	22,0	258 018	10	258 018 T	10		258 018 F	10	
1,90	46,0	22,0	258 019	10	258 019 T	10		258 019 F	10	
2,00	49,0	24,0	258 020	10	258 020 T	10		258 020 F	10	
2,10	49,0	24,0	258 021	10	258 021 T	10		258 021 F	10	
2,20	53,0	27,0	258 022	10	258 022 T	10		258 022 F	10	
2,30	53,0	27,0	258 023	10	258 023 T	10		258 023 F	10	
2,40	57,0	30,0	258 024	10	258 024 T	10		258 024 F	10	
2,50	57,0	30,0	258 025	10	258 025 T	10		258 025 F	10	
2,60	57,0	30,0	258 026	10	258 026 T	10		258 026 F	10	
2,70	61,0	33,0	258 027	10	258 027 T	10		258 027 F	10	
2,80	61,0	33,0	258 028	10	258 028 T	10		258 028 F	10	
2,90	61,0	33,0	258 029	10	258 029 T	10		258 029 F	10	
3,00	61,0	33,0	258 030	10	258 030 T	10		258 030 F	10	
3,10	65,0	36,0	258 031	10	258 031 T	10		258 031 F	10	
3,20	65,0	36,0	258 032	10	258 032 T	10		258 032 F	10	
3,30	65,0	36,0	258 033	10	258 033 T	10		258 033 F	10	
3,40	70,0	39,0	258 034	10	258 034 T	10		258 034 F	10	
3,50	70,0	39,0	258 035	10	258 035 T	10		258 035 F	10	
3,60	70,0	39,0	258 036	10	258 036 T	10		258 036 F	10	
3,70	70,0	39,0	258 037	10	258 037 T	10		258 037 F	10	
3,80	75,0	43,0	258 038	10	258 038 T	10		258 038 F	10	
3,90	75,0	43,0	258 039	10	258 039 T	10		258 039 F	10	
4,00	75,0	43,0	258 040	10	258 040 T	10		258 040 F	10	
4,10	75,0	43,0	258 041	10	258 041 T	10		258 041 F	10	
4,20	75,0	43,0	258 042	10	258 042 T	10		258 042 F	10	
4,30	80,0	47,0	258 043	10	258 043 T	10		258 043 F	10	
4,40	80,0	47,0	258 044	10	258 044 T	10		258 044 F	10	
4,50	80,0	47,0	258 045	10	258 045 T	10		258 045 F	10	
4,60	80,0	47,0	258 046	10	258 046 T	10		258 046 F	10	
4,70	80,0	47,0	258 047	10	258 047 T	10		258 047 F	10	
4,80	86,0	52,0	258 048	10	258 048 T	10		258 048 F	10	
4,90	86,0	52,0	258 049	10	258 049 T	10		258 049 F	10	

Ø mm	L1 mm	L2 mm	HSS-G 		HSS-G 	TiN 		HSS-G 	TiAlN 	
5,00	86,0	52,0	258 050	10	258 050 T	10		258 050 F		10
5,10	86,0	52,0	258 051	10	258 051 T	10		258 051 F		10
5,20	86,0	52,0	258 052	10	258 052 T	10		258 052 F		10
5,30	86,0	52,0	258 053	10	258 053 T	10		258 053 F		10
5,40	93,0	57,0	258 054	10	258 054 T	10		258 054 F		10
5,50	93,0	57,0	258 055	10	258 055 T	10		258 055 F		10
5,60	93,0	57,0	258 056	10	258 056 T	10		258 056 F		10
5,70	93,0	57,0	258 057	10	258 057 T	10		258 057 F		10
5,80	93,0	57,0	258 058	10	258 058 T	10		258 058 F		10
5,90	93,0	57,0	258 059	10	258 059 T	10		258 059 F		10
6,00	93,0	57,0	258 060	10	258 060 T	10		258 060 F		10
6,10	101,0	63,0	258 061	10	258 061 T	10		258 061 F		10
6,20	101,0	63,0	258 062	10	258 062 T	10		258 062 F		10
6,30	101,0	63,0	258 063	10	258 063 T	10		258 063 F		10
6,40	101,0	63,0	258 064	10	258 064 T	10		258 064 F		10
6,50	101,0	63,0	258 065	10	258 065 T	10		258 065 F		10
6,60	101,0	63,0	258 066	10	258 066 T	10		258 066 F		10
6,70	101,0	63,0	258 067	10	258 067 T	10		258 067 F		10
6,80	109,0	69,0	258 068	10	258 068 T	10		258 068 F		10
6,90	109,0	69,0	258 069	10	258 069 T	10		258 069 F		10
7,00	109,0	69,0	258 070	10	258 070 T	10		258 070 F		10
7,10	109,0	69,0	258 071	10	258 071 T	10		258 071 F		10
7,20	109,0	69,0	258 072	10	258 072 T	10		258 072 F		10
7,30	109,0	69,0	258 073	10	258 073 T	10		258 073 F		10
7,40	109,0	69,0	258 074	10	258 074 T	10		258 074 F		10
7,50	109,0	69,0	258 075	10	258 075 T	10		258 075 F		10
7,60	117,0	75,0	258 076	10	258 076 T	10		258 076 F		10
7,70	117,0	75,0	258 077	10	258 077 T	10		258 077 F		10
7,80	117,0	75,0	258 078	10	258 078 T	10		258 078 F		10
7,90	117,0	75,0	258 079	10	258 079 T	10		258 079 F		10
8,00	117,0	75,0	258 080	10	258 080 T	10		258 080 F		10
8,10	117,0	75,0	258 081	10	258 081 T	10		258 081 F		10
8,20	117,0	75,0	258 082	10	258 082 T	10		258 082 F		10
8,30	117,0	75,0	258 083	10	258 083 T	10		258 083 F		10
8,40	117,0	75,0	258 084	10	258 084 T	10		258 084 F		10
8,50	117,0	75,0	258 085	10	258 085 T	10		258 085 F		10
8,60	125,0	81,0	258 086	10	258 086 T	10		258 086 F		10
8,70	125,0	81,0	258 087	10	258 087 T	10		258 087 F		10
8,80	125,0	81,0	258 088	10	258 088 T	10		258 088 F		10
8,90	125,0	81,0	258 089	10	258 089 T	10		258 089 F		10
9,00	125,0	81,0	258 090	10	258 090 T	10		258 090 F		10
9,10	125,0	81,0	258 091	10	258 091 T	10		258 091 F		10
9,20	125,0	81,0	258 092	10	258 092 T	10		258 092 F		10
9,30	125,0	81,0	258 093	10	258 093 T	10		258 093 F		10
9,40	125,0	81,0	258 094	10	258 094 T	10		258 094 F		10
9,50	125,0	81,0	258 095	10	258 095 T	10		258 095 F		10
9,60	133,0	87,0	258 096	10	258 096 T	10		258 096 F		10
9,70	133,0	87,0	258 097	10	258 097 T	10		258 097 F		10
9,80	133,0	87,0	258 098	10	258 098 T	10		258 098 F		10
9,90	133,0	87,0	258 099	10	258 099 T	10		258 099 F		10
10,00	133,0	87,0	258 100	10	258 100 T	10		258 100 F		10
10,10	133,0	87,0	258 101	10	258 101 T	10		258 101 F		10
10,20	133,0	87,0	258 102	10	258 102 T	10		258 102 F		10
10,30	133,0	87,0	258 103	10	258 103 T	10		258 103 F		10
10,40	133,0	87,0	258 104	10	258 104 T	10		258 104 F		10
10,50	133,0	87,0	258 105	5	258 105 T	5		258 105 F		5
10,60	133,0	87,0	258 106	5	258 106 T	5		258 106 F		5
10,70	142,0	94,0	258 107	5	258 107 T	5		258 107 F		5
10,80	142,0	94,0	258 108	5	258 108 T	5		258 108 F		5
10,90	142,0	94,0	258 109	5	258 109 T	5		258 109 F		5
11,00	142,0	94,0	258 110	5	258 110 T	5		258 110 F		5
11,10	142,0	94,0	258 111	5	258 111 T	5		258 111 F		5
11,20	142,0	94,0	258 112	5	258 112 T	5		258 112 F		5
11,30	142,0	94,0	258 113	5	258 113 T	5		258 113 F		5
11,40	142,0	94,0	258 114	5	258 114 T	5		258 114 F		5
11,50	142,0	94,0	258 115	5	258 115 T	5		258 115 F		5
11,60	142,0	94,0	258 116	5	258 116 T	5		258 116 F		5
11,70	142,0	94,0	258 117	5	258 117 T	5		258 117 F		5
11,80	142,0	94,0	258 118	5	258 118 T	5		258 118 F		5
11,90	151,0	101,0	258 119	5	258 119 T	5		258 119 F		5
12,00	151,0	101,0	258 120	5	258 120 T	5		258 120 F		5
12,10	151,0	101,0	258 121	5	258 121 T	5		258 121 F		5
12,20	151,0	101,0	258 122	5	258 122 T	5		258 122 F		5
12,30	151,0	101,0	258 123	5	258 123 T	5		258 123 F		5

Twist drills DIN 338 TL 3000, HSS ground

Ø mm	L1 mm	L2 mm	HSS-G			HSS-G	TiN		HSS-G	TiAIN	
12,40	151,0	101,0	258 124	5		258 124 T	5		258 124 F	5	
12,50	151,0	101,0	258 125	5		258 125 T	5		258 125 F	5	
12,60	151,0	101,0	258 126	5		258 126 T	5		258 126 F	5	
12,70	151,0	101,0	258 127	5		258 127 T	5		258 127 F	5	
12,80	151,0	101,0	258 128	5		258 128 T	5		258 128 F	5	
12,90	151,0	101,0	258 129	5		258 129 T	5		258 129 F	5	
13,00	151,0	101,0	258 130	5		258 130 T	5		258 130 F	5	
13,50	160,0	108,0	258 135	5		258 135 T	5		258 135 F	5	
14,00	160,0	108,0	258 140	5		258 140 T	5		258 140 F	5	
14,50	169,0	114,0	258 145	5		258 145 T	5		258 145 F	5	
15,00	169,0	114,0	258 150	5		258 150 T	5		258 150 F	5	
15,50	178,0	120,0	258 155	5		258 155 T	5		258 155 F	5	
16,00	178,0	120,0	258 160	5		258 160 T	5		258 160 F	5	

Twist drill sets DIN 338 TL 3000, HSS ground

	HSS-G	TiN	HSS-G	TiAIN
19-piece set of twist drills DIN 338 type TL 3000 Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	258 214	258 214 T	258 214 F	
25-piece set of twist drills DIN 338 type TL 3000 Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	258 215	258 215 T	258 215 F	
19-piece set of twist drills DIN 338 type TL 3000 Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	258 214 RO	258 214 TRO	258 214 FRO	
25-piece set of twist drills DIN 338 type TL 3000 Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	258 215 RO	258 215 TRO	258 215 FRO	





Twist drills DIN 338 type TURBO, HSS ground

Ground twist drill in high-performance high-speed steel. Drills very cleanly with burr-free hole edges. Immediate drilling start after insertion as no prepunching is necessary. Shatter stability is increased by up to 50 % as the core diameter increases constantly in the direction of the shank (from Ø 3,2 mm). Triple milled clamping areas prevent the drill from spinning in the machine (from Ø 5,0 mm).

For use on: non-alloy and alloy steel (up to grade of approx. 900 N/mm²), for drilling thin-walled profiles and sheeting up to 5,0 mm, plastics and wood.



High performance twist drill for all-purpose use in drilling machines and cordless drills. (Materials up to 5,0 mm thickness)



Packing unit: in plastic box

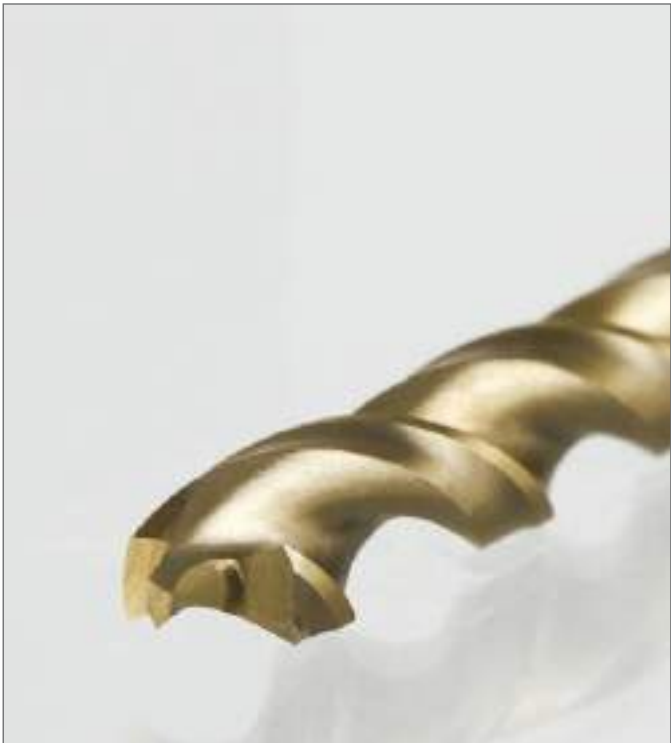
Steel (N/mm ²) < 900	■
Steel (N/mm ²) < 1100	
Steel (N/mm ²) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	
Titanium alloyed	

Ø mm	L1 mm	L2 mm	HSS-G	
1,00	34,0	12,0	2146 010	10
1,50	40,0	18,0	2146 015	10
2,00	49,0	24,0	2146 020	10
2,50	57,0	30,0	2146 025	10
3,00	61,0	33,0	2146 030	10
3,20	65,0	36,0	2146 032	10
3,30	65,0	36,0	2146 033	10
3,50	70,0	39,0	2146 035	10
4,00	75,0	43,0	2146 040	10
4,10	75,0	43,0	2146 041	10
4,20	75,0	43,0	2146 042	10
4,50	80,0	46,0	2146 045	10
4,80	86,0	46,0	2146 048	10
5,00	86,0	46,0	2146 050	10
5,10	86,0	46,0	2146 051	10
5,20	86,0	46,0	2146 052	10
5,40	93,0	52,0	2146 054	10
5,50	93,0	52,0	2146 055	10
6,00	93,0	57,0	2146 060	10
6,50	101,0	58,0	2146 065	10
6,80	109,0	66,0	2146 068	10
7,00	109,0	66,0	2146 070	10
7,50	109,0	66,0	2146 075	10
8,00	117,0	72,0	2146 080	10
8,50	117,0	72,0	2146 085	10
9,00	125,0	78,0	2146 090	10
9,50	125,0	78,0	2146 095	10
10,00	133,0	84,0	2146 100	10
10,50	133,0	84,0	2146 105	5
11,00	142,0	91,0	2146 110	5
11,50	142,0	91,0	2146 115	5
12,00	151,0	98,0	2146 120	5
12,50	151,0	98,0	2146 125	5
13,00	151,0	98,0	2146 130	5

Twist drill sets DIN 338 type TURBO, HSS ground

	<div> <div>HSS-G</div> <div></div> </div>
19-piece set of twist drills DIN 338 type TURBO Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	214 614
25-piece set of twist drills DIN 338 type TURBO Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	214 615
19-piece set of twist drills DIN 338 type TURBO Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	214 614 RO
19-piece set of twist drills DIN 338 type TURBO Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	214 615 RO





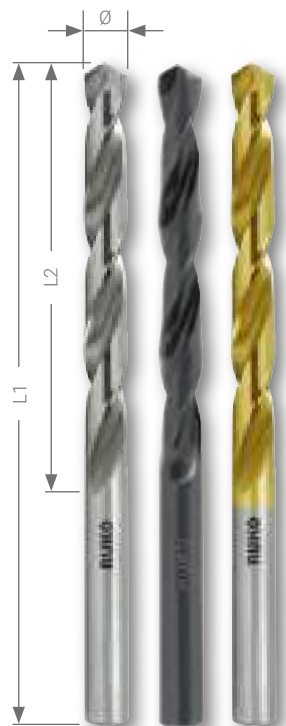
Twist drills DIN 338 type N, HSS ground

High-performance ground standard twist drill made from heavy-duty high speed steel. The fully ground twist drill has a precise concentricity. Thanks to the split point, this drill has good centring properties and requires little pressure.

Packing unit: in plastic box

Steel (N/mm ²) < 900	■	■	■
Steel (N/mm ²) < 1100			□
Steel (N/mm ²) < 1300			
Rust-resistant steel			□
Aluminium	■	■	

Brass	■	■	■
Bronze	□	□	□
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			










Ø mm	L1 mm	L2 mm	HSS-G	
0,30	19,0	3,0	214 003	10
0,40	20,0	5,0	214 004	10
0,50	22,0	6,0	214 005	10
0,60	24,0	7,0	214 006	10
0,70	28,0	9,0	214 007	10
0,80	30,0	10,0	214 008	10
0,90	32,0	11,0	214 009	10
1,00	34,0	12,0	214 010	10
1,10	36,0	14,0	214 011	10
1,20	38,0	16,0	214 012	10
1,25	38,0	16,0	214 0125	10
1,30	38,0	16,0	214 013	10
1,40	40,0	18,0	214 014	10
1,50	40,0	18,0	214 015	10
1,60	43,0	20,0	214 016	10
1,70	43,0	20,0	214 017	10
1,75	46,0	20,0	214 0175	10
1,80	46,0	22,0	214 018	10
1,90	46,0	22,0	214 019	10
2,00	49,0	24,0	214 020	10
2,10	49,0	24,0	214 021	10
2,20	53,0	27,0	214 022	10
2,25	53,0	27,0	214 0225	10
2,30	53,0	27,0	214 023	10
2,40	57,0	30,0	214 024	10
2,50	57,0	30,0	214 025	10
2,60	57,0	30,0	214 026	10
2,70	61,0	33,0	214 027	10
2,75	61,0	33,0	214 0275	10
2,80	61,0	33,0	214 028	10
2,90	61,0	33,0	214 029	10
3,00	61,0	33,0	214 030	10
3,10	65,0	36,0	214 031	10
3,20	65,0	36,0	214 032	10
3,25	65,0	36,0	214 0325	10
3,30	65,0	36,0	214 033	10
3,40	70,0	39,0	214 034	10
3,50	70,0	39,0	214 035	10
3,60	70,0	39,0	214 036	10
3,70	70,0	39,0	214 037	10

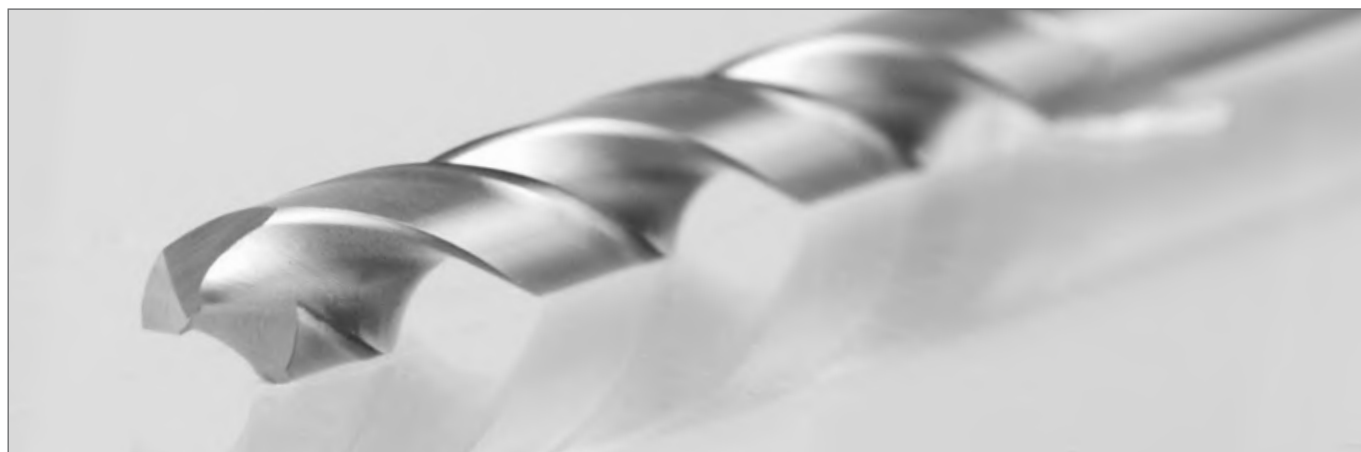
HSS-G	
214 003 S	10
214 004 S	10
214 005 S	10
214 006 S	10
214 007 S	10
214 008 S	10
214 009 S	10
214 010 S	10
214 011 S	10
214 012 S	10
214 0125 S	10
214 013 S	10
214 014 S	10
214 015 S	10
214 016 S	10
214 017 S	10
214 0175 S	10
214 018 S	10
214 019 S	10
214 020 S	10
214 021 S	10
214 022 S	10
214 0225 S	10
214 023 S	10
214 024 S	10
214 025 S	10
214 026 S	10
214 027 S	10
214 0275 S	10
214 028 S	10
214 029 S	10
214 030 S	10
214 031 S	10
214 032 S	10
214 0325 S	10
214 033 S	10
214 034 S	10
214 035 S	10
214 036 S	10
214 037 S	10

HSS-G	TiN	
250 003 T	10	
250 004 T	10	
250 005 T	10	
250 006 T	10	
250 007 T	10	
250 008 T	10	
250 009 T	10	
250 010 T	10	
250 011 T	10	
250 012 T	10	
250 0125 T	10	
250 013 T	10	
250 014 T	10	
250 015 T	10	
250 016 T	10	
250 017 T	10	
250 0175 T	10	
250 018 T	10	
250 019 T	10	
250 020 T	10	
250 021 T	10	
250 022 T	10	
250 0225 T	10	
250 023 T	10	
250 024 T	10	
250 025 T	10	
250 026 T	10	
250 027 T	10	
250 0275 T	10	
250 028 T	10	
250 029 T	10	
250 030 T	10	
250 031 T	10	
250 032 T	10	
250 0325 T	10	
250 033 T	10	
250 034 T	10	
250 035 T	10	
250 036 T	10	
250 037 T	10	

Twist drills DIN 338 type N, HSS ground

Ø mm	L1 mm	L2 mm	HSS-G			HSS-G			HSS-G	TiN	
3,75	70,0	39,0	214 0375	10		214 0375 S	10		250 0375 T	10	
3,80	75,0	43,0	214 038	10		214 038 S	10		250 038 T	10	
3,90	75,0	43,0	214 039	10		214 039 S	10		250 039 T	10	
4,00	75,0	43,0	214 040	10		214 040 S	10		250 040 T	10	
4,10	75,0	43,0	214 041	10		214 041 S	10		250 041 T	10	
4,20	75,0	43,0	214 042	10		214 042 S	10		250 042 T	10	
4,25	75,0	43,0	214 0425	10		214 0425 S	10		250 0425 T	10	
4,30	80,0	47,0	214 043	10		214 043 S	10		250 043 T	10	
4,40	80,0	47,0	214 044	10		214 044 S	10		250 044 T	10	
4,50	80,0	47,0	214 045	10		214 045 S	10		250 045 T	10	
4,60	80,0	47,0	214 046	10		214 046 S	10		250 046 T	10	
4,70	80,0	47,0	214 047	10		214 047 S	10		250 047 T	10	
4,75	80,0	47,0	214 0475	10		214 0475 S	10		250 0475 T	10	
4,80	86,0	52,0	214 048	10		214 048 S	10		250 048 T	10	
4,90	86,0	52,0	214 049	10		214 049 S	10		250 049 T	10	
5,00	86,0	52,0	214 050	10		214 050 S	10		250 050 T	10	
5,10	86,0	52,0	214 051	10		214 051 S	10		250 051 T	10	
5,20	86,0	52,0	214 052	10		214 052 S	10		250 052 T	10	
5,25	86,0	52,0	214 0525	10		214 0525 S	10		250 0525 T	10	
5,30	86,0	52,0	214 053	10		214 053 S	10		250 053 T	10	
5,40	93,0	57,0	214 054	10		214 054 S	10		250 054 T	10	
5,50	93,0	57,0	214 055	10		214 055 S	10		250 055 T	10	
5,60	93,0	57,0	214 056	10		214 056 S	10		250 056 T	10	
5,70	93,0	57,0	214 057	10		214 057 S	10		250 057 T	10	
5,75	93,0	57,0	214 0575	10		214 0575 S	10		250 0575 T	10	
5,80	93,0	57,0	214 058	10		214 058 S	10		250 058 T	10	
5,90	93,0	57,0	214 059	10		214 059 S	10		250 059 T	10	
6,00	93,0	57,0	214 060	10		214 060 S	10		250 060 T	10	
6,10	101,0	63,0	214 061	10		214 061 S	10		250 061 T	10	
6,20	101,0	63,0	214 062	10		214 062 S	10		250 062 T	10	
6,25	101,0	63,0	214 0625	10		214 0625 S	10		250 0625 T	10	
6,30	101,0	63,0	214 063	10		214 063 S	10		250 063 T	10	
6,40	101,0	63,0	214 064	10		214 064 S	10		250 064 T	10	
6,50	101,0	63,0	214 065	10		214 065 S	10		250 065 T	10	
6,60	101,0	63,0	214 066	10		214 066 S	10		250 066 T	10	
6,70	101,0	63,0	214 067	10		214 067 S	10		250 067 T	10	
6,75	101,0	63,0	214 0675	10		214 0675 S	10		250 0675 T	10	
6,80	109,0	69,0	214 068	10		214 068 S	10		250 068 T	10	
6,90	109,0	69,0	214 069	10		214 069 S	10		250 069 T	10	
7,00	109,0	69,0	214 070	10		214 070 S	10		250 070 T	10	
7,10	109,0	69,0	214 071	10		214 071 S	10		250 071 T	10	
7,20	109,0	69,0	214 072	10		214 072 S	10		250 072 T	10	
7,25	109,0	69,0	214 0725	10		214 0725 S	10		250 0725 T	10	
7,30	109,0	69,0	214 073	10		214 073 S	10		250 073 T	10	
7,40	109,0	69,0	214 074	10		214 074 S	10		250 074 T	10	
7,50	109,0	69,0	214 075	10		214 075 S	10		250 075 T	10	
7,60	117,0	75,0	214 076	10		214 076 S	10		250 076 T	10	
7,70	117,0	75,0	214 077	10		214 077 S	10		250 077 T	10	
7,75	117,0	75,0	214 0775	10		214 0775 S	10		250 0775 T	10	
7,80	117,0	75,0	214 078	10		214 078 S	10		250 078 T	10	
7,90	117,0	75,0	214 079	10		214 079 S	10		250 079 T	10	
8,00	117,0	75,0	214 080	10		214 080 S	10		250 080 T	10	
8,10	117,0	75,0	214 081	10		214 081 S	10		250 081 T	10	
8,20	117,0	75,0	214 082	10		214 082 S	10		250 082 T	10	
8,25	117,0	75,0	214 0825	10		214 0825 S	10		250 0825 T	10	
8,30	117,0	75,0	214 083	10		214 083 S	10		250 083 T	10	
8,40	117,0	75,0	214 084	10		214 084 S	10		250 084 T	10	
8,50	117,0	75,0	214 085	10		214 085 S	10		250 085 T	10	
8,60	125,0	81,0	214 086	10		214 086 S	10		250 086 T	10	
8,70	125,0	81,0	214 087	10		214 087 S	10		250 087 T	10	
8,75	125,0	81,0	214 0875	10		214 0875 S	10		250 0875 T	10	
8,80	125,0	81,0	214 088	10		214 088 S	10		250 088 T	10	
8,90	125,0	81,0	214 089	10		214 089 S	10		250 089 T	10	
9,00	125,0	81,0	214 090	10		214 090 S	10		250 090 T	10	
9,10	125,0	81,0	214 091	10		214 091 S	10		250 091 T	10	
9,20	125,0	81,0	214 092	10		214 092 S	10		250 092 T	10	

Ø mm	L1 mm	L2 mm	HSS-G 		HSS-G 		HSS-G 	TiN 	
9,25	125,0	81,0	214 0925	10	214 0925 S	10	250 0925 T	10	
9,30	125,0	81,0	214 093	10	214 093 S	10	250 093 T	10	
9,40	125,0	81,0	214 094	10	214 094 S	10	250 094 T	10	
9,50	125,0	81,0	214 095	10	214 095 S	10	250 095 T	10	
9,60	133,0	87,0	214 096	10	214 096 S	10	250 096 T	10	
9,70	133,0	87,0	214 097	10	214 097 S	10	250 097 T	10	
9,75	133,0	87,0	214 0975	10	214 0975 S	10	250 0975 T	10	
9,80	133,0	87,0	214 098	10	214 098 S	10	250 098 T	10	
9,90	133,0	87,0	214 099	10	214 099 S	10	250 099 T	10	
10,00	133,0	87,0	214 100	10	214 100 S	10	250 100 T	10	
10,10	133,0	87,0	214 101	10	214 101 S	10	250 101 T	10	
10,20	133,0	87,0	214 102	10	214 102 S	10	250 102 T	10	
10,30	133,0	87,0	214 103	10	214 103 S	10	250 103 T	10	
10,40	133,0	87,0	214 104	10	214 104 S	10	250 104 T	10	
10,50	133,0	87,0	214 105	5	214 105 S	5	250 105 T	5	
10,60	133,0	87,0	214 106	5	214 106 S	5	250 106 T	5	
10,70	142,0	94,0	214 107	5	214 107 S	5	250 107 T	5	
10,80	142,0	94,0	214 108	5	214 108 S	5	250 108 T	5	
10,90	142,0	94,0	214 109	5	214 109 S	5	250 109 T	5	
11,00	142,0	94,0	214 110	5	214 110 S	5	250 110 T	5	
11,10	142,0	94,0	214 111	5	214 111 S	5	250 111 T	5	
11,20	142,0	94,0	214 112	5	214 112 S	5	250 112 T	5	
11,30	142,0	94,0	214 113	5	214 113 S	5	250 113 T	5	
11,40	142,0	94,0	214 114	5	214 114 S	5	250 114 T	5	
11,50	142,0	94,0	214 115	5	214 115 S	5	250 115 T	5	
11,60	142,0	94,0	214 116	5	214 116 S	5	250 116 T	5	
11,70	142,0	94,0	214 117	5	214 117 S	5	250 117 T	5	
11,80	142,0	94,0	214 118	5	214 118 S	5	250 118 T	5	
11,90	151,0	101,0	214 119	5	214 119 S	5	250 119 T	5	
12,00	151,0	101,0	214 120	5	214 120 S	5	250 120 T	5	
12,10	151,0	101,0	214 121	5	214 121 S	5	250 121 T	5	
12,20	151,0	101,0	214 122	5	214 122 S	5	250 122 T	5	
12,30	151,0	101,0	214 123	5	214 123 S	5	250 123 T	5	
12,40	151,0	101,0	214 124	5	214 124 S	5	250 124 T	5	
12,50	151,0	101,0	214 125	5	214 125 S	5	250 125 T	5	
12,60	151,0	101,0	214 126	5	214 126 S	5	250 126 T	5	
12,70	151,0	101,0	214 127	5	214 127 S	5	250 127 T	5	
12,80	151,0	101,0	214 128	5	214 128 S	5	250 128 T	5	
12,90	151,0	101,0	214 129	5	214 129 S	5	250 129 T	5	
13,00	151,0	101,0	214 130	5	214 130 S	5	250 130 T	5	
13,50	160,0	108,0	214 135	5	214 135 S	5	250 135 T	5	
14,00	160,0	108,0	214 140	5	214 140 S	5	250 140 T	5	
14,50	169,0	114,0	214 145	5	214 145 S	5	250 145 T	5	
15,00	169,0	114,0	214 150	5	214 150 S	5	250 150 T	5	
15,50	178,0	120,0	214 155	5	214 155 S	5	250 155 T	5	
16,00	178,0	120,0	214 160	5	214 160 S	5	250 160 T	5	
16,50	184,0	125,0	214 165	1	—	—	—	—	
17,00	184,0	125,0	214 170	1	—	—	—	—	
17,50	191,0	130,0	214 175	1	—	—	—	—	
18,00	191,0	130,0	214 180	1	—	—	—	—	
18,50	198,0	135,0	214 185	1	—	—	—	—	
19,00	198,0	135,0	214 190	1	—	—	—	—	
19,50	205,0	140,0	214 195	1	—	—	—	—	
20,00	205,0	140,0	214 201	1	—	—	—	—	



Twist drill sets DIN 338 type N, HSS ground

	<div>HSS-G</div> <div></div>	<div>HSS-G</div> <div></div>	<div>HSS-G</div> <div>TiN</div>
19-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	214 214	214 214 S	250 214 T
25-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	214 215	214 215 S	250 215 T
41-piece set of twist drills DIN 338 type N Ø 6,0 mm up to 10,0 mm in increments of 0,1 mm in steel case	214 218	—	—
50-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 5,9 mm in increments of 0,1 mm in steel case	214 217	—	—



214 214



214 214 S



214 218

	<div>HSS-G</div> <div></div>	<div>HSS-G</div> <div></div>	<div>HSS-G</div> <div>TiN</div>
19-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	214 214 RO	214 214 SRO	250 214 TRO
25-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	214 215 RO	214 215 SRO	250 215 TRO



214 214 RO



214 214 SRO

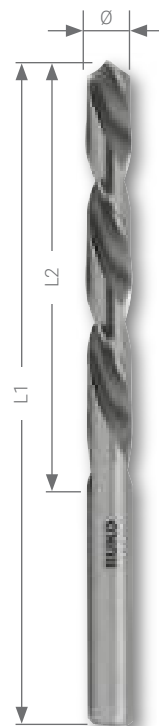


250 214 TRO



Twist drills DIN 338 type N, HSS ground - left hand cutting

High-performance ground twist drill made from heavy-duty high speed steel. The fully ground twist drill has a precise concentricity.



Packing unit: in plastic box

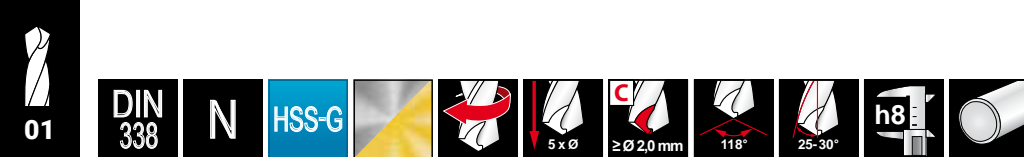
Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100		Bronze	□
Steel (N/mm ²) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø mm	L1 mm	L2 mm	HSS-G			Ø mm	L1 mm	L2 mm	HSS-G		
1,00	34,0	12,0	214 010 Li	10		6,50	101,0	63,0	214 065 Li	10	
1,50	40,0	18,0	214 015 Li	10		7,00	109,0	69,0	214 070 Li	10	
2,00	49,0	24,0	214 020 Li	10		7,50	109,0	69,0	214 075 Li	10	
2,50	57,0	30,0	214 025 Li	10		8,00	117,0	75,0	214 080 Li	10	
3,00	61,0	33,0	214 030 Li	10		8,50	117,0	75,0	214 085 Li	10	
3,20	65,0	36,0	214 032 Li	10		9,00	125,0	81,0	214 090 Li	10	
3,50	70,0	39,0	214 035 Li	10		9,50	125,0	81,0	214 095 Li	10	
4,00	75,0	43,0	214 040 Li	10		10,00	133,0	87,0	214 100 Li	10	
4,20	75,0	43,0	214 042 Li	10		10,50	133,0	87,0	214 105 Li	5	
4,50	80,0	47,0	214 045 Li	10		11,00	142,0	94,0	214 110 Li	5	
4,80	86,0	52,0	214 048 Li	10		11,50	142,0	94,0	214 115 Li	5	
5,00	86,0	52,0	214 050 Li	10		12,00	151,0	101,0	214 120 Li	5	
5,50	93,0	57,0	214 055 Li	10		12,50	151,0	101,0	214 125 Li	5	
6,00	93,0	57,0	214 060 Li	10		13,00	151,0	101,0	214 130 Li	5	

Twist drill sets DIN 338 type N, HSS ground - left hand cutting

19-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	214 214 Li
25-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	214 215 Li
19-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	214 214 Li RO
25-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	214 215 Li RO





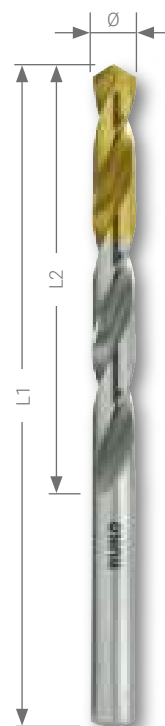
Twist drill DIN 338 type N, HSS-G with TiN-coated tips

High-performance ground standard twist drill made from heavy-duty high speed steel. The fully ground twist drill has a precise concentricity. Thanks to the split point, this drill has good centring properties and requires little pressure.

The titanium nitride coating is a universally usable standard coating. It has a 300-400 % longer service life than non-coated materials. Cooling is recommended.

Packing unit: in plastic box

Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100	□	Bronze	□
Steel (N/mm ²) < 1300		Plastics	■
Rust-resistant steel	□	Cast iron	□
Aluminium		Titanium alloyed	



Ø mm	L1 mm	L2 mm	HSS-G			Ø mm	L1 mm	L2 mm	HSS-G		
1,00	34,0	12,0	2501 010 T	10		6,80	109,0	69,0	2501 068 T	10	
1,50	40,0	18,0	2501 015 T	10		7,00	109,0	69,0	2501 070 T	10	
1,60	43,0	20,0	2501 016 T	10		7,50	109,0	69,0	2501 075 T	10	
2,00	49,0	24,0	2501 020 T	10		8,00	117,0	75,0	2501 080 T	10	
2,10	49,0	24,0	2501 021 T	10		8,50	117,0	75,0	2501 085 T	10	
2,50	57,0	30,0	2501 025 T	10		9,00	125,0	81,0	2501 090 T	10	
3,00	61,0	33,0	2501 030 T	10		9,50	125,0	81,0	2501 095 T	10	
3,30	65,0	36,0	2501 033 T	10		10,00	133,0	87,0	2501 100 T	10	
3,50	70,0	39,0	2501 035 T	10		10,20	133,0	87,0	2501 102 T	10	
4,00	75,0	43,0	2501 040 T	10		10,50	133,0	87,0	2501 105 T	5	
4,20	75,0	43,0	2501 042 T	10		11,00	142,0	94,0	2501 110 T	5	
4,50	80,0	47,0	2501 045 T	10		11,50	142,0	94,0	2501 115 T	5	
5,00	86,0	52,0	2501 050 T	10		12,00	151,0	101,0	2501 120 T	5	
5,50	93,0	57,0	2501 055 T	10		12,50	151,0	101,0	2501 125 T	5	
6,00	93,0	57,0	2501 060 T	10		13,00	151,0	101,0	2501 130 T	5	
6,50	101,0	63,0	2501 065 T	10							

Twist drill sets DIN 338 type N, HSS-G with TiN-coated tips

19-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	2501 214 T
25-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	2501 215 T
19-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	2501 214 TRO
25-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	2501 215 TRO





Twist drill sets, DIN 338 type N and type VA in bench stand

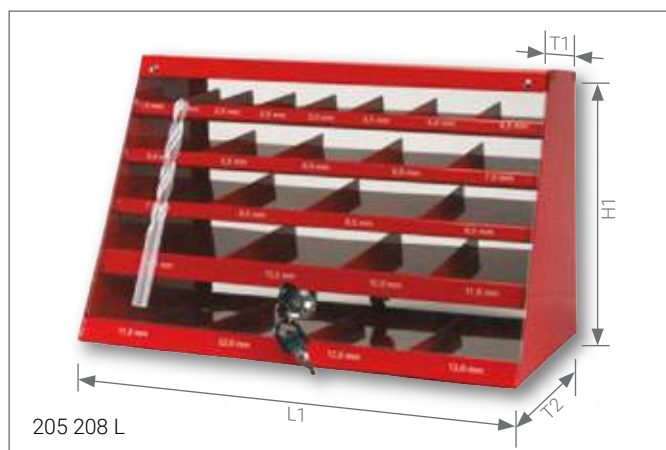
	HSS-R N	HSS-G N	HSSE Co 5 VA
91-piece set of twist drills DIN 338 Ø 1,0 mm up to 10,0 mm in increments of 0,1 mm	205 223	214 223	215 223

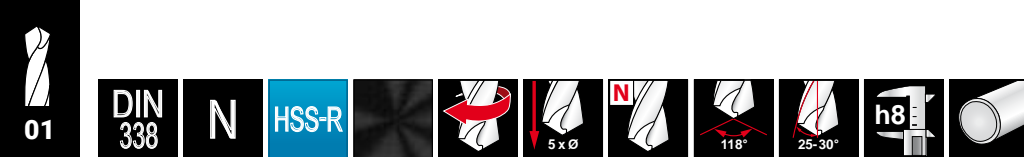
Twist drill sets, DIN 338 type N and type VA in magazine

	HSS-G N	HSSE Co 5 VA
Consisting of 170 twist drills DIN 338 10 pcs, Ø 1,0 - 8,0 mm in increments of 0,5 mm 5 pcs, Ø 8,5 - 10,0 mm in increments of 0,5 mm	214 200	215 200

Twist drill cabinet, DIN 338 type N and type VA

	HSS-R N	HSS-G N	HSSE Co 5 VA
Drill cabinet consisting of 570 twist drills DIN 338 50 pcs Ø 1,0 - 2,5 mm in increments of 0,5 mm 30 pcs Ø 3,0 - 5,5 mm in increments of 0,5 mm 20 pcs Ø 6,0 - 7,5 mm in increments of 0,5 mm 10 pcs Ø 8,0 - 13,0 mm in increments of 0,5 mm	205 208	214 208	215 208
Drill cabinet empty Measurements: H1: 46,5 cm, L1: 39,0 cm, T1: 9,5 cm, T2: 20,0 cm Ø 1,0 mm up to 10,0 mm in increments of 0,1 mm Ø 10,5 mm up to 13,0 mm in increments of 0,5 mm	205 208 L		
Drill cabinet empty Measurements: H1: 23,0 cm, L1: 37,0 cm, T1: 9,5 cm, T2: 20,0 cm Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm	205 208 L		



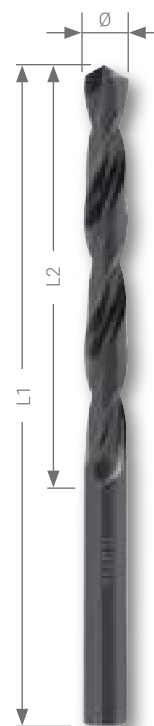


Twist drills DIN 338 type N, HSS rolled

High-performance rolled, steam-treated twist drill made from heavy-duty high speed steel. The manufacturing procedure (no structural disruption) solidifies the material making it more elasticated. This makes it more resistant to fracture and suitable for robust drilling units. (e.g. hand-held drilling machines)

Packing unit: in plastic box

Steel (N/mm2) < 900		Brass	
Steel (N/mm2) < 1100		Bronze	
Steel (N/mm2) < 1300		Plastics	
Rust-resistant steel		Cast iron	
Aluminium		Titanium alloyed	



Ø mm	L1 mm	L2 mm	HSS-R		
0,30	19,0	3,0	201 003	10	
0,40	20,0	5,0	201 004	10	
0,50	22,0	6,0	201 005	10	
0,60	24,0	7,0	201 006	10	
0,70	28,0	9,0	201 007	10	
0,80	30,0	10,0	201 008	10	
0,90	32,0	11,0	201 009	10	
1,00	34,0	12,0	201 010	10	
1,10	36,0	14,0	201 011	10	
1,20	38,0	16,0	201 012	10	
1,25	38,0	16,0	201 0125	10	
1,30	38,0	16,0	201 013	10	
1,40	40,0	18,0	201 014	10	
1,50	40,0	18,0	201 015	10	
1,60	43,0	20,0	201 016	10	
1,70	43,0	20,0	201 017	10	
1,75	46,0	20,0	201 0175	10	
1,80	46,0	22,0	201 018	10	
1,90	46,0	22,0	201 019	10	
2,00	49,0	24,0	201 020	10	
2,10	49,0	24,0	201 021	10	
2,20	53,0	27,0	201 022	10	
2,25	53,0	27,0	201 0225	10	
2,30	53,0	27,0	201 023	10	
2,40	57,0	30,0	201 024	10	
2,50	57,0	30,0	201 025	10	
2,60	57,0	30,0	201 026	10	
2,70	61,0	33,0	201 027	10	
2,75	61,0	33,0	201 0275	10	
2,80	61,0	33,0	201 028	10	
2,90	61,0	33,0	201 029	10	
3,00	61,0	33,0	201 030	10	
3,10	65,0	36,0	201 031	10	
3,20	65,0	36,0	201 032	10	
3,25	65,0	36,0	201 0325	10	
3,30	65,0	36,0	201 033	10	
3,40	70,0	39,0	201 034	10	
3,50	70,0	39,0	201 035	10	
3,60	70,0	39,0	201 036	10	
3,70	70,0	39,0	201 037	10	
3,75	70,0	39,0	201 0375	10	
3,80	75,0	43,0	201 038	10	
3,90	75,0	43,0	201 039	10	
4,00	75,0	43,0	201 040	10	
4,10	75,0	43,0	201 041	10	
4,20	75,0	43,0	201 042	10	
4,25	75,0	43,0	201 0425	10	
4,30	80,0	47,0	201 043	10	
4,40	80,0	47,0	201 044	10	
4,50	80,0	47,0	201 045	10	
4,60	80,0	47,0	201 046	10	
4,70	80,0	47,0	201 047	10	
4,75	80,0	47,0	201 0475	10	
4,80	86,0	52,0	201 048	10	
4,90	86,0	52,0	201 049	10	
5,00	86,0	52,0	201 050	10	
5,10	86,0	52,0	201 051	10	
5,20	86,0	52,0	201 052	10	
5,25	86,0	52,0	201 0525	10	
5,30	86,0	52,0	201 053	10	
5,40	93,0	57,0	201 054	10	
5,50	93,0	57,0	201 055	10	
5,60	93,0	57,0	201 056	10	
5,70	93,0	57,0	201 057	10	
5,75	93,0	57,0	201 0575	10	
5,80	93,0	57,0	201 058	10	
5,90	93,0	57,0	201 059	10	
6,00	93,0	57,0	201 060	10	
6,10	101,0	63,0	201 061	10	
6,20	101,0	63,0	201 062	10	
6,25	101,0	63,0	201 0625	10	
6,30	101,0	63,0	201 063	10	
6,40	101,0	63,0	201 064	10	
6,50	101,0	63,0	201 065	10	
6,60	101,0	63,0	201 066	10	
6,70	101,0	63,0	201 067	10	
6,75	101,0	63,0	201 0675	10	
6,80	109,0	69,0	201 068	10	
6,90	109,0	69,0	201 069	10	
7,00	109,0	69,0	201 070	10	

Ø mm	L1 mm	L2 mm	HSS-R			Ø mm	L1 mm	L2 mm	HSS-R		
7,10	109,0	69,0	201 071	10		10,50	133,0	87,0	201 105	5	
7,20	109,0	69,0	201 072	10		10,60	133,0	87,0	201 106	5	
7,25	109,0	69,0	201 0725	10		10,70	142,0	94,0	201 107	5	
7,30	109,0	69,0	201 073	10		10,80	142,0	94,0	201 108	5	
7,40	109,0	69,0	201 074	10		10,90	142,0	94,0	201 109	5	
7,50	109,0	69,0	201 075	10		11,00	142,0	94,0	201 110	5	
7,60	117,0	75,0	201 076	10		11,10	142,0	94,0	201 111	5	
7,70	117,0	75,0	201 077	10		11,20	142,0	94,0	201 112	5	
7,75	117,0	75,0	201 0775	10		11,30	142,0	94,0	201 113	5	
7,80	117,0	75,0	201 078	10		11,40	142,0	94,0	201 114	5	
7,90	117,0	75,0	201 079	10		11,50	142,0	94,0	201 115	5	
8,00	117,0	75,0	201 080	10		11,60	142,0	94,0	201 116	5	
8,10	117,0	75,0	201 081	10		11,70	142,0	94,0	201 117	5	
8,20	117,0	75,0	201 082	10		11,80	142,0	94,0	201 118	5	
8,25	117,0	75,0	201 0825	10		11,90	151,0	101,0	201 119	5	
8,30	117,0	75,0	201 083	10		12,00	151,0	101,0	201 120	5	
8,40	117,0	75,0	201 084	10		12,10	151,0	101,0	201 121	5	
8,50	117,0	75,0	201 085	10		12,20	151,0	101,0	201 122	5	
8,60	125,0	81,0	201 086	10		12,30	151,0	101,0	201 123	5	
8,70	125,0	81,0	201 087	10		12,40	151,0	101,0	201 124	5	
8,75	125,0	81,0	201 0875	10		12,50	151,0	101,0	201 125	5	
8,80	125,0	81,0	201 088	10		12,60	151,0	101,0	201 126	5	
8,90	125,0	81,0	201 089	10		12,70	151,0	101,0	201 127	5	
9,00	125,0	81,0	201 090	10		12,80	151,0	101,0	201 128	5	
9,10	125,0	81,0	201 091	10		12,90	151,0	101,0	201 129	5	
9,20	125,0	81,0	201 092	10		13,00	151,0	101,0	201 130	5	
9,25	125,0	81,0	201 0925	10		13,50	160,0	108,0	201 135	5	
9,30	125,0	81,0	201 093	10		14,00	160,0	108,0	201 140	5	
9,40	125,0	81,0	201 094	10		14,50	169,0	114,0	201 145	5	
9,50	125,0	81,0	201 095	10		15,00	169,0	114,0	201 150	5	
9,60	133,0	87,0	201 096	10		15,50	178,0	120,0	201 155	5	
9,70	133,0	87,0	201 097	10		16,00	178,0	120,0	201 160	5	
9,75	133,0	87,0	201 0975	10		16,50	184,0	125,0	201 165	1	
9,80	133,0	87,0	201 098	10		17,00	184,0	125,0	201 170	1	
9,90	133,0	87,0	201 099	10		17,50	191,0	130,0	201 175	1	
10,00	133,0	87,0	201 100	10		18,00	191,0	130,0	201 180	1	
10,10	133,0	87,0	201 101	10		18,50	198,0	135,0	201 185	1	
10,20	133,0	87,0	201 102	10		19,00	198,0	135,0	201 190	1	
10,30	133,0	87,0	201 103	10		19,50	205,0	140,0	201 195	1	
10,40	133,0	87,0	201 104	10		20,00	205,0	140,0	201 200	1	

Twist drill sets DIN 338 type N, HSS rolled

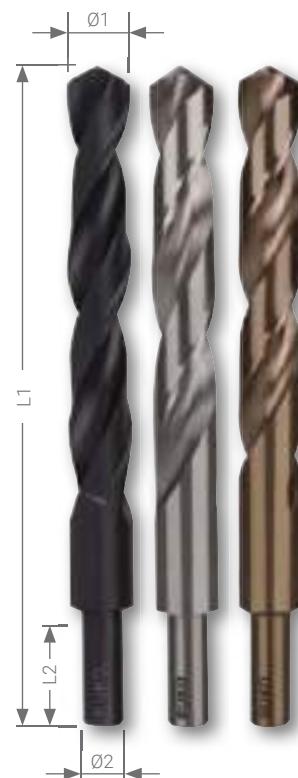
	HSS-R
19-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	205 212
25-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	205 213
41-piece set of twist drills DIN 338 type N Ø 6,0 mm up to 10,0 mm in increments of 0,1 mm in steel case	205 218
50-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 5,9 mm in increments of 0,1 mm in steel case	205 217
19-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	205 212 RO
25-piece set of twist drills DIN 338 type N Ø 1,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	205 213 RO











Twist drills DIN 338 type N, with reduced shank

Ideal solution for larger diameter hole drilling in all commonly used drilling machines.



Steel (N/mm ²) < 900			
Steel (N/mm ²) < 1100			
Steel (N/mm ²) < 1300			
Rust-resistant steel			
Aluminium			

Brass			
Bronze			
Plastics			
Cast iron			
Titanium alloyed			

Ø1 mm	L1 mm	Ø2 mm	L2 mm						
10,50	133,0	10,0	30,0	200 105	1	200 4 105	1	200 5 105	1
11,00	142,0	10,0	30,0	200 110	1	200 4 110	1	200 5 110	1
11,50	142,0	10,0	30,0	200 115	1	200 4 115	1	200 5 115	1
12,00	151,0	10,0	30,0	200 120	1	200 4 120	1	200 5 120	1
12,50	151,0	10,0	30,0	200 125	1	200 4 125	1	200 5 125	1
13,00	151,0	10,0	30,0	200 130	1	200 4 130	1	200 5 130	1
13,50	160,0	10,0	30,0	200 135	1	200 4 135	1	200 5 135	1
14,00	160,0	10,0	30,0	200 140	1	200 4 140	1	200 5 140	1
14,50	169,0	10,0	30,0	200 145	1	200 4 145	1	200 5 145	1
15,00	169,0	10,0	30,0	200 150	1	200 4 150	1	200 5 150	1
15,50	178,0	10,0	30,0	200 155	1	200 4 155	1	200 5 155	1
16,00	178,0	10,0	30,0	200 160	1	200 4 160	1	200 5 160	1
16,50	184,0	13,0	35,0	200 165	1	200 4 165	1	200 5 165	1
17,00	184,0	13,0	35,0	200 170	1	200 4 170	1	200 5 170	1
17,50	191,0	13,0	35,0	200 175	1	200 4 175	1	200 5 175	1
18,00	191,0	13,0	35,0	200 180	1	200 4 180	1	200 5 180	1
18,50	198,0	13,0	35,0	200 185	1	200 4 185	1	200 5 185	1
19,00	198,0	13,0	35,0	200 190	1	200 4 190	1	200 5 190	1
19,50	205,0	13,0	35,0	200 195	1	200 4 195	1	200 5 195	1
20,00	205,0	13,0	35,0	200 200	1	200 4 200	1	200 5 200	1
22,00	205,0	13,0	35,0	200 220	1	—	—	—	—
24,00	205,0	13,0	35,0	200 240	1	—	—	—	—
25,00	205,0	13,0	35,0	200 250	1	—	—	—	—





Solid TC twist drills DIN 338 type N

High performance solid carbide K 20 twist drill, especially well suited for high strength steels at high cutting speeds.

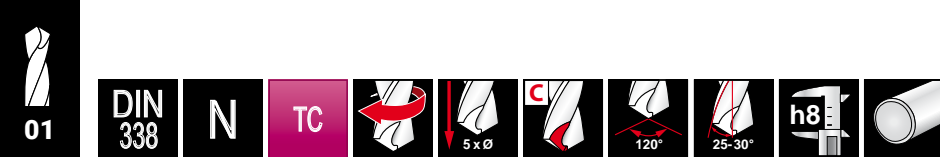
Packing unit: in plastic box

Steel (N/mm ²) < 900		Brass	
Steel (N/mm ²) < 1100		Bronze	
Steel (N/mm ²) < 1300		Plastics	
Rust-resistant steel		Cast iron	
Aluminium		Titanium alloyed	



Ø mm	L1 mm	L2 mm		
3,00	61,0	33,0	814 030	1
3,50	70,0	39,0	814 035	1
4,00	75,0	43,0	814 040	1
4,50	80,0	47,0	814 045	1
5,00	86,0	52,0	814 050	1
5,50	93,0	57,0	814 055	1
6,00	93,0	57,0	814 060	1
6,50	101,0	63,0	814 065	1
7,00	109,0	69,0	814 070	1
7,50	109,0	69,0	814 075	1
8,00	117,0	75,0	814 080	1
8,50	117,0	75,0	814 085	1
9,00	125,0	81,0	814 090	1
9,50	125,0	81,0	814 095	1
10,00	133,0	87,0	814 100	1
10,50	133,0	87,0	814 105	1
11,00	142,0	94,0	814 110	1
11,50	142,0	94,0	814 115	1
12,00	151,0	101,0	814 120	1
12,50	151,0	101,0	814 125	1
13,00	151,0	101,0	814 130	1





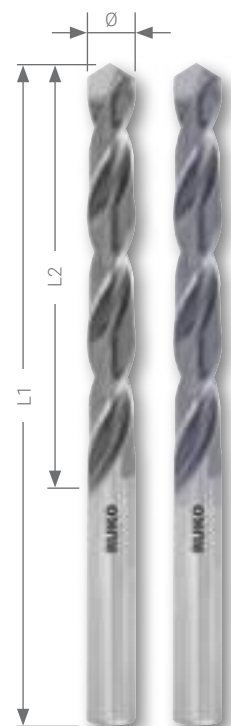
Twist drill DIN 338 Type N, with brazed-on TC cutting inserts

High-performance twist drill with brazed-on HM cutting inserts made from K20 fine grained material. It is suited for universal applications and for high-strength steel. Continuous cooling is required when drilling into high-strength steel. Highly recommended for machining cast iron.

Packing unit: in plastic box

Steel (N/mm2) < 900	■	■
Steel (N/mm2) < 1100	■	■
Steel (N/mm2) < 1300	□	□
Rust-resistant steel	■	■
Aluminium	■	■

Brass	■	■
Bronze	□	■
Plastics	■	■
Cast iron	■	■
Titanium alloyed	□	■





Ø mm	L1 mm	L2 mm		
2,00	49,0	24,0	815 020	1
2,50	57,0	30,0	815 025	1
3,00	61,0	33,0	815 030	1
3,30	65,0	36,0	815 033	1
3,50	70,0	39,0	815 035	1
4,00	75,0	43,0	815 040	1
4,20	75,0	43,0	815 042	1
4,50	80,0	47,0	815 045	1
5,00	86,0	52,0	815 050	1
5,50	93,0	57,0	815 055	1
6,00	93,0	57,0	815 060	1
6,50	101,0	63,0	815 065	1
6,80	109,0	69,0	815 068	1
7,00	109,0	69,0	815 070	1
7,50	109,0	69,0	815 075	1
8,00	117,0	75,0	815 080	1
8,50	117,0	75,0	815 085	1
9,00	125,0	81,0	815 090	1
9,50	125,0	81,0	815 095	1
10,00	133,0	87,0	815 100	1
10,20	133,0	87,0	815 102	1
10,50	133,0	87,0	815 105	1
11,00	142,0	94,0	815 110	1
11,50	142,0	94,0	815 115	1
12,00	151,0	101,0	815 120	1
12,50	151,0	101,0	815 125	1
13,00	151,0	101,0	815 130	1

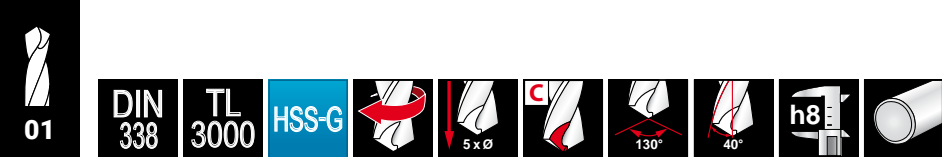
815 020 C		1
815 025 C		1
815 030 C		1
815 033 C		1
815 035 C		1
815 040 C		1
815 042 C		1
815 045 C		1
815 050 C		1
815 055 C		1
815 060 C		1
815 065 C		1
815 068 C		1
815 070 C		1
815 075 C		1
815 080 C		1
815 085 C		1
815 090 C		1
815 095 C		1
815 100 C		1
815 102 C		1
815 105 C		1
815 110 C		1
815 115 C		1
815 120 C		1
815 125 C		1
815 130 C		1



Twist drill sets DIN 338 Type N, with brazed-on TC cutting inserts

	 TC	 TC
17-piece set of twist drills DIN 338 type N Ø 2,0 mm up to 10,0 mm in increments of 0,5 mm in steel case	815 214	815 214 C
23-piece set of twist drills DIN 338 type N Ø 2,0 mm up to 13,0 mm in increments of 0,5 mm in steel case	815 215	815 215 C
17-piece set of twist drills DIN 338 type N Ø 2,0 mm up to 10,0 mm in increments of 0,5 mm in plastic case	815 214 RO	815 214 CRO
23-piece set of twist drills DIN 338 type N Ø 2,0 mm up to 13,0 mm in increments of 0,5 mm in plastic case	815 215 RO	815 215 CRO





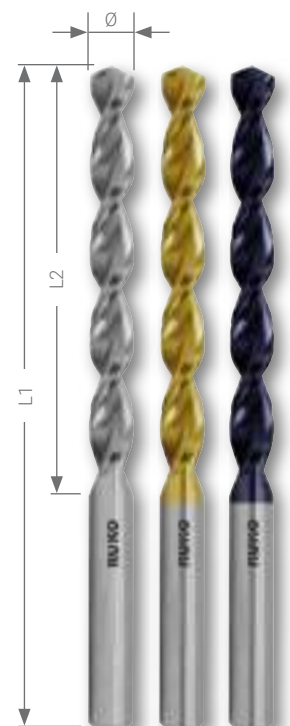
Twist drills DIN 338 TL 3000, in fractional sizes

Highly stable multirange drill with outstanding heat resistance, a reinforced drill core and a parabolic flute for ideal chip removal. Ideal for drilling medium and long-chipping materials. Thanks to its thick core and the special flute with a rounded rear edge, this drill is best suited for high-performance use. It covers types N, H and W for a wide range of applications.

Packing unit: in plastic box

Steel (N/mm ²) < 900	■	■	■
Steel (N/mm ²) < 1100		□	■
Steel (N/mm ²) < 1300			
Rust-resistant steel		□	■
Aluminium	■		■

Brass	■	■	■
Bronze	□	□	■
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			



Ø inch	Ø mm	L1 inch	L2 inch	HSS-G		HSS-G	TiN		HSS-G	TiAIN	
1/16	1,59	1 7/8	7/8	258 801	10	258 801 T	10	258 801 F	10		
5/64	1,98	2	1	258 802	10	258 802 T	10	258 802 F	10		
3/32	2,38	2 1/4	1 1/4	258 803	10	258 803 T	10	258 803 F	10		
7/64	2,78	2 5/8	1 1/2	258 804	10	258 804 T	10	258 804 F	10		
1/8	3,18	2 3/4	1 5/8	258 805	10	258 805 T	10	258 805 F	10		
9/64	3,57	2 7/8	1 3/4	258 806	10	258 806 T	10	258 806 F	10		
5/32	3,97	3 1/8	2	258 807	10	258 807 T	10	258 807 F	10		
11/64	4,37	3 1/4	2 1/8	258 808	10	258 808 T	10	258 808 F	10		
3/16	4,76	3 1/2	2 5/16	258 809	10	258 809 T	10	258 809 F	10		
13/64	5,16	3 5/8	2 7/16	258 810	10	258 810 T	10	258 810 F	10		
7/32	5,56	3 3/4	2 1/2	258 811	10	258 811 T	10	258 811 F	10		
15/64	5,95	3 7/8	2 5/8	258 812	10	258 812 T	10	258 812 F	10		
1/4	6,35	4	2 3/4	258 813	10	258 813 T	10	258 813 F	10		
17/64	6,75	4 1/8	2 7/8	258 814	10	258 814 T	10	258 814 F	10		
9/32	7,14	4 1/4	2 15/16	258 815	10	258 815 T	10	258 815 F	10		
19/64	7,54	4 3/8	3 1/16	258 816	10	258 816 T	10	258 816 F	10		
5/16	7,94	4 1/2	3 3/16	258 817	10	258 817 T	10	258 817 F	10		
21/64	8,33	4 5/8	3 5/16	258 818	10	258 818 T	10	258 818 F	10		
11/32	8,73	4 3/4	3 7/16	258 819	10	258 819 T	10	258 819 F	10		
23/64	9,13	4 7/8	3 1/2	258 820	10	258 820 T	10	258 820 F	10		
3/8	9,53	5	3 5/8	258 821	10	258 821 T	10	258 821 F	10		
25/64	9,92	5 1/8	3 3/4	258 822	10	258 822 T	10	258 822 F	10		
13/32	10,32	5 1/4	3 7/8	258 823	10	258 823 T	10	258 823 F	10		
27/64	10,72	5 3/8	3 15/16	258 824	5	258 824 T	5	258 824 F	5		
7/16	11,11	5 1/2	4 1/16	258 825	5	258 825 T	5	258 825 F	5		
29/64	11,51	5 5/8	4 3/16	258 826	5	258 826 T	5	258 826 F	5		
15/32	11,91	5 3/4	4 5/16	258 827	5	258 827 T	5	258 827 F	5		
31/64	12,30	5 7/8	4 3/8	258 828	5	258 828 T	5	258 828 F	5		
1/2	12,70	6	4 1/2	258 829	5	258 829 T	5	258 829 F	5		

Twist drill sets DIN 338 TL 3000, in fractional sizes

	HSS-G	HSS-G	TiN	HSS-G	TiAIN
21-piece set of twist drills DIN 338 TL 3000, in fractional sizes Ø 1/16" up to 3/8" in increments of 1/64" in steel case	258 850	258 850 T	258 850 F		
29-piece set of twist drills DIN 338 TL 3000, in fractional sizes Ø 1/16" up to 1/2" in increments of 1/64" in steel case	258 851	258 851 T	258 851 F		

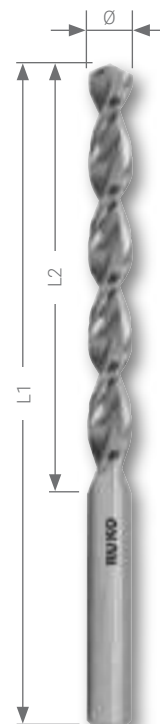


Twist drills DIN 338 UTL 3000, in fractional sizes

Highly stable multirange drill with outstanding heat resistance, a reinforced drill core and a parabolic flute for ideal chip removal. Ideal for drilling medium and long-chipping materials. Thanks to its thick core and the special flute with a rounded rear edge, this drill is best suited for high-performance use. It covers types N, H and W for a wide range of applications.

Packing unit: in plastic box

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100	■	Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel	■	Cast iron	□
Aluminium	■	Titanium alloyed	

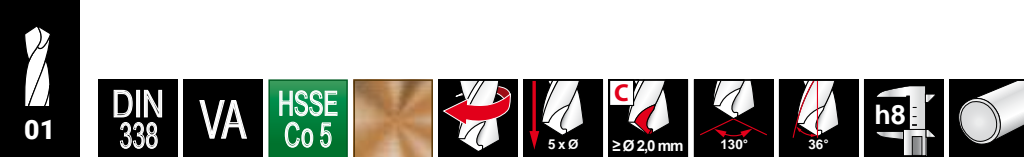


Ø inch	Ø mm	L1 inch	L2 inch	HSSE Co 5		
1/16	1,59	1 7/8	7/8	229 801		10
5/64	1,98	2	1	229 802		10
3/32	2,38	2 1/4	1 1/4	229 803		10
7/64	2,78	2 5/8	1 1/2	229 804		10
1/8	3,18	2 3/4	1 5/8	229 805		10
9/64	3,57	2 7/8	1 3/4	229 806		10
5/32	3,97	3 1/8	2	229 807		10
11/64	4,37	3 1/4	2 1/8	229 808		10
3/16	4,76	3 1/2	2 5/16	229 809		10
13/64	5,16	3 5/8	2 7/16	229 810		10
7/32	5,56	3 3/4	2 1/2	229 811		10
15/64	5,95	3 7/8	2 5/8	229 812		10
1/4	6,35	4	2 3/4	229 813		10
17/64	6,75	4 1/8	2 7/8	229 814		10
9/32	7,14	4 1/4	2 15/16	229 815		10
19/64	7,54	4 3/8	3 1/16	229 816		10
5/16	7,94	4 1/2	3 3/16	229 817		10
21/64	8,33	4 5/8	3 5/16	229 818		10
11/32	8,73	4 3/4	3 7/16	229 819		10
23/64	9,13	4 7/8	3 1/2	229 820		10
3/8	9,53	5	3 5/8	229 821		10
25/64	9,92	5 1/8	3 3/4	229 822		10
13/32	10,32	5 1/4	3 7/8	229 823		10
27/64	10,72	5 3/8	3 15/16	229 824		5
7/16	11,11	5 1/2	4 1/16	229 825		5
29/64	11,51	5 5/8	4 3/16	229 826		5
15/32	11,91	5 3/4	4 5/16	229 827		5
31/64	12,30	5 7/8	4 3/8	229 828		5
1/2	12,70	6	4 1/2	229 829		5

Twist drill sets DIN 338 UTL 3000, in fractional sizes

21-piece set of twist drills DIN 338 UTL 3000, in fractional sizes Ø 1/16" up to 3/8" in increments of 1/64" in steel case	229 850
29-piece set of twist drills DIN 338 UTL 3000, in fractional sizes Ø 1/16" up to 1/2" in increments of 1/64" in steel case	229 851





Twist drills DIN 338 type VA, in fractional sizes

Powerful right-hand cutting high-performance drill with distinctive heat resistance and reinforced drill core. Ideal for drilling high-strength stainless, acid-resistant and heat-resistant steel.

Packing unit: in plastic box

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100	■	Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel	■	Cast iron	□
Aluminium	■	Titanium alloyed	

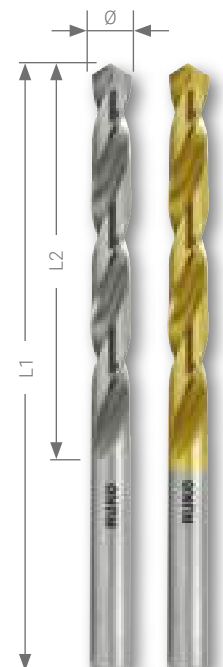


Ø mm	L1 mm	L1 inch	L2 inch	HSSE Co 5		
1/16	1,59	1 7/8	7/8	215 801		10
5/64	1,98	2	1	215 802		10
3/32	2,38	2 1/4	1 1/4	215 803		10
7/64	2,78	2 5/8	1 1/2	215 804		10
1/8	3,18	2 3/4	1 5/8	215 805		10
9/64	3,57	2 7/8	1 3/4	215 806		10
5/32	3,97	3 1/8	2	215 807		10
11/64	4,37	3 1/4	2 1/8	215 808		10
3/16	4,76	3 1/2	2 5/16	215 809		10
13/64	5,16	3 5/8	2 7/16	215 810		10
7/32	5,56	3 3/4	2 1/2	215 811		10
15/64	5,95	3 7/8	2 5/8	215 812		10
1/4	6,35	4	2 3/4	215 813		10
17/64	6,75	4 1/8	2 7/8	215 814		10
9/32	7,14	4 1/4	2 15/16	215 815		10
19/64	7,54	4 3/8	3 1/16	215 816		10
5/16	7,94	4 1/2	3 3/16	215 817		10
21/64	8,33	4 5/8	3 5/16	215 818		10
11/32	8,73	4 3/4	3 7/16	215 819		10
23/64	9,13	4 7/8	3 1/2	215 820		10
3/8	9,53	5	3 5/8	215 821		10
25/64	9,92	5 1/8	3 3/4	215 822		10
13/32	10,32	5 1/4	3 7/8	215 823		10
27/64	10,72	5 3/8	3 15/16	215 824		5
7/16	11,11	5 1/2	4 1/16	215 825		5
29/64	11,51	5 5/8	4 3/16	215 826		5
15/32	11,91	5 3/4	4 5/16	215 827		5
31/64	12,30	5 7/8	4 3/8	215 828		5
1/2	12,70	6	4 1/2	215 829		5

Twist drill sets DIN 338 type VA, in fractional sizes

21-piece set of twist drills DIN 338 type VA, in fractional sizes Ø 1/16" up to 3/8" in increments of 1/64" in steel case	215 850
29-piece set of twist drills DIN 338 type VA, in fractional sizes Ø 1/16" up to 1/2" in increments of 1/64" in steel case	215 851





Twist drills DIN 338 type N, in fractional sizes

High-performance ground standard twist drill made from heavy-duty high speed steel. The fully ground twist drill has a precise concentricity. Thanks to the split point, this drill has good centring properties and requires little pressure.

Packing unit: in plastic box

Steel (N/mm2) < 900	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Steel (N/mm2) < 1100	<input type="checkbox"/>	<input type="checkbox"/>
Steel (N/mm2) < 1300	<input type="checkbox"/>	<input type="checkbox"/>
Rust-resistant steel	<input type="checkbox"/>	<input type="checkbox"/>
Aluminium	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Brass	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Bronze	<input type="checkbox"/>	<input type="checkbox"/>
Plastics	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Cast iron	<input type="checkbox"/>	<input type="checkbox"/>
Titanium alloyed	<input type="checkbox"/>	<input type="checkbox"/>

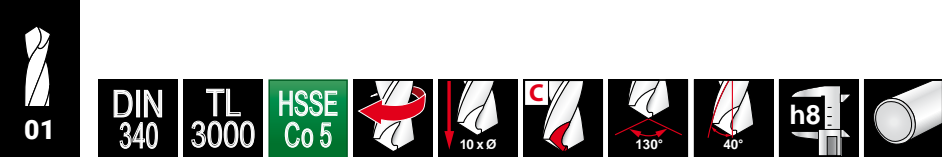
Ø mm	L1 mm	L1 inch	L2 inch	HSS-G	
1/16	1,59	1 7/8	7/8	214 801	10
5/64	1,98	2	1	214 802	10
3/32	2,38	2 1/4	1 1/4	214 803	10
7/64	2,78	2 5/8	1 1/2	214 804	10
1/8	3,18	2 3/4	1 5/8	214 805	10
9/64	3,57	2 7/8	1 3/4	214 806	10
5/32	3,97	3 1/8	2	214 807	10
11/64	4,37	3 1/4	2 1/8	214 808	10
3/16	4,76	3 1/2	2 5/16	214 809	10
13/64	5,16	3 5/8	2 7/16	214 810	10
7/32	5,56	3 3/4	2 1/2	214 811	10
15/64	5,95	3 7/8	2 5/8	214 812	10
1/4	6,35	4	2 3/4	214 813	10
17/64	6,75	4 1/8	2 7/8	214 814	10
9/32	7,14	4 1/4	2 15/16	214 815	10
19/64	7,54	4 3/8	3 1/16	214 816	10
5/16	7,94	4 1/2	3 3/16	214 817	10
21/64	8,33	4 5/8	3 5/16	214 818	10
11/32	8,73	4 3/4	3 7/16	214 819	10
23/64	9,13	4 7/8	3 1/2	214 820	10
3/8	9,53	5	3 5/8	214 821	10
25/64	9,92	5 1/8	3 3/4	214 822	10
13/32	10,32	5 1/4	3 7/8	214 823	10
27/64	10,72	5 3/8	3 15/16	214 824	5
7/16	11,11	5 1/2	4 1/16	214 825	5
29/64	11,51	5 5/8	4 3/16	214 826	5
15/32	11,91	5 3/4	4 5/16	214 827	5
31/64	12,30	5 7/8	4 3/8	214 828	5
1/2	12,70	6	4 1/2	214 829	5

HSS-G	TIN	
250 801 T	10	
250 802 T	10	
250 803 T	10	
250 804 T	10	
250 805 T	10	
250 806 T	10	
250 807 T	10	
250 808 T	10	
250 809 T	10	
250 810 T	10	
250 811 T	10	
250 812 T	10	
250 813 T	10	
250 814 T	10	
250 815 T	10	
250 816 T	10	
250 817 T	10	
250 818 T	10	
250 819 T	10	
250 820 T	10	
250 821 T	10	
250 822 T	10	
250 823 T	10	
250 824 T	5	
250 825 T	5	
250 826 T	5	
250 827 T	5	
250 828 T	5	
250 829 T	5	

Twist drill sets DIN 338 type N, in fractional sizes

	HSS-G	HSS-G TIN
21-piece set of twist drills DIN 338 type N, in fractional sizes Ø 1/16" up to 3/8" in increments of 1/64" in steel case	214 850	250 850 T
29-piece set of twist drills DIN 338 type N, in fractional sizes Ø 1/16" up to 1/2" in increments of 1/64" in steel case	214 851	250 851 T
















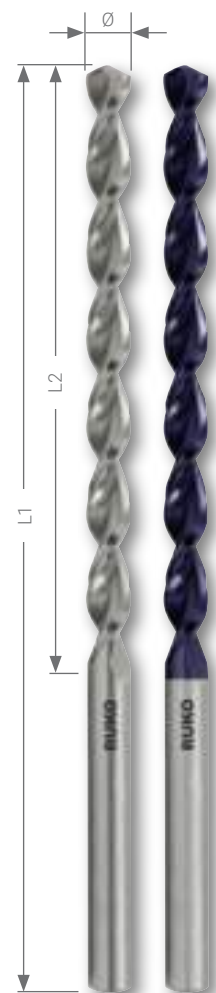
Twist drills DIN 340 TL 3000, HSSE-Co 5 ground



Highly stable multirange drill with outstanding heat resistance, a reinforced drill core and a parabolic flute for ideal chip removal. Ideal for drilling medium and long-chipping materials. Thanks to its thick core and the special flute with a rounded rear edge, this drill is best suited for high-performance use. It covers types N, H and W for a wide range of applications.



Packing unit: in plastic box




		
Steel (N/mm2) < 900		
Steel (N/mm2) < 1100		
Steel (N/mm2) < 1300		
Rust-resistant steel		
Aluminium		

		
Brass		
Bronze		
Plastics		
Cast iron		
Titanium alloyed		

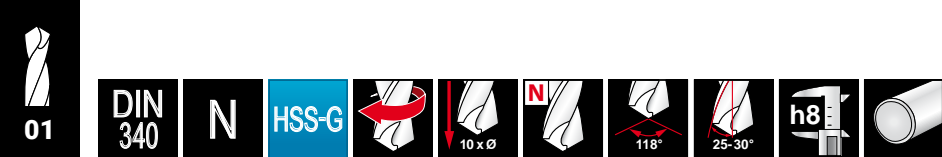


Ø mm	L1 mm	L2 mm		
2,50	95,0	62,0	253 025	10
3,00	100,0	66,0	253 030	10
3,10	106,0	69,0	253 031	10
3,20	106,0	69,0	253 032	10
3,30	106,0	69,0	253 033	10
3,40	112,0	73,0	253 034	10
3,50	112,0	73,0	253 035	10
3,60	112,0	73,0	253 036	10
3,70	112,0	73,0	253 037	10
3,80	119,0	78,0	253 038	10
3,90	119,0	78,0	253 039	10
4,00	119,0	78,0	253 040	10
4,10	119,0	78,0	253 041	10
4,20	119,0	78,0	253 042	10
4,30	126,0	82,0	253 043	10
4,40	126,0	82,0	253 044	10
4,50	126,0	82,0	253 045	10
4,60	126,0	82,0	253 046	10
4,70	126,0	82,0	253 047	10
4,80	132,0	87,0	253 048	10
4,90	132,0	87,0	253 049	10
5,00	132,0	87,0	253 050	10
5,10	132,0	87,0	253 051	10
5,20	132,0	87,0	253 052	10
5,30	132,0	87,0	253 053	10
5,40	139,0	91,0	253 054	10
5,50	139,0	91,0	253 055	10
5,60	139,0	91,0	253 056	10
5,70	139,0	91,0	253 057	10
5,80	139,0	91,0	253 058	10
5,90	139,0	91,0	253 059	10
6,00	139,0	91,0	253 060	10
6,10	148,0	97,0	253 061	10
6,20	148,0	97,0	253 062	10
6,30	148,0	97,0	253 063	10

	
253 025 F	10
253 030 F	10
253 031 F	10
253 032 F	10
253 033 F	10
253 034 F	10
253 035 F	10
253 036 F	10
253 037 F	10
253 038 F	10
253 039 F	10
253 040 F	10
253 041 F	10
253 042 F	10
253 043 F	10
253 044 F	10
253 045 F	10
253 046 F	10
253 047 F	10
253 048 F	10
253 049 F	10
253 050 F	10
253 051 F	10
253 052 F	10
253 053 F	10
253 054 F	10
253 055 F	10
253 056 F	10
253 057 F	10
253 058 F	10
253 059 F	10
253 060 F	10
253 061 F	10
253 062 F	10
253 063 F	10

Ø mm	L1 mm	L2 mm	HSSE Co 5			HSSE Co 5	TAIN	
6,40	148,0	97,0	253 064	10		253 064 F	10	
6,50	148,0	97,0	253 065	10		253 065 F	10	
6,60	148,0	97,0	253 066	10		253 066 F	10	
6,70	148,0	97,0	253 067	10		253 067 F	10	
6,80	156,0	102,0	253 068	10		253 068 F	10	
6,90	156,0	102,0	253 069	10		253 069 F	10	
7,00	156,0	102,0	253 070	10		253 070 F	10	
7,10	156,0	102,0	253 071	10		253 071 F	10	
7,20	156,0	102,0	253 072	10		253 072 F	10	
7,30	156,0	102,0	253 073	10		253 073 F	10	
7,40	156,0	102,0	253 074	10		253 074 F	10	
7,50	156,0	102,0	253 075	10		253 075 F	10	
7,60	165,0	109,0	253 076	10		253 076 F	10	
7,70	165,0	109,0	253 077	10		253 077 F	10	
7,80	165,0	109,0	253 078	10		253 078 F	10	
7,90	165,0	109,0	253 079	10		253 079 F	10	
8,00	165,0	109,0	253 080	10		253 080 F	10	
8,10	165,0	109,0	253 081	10		253 081 F	10	
8,20	165,0	109,0	253 082	10		253 082 F	10	
8,30	165,0	109,0	253 083	10		253 083 F	10	
8,40	165,0	109,0	253 084	10		253 084 F	10	
8,50	165,0	109,0	253 085	10		253 085 F	10	
8,60	175,0	115,0	253 086	10		253 086 F	10	
8,70	175,0	115,0	253 087	10		253 087 F	10	
8,80	175,0	115,0	253 088	10		253 088 F	10	
8,90	175,0	115,0	253 089	10		253 089 F	10	
9,00	175,0	115,0	253 090	10		253 090 F	10	
9,10	175,0	115,0	253 091	10		253 091 F	10	
9,20	175,0	115,0	253 092	10		253 092 F	10	
9,30	175,0	115,0	253 093	10		253 093 F	10	
9,40	175,0	115,0	253 094	10		253 094 F	10	
9,50	175,0	115,0	253 095	10		253 095 F	10	
9,60	184,0	121,0	253 096	10		253 096 F	10	
9,70	184,0	121,0	253 097	10		253 097 F	10	
9,80	184,0	121,0	253 098	10		253 098 F	10	
9,90	184,0	121,0	253 099	10		253 099 F	10	
10,00	184,0	121,0	253 100	10		253 100 F	10	
10,50	184,0	121,0	253 105	5		253 105 F	5	
11,00	195,0	128,0	253 110	5		253 110 F	5	
11,50	195,0	128,0	253 115	5		253 115 F	5	
12,00	205,0	134,0	253 120	5		253 120 F	5	
12,50	205,0	134,0	253 125	5		253 125 F	5	
13,00	205,0	134,0	253 130	5		253 130 F	5	





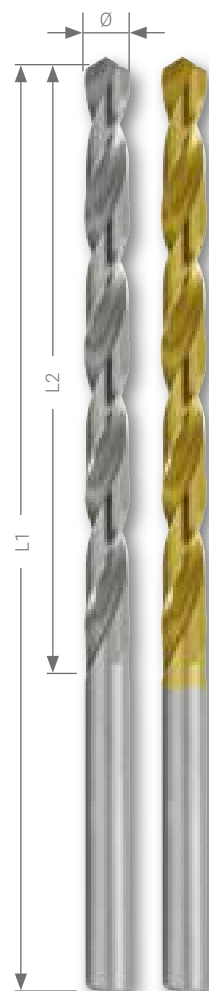
Twist drills DIN 340 type N, HSS ground

High-performance ground standard twist drill made from heavy-duty high speed steel. The fully ground twist drill has a precise concentricity.

Packing unit: in plastic box





Steel (N/mm ²) < 900		
Steel (N/mm ²) < 1100		
Steel (N/mm ²) < 1300		
Rust-resistant steel		
Aluminium		

Brass		
Bronze		
Plastics		
Cast iron		
Titanium alloyed		



Ø mm	L1 mm	L2 mm	HSS-G	
2,50	95,0	62,0	203 025	10
3,00	100,0	66,0	203 030	10
3,10	106,0	69,0	203 031	10
3,20	106,0	69,0	203 032	10
3,30	106,0	69,0	203 033	10
3,40	112,0	73,0	203 034	10
3,50	112,0	73,0	203 035	10
3,60	112,0	73,0	203 036	10
3,70	112,0	73,0	203 037	10
3,80	119,0	78,0	203 038	10
3,90	119,0	78,0	203 039	10
4,00	119,0	78,0	203 040	10
4,10	119,0	78,0	203 041	10
4,20	119,0	78,0	203 042	10
4,30	126,0	82,0	203 043	10
4,40	126,0	82,0	203 044	10
4,50	126,0	82,0	203 045	10
4,60	126,0	82,0	203 046	10
4,70	126,0	82,0	203 047	10
4,80	132,0	87,0	203 048	10
4,90	132,0	87,0	203 049	10
5,00	132,0	87,0	203 050	10
5,10	132,0	87,0	203 051	10
5,20	132,0	87,0	203 052	10
5,30	132,0	87,0	203 053	10
5,40	139,0	91,0	203 054	10
5,50	139,0	91,0	203 055	10
5,60	139,0	91,0	203 056	10
5,70	139,0	91,0	203 057	10
5,80	139,0	91,0	203 058	10
5,90	139,0	91,0	203 059	10
6,00	139,0	91,0	203 060	10
6,10	148,0	97,0	203 061	10
6,20	148,0	97,0	203 062	10
6,30	148,0	97,0	203 063	10

HSS-G	TIN	
203 025 T		10
203 030 T		10
203 031 T		10
203 032 T		10
203 033 T		10
203 034 T		10
203 035 T		10
203 036 T		10
203 037 T		10
203 038 T		10
203 039 T		10
203 040 T		10
203 041 T		10
203 042 T		10
203 043 T		10
203 044 T		10
203 045 T		10
203 046 T		10
203 047 T		10
203 048 T		10
203 049 T		10
203 050 T		10
203 051 T		10
203 052 T		10
203 053 T		10
203 054 T		10
203 055 T		10
203 056 T		10
203 057 T		10
203 058 T		10
203 059 T		10
203 060 T		10
203 061 T		10
203 062 T		10
203 063 T		10

Ø mm	L1 mm	L2 mm	HSS-G 		HSS-G TiN 	
6,40	148,0	97,0	203 064	10	203 064 T	10
6,50	148,0	97,0	203 065	10	203 065 T	10
6,60	148,0	97,0	203 066	10	203 066 T	10
6,70	148,0	97,0	203 067	10	203 067 T	10
6,80	156,0	102,0	203 068	10	203 068 T	10
6,90	156,0	102,0	203 069	10	203 069 T	10
7,00	156,0	102,0	203 070	10	203 070 T	10
7,10	156,0	102,0	203 071	10	203 071 T	10
7,20	156,0	102,0	203 072	10	203 072 T	10
7,30	156,0	102,0	203 073	10	203 073 T	10
7,40	156,0	102,0	203 074	10	203 074 T	10
7,50	156,0	102,0	203 075	10	203 075 T	10
7,60	165,0	109,0	203 076	10	203 076 T	10
7,70	165,0	109,0	203 077	10	203 077 T	10
7,80	165,0	109,0	203 078	10	203 078 T	10
7,90	165,0	109,0	203 079	10	203 079 T	10
8,00	165,0	109,0	203 080	10	203 080 T	10
8,10	165,0	109,0	203 081	10	203 081 T	10
8,20	165,0	109,0	203 082	10	203 082 T	10
8,30	165,0	109,0	203 083	10	203 083 T	10
8,40	165,0	109,0	203 084	10	203 084 T	10
8,50	165,0	109,0	203 085	10	203 085 T	10
8,60	175,0	115,0	203 086	10	203 086 T	10
8,70	175,0	115,0	203 087	10	203 087 T	10
8,80	175,0	115,0	203 088	10	203 088 T	10
8,90	175,0	115,0	203 089	10	203 089 T	10
9,00	175,0	115,0	203 090	10	203 090 T	10
9,10	175,0	115,0	203 091	10	203 091 T	10
9,20	175,0	115,0	203 092	10	203 092 T	10
9,30	175,0	115,0	203 093	10	203 093 T	10
9,40	175,0	115,0	203 094	10	203 094 T	10
9,50	175,0	115,0	203 095	10	203 095 T	10
9,60	184,0	121,0	203 096	10	203 096 T	10
9,70	184,0	121,0	203 097	10	203 097 T	10
9,80	184,0	121,0	203 098	10	203 098 T	10
9,90	184,0	121,0	203 099	10	203 099 T	10
10,00	184,0	121,0	203 100	10	203 100 T	10
10,50	184,0	121,0	203 105	5	203 105 T	5
11,00	195,0	128,0	203 110	5	203 110 T	5
11,50	195,0	128,0	203 115	5	203 115 T	5
12,00	205,0	134,0	203 120	5	203 120 T	5
12,50	205,0	134,0	203 125	5	203 125 T	5
13,00	205,0	134,0	203 130	5	203 130 T	5





Twist drills DIN 1869 TL 3000, HSS ground - extra long

Stable special drill. Ideally suitable for deep holes under difficult conditions, e.g. bad chipping materials.

Suitable for all usual drilling work in all normal materials. High rotational precision. For drilling deep holes please use small feed and remove chips frequently.

Packing unit: in plastic box

Steel (N/mm2) < 900	■
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Ø mm	L1 mm	L2 mm	HSS-G	
2,00	125,0	85,0	254 020	1
2,50	140,0	95,0	254 025	1
3,00	150,0	100,0	254 030	1
3,20	155,0	105,0	254 032	1
3,30	155,0	105,0	254 033	1
3,50	165,0	115,0	254 035	1
4,00	175,0	120,0	254 040	1
4,20	175,0	120,0	254 042	1
4,50	185,0	125,0	254 045	1
5,00	195,0	135,0	254 050	1
5,50	205,0	140,0	254 055	1
6,00	205,0	140,0	254 060	1
6,50	215,0	150,0	254 065	1

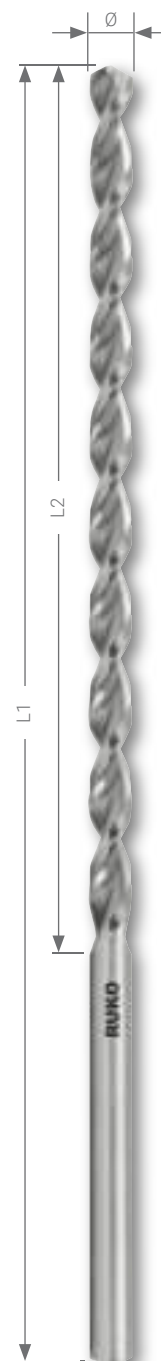
Ø mm	L1 mm	L2 mm	HSS-G	
7,00	225,0	155,0	254 070	1
7,50	225,0	155,0	254 075	1
8,00	240,0	165,0	254 080	1
8,50	240,0	165,0	254 085	1
9,00	250,0	175,0	254 090	1
9,50	250,0	175,0	254 095	1
10,00	265,0	185,0	254 100	1
10,50	265,0	185,0	254 105	1
11,00	280,0	195,0	254 110	1
11,50	280,0	195,0	254 115	1
12,00	295,0	205,0	254 120	1
12,50	295,0	205,0	254 125	1
13,00	295,0	205,0	254 130	1

3,00	190,0	130,0	255 030	1
3,20	200,0	135,0	255 032	1
3,30	200,0	135,0	255 033	1
3,50	210,0	145,0	255 035	1
4,00	220,0	150,0	255 040	1
4,20	220,0	150,0	255 042	1
4,50	235,0	160,0	255 045	1
5,00	245,0	170,0	255 050	1
5,50	260,0	180,0	255 055	1
6,00	260,0	180,0	255 060	1
6,50	275,0	190,0	255 065	1
7,00	290,0	200,0	255 070	1

7,50	290,0	200,0	255 075	1
8,00	305,0	210,0	255 080	1
8,50	305,0	210,0	255 085	1
9,00	320,0	220,0	255 090	1
9,50	320,0	220,0	255 095	1
10,00	340,0	235,0	255 100	1
10,50	340,0	235,0	255 105	1
11,00	365,0	250,0	255 110	1
11,50	365,0	250,0	255 115	1
12,00	375,0	260,0	255 120	1
12,50	375,0	260,0	255 125	1
13,00	375,0	260,0	255 130	1

3,50	265,0	180,0	256 035	1
4,00	280,0	190,0	256 040	1
4,20	280,0	190,0	256 042	1
4,50	295,0	200,0	256 045	1
5,00	315,0	210,0	256 050	1
5,50	330,0	225,0	256 055	1
6,00	330,0	225,0	256 060	1
6,50	350,0	235,0	256 065	1
7,00	370,0	250,0	256 070	1
7,50	370,0	250,0	256 075	1
8,00	390,0	265,0	256 080	1

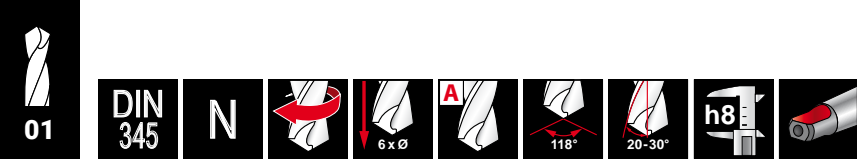
8,50	390,0	265,0	256 085	1
9,00	410,0	280,0	256 090	1
9,50	410,0	280,0	256 095	1
10,00	430,0	295,0	256 100	1
10,50	430,0	295,0	256 105	1
11,00	455,0	310,0	256 110	1
11,50	455,0	310,0	256 115	1
12,00	480,0	330,0	256 120	1
12,50	480,0	330,0	256 125	1
13,00	480,0	330,0	256 130	1
—	—	—	—	—





DIN 1869 · TL 3000





Twist drills DIN 345 type N, HSS and HSSE-Co 5








Performance standard drills with a morse taper shank.
Suitable for drilling steel, cast steel and cast iron – alloyed and unalloyed. Resistant to fracture.

Packing unit: in plastic box

Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100		■	■
Steel (N/mm2) < 1300			□
Rust-resistant steel		■	■
Aluminium	■	■	

Brass	■	■	■
Bronze	□	□	□
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			□

Ø1 mm	L1 mm	L2 mm		HSS 		HSSE Co 5 		HSSE Co 5 TIN 	
10,00	168,0	87,0	1	204 100	1	204 100 E	1	204 100 T	1
10,50	168,0	87,0	1	204 105	1	204 105 E	1	204 105 T	1
11,00	175,0	94,0	1	204 110	1	204 110 E	1	204 110 T	1
11,50	175,0	94,0	1	204 115	1	204 115 E	1	204 115 T	1
12,00	182,0	101,0	1	204 120	1	204 120 E	1	204 120 T	1
12,50	182,0	101,0	1	204 125	1	204 125 E	1	204 125 T	1
13,00	182,0	101,0	1	204 130	1	204 130 E	1	204 130 T	1
13,50	189,0	108,0	1	204 135	1	204 135 E	1	204 135 T	1
14,00	189,0	108,0	1	204 140	1	204 140 E	1	204 140 T	1
14,50	212,0	114,0	2	204 145	1	204 145 E	1	204 145 T	1
15,00	212,0	114,0	2	204 150	1	204 150 E	1	204 150 T	1
15,50	218,0	120,0	2	204 155	1	204 155 E	1	204 155 T	1
16,00	218,0	120,0	2	204 160	1	204 160 E	1	204 160 T	1
16,50	223,0	125,0	2	204 165	1	204 165 E	1	204 165 T	1
17,00	223,0	125,0	2	204 170	1	204 170 E	1	204 170 T	1
17,50	228,0	130,0	2	204 175	1	204 175 E	1	204 175 T	1
18,00	228,0	130,0	2	204 180	1	204 180 E	1	204 180 T	1
18,50	233,0	135,0	2	204 185	1	204 185 E	1	204 185 T	1
19,00	233,0	135,0	2	204 190	1	204 190 E	1	204 190 T	1
19,50	238,0	140,0	2	204 195	1	204 195 E	1	204 195 T	1
20,00	238,0	140,0	2	204 200	1	204 200 E	1	204 200 T	1
20,50	243,0	145,0	2	204 205	1	204 205 E	1	204 205 T	1
21,00	243,0	145,0	2	204 210	1	204 210 E	1	204 210 T	1
21,50	248,0	150,0	2	204 215	1	204 215 E	1	204 215 T	1
22,00	248,0	150,0	2	204 220	1	204 220 E	1	204 220 T	1
22,50	253,0	155,0	2	204 225	1	204 225 E	1	204 225 T	1
23,00	253,0	155,0	2	204 230	1	204 230 E	1	204 230 T	1
23,50	276,0	155,0	3	204 235	1	204 235 E	1	204 235 T	1
24,00	281,0	160,0	3	204 240	1	204 240 E	1	204 240 T	1
24,50	281,0	160,0	3	204 245	1	204 245 E	1	204 245 T	1
25,00	281,0	160,0	3	204 250	1	204 250 E	1	204 250 T	1
25,50	286,0	165,0	3	204 255	1	204 255 E	1	204 255 T	1
26,00	286,0	165,0	3	204 260	1	204 260 E	1	204 260 T	1
26,50	286,0	165,0	3	204 265	1	204 265 E	1	204 265 T	1
27,00	291,0	170,0	3	204 270	1	204 270 E	1	204 270 T	1
27,50	291,0	170,0	3	204 275	1	204 275 E	1	204 275 T	1
28,00	291,0	170,0	3	204 280	1	204 280 E	1	204 280 T	1
28,50	296,0	175,0	3	204 285	1	204 285 E	1	204 285 T	1
29,00	296,0	175,0	3	204 290	1	204 290 E	1	204 290 T	1
29,50	296,0	175,0	3	204 295	1	204 295 E	1	204 295 T	1

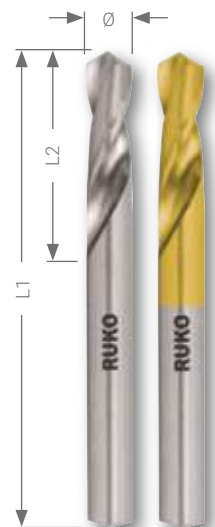
Ø1 mm	L1 mm	L2 mm							
30,00	296,0	175,0	3	204 300	1	204 300 E	1	204 300 T	1
30,50	301,0	180,0	3	204 305	1	—	—	—	—
31,00	301,0	180,0	3	204 310	1	—	—	—	—
31,50	301,0	180,0	3	204 315	1	—	—	—	—
32,00	334,0	185,0	4	204 320	1	—	—	—	—
32,50	334,0	185,0	4	204 325	1	—	—	—	—
33,00	334,0	185,0	4	204 330	1	—	—	—	—
33,50	334,0	185,0	4	204 335	1	—	—	—	—
34,00	339,0	190,0	4	204 340	1	—	—	—	—
34,50	339,0	190,0	4	204 345	1	—	—	—	—
35,00	339,0	190,0	4	204 350	1	—	—	—	—
35,50	339,0	190,0	4	204 355	1	—	—	—	—
36,00	344,0	195,0	4	204 360	1	—	—	—	—
36,50	344,0	195,0	4	204 365	1	—	—	—	—
37,00	344,0	195,0	4	204 370	1	—	—	—	—
37,50	344,0	195,0	4	204 375	1	—	—	—	—
38,00	349,0	200,0	4	204 380	1	—	—	—	—
38,50	349,0	200,0	4	204 385	1	—	—	—	—
39,00	349,0	200,0	4	204 390	1	—	—	—	—
39,50	349,0	200,0	4	204 395	1	—	—	—	—
40,00	349,0	200,0	4	204 400	1	—	—	—	—
40,50	354,0	205,0	4	204 405	1	—	—	—	—
41,00	354,0	205,0	4	204 410	1	—	—	—	—
41,50	354,0	205,0	4	204 415	1	—	—	—	—
42,00	354,0	205,0	4	204 420	1	—	—	—	—
42,50	354,0	205,0	4	204 425	1	—	—	—	—
43,00	359,0	210,0	4	204 430	1	—	—	—	—
43,50	359,0	210,0	4	204 435	1	—	—	—	—
44,00	359,0	210,0	4	204 440	1	—	—	—	—
44,50	359,0	210,0	4	204 445	1	—	—	—	—
45,00	359,0	210,0	4	204 450	1	—	—	—	—
45,50	364,0	215,0	4	204 455	1	—	—	—	—
46,00	364,0	215,0	4	204 460	1	—	—	—	—
46,50	364,0	215,0	4	204 465	1	—	—	—	—
47,00	364,0	215,0	4	204 470	1	—	—	—	—
47,50	364,0	215,0	4	204 475	1	—	—	—	—
48,00	369,0	220,0	4	204 480	1	—	—	—	—
48,50	369,0	220,0	4	204 485	1	—	—	—	—
49,00	369,0	220,0	4	204 490	1	—	—	—	—
49,50	369,0	220,0	4	204 495	1	—	—	—	—
50,00	369,0	220,0	4	204 500	1	—	—	—	—
51,00	412,0	225,0	5	204 510	1	—	—	—	—
52,00	412,0	225,0	5	204 520	1	—	—	—	—
53,00	412,0	225,0	5	204 530	1	—	—	—	—
54,00	417,0	230,0	5	204 540	1	—	—	—	—
55,00	417,0	230,0	5	204 550	1	—	—	—	—
56,00	417,0	230,0	5	204 560	1	—	—	—	—
57,00	422,0	235,0	5	204 570	1	—	—	—	—
58,00	422,0	235,0	5	204 580	1	—	—	—	—
59,00	422,0	235,0	5	204 590	1	—	—	—	—
60,00	422,0	235,0	5	204 600	1	—	—	—	—





Twist drills DIN 1897 type N, HSS-G ground - short

Short and stable twist drill with distinctive heat resistance. Ideally suited for assembly work with thin-walled materials such as sheet steels, flat steels and profile steel in bodysheet construction. Use in hand-held drilling machines, with automatic machines and with turret lathes.







Packing unit: in plastic box

Steel (N/mm ²) < 900	■	■
Steel (N/mm ²) < 1100		□
Steel (N/mm ²) < 1300		
Rust-resistant steel		□
Aluminium	■	

Brass	■	■
Bronze	□	□
Plastics	■	■
Cast iron	□	□
Titanium alloyed		

Ø mm	L1 mm	L2 mm				
2,00	38,0	12,0	202 020	10	202 020 T	10
2,10	38,0	12,0	202 021	10	202 021 T	10
2,20	40,0	13,0	202 022	10	202 022 T	10
2,30	40,0	13,0	202 023	10	202 023 T	10
2,40	43,0	14,0	202 024	10	202 024 T	10
2,50	43,0	14,0	202 025	10	202 025 T	10
2,60	43,0	14,0	202 026	10	202 026 T	10
2,70	46,0	16,0	202 027	10	202 027 T	10
2,80	46,0	16,0	202 028	10	202 028 T	10
2,90	46,0	16,0	202 029	10	202 029 T	10
3,00	46,0	16,0	202 030	10	202 030 T	10
3,10	49,0	18,0	202 031	10	202 031 T	10
3,20	49,0	18,0	202 032	10	202 032 T	10
3,30	49,0	18,0	202 033	10	202 033 T	10
3,40	52,0	20,0	202 034	10	202 034 T	10
3,50	52,0	20,0	202 035	10	202 035 T	10
3,60	52,0	20,0	202 036	10	202 036 T	10
3,70	52,0	20,0	202 037	10	202 037 T	10
3,80	55,0	22,0	202 038	10	202 038 T	10
3,90	55,0	22,0	202 039	10	202 039 T	10
4,00	55,0	22,0	202 040	10	202 040 T	10
4,10	55,0	22,0	202 041	10	202 041 T	10
4,20	55,0	22,0	202 042	10	202 042 T	10
4,30	58,0	24,0	202 043	10	202 043 T	10
4,40	58,0	24,0	202 044	10	202 044 T	10
4,50	58,0	24,0	202 045	10	202 045 T	10
4,60	58,0	24,0	202 046	10	202 046 T	10
4,70	58,0	24,0	202 047	10	202 047 T	10
4,80	62,0	26,0	202 048	10	202 048 T	10
4,90	62,0	26,0	202 049	10	202 049 T	10
5,00	62,0	26,0	202 050	10	202 050 T	10
5,10	62,0	26,0	202 051	10	202 051 T	10
5,20	62,0	26,0	202 052	10	202 052 T	10
5,30	62,0	26,0	202 053	10	202 053 T	10
5,40	66,0	28,0	202 054	10	202 054 T	10
5,50	66,0	28,0	202 055	10	202 055 T	10
5,60	66,0	28,0	202 056	10	202 056 T	10
5,70	66,0	28,0	202 057	10	202 057 T	10
5,80	66,0	28,0	202 058	10	202 058 T	10
5,90	66,0	28,0	202 059	10	202 059 T	10

Ø mm	L1 mm	L2 mm				
6,00	66,0	28,0	202 060	10	202 060 T	10
6,50	70,0	31,0	202 065	10	202 065 T	10
6,80	74,0	34,0	202 068	10	202 068 T	10
7,00	74,0	34,0	202 070	10	202 070 T	10
7,20	74,0	34,0	202 072	10	202 072 T	10
7,50	74,0	34,0	202 075	10	202 075 T	10
7,80	79,0	37,0	202 078	10	202 078 T	10
8,00	79,0	37,0	202 080	10	202 080 T	10
8,50	79,0	37,0	202 085	10	202 085 T	10
9,00	84,0	40,0	202 090	10	202 090 T	10
9,50	84,0	40,0	202 095	10	202 095 T	10
10,00	89,0	43,0	202 100	10	202 100 T	10
10,20	89,0	43,0	202 102	10	202 102 T	10
10,50	89,0	43,0	202 105	5	202 105 T	5
11,00	95,0	47,0	202 110	5	202 110 T	5
11,50	95,0	47,0	202 115	5	202 115 T	5
12,00	102,0	51,0	202 120	5	202 120 T	5
12,50	102,0	51,0	202 125	5	202 125 T	5
13,00	102,0	51,0	202 130	5	202 130 T	5



Centre drills DIN 333, HSS ground

Centre drills for making centre holes according to shape A, shape A with reinforcing bead and shape R.

A shape A

A₊ shape A with reinforcing bead

R shape R



Packing unit: in plastic box

	A	A ₊	R		A	A ₊	R
Steel (N/mm ²) < 900	■	■	■	Brass	■	■	■
Steel (N/mm ²) < 1100				Bronze	□	□	□
Steel (N/mm ²) < 1300				Plastics	■	■	■
Rust-resistant steel				Cast iron	□	□	□
Aluminium	■	■	■	Titanium alloyed			

Ø1 mm	L1 mm	Ø2 mm	HSS	A		HSS	A ₊		HSS	R	
0,80	20,0	3,15	217 008	1		—	1		217 2 008	1	
1,00	31,5	3,15	217 010	1		217 1 010	1		217 2 010	1	
1,60	35,5	4,00	217 016	1		217 1 016	1		217 2 016	1	
2,00	40,0	5,00	217 020	1		217 1 020	1		217 2 020	1	
2,50	45,0	6,30	217 025	1		217 1 025	1		217 2 025	1	
3,15	50,0	8,00	217 315	1		217 1 315	1		217 2 315	1	
4,00	56,0	10,00	217 040	1		217 1 040	1		217 2 040	1	
5,00	63,0	12,50	217 050	1		217 1 050	1		217 2 050	1	
6,30	71,0	16,00	217 063	1		217 1 063	1		217 2 063	1	



Twist drills DIN 1897 type N, HSSE-Co 5 ground - short

Short and stable twist drill with distinctive heat resistance. Ideally suited for assembly work with thin-walled materials such as sheet steels, flat steels and profile steel in bodysHELL construction. Use in hand-held drilling machines, with automatic machines and with turret lathes.

Special sizes available on request.



Packing unit: in plastic box

Steel (N/mm2) < 900		
Steel (N/mm2) < 1100		
Steel (N/mm2) < 1300		
Rust-resistant steel		
Aluminium		
Brass		
Bronze		
Plastics		
Cast iron		
Titanium alloyed		

Ø mm	L1 mm	L2 mm		
2,00	38,0	12,0	202 020 E	10
2,50	43,0	14,0	202 025 E	10
3,00	46,0	16,0	202 030 E	10
3,10	49,0	18,0	202 031 E	10
3,20	49,0	18,0	202 032 E	10
3,25	49,0	18,0	202 0325 E	10
3,30	49,0	18,0	202 033 E	10
3,50	52,0	20,0	202 035 E	10
3,60	52,0	20,0	202 036 E	10
4,00	55,0	22,0	202 040 E	10
4,10	55,0	22,0	202 041 E	10
4,20	55,0	22,0	202 042 E	10
4,50	58,0	24,0	202 045 E	10
4,80	62,0	26,0	202 048 E	10
4,90	62,0	26,0	202 049 E	10
5,00	62,0	26,0	202 050 E	10
5,10	62,0	26,0	202 051 E	10
5,20	62,0	26,0	202 052 E	10
5,50	66,0	28,0	202 055 E	10
5,70	66,0	28,0	202 057 E	10
5,80	66,0	28,0	202 058 E	10
5,90	66,0	28,0	202 059 E	10
6,00	66,0	28,0	202 060 E	10
6,30	70,0	31,0	202 063 E	10
6,50	70,0	31,0	202 065 E	10
6,80	74,0	34,0	202 068 E	10
7,00	74,0	34,0	202 070 E	10
7,50	74,0	34,0	202 075 E	10
8,00	79,0	37,0	202 080 E	10
8,50	79,0	37,0	202 085 E	10
9,00	84,0	40,0	202 090 E	10
9,50	84,0	40,0	202 095 E	10
10,00	89,0	43,0	202 100 E	10
10,50	89,0	43,0	202 105 E	5
11,00	95,0	47,0	202 110 E	5
11,50	95,0	47,0	202 115 E	5
12,00	102,0	51,0	202 120 E	5
12,50	102,0	51,0	202 125 E	5
13,00	102,0	51,0	202 130 E	5

202 020 EF		10
202 025 EF		10
202 030 EF		10
202 031 EF		10
202 032 EF		10
202 0325 EF		10
202 033 EF		10
202 035 EF		10
202 036 EF		10
202 040 EF		10
202 041 EF		10
202 042 EF		10
202 045 EF		10
202 048 EF		10
202 049 EF		10
202 050 EF		10
202 051 EF		10
202 052 EF		10
202 055 EF		10
202 057 EF		10
202 058 EF		10
202 059 EF		10
202 060 EF		10
202 063 EF		10
202 065 EF		10
202 068 EF		10
202 070 EF		10
202 075 EF		10
202 080 EF		10
202 085 EF		10
202 090 EF		10
202 095 EF		10
202 100 EF		10
202 105 EF		5
202 110 EF		5
202 115 EF		5
202 120 EF		5
202 125 EF		5
202 130 EF		5



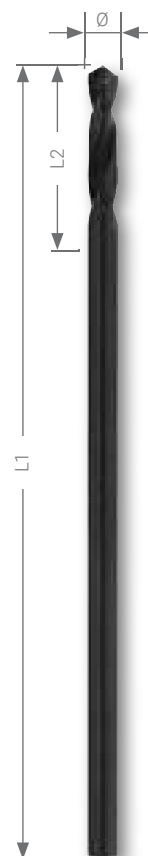
Hollow section twist drills type N, HSS ground

Due to the short spiral shape the drill is particularly suitable for the working and fitting of hollow sections. The reduction of the cross cutting edge guarantees an optimized centring and long tool life.

Packing unit: in plastic box

Steel (N/mm ²) < 900	■
Steel (N/mm ²) < 1100	
Steel (N/mm ²) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	
Plastics	■
Cast iron	
Titanium alloyed	



Ø mm	L1 mm	L2 mm	HSS-G	
4,90	70,0	30,0	257 515	10
4,90	100,0	30,0	257 491	10
4,90	120,0	30,0	257 516	10
4,90	150,0	30,0	257 492	10
5,00	70,0	30,0	257 501	10
5,00	100,0	30,0	257 502	10
5,00	120,0	30,0	257 517	10
5,00	150,0	30,0	257 503	10
5,00	180,0	30,0	257 518	10
5,00	210,0	30,0	257 504	10
5,10	70,0	30,0	257 519	10
5,10	100,0	30,0	257 511	10
5,10	120,0	30,0	257 520	10
5,10	150,0	30,0	257 512	10
5,10	180,0	30,0	257 521	10
5,10	210,0	30,0	257 513	10
5,30	70,0	30,0	257 522	10
5,30	100,0	30,0	257 531	10
5,30	120,0	30,0	257 523	10
5,30	150,0	30,0	257 532	10
5,30	180,0	30,0	257 524	10
5,30	210,0	30,0	257 533	10
5,50	100,0	30,0	257 551	10
5,50	150,0	30,0	257 552	10
5,50	210,0	30,0	257 553	10
5,70	70,0	30,0	257 571	10
5,70	100,0	30,0	257 572	10
5,70	150,0	30,0	257 573	10
5,70	180,0	30,0	257 529	10
5,70	210,0	30,0	257 574	10
5,80	70,0	30,0	257 530	10
5,80	100,0	30,0	257 581	10
5,80	120,0	30,0	257 534	10
5,80	150,0	30,0	257 582	10
5,80	180,0	30,0	257 535	10
5,80	210,0	30,0	257 583	10



Spot drills type N, HSS ground - extra short

Extra short and stable standard drill. Shorter than DIN 1897. Ideally suitable for assembly work in thin-walled materials such as sheet steels, flat steels and profile steels. Highly secure against fracture. For use in all hand-held drilling machines.

Advantages DIN 1412 C: good centring, little pressure required. Chip spreading improves chip removal.



Packing unit: in plastic box

Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100		Bronze	□
Steel (N/mm ²) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

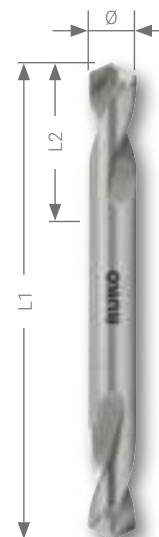
Ø mm	L1 mm	L2 mm	HSS-G	
2,50	38,0	14,0	251 025	10
2,80	40,0	16,0	251 028	10
3,00	40,0	16,0	251 030	10
3,10	40,0	16,0	251 031	10
3,20	40,0	16,0	251 032	10
3,25	41,0	16,0	251 0325	10
3,30	41,0	16,0	251 033	10
3,40	42,0	16,0	251 034	10
3,50	42,0	16,0	251 035	10
4,00	42,0	16,0	251 040	10
4,10	44,0	18,0	251 041	10
4,20	44,0	18,0	251 042	10
4,30	44,0	18,0	251 043	10
4,50	48,0	20,0	251 045	10
4,70	48,0	20,0	251 047	10
4,80	48,0	20,0	251 048	10
4,90	50,0	22,0	251 049	10
5,00	52,0	24,0	251 050	10
5,10	52,0	24,0	251 051	10
5,20	52,0	24,0	251 052	10
5,50	52,0	24,0	251 055	10
6,00	55,0	26,0	251 060	10
6,50	60,0	26,0	251 065	10



Double end drills type KV, HSS ground

Extra short and stable standard drill. Shorter than DIN 1897. Ideally suitable for assembly work in thin-walled materials such as sheet steels, flat steels and profile steels. High security against fracture. For use in hand-held drilling machines. Usable at both ends.

Advantages DIN 1412 C: good centring, little pressure required. Chip distribution improves chip removal.



Packing unit: in plastic box

Steel (N/mm ²) < 900	■
Steel (N/mm ²) < 1100	
Steel (N/mm ²) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Ø mm	L1 mm	L2 mm	HSS-G	
2,50	43,0	10,0	252 025	10
2,80	46,0	11,0	252 028	10
3,00	46,0	11,0	252 030	10
3,10	49,0	11,0	252 031	10
3,20	49,0	11,0	252 032	10
3,25	49,0	11,0	252 0325	10
3,30	49,0	11,0	252 033	10
3,40	52,0	14,0	252 034	10
3,50	52,0	14,0	252 035	10
4,00	55,0	14,0	252 040	10
4,10	55,0	14,0	252 041	10
4,20	55,0	14,0	252 042	10
4,30	58,0	17,0	252 043	10
4,50	58,0	17,0	252 045	10
4,80	62,0	17,0	252 048	10
4,90	62,0	17,0	252 049	10
5,00	62,0	17,0	252 050	10
5,10	62,0	17,0	252 051	10
5,20	62,0	17,0	252 052	10
5,50	66,0	20,0	252 055	10
6,00	66,0	20,0	252 060	10
6,50	70,0	20,0	252 065	10

Table of cutting speeds for twist drills

Drills Ø mm	Cutting speed Vc = m/min															
	4	6	8	10	12	15	18	20	25	30	35	40	50	60	80	100
	r.p.m.															
1,0	1274	1911	2548	3185	3822	4777	5732	6369	7962	9554	11146	12739	15924	19108	25478	31847
1,5	849	1274	1699	2123	2548	3185	3822	4246	5308	6369	7431	8493	10616	12739	16985	21231
2,0	637	955	1274	1592	1911	2389	2866	3185	3981	4777	5573	6369	7962	9554	12739	15924
2,5	510	764	1019	1274	1529	1911	2293	2548	3185	3822	4459	5096	6369	7643	10191	12739
3,0	425	637	849	1062	1274	1592	1911	2123	2654	3185	3715	4246	5308	6369	8493	10616
3,5	364	546	728	910	1092	1365	1638	1820	2275	2730	3185	3640	4550	5460	7279	9099
4,0	318	478	637	796	955	1194	1433	1592	1990	2389	2787	3185	3981	4777	6369	7962
4,5	283	425	566	708	849	1062	1274	1415	1769	2123	2477	2831	3539	4246	5662	7077
5,0	255	382	510	637	764	955	1146	1274	1592	1911	2229	2548	3185	3822	5096	6369
5,5	232	347	463	579	695	869	1042	1158	1448	1737	2027	2316	2895	3474	4632	5790
6,0	212	318	425	531	637	796	955	1062	1327	1592	1858	2123	2654	3185	4246	5308
6,5	196	294	392	490	588	735	882	980	1225	1470	1715	1960	2450	2940	3920	4900
7,0	182	273	364	455	546	682	819	910	1137	1365	1592	1820	2275	2730	3640	4550
7,5	170	255	340	425	510	637	764	849	1062	1274	1486	1699	2123	2548	3397	4246
8,0	159	239	318	398	478	597	717	796	995	1194	1393	1592	1990	2389	3185	3981
8,5	150	225	300	375	450	562	674	749	937	1124	1311	1499	1873	2248	2997	3747
9,0	142	212	283	354	425	531	637	708	885	1062	1238	1415	1769	2123	2831	3539
9,5	134	201	268	335	402	503	603	670	838	1006	1173	1341	1676	2011	2682	3352
10,0	127	191	255	318	382	478	573	637	796	955	1115	1274	1592	1911	2548	3185
11,0	116	174	232	290	347	434	521	579	724	869	1013	1158	1448	1737	2316	2895
12,0	106	159	212	265	318	398	478	531	663	796	929	1062	1327	1592	2123	2654
13,0	98	147	196	245	294	367	441	490	612	735	857	980	1225	1470	1960	2450
14,0	91	136	182	227	273	341	409	455	569	682	796	910	1137	1365	1820	2275
15,0	85	127	170	212	255	318	382	425	531	637	743	849	1062	1274	1699	2123
16,0	80	119	159	199	239	299	358	398	498	597	697	796	995	1194	1592	1990
17,0	75	112	150	187	225	281	337	375	468	562	656	749	937	1124	1499	1873
18,0	71	106	142	177	212	265	318	354	442	531	619	708	885	1062	1415	1769
19,0	67	101	134	168	201	251	302	335	419	503	587	670	838	1006	1341	1676
20,0	64	96	127	159	191	239	287	318	398	478	557	637	796	955	1274	1592
21,0	61	91	121	152	182	227	273	303	379	455	531	607	758	910	1213	1517
22,0	58	87	116	145	174	217	261	290	362	434	507	579	724	869	1158	1448
23,0	55	83	111	138	166	208	249	277	346	415	485	554	692	831	1108	1385
24,0	53	80	106	133	159	199	239	265	332	398	464	531	663	796	1062	1327
25,0	51	76	102	127	153	191	229	255	318	382	446	510	637	764	1019	1274
26,0	49	73	98	122	147	184	220	245	306	367	429	490	612	735	980	1225
27,0	47	71	94	118	142	177	212	236	295	354	413	472	590	708	944	1180
28,0	45	68	91	114	136	171	205	227	284	341	398	455	569	682	910	1137
29,0	44	66	88	110	132	165	198	220	275	329	384	439	549	659	879	1098
30,0	42	64	85	106	127	159	191	212	265	318	372	425	531	637	849	1062
31,0	41	62	82	103	123	154	185	205	257	308	360	411	514	616	822	1027
32,0	40	60	80	100	119	149	179	199	249	299	348	398	498	597	796	995
33,0	39	58	77	97	116	145	174	193	241	290	338	386	483	579	772	965
34,0	37	56	75	94	112	141	169	187	234	281	328	375	468	562	749	937
35,0	36	55	73	91	109	136	164	182	227	273	318	364	455	546	728	910
36,0	35	53	71	88	106	133	159	177	221	265	310	354	442	531	708	885
37,0	34	52	69	86	103	129	155	172	215	258	301	344	430	516	689	861
38,0	34	50	67	84	101	126	151	168	210	251	293	335	419	503	670	838
39,0	33	49	65	82	98	122	147	163	204	245	286	327	408	490	653	817
40,0	32	48	64	80	96	119	143	159	199	239	279	318	398	478	637	796
41,0	31	47	62	78	93	117	140	155	194	233	272	311	388	466	621	777
42,0	30	45	61	76	91	114	136	152	190	227	265	303	379	455	607	758
43,0	30	44	59	74	89	111	133	148	185	222	259	296	370	444	593	741
44,0	29	43	58	72	87	109	130	145	181	217	253	290	362	434	579	724
45,0	28	42	57	71	85	106	127	142	177	212	248	283	354	425	566	708
46,0	28	42	55	69	83	104	125	138	173	208	242	277	346	415	554	692
47,0	27	41	54	68	81	102	122	136	169	203	237	271	339	407	542	678
48,0	27	40	53	66	80	100	119	133	166	199	232	265	332	398	531	663
49,0	26	39	52	65	78	97	117	130	162	195	227	260	325	390	520	650
50,0	25	38	51	64	76	96	115	127	159	191	223	255	318	382	510	637

Material	Cutting speed Vc m/min	Coolant	Material	Cutting speed Vc m/min	Coolant
High carbon struc. steel < 700 N/mm ²	30 - 35	cutting spray	CuZn alloy tough	35 - 60	compressed air
High carbon struc. steel > 700 N/mm ²	20 - 25	cutting spray	Al alloy 11% Si	30 - 50	cutting spray
Alloyed steel < 1000 N/mm ²	20 - 25	cutting spray	Thermoplastics	20 - 40	water
Cast iron < 250 N/mm ²	15 - 25	compressed air	Duroplastics with inorganic filling	15 - 25	compressed air
Cast iron > 250 N/mm ²	10 - 20	compressed air	Duroplastics with organic filling	15 - 35	compressed air
CuZn alloy brittle	60 - 100	compressed air			

Table of cutting speeds for twist drills

Drills Ø inch	Cutting speed Vc = m/min															
	4	6	8	10	12	15	18	20	25	30	35	40	50	60	80	100
	r.p.m.															
1/16	800	1190	1590	1990	2390	2990	3580	3980	4980	5970	6970	7960	9950	11940	15920	19900
5/64	640	960	1270	1590	1910	2390	2870	3180	3980	4780	5570	6370	7960	9550	12740	15920
3/32	530	800	1060	1330	1590	1990	2390	2650	3320	3980	4640	5310	6630	7960	10620	13270
7/64	450	680	910	1140	1360	1710	2050	2270	2840	3410	3980	4550	5690	6820	9100	11370
1/8	400	600	800	1000	1190	1490	1790	1990	2490	2990	3480	3980	4980	5970	7960	9950
9/64	350	530	710	880	1060	1330	1590	1770	2210	2650	3100	3540	4420	5310	7080	8850
5/32	320	480	640	800	960	1190	1430	1590	1990	2390	2790	3180	3980	4780	6370	7960
11/64	290	430	580	720	870	1090	1300	1450	1810	2170	2530	2900	3620	4340	5790	7240
3/16	270	400	530	660	800	1000	1190	1330	1660	1990	2320	2650	3320	3980	5310	6630
13/64	240	370	490	610	730	920	1100	1220	1530	1840	2140	2450	3060	3670	4900	6120
7/32	230	340	450	570	680	850	1020	1140	1420	1710	1990	2270	2840	3410	4550	5690
15/64	210	320	420	530	640	800	960	1060	1330	1590	1860	2120	2650	3180	4250	5310
1/4	200	300	400	500	600	750	900	1000	1240	1490	1740	1990	2490	2990	3980	4980
17/64	190	290	380	480	570	710	860	950	1190	1430	1660	1900	2380	2850	3800	4750
9/32	180	270	360	450	540	670	810	900	1120	1350	1570	1790	2240	2690	3590	4490
19/64	170	250	340	420	510	640	760	850	1060	1270	1490	1700	2120	2550	3400	4250
5/16	160	240	320	400	480	600	730	810	1010	1210	1410	1610	2020	2420	3230	4030
21/64	150	230	310	380	460	580	690	770	960	1150	1340	1530	1920	2300	3070	3840
11/32	150	220	290	370	440	550	660	730	920	1100	1280	1460	1830	2200	2930	3660
23/64	140	210	280	350	420	520	630	700	870	1050	1220	1400	1750	2100	2800	3500
3/8	130	200	270	340	400	500	600	670	840	1010	1170	1340	1680	2010	2680	3350
25/64	130	190	260	320	390	480	580	640	800	970	1130	1290	1610	1930	2570	3220
13/32	120	190	250	310	370	460	560	620	770	930	1080	1240	1550	1860	2470	3090
27/64	120	180	240	300	360	450	540	600	740	890	1040	1190	1490	1790	2380	2980
7/16	110	170	230	290	340	430	520	570	720	860	1000	1150	1430	1720	2300	2870
29/64	110	170	220	280	330	420	500	550	690	830	970	1110	1380	1660	2220	2770
15/32	110	160	210	270	320	400	480	540	670	800	940	1070	1340	1610	2140	2680
31/64	110	160	210	260	310	390	470	520	650	780	910	1040	1290	1550	2070	2590
1/2	110	150	200	250	300	380	450	500	630	750	880	1000	1250	1500	2010	2510

Material	Cutting speed Vc m/min	Coolant	Material	Cutting speed Vc m/min	Coolant
High carbon struc. steel < 700 N/mm ²	30 - 35	cutting spray	CuZn alloy tough	35 - 60	compressed air
High carbon struc. steel > 700 N/mm ²	20 - 25	cutting spray	Al alloy 11% Si	30 - 50	cutting spray
Alloyed steel < 1000 N/mm ²	20 - 25	cutting spray	Thermoplastics	20 - 40	water
Cast iron < 250 N/mm ²	15 - 25	compressed air	Duroplastics with inorganic filling	15 - 25	compressed air
Cast iron > 250 N/mm ²	10 - 20	compressed air	Duroplastics with organic filling	15 - 35	compressed air
CuZn alloy brittle	60 - 100	compressed air			

Application of drills and cutting conditions

Material	Recommended for use		Cooling	Cutting speed v [m/min]	Drill diameter d [mm]				
					2	4	6	9	12
	Main suggestion	Other suggestion			Feed rate f [mm/rotation]				
Free cutting steel 350-500 N/mm2	214 ...	258 ... / 202 ...	E	30-40	0,05	0,1	0,125	0,16	0,2
Free cutting steel 500-900 N/mm2	214 ...	228 ... / 202 ...	E	25-30	0,04	0,08	0,1	0,125	0,16
Structural steel up to 500 N/mm2	214 ...	258 ... / 202 ...	E	30-40	0,04	0,08	0,1	0,125	0,16
Structural steel 500-900 N/mm2	214 ...	228 ... / 202 ...	E	20-25	0,032	0,063	0,08	0,1	0,125
Plain carbon case hardening steel up to 600 N/mm2	214 ...	258 ... / 202 ...	E	25-35	0,05	0,1	0,125	0,16	0,2
Alloyed case hardening steel 500-900 N/mm2	214 ...	228 ... / 202 ...	E	20-25	0,4	0,08	0,1	0,125	0,16
Alloyed case hardening steel 900-1000 N/mm2	281 ... E	202 ... E	E, O	10-15	0,025	0,05	0,063	0,08	0,1
Nitriding steel 700-900 N/mm2	281 ... E	228 ... / 202 ... E	E	15-20	0,032	0,063	0,08	0,1	0,125
Heat treated nitriding steel 800-1250 N/mm2	281 ... E	228 ...	E, O	8-12	0,025	0,05	0,063	0,08	0,1
Mild steel for heat treatment 500-750 N/mm2	214 ...	228 ... / 202 ...	E	25-35	0,04	0,08	0,1	0,125	0,16
Plain carbon steel for heat treatment 700-1000 N/mm2	281 ... E	228 ...	E	15-20	0,04	0,08	0,1	0,125	0,16
Alloyed steel heat treatment 900-1250 N/mm2	281 ... E	228 ...	E, O	10-15	0,032	0,063	0,08	0,1	0,125
Maganese steel with content over 10 % Mn	281 ... E	202 ... E	E, O	3-6	0,2	0,04	0,063	0,08	0,1
Plain carbon tool steel 700-900 N/mm2	281 ... E	228 ... / 202 ... E	E	14-18	0,032	0,063	0,08	0,1	0,12
Alloyed tool steel 850-1250 N/mm2	281 ... E	228 ...	E, O	8-12	0,025	0,05	0,063	0,08	0,1
Heat resistant steel 450-600 N/mm2	281 ... E	281 ... EF	O	15-20	0,032	0,063	0,08	0,1	0,125
Stainless steel	215 ...	281 ... E	E, O	6-10	0,02	0,032	0,05	0,08	0,1
Alloys hastelloy, inconel, nimonic	281 ... E	281 ... EF	O	3-6	0,02	0,04	0,063	0,08	0,125
Grey cast iron HB 180-240	214 ...	228 ...	E, CA	30-40	0,05	0,1	0,125	0,16	0,2
Grey cast iron HB 240-300	214 ...	228 ...	E, CA	20-30	0,05	0,1	0,125	0,16	0,2
Malleable cast iron HB 180-240	214 ...	228 ...	CA	20-30	0,05	0,1	0,125	0,16	0,2
Aluminium	258 ... F	258 ...	E	50-80	0,05	0,1	0,125	0,16	0,2
Aluminium alloys with content up to 10 % Si and 180 N/mm2	258 ... F	258 ...	E	40-65	0,063	0,1255	0,16	0,2	0,25
Aluminium alloys with content up to 10 % Si and 150-250 N/mm2	214 ...	202 ...	E	30-50	0,063	0,1255	0,16	0,2	0,25
Copper 200-400 N/mm2	258 ... F	228 ...	E, O	30-40	0,05	0,1	0,125	0,16	0,2
Fragile brass with short chip 350-550 N/mm2	281 ... E	281 ... EF	E, O	60-80	0,063	0,1255	0,16	0,2	0,25
Tough brass with long chip 250-550 N/mm2	258 ... F	258 ... F	E, O	30-50	0,063	0,1	0,125	0,16	0,2
Bronze 200-500 N/mm2	258 ... F	258 ... F	E, O	20-40	0,05	0,08	0,125	0,16	0,2
Bronze 500-800 N/mm2	214 ...	258 ...	E, O	15-30	0,05	0,08	0,125	0,16	0,2
Magnesium alloys-electron	281 ... E	281 ... EF	-	60-100	0,08	0,125	0,016	0,02	0,25
Zinc, zinc alloys	214 ...	258 ...	E	35-45	0,05	0,1	0,125	0,16	0,2
Titanium alloys up to 700 N/mm2	281 ... E	281 ... EF	O	3-6	0,03	0,05	0,063	0,08	0,1
Titanium alloys 700-1000 N/mm2	281 ... E	281 ... EF	O	3-6	0,02	0,04	0,05	0,063	0,08
Silver	214 ...	258 ...	E	30-40	0,05	0,08	0,1	0,125	0,16
Duroplastics	281 ... E	281 ... EF	CA	10-20	0,04	0,08	0,1	0,125	0,16
Thermoplastics	258 ... F	258 ... F	W, CA	20-40	0,05	0,1	0,125	0,16	0,2
Laminated materials (paper, wood) across layer	258 ... F	258 ... F	CA	15-25	0,05	0,08	0,125	0,16	0,2

E = emulsion / O = cutting oil / CA = compressed air / W = water



SPECIAL DRILLS

FASCINATION FOR PRECISION®

Range and applications overview:













NEXT GENERATION



NEXT GENERATION



Material	Surface	DIN	Point cuts	Point angle	Helix angle	Shank	Ø mm	Article no.	Page
HSS							9,6	101 101 - 101 104 M	78
HSSE Co 5		DIN 1897					6,0 - 10,0	101 107 - 101 114	79
HSSE Co 5	TiCN	DIN 1897					6,0 - 10,0	101 107 TC - 101 114 TC	79
TC	AlTiN	DIN 1897					6,5 - 8,0	101 107 HM - 101 114 HM	79
HSSE Co 5							6,5 - 8,0	101 065 - 101 081	79
HSSE Co 5	TiCN						6,5 - 8,0	101 080 TC - 101 081 TC	79
HSS							6,5 - 8,0	101 201 - 101 202	80
HSS							6,5 - 8,0	101 201 T - 101 202 T	80

Steel (N/mm ²) < 900	Steel (N/mm ²) < 1100	Steel (N/mm ²) < 1300	Stainless steel	Aluminium	Brass	Bronze	Plastics	Cast iron	Titanium alloyed
									
■				■	■	□	■		
■	■		■	■	■	□	■	□	
■	■	□	■	■	■	■	■	□	
■	■	■	■	■	■	■	■	■	■
■	■		■	■	■	□	■	□	
■	■	□	■	■	■	■	■	□	
■				■	■	□	■	□	
■	□		□		■	□	■	□	

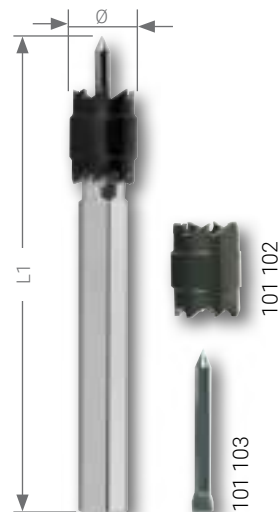


Spot weld miller HSS

For removing spot welds from sheet metal. Exchangeable and double-headed milling crown.
Adjustable milling depth with setting screw. No tearing of the sheet metal.
No deformation of the sheet metal. Efficient and rapid working.

Packing unit: in plastic boxes

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Stainless steel		Cast iron	
Aluminium	■	Titanium alloyed	



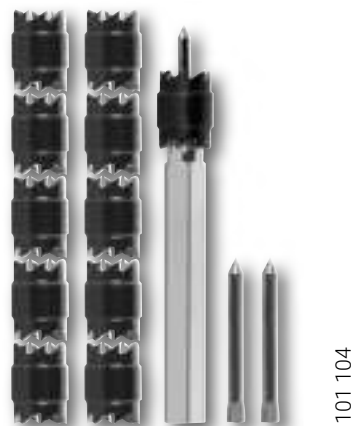
	L1 mm	Ø mm		
Spot weld miller, complete	72,0	-	101 101	1
Milling crown	-	9,6	101 102	5
Centering pin	-	2,5	101 103	1



Spot weld miller set

Packing unit: in plastic boxes

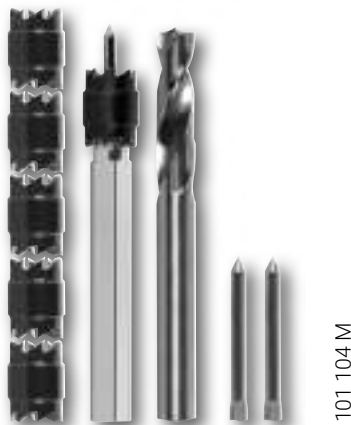
13-piece set of spot weld miller 1 spot weld miller, complete + 10 milling crowns + 2 centering pins	101 104



Spot weld miller special set

Packing unit: in plastic boxes

9-piece set of spot weld miller-special set 1 spot weld miller, complete + 5 milling + 2 centering pins + 1 fast cut HSSE-Co 5 Ø 8,0 mm	101 104 M	





Spot weld miller HSSE-Co 5 and tungsten carbide long series

Extra stable special drill for hard materials for use in hand drills. Well suited to achieve clean and burr-free milling of spot welds and thin walled work pieces without need to centre mark. Very high precision. Applications include: sheet steel, sheet brass, sheet aluminium, sheet zinc, sheet copper, plastic sheet.

Packing unit: in plastic boxes

Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100	■	■	■
Steel (N/mm2) < 1300		□	■
Stainless steel	■	■	■
Aluminium	■	■	■

Brass	■	■	■
Bronze	□	■	■
Plastics	■	■	■
Cast iron	□	■	■
Titanium alloyed			■

**NEXT
GENERATION**

Upgraded and Improved Product.
Improved specification replaces previous version.

Ø mm	L1 mm								
6,0	66,0	101 107		101 107 TC			101 107 HM		1
7,0	74,0	101 111		—			—		1
8,0	80,0	101 108		101 108 TC			101 108 HM		1
10,0	88,0	101 114		101 114 TC			—		1



Spot weld miller HSSE-Co 5 short series

Special shank for the application in pneumatic machines.
For clean and burr-free milling of welding spots and thin-walled work pieces without centering.
Extreme high precision. (v = vario)

Packing unit: in plastic boxes

Steel (N/mm2) < 900	■	■
Steel (N/mm2) < 1100	■	■
Steel (N/mm2) < 1300	□	□
Stainless steel	■	■
Aluminium	■	■

Brass	■	■
Bronze	□	□
Plastics	■	■
Cast iron	□	■
Titanium alloyed		□

Ø mm	L1 mm				
6,5	40,0	101 065		—	1
8,0	40,0	101 080		101 080 TC	1
8,0 (v)	44,0	101 081		101 081 TC	1



Milling drill HSS

For drilling and milling contours in wood, sheet metal, plastics and other thin-walled materials.
Twist drill at tip with milling cutter design and chip breaker.

Packing unit: in plastic boxes

Steel (N/mm2) < 900	■	■
Steel (N/mm2) < 1100		□
Steel (N/mm2) < 1300		
Stainless steel		□
Aluminium	■	

Brass	■	■
Bronze	□	□
Plastics	■	■
Cast iron	□	□
Titanium alloyed		

Ø mm	L1 mm			
6,0	90,0	101 201	101 201 T	1
8,0	90,0	101 202	101 202 T	1

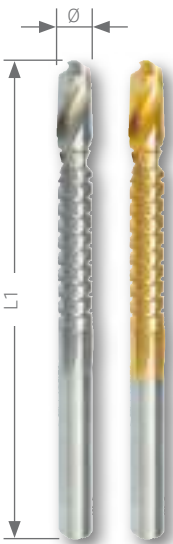
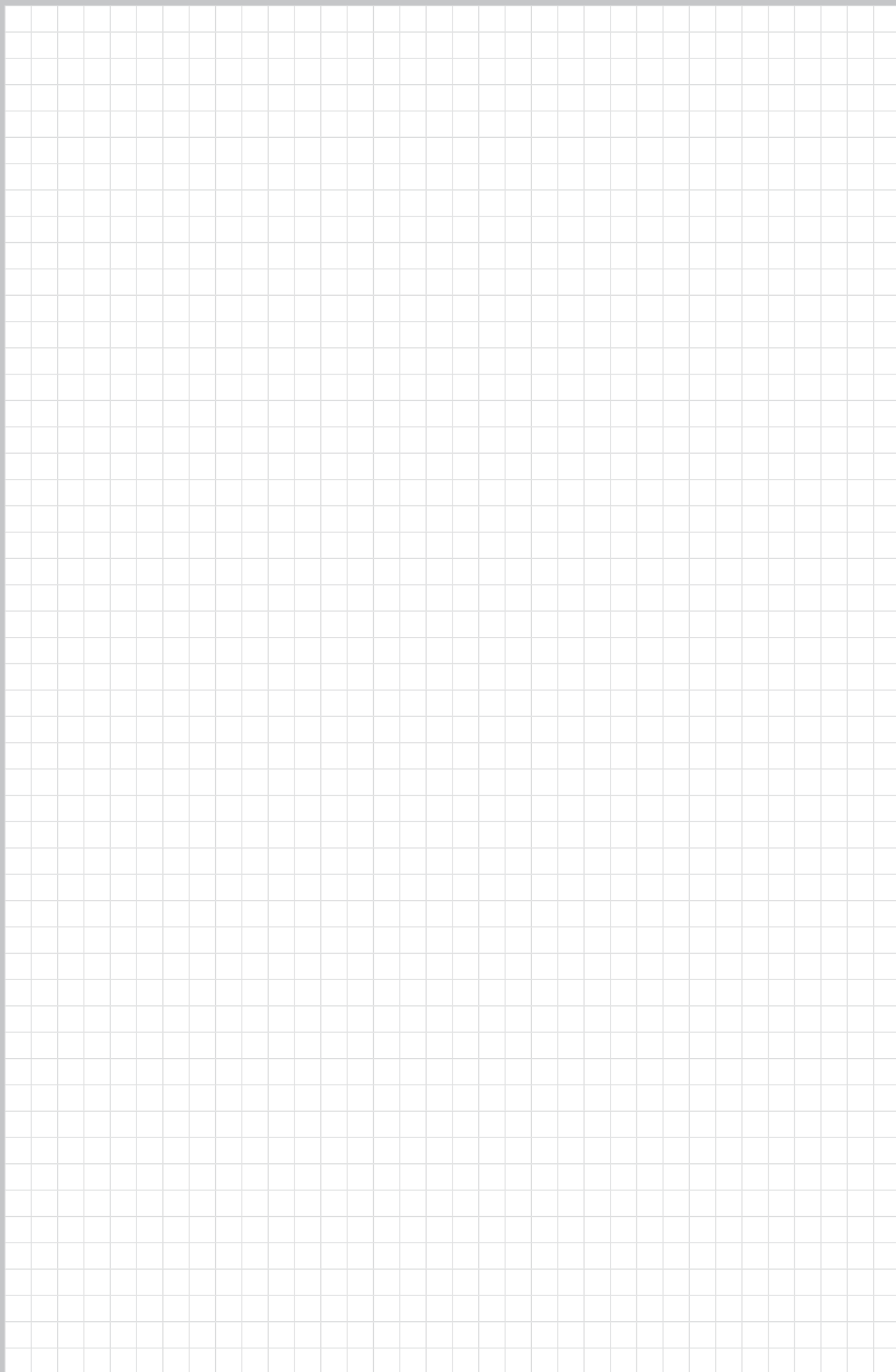


Table of cutting speeds for special drills

Vc = m/min	4	6	8	10	12	15	18	20	25	30	35	40	50	60	80	100
Ø mm	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.
1,0	1274	1911	2548	3185	3822	4777	5732	6369	7962	9554	11146	12739	15924	19108	25478	31847
1,5	849	1274	1699	2123	2548	3185	3822	4246	5308	6369	7431	8493	10616	12739	16985	21231
2,0	637	955	1274	1592	1911	2389	2866	3185	3981	4777	5573	6369	7962	9554	12739	15924
2,5	510	764	1019	1274	1529	1911	2293	2548	3185	3822	4459	5096	6369	7643	10191	12739
3,0	425	637	849	1062	1274	1592	1911	2123	2654	3185	3715	4246	5308	6369	8493	10616
3,5	364	546	728	910	1092	1365	1638	1820	2275	2730	3185	3640	4550	5460	7279	9099
4,0	318	478	637	796	955	1194	1433	1592	1990	2389	2787	3185	3981	4777	6369	7962
4,5	283	425	566	708	849	1062	1274	1415	1769	2123	2477	2831	3539	4246	5662	7077
5,0	255	382	510	637	764	955	1146	1274	1592	1911	2229	2548	3185	3822	5096	6369
5,5	232	347	463	579	695	869	1042	1158	1448	1737	2027	2316	2895	3474	4632	5790
6,0	212	318	425	531	637	796	955	1062	1327	1592	1858	2123	2654	3185	4246	5308
6,5	196	294	392	490	588	735	882	980	1225	1470	1715	1960	2450	2940	3920	4900
7,0	182	273	364	455	546	682	819	910	1137	1365	1592	1820	2275	2730	3640	4550
7,5	170	255	340	425	510	637	764	849	1062	1274	1486	1699	2123	2548	3397	4246
8,0	159	239	318	398	478	597	717	796	995	1194	1393	1592	1990	2389	3185	3981
8,5	150	225	300	375	450	562	674	749	937	1124	1311	1499	1873	2248	2997	3747
9,0	142	212	283	354	425	531	637	708	885	1062	1238	1415	1769	2123	2831	3539
9,5	134	201	268	335	402	503	603	670	838	1006	1173	1341	1676	2011	2682	3352
10,0	127	191	255	318	382	478	573	637	796	955	1115	1274	1592	1911	2548	3185
11,0	116	174	232	290	347	434	521	579	724	869	1013	1158	1448	1737	2316	2895
12,0	106	159	212	265	318	398	478	531	663	796	929	1062	1327	1592	2123	2654
13,0	98	147	196	245	294	367	441	490	612	735	857	980	1225	1470	1960	2450
14,0	91	136	182	227	273	341	409	455	569	682	796	910	1137	1365	1820	2275
15,0	85	127	170	212	255	318	382	425	531	637	743	849	1062	1274	1699	2123
16,0	80	119	159	199	239	299	358	398	498	597	697	796	995	1194	1592	1990
17,0	75	112	150	187	225	281	337	375	468	562	656	749	937	1124	1499	1873
18,0	71	106	142	177	212	265	318	354	442	531	619	708	885	1062	1415	1769
19,0	67	101	134	168	201	251	302	335	419	503	587	670	838	1006	1341	1676
20,0	64	96	127	159	191	239	287	318	398	478	557	637	796	955	1274	1592
21,0	61	91	121	152	182	227	273	303	379	455	531	607	758	910	1213	1517
22,0	58	87	116	145	174	217	261	290	362	434	507	579	724	869	1158	1448
23,0	55	83	111	138	166	208	249	277	346	415	485	554	692	831	1108	1385
24,0	53	80	106	133	159	199	239	265	332	398	464	531	663	796	1062	1327
25,0	51	76	102	127	153	191	229	255	318	382	446	510	637	764	1019	1274
26,0	49	73	98	122	147	184	220	245	306	367	429	490	612	735	980	1225
27,0	47	71	94	118	142	177	212	236	295	354	413	472	590	708	944	1180
28,0	45	68	91	114	136	171	205	227	284	341	398	455	569	682	910	1137
29,0	44	66	88	110	132	165	198	220	275	329	384	439	549	659	879	1098
30,0	42	64	85	106	127	159	191	212	265	318	372	425	531	637	849	1062
31,0	41	62	82	103	123	154	185	205	257	308	360	411	514	616	822	1027
32,0	40	60	80	100	119	149	179	199	249	299	348	398	498	597	796	995
33,0	39	58	77	97	116	145	174	193	241	290	338	386	483	579	772	965
34,0	37	56	75	94	112	141	169	187	234	281	328	375	468	562	749	937
35,0	36	55	73	91	109	136	164	182	227	273	318	364	455	546	728	910
36,0	35	53	71	88	106	133	159	177	221	265	310	354	442	531	708	885
37,0	34	52	69	86	103	129	155	172	215	258	301	344	430	516	689	861
38,0	34	50	67	84	101	126	151	168	210	251	293	335	419	503	670	838
39,0	33	49	65	82	98	122	147	163	204	245	286	327	408	490	653	817
40,0	32	48	64	80	96	119	143	159	199	239	279	318	398	478	637	796
41,0	31	47	62	78	93	117	140	155	194	233	272	311	388	466	621	777
42,0	30	45	61	76	91	114	136	152	190	227	265	303	379	455	607	758
43,0	30	44	59	74	89	111	133	148	185	222	259	296	370	444	593	741
44,0	29	43	58	72	87	109	130	145	181	217	253	290	362	434	579	724
45,0	28	42	57	71	85	106	127	142	177	212	248	283	354	425	566	708
46,0	28	42	55	69	83	104	125	138	173	208	242	277	346	415	554	692
47,0	27	41	54	68	81	102	122	136	169	203	237	271	339	407	542	678
48,0	27	40	53	66	80	100	119	133	166	199	232	265	332	398	531	663
49,0	26	39	52	65	78	97	117	130	162	195	227	260	325	390	520	650
50,0	25	38	51	64	76	96	115	127	159	191	223	255	318	382	510	637

Material	Cutting speed Vc m/min	Coolant	Material	Cutting speed Vc m/min	Coolant
High carbon struc. steel < 700 N/mm ²	30 - 35	cutting spray	CuZn alloy tough	35 - 60	compressed air
High carbon struc. steel > 700 N/mm ²	20 - 25	cutting spray	Al alloy 11% Si	30 - 50	cutting spray
Alloyed steel < 1000 N/mm ²	20 - 25	cutting spray	Thermoplastics	20 - 40	water
Cast iron < 250 N/mm ²	15 - 25	compressed air	Duroplastics with inorganic filling	15 - 25	compressed air
Cast iron > 250 N/mm ²	10 - 20	compressed air	Duroplastics with organic filling	15 - 35	compressed air
CuZn alloy brittle	60 - 100	compressed air			





TUBE AND SHEET DRILLS

FASCINATION FOR PRECISION®

Range and applications overview:



Material	Surface	Shape	Point angle	Cone angle	Shank	Ø mm	Article no.	Page
HSS						3,0 - 61,0	101 001 - 101 022	85 - 86
HSSE Co 5						3,0 - 31,0	101 001 E - 101 008 E	85 - 86
HSS						3,0 - 40,0	101 001 T - 101 008 T	85 - 86
HSS						5,0 - 20,0	101 049 H	85
HSS						2,0 - 11,8	101 041 - 101 045-1	87



Steel (N/mm ²) < 900	Steel (N/mm ²) < 1100	Steel (N/mm ²) < 1300	Stainless steel	Aluminium	Brass	Bronze	Plastics	Cast iron	Titanium alloyed



Tube and sheet drills HSS and HSSE-Co 5 with split point

The CBN ground flutes guarantee quiet running and high cutting performance.
The relief angle on the underside of the tool enables easier removal from the material.

Packing unit: in plastic boxes

Steel (N/mm ²) < 900	■	■	■
Steel (N/mm ²) < 1100		■	□
Steel (N/mm ²) < 1300			
Stainless steel		■	□
Aluminium	■	■	

Brass	■	■	■
Bronze	□	□	□
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			



Size no.	Ø1 - Ø2 mm	L1 mm	Ø3 mm	HSS	HSSE Co 5	HSS TIN	
1	3,0 - 14,0	58,0	6,0	101 001	101 001 E	101 001 T	1
2	4,0 - 20,0	71,0	8,0	101 002	101 002 E	101 002 T	1
3	16,0 - 30,5	76,0	9,0	101 003	101 003 E	101 003 T	1
4	24,0 - 40,0	89,0	10,0	101 004	—	101 004 T	1
5	36,0 - 50,0	97,0	12,0	101 005	—	—	1
6	40,0 - 61,0	103,0	13,0	101 006	—	—	1
7	5,0 - 25,4	87,0	10,0	101 007	—	—	1
8	5,0 - 31,0	103,0	9,0	101 008	101 008 E	101 008 T	1
9	5,0 - 22,5	79,0	8,0	101 022	—	—	1



Tube and sheet drill bits HSS, 1/4" with split point

The CBN ground flutes guarantee quiet running and high cutting performance.
The relief angle on the underside of the tool enables easier removal from the material.

Packing unit: in plastic boxes

Steel (N/mm ²) < 900	■
Steel (N/mm ²) < 1100	
Steel (N/mm ²) < 1300	
Stainless steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	



Size no.	Ø1 - Ø2 mm	L1 mm	Ø3 mm	Ø3 inch	HSS	
2	5,0 - 20,0	78,0	6,35 x 27,0	1/4"	101 049 H	1

Tube and sheet drill sets HSS and HSSE-Co 5 in steel case

	<div>HSS</div> <div></div>	<div>HSSE Co 5</div> <div></div>	<div>HSS</div> <div>TiN</div>
4-piece set of tube and sheet drills sizes 1, 2, 3 and 1 cutting paste 50 g in polystyrene case	101 009	—	—
4-piece set of tube and sheet drills sizes 1, 2, 3 and 1 cutting paste 30 g in steel case	101 020	101 020 E	101 020 T



Tube and sheet drill sets HSS and HSSE-Co 5 in plastic case

	<div>HSS</div> <div></div>	<div>HSSE Co 5</div> <div></div>	<div>HSS</div> <div>TiN</div>
4-piece set of tube and sheet drills sizes 1, 2, 3 and 1 cutting paste 30 g	101 020 RO	101 020 ERO	101 020 TRO





Tube and sheet drills HSS with stopper and spot facer for cavity sealing, with split point

The CBN ground flutes guarantee quiet running and high cutting performance.

Packing unit: in plastic boxes

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Stainless steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Size no.	Ø1 - Ø2 mm	L1 mm	Ø3 mm	HSS		
1	3,0 - 7,8	48,0	6,0	101 041	1	
2	3,0 - 10,2	52,0	6,0	101 042	1	
3	3,0 - 11,8	56,0	6,0	101 043	1	
5	2,0 - 7,8	48,0	6,0	101 045-1	1	



Magnetic bit holder for 1/4" hexagonal shank tools

Packing unit: in plastic boxes

	Article no.	
Magnetic bit holder	270 013	1



Coolants and lubricants

RUKO high performance coolants and lubricants with outstanding cooling and anti-separation qualities. Increases tool life even with hard and brittle materials. High heat resistance ensures good lubrication and cooling, even at high temperatures. Good adhesion quality improves lubrication.

For all standard metal working processes, such as drilling, thread cutting, countersinking, deburring, sawing, turning, milling, grinding.

Perfectly matched for use with RUKO metal working tools.
Section 14 – Page 289



Table of cutting speeds for tube and sheet drills

Material:		High carbon struc. steel up to 700 N/mm ²	High carbon struc. steel over 700 N/mm ²	Alloyed steel over 1000 N/mm ²	Cast iron up to 250 N/mm ²	Cast iron over 250 N/mm ²	CuZn-alloy brittle	CuZn-alloy tough	Al-alloy up to 11% Si	Thermo-plastics	Duro-plastics
Sheet thickness:		up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0
Vc = m/min		30	20	20	15	10	60	35	30	20	15
Cooling lubricant:		Cutting spray	Cutting spray	Cutting spray	Cutting spray	Air	Air	Air	Cutting spray	Water	Air
Size	Ø mm	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.
No. 1	3,0-14,0	3185-682	2123-455	2123-455	1592-341	1062-227	6369-1365	3715-796	3185-682	2123-455	1592-341
No. 2	4,0-20,0	1911-478	1274-318	1274-318	955-239	637-159	3822- 955	2229-557	1911-478	1274-318	955-239
No. 3	16,0-30,5	597-313	398-209	398-209	299-157	199-104	1194- 627	697-365	597-313	398-209	299-157
No. 4	24,0-40,0	398-239	265-159	265-159	199-119	133- 80	796- 478	464-279	398-239	265-159	199-119
No. 5	36,0-50,0	265-191	177-127	177-127	133- 96	88- 64	531- 382	310-223	265-191	177-127	133- 96
No. 6	40,0-61,0	239-157	159-104	159-104	119- 78	80- 52	478- 313	279-183	239-157	159-104	119- 78
No. 7	5,0-25,4	1911-376	1274-251	1274-251	955-188	637-125	3822- 752	2229-439	1911-376	1274-251	955-188
No. 8	5,0-31,0	1911-308	1274-205	1274-205	955-154	637-103	3822- 616	2229-360	1911-308	1274-205	955-154
No. 9	5,0-22,5	1911-425	1274-283	1274-283	955-212	637-142	3822- 849	2229-495	1911-425	1274-283	955-212





STEP DRILLS

FASCINATION FOR PRECISION®

Range and applications overview:

ULTIMATECUT®



NEXT GENERATION



NEXT GENERATION



NEXT GENERATION



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NEXT GENERATION













NEXT GENERATION



NEXT GENERATION



	Material	Surface	Cutting edges	Material thickness	Point angle	Point cut	Shank	Ø mm	Article no.	Page
	HSS	RUNa TEC	4	↓ max 10,0 mm ↑	130°			6,0 - 12,0 - 6,0 - 27,0	101 082 P - 101 084 P	92 - 95
	HSS		2	↓ max 4,0 mm ↑	118°			4,0 - 12,0 - 6,0 - 40,0	101 050-5 - 101 097	96 - 99
	HSSE Co 5		2	↓ max 4,0 mm ↑	118°			4,0 - 12,0 - 6,5 - 32,5	101 050-9 E - 101 534 E	96 - 99
	HSS	TiN	2	↓ max 4,0 mm ↑	118°			4,0 - 12,0 - 6,0 - 40,0	101 050-5 T - 101 097 T	96 - 99
	HSS	TiAlN	2	↓ max 4,0 mm ↑	118°			4,0 - 12,0 - 6,0 - 40,0	101 050-5 F - 101 097 F	96 - 99
	HSS	TiAlN	2	↓ max 3,5 mm ↑	118°			6,0 - 18,0	101 068 F-1	100
	HSS		2	↓ max 4,0 mm ↑	118°			4,0 - 12,0 - 4,0 - 30,0	101 050-9 H - 101 052 H	101
	HSS	TiN	2	↓ max 4,0 mm ↑	118°			4,0 - 12,0 - 4,0 - 30,0	101 050-9 TH - 101 052 TH	101
	HSS		2	↓ max 2,0 mm ↑	118°			4,0 - 12,0 - 4,0 - 30,0	101 061 - 101 063	101
	HSS		2	↓ max 4,0 mm ↑	118°			3/16 - 1/2 - 7/8 - 1 1/8	101 701 - 101 709	102
	HSSE Co 5		2	↓ max 4,0 mm ↑	118°			3/16 - 1/2 - 7/8 - 1 1/8	101 701 E - 101 709 E	102
	HSS	TiN	2	↓ max 4,0 mm ↑	118°			3/16 - 1/2 - 7/8 - 1 1/8	101 701 T - 101 709 T	102
	HSS	TiAlN	2	↓ max 4,0 mm ↑	118°			3/16 - 1/2 - 7/8 - 1 1/8	101 701 F - 101 709 F	102
	HSS		3	↓ max 4,0 mm ↑	118°			4,0 - 12,0 - 4,0 - 30,0	101 350-9 - 101 352	103
	HSS		2	↓ max 4,0 mm ↑	118°			5,3 - 30,5 - 6,5 - 32,5	101 090 - 101 093	104
	HSS	TiN	2	↓ max 4,0 mm ↑	118°			5,3 - 30,5 - 6,5 - 32,5	101 090 T - 101 093 T	104
	HSS	TiAlN	2	↓ max 4,0 mm ↑	118°			5,3 - 30,5 - 6,5 - 32,5	101 090 F - 101 093 F	104
	HSS		2	↓ max 4,0 mm ↑				12,0 - 20,0 - 30,0 - 40,0	101 361 - 101 363	104

Steel (N/mm ²) < 900 	Steel (N/mm ²) < 1100 	Steel (N/mm ²) < 1300 	Stainless steel 	Aluminium 	Brass 	Bronze 	Plastics 	Cast iron 	Titanium alloyed 
■	■	□	□	■	■	□	■	□	
■				■	■	□	■	□	
■	■		■	■	■	□	■	□	
■	□		□		■	□	■	□	
■	■	□	□	■	■	□	■	□	
■	■	□	□	■	■	□	■	□	
■				■	■	□	■	□	
■	□		□		■	□	■	□	
■				■	■	□	■	□	
■				■	■	□	■	□	
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■				■	■	□	■	□	
■				■	■	□	■	□	
■			□		■	□	■	□	
■	■		■	■	■	■	■	□	
■				■	■	□	■	□	

Welcome to the world's first.

The new RUKO
ULTIMATECUT[®]
step drill

- 5 in 1 tool
- Up to 75% time savings
- Ultimate flexibility



OUT NOW

Information
and videos



**RUna
TEC**



10
mm

Unique in every step.

- No **center punching** thanks to specially developed turbo tip.
- No **tool changes** due to pre-drilling and different drill hole diameters, which would occur with for e.g. **twist drills**.
- No problems in **hard-to-reach places**, for e.g. T-beams, where the use of big machines with **core drills** is problematic.
- No problems with **low holding forces** of magnetic stand drilling machines for materials < 10 mm, since it can be drilled with a manual drilling machine.
- No extra **deburring** necessary, the next step takes over this function.



ULTIMATECUT Step drills HSS RUNaTEC, spiral fluted with turbo tip

The **ULTIMATECUT** step drill revolutionizes the work process and sets new standards in machining time with time savings of up to 75%. The step drill from RUKO achieves this through its revolutionary cutting edge geometry by combining the most diverse applications and tools. This means less tools needed, no tool changes and ultimate flexibility.

Packing unit: in plastic tubes of 1

- Cooling
- Adjust speed
- Low speeds for hand drills
- Follow table of application for **ULTIMATECUT** step drills
- Pay attention to total length while drilling

Steel (N/mm2) < 900		Brass	
Steel (N/mm2) < 1100		Bronze	
Steel (N/mm2) < 1300		Plastics	
Rust-resistant steel		Cast iron	
Aluminium		Titanium alloyed	



Size no.	Ø1 - Ø2 mm	Drilling range Ø mm	L1 mm	Steps	Ø3 mm	HSS	RUNa TEC	
S1	6,0 - 12,00	6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0	105,0	7	8,0	101 082 P	1	
M2	6,0 - 20,00	6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0	120,0	8	10,0	101 083 P	1	
L3	6,0 - 27,00	6,0 / 9,0 / 12,0 / 15,0 / 18,0 / 21,0 / 24,0 / 27,0	125,0	8	12,0	101 084 P	1	

ULTIMATECUT Step drill set HSS RUNaTEC, in plastic case

3-piece set of ULTIMATECUT step drills spiral fluted, sizes S1, M2, L3	101 087 PRO





Table of cutting speeds for ULTIMATECUT step drills

Material	Application	Working step	Hand drill	Pillar drill manual feed	Pillar drill / CNC machine automatic feed
Structural steel (e.g. S235JR) Non-ferrous metals / Plexiglas / Plastics / Wood		tapping (drilling through 1st step)	up to 1000 rpm cooling recommended	up to 1000 rpm cooling recommended	approx. 750 rpm f = 0,1mm/rev cooling necessary
		reaming (from 2nd step)	100 - 250 rpm cooling recommended	250- 350 rpm cooling recommended	
Stainless steel up to V2A		tapping (drilling through 1st step)	up to 600 rpm cooling necessary	up to 600 rpm cooling necessary	approx. 600 rpm f = 0,05mm/rev cooling necessary
		reaming (from 2nd step)	100 - 200 rpm cooling necessary	200 - 300 rpm cooling necessary	

Effective without compromises.

The new RUKO
step drill generation

- **Up to 4 times more holes**
- **Smooth and quiet drilling**
- **Significantly improved drilling result**

**NEXT
GENERATION**

Upgraded and Improved Product.
Improved specification replaces previous version.



NEXT GENERATION

OUT NOW

FlowStep Technology

Improved control on more difficult to cut materials, such as thin sheet and Plexiglas, whilst still providing outstanding performance on tougher materials such as stainless steel.

Unique new cutting geometry design provides an easy, low force, seamless transition between the increasing hole diameters.

Information
and videos





NEXT GENERATION Step drills HSS and HSSE-Co 5, spiral fluted with split point

The CBN ground and spiral flutes guarantee quiet running and high cutting performance. Especially the chip flow is optimized, so even long, non-breaking chips will be removed easily. The optimized chip flow protects the cutting edges and reduces built-up edges and cold weld marks. The chamfer on the base of the cone makes withdrawal of the tool from the material simple when through hole drilling.



Packing unit: in plastic tubes of 1



- Cooling
- Adjust speed
- Do not press
- Step drill is pulled automatically into the plate

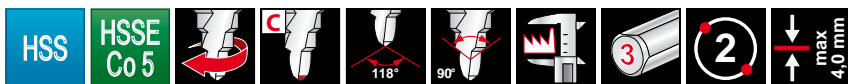
Steel (N/mm ²) < 900	■	■	■	■
Steel (N/mm ²) < 1100		■	□	■
Steel (N/mm ²) < 1300				□
Rust-resistant steel		■	□	□
Aluminium	■	■		■

Brass	■	■	■	■
Bronze	□	□	□	□
Plastics	■	■	■	■
Cast iron	□	□	□	□
Titanium alloyed				

Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	HSSE Co 5	HSS TiN	HSS TiAlN	
0/5	4,0 - 12,00	65,0	5	6,0	101 050-5	—	101 050-5 T	101 050-5 F	1
0/9	4,0 - 12,00	65,0	9	6,0	101 050-9	101 050-9 E	101 050-9 T	101 050-9 F	1
1	4,0 - 20,00	75,0	9	8,0	101 051	101 051 E	101 051 T	101 051 F	1
2	4,0 - 30,00	100,0	14	10,0	101 052	101 052 E	101 052 T	101 052 F	1
3	6,0 - 38,00	100,0	12	10,0	101 053	—	101 053 T	101 053 F	1
4	6,0 - 26,75	75,0	8	10,0	101 055	—	101 055 T	101 055 F	1
5	4,0 - 39,00	107,0	13	10,0	101 056	101 056 E	101 056 T	101 056 F	1
6	6,0 - 32,00	75,0	8	10,0	101 057	—	101 057 T	101 057 F	1
7	5,0 - 28,00	69,0	7	10,0	101 058	—	101 058 T	101 058 F	1
8	6,0 - 30,50	80,0	9	10,0	101 098	—	101 098 T	101 098 F	1
9	6,0 - 37,00	100,0	12	10,0	101 060	101 060 E	101 060 T	101 060 F	1
12	6,0 - 32,00	76,0	9	10,0	101 096	—	101 096 T	101 096 F	1
13	6,0 - 40,00	105,0	16	13,0	101 097*	—	101 097 T*	101 097 F*	1
18	6,5 - 32,50	91,0	12	10,0	—	101 534 E	—	—	1

* straight flute

Size no.	Drilling range Ø mm
0/5	4,0 / 6,0 / 8,0 / 10,0 / 12,0
0/9	4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0
1	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0
2	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 22,0 / 24,0 / 26,0 / 28,0 / 30,0
3	6,0 / 9,0 / 13,0 / 16,0 / 19,0 / 21,0 / 23,0 / 26,0 / 29,0 / 32,0 / 35,0 / 38,0
4	6,0 / 9,0 / 11,4 (PG7) / 14,0 (PG9) / 17,25 (PG11) / 19,0 (PG13,5) / 21,25 (PG16) / 26,75 (PG21)
5	4,0 / 6,0 / 12,0 / 15,0 / 18,0 / 21,0 / 24,0 / 27,0 / 30,0 / 33,0 / 36,0 / 39,0
6	6,0 / 9,0 / 11,2 (R1/8) / 14,5 (R1/4) / 18,2 (R3/8) / 22,3 (R1/2) / 27,9 (R3/4) / 32,0
7	5,0 / 8,8 (G1/8) / 11,8 (G1/4) / 15,3 (G3/8) / 19,0 (G1/2) / 24,5 (G3/4) / 28,0
8	6,0 / 9,0 / 12,5 (PG7) / 15,2 (PG9) / 18,6 (PG11) / 20,4 (PG13,5) / 22,5 (PG16) / 28,3 (PG21) / 30,5
9	6,0 / 9,0 / 12,5 (PG7) / 15,2 (PG9) / 18,6 (PG11) / 20,4 (PG13,5) / 22,5 (PG16) / 26,0 / 28,3 (PG21) / 30,5 / 34,0 / 37,0 (PG29)
12	6,0 / 9,0 / 12,0 / 16,0 / 20,0 / 22,5 / 25,0 / 28,5 / 32,0
13	6,0 / 11,0 / 17,0 / 23,0 / 29,0 / 30,0 / 31,0 / 32,0 / 33,0 / 34,0 / 35,0 / 36,0 / 37,0 / 38,0 / 39,0 / 40,0
18	6,5 / 8,5 / 10,5 / 12,7 / 15,2 (PG9) / 16,2 / 18,6 (PG11) / 20,4 (PG13,5) / 22,5 (PG16) / 25,5 / 28,3 (PG21) / 32,5



NEXT GENERATION Step drill sets HSS and HSSE-Co 5 in steel case

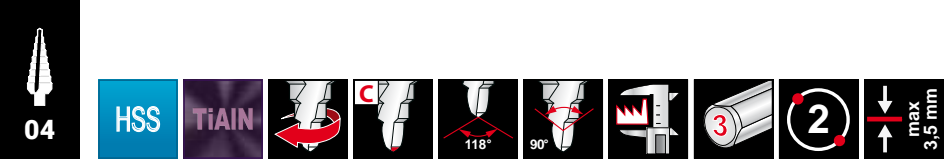
	HSS	HSSE Co 5	HSS TIN	HSS TiAIN
3-piece set of step drills spiral fluted, sizes 0/9, 1, 2	101 026	101 026 E	101 026 T	101 026 F



NEXT GENERATION Step drill sets HSS and HSSE-Co 5 in plastic case

	HSS	HSSE Co 5	HSS TIN	HSS TiAIN
3-piece set of step drills spiral fluted, sizes 0/9, 1, 2	101 026 RO	101 026 ERO	101 026 TRO	101 026 FRO






NEXT GENERATION Crash barrier step drill HSS-TiAlN spiral fluted with split point

Specially designed for drilling crash barriers.
 For use on material strengths of up to 3,5 mm.
 Cooling recommended but not required (increased service life)
 Steps Ø: 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 mm

Packing unit: in plastic tubes of 1

			
Steel (N/mm2) < 900		Brass	
Steel (N/mm2) < 1100		Bronze	
Steel (N/mm2) < 1300		Plastics	
Rust-resistant steel		Cast iron	
Aluminium		Titanium alloyed	

Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	 	
6,0 - 18,00	68,0	7	10,0	101 068 F-1	1





NEXT GENERATION Step drills bit HSS, spiral fluted with split point

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900		
Steel (N/mm2) < 1100		
Steel (N/mm2) < 1300		
Rust-resistant steel		
Aluminium		

Brass		
Bronze		
Plastics		
Cast iron		
Titanium alloyed		



Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	Ø3 inch	HSS	HSS TIN	
0/9	4,0 - 12,00	72,0	9	6,35 x 27,0	1/4"	101 050-9 H	101 050-9 TH	1
1	4,0 - 20,00	81,0	9	6,35 x 27,0	1/4"	101 051 H	101 051 TH	1
2	4,0 - 30,00	105,0	14	6,35 x 27,0	1/4"	101 052 H	101 052 TH	1

0/9	4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0							
1	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0							
2	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 22,0 / 24,0 / 26,0 / 28,0 / 30,0							



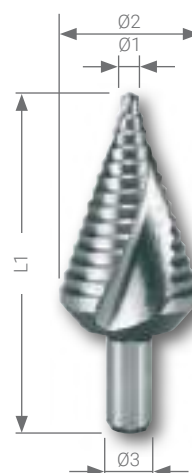
Step drills HSS, spiral fluted with split point, short design

Step height 2,0 mm ideal to produce switchboards.

Packing unit: in plastic tubes of 1

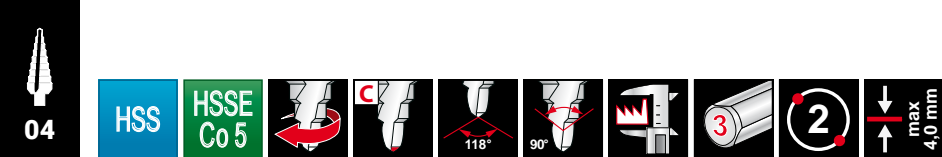
Steel (N/mm2) < 900	
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Rust-resistant steel	
Aluminium	

Brass	
Bronze	
Plastics	
Cast iron	
Titanium alloyed	



Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	
0/9k	4,0 - 12,00	48,0	9	6,0	101 061	1
1k	4,0 - 20,00	58,0	9	8,0	101 062	1
2k	4,0 - 30,00	72,0	14	10,0	101 063	1

0/9k	4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0					
1k	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0					
2k	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 22,0 / 24,0 / 26,0 / 28,0 / 30,0					



NEXT GENERATION Step drills HSS and HSSE-Co 5, fractional sizes, spiral fluted with split point

The CBN ground and spiral flutes guarantee quiet running and high cutting performance. Especially the chip flow is optimized, so even long, non-breaking chips will be removed easily. The optimized chip flow protects the cutting edges and reduces built-up edges and cold weld marks. The chamfer on the base of the cone makes withdrawal of the tool from the material simple when through hole drilling.

Packing unit: in plastic tubes of 1



Steel (N/mm2) < 900	■	■	■	■
Steel (N/mm2) < 1100		■	□	■
Steel (N/mm2) < 1300				
Rust-resistant steel		■	□	■
Aluminium	■	■		■

Brass	■	■	■	■
Bronze	□	□	□	■
Plastics	■	■	■	■
Cast iron	□	□	□	□
Titanium alloyed				

Size no.	Ø1 - Ø2 inch	L1 inch	Steps	Ø3 inch	HSS	HSSE Co 5	HSS TiN	HSS TiAlN	
1	3/16 - 1/2	3 1/8	6	1/4	101 701	101 701 E	101 701 T	101 701 F	1
2	1/8 - 1/2	3 1/8	13	1/4	101 702	101 702 E	101 702 T	101 702 F	1
3	1/4 - 3/4	2 3/4	9	3/8	101 703	101 703 E	101 703 T	101 703 F	1
4	3/16 - 7/8	3 1/4	12	3/8	101 704	101 704 E	101 704 T	101 704 F	1
5	5/16 - 1	3 1/4	9	3/8	101 705	101 705 E	101 705 T	101 705 F	1
6	7/8 - 1 3/8	3 1/4	5	3/8	101 706	101 706 E	101 706 T	101 706 F	1
7	3/8 - 1/2	1 7/8	2	1/4	101 707	101 707 E	101 707 T	101 707 F	1
8	7/8	2 19/32	1	3/8	101 708	101 708 E	101 708 T	101 708 F	1
9	7/8 - 1 1/8	3 7/64	2	3/8	101 709	101 709 E	101 709 T	101 709 F	1

Size no.	Drilling range Ø mm
1	3/16 - 1/4 - 5/16 - 3/8 - 7/16 - 1/2
2	1/8 - 5/32 - 3/16 - 7/32 - 1/4 - 9/32 - 5/16 - 11/32 - 3/8 - 19/32 - 3/16 - 15/32 - 1/2
3	1/4 - 5/16 - 3/8 - 7/16 - 1/2 - 9/16 - 5/8 - 11/16 - 3/4
4	3/16 - 1/4 - 5/16 - 3/8 - 7/16 - 1/2 - 9/16 - 5/8 - 11/16 - 3/4 - 13/16 - 7/8
5	5/16 - 1/2 - 9/16 - 5/8 - 11/16 - 3/4 - 13/16 - 7/8 - 15/16 - 1"
6	7/8 - 1 1/8 - 1 7/32 - 1 1/4 - 1 3/8
7	3/8 - 1/2
8	7/8
9	7/8 - 1 1/8





NEXT GENERATION Step drills HSS, with 3 cutting edges

The deep-ground flutes of step drills with 3 cutting edges guarantee absolutely chatter-free working. The reduced load of the cutting edges allows a higher feed rate especially for soft materials like non-ferrous metals. The chamfer on the base of the cone makes withdrawal of the tool from the material simple when through hole drilling.

Packing unit: in plastic tubes of 1

Steel (N/mm ²) < 900		Brass	
Steel (N/mm ²) < 1100		Bronze	
Steel (N/mm ²) < 1300		Plastics	
Rust-resistant steel		Cast iron	
Aluminium		Titanium alloyed	

Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS		
0/9	4,0 - 12,00	65,0	9	6,0	101 350-9		1
1	4,0 - 20,00	75,0	9	8,0	101 351		1
2	4,0 - 30,00	100,0	14	10,0	101 352		1

0/9	4,0 / 5,0 / 6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0
1	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0
2	4,0 / 6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0 / 22,0 / 24,0 / 26,0 / 28,0 / 30,0



NEXT GENERATION Step drill sets HSS, with 3 cutting edges in steel case

Description	HSS
3-piece set of step drills with 3 cutting edges, sizes 0/9, 1, 2	101 326



101 326

Hexagonal magnetic holder

Packing unit: in plastic tubes of 1

Description	Article no.	
Hexagonal magnetic holder	270 013	1





NEXT GENERATION Step drills HSS, spiral fluted with split point for metric cable connections

Packing unit: in plastic tubes of 1

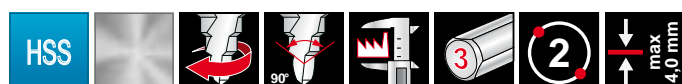
Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100			■
Steel (N/mm2) < 1300			
Rust-resistant steel		□	■
Aluminium	■		■

Brass	■	■	■
Bronze	□	□	■
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			



Size no.	Measurements	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	TIN	TiAIN	
14	Core holes	5,3 - 30,5	79,0	9	10,0	101 093	101 093 T	101 093 F	1
15	Through holes	6,5 - 32,5	79,0	9	10,0	101 092	101 092 T	101 092 F	1
16	Core holes	5,3 - 38,5	96,0	11	10,0	101 091	101 091 T	101 091 F	1
17	Through holes	6,5 - 40,5	96,0	11	10,0	101 090	101 090 T	101 090 F	1

14	DIN/EN 60423	5,3 / 7,0 / 9,0 / 10,5 / 14,5 / 18,5 / 23,5 / 27,0 / 30,5
15	DIN/EN 50262	6,5 / 8,5 / 10,5 / 12,5 / 16,5 / 20,5 / 25,5 / 29,0 / 32,5
16	DIN/EN 60423	5,3 / 7,0 / 9,0 / 10,5 / 14,5 / 18,5 / 23,5 / 27,0 / 30,5 / 34,5 / 38,5
17	DIN/EN 50262	6,5 / 8,5 / 10,5 / 12,5 / 16,5 / 20,5 / 25,5 / 29,0 / 32,5 / 36,5 / 40,5



Step drills HSS without point

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	



Size no.	Ø1 - Ø2 mm	L1 mm	Steps	Ø3 mm	HSS	
20	12,0 - 20,00	66,0	9	8,0	101 361	1
30	20,0 - 30,00	78,0	11	10,0	101 362	1
40	30,0 - 40,00	78,0	11	10,0	101 363	1

20	12,0 / 13,0 / 14,0 / 15,0 / 16,0 / 17,0 / 18,0 / 19,0 / 20,0
30	20,0 / 21,0 / 22,0 / 23,0 / 24,0 / 25,0 / 26,0 / 27,0 / 28,0 / 29,0 / 30,0
40	30,0 / 31,0 / 32,0 / 33,0 / 34,0 / 35,0 / 36,0 / 37,0 / 38,0 / 39,0 / 40,0

Material:		High carbon struc. steel up to 700 N/mm ²	High carbon struc. steel over 700 N/mm ²	Alloyed steel over 1000 N/mm ²	Cast iron up to 250 N/mm ²	Cast iron over 250 N/mm ²	CuZn- alloy brittle	CuZn- alloy tough	Al- alloy up to 11% Si	Thermo- plastics	Duro- plastics
Sheet thickness mm:		up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0
Vc = m/min		30	20	20	15	10	60	35	30	20	15
Cooling lubricant:		Cutting spray	Cutting spray	Cutting spray	Air	Air	Air	Air	Cutting spray	Water	Air
Size	Ø mm	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m
0/5	4,0 - 12,0	800 - 2400	500 - 1600	500 - 1600	400 - 1200	300 - 800	1600 - 4800	900 - 2800	800 - 2400	500 - 1600	400 - 1200
0/9	4,0 - 12,0	800 - 2400	500 - 1600	500 - 1600	400 - 1200	300 - 800	1600 - 4800	900 - 2800	800 - 2400	500 - 1600	400 - 1200
1	4,0 - 20,0	500 - 2400	300 - 1600	300 - 1600	200 - 1200	200 - 800	1000 - 4800	600 - 2800	500 - 2400	300 - 1600	200 - 1200
2	4,0 - 30,0	300 - 2400	200 - 1600	200 - 1600	200 - 1200	100 - 800	600 - 4800	400 - 2800	300 - 2400	200 - 1600	200 - 1200
3	6,0 - 38,0	300 - 1600	200 - 1100	200 - 1100	100 - 800	100 - 500	500 - 3200	300 - 1900	300 - 1600	200 - 1100	100 - 800
4	6,0 - 26,8	400 - 1600	200 - 1100	200 - 1100	200 - 800	100 - 500	700 - 3200	400 - 1900	400 - 1600	200 - 1100	200 - 800
5	4,0 - 32,0	300 - 2400	200 - 1600	200 - 1600	1200 - 100	100 - 800	600 - 4800	300 - 2800	300 - 2400	200 - 1600	100 - 1200
6	6,0 - 32,0	300 - 1600	200 - 1100	200 - 1100	800 - 100	100 - 500	600 - 3200	300 - 1900	300 - 1600	200 - 1100	100 - 800
7	5,0 - 28,0	300 - 1900	200 - 1300	200 - 1300	200 - 1000	100 - 600	700 - 3800	400 - 2200	300 - 1900	200 - 1300	200 - 1000
8	6,0 - 30,5	300 - 1600	200 - 1100	200 - 1100	200 - 800	100 - 500	600 - 3200	400 - 1900	300 - 1600	200 - 1100	200 - 800
9	6,0 - 37,0	300 - 1600	200 - 1100	200 - 1100	100 - 800	100 - 500	500 - 3200	300 - 1900	300 - 1600	200 - 1100	100 - 800
10	4,8 - 10,7	900 - 2000	600 - 1300	600 - 1300	400 - 1000	300 - 700	1800 - 4000	1000 - 2300	900 - 2000	600 - 1300	400 - 1000
11	6,0 - 25,0	400 - 1600	300 - 1100	300 - 1100	200 - 800	100 - 500	800 - 3200	400 - 1900	400 - 1600	300 - 1100	200 - 800
12	6,0 - 32,0	300 - 1600	200 - 1100	200 - 1100	100 - 800	100 - 500	600 - 3200	300 - 1900	300 - 1600	200 - 1100	100 - 800
13	6,0 - 40,0	200 - 1600	200 - 1100	200 - 1100	100 - 800	100 - 500	500 - 3200	300 - 1900	200 - 1600	200 - 1100	100 - 800
14	5,3 - 30,5	300 - 1800	200 - 1200	200 - 1200	200 - 900	100 - 600	600 - 3600	400 - 2100	300 - 1800	200 - 1200	200 - 900
15	6,5 - 32,5	300 - 1500	200 - 1000	200 - 1000	100 - 700	100 - 500	600 - 2900	300 - 700	300 - 1500	200 - 1000	100 - 700
16	5,3 - 38,5	200 - 1800	200 - 1200	200 - 1200	100 - 900	100 - 600	500 - 3600	300 - 2100	200 - 1800	200 - 1200	100 - 900
17	6,5 - 40,5	200 - 1500	200 - 1000	200 - 1000	100 - 700	100 - 500	500 - 2900	300 - 1700	200 - 1500	200 - 1000	100 - 700
18	6,5 - 32,5	300 - 1500	200 - 1000	200 - 1000	100 - 700	100 - 500	600 - 2900	300 - 1700	300 - 1500	200 - 1000	100 - 700
20	12,0 - 20,0	500 - 800	300 - 500	300 - 500	200 - 400	200 - 300	600 - 1600	600 - 900	500 - 800	300 - 500	200 - 400
30	20,0 - 30,0	300 - 500	200 - 300	200 - 300	200 - 200	100 - 200	600 - 1000	400 - 600	300 - 500	200 - 300	200 - 200
40	30,0 - 40,0	200 - 300	200 - 200	200 - 200	100 - 200	100 - 100	500 - 600	300 - 400	200 - 300	200 - 200	100 - 200

Size	Ø inch	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m	n = r.p.m
1	3/16 - 1/2	800 - 2000	500 - 1300	1300 - 500	400 - 1000	300 - 700	1500 - 4000	900 - 2300	800 - 2000	500 - 1300	400 - 1000
2	1/8 - 1/2	800 - 3000	500 - 2000	2000 - 500	400 - 1500	300 - 1000	1500 - 6000	900 - 3500	800 - 3000	500 - 2000	400 - 1500
3	1/4 - 3/4	500 - 1500	300 - 1000	1000 - 300	300 - 800	200 - 500	1000 - 3000	600 - 1800	500 - 1500	300 - 1000	300 - 800
4	3/16 - 7/8	400 - 2000	300 - 1300	1300 - 300	200 - 1000	100 - 700	900 - 4000	500 - 2300	400 - 2000	300 - 1300	200 - 1000
5	5/16 - 1	400 - 1200	300 - 800	800 - 300	200 - 600	100 - 400	800 - 2400	400 - 1400	400 - 1200	300 - 800	200 - 600
6	7/8 - 1 3/8	300 - 400	200 - 300	300 - 200	100 - 200	100 - 100	500 - 900	300 - 500	300 - 400	200 - 300	100 - 200
7	3/8 - 1/2	800 - 1000	500 - 700	700 - 500	400 - 500	300 - 300	1500 - 2000	900 - 1200	800 - 1000	500 - 700	400 - 500
8	7/8	400	300	300	200	100	900	500	400	300	200
9	7/8 - 1 1/8	300 - 400	200 - 300	300 - 200	200 - 200	100 - 100	700 - 900	400 - 500	300 - 400	200 - 300	200 - 200

Size No-	Drilling range Ø mm													
0/5	for metric hole diameters													
	Ø 4,0	Ø 6,0	Ø 8,0	Ø 10,0	Ø 12,0									
0/9	for metric hole diameters													
	Ø 4,0	Ø 5,0	Ø 6,0	Ø 7,0	Ø 8,0	Ø 9,0	Ø 10,0	Ø 11,0	Ø 12,0					
1	for metric hole diameters													
	Ø 4,0	Ø 6,0	Ø 8,0	Ø 10,0	Ø 12,0	Ø 14,0	Ø 16,0	Ø 18,0	Ø 20,0					
2	for metric hole diameters													
	Ø 4,0	Ø 6,0	Ø 8,0	Ø 10,0	Ø 12,0	Ø 14,0	Ø 16,0	Ø 18,0	Ø 20,0	Ø 22,0	Ø 24,0	Ø 26,0	Ø 28,0	Ø 30,0
3	for metric hole diameters													
	Ø 6,0	Ø 9,0	Ø 13,0	Ø 16,0	Ø 19,0	Ø 21,0	Ø 23,0	Ø 26,0	Ø 29,0	Ø 32,0	Ø 35,0	Ø 38,0		
4	for steel conduit threads (core holes)													
	PG 7 / Ø 11,4		PG 9 / Ø 14,0		PG 11 / Ø 17,25		PG 13,5 / Ø 19,0		PG 16 / Ø 21,25		PG 21 / Ø 26,75			
5	for metric hole diameters													
	Ø 4,0	Ø 6,0	Ø 9,0	Ø 12,0	Ø 15,0	Ø 18,0	Ø 21,0	Ø 24,0	Ø 27,0	Ø 30,0	Ø 33,0	Ø 36,0	Ø 39,0	
6	for pipe threads (external Ø, through holes)													
	R 1/8" / Ø 11,2		R 1/4" / 14,5		R 3/8" / Ø 18,2		R 1/2" / Ø 22,3		R 3/4" / Ø 27,9					
7	for pipe threads (core holes)													
	G 1/8" / Ø 8,8		G 1/4" / 11,8		G 3/8" / Ø 15,3		G 1/2" / Ø 19,0		G 3/4" / Ø 24,5					
8	for steel conduit threads (through holes)													
	PG 7 / Ø 12,5		PG 9 / Ø 15,2		PG 11 / Ø 18,6		PG 13,5 / Ø 20,4		PG 16 / Ø 22,5		PG 21 / Ø 28,3			
9	for steel conduit threads (through holes)													
	PG 7 / Ø 12,5		PG 9 / Ø 15,2		PG 11 / Ø 18,6		PG 13,5 / Ø 20,4		PG 16 / Ø 22,5		PG 21 / Ø 28,3		PG 29 / Ø 37,0	
10	for blind rivets M3 - M4 - M5 - M6 - M8													
	Ø 4,8	Ø 6,4	Ø 7,2	Ø 9,6	Ø 10,65									
11	for metric hole diameters with high steps													
	Ø 6,0	Ø 9,0	Ø 12,0	Ø 16,0	Ø 20,0	Ø 22,5	Ø 25,0							
12	for metric hole diameters with high steps													
	Ø 6,0	Ø 9,0	Ø 12,0	Ø 16,0	Ø 20,0	Ø 22,5	Ø 25,0	Ø 28,5	Ø 32,0					
13	for metric hole diameters and large diameters													
	Ø 6,0	Ø 11,0	Ø 17,0	Ø 23,0	Ø 29,0	Ø 30,0	Ø 31,0	Ø 32,0	Ø 33,0	Ø 34,0	Ø 35,0	Ø 36,0	Ø 37,0	Ø 38,0
	Ø 39,0	Ø 40,0												
14	for metric cable connections, core holes after DIN/EN 60423													
	M 6	M 8	M 10	M 12	M 16	M 20	M 25	M 32						
	Ø 5,3	Ø 7,0	Ø 9,0	Ø 10,5	Ø 14,5	Ø 18,5	Ø 23,5	Ø 30,5						
15	for metric cable connections, through holes after DIN/EN 50262													
	M 6	M 8	M 10	M 12	M 16	M 20	M 25	M 32						
	Ø 6,5	Ø 8,5	Ø 10,5	Ø 12,5	Ø 16,5	Ø 20,5	Ø 25,5	Ø 32,5						
16	for metric cable connections, core holes after DIN/EN 60423													
	M 6	M 8	M 10	M 12	M 16	M 20	M 25	M 32	M 40					
	Ø 5,3	Ø 7,0	Ø 9,0	Ø 10,5	Ø 14,5	Ø 18,5	Ø 23,5	Ø 30,5	Ø 38,5					
17	for metric cable connections, through holes after DIN/EN 50262													
	M 6	M 8	M 10	M 12	M 16	M 20	M 25	M 32	M 40					
	Ø 6,5	Ø 8,5	Ø 10,5	Ø 12,5	Ø 16,5	Ø 20,5	Ø 25,5	Ø 32,5	Ø 40,5					
18	for metric cable connections / for steel conduit threads, through holes													
	M 6	M 8	M 10	M 12 / PG 7		PG 9	M 16	PG 11	M 20 / PG 13,5		PG 16	M 25	PG 21	M 32
	Ø 6,5	Ø 8,5	Ø 10,5	Ø 12,7		Ø 15,2	Ø 16,2	Ø 18,6	Ø 20,4		Ø 22,5	Ø 25,5	Ø 28,3	Ø 32,5













TAPER AND DEBURRING COUNTERSINKERS

FASCINATION  PRECISION®

Range and applications overview:













Material	Surface	DIN	Shape	Countersink angle	Cutting edges	Shank	Ø mm	Article no.	Miscellaneous	Page
HSS		DIN 335	C	90°			6,3 - 31,0 mm	102 767 - 102 785		112 - 115
HSS	RUNa TEC	DIN 335	C	90°			6,3 - 31,0 mm	102 767 P - 102 785 P		112 - 115
HSSE Co 5		DIN 335	C	90°			6,3 - 31,0 mm	102 767 E - 102 785 E		112 - 115
HSSE Co 5	RUNa TEC	DIN 335	C	90°			6,3 - 31,0 mm	102 767 EP - 102 785 EP		112 - 115
HSS		DIN 335	C	90°			4,3 - 40,0 mm	102 101 - 102 174		116 - 118
HSS		DIN 335	C	90°			6,3 - 31,0 mm	102 107 A - 102 125 A	AL	116 - 118
HSSE Co 5		DIN 335	C	90°			4,3 - 31,0 mm	102 101 E - 102 125 E		116 - 118
HSS	TiN	DIN 335	C	90°			4,3 - 40,0 mm	102 101 T - 102 174 T		116 - 118
HSS	TiAlN	DIN 335	C	90°			4,3 - 40,0 mm	102 101 F - 102 174 F		116 - 118
TC		DIN 335	C	90°			6,3 - 31,0 mm	102 261 - 102 268		116 - 118
ASP		DIN 335	C	90°			6,3 - 31,0 mm	102 107 ASP - 102 125 ASP		119
HSS		DIN 335	C	90°			6,3 - 25,0 mm	102 271 - 102 288		120
HSS		DIN 335	D	90°			15,0 - 80,0 mm	102 126 - 102 141		121
HSS		DIN 335	C	82°			1/4" - 1"	102 182 - 102 191	Inch"	122
HSS		DIN 334	C	60°			6,3 - 25,0 mm	102 201 - 102 207		123
HSS		DIN 334	D	60°			16,0 - 80,0 mm	102 208 - 102 215		123
HSS			C	75°			6,3 - 25,0 mm	102 221 - 102 227		124
HSS			D	75°			16,5 - 40,0 mm	102 228 - 102 232		124

Steel (N/mm ²) < 900 	Steel (N/mm ²) < 1100 	Steel (N/mm ²) < 1300 	Stainless steel 	Aluminium 	Brass 	Bronze 	Plastics 	Cast iron 	Titanium alloyed 
■			□	■	■	□	■	□	
■	□		■	■	■	□	■	□	
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■				■	■	□	■	□	

Range and applications overview:



Material	Surface	DIN	Shape	Countersink angle	Cutting edges	Shank	Ø mm	Article no.	Miscellaneous	Page
HSS			C				6,3 - 25,0 mm	102 241 - 102 247		125
HSS			D				16,5 - 40,0 mm	102 248 - 102 252		125
HSS			C				6,0 - 50,0 mm	102 521 - 102 530		126
HSS							2/5 - 20/25	102 301 - 102 305		127
HSSE Co 5							1/4 - 20/25	102 300 E - 102 305 E		127
HSS	TiN						2/5 - 20/25	102 301 T - 102 305 T		127
HSS							6,3 - 20,5 mm	W102 313 - W102 318		128
HSS	TiN						6,3 - 20,5 mm	W102 313T - W102 318T		128
HSS							6,3 - 20,5 mm	102 313 - 102 318		129
HSS	TiN						6,3 - 20,5 mm	102 313T - 102 318T		129
HSS							M3 - M12	102 401 - 102 421		130 - 131
HSS	TiN						M3 - M12	102 401 T - 102 421 T		130 - 131
HSS							M10 - M22	102 422 - 102 442		132
HSS		DIN 8374 DIN 8376 DIN 8378	N				M3 - M12	102 601 - 102 619		134
HSS			N				M3 - M12	102 620 - 102 638		135

Steel (N/mm ²) < 900 	Steel (N/mm ²) < 1100 	Steel (N/mm ²) < 1300 	Stainless steel 	Aluminium 	Brass 	Bronze 	Plastics 	Cast iron 	Titanium alloyed 
■				■	■	□	■	□	
■				■	■	□	■	□	
■				■	■	□	■	□	
■				■	■	□	■	□	
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■				■	■	□	■	□	

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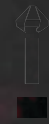
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Information
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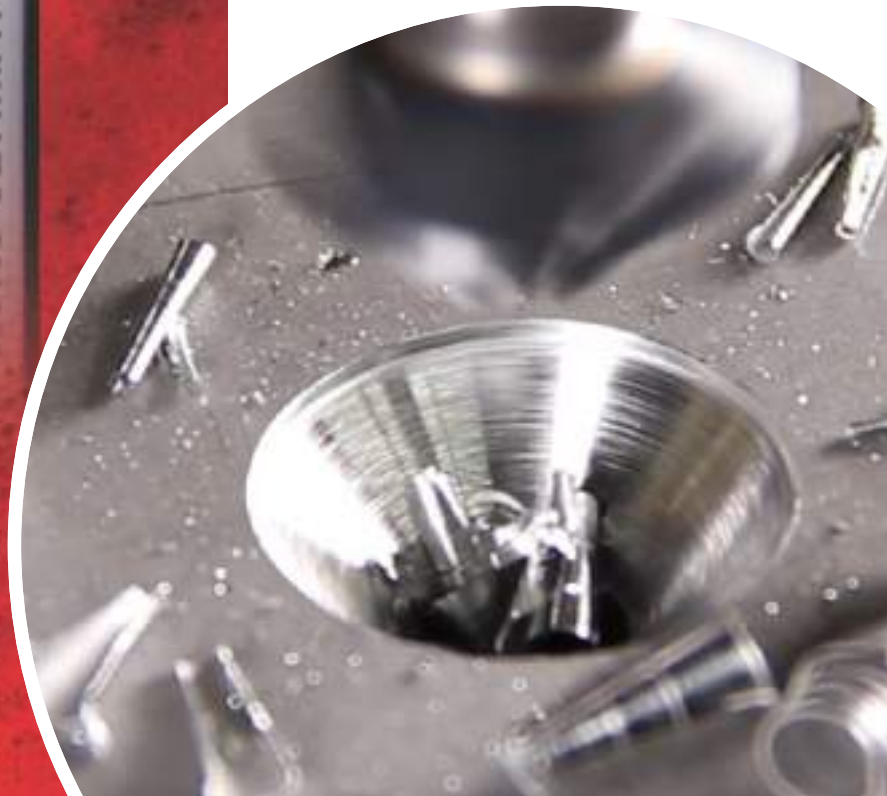
ULTIMATECUT®

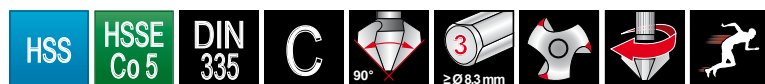


More precise. More powerful. Faster.

The specially developed flute parameters, such as the angle, the transition radius as well as the extra-wide chip flute, ensures optimal chip and heat removal and therefore enables a high wear resistance. Furthermore, the new geometry prevents material welding and reduces the countersinking force.

The variably running relief grinding was specially developed and ensures a very quiet countersinking procedure and a perfect surface quality, which guarantees the best results. (The new RUnATEC coating increases the quality additionally)





ULTIMATECUT Taper and deburring countersinker DIN 335 type C 90°

The **ULTIMATECUT** countersink is a high performance tool which stands for best performance: up to 30% time savings, twice as many countersinks as standard tools and excellent, smooth countersinking results in almost all materials.

The specially developed countersink from RUKO achieves this through its unique cutting edge geometry, with the specially developed variably running relief grinding, transition radius and the extra-wide chip flute.



Packing unit: in plastic tubes of 1



- achieves the best performance in almost all materials and applications
- considerably less feed force required
- up to 60% longer service life
- up to 30% faster countersinking
- extremely quiet running
- optimal and smooth surface
- perfect chip removal

Steel (N/mm ²) < 900	■	■	■	■
Steel (N/mm ²) < 1100		□	■	■
Steel (N/mm ²) < 1300			□	■
Rust-resistant steel	□	■	■	■
Aluminium	■	■	■	■

Brass	■	■	■	■
Bronze	□	□	□	□
Plastics	■	■	■	■
Cast iron	□	□	□	□
Titanium alloyed				□

Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	Countersinkings as per DIN 74	HSS	HSS	HSSE Co 5	HSSE Co 5	
6,3	1,5	45,0	5,0	M 3	102 767	102 767 P	102 767 E	102 767 EP	1
8,3	2,0	50,0	6,0	M 4	102 771	102 771 P	102 771 E	102 771 EP	1
10,4	2,5	50,0	6,0	M 5	102 774	102 774 P	102 774 E	102 774 EP	1
12,4	2,8	56,0	8,0	M 6	102 776	102 776 P	102 776 E	102 776 EP	1
15,0	3,2	60,0	10,0	M 8	102 778	102 778 P	102 778 E	102 778 EP	1
16,5	3,2	60,0	10,0	M 8	102 779	102 779 P	102 779 E	102 779 EP	1
19,0	3,5	63,0	10,0	M 10	102 780	102 780 P	102 780 E	102 780 EP	1
20,5	3,5	63,0	10,0	M 10	102 781	102 781 P	102 781 E	102 781 EP	1
23,0	3,8	67,0	10,0	M 12	102 782	102 782 P	102 782 E	102 782 EP	1
25,0	3,8	67,0	10,0	M 12	102 783	102 783 P	102 783 E	102 783 EP	1
31,0	4,2	71,0	12,0	M 16	102 785	102 785 P	102 785 E	102 785 EP	1





ULTIMATECUT Taper and deburring countersinker sets HSS DIN 335 type C 90° in plastic case

	HSS	RUna TEC
6-piece set of ULTIMATECUT taper and deburring countersinkers HSS (DIN 335) type C 90° Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm	102 790 RO	102 790 PRO
5-piece set of ULTIMATECUT taper and deburring countersinkers HSS (DIN 335) type C 90° Ø 6,3 - 10,4 - 16,5 - 20,5 - 25,0 mm	102 791 RO	102 791 PRO



ULTIMATECUT Taper and deburring countersinker sets HSSE-Co 5 DIN 335 type C 90° in plastic case

	HSSE Co 5	RUna TEC
6-piece set of ULTIMATECUT taper and deburring countersinkers HSSE-Co 5 (DIN 335) type C 90° Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm	102 790 ERO	102 790 EPRO
5-piece set of ULTIMATECUT taper and deburring countersinkers HSSE-Co 5 (DIN 335) type C 90° Ø 6,3 - 10,4 - 16,5 - 20,5 - 25,0 mm	102 791 ERO	102 791 EPRO





Taper and deburring countersinkers DIN 335 type C 90°

Because of the CBN deep-ground flutes the cutting edges are extremely sharp.
Ideal for burr- and chatter-free deburring and countersinking.
Best results at low cutting speeds.








Packing unit: in plastic tubes of 1



To increase the service life - reduce speed!
Cooling while countersinking!

Steel (N/mm ²) < 900	■	□	■	■	■	■
Steel (N/mm ²) < 1100			■	□	■	■
Steel (N/mm ²) < 1300						■
Rust-resistant steel			■	□	■	■
Aluminium	■	■	■		■	■

Brass	■	□	■	■	■	□
Bronze	□		□	□	□	■
Plastics	■	■	■	■	■	■
Cast iron	□		□	□	□	■
Titanium alloyed						

Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	Countersinkings as per DIN 74								
				AF	BF							
4,3	1,3	40,0	4,0	M 2,5		102 101	—	102 101 E	102 101 T	102 101 F	—	1
4,8	1,5	40,0	4,0			102 102	—	—	102 102 T	102 102 F	—	1
5,0	1,5	40,0	4,0			102 103	—	102 103 E	102 103 T	102 103 F	—	1
5,3	1,5	40,0	4,0			102 104	—	102 104 E	102 104 T	102 104 F	—	1
5,8	1,5	45,0	5,0	M 3		102 105	—	—	102 105 T	102 105 F	—	1
6,0	1,5	45,0	5,0			102 106	—	102 106 E	102 106 T	102 106 F	—	1
6,3	1,5	45,0	5,0		M 3	102 107	102 107 A	102 107 E	102 107 T	102 107 F	102 261	1
7,0	1,8	50,0	6,0	M 3,5		102 108	—	—	102 108 T	102 108 F	—	1
7,3	1,8	50,0	6,0			102 109	—	—	102 109 T	102 109 F	—	1
8,0	2,0	50,0	6,0	M 4		102 110	—	102 110 E	102 110 T	102 110 F	—	1
8,3	2,0	50,0	6,0			M 4	102 111	102 111 A	102 111 E	102 111 T	102 111 F	102 262
9,4	2,2	50,0	6,0			102 112	—	—	102 112 T	102 112 F	—	1
10,0	2,5	50,0	6,0	M 5		102 113	—	102 113 E	102 113 T	102 113 F	—	1
10,4	2,5	50,0	6,0			M 5	102 114	102 114 A	102 114 E	102 114 T	102 114 F	102 263
11,5	2,8	56,0	8,0	M 6		102 115	—	102 115 E	102 115 T	102 115 F	—	1
12,4	2,8	56,0	8,0			M 6	102 116	102 116 A	102 116 E	102 116 T	102 116 F	102 264
13,4	2,9	56,0	8,0			102 117	—	—	102 117 T	102 117 F	—	1
15,0	3,2	60,0	10,0	M 8		102 118	—	102 118 E	102 118 T	102 118 F	—	1
16,5	3,2	60,0	8,0			M 8	102 119	102 119 A	102 119 E	102 119 T	102 119 F	—
16,5	3,2	60,0	10,0		M 8	102 119-1	102 119-1 A	102 119-1 E	102 119-1 T	102 119-1 F	102 265	1
19,0	3,5	63,0	10,0	M 10		102 120	—	102 120 E	102 120 T	102 120 F	—	1
20,5	3,5	63,0	10,0			M 10	102 121	102 121 A	102 121 E	102 121 T	102 121 F	102 266
23,0	3,8	67,0	10,0	M 12		102 122	—	102 122 E	102 122 T	102 122 F	—	1
25,0	3,8	67,0	10,0			M 12	102 123	102 123 A	102 123 E	102 123 T	102 123 F	102 267
26,0	3,9	71,0	12,0	M 14		102 171	—	—	102 171 T	102 171 F	—	1
28,0	4,0	71,0	12,0			M 14	102 124	—	102 124 E	102 124 T	102 124 F	—
30,0	4,1	71,0	12,0	M 16		102 172	—	—	102 172 T	102 172 F	—	1
31,0	4,2	71,0	12,0			M 16	102 125	102 125 A	102 125 E	102 125 T	102 125 F	102 268
37,0	4,8	90,0	12,0			102 173	—	—	102 173 T	102 173 F	—	1
40,0	10,0	80,0	15,0			102 174	—	—	102 174 T	102 174 F	—	1

Taper and deburring countersinker sets DIN 335 type C 90° HSS, HSSE-Co 5 and tungsten carbide K 20 in steel case

	HSS	HSS für / for ALU	HSSE Co 5	HSS TiN	HSS TiAIN	TC
5-piece set of taper and deburring countersinkers DIN 335 type C 90° Ø 6,3 - 10,4 - 16,5 - 20,5 - 25,0 mm (Ø 16,5 mm = shank-Ø 10,0 mm)	102 154	102 154 A	102 154 E	102 154 T	102 154 F	—
6-piece set of taper and deburring countersinkers DIN 335 type C 90° Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm (Ø 16,5 mm = shank-Ø 10,0 mm)	102 152	102 152 A	102 152 E	102 152 T	102 152 F	102 152 HM



102 154



102 154 T



102 154 F



102 152



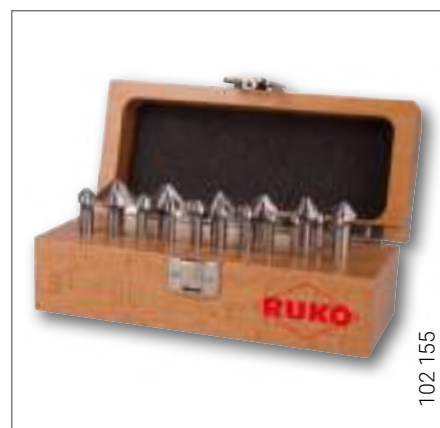
102 152 T



102 152 F

Taper and deburring countersinker sets DIN 335 type C 90° HSS in wooden case

	HSS
17-piece set of taper and deburring countersinkers DIN 335 type C 90° Ø 4,3 - 5,0 - 6,0 - 6,3 - 7,0 - 8,0 - 8,3 - 10,0 - 10,4 - 11,5 - 12,4 - 15,0 - 16,5 - 19,0 - 20,5 - 23,0 - 25,0 mm (Ø 16,5 mm = shank-Ø 10,0 mm) in wooden case	102 155



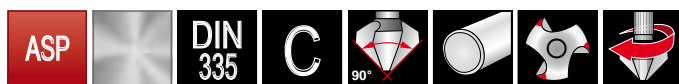
102 155



Taper and deburring countersinker sets DIN 335 type C 90° HSS, HSSE-Co 5 and tungsten carbide K 20 in plastic case

	HSS	HSS	HSSE Co 5	HSS	HSS	TC
5-piece set of taper and deburring countersinkers DIN 335 type C 90° Ø 6,3 - 10,4 - 16,5 - 20,5 - 25,0 mm (Ø 16,5 mm = shank-Ø 10,0 mm)	102 154 RO	–	102 154 ERO	102 154 TRO	102 154 FRO	–
6-piece set of taper and deburring countersinkers DIN 335 type C 90° Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm (Ø 16,5 mm = shank-Ø 10,0 mm)	102 152 RO	–	102 152 ERO	102 152 TRO	102 152 FRO	102 152 HMRO
17-piece set of taper and deburring countersinkers DIN 335 type C 90° Ø 4,3 - 5,0 - 6,0 - 6,3 - 7,0 - 8,0 - 8,3 - 10,0 - 10,4 - 11,5 - 12,4 - 15,0 - 16,5 - 19,0 - 20,5 - 23,0 - 25,0 mm (Ø 16,5 mm = shank-Ø 10,0 mm)	102 155 RO	–	–	–	–	–
6-piece set of taper and deburring countersinkers DIN 335 type C 90° Ø 6,3 - 10,4 - 16,5 - 20,5 - 25,0 mm (Ø 16,5 mm = shank-Ø 8,0 mm) + 1x cutting paste, 50 g	102 142	102 142 A	102 142 E	102 142 T	–	–





Taper and deburring countersinkers DIN 335 type C 90° ASP

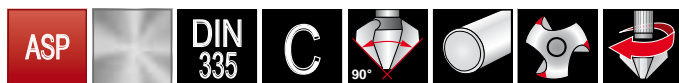
The taper and deburring countersinker DIN 335 form C 90° ASP is made of powder-metallurgical metal and thus has a higher cutting edge stability. Best results in VA steels, Hardox 400 steels, titanium and titanium alloys.

Packing unit: in plastic tubes of 1



Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100	■	Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel	■	Cast iron	■
Aluminium	■	Titanium alloyed	□

Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	Countersinkings as per DIN 74 / BF			
6,3	1,5	45,0	5,0	M 3	102 107 ASP	1	
8,3	2,0	50,0	6,0	M 4	102 111 ASP	1	
10,4	2,5	50,0	6,0	M 5	102 114 ASP	1	
12,4	2,8	56,0	8,0	M 6	102 116 ASP	1	
16,5	3,2	60,0	10,0	M 8	102 119-1 ASP	1	
20,5	3,5	63,0	10,0	M 10	102 121 ASP	1	
25,0	3,8	67,0	10,0	M 12	102 123 ASP	1	
31,0	4,2	71,0	12,0	M 16	102 125 ASP	1	



Taper and deburring countersinker sets DIN 335 type C 90° ASP in steel case

6-piece set of taper and deburring countersinkers DIN 335 type C 90° ASP Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm	102 152 ASP
5-piece set of taper and deburring countersinkers DIN 335 type C 90° ASP Ø 6,3 - 10,4 - 16,5 - 20,5 - 25,0 mm	102 154 ASP



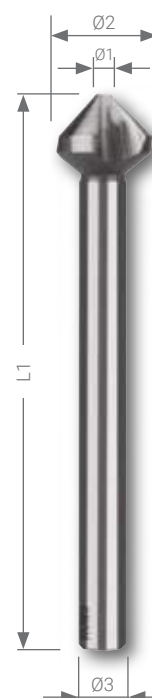


Taper and deburring countersinkers DIN 335 type C 90° HSS, with long cylindrical shank

Because of the CBN deep-ground flutes the cutting edges are extremely sharp.
Ideal for burr- and chatter-free deburring and countersinking. Best results at low cutting speeds.

Packing unit: in plastic tubes of 1

Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100		Bronze	□
Steel (N/mm ²) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	



Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	Countersinkings as per DIN 74				
				AF	BF			
6,3	1,5	85,0	5,0	-	M 3	102 271		1
8,3	2,0	85,0	6,0	-	M 4	102 272		1
10,4	2,5	88,0	6,0	-	M 5	102 273		1
12,4	2,8	108,0	8,0	-	M 6	102 274		1
15,0	3,2	110,0	10,0	M 8	-	102 275		1
16,5	3,2	112,0	10,0	-	M 8	102 276		1
20,5	3,5	115,0	10,0	-	M10	102 277		1
25,0	3,8	118,0	10,0	-	M12	102 278		1

Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	Countersinkings as per DIN 74				
				AF	BF			
6,3	1,5	154,0	5,0	-	M 3	102 281		1
8,3	2,0	155,0	6,0	-	M 4	102 282		1
10,4	2,5	157,0	6,0	-	M 5	102 283		1
12,4	2,8	158,0	8,0	-	M 6	102 284		1
15,0	3,2	158,0	10,0	M 8	-	102 285		1
16,5	3,2	161,0	10,0	-	M 8	102 286		1
20,5	3,5	164,0	10,0	-	M10	102 287		1
25,0	3,8	164,0	10,0	-	M12	102 288		1



Taper and deburring countersinkers DIN 335 type C 90° HSS, with long cylindrical shank, in plastic case

6-piece set of taper and deburring countersinkers DIN 335 type C 90° Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm	102 158 RO

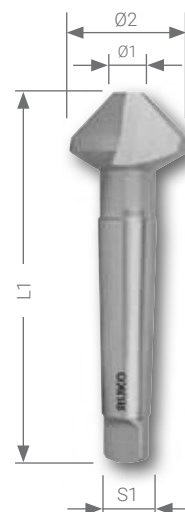




Taper and deburring countersinkers DIN 335 type D 90° HSS

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	



Ø2 mm	Ø1 mm	L1 mm	Shank S1	Senkungen nach DIN 74			
				AF	BF		
15,0	3,2	85,0	MT 1	M 8	-	102 126	1
16,5	3,2	85,0	MT 1	-	M 8	102 127	1
19,0	3,5	100,0	MT 2	M 10	-	102 128	1
20,5	3,5	100,0	MT 2	-	M 10	102 129	1
23,0	3,8	106,0	MT 2	M 12	-	102 130	1
25,0	3,8	106,0	MT 2	-	M 12	102 131	1
26,0	3,8	106,0	MT 2	M 14	-	102 132	1
28,0	4,0	112,0	MT 2	-	M 14	102 133	1
30,0	4,2	112,0	MT 2	M 16	-	102 134	1
31,0	4,2	112,0	MT 2	-	M 16	102 135	1
34,0	4,5	118,0	MT 2	M 18	M 18	102 136	1
37,0	4,8	118,0	MT 2	M 20	M 20	102 137	1
40,0	10,0	140,0	MT 3	-	-	102 138	1
50,0	14,0	150,0	MT 3	-	-	102 139	1
63,0	16,0	180,0	MT 4	-	-	102 140	1
80,0	22,0	190,0	MT 4	-	-	102 141	1



Hand deburrer DIN 335 type C 90° HSS, CBN ground

Packing unit: in plastic tubes of 1

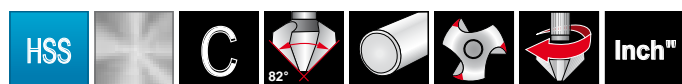
Hand deburrer with countersinker Ø 12,4 mm	102 143	1
Hand deburrer with countersinker Ø 15,0 mm	102 144	1
Hand deburrer with countersinker Ø 16,5 mm	102 145	1
Hand deburrer with countersinker Ø 20,5 mm	102 146	1
Hand deburrer with countersinker Ø 25,0 mm	102 147	1

Universal handle to fit countersinkers

Packing unit: in plastic tubes of 1

Universal handle for countersinker with 8,0 mm shank Ø	102 148	1
Universal handle for countersinker with 10,0 mm shank Ø	102 149	1
Universal handle for countersinker with 1/4" hexagon socket	102 320	1



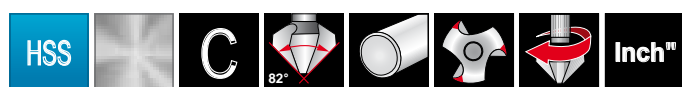


Taper and deburring countersinkers type C 82° HSS, inch size

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø2		Ø1	Ø3		L1				
inch	mm		inch	mm	inch	mm			
1/4	6,4	3/64	3/16	5,0	1 3/4	45,0	102 182		1
5/16	7,9	4/64	1/4	6,0	2"	50,0	102 183		1
3/8	9,5	5/64	1/4	6,0	2"	50,0	102 184		1
1/2	12,7	6/64	5/16	8,0	2 3/16	56,0	102 186		1
5/8	15,9	7/64	3/8	10,0	2 3/8	60,0	102 188		1
3/4	19,1	8/64	3/8	10,0	2 1/2	63,0	102 189		1
7/8	22,2	9/64	3/8	10,0	2 5/8	67,0	102 190		1
1	25,4	9/64	3/8	10,0	2 5/8	76,0	102 191		1



Taper and deburring countersinker set type C 82° HSS, inch size, in plastic case

5-piece set of taper and deburring countersinkers type C 82° HSS Ø 1/4 - 3/8 - 1/2 - 3/4 - 1 inch	102 193 RO



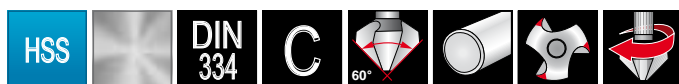
Coolants and lubricants

RUKO high performance coolants and lubricants with outstanding cooling and anti-separation qualities. Increases tool life even with hard and brittle materials. High heat resistance ensures good lubrication and cooling, even at high temperatures. Good adhesion quality improves lubrication.

For all standard metal working processes, such as drilling, thread cutting, countersinking, deburring, sawing, turning, milling, grinding.

Perfectly matched for use with RUKO metal working tools.
Section 14 – Page 289





Taper and deburring countersinkers DIN 334 type C 60° HSS

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	HSS		
6,3	1,6	45,0	5,0	102 201		1
8,0	2,0	50,0	6,0	102 202		1
10,0	2,5	50,0	6,0	102 203		1
12,5	3,2	56,0	8,0	102 204		1
16,0	4,0	63,0	10,0	102 205		1
20,0	5,0	67,0	10,0	102 206		1
25,0	6,3	71,0	10,0	102 207		1

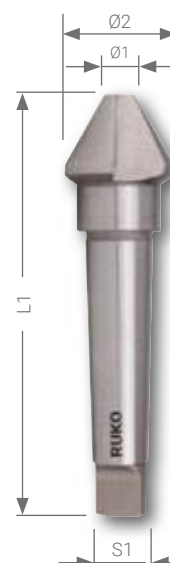


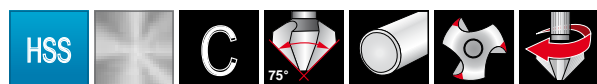
Taper and deburring countersinkers DIN 334 type D 60° HSS

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø2 mm	Ø1 mm	L1 mm	Shank S1	HSS		
16,0	4,0	90,0	MT 1	102 208		1
20,0	5,0	106,0	MT 2	102 209		1
25,0	6,3	112,0	MT 2	102 210		1
31,5	10,0	118,0	MT 2	102 211		1
40,0	12,5	150,0	MT 3	102 212		1
50,0	16,0	160,0	MT 3	102 213		1
63,0	20,0	190,0	MT 4	102 214		1
80,0	25,0	200,0	MT 4	102 215		1



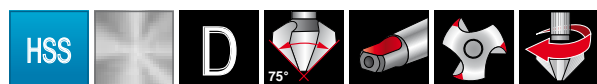


Taper and deburring countersinkers type C 75° HSS

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	HSS		
6,3	1,6	45,0	5,0	102 221	1	
8,3	2,0	50,0	6,0	102 222	1	
10,4	2,5	50,0	6,0	102 223	1	
12,4	3,2	56,0	8,0	102 224	1	
16,5	4,0	63,0	10,0	102 225	1	
20,5	5,0	67,0	10,0	102 226	1	
25,0	6,3	71,0	10,0	102 227	1	



Taper and deburring countersinkers type D 75° HSS

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø2 mm	Ø1 mm	L1 mm	Shank S1	HSS		
16,5	3,5	87,0	MT 1	102 228	1	
20,5	4,5	102,0	MT 2	102 229	1	
25,0	5,0	109,0	MT 2	102 230	1	
31,0	5,0	116,0	MT 2	102 231	1	
40,0	10,0	145,0	MT 3	102 232	1	





Taper and deburring countersinkers type C 120° HSS

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	HSS		
6,3	1,5	45,0	5,0	102 241	1	
8,3	2,0	50,0	6,0	102 242	1	
10,4	2,5	50,0	6,0	102 243	1	
12,4	3,0	56,0	8,0	102 244	1	
16,5	3,5	63,0	10,0	102 245	1	
20,5	4,0	67,0	10,0	102 246	1	
25,0	5,0	71,0	10,0	102 247	1	



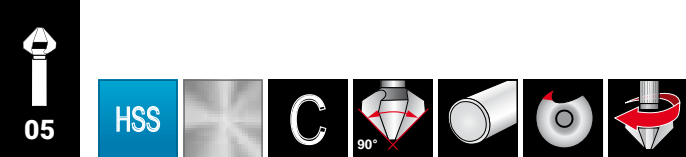
Taper and deburring countersinkers type D 120° HSS

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø2 mm	Ø1 mm	L1 mm	Shank S1	HSS		
16,5	3,5	87,0	MT 1	102 248	1	
20,5	4,5	102,0	MT 2	102 249	1	
25,0	5,0	109,0	MT 2	102 250	1	
31,0	5,0	116,0	MT 2	102 251	1	
40,0	10,0	145,0	MT 3	102 252	1	







Taper and deburring countersinkers type C 90° HSS

Only countersinking and deburring possible.
Countersink with a blade not recommended for full countersinking.

Packing unit: in plastic tubes of 1

			
Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	

Ø2 mm	L1 mm	Ø3 mm	HSS 	
6,0	45,0	5,0	102 521	1
8,0	50,0	6,0	102 522	1
10,0	50,0	6,0	102 523	1
12,0	56,0	8,0	102 524	1
16,0	60,0	10,0	102 525	1
20,0	63,0	10,0	102 526	1
25,0	67,0	10,0	102 527	1
30,0	71,0	12,0	102 528	1
40,0	89,0	15,0	102 529	1
50,0	98,0	15,0	102 530	1





Slotted taper and deburring countersinkers 90° HSS, HSSE-Co 5 and HSS-TiN

Peeling cut. Chip removal through the slot prevents chips from clogging the workpiece.
Ideal for burr- and chatter-free deburring and countersinking. Applicable for steel, cast iron,
non-ferrous and light metals. Best results at low cutting speeds.
Countersink with a blade not recommended for full countersinking.

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100		■	□
Steel (N/mm2) < 1300		□	
Rust-resistant steel		■	
Aluminium	■	■	

Brass	■	■	■
Bronze	□	□	□
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			



Size no.	Ø1 mm	Ø2 mm	Ø3 mm	L1 mm				
1/4	1,0 - 4,0	6,35	6,35	45,0	—	102 300 E	—	1
2/5	2,0 - 5,0	10,00	6,00	45,0	102 301	102 301 E	102 301 T	1
5/10	5,0 - 10,0	14,00	8,00	48,0	102 302	102 302 E	102 302 T	1
10/15	10,0 - 15,0	21,00	10,00	65,0	102 303	102 303 E	102 303 T	1
15/20	15,0 - 20,0	28,00	12,00	85,0	102 304	102 304 E	102 304 T	1
20/25	20,0 - 25,0	35,00	12,00	102,0	102 305	102 305 E	102 305 T	1

Slotted taper and deburring countersinkers sets 90° HSS, HSSE-Co 5 and HSS-TiN

6-piece set of slotted taper and deburring countersinkers 90° in polystyrene case nominal Ø mm: 2/5 - 5/10 - 10/15 - 15/20 + 1 cutting paste, 50 g	—	102 310 E	—
5-piece set of slotted taper and deburring countersinkers 90° in steel case nominal Ø mm: 2/5 - 5/10 - 10/15 - 15/20 + 1 cutting paste, 30 g	102 312	102 312 E	102 312 T



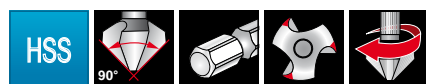
102 312

Slotted taper and deburring countersinkers sets 90° HSS, HSSE-Co 5 and HSS-TiN in plastic case

4-piece set of slotted taper and deburring countersinkers 90° nominal Ø mm: 2/5 - 5/10 - 10/15 - 15/20	102 312 RO	102 312 ERO	102 312 TRO



102 312 TRO



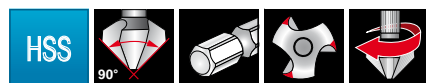
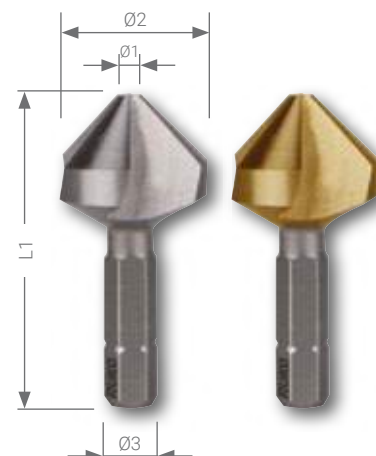
Taper and deburring countersinker bits 90° "short series" HSS / HSS-TiN with 1/4" hexagonal shank

Rapid tool-changing thanks to hexagonal bit holder. Ideal for burr- and chatter-free deburring and countersinking. Applicable for steel, cast iron, non-ferrous and light metals. Best results at low cutting speeds.

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	■
Steel (N/mm2) < 1100		□
Steel (N/mm2) < 1300		
Rust-resistant steel		□
Aluminium	■	
Brass	■	■
Bronze	□	□
Plastics	■	■
Cast iron	□	□
Titanium alloyed		

Ø2 mm	Ø1 mm	L1 mm	Ø3 inch	Countersinkings as per DIN 74				
				AF	BF			
6,3	1,5	31,0	1/4"	-	M 3	W 102 313	W 102 313 T	1
8,3	2,0	31,0	1/4"	-	M 4	W 102 314	W 102 314 T	1
10,4	2,5	34,0	1/4"	-	M 5	W 102 315	W 102 315 T	1
12,4	2,8	35,0	1/4"	-	M 6	W 102 316	W 102 316 T	1
16,5	3,2	40,0	1/4"	-	M 8	W 102 317	W 102 317 T	1
20,5	3,5	41,0	1/4"	-	M 10	W 102 318	W 102 318 T	1



Taper and deburring countersinker bits 90° "short series" HSS / HSS-TiN with 1/4" hexagonal shank in steel case

7-piece set of taper and deburring countersinker bits 90° 6 taper and deburring countersinker bits Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm + 1 universal handle with 1/4" hexagon socket	W 102 319	W 102 319 T

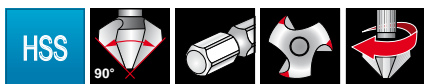


Magnetic bit holder for 1/4" hexagonal shank tools

Packing unit: in plastic tubes of 1

Magnetic bit holder	270 013	1





Taper and deburring countersinker bits 90° "long series" HSS / HSS-TiN with 1/4" hexagonal shank

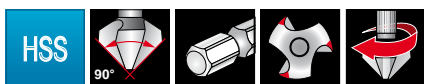
Rapid tool-changing thanks to hexagonal bit holder. Ideal for burr- and chatter-free deburring and countersinking. Applicable for steel, cast iron, non-ferrous and light metals. Best results at low cutting speeds.

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	■	
Steel (N/mm2) < 1100			□
Steel (N/mm2) < 1300			
Rust-resistant steel			□
Aluminium	■		
Brass	■	■	
Bronze	□	□	
Plastics	■	■	
Cast iron	□	□	
Titanium alloyed			



Ø2 mm	Ø1 mm	L1 mm	Ø3 inch	Countersinkings as per DIN 74				
				AF	BF			
6,3	1,5	38,0	1/4"	-	M 3	102 313	102 313 T	1
8,3	2,0	38,0	1/4"	-	M 4	102 314	102 314 T	1
10,4	2,5	41,0	1/4"	-	M 5	102 315	102 315 T	1
12,4	2,8	42,0	1/4"	-	M 6	102 316	102 316 T	1
16,5	3,2	47,0	1/4"	-	M 8	102 317	102 317 T	1
20,5	3,5	48,0	1/4"	-	M 10	102 318	102 318 T	1



Taper and deburring countersinker bits 90° "long series" HSS / HSS-TiN with 1/4" hexagonal shank in steel case

7-piece set of taper and deburring countersinker bits 90° 6 taper and deburring countersinker bits Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm + 1 universal handle with 1/4" hexagon socket	102 319	102 319 T



Taper and deburring countersinker bits 90° "long series" HSS / HSS-TiN with 1/4" hexagonal shank in plastic case

8-piece set of taper and deburring countersinker bits 90° 6 taper and deburring countersinker bits Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm + 1 universal handle with 1/4" hexagon socket + 1 cutting paste, 30 g	102 319 RO	102 319 TRO



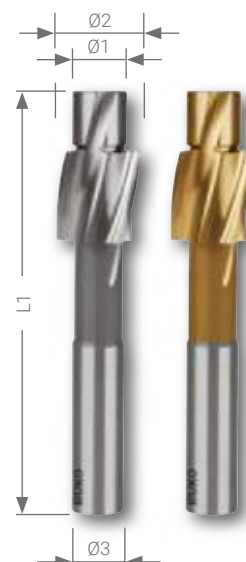


Flat countersinkers DIN 373 HSS and HSS-TiN with fixed guide

For producing countersinkings for cylinderhead screws, thread-cutting screws and thread-furrowing screws. Ideal for burr- and chatter-free deburring and countersinking. Applicable for steel, cast iron, non-ferrous and light metals. Best results at low cutting speeds.

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	■
Steel (N/mm2) < 1100		□
Steel (N/mm2) < 1300		
Rust-resistant steel		□
Aluminium	■	
Brass	■	■
Bronze	□	□
Plastics	■	■
Cast iron	□	□
Titanium alloyed		



Fine grade for through hole

For thread	Ø2 mm	Ø1 mm	Ø3 mm	L1 mm			
M 3	6,0	3,2	5,0	71,0	102 401	102 401 T	1
M 4	8,0	4,3	5,0	71,0	102 402	102 402 T	1
M 5	10,0	5,3	8,0	80,0	102 403	102 403 T	1
M 6	11,0	6,4	8,0	80,0	102 404	102 404 T	1
M 8	15,0	8,4	12,5	100,0	102 405	102 405 T	1
M 10	18,0	10,5	12,5	100,0	102 406	102 406 T	1
M 12	20,0	13,0	12,5	100,0	102 407	102 407 T	1

Medium grade for through hole

For thread	Ø2 mm	Ø1 mm	Ø3 mm	L1 mm			
M 3	6,0	3,4	5,0	71,0	102 408	102 408 T	1
M 4	8,0	4,5	5,0	71,0	102 409	102 409 T	1
M 5	10,0	5,5	8,0	80,0	102 410	102 410 T	1
M 6	11,0	6,6	8,0	80,0	102 411	102 411 T	1
M 8	15,0	9,0	12,5	100,0	102 412	102 412 T	1
M 10	18,0	11,0	12,5	100,0	102 413	102 413 T	1
M 12	20,0	13,5	12,5	100,0	102 414	102 414 T	1

For thread core hole

For thread	Ø2 mm	Ø1 mm	Ø3 mm	L1 mm			
M 3	6,0	2,5	5,0	71,0	102 415	102 415 T	1
M 4	8,0	3,3	5,0	71,0	102 416	102 416 T	1
M 5	10,0	4,2	8,0	80,0	102 417	102 417 T	1
M 6	11,0	5,0	8,0	80,0	102 418	102 418 T	1
M 8	15,0	6,8	12,5	100,0	102 419	102 419 T	1
M 10	18,0	8,5	12,5	100,0	102 420	102 420 T	1
M 12	20,0	10,2	12,5	100,0	102 421	102 421 T	1

Flat countersinker sets DIN 373 HSS and HSS-TiN with straight shank and fixed pilot in steel case

	HSS	HSS TiN
6-piece set of flat countersinkers for through holes, fine grade, for threads: M 3 - M 4 - M 5 - M 6 - M 8 - M 10	102 450	102 450 T
6-piece set of flat countersinkers for through holes, medium grade, for threads: M 3 - M 4 - M 5 - M 6 - M 8 - M 10	102 451	102 451 T
6-piece set of flat countersinkers for core holes, for threads: M 3 - M 4 - M 5 - M 6 - M 8 - M 10	102 452	102 452 T



Flat countersinker sets DIN 373 HSS and HSS-TiN with straight shank and fixed pilot in plastic case

	HSS	HSS TiN
6-piece set of flat countersinkers for through holes, fine grade, for threads: M 3 - M 4 - M 5 - M 6 - M 8 - M 10	102 450 RO	102 450 TRO
6-piece set of flat countersinkers for through holes, medium grade, for threads: M 3 - M 4 - M 5 - M 6 - M 8 - M 10	102 451 RO	102 451 TRO
6-piece set of flat countersinkers for core holes, for threads: M 3 - M 4 - M 5 - M 6 - M 8 - M 10	102 452 RO	102 452 TRO





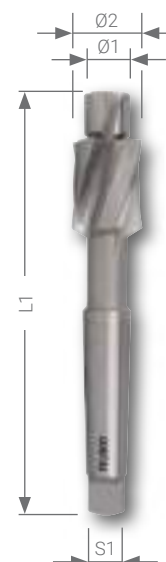
Flat countersinkers HSS with fixed guide

For producing countersinkings for cylinderhead screws, thread-cutting screws and thread-furrowing screws. Ideal for burr- and chatter-free deburring and countersinking.

Applicable for steel, cast iron, non-ferrous and light metals. Best results at low cutting speeds.

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	



Fine grade for through hole

For thread	Ø2 mm	Ø1 mm	Shank S1	L1 mm	HSS		
M 10	18,0	10,5	MT 2	150,0	102 422		1
M 12	20,0	13,0	MT 2	150,0	102 423		1
M 14	24,0	15,0	MT 2	160,0	102 424		1
M 16	26,0	17,0	MT 3	190,0	102 425		1
M 18	30,0	19,0	MT 3	190,0	102 426		1
M 20	33,0	21,0	MT 3	190,0	102 427		1
M 22	36,0	23,0	MT 3	205,0	102 428		1

Medium grade for through hole

For thread	Ø2 mm	Ø1 mm	Shank S1	L1 mm	HSS		
M 10	18,0	11,0	MT 2	150,0	102 429		1
M 12	20,0	13,5	MT 2	150,0	102 430		1
M 14	24,0	15,5	MT 2	160,0	102 431		1
M 16	26,0	17,5	MT 3	190,0	102 432		1
M 18	30,0	20,0	MT 3	190,0	102 433		1
M 20	33,0	22,0	MT 3	190,0	102 434		1
M 22	36,0	24,0	MT 3	205,0	102 435		1

For thread core hole

For thread	Ø2 mm	Ø1 mm	Shank S1	L1 mm	HSS		
M 10	18,0	8,5	MT 2	150,0	102 436		1
M 12	20,0	10,2	MT 2	150,0	102 437		1
M 14	24,0	12,0	MT 2	160,0	102 438		1
M 16	26,0	14,0	MT 3	190,0	102 439		1
M 18	30,0	15,5	MT 3	190,0	102 440		1
M 20	33,0	17,5	MT 3	190,0	102 441		1
M 22	36,0	19,5	MT 3	205,0	102 442		1



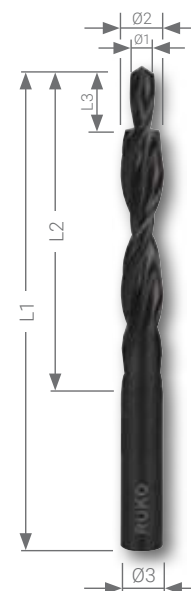


Subland drills long type N HSS

Enables drilling and sinking combined in one step. Application: adjust the cutting speed according to the big diameter and the feed rate according to the small diameter.




Packing unit: in plastic tubes of 1

Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100		Bronze	□
Steel (N/mm ²) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	



90° fine grade for through hole




For efficient drilling of through holes and screw head counterborings with 90° angle.

For thread	Ø1 mm	Ø2 / Ø3 mm	L3 mm	L2 mm	L1 mm	 	
M 3	3,2	6,0	9,0	57,0	93,0	102 601	1
M 4	4,3	8,0	11,0	75,0	117,0	102 602	1
M 5	5,3	10,0	13,0	87,0	133,0	102 603	1
M 6	6,4	11,5	15,0	94,0	142,0	102 604	1
M 8	8,4	15,0	19,0	114,0	169,0	102 605	1
M 10	10,5	19,0	23,0	135,0	198,0	102 606	1



180° medium grade for through hole




For efficient drilling of through holes and screw head counterborings with 180° angle.

For thread	Ø1 mm	Ø2 / Ø3 mm	L3 mm	L2 mm	L1 mm			
M 3	3,4	6,0	9,0	57,0	93,0	102 607		1
M 4	4,5	8,0	11,0	75,0	117,0	102 608		1
M 5	5,5	10,0	13,0	87,0	133,0	102 609		1
M 6	6,6	11,0	15,0	94,0	142,0	102 610		1
M 8	9,0	15,0	19,0	114,0	169,0	102 611		1
M 10	11,0	18,0	23,0	130,0	191,0	102 612		1



90° for thread core hole

For efficient drilling of tapping holes and countersinkings with 90° angle.

For thread	Ø1 mm	Ø2 / Ø3 mm	L3 mm	L2 mm	L1 mm	 	
M 3	2,5	3,4	8,8	39,0	70,0	102 613	1
M 4	3,3	4,5	11,4	47,0	80,0	102 614	1
M 5	4,2	5,5	13,6	57,0	93,0	102 615	1
M 6	5,0	6,6	16,5	63,0	101,0	102 616	1
M 8	6,8	9,0	21,0	81,0	125,0	102 617	1
M 10	8,5	11,0	25,5	94,0	142,0	102 618	1
M 12	10,2	13,5	30,0	108,0	160,0	102 619	1



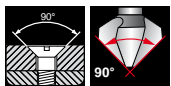
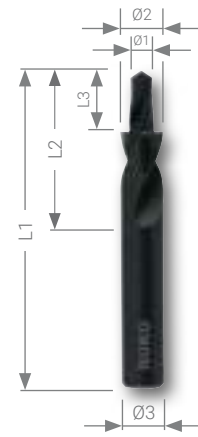
Subland drills short type N HSS

Short and torsion stable drill, suitable for the use on CNC or NC machines.

The drilling and countersinking is made in one step. Application: adjust the cutting speed according to the big diameter and the feed rate according to the small diameter.

Packing unit: in plastic tubes of 1

Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100		Bronze	□
Steel (N/mm ²) < 1300		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	



90° fine grade for through hole

For efficient drilling of through holes and screw head counterborings with 90° angle.

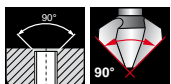
For thread	Ø1 mm	Ø2 / Ø3 mm	L3 mm	L2 mm	L1 mm	HSS		
M 3	3,2	6,0	9,0	28,0	66,0	102 620		1
M 4	4,3	8,0	11,0	37,0	79,0	102 621		1
M 5	5,3	10,0	13,0	43,0	89,0	102 622		1
M 6	6,4	11,5	15,0	47,0	95,0	102 623		1
M 8	8,4	15,0	19,0	56,0	111,0	102 624		1
M 10	10,5	19,0	23,0	64,0	127,0	102 625		1



180° medium grade for through hole

For efficient drilling of through holes and screw head counterborings with 180° angle.

For thread	Ø1 mm	Ø2 / Ø3 mm	L3 mm	L2 mm	L1 mm	HSS		
M 3	3,4	6,0	9,0	28,0	66,0	102 626		1
M 4	4,5	8,0	11,0	37,0	79,0	102 627		1
M 5	5,5	10,0	13,0	43,0	89,0	102 628		1
M 6	6,6	11,0	15,0	47,0	95,0	102 629		1
M 8	9,0	15,0	19,0	56,0	111,0	102 630		1
M 10	11,0	18,0	23,0	62,0	123,0	102 631		1



90° for thread core hole

For efficient drilling of tapping holes and countersinkings with 90° angle.

For thread	Ø1 mm	Ø2 / Ø3 mm	L3 mm	L2 mm	L1 mm	HSS		
M 3	2,5	3,4	8,8	20,0	52,0	102 632		1
M 4	3,3	4,5	11,4	24,0	58,0	102 633		1
M 5	4,2	5,5	13,6	28,0	66,0	102 634		1
M 6	5,0	6,6	16,5	31,0	70,0	102 635		1
M 8	6,8	9,0	21,0	40,0	84,0	102 636		1
M 10	8,5	11,0	25,5	47,0	95,0	102 637		1
M 12	10,2	13,5	30,0	54,0	107,0	102 638		1

Table of recommended cutting speeds for taper and deburring countersinkers

Material:	High carbon struc. steel up to 700 N/mm ²	High carbon struc. steel up to 700 N/mm ²	Alloyed steel up to 1000 N/mm ²	Cast iron up to 250 N/mm ²	Cast iron over 250 N/mm ²	CuZn alloy brittle	CuZn alloy tough	Aluminium alloy up to 11% Si	Thermo- plastics	Duro- plastics
Vc = m/min	20	15	10	10	8	40	20	20	15	10
Cooling lubricant	Cutting spray	Cutting spray	Cutting spray	Compressed air	Compressed air	Compressed air	Compressed air	Cutting spray	Water	Compressed air
Ø mm	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.
4,3	1481	1111	741	741	593	2963	1481	1481	1111	741
5,0	1274	955	637	637	510	2548	1274	1274	955	637
5,3	1202	901	601	601	481	2404	1202	1202	901	601
5,8	1098	824	549	549	439	2196	1098	1098	824	549
6,0	1062	796	531	531	425	2123	1062	1062	796	531
6,3	1011	758	506	506	404	2022	1011	1011	758	506
7,0	910	682	455	455	364	1820	910	910	682	455
7,3	873	654	436	436	349	1745	873	873	654	436
8,0	796	597	398	398	318	1592	796	796	597	398
8,3	767	576	384	384	307	1535	767	767	576	384
9,4	678	508	339	339	271	1355	678	678	508	339
10,0	637	478	318	318	255	1274	637	637	478	318
10,4	612	459	306	306	245	1225	612	612	459	306
11,5	554	415	277	277	222	1108	554	554	415	277
12,0	531	398	265	265	212	1062	531	531	398	265
12,4	514	385	257	257	205	1027	514	514	385	257
12,5	510	382	255	255	204	1019	510	510	382	255
13,4	475	356	238	238	190	951	475	475	356	238
15,0	425	318	212	212	170	849	425	425	318	212
16,0	398	299	199	199	159	796	398	398	299	199
16,5	386	290	193	193	154	772	386	386	290	193
19,0	335	251	168	168	134	670	335	335	251	168
20,0	318	239	159	159	127	637	318	318	239	159
20,5	311	233	155	155	124	621	311	311	233	155
23,0	277	208	138	138	111	554	277	277	208	138
25,0	255	191	127	127	102	510	255	255	191	127
26,0	245	184	122	122	98	490	245	245	184	122
28,0	227	171	114	114	91	455	227	227	171	114
30,0	212	159	106	106	85	425	212	212	159	106
31,0	205	154	103	103	82	411	205	205	154	103
31,5	202	152	101	101	81	404	202	202	152	101
34,0	187	141	94	94	75	375	187	187	141	94
37,0	172	129	86	86	69	344	172	172	129	86
40,0	159	119	80	80	64	318	159	159	119	80
50,0	127	96	64	64	51	255	127	127	96	64
63,0	101	76	51	51	40	202	101	101	76	51
80,0	80	60	40	40	32	159	80	80	60	40

Countersinkings as per DIN 74 for countersunk screws as per DIN

as per DIN 74	
type AF	type BF
DIN 963 / DIN 964 DIN 965 / DIN 966 DIN 7513 F. u. G. DIN 7516 D. u. E.	DIN 7991 (ISO 10642)



Table of recommended cutting speeds for Solid TC countersinkers

Material:	High carbon struc. steel up to 700 N/mm ²		High carbon struc. steel up to 700 N/mm ²		Alloyed steel up to 1200 N/mm ²		Cast iron up to 250 N/mm ²		Cast iron over 250 N/mm ²		CuZn alloy brittle		CuZn alloy tough		Aluminium alloy up to 11% Si		Thermo-plastics		Duro-plastics	
Vc = m/min	15		12		8		12		10		25		15		20		20		10	
Ø mm	r.p.m.	f	r.p.m.	f	r.p.m.	f	r.p.m.	f	r.p.m.	f	r.p.m.	f	r.p.m.	f	r.p.m.	f	r.p.m.	f	r.p.m.	f
6,3	758	0,10	606	0,10	404	0,10	606	0,15	505	0,15	1263	0,13	758	0,13	1011	0,13	1011	0,13	505	0,13
8,3	575	0,15	460	0,15	307	0,15	460	0,20	384	0,20	959	0,16	575	0,16	767	0,16	767	0,18	384	0,18
10,4	459	0,15	367	0,15	245	0,15	367	0,20	306	0,20	765	0,16	459	0,16	612	0,16	612	0,20	306	0,20
12,4	385	0,20	308	0,20	205	0,20	308	0,25	257	0,25	642	0,20	385	0,20	513	0,20	513	0,20	257	0,20
16,5	289	0,20	231	0,20	154	0,20	231	0,25	193	0,25	482	0,22	289	0,22	386	0,22	386	0,25	193	0,25
20,5	233	0,25	186	0,25	124	0,25	186	0,30	155	0,30	388	0,25	233	0,25	311	0,25	311	0,25	155	0,25
25,0	191	0,30	153	0,30	102	0,30	153	0,30	127	0,30	318	0,25	191	0,25	255	0,25	255	0,30	127	0,30
31,0	154	0,35	123	0,35	82	0,35	123	0,35	103	0,35	257	0,30	154	0,30	205	0,30	205	0,35	103	0,35

f in mm/rev = feed per revolution

Countersinkings as per DIN 74, Sheet 2

Countersinkings, type H

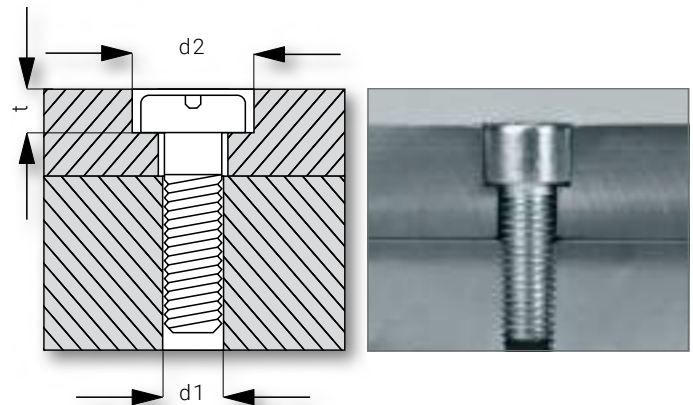
for cylinder-head screws as per DIN 84 and DIN 7984
for thread-cutting screws as per DIN 7513, Type B
for thread-furrowing screws as per DIN 7500, Type B

Countersinkings, type J

for cylinder-head screws as per DIN 6912

Countersinkings, type K

for cylinder-head screws as per DIN 912



For thread	d1 fine H 12 mm	d1 medium H 13 mm	d1 core hole mm	d2 H 13 mm	t type H mm	t type J mm	t type K mm	Tolerance for t mm
M 3	3,2	3,4	2,5	6,0	2,4	—	3,4	0 + 0,1
M 4	4,3	4,5	3,3	8,0	3,2	3,4	4,6	0 + 0,4
M 5	5,3	5,5	4,2	10,0	4,0	4,2	5,7	0 + 0,4
M 6	6,4	6,6	5,0	11,0	4,7	4,8	6,8	0 + 0,4
M 8	8,4	9,0	6,8	15,0	6,0	6,0	6,0	0 + 0,4
M 10	10,5	11,0	8,5	18,0	7,0	7,5	11,0	0 + 0,4
M 12	13,0	13,5	10,2	20,0	8,0	8,5	13,0	0 + 0,4
M 14	15,0	15,5	12,0	24,0	9,0	9,5	15,0	0 + 0,4
M 16	17,0	17,5	14,0	26,0	10,5	11,5	17,5	0 + 0,4
M 18	19,0	20,0	15,5	30,0	11,5	12,5	19,5	0 + 0,4
M 20	21,0	22,0	17,5	33,0	12,5	13,5	21,5	0 + 0,4
M 22	23,0	24,0	19,5	36,0	13,5	14,5	23,5	0 + 0,4

Type A for:

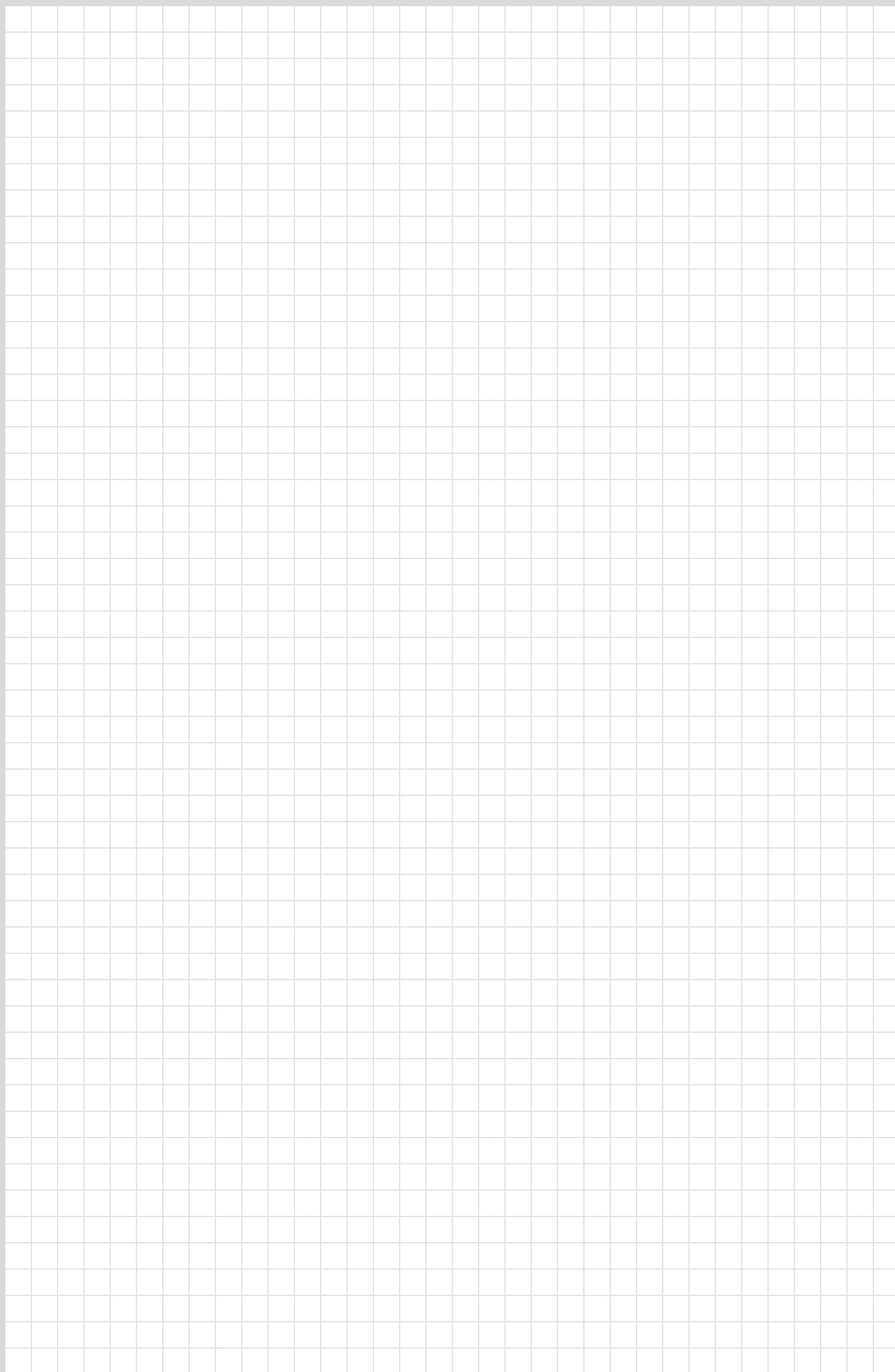
- countersunk screws as per DIN 963 and DIN 965,
- raised countersunk head screws as per DIN 964 and DIN 966,
- thread forming screws type F and G as per DIN 7513 and type D and E as per DIN 7516,
- countersunk tapping screws type K, L, M and N as per DIN 7500,
- wood screws as per DIN 97 and DIN 7997
- oval head wood screws as per DIN 95 DIN 7997

Type B for:

countersunk screws with hexagon socket DIN 7991



05





THREAD CUTTING TOOLS

FASCINATION  PRECISION®











Range and applications overview:



Material	Surface	DIN	Shape	Left hand cutting / right hand cutting	Thread	Tenacity classes	Nominal thread size	Article no.	Page
HSS		DIN 352			M	800 N/mm²	M 2 - M 52	230 020 - 230 520	142
HSS		DIN 352			M	800 N/mm²	M 3 - M 20	230 030 Li - 230 200 Li	142
HSSE Co 5		DIN 352			M	1000 N/mm²	M 2 - M 24	230 020 E - 230 240 E	142
HSS		DIN 2181			MF	800 N/mm²	MF 3 - MF 52	235 030 - 235 520	144
HSS		DIN 5157			G (BSP)	800 N/mm²	G 1/8 - G 2"	236 018 - 236 020	146
HSS		DIN 352			Ww (BSW)	800 N/mm²	1/16 - 2"	246 116 - 246 020	147
HSS		DIN 352			UNC	800 N/mm²	Nr. 2 - 2"	246 020 UNC - 246 200 UNC	148
HSS		DIN 352			UNF	800 N/mm²	Nr. 2 - 1 1/2"	246 020 UNF - 246 112 UNF	149
HSS		DIN 352	B		M	800 N/mm²	M 3 - M 12	231 030 - 231 120	152
HSSE Co 5		DIN 352	B		M	1000 N/mm²	M 3 - M 12	231 030 E - 231 120 E	152
HSS			C		NPT	800 N/mm²	1/16 - 2"	231 116 NPT - 231 020 NPT	153
HSS		DIN 5157	B		G (BSP)	800 N/mm²	G 1/8 - G 1"	236 210 - 236 238	154



HSS		DIN 22568	B		M	800 N/mm²	M 2 - M 52	237 020 - 237 520	143
HSS		DIN 22568	B		M	800 N/mm²	M 3 - M 12	238 030 - 238 120	143
HSS		DIN 22568	B		M	800 N/mm²	M 3 - M 20	237 030 Li - 230 200 Li	143
HSSE Co 5		DIN 22568	B		M	1000 N/mm²	M 2 - M 24	237 020 E - 237 240 E	143
HSS		DIN 22568	B		MF	800 N/mm²	MF 3 - MF 52	239 030 - 239 520	145
HSS		DIN 24231	B		G (BSP)	800 N/mm²	G 1/8 - G 2"	240 018 - 240 020	146
HSS		DIN 22568	B		Ww (BSW)	800 N/mm²	1/16 - 2"	247 116 - 247 020	147
HSS		DIN 22568	B		UNC	800 N/mm²	Nr. 2 - 2"	240 020 UNC - 240 112 UNC	148
HSS		DIN 22568	B		UNF	800 N/mm²	Nr. 2 - 1 1/2"	240 020 UNF - 240 112 UNF	149
HSS		DIN 382			M	800 N/mm²	M 3 - M 30	267 030 - 267 300	153
HSS		DIN 382	B		G (BSP)	800 N/mm²	G 1/8 - G 1"	267 610 - 267 638	154

Steel (N/mm ²) < 800 	Steel (N/mm ²) < 1000 	Steel (N/mm ²) < 1200 	Stainless steel 	Aluminium 	Brass 	Bronze 	Plastics 	Cast iron 	Titanium alloyed 
■				■	■	□	■	□	
■				■	■	□	■	□	
■	■		■	■	■	■	■	□	
■				■	■	□	■	□	
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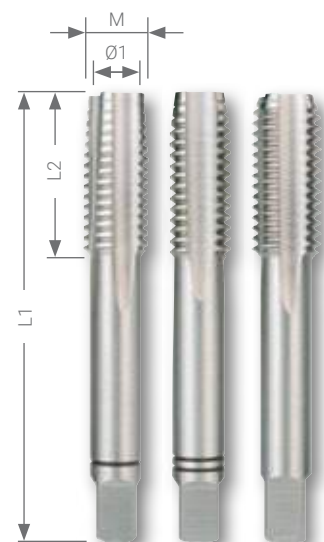
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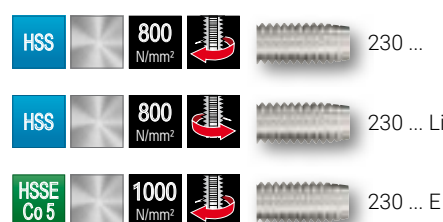
Hand taps M DIN 352 HSS, HSS-left-handed thread and HSSE-Co 5 ground

Set: 3-piece
 Taper tap: 6 - 8-thread chamfer
 Second tap: 4 - 5-thread chamfer
 Final tap: 2 - 3-thread chamfer
 Thread: metric, DIN ISO 13
 Flanks: relief-ground

Also available individually
 Taper tap: Article no. 230-1
 Second tap: Article no. 230-2
 Final tap: Article no. 230-3



Packing unit: set in plastic pack



Steel (N/mm ²) < 800	■	■	■
Steel (N/mm ²) < 1000			■
Rust-resistant steel			■
Aluminium	■	■	■

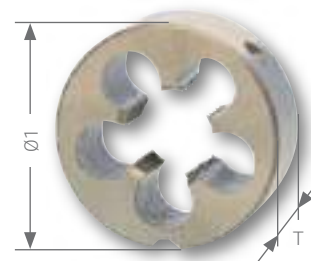
Brass	■	■	■
Bronze	□	□	■
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			

Nominal thread size M	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm				
M 2	0,40	1,60	36,0	8,0	230 020	—	230 020 E	1
M 2,5	0,45	2,10	40,0	8,0	230 025	—	—	1
M 3	0,50	2,50	40,0	10,0	230 030	230 030 Li	230 030 E	1
M 3,5	0,60	2,90	45,0	12,0	230 035	—	—	1
M 4	0,70	3,30	45,0	12,0	230 040	230 040 Li	230 040 E	1
M 4,5	0,75	3,70	50,0	16,0	230 045	—	—	1
M 5	0,80	4,20	50,0	13,0	230 050	230 050 Li	230 050 E	1
M 6	1,00	5,00	56,0	15,0	230 060	230 060 Li	230 060 E	1
M 7	1,00	6,00	56,0	16,0	230 070	—	—	1
M 8	1,25	6,80	56,0	18,0	230 080	230 080 Li	230 080 E	1
M 9	1,25	7,80	63,0	22,0	230 090	—	—	1
M 10	1,50	8,50	70,0	24,0	230 100	230 100 Li	230 100 E	1
M 11	1,50	9,50	70,0	24,0	230 110	—	—	1
M 12	1,75	10,20	75,0	29,0	230 120	230 120 Li	230 120 E	1
M 14	2,00	12,00	80,0	30,0	230 140	230 140 Li	230 140 E	1
M 15	2,00	13,00	80,0	32,0	230 150	—	—	1
M 16	2,00	14,00	80,0	32,0	230 160	230 160 Li	230 160 E	1
M 18	2,50	15,50	95,0	40,0	230 180	230 180 Li	230 180 E	1
M 20	2,50	17,50	95,0	40,0	230 200	230 200 Li	230 200 E	1
M 22	2,50	19,50	100,0	40,0	230 220	—	230 220 E	1
M 24	3,00	21,00	110,0	45,0	230 240	—	230 240 E	1
M 27	3,00	24,00	110,0	50,0	230 270	—	—	1
M 30	3,50	26,50	125,0	56,0	230 300	—	—	1
M 33	3,50	29,50	125,0	56,0	230 330	—	—	1
M 36	4,00	32,00	150,0	63,0	230 360	—	—	1
M 39	4,00	35,00	150,0	63,0	230 390	—	—	1
M 42	4,50	37,50	150,0	63,0	230 420	—	—	1
M 45	4,50	40,50	160,0	70,0	230 450	—	—	1
M 48	5,00	43,00	180,0	75,0	230 480	—	—	1
M 52	5,00	47,00	180,0	75,0	230 520	—	—	1



Round dies M DIN EN 22568 HSS, HSS-left-handed thread and HSSE-Co 5 ground

Type: Type B closed – solid die
Thread: metric, DIN ISO 13



Packing unit: in plastic tubes of 1

HSS	800 N/mm ²	237 ... 238 ...
HSS	800 N/mm ²	237 ... Li
HSSE Co 5	1000 N/mm ²	237 ... E

Steel (N/mm ²) < 800	■	■	■
Steel (N/mm ²) < 1000			■
Rust-resistant steel			■
Aluminium	■	■	■

Brass	■	■	■
Bronze	□	□	■
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			

Nominal thread size M	Pitch mm	Outside Ø1 mm	Thickness T mm	HSS	HSS	HSS	HSSE Co 5	
M 2	0,40	16,0	5,0	237 020	—	—	237 020 E	1
M 2,5	0,45	16,0	5,0	237 025	—	—	—	1
M 3	0,50	20,0	5,0	237 030	—	237 030 Li	237 030 E	1
M 3	0,50	25,0	9,0	—	238 030	—	—	1
M 3,5	0,60	20,0	5,0	237 035	—	—	—	1
M 4	0,70	20,0	5,0	237 040	—	237 040 Li	237 040 E	1
M 4	0,70	25,0	9,0	—	238 040	—	—	1
M 4,5	0,75	20,0	7,0	237 045	—	—	—	1
M 5	0,80	20,0	7,0	237 050	—	237 050 Li	237 050 E	1
M 5	0,80	25,0	9,0	—	238 050	—	—	1
M 6	1,00	20,0	7,0	237 060	—	237 060 Li	237 060 E	1
M 6	1,00	25,0	9,0	—	238 060	—	—	1
M 7	1,00	25,0	9,0	237 070	—	237 070 Li	—	1
M 8	1,25	25,0	9,0	237 080	238 080	237 080 Li	237 080 E	1
M 9	1,25	25,0	9,0	237 090	—	—	—	1
M 10	1,50	30,0	11,0	237 100	—	237 100 Li	237 100 E	1
M 10	1,50	25,0	9,0	—	238 100	—	—	1
M 11	1,50	30,0	11,0	237 110	—	—	—	1
M 12	1,75	38,0	14,0	237 120	—	237 120 Li	237 120 E	1
M 12	1,75	25,0	9,0	—	238 120	—	—	1
M 14	2,00	38,0	14,0	237 140	—	237 140 Li	237 140 E	1
M 16	2,00	45,0	18,0	237 160	—	237 160 Li	237 160 E	1
M 18	2,50	45,0	18,0	237 180	—	237 180 Li	237 180 E	1
M 20	2,50	45,0	18,0	237 200	—	237 200 Li	237 200 E	1
M 22	2,50	55,0	22,0	237 220	—	—	237 220 E	1
M 24	3,00	55,0	22,0	237 240	—	—	237 240 E	1
M 27	3,00	65,0	25,0	237 270	—	—	—	1
M 30	3,50	65,0	25,0	237 300	—	—	—	1
M 33	3,50	65,0	25,0	237 330	—	—	—	1
M 36	4,00	65,0	25,0	237 360	—	—	—	1
M 39	4,00	75,0	30,0	237 390	—	—	—	1
M 42	4,50	75,0	30,0	237 420	—	—	—	1
M 45	4,50	90,0	36,0	237 450	—	—	—	1
M 48	5,00	90,0	36,0	237 480	—	—	—	1
M 52	5,00	90,0	36,0	237 520	—	—	—	1

Hand taps MF DIN 2181 HSS, ground

Set: 2-piece
 Taper tap: 5 - 6-thread chamfer
 Final tap: 2 - 3-thread chamfer
 Thread: metric, fine, DIN ISO 13
 Flanks: relief-ground



After two rotations of the drill turn back 1/3 rotation to break the chip.
 Thus the strain on the screw tap decreases.
 Lubrication with RUKO cutting oil is recommended.

Packing unit: set in plastic pack

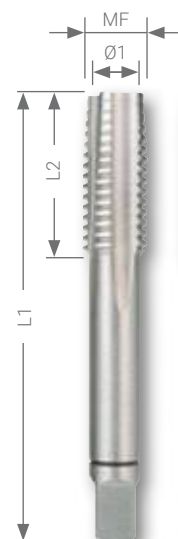
Steel (N/mm2) < 800	■
Steel (N/mm2) < 1000	
Rust-resistant steel	
Aluminium	■

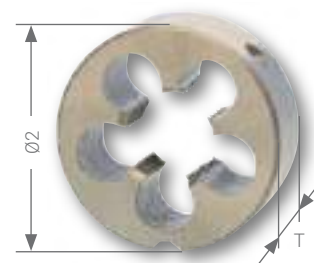
Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Also available individually
 Taper tap: Article no. 235-1
 Final tap: Article no. 235-2

Nominal thread size MF	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
MF 3	0,35	2,60	40,0	10,0	235 030	1
MF 4	0,35	3,10	45,0	10,0	235 040	1
MF 4	0,50	3,50	45,0	12,0	235 041	1
MF 5	0,50	4,50	50,0	13,0	235 050	1
MF 5	0,75	4,25	50,0	13,0	235 051	1
MF 6	0,50	5,50	50,0	14,0	235 061	1
MF 6	0,75	5,20	50,0	15,0	235 060	1
MF 7	0,75	6,20	50,0	14,0	235 070	1
MF 8	0,50	7,50	50,0	19,0	235 082	1
MF 8	0,75	7,20	56,0	18,0	235 080	1
MF 8	1,00	7,00	56,0	18,0	235 081	1
MF 9	0,75	8,20	56,0	19,0	235 092	1
MF 9	1,00	8,00	63,0	20,0	235 090	1
MF 10	0,75	9,20	63,0	20,0	235 102	1
MF 10	1,00	9,00	63,0	18,0	235 100	1
MF 10	1,25	8,70	70,0	24,0	235 101	1
MF 11	1,00	9,20	63,0	20,0	235 110	1
MF 11	1,25	9,80	63,0	22,0	235 111	1
MF 12	1,00	11,00	70,0	20,0	235 122	1
MF 12	1,25	10,70	70,0	20,0	235 121	1
MF 12	1,50	10,50	70,0	20,0	235 120	1
MF 13	1,00	12,00	70,0	22,0	235 130	1
MF 13	1,50	11,50	70,0	22,0	235 131	1
MF 14	1,00	13,00	70,0	20,0	235 142	1
MF 14	1,25	12,70	70,0	20,0	235 140	1
MF 14	1,50	12,50	70,0	20,0	235 141	1
MF 15	1,50	13,50	70,0	22,0	235 150	1
MF 16	1,00	15,00	70,0	20,0	235 161	1
MF 16	1,25	14,75	70,0	20,0	235 162	1
MF 16	1,50	14,50	70,0	20,0	235 160	1
MF 18	1,00	17,00	80,0	22,0	235 181	1
MF 18	1,25	16,80	80,0	22,0	235 183	1

Nominal thread size MF	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
MF 18	1,50	16,50	80,0	22,0	235 180	1
MF 18	2,00	16,00	80,0	22,0	235 182	1
MF 20	1,00	19,00	80,0	22,0	235 201	1
MF 20	1,25	18,80	80,0	22,0	235 203	1
MF 20	1,50	18,50	80,0	22,0	235 200	1
MF 20	2,00	18,00	80,0	22,0	235 202	1
MF 22	1,00	21,00	80,0	22,0	235 221	1
MF 22	1,50	20,50	80,0	22,0	235 220	1
MF 22	2,00	20,00	80,0	22,0	235 222	1
MF 24	1,00	23,00	90,0	22,0	235 242	1
MF 24	1,50	22,50	90,0	22,0	235 240	1
MF 24	2,00	22,00	90,0	22,0	235 241	1
MF 25	1,50	23,50	90,0	22,0	235 250	1
MF 26	1,50	24,50	90,0	22,0	235 261	1
MF 26	2,00	24,00	90,0	22,0	235 260	1
MF 27	1,50	25,50	90,0	22,0	235 270	1
MF 27	2,00	25,00	90,0	22,0	235 271	1
MF 28	1,50	26,50	90,0	22,0	235 280	1
MF 28	2,00	26,00	90,0	22,0	235 281	1
MF 30	1,00	29,00	90,0	22,0	235 300	1
MF 30	1,50	28,50	90,0	22,0	235 301	1
MF 30	2,00	28,00	90,0	22,0	235 302	1
MF 32	1,50	30,50	90,0	22,0	235 320	1
MF 35	1,50	33,50	100,0	25,0	235 350	1
MF 38	1,50	36,50	110,0	25,0	235 380	1
MF 40	1,50	38,50	110,0	25,0	235 400	1
MF 42	1,50	40,50	110,0	25,0	235 420	1
MF 45	1,50	43,50	110,0	25,0	235 450	1
MF 48	1,50	46,50	125,0	40,0	235 480	1
MF 50	1,50	48,50	125,0	40,0	235 500	1
MF 52	1,50	50,50	125,0	40,0	235 520	1





Round dies MF DIN EN 22568 HSS, ground

Type: Type B closed – solid die

Thread: metric fine, DIN ISO 13



It is recommended that the threading dies are turned back briefly now and then so that the chips break and do not clog the threads. Lubrication with RUKO cutting oil is recommended.

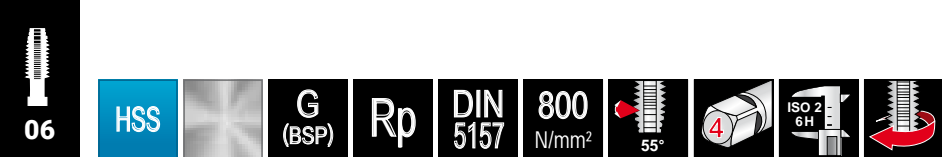
Packing unit: in plastic tubes of 1

Steel (N/mm²) < 800	■
Steel (N/mm²) < 1000	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Nominal thread size MF	Pitch mm	Outside Ø2 mm	Thickness T mm	HSS	
MF 3	0,35	20,0	5,0	239 030	1
MF 4	0,35	20,0	5,0	239 040	1
MF 4	0,50	20,0	5,0	239 041	1
MF 5	0,50	20,0	5,0	239 050	1
MF 5	0,75	20,0	7,0	239 051	1
MF 6	0,50	20,0	5,0	239 061	1
MF 6	0,75	20,0	7,0	239 060	1
MF 7	0,75	25,0	9,0	239 070	1
MF 8	0,50	25,0	9,0	239 082	1
MF 8	0,75	25,0	9,0	239 080	1
MF 8	1,00	25,0	9,0	239 081	1
MF 9	0,75	25,0	9,0	239 090	1
MF 9	1,00	25,0	9,0	239 091	1
MF 10	0,75	30,0	11,0	239 102	1
MF 10	1,00	30,0	11,0	239 100	1
MF 10	1,25	30,0	11,0	239 101	1
MF 11	1,00	30,0	11,0	239 110	1
MF 11	1,25	30,0	11,0	239 111	1
MF 12	1,00	38,0	10,0	239 121	1
MF 12	1,25	38,0	10,0	239 122	1
MF 12	1,50	38,0	10,0	239 120	1
MF 13	1,00	38,0	10,0	239 131	1
MF 13	1,50	38,0	10,0	239 130	1
MF 14	1,00	38,0	10,0	239 142	1
MF 14	1,25	38,0	10,0	239 140	1
MF 14	1,50	38,0	10,0	239 141	1
MF 15	1,50	38,0	10,0	239 150	1
MF 16	1,00	45,0	14,0	239 161	1
MF 16	1,25	45,0	14,0	239 162	1
MF 16	1,50	45,0	14,0	239 160	1
MF 18	1,00	45,0	14,0	239 181	1
MF 18	1,25	45,0	14,0	239 183	1

Nominal thread size MF	Pitch mm	Outside Ø2 mm	Thickness T mm	HSS	
MF 18	1,50	45,0	14,0	239 180	1
MF 18	2,00	45,0	14,0	239 182	1
MF 20	1,00	45,0	14,0	239 201	1
MF 20	1,25	45,0	14,0	239 203	1
MF 20	1,50	45,0	14,0	239 200	1
MF 20	2,00	45,0	14,0	239 202	1
MF 22	1,00	55,0	16,0	239 221	1
MF 22	1,50	55,0	16,0	239 220	1
MF 22	2,00	55,0	16,0	239 222	1
MF 24	1,00	55,0	16,0	239 242	1
MF 24	1,50	55,0	16,0	239 240	1
MF 24	2,00	55,0	16,0	239 241	1
MF 25	1,50	55,0	16,0	239 250	1
MF 26	1,50	55,0	16,0	239 261	1
MF 26	2,00	55,0	16,0	239 262	1
MF 27	1,50	65,0	18,0	239 270	1
MF 27	2,00	65,0	18,0	239 271	1
MF 28	1,50	65,0	18,0	239 281	1
MF 28	2,00	65,0	18,0	239 282	1
MF 30	1,00	65,0	18,0	239 300	1
MF 30	1,50	65,0	18,0	239 301	1
MF 30	2,00	65,0	18,0	239 302	1
MF 32	1,50	65,0	18,0	239 320	1
MF 35	1,50	65,0	18,0	239 350	1
MF 38	1,50	75,0	20,0	239 380	1
MF 40	1,50	75,0	20,0	239 400	1
MF 42	1,50	75,0	20,0	239 420	1
MF 45	1,50	90,0	22,0	239 450	1
MF 48	1,50	90,0	22,0	239 480	1
MF 50	1,50	90,0	22,0	239 500	1
MF 52	1,50	90,0	22,0	239 520	1

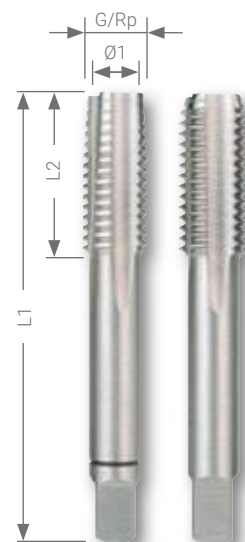


Hand taps G DIN 5157 HSS, ground

Set: 2-piece
 Taper tap: 5 - 6-thread chamfer
 Final tap: 2 - 3-thread chamfer
 Thread: DIN ISO 228 "G" (cylindrical pipe thread)
 DIN 9999 "Rp" (Whitworth pipe thread)
 Flanks: relief-ground

Packing unit: set in plastic pack

Steel (N/mm²) < 800	■	Brass	■
Steel (N/mm²) < 1000		Bronze	□
		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	



Also available individually
 Taper tap: Article no. 236-1
 Final tap: Article no. 236-2

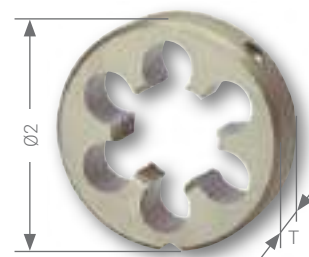
Nominal thread size G / Rp		Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
G 1/8	Rp 1/8	28	8,80	63,0	18,0	236 018	1
G 1/4	Rp 1/4	19	11,80	70,0	20,0	236 014	1
G 3/8	Rp 3/8	19	15,25	70,0	20,0	236 038	1
G 1/2	Rp 1/2	14	19,00	80,0	22,0	236 012	1
G 5/8	Rp 5/8	14	21,00	80,0	22,0	236 058	1
G 3/4	Rp 3/4	14	24,50	90,0	22,0	236 034	1
G 7/8	Rp 7/8	14	28,25	90,0	22,0	236 078	1
G 1"	Rp 1"	11	30,75	100,0	25,0	236 010	1
G 1 1/8	Rp 1 1/8	11	35,30	125,0	40,0	236 118	1
G 1 1/4	Rp 1 1/4	11	39,25	125,0	40,0	236 114	1
G 1 3/8	Rp 1 3/8	11	41,70	140,0	40,0	236 138	1
G 1 1/2	Rp 1 1/2	11	45,25	140,0	40,0	236 112	1
G 1 3/4	Rp 1 3/4	11	51,10	140,0	40,0	236 134	1
G 2"	Rp 2"	11	57,00	160,0	40,0	236 020	1



Round dies G DIN EN 24231 HSS, ground

Type: Type B closed – solid die
 Thread: DIN ISO 228 "G" (cylindrical pipe thread)

Packing unit: individual plastic pack



Nominal thread size G	Threads per inch	Outside Ø2 mm	Thickness T mm	HSS	
G 1/8	28	30,0	11,0	240 018	1
G 1/4	19	38,0	10,0	240 014	1
G 3/8	19	45,0	14,0	240 038	1
G 1/2	14	45,0	14,0	240 012	1
G 5/8	14	55,0	16,0	240 058	1
G 3/4	14	55,0	16,0	240 034	1
G 7/8	14	65,0	18,0	240 078	1
G 1"	11	65,0	18,0	240 010	1

Nominal thread size G	Threads per inch	Outside Ø2 mm	Thickness T mm	HSS	
G 1 1/8	11	75,0	20,0	240 118	1
G 1 1/4	11	75,0	20,0	240 114	1
G 1 3/8	11	90,0	22,0	240 138	1
G 1 1/2	11	90,0	22,0	240 112	1
G 1 5/8	11	90,0	22,0	240 158	1
G 1 3/4	11	105,0	22,0	240 134	1
G 2"	11	105,0	22,0	240 020	1

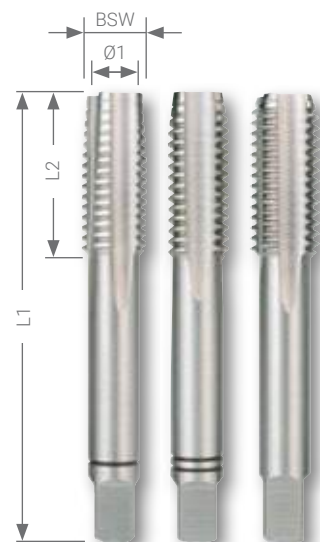


Hand taps BSW ≈ DIN 352 HSS, ground

Set: 3-piece
 Taper tap: 5 - 6-thread chamfer
 Second tap: 4 - 5-thread chamfer
 Final tap: 2 - 3-thread chamfer
 Thread: BSW, formerly DIN 11
 Flanks: relief-ground

Packing unit: set in plastic pack

Steel (N/mm²) < 800	■	Brass	■
Steel (N/mm²) < 1000		Bronze	□
		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	



Also available individually
 Taper tap: Article no. 246-1
 Second tap: Article no. 246-2
 Final tap: Article no. 246-3

Nominal thread size BSW	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
1/16	60	1,15	32,0	7,0	246 116	1
3/32	48	1,80	40,0	8,0	246 332	1
1/8	40	2,50	40,0	10,0	246 018	1
5/32	32	3,10	45,0	12,0	246 532	1
3/16	24	3,60	50,0	13,0	246 316	1
7/32	24	4,40	50,0	15,0	246 732	1
1/4	20	5,10	50,0	16,0	246 014	1
5/16	18	6,50	56,0	18,0	246 516	1
3/8	16	7,90	70,0	24,0	246 038	1
7/16	14	9,30	70,0	24,0	246 716	1
1/2	12	10,50	80,0	30,0	246 012	1
9/16	12	12,00	80,0	30,0	246 916	1

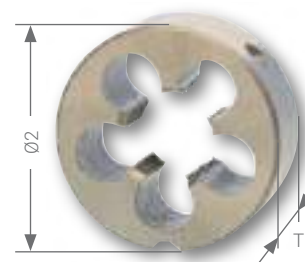
Nominal thread size BSW	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
5/8	11	13,50	80,0	32,0	246 058	1
3/4	10	16,50	95,0	40,0	246 034	1
7/8	9	19,25	100,0	40,0	246 078	1
1"	8	22,00	110,0	50,0	246 010	1
1 1/8	7	24,75	125,0	50,0	246 118	1
1 1/4	7	27,75	125,0	50,0	246 114	1
1 3/8	6	30,20	150,0	63,0	246 138	1
1 1/2	6	33,50	150,0	63,0	246 112	1
1 5/8	5	35,50	150,0	63,0	246 158	1
1 3/4	5	38,50	160,0	70,0	246 134	1
1 7/8	4 1/2	41,50	180,0	75,0	246 178	1
2"	4 1/2	44,50	180,0	75,0	246 020	1



Round dies BSW ≈ DIN EN 22568 HSS, ground

Type: Type B closed – solid die
 Thread: BSW, formerly DIN 11

Packing unit: individual plastic pack



Nominal thread size BSW	Threads per inch	Outside Ø2 mm	Thickness T mm	HSS	
1/16	60	16,0	5,0	247 116	1
3/32	48	16,0	5,0	247 332	1
1/8	40	20,0	5,0	247 018	1
5/32	32	20,0	5,0	247 532	1
3/16	24	20,0	7,0	247 316	1
7/32	24	20,0	7,0	247 732	1
1/4	20	25,0	9,0	247 014	1
5/16	18	25,0	9,0	247 516	1
3/8	16	30,0	11,0	247 038	1
7/16	14	30,0	11,0	247 716	1
1/2	12	38,0	14,0	247 012	1
9/16	12	38,0	14,0	247 916	1

Nominal thread size BSW	Threads per inch	Outside Ø2 mm	Thickness T mm	HSS	
5/8	11	45,0	18,0	247 058	1
3/4	10	45,0	18,0	247 034	1
7/8	9	55,0	22,0	247 078	1
1"	8	55,0	22,0	247 010	1
1 1/8	7	65,0	25,0	247 118	1
1 1/4	7	65,0	25,0	247 114	1
1 3/8	6	65,0	25,0	247 138	1
1 1/2	6	75,0	30,0	247 112	1
1 5/8	5	75,0	30,0	247 158	1
1 3/4	5	90,0	36,0	247 134	1
1 7/8	4 1/2	90,0	36,0	247 178	1
2"	4 1/2	90,0	36,0	247 020	1



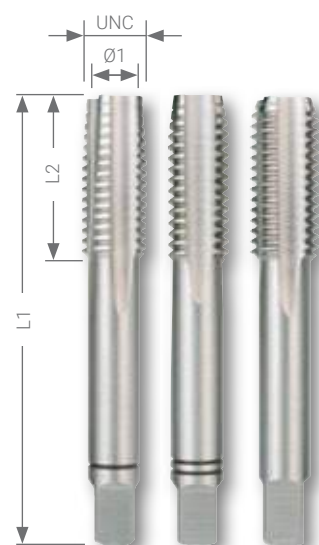
Hand taps UNC ≈ DIN 352 HSS, ground

Set: 3-piece
 Taper tap: 5 - 6-thread chamfer
 Second tap: 4 - 5-thread chamfer
 Final tap: 2 - 3-thread chamfer
 Thread: American UNC coarse thread
 Flanks: relief-ground

Packing unit: set in plastic pack

Steel (N/mm²) < 800	■
Steel (N/mm²) < 1000	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

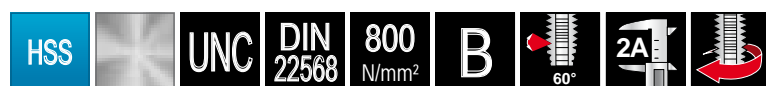


Also available individually

Taper tap: Article no. 246 UNC1
 Second tap: Article no. 246 UNC2
 Final tap: Article no. 246 UNC3

Nominal thread size UNC	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
Nr. 2	56	1,8	36,0	11,0	246 020 UNC	1
Nr. 3	48	2,1	36,0	11,0	246 030 UNC	1
Nr. 4	40	2,3	40,0	12,0	246 040 UNC	1
Nr. 5	40	2,6	40,0	12,0	246 050 UNC	1
Nr. 6	32	2,8	45,0	14,0	246 060 UNC	1
Nr. 8	32	3,5	45,0	14,0	246 080 UNC	1
Nr. 10	24	3,9	50,0	16,0	246 100 UNC	1
Nr. 12	24	4,5	50,0	18,0	246 120 UNC	1
1/4	20	5,1	50,0	19,0	246 014 UNC	1
5/16	18	6,6	56,0	22,0	246 516 UNC	1
3/8	16	8,0	70,0	24,0	246 038 UNC	1
7/16	14	9,4	70,0	24,0	246 716 UNC	1

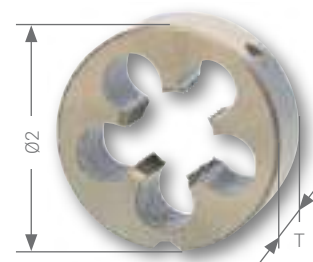
Nominal thread size UNC	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
1/2	13	10,8	75,0	29,0	246 012 UNC	1
9/16	12	12,2	80,0	30,0	246 916 UNC	1
5/8	11	13,5	80,0	32,0	246 058 UNC	1
3/4	10	16,5	95,0	40,0	246 034 UNC	1
7/8	9	19,5	100,0	40,0	246 078 UNC	1
1"	8	22,2	110,0	50,0	246 010 UNC	1
1 1/8	7	25,0	132,0	56,0	246 118 UNC	1
1 1/4	7	28,0	132,0	56,0	246 114 UNC	1
1 3/8	6	30,7	150,0	63,0	246 138 UNC	1
1 1/2	6	34,0	150,0	63,0	246 112 UNC	1
1 3/4	5	39,5	160,0	70,0	246 134 UNC	1
2"	4 1/2	45,0	190,0	80,0	246 200 UNC	1



Round dies UNC ≈ DIN EN 22568 HSS, ground

Type: Type B closed – solid die
 Thread: American UNC coarse thread

Packing unit: individual plastic pack



Nominal thread size UNC	Threads per inch	Outside Ø2 mm	Thickness T mm	HSS	
Nr. 2	56	16,0	5,0	240 020 UNC	1
Nr. 3	48	16,0	5,0	240 030 UNC	1
Nr. 4	40	20,0	5,0	240 040 UNC	1
Nr. 5	40	20,0	5,0	240 050 UNC	1
Nr. 6	32	20,0	7,0	240 060 UNC	1
Nr. 8	32	20,0	7,0	240 080 UNC	1
Nr. 10	24	20,0	7,0	240 100 UNC	1
Nr. 12	24	20,0	7,0	240 120 UNC	1
1/4	20	20,0	7,0	240 014 UNC	1
5/16	18	25,0	9,0	240 516 UNC	1
3/8	16	30,0	11,0	240 038 UNC	1
7/16	14	30,0	11,0	240 716 UNC	1

Nominal thread size UNC	Threads per inch	Outside Ø2 mm	Thickness T mm	HSS	
1/2	13	38,0	14,0	240 012 UNC	1
9/16	12	38,0	14,0	240 916 UNC	1
5/8	11	45,0	18,0	240 058 UNC	1
3/4	10	45,0	18,0	240 034 UNC	1
7/8	9	55,0	22,0	240 078 UNC	1
1"	8	55,0	22,0	240 010 UNC	1
1 1/8	7	65,0	25,0	240 118 UNC	1
1 1/4	7	65,0	25,0	240 114 UNC	1
1 3/8	6	65,0	25,0	240 138 UNC	1
1 1/2	6	75,0	30,0	240 112 UNC	1
1 3/4	5	90,0	36,0	240 134 UNC	1
2"	4,5	90,0	36,0	240 200 UNC	1



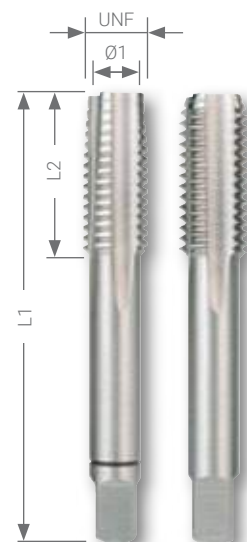
Hand taps UNF ≈ DIN 2181 HSS, ground

Set: 2-piece
 Taper tap: 5 - 6-thread chamfer
 Final tap: 2 - 3-thread chamfer
 Thread: American UNF fine thread
 Flanks: relief-ground

Packing unit: set in plastic pack

Steel (N/mm²) < 800	■
Steel (N/mm²) < 1000	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	



Also available individually

Taper tap: Article no. 246 UNF1

Final tap: Article no. 246 UNF2

Nominal thread size UNF	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
Nr. 2	64	1,85	32,0	10,0	246 020 UNF	1
Nr. 3	56	2,15	32,0	10,0	246 030 UNF	1
Nr. 4	48	2,40	36,0	11,0	246 040 UNF	1
Nr. 5	44	2,70	36,0	11,0	246 050 UNF	1
Nr. 6	40	2,95	40,0	12,0	246 060 UNF	1
Nr. 8	36	3,50	40,0	12,0	246 080 UNF	1
Nr. 10	32	4,10	45,0	14,0	246 100 UNF	1
Nr. 12	28	4,60	50,0	14,0	246 120 UNF	1
1/4	28	5,50	50,0	18,0	246 014 UNF	1
5/16	24	6,90	56,0	22,0	246 516 UNF	1
3/8	24	8,50	63,0	22,0	246 038 UNF	1

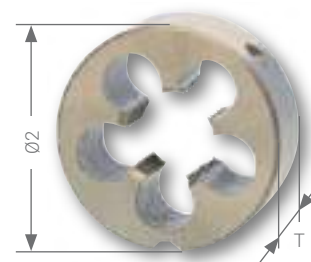
Nominal thread size UNF	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
7/16	20	9,90	63,0	22,0	246 716 UNF	1
1/2	20	11,50	75,0	24,0	246 012 UNF	1
9/16	18	12,90	80,0	28,0	246 916 UNF	1
5/8	18	14,50	80,0	28,0	246 058 UNF	1
3/4	16	17,50	95,0	32,0	246 034 UNF	1
7/8	14	20,50	100,0	36,0	246 078 UNF	1
1"	12	23,25	110,0	40,0	246 010 UNF	1
1 1/8	12	22,00	110,0	50,0	246 118 UNF	1
1 1/4	12	22,00	132,0	56,0	246 114 UNF	1
1 3/8	12	28,00	132,0	56,0	246 138 UNF	1
1 1/2	12	32,00	150,0	63,0	246 112 UNF	1



Round dies UNF ≈ DIN EN 22568 HSS, ground

Type: Type B closed – solid die
 Thread: American UNF fine thread

Packing unit: individual plastic pack



Nominal thread size UNF	Threads per inch	Outside Ø2 mm	Thickness T mm	HSS	
Nr. 2	64	16,0	5,0	240 020 UNF	1
Nr. 3	56	16,0	5,0	240 030 UNF	1
Nr. 4	48	16,0	5,0	240 040 UNF	1
Nr. 5	44	20,0	5,0	240 050 UNF	1
Nr. 6	40	20,0	5,0	240 060 UNF	1
Nr. 8	36	20,0	7,0	240 080 UNF	1
Nr. 10	32	20,0	7,0	240 100 UNF	1
Nr. 12	28	20,0	7,0	240 120 UNF	1
1/4	28	20,0	7,0	240 014 UNF	1
5/16	24	25,0	9,0	240 516 UNF	1
3/8	24	30,0	11,0	240 038 UNF	1

Nominal thread size UNF	Threads per inch	Outside Ø2 mm	Thickness T mm	HSS	
7/16	20	30,0	11,0	240 716 UNF	1
1/2	20	38,0	10,0	240 012 UNF	1
9/16	18	38,0	10,0	240 916 UNF	1
5/8	18	45,0	14,0	240 058 UNF	1
3/4	16	45,0	14,0	240 034 UNF	1
7/8	14	55,0	16,0	240 078 UNF	1
1"	12	55,0	16,0	240 010 UNF	1
1 1/8	12	65,0	18,0	240 118 UNF	1
1 1/4	12	65,0	18,0	240 114 UNF	1
1 3/8	12	65,0	18,0	240 138 UNF	1
1 1/2	12	75,0	20,0	240 112 UNF	1



Hand tap sets HSS and HSSE-Co 5 in steel case

	HSS	HSSE Co 5
21- piece set of hand taps M DIN 352 one three-piece set each of M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12	245 001	245 001 E
22- piece set of hand taps M DIN 352 one three-piece set each of M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 1 tap wrench DIN 1814 size 1 1/2	245 002	245 002 E
29- piece set of hand taps DIN 352 one three-piece set each of M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 Type N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm + 1 tap wrench DIN 1814 size 1 1/2	245 003	245 003 E



Hand tap sets HSS and HSSE-Co 5 in plastic case

	HSS	HSSE Co 5
21- piece set of hand taps M DIN 352 one three-piece set each of M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12	245 001 RO	245 001 ERO
28- piece set of hand taps DIN 352 one three-piece set each of M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 Type N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm	245 003 RO	245 003 ERO



Thread-cutting sets HSS and HSSE-Co 5 in steel case

	HSS	HSSE Co 5
31-piece set of DIY thread-cutting tools one three-piece set each of hand taps M DIN 352 M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 dies Ø 25,0 mm ≈ DIN EN 22568 in each of the sizes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 1 die stock 25,0 x 9,0 mm DIN 225 + 1 tap wrench, size 1½ DIN 1814 + 1 screwdriver	245 010	245 010 E
37-piece set of thread-cutting tools one three-piece set each of hand taps M DIN 352 M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 dies M DIN EN 22568 in each of the sizes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 5 die stocks DIN 225 in each of the sizes 20,0 x 5,0 mm - 20,0 x 7,0 mm - 25,0 x 9,0 mm - 30,0 x 11,0 mm - 38,0 x 14,0 mm + 2 tap wrenches, size 1 and size 2 DIN 1814 + 1 screwdriver + 1 screw-pitch gauge	245 020	245 020 E
44-piece set of thread-cutting tools one three-piece set each of hand taps M DIN 352 M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 type N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm + 7 dies M DIN EN 22568 in each of the sizes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 5 die stocks DIN 225 in each of the sizes 20,0 x 5,0 mm - 20,0 x 7,0 mm - 25,0 x 9,0 mm - 30,0 x 11,0 mm - 38,0 x 14,0 mm + 2 tap wrenches, size 1 and size 2 DIN 1814 + 1 screwdriver + 1 screw-pitch gauge	245 030	245 030 E
54-piece set of thread-cutting tools one three-piece set each of hand taps M DIN 352 M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 - M 14 - M 16 - M 18 - M 20 + 11 dies M DIN EN 22568 in each of the sizes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 - M 14 - M 16 - M 18 - M 20 + 6 die stocks DIN 225 in each of the sizes 20,0 x 5,0 mm - 20,0 x 7,0 mm - 25,0 x 9,0 mm - 30,0 x 11,0 mm - 38,0 x 14,0 mm - 45,0 x 18,0 mm + 2 tap wrenches, size 1 and size 3 DIN 1814 + 1 screwdriver + 1 screw-pitch gauge	245 040	245 040 E
43-piece set of thread-cutting tools MF (metric fine) one two-piece set each of hand taps MF DIN 2181 MF 3 x 0,35 - MF 4 x 0,35 - MF 5 x 0,5 - MF 6 x 0,75 - MF 8 x 0,75 - MF 10 x 1,0 - MF 12 x 1,5 - MF 14 x 1,5 - MF 16 x 1,5 - MF 18 x 1,5 - MF 20 x 1,5 mm + 11 dies MF DIN 22568 in each of the sizes MF 3 - MF 4 - MF 5 - MF 6 - MF 8 - MF 10 - MF 12 - MF 14 - MF 16 - MF 18 - MF 20 + 6 die stocks DIN 225 in each of the sizes 20,0 x 5,0 mm - 20,0 x 7,0 mm - 25,0 x 9,0 mm - 30,0 x 11,0 mm - 38,0 x 10,0 mm - 45,0 x 14,0 mm + 2 tap wrenches, size 1 and 3 DIN 1814 + 1 screwdriver + 1 screw-pitch gauge	245 041	—



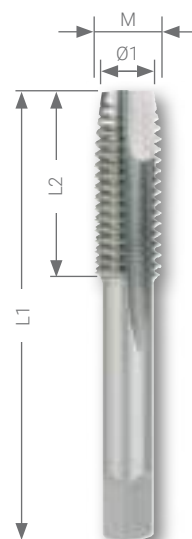


Single-cut taps M ≈ DIN 352 HSS and HSSE-Co 5 ground













Thread: metric, DIN ISO 13






Flanks: relief-ground

The single-cut tap HSS for through threads in unalloyed and low-alloyed steels up to a strength of 800 N/mm². The single-cut tap HSSE-Co 5 for through threads in unalloyed and alloyed steels up to a strength of 1000 N/mm², malleable cast iron and non-ferrous metals. The thread can be cut in one operation by hand or machine.





Packing unit: individual plastic pack

				231 ...		 	
				231 ... E		 	



Nominal thread size M	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	 	 	
M 3	0,50	2,50	40,0	10,0	231 030	231 030 E	1
M 4	0,70	3,30	45,0	12,0	231 040	231 040 E	1
M 5	0,80	4,20	50,0	13,0	231 050	231 050 E	1
M 6	1,00	5,00	50,0	15,0	231 060	231 060 E	1
M 8	1,25	6,80	56,0	18,0	231 080	231 080 E	1
M 9	1,25	7,80	67,0	22,0	231 090	–	1
M 10	1,50	8,50	70,0	24,0	231 100	231 100 E	1
M 12	1,75	10,20	75,0	29,0	231 120	231 120 E	1

Single-cut tap set HSS in steel case

	 
15-piece set of single-cut taps 7 single-cut taps ≈ DIN 352 HSS, ground M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 Type N HSS, ground Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm + 1 tap wrench, size 1 1/2 DIN 1814	245 004



Single-cut tap set HSS in plastic case

	 
15-piece set of single-cut taps 7 single-cut taps ≈ DIN 352 HSS, ground M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 Type N HSS, ground Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm + 1 tap wrench, size 1 1/2 DIN 1814	245 004 RO





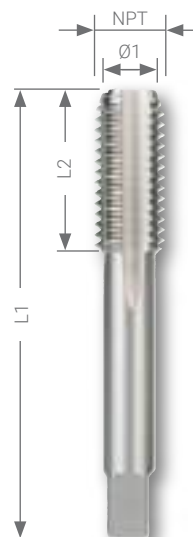
Single-cut taps NPT HSS, ground

Thread: American conical pipe thread to ANSI B.1.20.1
 Flanks: relief-ground
 Cone: 1:16

For through threads in unalloyed or low-alloyed steels up to 800 N/mm² strength, malleable cast iron and non-ferrous metals. The thread can be cut in one operation by hand or machine.

Note: pilot drill cylindrically

Packing unit: individual plastic pack



Steel (N/mm ²) < 800		Brass	
Steel (N/mm ²) < 1000		Bronze	
		Plastics	
Rust-resistant steel		Cast iron	
Aluminium		Titanium alloyed	

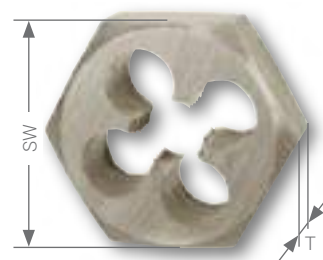
Nominal thread size NPT	Threads per inch	Thread core hole Ø1 mm	Cutting depth mm	L1 mm	L2 mm	HSS	
1/16	27,0	6,00	12,00	65,0	19,0	231 116 NPT	1
1/8	27,0	8,25	12,00	65,0	19,0	231 018 NPT	1
1/4	18,0	10,70	17,50	70,0	25,0	231 014 NPT	1
3/8	18,0	14,10	17,50	75,0	26,0	231 038 NPT	1
1/2	14,0	17,40	22,90	80,0	31,0	231 012 NPT	1
3/4	14,0	22,60	23,00	100,0	33,0	231 034 NPT	1
1"	11,5	28,50	27,40	110,0	38,0	231 010 NPT	1
1 1/4"	11,5	37,00	28,10	125,0	41,0	231 114 NPT	1
1 1/2"	11,5	43,50	28,40	140,0	42,0	231 112 NPT	1
2"	11,5	55,00	28,40	160,0	44,0	231 020 NPT	1



Hexagonal die nut M DIN 382 HSS ground

Thread: metric, DIN ISO 13

Packing unit: individual plastic pack



Nominal thread size M	Pitch mm	Outside Ø SW mm	Thickness T mm	HSS	
M 3	0,50	18,0	5,0	267 030	1
M 4	0,70	18,0	5,0	267 040	1
M 5	0,80	18,0	7,0	267 050	1
M 6	1,00	18,0	7,0	267 060	1
M 8	1,25	21,0	9,0	267 080	1
M 10	1,50	27,0	11,0	267 100	1
M 12	1,75	36,0	14,0	267 120	1
M 14	2,00	36,0	14,0	267 140	1

Nominal thread size M	Pitch mm	Outside Ø SW mm	Thickness T mm	HSS	
M 16	2,00	41,0	18,0	267 160	1
M 18	2,50	41,0	18,0	267 180	1
M 20	2,50	41,0	18,0	267 200	1
M 22	2,50	50,0	22,0	267 220	1
M 24	3,00	50,0	22,0	267 240	1
M 27	3,00	60,0	25,0	267 270	1
M 30	3,50	60,0	25,0	267 300	1



Single-cut taps G ≈ DIN 5157 HSS, ground

Thread: DIN ISO 228 "G" (cylindrical pipe thread)
DIN 2999 "Rp" (Whitworth pipe thread)
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm²) < 800	■	Brass	■
Steel (N/mm²) < 1000		Bronze	□
		Plastics	■
Rust-resistant steel		Cast iron	□
Aluminium	■	Titanium alloyed	



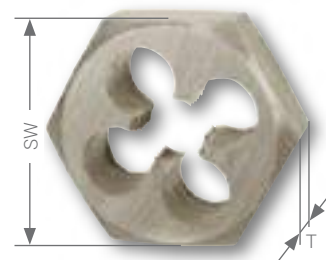
Nominal thread size G / Rp	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
G 1/8 Rp 1/8	28	8,6	63,0	20,0	236 218	1
G 1/4 Rp 1/4	19	11,5	70,0	22,0	236 214	1
G 3/8 Rp 3/8	19	15,0	70,0	22,0	236 238	1
G 1/2 Rp 1/2	14	19,0	80,0	22,0	236 212	1
G 3/4 Rp 3/4	14	24,5	90,0	22,0	236 234	1
G 1" Rp 1"	11	30,5	100,0	25,0	236 210	1



Hexagonal die nut G DIN 382 HSS ground

Thread: DIN ISO 228 "G" (cylindrical pipe thread)

Packing unit: individual plastic pack



Nominal thread size G	Threads per inch	Outside Ø SW mm	Thickness T mm	HSS	
G 1/8	28	27,0	11,0	267 618	1
G 1/4	19	36,0	10,0	267 614	1
G 3/8	19	41,0	14,0	267 638	1
G 1/2	14	41,0	14,0	267 612	1
G 3/4	14	50,0	16,0	267 634	1
G 1"	11	60,0	18,0	267 610	1

Sanitary repair thread-cutting set HSS for cylindrical pipe thread in plastic case

	HSS
13-piece set of sanitary repair thread-cutting tools 6 single-cut taps G/Rp ≈ DIN 5157 HSS, ground G/Rp 1/8" x 28 - G/Rp 1/4" x 19 - G/Rp 3/8" x 19 - G/Rp 1/2" x 14 - G/Rp 3/4" x 14 - G/Rp 1" x 11 + 6 hexagonal dies G DIN 382 HSS, ground G 1/8" x 28 - G 1/4" x 19 - G 3/8" x 19 - G 1/2" x 14 - G 3/4" x 14 - G 1" x 11 + 1 cutting paste, 50 g	245 059



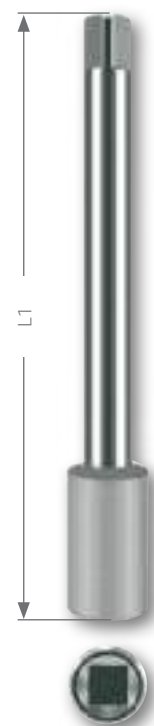
Extension sleeves DIN 377

As extension for hand thread-cutting tools.
Inside and outside square of identical size.

Version: hardened and ground
Shank: square as per DIN 10

Packing unit: individual plastic pack

Square mm	Length mm	M	for hand tap size Ww	G		
2,1	60,0	M 1 - M 2,6	1/16 - 3/32	—	241 021	1
2,7	80,0	M 3	—	—	241 027	1
3,4	95,0	M 4	5/32	—	241 034	1
4,9	110,0	M 5 - M 8	7/32 - 5/16	—	241 049	1
5,5	115,0	M 9 - M 10	3/8	1/8	241 055	1
7,0	125,0	M 12	1/2	—	241 070	1
9,0	135,0	M 13 - M 16	9/16 - 5/8	1/4	241 090	1
11,0	150,0	M 18	11/16 - 3/4	—	241 110	1
12,0	155,0	M 20	13/16	1/2	241 120	1
14,5	174,0	M 22 - M 24	7/8 - 15/16	5/8	241 145	1
16,0	185,0	M 27 - M 28	1	3/4	241 160	1
18,0	195,0	M 30 - M 32	1 1/8	7/8	241 180	1



Thread-cutting sets HSS in wood case

	HSS
28- piece set of thread-cutting tools one two-piece set each of hand taps G DIN 5157 — 1/8 - 1/4 - 3/8 - 1/2 - 5/8 - 3/4 - 1" + 7 dies G DIN EN 24231 in each of the sizes - 1/8 - 1/4 - 3/8 - 1/2 - 5/8 - 3/4 - 1" + 5 die stocks DIN 225 in each of the sizes 30,0 x 11,0 mm - 38,0 x 10,0 mm - 45,0 x 14,0 mm - 55,0 x 16,0 mm - 65,0 x 18,0 mm + 2 tap wrenches, size 3 and size 5 DIN 1814	245 074
35- piece set of thread-cutting tools one two-piece set each of hand taps UNF ≈ DIN 2181 — 1/4 - 5/16 - 3/8 - 7/16 - 1/2 - 5/8 - 3/4 - 7/8 - 1" + 9 dies UNF ≈ DIN EN 22568 in each of the sizes - 1/4 - 5/16 - 3/8 - 7/16 - 1/2 - 5/8 - 3/4 - 7/8 - 1" + 6 die stocks DIN 225 in each of the sizes 20,0 x 7,0 - 25,0 x 9,0 - 30,0 x 11,0 - 38,0 x 10,0 - 45,0 x 14,0 - 55,0 x 16,0 mm + 2 tap wrenches, size 2 and size 4 DIN 1814	245 073
44- piece set of thread-cutting tools one three-piece set each of hand taps UNC ≈ DIN 352 — 1/4 - 5/16 - 3/8 - 7/16 - 1/2 - 5/8 - 3/4 - 7/8 - 1" + 9 dies UNC ≈ DIN EN 22568 in each of the sizes - 1/4 - 5/16 - 3/8 - 7/16 - 1/2 - 5/8 - 3/4 - 7/8 - 1" + 6 die stocks DIN 225 in each of the sizes 20,0 x 7,0 mm - 25,0 x 9,0 mm - 30,0 x 11,0 mm - 38,0 x 10,0 mm - 45,0 x 14,0 mm - 55,0 x 16,0 mm + 2 tap wrenches, size 2 and size 4 DIN 1814	245 072



245 074



245 073



245 072

Die stocks as per DIN 225

For closed and slotted taps as per DIN EN 24231.

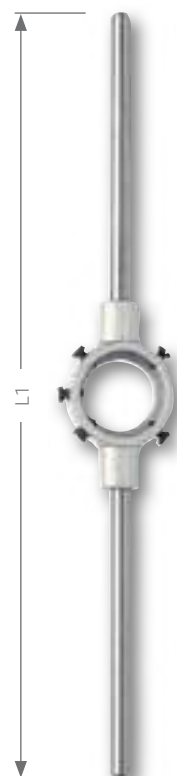
With steel handles one of which can be unscrewed and five screws for clamping the tap.

Version: die-cast zinc housing

Packing unit: individual plastic pack

Size	Thickness mm	L1 mm	for tap size			No.	
			M + MF	Ww	G		
16	5,0	160,0	M 1 - M 2,6	1/16 - 3/32	—	242 165	1
20	5,0	175,0	M 3 - M 4	1/8 - 5/32	—	242 205	1
20	7,0	175,0	M 4,5 - M 6	3/16 - 1/4	—	242 207	1
25	9,0	210,0	M 7 - M 9	5/16	1/16	242 259	1
30	11,0	260,0	M 10 - M 11	3/8 - 7/16	1/8	242 3011	1
38	14,0	310,0	M 12 - M 14	1/2 - 9/16	—	242 3814	1
45	18,0	440,0	M 16 - M 20	5/8 - 3/4	—	242 4518	1
55	22,0	495,0	M 22 - M 24	7/8 - 1	—	242 5522	1
65	25,0	630,0	M 27 - M 36	1 1/8 - 1 3/8	—	242 6525	1
75	30,0	700,0	M 38 - M 42	1 1/2 - 1 5/8	—	242 7530	1
90	36,0	900,0	M 45 - M 52	1 3/4 - 2	—	242 9036	1
105	36,0	930,0	M 54 - M 63	2 1/4 - 2 3/4	—	242 10536	1

38	10,0	310,0	MF 12 - MF 14	—	1/4	242 3810	1
45	14,0	440,0	MF 16 - MF 20	—	3/8 - 1/2	242 4514	1
55	16,0	495,0	MF 22 - MF 24	—	5/8 - 3/4	242 5516	1
65	18,0	630,0	MF 27 - MF 36	—	7/8 - 1	242 6518	1
75	20,0	750,0	MF 38 - MF 42	—	1 1/8 - 1 1/4	242 7520	1
90	22,0	900,0	MF 45 - MF 52	—	1 3/8 - 1 5/8	242 9022	1
105	22,0	930,0	MF 54 - MF 63	—	1 3/4 - 2	242 10522	1




Adjustable tap wrenches as per DIN 1814

Ideal for thread-cutting in inaccessible places.
With two-jaw chuck for tensioning square shanks.
With steel handles one of which can be unscrewed.

Version: die-cast zinc housing
Chuck jaws: hardened

Packing unit: individual plastic pack


Size	L1 mm	for hand tape size			No.	
		M	Ww	G		
0	125,0	M 1 - M 8	1/16 - 5/16	—	241 100	1
1	175,0	M 1 - M 10	1/8 - 3/8	—	241 101	1
1 1/2	175,0	M 1 - M 12	1/8 - 1/2	1/8	241 112	1
2	265,0	M 4 - M 12	3/16 - 5/8	1/8 - 3/8	241 102	1
3	370,0	M 5 - M 20	1/4 - 3/4	1/8 - 1/2	241 103	1
4	480,0	M 11 - M 27	1/2 - 1	1/8 - 3/4	241 104	1
5	700,0	M 13 - M 32	5/8 - 1 1/4	1/4 - 1	241 105	1
6	1000,0	M 19 - M 38	3/4 - 1 1/2	1/4 - 1 1/4	241 106	1
7	1250,0	M 25 - M 52	7/8 - 2	5/8 - 2 1/4	241 107	1

Ball tap wrenches

Ideal for rapid fitting of taps.

Version: die-cast zinc housing
Shank: square as per DIN 10

Packing unit: individual plastic pack


Size	L1 mm	for hand tape size			No.	
		M	Ww	G		
0	200,0	M 1 - M 4	1/16 - 5/32	—	241 200	1
1	200,0	M 3,5 - M 8	5/32 - 5/16	—	241 201	1
2	240,0	M 4 - M 10	5/32 - 3/8	—	241 202	1
3	300,0	M 5 - M 12	7/32 - 1/2	—	241 203	1
4	340,0	M 9 - M 16	3/8 - 5/8	—	241 204	1
5	450,0	M 12 - M 20	1/2 - 13/16	—	241 205	1
6	650,0	M 18 - M 27	11/16 - 1	—	241 206	1

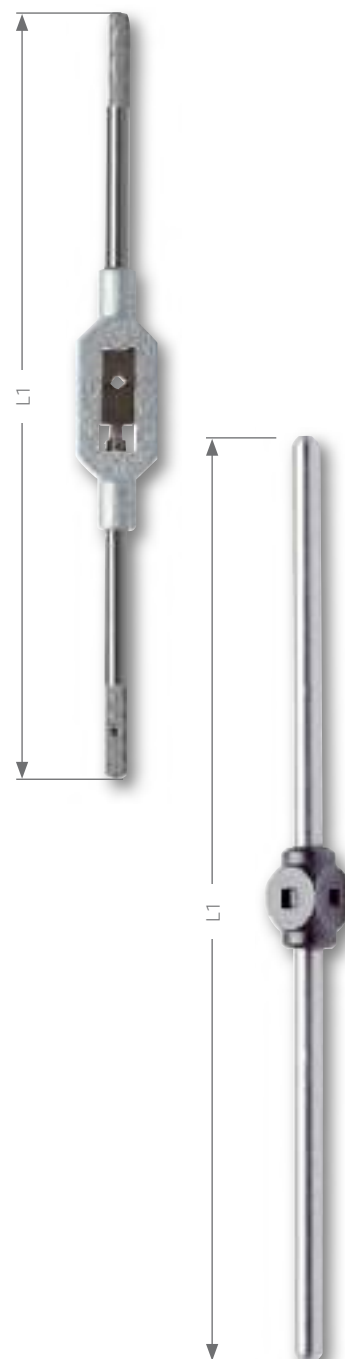
Tap wrench with ratchet

Ideal for thread-cutting in inaccessible places.
With two-jaw chuck for tensioning square shanks.

Version: adjustable left, right, fixed
Shank: sliding cross-handle with grooves at both ends
Surface: chromium-plated

Packing unit: individual plastic pack











Size	L1 mm	for hand tape size			No.	
		M	Ww	G		
1	85,0	M 3 - M 10	1/8 - 3/8	—	241 001	1
2	100,0	M 5 - M 12	7/32 - 1/2	1/8	241 002	1
10	250,0	M 3 - M 10	1/8 - 3/8	—	241 010	1
20	300,0	M 5 - M 12	7/32 - 1/2	1/8	241 020	1



Range and applications overview:



Material	Surface	DIN	Shape	Left hand cutting / right hand cutting	Thread	Tenacity classes	Blind hole / Through hole	Nominal thread size	Article no.	Page
HSS		DIN 371	B		M	800 N/mm²		M 2 - M 10	232 020 - 232 100	164
HSSE Co 5		DIN 371	B		M	1000 N/mm²		M 2 - M 10	232 020 E - 232 100 E	164
HSSE Co 5		DIN 371	B		M	1000 N/mm²		M 2 - M 10	232 020 VA - 232 100 VA	164
HSS	TiN	DIN 371	B		M	900 N/mm²		M 2 - M 10	232 020 T - 232 100 T	164
HSSE Co 5	TiAlN	DIN 371	B		M	1200 N/mm²		M 2 - M 10	232 020 EF - 232 100 EF	164
HSS		DIN 371	C		M	800 N/mm²		M 2 - M 10	234 020 - 234 100	165
HSSE Co 5		DIN 371	C		M	1000 N/mm²		M 2 - M 10	234 020 E - 234 100 E	165
HSSE Co 5		DIN 371	C		M	1000 N/mm²		M 2 - M 10	234 020 VA - 234 100 VA	165
HSS	TiN	DIN 371	C		M	900 N/mm²		M 2 - M 10	234 020 T - 234 100 T	165
HSSE Co 5	TiAlN	DIN 371	C		M	1200 N/mm²		M 2 - M 10	234 020 EF - 234 100 EF	165
HSS		DIN 376	B		M	800 N/mm²		M 12 - M 30	232 120 - 232 300	166
HSSE Co 5		DIN 376	B		M	1000 N/mm²		M 3 - M 30	232 031 E - 232 300 E	166
HSSE Co 5		DIN 376	B		M	1000 N/mm²		M 3 - M 30	232 031 VA - 232 300 VA	166
HSS	TiN	DIN 376	B		M	900 N/mm²		M 12 - M 30	232 120 T - 232 300 T	166
HSSE Co 5	TiAlN	DIN 376	B		M	1200 N/mm²		M 3 - M 30	232 031 EF - 232 300 EF	166
HSS		DIN 376	C		M	800 N/mm²		M 12 - M 30	233 120 - 233 300	167
HSSE Co 5		DIN 376	C		M	1000 N/mm²		M 3 - M 30	233 030 E - 233 300 E	167
HSSE Co 5		DIN 376	C		M	1000 N/mm²		M 3 - M 30	233 030 VA - 233 300 VA	167
HSS	TiN	DIN 376	C		M	900 N/mm²		M 12 - M 30	233 120 T - 233 300 T	167
HSSE Co 5	TiAlN	DIN 376	C		M	1200 N/mm²		M 3 - M 30	233 030 EF - 233 300 EF	167
HSS		DIN 371	B _{AZ}		M	800 N/mm²		M 3 - M 10	272 030 - 272 100	170
HSS		DIN 376	B _{AZ}		M	800 N/mm²		M 12 - M 24	272 120 - 272 240	170

 Steel (N/mm2) < 800	 Steel (N/mm2) < 1000	 Steel (N/mm2) < 1200	 Stainless steel	 Aluminium	 Brass	 Bronze	 Plastics	 Cast iron	 Titanium alloyed
■				□	■	□	□	□	
■	■		□	□	■	□	□	□	
■	■		□	□	■	□	□	□	
■	□		□		■	□	□	□	
■	■	■	■	□	■	■	□	□	□
■				□	■	□	□	□	
■	■		□	□	■	□	□	□	
■	■		□	□	■	□	□	□	
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■	■	■	■	□	■	■	□	□	□
□				■	□		■		
□				■	□		■		

Range and applications overview:



Material	Surface	DIN	Shape	Left hand cutting / right hand cutting	Thread	Tenacity classes	Blind hole / Through hole	Nominal thread size	Article no.	Page
HSSE Co 5	TiCN	DIN 371	B		M	800 N/mm²		M 3 - M 10	273 030 ETC - 273 100 ETC	171
HSSE Co 5	TiCN	DIN 376	C		M	1000 N/mm²		M 12 - M 24	273 120 ETC - 273 240 ETC	171
HSSE Co 5		DIN 5156	B		G (BSP)	1000 N/mm²		G 1/8 - G 2"	262 018 E - 262 020 E	172
HSSE Co 5		DIN 5156	C		G (BSP)	1000 N/mm²		G 1/8 - G 2"	263 018 E - 263 020 E	172
HSSE Co 5		DIN 374	B		MF	1000 N/mm²		MF 4 - MF 30	260 041 E - 260 302 E	174
HSSE Co 5		DIN 374	C		MF	1000 N/mm²		MF 4 - MF 30	261 041 E - 261 302 E	175
HSSE Co 5			B		UNC	1000 N/mm²		Nr. 4 - 3/8	265 040 UNC - 265 038 UNC	176
HSSE Co 5			B		UNC	1000 N/mm²		7/16 - 1"	265 716 UNC - 265 010 UNC	176
HSSE Co 5			C		UNC	1000 N/mm²		Nr. 4 - 3/8	266 040 UNC - 266 038 UNC	177
HSSE Co 5			C		UNC	1000 N/mm²		7/16 - 1"	266 716 UNC - 266 010 UNC	177
HSSE Co 5			B		UNF	1000 N/mm²		Nr. 4 - 3/8	265 040 UNF - 265 038 UNF	178
HSSE Co 5			B		UNF	1000 N/mm²		7/16 - 1"	265 716 UNF - 265 010 UNF	178
HSSE Co 5			C		UNF	1200 N/mm²		Nr. 4 - 3/8	266 040 UNF - 266 038 UNF	179
HSSE Co 5			C		UNF	1000 N/mm²		7/16 - 1"	266 716 UNF - 266 010 UNF	179
HSS		DIN 40430	B		PG	800 N/mm²		PG 7 - PG 48	264 007 - 264 048	180
HSS		DIN 357			M	800 N/mm²		M 3 - M 24	243 030 - 243 240	180
HSSE Co 5		DIN 2174	D		M	1000 N/mm²		M 3 - M 12	271 003 N - 271 012 N	181
HSSE Co 5	TiAlN	DIN 2174	D		M	1200 N/mm²		M 3 - M 12	271 003 F - 271 012 F	181
HSS					M	600 N/mm²		M 3 - M 10	270 014 - 270 019	182 - 183
HSS	TiN				M	900 N/mm²		M 3 - M 10	270 014 T - 270 019 T	182 - 183
HSS					M	600 N/mm²		M 3 - M 10	R 270 014 - R 270 019	182 - 183
HSS	TiN				M	900 N/mm²		M 3 - M 10	R 270 014 T - R 270 019 T	182 - 183

■ Main application □ Other application

Product information for machine taps



HSS

The machine tap consists of heavy-duty high-speed steel. For through threads and bottoming threads in unalloyed steels up to a strength of 800 N/mm², malleable. The thread is cut in one operation.

High speed tool steel, best known as 'high speed steel', refers to a group of alloyed tool steels with up to 2,06% carbon content and up to 30% proportion of alloying elements such as tungsten, molybdenum, vanadium, cobalt, nickel and titanium. HSS materials are characterised by great hardness, wear resistance and heat resistance up to 600° C. The HSS tools are less sensitive to shocks and vibrations, which sometimes quickly lead to breaks in the harder cutting materials.



HSSE-Co 5

The machine tap consists of cobalt alloyed heavy-duty high-speed steel. Its high heat resistance means a longer tool life. For through threads and bottoming threads in unalloyed and alloyed steels up to a strength of 1000 N/mm², malleable cast iron and non-ferrous metals. The thread is cut in one operation.

Like high speed steel with cobalt alloy. This heat-resistant material is used for processing materials with high strength and in long cutting channels with correspondingly strong heating. The cobalt content of 5% provides a higher heat resistance and higher stressing capacity.



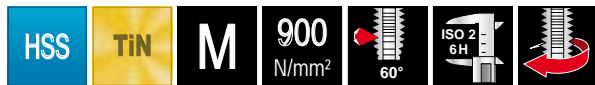
HSSE-Co 5 VAP for stainless steel

The machine tap consists of cobalt alloyed and vaporised heavy-duty high-speed steel. For through threads and bottoming threads in unalloyed and alloyed steels up to a strength of 1000 N/mm², stainless steel. The thread is cut in one operation.

By "vaporisation" is meant the evaporation of a non-metallic oxide film. Vaporisation acts as a separating layer and reduces the occurrence of cold welding. In cold welding there are workpiece chips that build up on the flanks of the tap and damage the finished thread. Consequences of cold welding are torn and dirty flanks. VAP improves the adhesion of lubricants to the tool surface.



Product information for machine taps



HSS-TiN

The machine tap consists of heavy-duty high-speed steel with a titanium nitride coating. For universal use on a wide range of materials due to layer of hard material! For through threads and bottoming threads in unalloyed and alloyed steels up to a strength of 900 N/mm², stainless steel. The thread is cut in one operation.

Note: cutting speeds from 10 m/min. By the TiN wear-resistant coating, the surface hardness increases to about 2500 HV. Titanium nitride is a chemical compound of the two elements, titanium and nitrogen. TiN is a metallic hard material with a typical golden yellow colour.

Advantages: Increased hardness, low friction coefficient, more service life. Cooling is not necessary, but recommended.



HSSE-Co 5 TiAlN

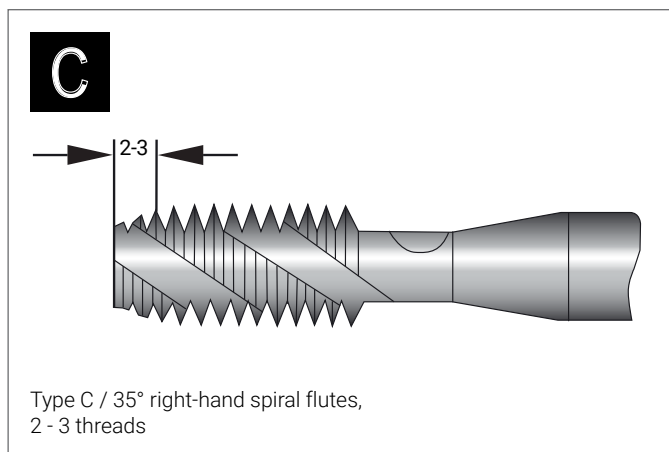
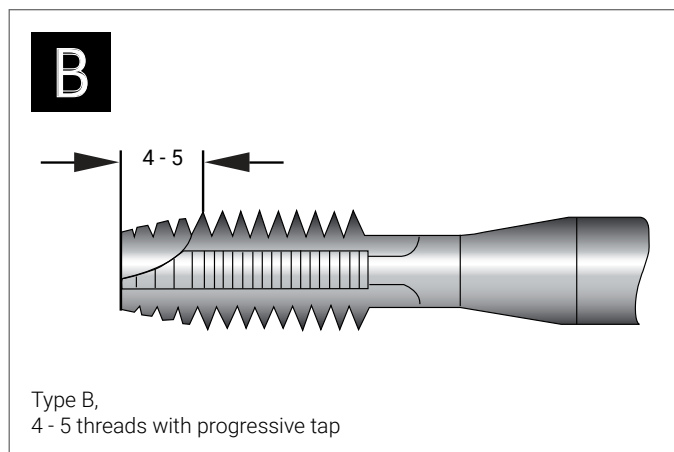
The machine tap consists of heavy-duty high-speed steel. For through-hole threads and blind-hole threads, in unalloyed, low alloy and alloyed steels up to 1200 N/mm² strength and cast. The thread is cut in one operation.

By the TiAlN wear-resistant coating, the surface hardness increases to about 3500 HV. Titanium aluminium nitride is a chemical compound of three elements titanium, aluminium and nitrogen. TiAlN is a metallic hard material with a typical black/violet colour.

Advantages: The TiAlN coating enables the dry machining tools to cut without a cooling. Increased hardness, very low friction coefficient, optimal service life.



Technical data:





Machine taps M DIN 371 HSS and HSSE-Co 5, ground

Machine taps with reinforced shank
for through threads.

Chamfer: type B, 4 - 5 threads with progressive tap
Thread: metric, DIN ISO 13
Flanks: relief-ground

Packing unit: individual plastic pack














To increase the service life - reduce speed!
Cooling while countersinking!



Steel (N/mm ²) < 800	■	■	■	■	■
Steel (N/mm ²) < 1000		■	■	□	■
Steel (N/mm ²) < 1200					■
Rust-resistant steel		□	□	□	■
Aluminium	□	□	□		□

Brass	■	■	■	■	■
Bronze	□	□	□	□	■
Plastics	□	□	□	□	□
Cast iron	□	□	□	□	□
Titanium alloyed					□

Nominal thread size	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm
M 2	0,40	1,60	45,0	8,0	2,8
M 2,5	0,45	2,05	50,0	9,0	2,8
M 3	0,50	2,50	56,0	11,0	3,5
M 4	0,70	3,30	63,0	13,0	4,5
M 5	0,80	4,20	70,0	16,0	6,0
M 6	1,00	5,00	80,0	19,0	6,0
M 8	1,25	6,80	90,0	22,0	8,0
M 10	1,50	8,50	100,0	24,0	10,0

Nominal thread size	 	 	 	 	 	
M 2	232 020	232 020 E	232 020 VA	232 020 T	232 020 EF	1
M 2,5	232 025	232 025 E	232 025 VA	232 025 T	232 025 EF	1
M 3	232 030	232 030 E	232 030 VA	232 030 T	232 030 EF	1
M 4	232 040	232 040 E	232 040 VA	232 040 T	232 040 EF	1
M 5	232 050	232 050 E	232 050 VA	232 050 T	232 050 EF	1
M 6	232 060	232 060 E	232 060 VA	232 060 T	232 060 EF	1
M 8	232 080	232 080 E	232 080 VA	232 080 T	232 080 EF	1
M 10	232 100	232 100 E	232 100 VA	232 100 T	232 100 EF	1

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.



Machine taps M DIN 371 HSS and HSSE-Co 5, ground

Machine taps with reinforced shank
and 35° right-hand spiral flutes for bottoming.

Chamfer: type C / 35° right-hand spiral flutes, 2 - 3 threads
Thread: metric, DIN ISO 13
Flanks: relief-ground

Packing unit: individual plastic pack



To increase the service life - reduce speed!
Cooling while countersinking!














06

Steel (N/mm ²) < 800	■	■	■	■	■
Steel (N/mm ²) < 1000		■	■	□	■
Steel (N/mm ²) < 1200					■
Rust-resistant steel		■	■	□	■
Aluminium	□	□	□		□

Brass	■	■	■	■	■
Bronze	□	□	□	□	■
Plastics	□	□	□	□	□
Cast iron	□	□	□	□	□
Titanium alloyed					□

Nominal thread size	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm
M 2	0,40	1,60	45,0	8,0	2,8
M 2,5	0,45	2,05	50,0	9,0	2,8
M 3	0,50	2,50	56,0	11,0	3,5
M 4	0,70	3,30	63,0	13,0	4,5
M 5	0,80	4,20	70,0	16,0	6,0
M 6	1,00	5,00	80,0	19,0	6,0
M 8	1,25	6,80	90,0	22,0	8,0
M 10	1,50	8,50	100,0	24,0	10,0

Nominal thread size	 	 	 	 	 	
M 2	234 020	234 020 E	234 020 VA	234 020 T	234 020 EF	1
M 2,5	234 025	234 025 E	234 025 VA	234 025 T	234 025 EF	1
M 3	234 030	234 030 E	234 030 VA	234 030 T	234 030 EF	1
M 4	234 040	234 040 E	234 040 VA	234 040 T	234 040 EF	1
M 5	234 050	234 050 E	234 050 VA	234 050 T	234 050 EF	1
M 6	234 060	234 060 E	234 060 VA	234 060 T	234 060 EF	1
M 8	234 080	234 080 E	234 080 VA	234 080 T	234 080 EF	1
M 10	234 100	234 100 E	234 100 VA	234 100 T	234 100 EF	1

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.

■ Main application

□ Other application





Machine taps M DIN 376 HSS and HSSE-Co 5, ground

Machine taps with overflow shank for through threads.

Chamfer: type B, 4 - 5 threads with progressive tap
Thread: metric, DIN ISO 13
Flanks: relief-ground

Packing unit: individual plastic pack

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.



Steel (N/mm ²) < 800					
Steel (N/mm ²) < 1000					
Steel (N/mm ²) < 1200					
Rust-resistant steel					
Aluminium					

Brass					
Bronze					
Plastics					
Cast iron					
Titanium alloyed					

Nominal thread size	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm
M 3	0,50	2,50	56,0	11,0	2,2
M 4	0,70	3,30	63,0	13,0	2,8
M 5	0,80	4,20	70,0	16,0	3,5
M 6	1,00	5,00	80,0	19,0	4,5
M 8	1,25	6,80	90,0	22,0	6,0
M 10	1,50	8,50	100,0	24,0	7,0
M 12	1,75	10,20	110,0	28,0	9,0
M 14	2,00	12,00	110,0	30,0	11,0
M 16	2,00	14,00	110,0	32,0	12,0
M 18	2,50	15,50	125,0	34,0	14,0
M 20	2,50	17,50	140,0	34,0	16,0
M 22	2,50	19,50	140,0	34,0	18,0
M 24	3,00	21,00	160,0	38,0	18,0
M 27	3,00	24,00	160,0	38,0	20,0
M 30	3,50	26,50	180,0	45,0	22,0

Nominal thread size													
M 3	—	—	232 031 E	232 031 VA	—	—	—	—	—	232 031 EF	—	—	1
M 4	—	—	232 041 E	232 041 VA	—	—	—	—	—	232 041 EF	—	—	1
M 5	—	—	232 051 E	232 051 VA	—	—	—	—	—	232 051 EF	—	—	1
M 6	—	—	232 061 E	232 061 VA	—	—	—	—	—	232 061 EF	—	—	1
M 8	—	—	232 081 E	232 081 VA	—	—	—	—	—	232 081 EF	—	—	1
M 10	—	—	232 101 E	232 101 VA	—	—	—	—	—	232 101 EF	—	—	1
M 12	232 120	—	232 120 E	232 120 VA	232 120 T	—	—	—	—	232 120 EF	—	—	1
M 14	232 140	—	232 140 E	232 140 VA	232 140 T	—	—	—	—	232 140 EF	—	—	1
M 16	232 160	—	232 160 E	232 160 VA	232 160 T	—	—	—	—	232 160 EF	—	—	1
M 18	232 180	—	232 180 E	232 180 VA	232 180 T	—	—	—	—	232 180 EF	—	—	1
M 20	232 200	—	232 200 E	232 200 VA	232 200 T	—	—	—	—	232 200 EF	—	—	1
M 22	232 220	—	232 220 E	232 220 VA	232 220 T	—	—	—	—	232 220 EF	—	—	1
M 24	232 240	—	232 240 E	232 240 VA	232 240 T	—	—	—	—	232 240 EF	—	—	1
M 27	232 270	—	232 270 E	232 270 VA	232 270 T	—	—	—	—	232 270 EF	—	—	1
M 30	232 300	—	232 300 E	232 300 VA	232 300 T	—	—	—	—	232 300 EF	—	—	1



Machine taps M DIN 376 HSS and HSSE-Co 5, ground

Machine taps with overflow shank and
35° right-hand spiral flutes for bottoming.

Chamfer: type C / 35° right-hand spiral flutes, 2 - 3 threads
Thread: metric, DIN ISO 13
Flanks: relief-ground

Packing unit: individual plastic pack

Schematic illustration. Smaller diameters can be supplied with a tip for
production reasons.



Steel (N/mm ²) < 800	■	■	■	■	■
Steel (N/mm ²) < 1000		■	■	□	■
Steel (N/mm ²) < 1200					■
Rust-resistant steel		■	■	□	■
Aluminium	□	□	□		□

Brass	■	■	■	■	■
Bronze	□	□	□	□	■
Plastics	□	□	□	□	□
Cast iron	□	□	□	□	□
Titanium alloyed					□

Nominal thread size	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm
M 3	0,50	2,50	56,0	11,0	2,2
M 4	0,70	3,30	63,0	13,0	2,8
M 5	0,80	4,20	70,0	16,0	3,5
M 6	1,00	5,00	80,0	19,0	4,5
M 8	1,25	6,80	90,0	22,0	6,0
M 10	1,50	8,50	100,0	24,0	7,0
M 12	1,75	10,20	110,0	28,0	9,0
M 14	2,00	12,00	110,0	30,0	11,0
M 16	2,00	14,00	110,0	32,0	12,0
M 18	2,50	15,50	125,0	34,0	14,0
M 20	2,50	17,50	140,0	34,0	16,0
M 22	2,50	19,50	140,0	34,0	18,0
M 24	3,00	21,00	160,0	38,0	18,0
M 27	3,00	24,00	160,0	38,0	20,0
M 30	3,50	26,50	180,0	45,0	22,0

Nominal thread size						
M 3	—	233 030 E	233 030 VA	—	233 030 EF	1
M 4	—	233 040 E	233 040 VA	—	233 040 EF	1
M 5	—	233 050 E	233 050 VA	—	233 050 EF	1
M 6	—	233 060 E	233 060 VA	—	233 060 EF	1
M 8	—	233 080 E	233 080 VA	—	233 080 EF	1
M 10	—	233 100 E	233 100 VA	—	233 100 EF	1
M 12	233 120	233 120 E	233 120 VA	233 120 T	233 120 EF	1
M 14	233 140	233 140 E	233 140 VA	233 140 T	233 140 EF	1
M 16	233 160	233 160 E	233 160 VA	233 160 T	233 160 EF	1
M 18	233 180	233 180 E	233 180 VA	233 180 T	233 180 EF	1
M 20	233 200	233 200 E	233 200 VA	233 200 T	233 200 EF	1
M 22	233 220	233 220 E	233 220 VA	233 220 T	233 220 EF	1
M 24	233 240	233 240 E	233 240 VA	233 240 T	233 240 EF	1
M 27	233 270	233 270 E	233 270 VA	233 270 T	233 270 EF	1
M 30	233 300	233 300 E	233 300 VA	233 300 T	233 300 EF	1

Machine tap sets HSS and HSSE-Co 5, in steel case

		<div>HSS</div> <div></div>	<div>HSSE Co 5</div> <div></div>	<div>HSSE Co 5</div> <div></div>	<div>HSS</div> <div>TIN</div>	<div>HSSE Co 5</div> <div>TiAlN</div>
<div>B</div> <div></div>	7-piece set of machine taps M DIN 371 / 376 type B with progressive tap M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12	245 057	245 061	245 063	245 065	245 068
<div>C</div> <div></div>	7-piece set of machine taps M DIN 371 / 376 type C / 35° right-hand spiral flutes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12	245 058	245 062	245 064	245 066	245 069
<div>B</div> <div></div>	14-piece set of machine taps 7 machine taps DIN 371 / 376 type B with progressive tap M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 type N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm	245 048	245 051	—	—	—
<div>C</div> <div></div>	14-piece set of machine taps 7 machine taps DIN 371 / 376 type C / 35° right-hand spiral flutes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 type N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm	245 049	245 052	—	—	—
<div>B</div> <div></div> <div>C</div> <div></div>	21-piece set of machine taps 7 machine taps DIN 371 / 376 type B with progressive tap M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 machine taps DIN 371 / 376 type C / 35° right-hand spiral flutes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 Typ N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm	—	245 054	—	—	—



Machine tap sets HSS and HSSE-Co 5, in plastic case

		HSS	HSSE Co 5	HSSE Co 5	HSS	TIN	HSSE Co 5	TITAN
B 	7-piece set of machine taps M DIN 371 / 376 type B with progressive tap M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12	245 057 RO	245 061 RO	245 063 RO	245 065 RO	245 068 RO		
C 	7-piece set of machine taps M DIN 371 / 376 type C / 35° right-hand spiral flutes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12	245 058 RO	245 062 RO	245 064 RO	245 066 RO	245 069 RO		
B 	14-piece set of machine taps 7 machine taps DIN 371 / 376 type B with progressive tap M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 type N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm	245 048 RO	245 051 RO	—	—	—		
C 	14-piece set of machine taps 7 machine taps DIN 371 / 376 type C / 35° right-hand spiral flutes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 type N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm	245 049 RO	245 052 RO	—	—	—		
B C 	21-piece set of machine taps 7 machine taps DIN 371 / 376 type B with progressive tap M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 machine taps DIN 371 / 376 type C / 35° right-hand spiral flutes M 3 - M 4 - M 5 - M 6 - M 8 - M 10 - M 12 + 7 twist drills DIN 338 Typ N Ø 2,5 - 3,3 - 4,2 - 5,0 - 6,8 - 8,5 - 10,2 mm	—	—	—	—	—		





Machine taps M DIN 371/376 HSS, ground with interrupted threads

Chamfer: type B, 4 - 5 threads with progressive tap and interrupted threads

Thread: metric, DIN ISO 13

Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm2) < 800	<input type="checkbox"/>	Brass	<input type="checkbox"/>
Steel (N/mm2) < 1000	<input type="checkbox"/>	Bronze	<input type="checkbox"/>
Steel (N/mm2) < 1200	<input type="checkbox"/>	Plastics	<input checked="" type="checkbox"/>
Rust-resistant steel	<input type="checkbox"/>	Cast iron	<input type="checkbox"/>
Aluminium	<input checked="" type="checkbox"/>	Titanium alloyed	<input type="checkbox"/>



DIN 371 Machine tap with reinforced shank, for through threads in aluminium, aluminium alloys, bronze, copper, nickel and plastics.

Nominal thread size	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm	HSS		
M 3	0,50	2,50	56,0	11,0	3,5	272 030	1	
M 4	0,70	3,30	63,0	13,0	4,5	272 040	1	
M 5	0,80	4,20	70,0	16,0	6,0	272 050	1	
M 6	1,00	5,00	80,0	19,0	6,0	272 060	1	
M 8	1,25	6,80	90,0	22,0	8,0	272 080	1	
M 10	1,50	8,50	100,0	24,0	10,0	272 100	1	

DIN 376 Machine tap with overflow shank, for through threads in aluminium, aluminium alloys, bronze, copper, nickel and plastics.

Nominal thread size	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm	HSS		
M 12	1,75	10,20	110,0	29,0	9,0	272 120	1	
M 14	2,00	12,00	110,0	30,0	11,0	272 140	1	
M 16	2,00	14,00	110,0	32,0	12,0	272 160	1	
M 18	2,50	15,50	125,0	34,0	14,0	272 180	1	
M 20	2,50	17,50	140,0	34,0	16,0	272 200	1	
M 22	2,50	19,50	140,0	34,0	18,0	272 220	1	
M 24	3,00	21,00	160,0	38,0	18,0	272 240	1	

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.



Machine taps M DIN 371/376 HSSE-Co 5 TiCN, ground

Chamfer: type C / 2 - 3 threads

Thread: metric, DIN ISO 13

Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm2) < 800		Brass	
Steel (N/mm2) < 1000		Bronze	
Steel (N/mm2) < 1200		Plastics	
Rust-resistant steel		Cast iron	
Aluminium		Titanium alloyed	



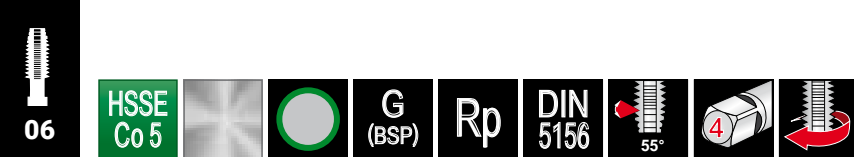
DIN 371 Machine taps with reinforced shank for through-hole thread in cast iron and cast alloys.

Nominal thread size	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm	HSSE Co 5 TiCN	
M 3	0,50	2,50	56,0	11,0	3,5	273 030 ETC	1
M 4	0,70	3,30	63,0	13,0	4,5	273 040 ETC	1
M 5	0,80	4,20	70,0	16,0	6,0	273 050 ETC	1
M 6	1,00	5,00	80,0	19,0	6,0	273 060 ETC	1
M 8	1,25	6,80	90,0	22,0	8,0	273 080 ETC	1
M 10	1,50	8,50	100,0	24,0	10,0	273 100 ETC	1

DIN 376 Machine taps with reduced shank for through-hole thread in cast iron and cast alloys.

Nominal thread size	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm	HSSE Co 5 TiCN	
M 12	1,75	10,20	110,0	29,0	9,0	273 120 ETC	1
M 14	2,00	12,00	110,0	30,0	11,0	273 140 ETC	1
M 16	2,00	14,00	110,0	32,0	12,0	273 160 ETC	1
M 18	2,50	15,50	125,0	34,0	14,0	273 180 ETC	1
M 20	2,50	17,50	140,0	34,0	16,0	273 200 ETC	1
M 22	2,50	19,50	140,0	34,0	18,0	273 220 ETC	1
M 24	3,00	21,00	160,0	38,0	18,0	273 240 ETC	1

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.

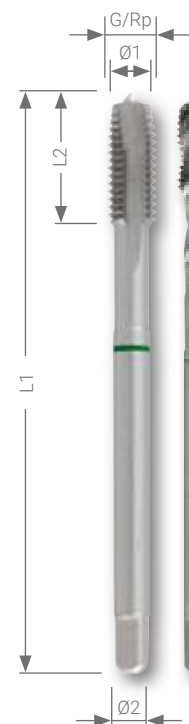


Machine taps G DIN 5156 HSSE-Co 5, ground

Thread: DIN ISO 228 "G" (cylindrical pipe thread)
DIN 2999 "Rp" (Whitworth pipe thread)
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm2) < 800	■	Brass	■
Steel (N/mm2) < 1000	■	Bronze	□
Steel (N/mm2) < 1200		Plastics	□
Rust-resistant steel	□	Cast iron	□
Aluminium	□	Titanium alloyed	



B Machine taps with overflow shank for through threads.

Nominal thread size G / Rp		Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm	HSSE Co 5		
G 1/8	Rp 1/8	28	8,80	90,0	20,0	7,0	262 018 E	1	
G 1/4	Rp 1/4	19	11,80	100,0	22,0	11,0	262 014 E	1	
G 3/8	Rp 3/8	19	15,25	100,0	22,0	12,0	262 038 E	1	
G 1/2	Rp 1/2	14	19,00	125,0	25,0	16,0	262 012 E	1	
G 5/8	Rp 5/8	14	21,00	125,0	25,0	18,0	262 058 E	1	
G 3/4	Rp 3/4	14	24,50	140,0	28,0	20,0	262 034 E	1	
G 7/8	Rp 7/8	14	28,25	150,0	28,0	22,0	262 078 E	1	
G 1"	Rp 1"	11	30,75	160,0	30,0	25,0	262 010 E	1	
G 1 1/8	Rp 1 1/8	11	35,50	170,0	30,0	28,0	262 118 E	1	
G 1 1/4	Rp 1 1/4	11	39,50	170,0	30,0	32,0	262 114 E	1	
G 1 3/8	Rp 1 3/8	11	41,80	180,0	32,0	36,0	262 138 E	1	
G 1 1/2	Rp 1 1/2	11	45,25	190,0	32,0	36,0	262 112 E	1	
G 1 3/4	Rp 1 3/4	11	51,30	190,0	32,0	40,0	262 134 E	1	
G 2"	Rp 2"	11	57,20	220,0	40,0	45,0	262 020 E	1	

C Machine taps with overflow shank and 35° right-hand spiral flutes for bottoming.

Nominal thread size G / Rp		Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm	HSSE Co 5		
G 1/8	Rp 1/8	28	8,80	90,0	20,0	7,0	263 018 E	1	
G 1/4	Rp 1/4	19	11,80	100,0	22,0	11,0	263 014 E	1	
G 3/8	Rp 3/8	19	15,25	100,0	22,0	12,0	263 038 E	1	
G 1/2	Rp 1/2	14	19,00	125,0	25,0	16,0	263 012 E	1	
G 5/8	Rp 5/8	14	21,00	125,0	25,0	18,0	263 058 E	1	
G 3/4	Rp 3/4	14	24,50	140,0	28,0	20,0	263 034 E	1	
G 7/8	Rp 7/8	14	28,25	150,0	28,0	22,0	263 078 E	1	
G 1"	Rp 1"	11	30,75	160,0	30,0	25,0	263 010 E	1	
G 1 1/8	Rp 1 1/8	11	35,50	170,0	30,0	28,0	263 118 E	1	
G 1 1/4	Rp 1 1/4	11	39,50	170,0	30,0	32,0	263 114 E	1	
G 1 3/8	Rp 1 3/8	11	41,80	180,0	32,0	36,0	263 138 E	1	
G 1 1/2	Rp 1 1/2	11	45,25	190,0	32,0	36,0	263 112 E	1	
G 1 3/4	Rp 1 3/4	11	51,30	190,0	32,0	40,0	263 134 E	1	
G 2"	Rp 2"	11	57,20	220,0	40,0	45,0	263 020 E	1	

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.



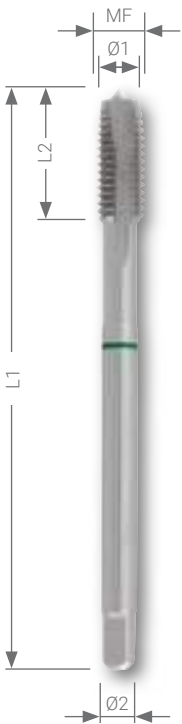


Machine taps MF DIN 374 HSSE-Co 5, ground

Thread: metric, fine, DIN ISO 13
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm2) < 800	■	Brass	■
Steel (N/mm2) < 1000	■	Bronze	□
Steel (N/mm2) < 1200		Plastics	□
Rust-resistant steel	□	Cast iron	□
Aluminium	□	Titanium alloyed	



Machine tap with overflow shank for through threads.

Nominal thread size MF	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm	HSSE Co 5		
MF 4	0,50	3,50	63,0	10,0	2,8	260 041 E	1	
MF 5	0,50	4,50	70,0	12,0	3,5	260 050 E	1	
MF 6	0,75	5,20	80,0	14,0	4,5	260 060 E	1	
MF 8	1,00	7,00	90,0	22,0	6,0	260 081 E	1	
MF 10	1,00	9,00	90,0	20,0	7,0	260 100 E	1	
MF 10	1,25	8,80	100,0	24,0	7,0	260 101 E	1	
MF 12	1,00	11,00	100,0	20,0	9,0	260 122 E	1	
MF 12	1,25	10,80	100,0	22,0	9,0	260 121 E	1	
MF 12	1,50	10,50	100,0	22,0	9,0	260 120 E	1	
MF 14	1,00	13,00	100,0	20,0	11,0	260 142 E	1	
MF 14	1,25	12,80	100,0	22,0	11,0	260 143 E	1	
MF 14	1,50	12,50	100,0	22,0	11,0	260 141 E	1	
MF 16	1,00	15,00	100,0	20,0	12,0	260 161 E	1	
MF 16	1,50	14,50	100,0	22,0	12,0	260 160 E	1	
MF 18	1,00	17,00	110,0	25,0	14,0	260 181 E	1	
MF 18	1,50	16,50	110,0	25,0	14,0	260 180 E	1	
MF 18	2,00	16,00	125,0	34,0	14,0	260 182 E	1	
MF 20	1,00	19,00	125,0	25,0	16,0	260 201 E	1	
MF 20	1,50	18,50	125,0	25,0	16,0	260 200 E	1	
MF 20	2,00	18,00	140,0	34,0	16,0	260 202 E	1	
MF 22	1,50	20,50	125,0	25,0	18,0	260 220 E	1	
MF 22	2,00	20,00	140,0	34,0	18,0	260 222 E	1	
MF 24	1,00	23,00	140,0	28,0	18,0	260 242 E	1	
MF 24	1,50	22,50	140,0	28,0	18,0	260 240 E	1	
MF 24	2,00	22,00	140,0	28,0	18,0	260 241 E	1	
MF 28	1,50	26,50	140,0	28,0	20,0	260 281 E	1	
MF 28	2,00	26,00	140,0	28,0	20,0	260 282 E	1	
MF 30	1,50	28,50	150,0	28,0	22,0	260 301 E	1	
MF 30	2,00	28,00	150,0	28,0	22,0	260 302 E	1	

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.

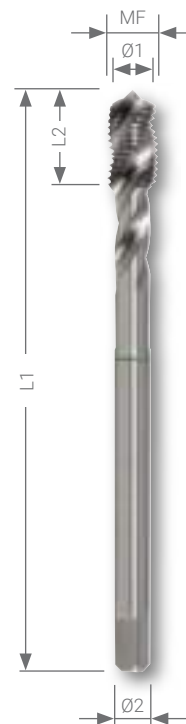


Machine taps MF DIN 374 HSSE-Co 5, ground

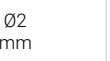


Thread: metric, fine, DIN ISO 13
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm ²) < 800	■	Brass	■
Steel (N/mm ²) < 1000	■	Bronze	□
Steel (N/mm ²) < 1200		Plastics	□
Rust-resistant steel	□	Cast iron	□
Aluminium	□	Titanium alloyed	



Machine taps with overflow shank and 35° right-hand spiral flutes for bottoming.

Nominal thread size MF	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 max. mm	Ø2 mm			
MF 4	0,50	3,50	63,0	10,0	2,8	261 041 E		1
MF 5	0,50	4,50	70,0	12,0	3,5	261 050 E		1
MF 6	0,75	5,20	80,0	14,0	4,5	261 060 E		1
MF 8	1,00	7,00	90,0	22,0	6,0	261 081 E		1
MF 10	1,00	9,00	90,0	20,0	7,0	261 100 E		1
MF 10	1,25	8,80	100,0	24,0	7,0	261 101 E		1
MF 12	1,00	11,00	100,0	20,0	9,0	261 122 E		1
MF 12	1,25	10,80	100,0	22,0	9,0	261 121 E		1
MF 12	1,50	10,50	100,0	22,0	9,0	261 120 E		1
MF 14	1,00	13,00	100,0	20,0	11,0	261 142 E		1
MF 14	1,25	12,80	100,0	22,0	11,0	261 143 E		1
MF 14	1,50	12,50	100,0	22,0	11,0	261 141 E		1
MF 16	1,00	15,00	100,0	20,0	12,0	261 161 E		1
MF 16	1,50	14,50	100,0	22,0	12,0	261 160 E		1
MF 18	1,00	17,00	110,0	25,0	14,0	261 181 E		1
MF 18	1,50	16,50	110,0	25,0	14,0	261 180 E		1
MF 18	2,00	16,00	125,0	34,0	14,0	261 182 E		1
MF 20	1,00	19,00	125,0	25,0	16,0	261 201 E		1
MF 20	1,50	18,50	125,0	25,0	16,0	261 200 E		1
MF 20	2,00	18,00	140,0	34,0	16,0	261 202 E		1
MF 22	1,50	20,50	125,0	25,0	18,0	261 220 E		1
MF 22	2,00	20,00	140,0	34,0	18,0	261 222 E		1
MF 24	1,00	23,00	140,0	28,0	18,0	261 242 E		1
MF 24	1,50	22,50	140,0	28,0	18,0	261 240 E		1
MF 24	2,00	22,00	140,0	28,0	18,0	261 241 E		1
MF 28	1,50	26,50	140,0	28,0	20,0	261 281 E		1
MF 28	2,00	26,00	140,0	28,0	20,0	261 282 E		1
MF 30	1,50	28,50	150,0	28,0	22,0	261 301 E		1
MF 30	2,00	28,00	150,0	28,0	22,0	261 302 E		1

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.

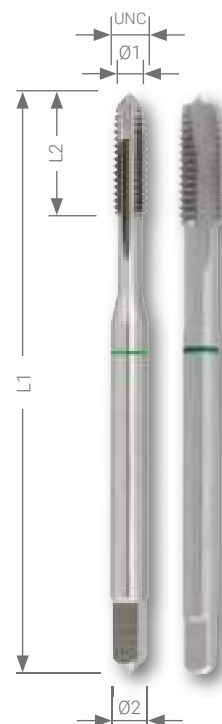


Machine taps UNC HSSE-Co 5, ground

Thread: American UNC coarse thread
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm2) < 800	■	Brass	■
Steel (N/mm2) < 1000	■	Bronze	□
Steel (N/mm2) < 1200		Plastics	□
Rust-resistant steel	□	Cast iron	□
Aluminium	□	Titanium alloyed	



Machine taps with reinforced shank for through threads.

Nominal thread size UNC	Threads per inch	Thread core hole 1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co 5		
Nr. 4	40	2,3	56,0	11,0	3,5	265 040 UNC	1	
Nr. 5	40	2,6	56,0	11,0	3,5	265 050 UNC	1	
Nr. 6	32	2,8	56,0	13,0	4,0	265 060 UNC	1	
Nr. 8	32	3,5	63,0	13,0	4,5	265 080 UNC	1	
Nr. 10	24	3,8	70,0	16,0	6,0	265 100 UNC	1	
Nr. 12	24	4,5	70,0	16,0	6,0	265 120 UNC	1	
1/4	20	5,1	80,0	17,0	7,0	265 014 UNC	1	
5/16	18	6,5	90,0	20,0	8,0	265 516 UNC	1	
3/8	16	8,0	100,0	22,0	9,0	265 038 UNC	1	

Machine taps with overflow shank for through threads.

Nominal thread size UNC	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co 5		
7/16	14	9,3	100,0	22,0	8,0	265 716 UNC	1	
1/2	13	10,8	110,0	25,0	9,0	265 012 UNC	1	
9/16	12	12,2	110,0	26,0	11,0	265 916 UNC	1	
5/8	11	13,5	110,0	27,0	12,0	265 058 UNC	1	
3/4	10	16,5	125,0	30,0	14,0	265 034 UNC	1	
7/8	9	19,3	140,0	32,0	18,0	265 078 UNC	1	
1"	8	22,2	160,0	36,0	18,0	265 010 UNC	1	

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.

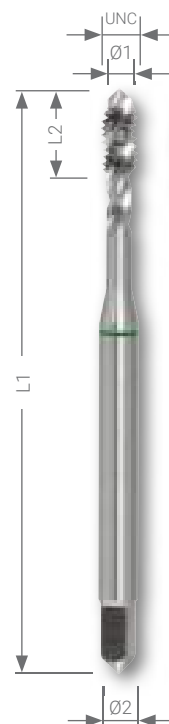


Machine taps UNC HSSE-Co 5, ground

Thread: American UNC coarse thread
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm ²) < 800	■	Brass	■
Steel (N/mm ²) < 1000	■	Bronze	□
Steel (N/mm ²) < 1200		Plastics	□
Rust-resistant steel	□	Cast iron	□
Aluminium	□	Titanium alloyed	



Machine taps with reinforced shank and 35° right-hand spiral flutes for bottoming.

Nominal thread size UNC	Threads per inch	Thread core hole 1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co 5	
Nr. 4	40	2,3	56,0	7,0	3,5	266 040 UNC	1
Nr. 5	40	2,6	56,0	7,0	3,5	266 050 UNC	1
Nr. 6	32	2,8	56,0	8,0	4,0	266 060 UNC	1
Nr. 8	32	3,5	63,0	8,0	4,5	266 080 UNC	1
Nr. 10	24	3,8	70,0	10,0	6,0	266 100 UNC	1
Nr. 12	24	4,5	70,0	10,0	6,0	266 120 UNC	1
1/4	20	5,1	80,0	13,0	7,0	266 014 UNC	1
5/16	18	6,5	90,0	14,0	8,0	266 516 UNC	1
3/8	16	8,0	100,0	16,0	10,0	266 038 UNC	1

Machine taps with overflow shank and 35° right-hand spiral flutes for bottoming.

Nominal thread size UNC	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co 5	
7/16	14	9,3	100,0	17,0	8,0	266 716 UNC	1
1/2	13	10,8	110,0	20,0	9,0	266 012 UNC	1
9/16	12	12,2	110,0	20,0	11,0	266 916 UNC	1
5/8	11	13,5	110,0	22,0	12,0	266 058 UNC	1
3/4	10	16,5	125,0	25,0	14,0	266 034 UNC	1
7/8	9	19,3	140,0	27,0	18,0	266 078 UNC	1
1"	8	22,2	160,0	30,0	18,0	266 010 UNC	1

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.

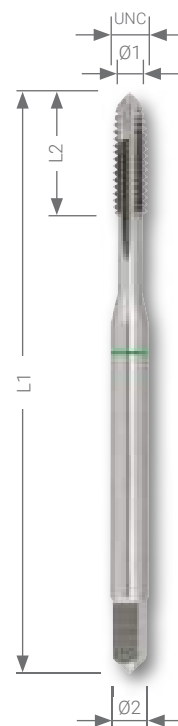


Machine taps UNF HSSE-Co 5, ground

Thread: American UNF fine thread
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm2) < 800	■	Brass	■
Steel (N/mm2) < 1000	■	Bronze	□
Steel (N/mm2) < 1200		Plastics	□
Rust-resistant steel	□	Cast iron	□
Aluminium	□	Titanium alloyed	



Machine taps with reinforced shank for through threads.

Nominal thread size UNF	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co 5		
Nr. 4	48	2,40	56,0	11,0	3,5	265 040 UNF	1	
Nr. 5	44	2,70	56,0	11,0	3,5	265 050 UNF	1	
Nr. 6	40	2,95	56,0	13,0	4,0	265 060 UNF	1	
Nr. 8	36	3,50	63,0	13,0	4,5	265 080 UNF	1	
Nr. 10	32	4,10	70,0	16,0	6,0	265 100 UNF	1	
Nr. 12	28	4,60	70,0	16,0	6,0	265 120 UNF	1	
1/4	28	5,50	80,0	17,0	7,0	265 014 UNF	1	
5/16	24	6,60	90,0	17,0	8,0	265 516 UNF	1	
3/8	24	8,50	100,0	18,0	10,0	265 038 UNF	1	

Machine taps with overflow shank for through threads.

Nominal thread size UNF	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co 5		
7/16	20	9,90	100,0	22,0	8,0	265 716 UNF	1	
1/2	20	11,50	100,0	22,0	9,0	265 012 UNF	1	
9/16	18	12,90	100,0	22,0	11,0	265 916 UNF	1	
5/8	18	14,50	100,0	22,0	12,0	265 058 UNF	1	
3/4	16	17,50	110,0	25,0	14,0	265 034 UNF	1	
7/8	14	20,50	140,0	26,0	18,0	265 078 UNF	1	
1"	12	23,25	150,0	28,0	18,0	265 010 UNF	1	

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.

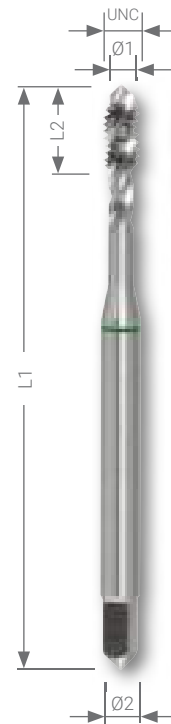


Machine taps UNF HSSE-Co 5, ground

Thread: American UNF fine thread
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm ²) < 800	■	Brass	■
Steel (N/mm ²) < 1000	■	Bronze	□
Steel (N/mm ²) < 1200		Plastics	□
Rust-resistant steel	□	Cast iron	□
Aluminium	□	Titanium alloyed	



Machine taps with reinforced shank and 35° right-hand spiral flutes for bottoming.

Nominal thread size UNF	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co 5	
Nr. 4	48	2,40	56,0	5,5	3,5	266 040 UNF	1
Nr. 5	44	2,70	56,0	6,0	3,5	266 050 UNF	1
Nr. 6	40	2,95	56,0	7,0	4,0	266 060 UNF	1
Nr. 8	36	3,50	63,0	7,5	4,5	266 080 UNF	1
Nr. 10	32	4,10	70,0	8,0	6,0	266 100 UNF	1
Nr. 12	28	4,60	70,0	9,0	6,0	266 120 UNF	1
1/4	28	5,50	80,0	10,0	7,0	266 014 UNF	1
5/16	24	6,90	90,0	10,0	8,0	266 516 UNF	1
3/8	24	8,50	100,0	10,0	10,0	266 038 UNF	1

Machine taps with overflow shank and 35° right-hand spiral flutes for bottoming.

Nominal thread size UNF	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co 5	
7/16	20	9,90	100,0	13,0	8,0	266 716 UNF	1
1/2	20	11,50	100,0	13,0	9,0	266 012 UNF	1
9/16	18	12,90	100,0	15,0	11,0	266 916 UNF	1
5/8	18	14,50	100,0	15,0	12,0	266 058 UNF	1
3/4	16	17,50	110,0	17,0	14,0	266 034 UNF	1
7/8	14	20,50	140,0	17,0	18,0	266 078 UNF	1
1"	12	23,25	150,0	20,0	18,0	266 010 UNF	1

Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.



Machine taps PG HSS, ground

Machine taps with overflow shank for through threads.

Thread: DIN 40 430 steel conduit thread
Flanks: relief-ground

Packing unit: individual plastic pack

Steel (N/mm2) < 800	■	Brass	■
Steel (N/mm2) < 1000		Bronze	□
Steel (N/mm2) < 1200		Plastics	□
Rust-resistant steel		Cast iron	□
Aluminium	□	Titanium alloyed	



Nominal thread size PG	Threads per inch	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSS	
PG 7	20	11,35	70,0	22,0	9,0	264 007	1
PG 9	18	13,95	70,0	22,0	12,0	264 009	1
PG 11	18	17,35	80,0	22,0	14,0	264 011	1
PG 13,5	18	19,15	80,0	22,0	16,0	264 135	1
PG 16	18	21,25	80,0	22,0	18,0	264 016	1
PG 21	16	26,95	90,0	22,0	22,0	264 021	1
PG 29	16	35,60	100,0	25,0	28,0	264 029	1
PG 36	16	45,60	140,0	40,0	36,0	264 036	1
PG 42	16	52,60	140,0	40,0	40,0	264 042	1
PG 48	16	57,90	160,0	40,0	45,0	264 048	1



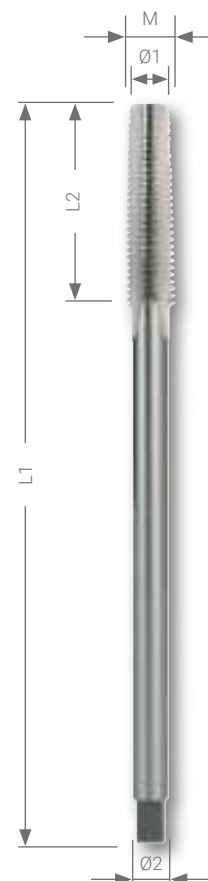
Nut taps M DIN 357 HSS, ground

Long shank to retain several cut nuts.

Chamfer: 2/3 of the thread length
Thread: metric, DIN ISO 13
Flanks: relief-ground

Packing unit: individual plastic pack

Nominal thread size M	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSS	
M 3	0,50	2,5	70,0	22,0	2,2	243 030	1
M 4	0,70	3,3	90,0	25,0	2,8	243 040	1
M 5	0,80	4,2	100,0	28,0	3,5	243 050	1
M 6	1,00	5,0	110,0	32,0	4,5	243 060	1
M 8	1,25	6,8	125,0	40,0	6,0	243 080	1
M 10	1,50	8,5	140,0	45,0	7,0	243 100	1
M 12	1,75	10,2	180,0	50,0	9,0	243 120	1
M 14	2,00	12,0	200,0	56,0	11,0	243 140	1
M 16	2,00	14,0	200,0	63,0	12,0	243 160	1
M 18	2,50	15,5	220,0	63,0	14,0	243 180	1
M 20	2,50	17,5	250,0	70,0	16,0	243 200	1
M 22	2,50	19,5	280,0	80,0	18,0	243 220	1
M 24	3,00	21,0	280,0	80,0	18,0	243 240	1



Schematic illustration. Smaller diameters can be supplied with a tip for production reasons.



Forming taps DIN 2174 HSSE-Co 5-nitrated-VAP and HSSE-Co 5-TiAlN, ground

Forming taps with reinforced shank for through threads and bottoming.

Thread: metric, DIN ISO 13
Flanks: relief-ground

As shaping is done without cutting, no interruption of the course of the fibre in the material. The deformation creates very rigid threads. Consistent accuracy even with high productivity.

HSSE-Co 5-nitrated-VAP HSSE-Co 5 TiAlN

The forming tap consists of cobalt alloyed, nitrated and vaporised heavy-duty high-speed steel. Applications: for non-alloyed and alloyed steels up to a strength of 1000 N/mm² and non-ferrous metals.

The forming tap consists of cobalt alloyed heavy-duty high-speed steel with titanium aluminium nitride coating. Applications: for non-alloyed and alloyed steels up to a strength of 1000 N/mm², V2A and non-ferrous metals.



Packing unit: individual plastic pack



271 ... N



271 ... F

	HSSE Co5	HSSE Co5 TiAlN
Steel (N/mm ²) < 800	■	■
Steel (N/mm ²) < 1000	■	■
Steel (N/mm ²) < 1200		■
Rust-resistant steel	□	■
Aluminium	□	□

	HSSE Co5	HSSE Co5 TiAlN
Brass	■	■
Bronze	□	□
Plastics	□	□
Cast iron	□	□
Titanium alloyed		□

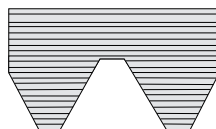
Nominal thread size M	Pitch mm	Thread core hole Ø1 mm	L1 mm	L2 mm	Ø2 mm	HSSE Co5	HSSE Co5 TiAlN	
M 3	0,50	2,80	56,0	11,0	3,5	271 003 N	271 003 F	1
M 4	0,70	3,70	63,0	13,0	4,5	271 004 N	271 004 F	1
M 5	0,80	4,65	70,0	16,0	6,0	271 005 N	271 005 F	1
M 6	1,00	5,55	80,0	19,0	6,0	271 006 N	271 006 F	1
M 8	1,25	7,45	90,0	22,0	8,0	271 008 N	271 008 F	1
M 10	1,50	9,35	100,0	24,0	10,0	271 010 N	271 010 F	1
M 12	1,75	11,20	110,0	28,0	9,0	271 012 N	271 012 F	1



General information:

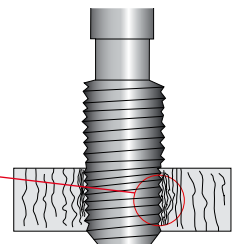
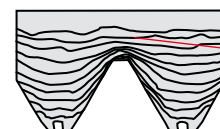
Tapping

Fibre orientation in tapping



Thread forming

Fibre orientation in thread forming



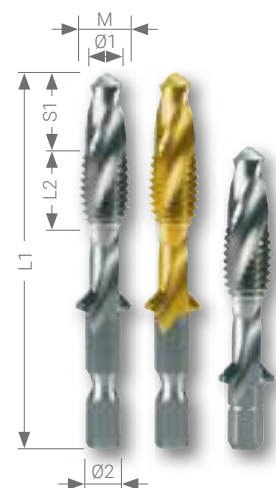


Combined machine drill taps “long series” and “short series” HSS and HSS-TiN ground

Combined machine drill tap with ¼" hexagon shank for drilling and through hole tapping in a single operation

Flanks: relief-ground
Shank: 6,35 x 27,0 mm

The combined machine tap is suitable for sheet metal working with right/left handed rotation cordless drilling machines. The thread is cut in one operation, without any tool changing. The tool incorporates a twist drill before the thread-tapping part.



Cooperation work process:

- ✓ hole drilling with twist drill
- ✓ thread cutting (tapping)
- ✓ thread deburring
- ✓ thread cleaning when using

HSS

Applications:
for unalloyed and low-alloyed steels up to 600 N/mm² strength, malleable cast iron and non-ferrous metals.

HSS-TiN

Applications:
for unalloyed and low-alloyed steels up to 900 N/mm² strength, malleable cast iron and non-ferrous metals.

Packing unit: individual plastic pack



Steel (N/mm ²) < 800	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Steel (N/mm ²) < 1000	<input type="checkbox"/>	<input type="checkbox"/>
Steel (N/mm ²) < 1200	<input type="checkbox"/>	<input type="checkbox"/>
Rust-resistant steel	<input type="checkbox"/>	<input type="checkbox"/>
Aluminium	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Brass	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Bronze	<input type="checkbox"/>	<input type="checkbox"/>
Plastics	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Cast iron	<input type="checkbox"/>	<input type="checkbox"/>
Titanium alloyed	<input type="checkbox"/>	<input type="checkbox"/>

Combined machine drill taps “long series” HSS and HSS-TiN ground

Nominal thread size M	Pitch mm	L1 mm	S1 mm	L2 mm	Ø1 mm	Ø2 mm			
M 3	0,50	51,0	5,0	7,0	2,5	7,0	270 014	270 014 T	1
M 4	0,70	54,0	6,0	8,5	3,3	7,0	270 015	270 015 T	1
M 5	0,80	57,0	7,0	10,0	4,2	7,0	270 016	270 016 T	1
M 6	1,00	60,0	8,0	12,0	5,0	7,0	270 017	270 017 T	1
M 8	1,25	68,0	11,0	15,0	6,8	9,5	270 018	270 018 T	1
M 10	1,50	75,0	15,0	17,0	8,5	11,5	270 019	270 019 T	1

Combined machine drill taps “short series” HSS and HSS-TiN ground

Nominal thread size M	Pitch mm	L1 mm	S1 mm	L2 mm	Ø1 mm	Ø2 mm			
M 3	0,50	36,0	5,0	6,0	2,5	7,2	R 270 014	R 270 014 T	1
M 4	0,70	39,0	6,0	8,0	3,3	7,2	R 270 015	R 270 015 T	1
M 5	0,80	41,0	7,0	9,0	4,2	7,2	R 270 016	R 270 016 T	1
M 6	1,00	44,0	8,0	11,0	5,0	7,2	R 270 017	R 270 017 T	1
M 8	1,25	51,0	11,0	14,0	6,8	8,8	R 270 018	R 270 018 T	1
M 10	1,50	59,0	15,0	15,0	8,5	11,0	R 270 019	R 270 019 T	1



Combined machine drill tap sets "long series" HSS and HSS-TiN ground in steel case

	HSS	HSS TiN
7-piece set of combined machine taps "long" 6 combined machine taps M 3 - M 4 - M 5 - M 6 - M 8 - M 10 + 1 hexagon magnetic holder	270 020	270 020 T



Combined machine drill tap sets "short series" HSS and HSS-TiN ground in steel case

	HSS	HSS TiN
7-piece set of combined machine taps "short" 6 combined machine taps M 3 - M 4 - M 5 - M 6 - M 8 - M 10 + 1 hexagon magnetic holder	R 270 020	R 270 021 T



Magnetic bit holder for 1/4" hexagonal shank tools

Packing unit: in plastic tubes of 1

	Article no.	
Magnetic bit holder	270 013	1





Thread-extractor sets in plastic case

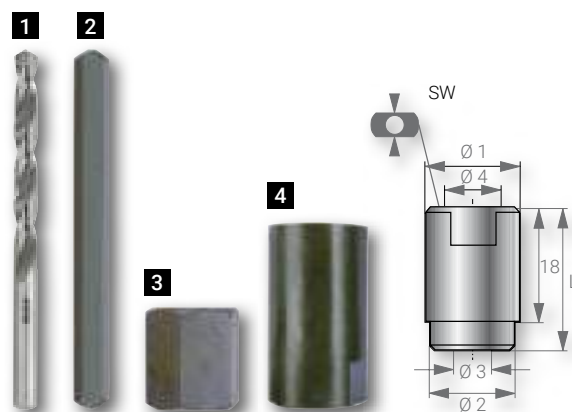
Set 1: 21 pieces in plastic case for threads upto M 12 Ø 4 twist drills, 4 studs, 4 extractor nuts and 9 drilling jigs	244 150
Set 2: 25 pieces in plastic case for threads upto M 16 Ø 5 twist drills, 5 studs, 5 extractor nuts and 10 drilling jigs	244 151



1 High-performance twist drills DIN 338 HSS ground



ground version, made to match the drilling jigs exactly

Ø mm	Ø inch	for stud size	Length mm		
3,2	1/8	1 - 4	65,0	214 032	1
4,8	3/16	5 - 7	86,0	214 048	1
6,4	1/4	8	101,0	214 064	1
8,0	5/16	9	117,0	214 080	1
8,7	11/32	10	125,0	214 087	1





2 Studs

made of special steel profile, hardened, gunmetal finish

Size	For threads	Ø mm	Ø inch	Length mm		
1	M 5 - M 6	3,2	1/8	60,0	244 001	1
2	M 7 - M 8	4,8	3/16	70,0	244 002	1
3	M 9 - M 10	6,4	1/4	78,0	244 003	1
4	M 12	8,0	5/16	83,0	244 004	1
5	M 14 - M 16	8,7	11/32	94,0	244 005	1



3 Extractor nuts

with special inside profile, hardened, gunmetal finish

Size	For stud size	Spanner width mm	Length mm		
1	1	10,0	16,0	244 032	1
2	2	11,0	16,0	244 046	1
3	3	13,0	16,0	244 064	1
4	4	14,0	16,0	244 080	1
5	5	17,0	16,0	244 087	1

4 Drilling jigs

Reduced shank, hardened, gunmetal finish. Suitable for sunken broken screws use (Ø 1 + Ø 2). For raised or protruding broken screws use (Ø 4).

Size	Ø 1 mm	Ø 2 mm	Ø 3 mm	Ø 4 mm	Ø 3 Zoll	Ø 4 Zoll	SW mm	L mm		
1	7,0	6,0	3,2	5,0	1/8	3/16	6,0	30,0	244 101	1
2	8,0	7,0	3,2	6,0	1/8	—	7,0	30,0	244 102	1
3	9,0	—	3,2	7,0	1/8	1/4	8,0	30,0	244 103	1
4	10,0	—	3,2	8,0	1/8	5/16	9,0	30,0	244 104	1
5	11,0	—	4,8	8,0	3/16	5/16	9,0	30,0	244 105	1
6	12,0	—	4,8	9,0	3/16	—	10,0	30,0	244 106	1
7	13,0	—	4,8	10,0	3/16	1/8	11,0	30,0	244 107	1
8	14,0	—	6,4	11,0	1/4	7/16	12,0	30,0	244 108	1
9	15,0	—	8,0	12,0	5/16	—	13,0	30,0	244 109	1
10	17,0	16,0	8,7	14,0	11/32	—	14,0	30,0	244 110	1

Instructions for use



No. 1
Drill into broken thread
with drilling jig

No. 2
Drive in stud and screw nut down to the base.

No. 3
Turn broken screw out steadily without tilting



THREAD REPAIR TOOLS

FASCINATION FOR PRECISION®

Thread Inserts

Standard design, stainless steel and free running.

Thread reinforcement for materials with low shearing strenght, e.g. aluminium alloys and magnesium alloys as well as to repair enables worn and damaged threads.

Packing unit: in plastic box

Nominal thread size	Pitch mm	Height = factor x Ø	Article no.	
M 3	0,50	1,0	244 303	50
M 4	0,70	1,0	244 304	50
M 5	0,80	1,0	244 305	50
M 6	1,00	1,0	244 306	50
M 8	1,25	1,0	244 308	50
M 10	1,50	1,0	244 310	50
M 12	1,75	1,0	244 312	25
M 14	2,00	1,0	244 314	25
MF 14	1,25	1,0	244 315	25

M 3	0,50	1,5	244 403	50
M 4	0,70	1,5	244 404	50
M 5	0,80	1,5	244 405	50
M 6	1,00	1,5	244 406	50
M 8	1,25	1,5	244 408	50
M 10	1,50	1,5	244 410	50
M 12	1,75	1,5	244 412	25
M 14	2,00	1,5	244 414	25
MF 14	1,25	1,5	244 415	25

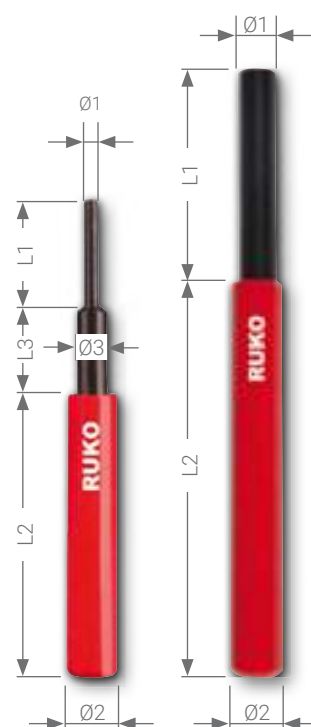
M 3	0,50	2,0	244 503	50
M 4	0,70	2,0	244 504	50
M 5	0,80	2,0	244 505	50
M 6	1,00	2,0	244 506	50
M 8	1,25	2,0	244 508	50
M 10	1,50	2,0	244 510	50
M 12	1,75	2,0	244 512	25
M 14	2,00	2,0	244 514	25
MF 14	1,25	2,0	244 515	25

Pin-Breaker


Nominal thread size	Ø1 mm	Ø2 mm	Ø3 mm	L1 mm	L2 mm	L3 mm	Article no.	
M 3	2,0	9,8	6,0	15,0	75,0	25,0	244 163	1
M 4	2,7	9,8	6,0	20,0	75,0	20,0	244 164	1
M 5	3,5	9,8	-	22,0	75,0	18,0	244 165	1
M 6	4,6	9,8	-	22,0	75,0	18,0	244 166	1
M 8	6,0	9,8	-	40,0	75,0	-	244 168	1
M 10	7,5	9,8	-	40,0	75,0	-	244 170	1
M 12	9,0	12,2	-	40,0	75,0	-	244 172	1
M 14	10,0	14,5	-	40,0	80,0	-	244 174	1

Fitting-Tools

Nominal thread size	Ø1 mm	L1 mm	Article no.	
M 3	2,0	60,0	244 183	1
M 4	2,8	60,0	244 184	1
M 5	3,5	60,0	244 185	1
M 6	4,8	60,0	244 186	1
M 8	6,0	80,0	244 188	1
M 10	7,5	80,0	244 190	1
M 12	9,5	80,0	244 192	1
M 14	11,2	80,0	244 194	1



ProCoil Thread repairing assortment in plastic case

		Article no.
Assortment 1	Assortment M 5 - M12 5 twist drills HSS Ø 5,2 - 6,2 - 8,3 - 10,3 - 12,4 mm + 5 single-cut taps DIN 352 HSS M 5 - M 6 - M 8 - M 10 - M 12 + 5 fitting tools M 5 - M 6 - M 8 - M 10 - M 12 + 5 pin-Breakers Ø 3,5 - 4,6 - 6,0 - 7,5 - 9,0 mm + 60 inserts M 5 - M 10, each 5 x Ø 1,0 / 1,5 / 2,0 : Height = 1,0 x Ø + 6 inserts M 12, each 2 x Ø 1,0 / 1,5 / 2,0 Height = 1,0 x Ø	244 208
Assortment 2 	Assortment M 6 - M14 5 twist drills HSS Ø 6,2 - 8,3 - 10,3 - 12,4 - 14,5 mm + 5 single-cut taps DIN 352 HSS M 6 - M 8 - M 10 - M 12 - MF 14 + 5 fitting tools M 6 - M 8 - M 10 - M 12 - M 14 + 5 pin-Breakers Ø 4,6 - 6,0 - 7,5 - 9,0 - 10,0 mm + 45 inserts M 6 - M 10, each 5 x Ø 1,0 / 1,5 / 2,0: Height = 1,0 x Ø + 12 inserts M 12 - MF 14, each 2 x Ø 1,0 / 1,5 / 2,0: Height = 1,0 x Ø	244 209



ProCoil Thread repairing sets in plastic case

18-piece set of ProCoil thread repairing tools

		Article no.
Set M 3	1 twist drill Ø 3,1 mm + 1 single-cut tap DIN 352 HSS for thread M 3 x 0,5 + 1 fitting tool M 3 + 1 pin-Breaker Ø 2,0 mm + each 5 inserts Height = 1,0 x Ø / Height = 1,5 x Ø / Height = 2,0 x Ø	244 200
Set M 4	1 twist drill Ø 4,1 mm + 1 single-cut tap DIN 352 HSS for thread M 4 x 0,7 + 1 fitting tool M 4 + 1 pin-Breaker Ø 2,7 mm + each 5 inserts Height = 1,0 x Ø / Height = 1,5 x Ø / Height = 2,0 x Ø	244 201
Set M 5	1 twist drill Ø 5,2 mm + 1 single-cut tap DIN 352 HSS for thread M 5 x 0,8 + 1 fitting tool M 5 + 1 pin-Breaker Ø 3,5 mm + each 5 inserts Height = 1,0 x Ø / Height = 1,5 x Ø / Height = 2,0 x Ø	244 202
Set M 6	1 twist drill Ø 6,2 mm + 1 single-cut tap DIN 352 HSS for thread M 6 x 1,0 + 1 fitting tool M 6 + 1 pin-Breaker Ø 4,6 mm + each 5 inserts Height = 1,0 x Ø / Height = 1,5 x Ø / Height = 2,0 x Ø	244 203
Set M 8	1 twist drill Ø 8,3 mm + 1 single-cut tap DIN 352 HSS for thread M 8 x 1,25 + 1 fitting tool M 8 + 1 pin-Breaker Ø 6,0 mm + each 5 inserts Height = 1,0 x Ø / Height = 1,5 x Ø / Height = 2,0 x Ø	244 204
Set M 10	1 twist drill Ø 10,3 mm + 1 single-cut tap DIN 352 HSS for thread M 10 x 1,5 + 1 fitting tool M 10 + 1 pin-Breaker Ø 7,5 mm + each 5 inserts Height = 1,0 x Ø / Height = 1,5 x Ø / Height = 2,0 x Ø	244 205
Set M 12	1 twist drill Ø 12,4 mm + 1 single-cut tap DIN 352 HSS for thread M 12 x 1,75 + 1 fitting tool M 12 + 1 pin-Breaker Ø 9,0 mm + each 5 inserts Height = 1,0 x Ø / Height = 1,5 x Ø / Height = 2,0 x Ø	244 206
Set M 14	1 twist drill Ø 14,5 mm + 1 single-cut tap DIN 352 HSS for thread M 14 x 2,0 + 1 fitting tool M 14 + 1 pin-Breaker Ø 10,0 mm + each 5 inserts Height = 1,0 x Ø / Height = 1,5 x Ø / Height = 2,0 x Ø	244 207





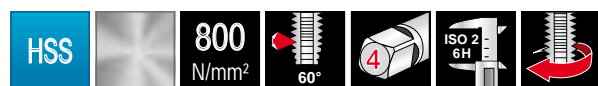
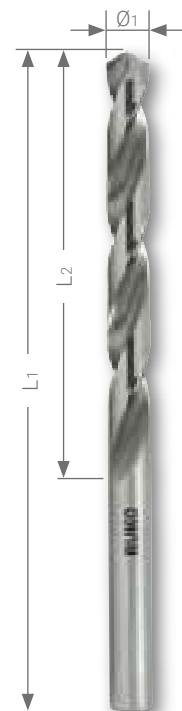
Twist drills DIN 338 type N HSS ground

High performance ground twist drill consisting of heavy-duty high speed steel. The fully ground twist drill has a more precise concentricity. Application areas: for steel, alloyed and unalloyed cast iron (up to a strength of 900 N/mm²), grey, malleable, ductile and die-cast iron, sintered iron, nickel silver, graphite, short chipping aluminium alloys, brass and bronze.

Packing unit: individual plastic pack

Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100		Bronze	□
Steel (N/mm ²) < 1300		Plastics	■
Stainless steel		Cast iron	□
Aluminium	■	Titanium alloyed	

For thread	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS		
M 3	3,10	65,0	36,0	214 031		10
M 4	4,10	75,0	43,0	214 041		10
M 5	5,20	86,0	52,0	214 052		10
M 6	6,20	101,0	63,0	214 062		10
M 8	8,30	117,0	75,0	214 083		10
M 10	10,30	133,0	87,0	214 103		10
M 12	12,40	151,0	101,0	214 124		5
M 14 + MF 14	14,50	169,0	114,0	214 145		5



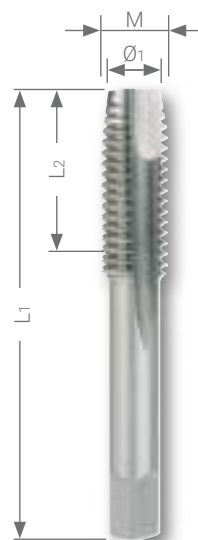
Single-cut taps HSS ground

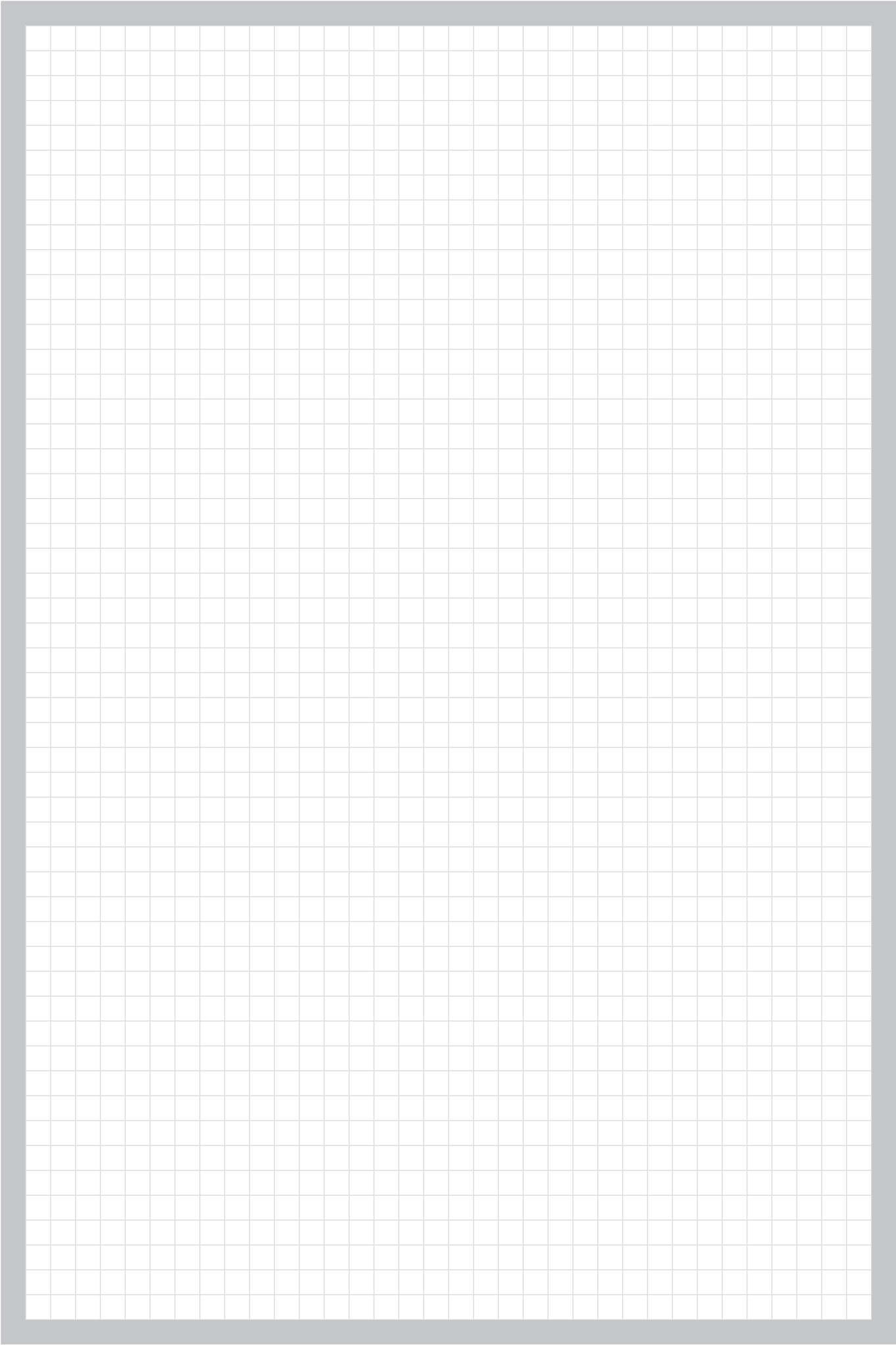
The single-cut tap HSS for through threads in unalloyed and low-alloyed steels up to a strength of 800 N/mm², malleable cast iron and non-ferrous metals. The thread can be cut in one operation by hand or machine.

Packing unit: individual plastic pack

Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100		Bronze	□
Steel (N/mm ²) < 1300		Plastics	■
Stainless steel		Cast iron	□
Aluminium	■	Titanium alloyed	

For thread	Thread core hole Ø1 mm	M mm	L1 mm	L2 mm	HSS		
M 3	3,10	3,6	53,0	13,0	244 603		1
M 4	4,10	4,9	58,0	16,0	244 604		1
M 5	5,20	6,0	66,0	19,0	244 605		1
M 6	6,20	7,3	72,0	22,0	244 606		1
M 8	8,30	9,6	80,0	24,0	244 608		1
M 10	10,30	11,9	89,0	29,0	244 610		1
M 12	12,40	14,3	95,0	30,0	244 612		1
M 14	14,50	16,6	102,0	32,0	244 614		1
MF 14	14,50	15,6	102,0	32,0	244 615		1

















CORE DRILLS

FASCINATION FOR PRECISION®

Range and applications overview:



Material	Surface	Drilling depth	Shank	Ejector pin	Magnetic-stand drilling machine	Ø mm	Article no.	Page
HSS				-	RS 5e/10 RS 25e/40e RS 126e/140e	10,0 - 15,0	108 1210 - 108 1215	195
HSS				108 304	RS 5e/10 RS 25e/40e RS 126e/140e	12,0 - 60,0	108 212 - 108 260	196 - 197
HSSE Co 5				108 304	RS 5e/10 RS 25e/40e RS 126e/140e	12,0 - 60,0	108 212 E - 108 260 E	196 - 197
HSS	TiAlN			108 304	RS 5e/10 RS 25e/40e RS 126e/140e	12,0 - 60,0	108 212 F - 108 260 F	196 - 197
HSS				108 305	RS 10 RS 25e/40e RS 126e/140e	12,0 - 60,0	108 512 - 108 560	198
HSSE Co 5				108 305	RS 10 RS 25e/40e RS 126e/140e	12,0 - 60,0	108 512 E - 108 560 E	198
HSS	TiAlN			108 305	RS 10 RS 25e/40e RS 126e/140e	12,0 - 60,0	108 512 F - 108 560 F	198
HSS				108 2000	RS 126e/140e	20,0 - 50,0	108 2020 - 108 2050	199
HSS	TiAlN			108 2000	RS 126e/140e	20,0 - 50,0	108 2020 F - 108 2050 F	199
HSSE Co 5				108 306	RS 10 RS 25e/40e RS 126e/140e	12,0 - 60,0	108 912 E - 108 960 E	200
TC				108 305 108 701	RS 10 RS 25e/40e RS 126e/140e	12,0 - 50,0	108 712 - 108 750	203
TC	Tecrona			108 305 108 701	RS 10 RS 25e/40e RS 126e/140e	12,0 - 50,0	108 712 C - 108 750 C	203
TC				108 306 108 110	RS 25e/40e RS 126e/140e	12,0 - 80,0	108 1112 - 108 1180	204 - 205
TC	Tecrona			108 306 108 110	RS 25e/40e RS 126e/140e	12,0 - 80,0	108 1112 C - 108 1180 C	204 - 205
TC				108 110	RS 10 RS 25e/40e RS 126e/140e	12,0 - 80,0	108 012 - 108 080	206 - 207
TC	Tecrona			108 110	RS 10 RS 25e/40e RS 126e/140e	12,0 - 80,0	108 012 C - 108 080 C	206 - 207
TC				108 1510	RS 5e/10 RS 25e/40e RS 126e/140e	19,0 - 36,0	108 1519 - 108 1536	208
TC	Tecrona			108 1510	RS 5e/10 RS 25e/40e RS 126e/140e	19,0 - 36,0	108 1519 C - 108 1536 C	208

Steel (N/mm ²) < 900	Steel (N/mm ²) < 1100	Steel (N/mm ²) < 1300	Stainless steel	Aluminium	Brass	Bronze	Plastics	Cast iron	Titanium alloyed
									
■				■	■	□	■	□	
■				■	■	□	■	□	
■	■	□	■	■	■	□	■	□	
■	■	□	■	■	■	□	■	□	
■				■	■	□	■	□	
■	■	□	■	■	■	□	■	□	
■	■	□	■	■	■	□	■	□	
■				■	■	□	■	□	
■	■	□	■	■	■	□	■	□	
■	■	□	■	■	■	□	■	□	
■	■	□	■	■	■	□	■	■	□
■	■	■	■	■	■	■	■	■	■
■	■	□	■	■	■	□	■	■	□
■	■	■	■	■	■	■	■	■	■
■	■	□	■	■	■	□	■	■	□
■	■	■	■	■	■	■	■	■	■
	■	□							
	■	■							



Solid drills with weldon shank (3/4")

For use in magnetic-stand and pillar drilling machines with morse taper retainer. In connection with RUKO arbor holders no. 108 302 / 108 303 / 108 315 / 108 316, with RUKO EasyLock no. 108 312 / 108 313 / 108 314 or a weldon direct shank such as the RUKO magnetic-stand RS 5e / RS10 drill.

Handling

- Push Solid drill „Solid 3S“ into arbor and tighten hexagon socket screw firmly.
- Check proper seating of Solid drill „Solid 3S“ in arbor holder.
- With the EasyLock arbor, the Solid drill „Solid 3S“ gets automatically locked.
- Drill to full dimension straight away. No centring or pre-drilling required.
- The blade geometry of the Solid drill „Solid 3S“ permits rapid upward chip removal.
- Observe table of cutting speeds and employ appropriate cooling agent.



Core drills with weldon shank (3/4")

For use in magnetic-stand and pillar drilling machines with morse taper retainer. In connection with RUKO arbor holders no. 108 302 / 108 303 / 108 315 / 108 316, with RUKO EasyLock no. 108 312 / 108 313 / 108 314 or a weldon direct shank such as the RUKO magnetic-stand RS 5e / RS10 drill.

Handling

- Insert Weldon shank ejector pin into core drill.
- Push core drill into arbor and tighten hexagon socket screw firmly.
- Check proper seating of core drill in arbor holder.
- With the EasyLock arbor, the core drill gets automatically locked.
- Drill to full dimension straight away. No centring or pre-drilling required.
- The blade geometry of the core drill permits rapid upward chip removal.
- The spring-loaded ejector pin facilitates removal of the cut-out.
- Observe table of cutting speeds and employ appropriate cooling agent.



Core drills HSS with Quick IN-shank

For use in magnetic-stand and column drilling machines in connection with Quick IN-adaptor as the Fein KBM 32 Q.

Handling

- Insert ejector pin into core drill.
- Push core drill into Quick In-adaptor.
- Drill to full dimension straight away. No centring or pre-drilling required.
- The blade geometry of the core drill permits rapid upward chip removal.
- The spring-loaded ejector pin facilitates removal of the cut-outs.
- Observe table of cutting speeds and employ appropriate cooling agent.



Core drills with threaded retainer

For use in magnetic-stand and pillar drilling machines with morse taper retainer. In connection with RUKO arbor holders no. 108 102 / 108 103 / 108 104 / 108 105 or a threaded retainer such as the Fein KBM 542 / KBM 65.

Handling

- Screw core drill into arbor holder.
- Drill to full dimension straight away. No centring or pre-drilling required.
- The blade geometry of the core drill permits rapid upward chip removal.
- The spring-loaded ejector pin facilitates removal of the cut-outs.
- Observe table of cutting speeds and employ appropriate cooling agent.



Solid drills „Solid 3S“ with weldon shank (3/4") and 3 cutting edges, cutting depth 30,0 mm

The spiral-grooved geometry with 3 cutting edges ensures extremely high stability of the "Solid 3S" solid drill, thus preventing the risk of breakage of the cutting edges by overloading or jamming of the chips. Thanks to the high stability, the service life of the "Solid 3S" is considerably increased. This reduces the costs of use. The "Solid 3S" enables drilling to full dimension without centring or pre-drilling. The "Solid 3S" can be ground more simply than core drills of the same diameter.



Packing unit: in plastic tubes of 1



Reduces the risk of breakage compared to core drills up to Ø 15,0 mm.

Cooling required.

Steel (N/mm ²) < 900	■
Steel (N/mm ²) < 1100	
Steel (N/mm ²) < 1300	
Rust-resistant steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	HSS		
10,0	19,0	64,0	30,0	108 1210	1	
11,0	19,0	64,0	30,0	108 1211	1	
12,0	19,0	64,0	30,0	108 1212	1	
13,0	19,0	64,0	30,0	108 1213	1	
14,0	19,0	64,0	30,0	108 1214	1	
15,0	19,0	64,0	30,0	108 1215	1	



Solid drills „Solid 3S“ with weldon shank (3/4") and 3 cutting edges in steel case

Description	HSS	
6- piece set of solid drills „Solid 3S“ HSS Ø 10,0 mm - 11,0 mm - 12,0 mm - 13,0 mm - 14,0 mm - 15,0 mm	108 830	



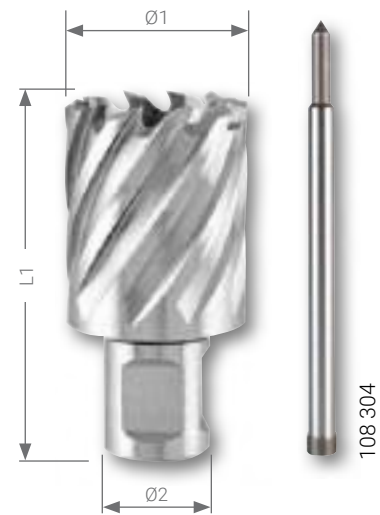
Core drills HSS and HSSE-Co 5 with weldon shank (3/4"), cutting depth 30,0 mm

Ejector pin: Article no. 108 304 (Ø 6,35 x 77,0 mm)

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100		■	■
Steel (N/mm2) < 1300		□	□
Rust-resistant steel		■	■
Aluminium	■	■	■

Brass	■	■	■
Bronze	□	□	□
Plastics		■	■
Cast iron	□	□	□
Titanium alloyed			



Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	HSS	HSSE Co 5	HSS	TITAN	
12,0	19,0	63,0	30,0	108 212	108 212 E	108 212 F		1
13,0	19,0	63,0	30,0	108 213	108 213 E	108 213 F		1
14,0	19,0	63,0	30,0	108 214	108 214 E	108 214 F		1
15,0	19,0	63,0	30,0	108 215	108 215 E	108 215 F		1
16,0	19,0	63,0	30,0	108 216	108 216 E	108 216 F		1
17,0	19,0	63,0	30,0	108 217	108 217 E	108 217 F		1
18,0	19,0	63,0	30,0	108 218	108 218 E	108 218 F		1
19,0	19,0	63,0	30,0	108 219	108 219 E	108 219 F		1
20,0	19,0	63,0	30,0	108 220	108 220 E	108 220 F		1
21,0	19,0	63,0	30,0	108 221	108 221 E	108 221 F		1
22,0	19,0	63,0	30,0	108 222	108 222 E	108 222 F		1
23,0	19,0	63,0	30,0	108 223	108 223 E	108 223 F		1
24,0	19,0	63,0	30,0	108 224	108 224 E	108 224 F		1
25,0	19,0	63,0	30,0	108 225	108 225 E	108 225 F		1
26,0	19,0	63,0	30,0	108 226	108 226 E	108 226 F		1
27,0	19,0	63,0	30,0	108 227	108 227 E	108 227 F		1
28,0	19,0	63,0	30,0	108 228	108 228 E	108 228 F		1
29,0	19,0	63,0	30,0	108 229	108 229 E	108 229 F		1
30,0	19,0	63,0	30,0	108 230	108 230 E	108 230 F		1
31,0	19,0	63,0	30,0	108 231	108 231 E	108 231 F		1
32,0	19,0	63,0	30,0	108 232	108 232 E	108 232 F		1
33,0	19,0	63,0	30,0	108 233	108 233 E	108 233 F		1
34,0	19,0	63,0	30,0	108 234	108 234 E	108 234 F		1
35,0	19,0	63,0	30,0	108 235	108 235 E	108 235 F		1
36,0	19,0	63,0	30,0	108 236	108 236 E	108 236 F		1
37,0	19,0	63,0	30,0	108 237	108 237 E	108 237 F		1
38,0	19,0	63,0	30,0	108 238	108 238 E	108 238 F		1
39,0	19,0	63,0	30,0	108 239	108 239 E	108 239 F		1
40,0	19,0	63,0	30,0	108 240	108 240 E	108 240 F		1
41,0	19,0	63,0	30,0	108 241	108 241 E	108 241 F		1
42,0	19,0	63,0	30,0	108 242	108 242 E	108 242 F		1
43,0	19,0	63,0	30,0	108 243	108 243 E	108 243 F		1
44,0	19,0	63,0	30,0	108 244	108 244 E	108 244 F		1
45,0	19,0	63,0	30,0	108 245	108 245 E	108 245 F		1
46,0	19,0	63,0	30,0	108 246	108 246 E	108 246 F		1
47,0	19,0	63,0	30,0	108 247	108 247 E	108 247 F		1
48,0	19,0	63,0	30,0	108 248	108 248 E	108 248 F		1
49,0	19,0	63,0	30,0	108 249	108 249 E	108 249 F		1
50,0	19,0	63,0	30,0	108 250	108 250 E	108 250 F		1
51,0	19,0	63,0	30,0	108 251	108 251 E	108 251 F		1
52,0	19,0	63,0	30,0	108 252	108 252 E	108 252 F		1
53,0	19,0	63,0	30,0	108 253	108 253 E	108 253 F		1
54,0	19,0	63,0	30,0	108 254	108 254 E	108 254 F		1
55,0	19,0	63,0	30,0	108 255	108 255 E	108 255 F		1
56,0	19,0	63,0	30,0	108 256	108 256 E	108 256 F		1
57,0	19,0	63,0	30,0	108 257	108 257 E	108 257 F		1
58,0	19,0	63,0	30,0	108 258	108 258 E	108 258 F		1
59,0	19,0	63,0	30,0	108 259	108 259 E	108 259 F		1
60,0	19,0	63,0	30,0	108 260	108 260 E	108 260 F		1



RS5e / RS10 / RS25e / RS40e
RS125e / RS126e / RS140e

08

Set of core drills HSS and HSSE-Co 5 with weldon shank (3/4"), cutting depth 30,0 mm in plastic case

Description	HSS	HSSE Co 5
10-piece set of core drills with weldon shank (3/4") 8 core drills with weldon shank (3/4") Ø 12,0 mm - 14,0 mm - 16,0 mm - 18,0 mm - 20,0 mm - 22,0 mm - 24,0 mm - 26,0 mm + 1 cutting paste 50 g, article-no. 101 021 + 1 ejector pin Ø 6,35 mm x 77,0 mm for cutting depth 30,0 mm article-no. 108 304	108 810	108 810 E
10-piece set of core drills with weldon shank (3/4") 8 core drills with weldon shank (3/4") Ø 2 x 14,0 mm - 2 x 16,0 mm - 2 x 18,0 mm - 1 x 20,0 mm - 1 x 22,0 mm + 1 cutting paste 50 g, article-no. 101 021 + 1 ejector pin Ø 6,35 mm x 77,0 mm for cutting depth 30,0 mm article-no. 108 304	108 813	—



Set of core drills HSS and HSSE-Co 5 with weldon shank (3/4"), cutting depth 30,0 mm in steel case

Description	HSS	HSSE Co 5	HSS TITAIN
7-piece set of core drills with weldon shank (3/4") 6 core drills with weldon shank (3/4") Ø 12,0 mm - 14,0 mm - 16,0 mm - 18,0 mm - 20,0 mm - 22,0 mm + 1 ejector pin Ø 6,35 mm x 77,0 mm for cutting depth 30,0 mm article-no. 108 304	108 820	—	108 820 F
7-piece set of core drills with weldon shank (3/4") 6 core drills with weldon shank (3/4") Ø 2 x 14,0 mm - 2 x 18,0 mm - 2 x 22,0 mm + 1 ejector pin Ø 6,35 mm x 77,0 mm for cutting depth 30,0 mm article-no. 108 304	108 840	108 840 E	108 840 F



Core drills HSS and HSSE-Co 5 with weldon shank (3/4"), cutting depth 55,0 mm

Ejector pin: Article no. 108 305 (Ø 6,35 x 102,0 mm)

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100		■	■
Steel (N/mm2) < 1300		□	□
Rust-resistant steel		■	■
Aluminium	■	■	■

Brass	■	■	■
Bronze	□	□	□
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			



Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	HSS	HSSE Co 5	HSS	TITAN	
12,0	19,0	88,0	55,0	108 512	108 512 E	108 512 F		1
13,0	19,0	88,0	55,0	108 513	108 513 E	108 513 F		1
14,0	19,0	88,0	55,0	108 514	108 514 E	108 514 F		1
15,0	19,0	88,0	55,0	108 515	108 515 E	108 515 F		1
16,0	19,0	88,0	55,0	108 516	108 516 E	108 516 F		1
17,0	19,0	88,0	55,0	108 517	108 517 E	108 517 F		1
18,0	19,0	88,0	55,0	108 518	108 518 E	108 518 F		1
19,0	19,0	88,0	55,0	108 519	108 519 E	108 519 F		1
20,0	19,0	88,0	55,0	108 520	108 520 E	108 520 F		1
21,0	19,0	88,0	55,0	108 521	108 521 E	108 521 F		1
22,0	19,0	88,0	55,0	108 522	108 522 E	108 522 F		1
23,0	19,0	88,0	55,0	108 523	108 523 E	108 523 F		1
24,0	19,0	88,0	55,0	108 524	108 524 E	108 524 F		1
25,0	19,0	88,0	55,0	108 525	108 525 E	108 525 F		1
26,0	19,0	88,0	55,0	108 526	108 526 E	108 526 F		1
27,0	19,0	88,0	55,0	108 527	108 527 E	108 527 F		1
28,0	19,0	88,0	55,0	108 528	108 528 E	108 528 F		1
29,0	19,0	88,0	55,0	108 529	108 529 E	108 529 F		1
30,0	19,0	88,0	55,0	108 530	108 530 E	108 530 F		1
31,0	19,0	88,0	55,0	108 531	108 531 E	108 531 F		1
32,0	19,0	88,0	55,0	108 532	108 532 E	108 532 F		1
33,0	19,0	88,0	55,0	108 533	108 533 E	108 533 F		1
34,0	19,0	88,0	55,0	108 534	108 534 E	108 534 F		1
35,0	19,0	88,0	55,0	108 535	108 535 E	108 535 F		1
36,0	19,0	88,0	55,0	108 536	108 536 E	108 536 F		1
37,0	19,0	88,0	55,0	108 537	108 537 E	108 537 F		1
38,0	19,0	88,0	55,0	108 538	108 538 E	108 538 F		1
39,0	19,0	88,0	55,0	108 539	108 539 E	108 539 F		1
40,0	19,0	88,0	55,0	108 540	108 540 E	108 540 F		1
41,0	19,0	88,0	55,0	108 541	108 541 E	108 541 F		1
42,0	19,0	88,0	55,0	108 542	108 542 E	108 542 F		1
43,0	19,0	88,0	55,0	108 543	108 543 E	108 543 F		1
44,0	19,0	88,0	55,0	108 544	108 544 E	108 544 F		1
45,0	19,0	88,0	55,0	108 545	108 545 E	108 545 F		1
46,0	19,0	88,0	55,0	108 546	108 546 E	108 546 F		1
47,0	19,0	88,0	55,0	108 547	108 547 E	108 547 F		1
48,0	19,0	88,0	55,0	108 548	108 548 E	108 548 F		1
49,0	19,0	88,0	55,0	108 549	108 549 E	108 549 F		1
50,0	19,0	88,0	55,0	108 550	108 550 E	108 550 F		1
51,0	19,0	88,0	55,0	108 551	108 551 E	108 551 F		1
52,0	19,0	88,0	55,0	108 552	108 552 E	108 552 F		1
53,0	19,0	88,0	55,0	108 553	108 553 E	108 553 F		1
54,0	19,0	88,0	55,0	108 554	108 554 E	108 554 F		1
55,0	19,0	88,0	55,0	108 555	108 555 E	108 555 F		1
56,0	19,0	88,0	55,0	108 556	108 556 E	108 556 F		1
57,0	19,0	88,0	55,0	108 557	108 557 E	108 557 F		1
58,0	19,0	88,0	55,0	108 558	108 558 E	108 558 F		1
59,0	19,0	88,0	55,0	108 559	108 559 E	108 559 F		1
60,0	19,0	88,0	55,0	108 560	108 560 E	108 560 F		1

Core drills HSS with weldon shank (3/4"), cutting depth 110,0 mm

Ejector pin: Article no. 108 2000 (Ø 8,0 x 155,0 mm)

Packing unit: in plastic tubes of 1



Move core drill out of the hole, remove the chips in the borehole.
Repeat this procedure several times.
Reduces the risk of breakage and increases the service life of the core drill.

Steel (N/mm ²) < 900			
Steel (N/mm ²) < 1100			
Steel (N/mm ²) < 1300			
Rust-resistant steel			
Aluminium			

Brass			
Bronze			
Plastics			
Cast iron			
Titanium alloyed			



Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	HSS	HSS	TiAIN	
20,0	19,0	145,0	110,0	108 2020	108 2020 F	1	
21,0	19,0	145,0	110,0	108 2021	108 2021 F	1	
22,0	19,0	145,0	110,0	108 2022	108 2022 F	1	
24,0	19,0	145,0	110,0	108 2024	108 2024 F	1	
25,0	19,0	145,0	110,0	108 2025	108 2025 F	1	
26,0	19,0	145,0	110,0	108 2026	108 2026 F	1	
28,0	19,0	145,0	110,0	108 2028	108 2028 F	1	
30,0	19,0	145,0	110,0	108 2030	108 2030 F	1	
32,0	19,0	145,0	110,0	108 2032	108 2032 F	1	
33,0	19,0	145,0	110,0	108 2033	108 2033 F	1	
34,0	19,0	145,0	110,0	108 2034	108 2034 F	1	
35,0	19,0	145,0	110,0	108 2035	108 2035 F	1	
36,0	19,0	145,0	110,0	108 2036	108 2036 F	1	
38,0	19,0	145,0	110,0	108 2038	108 2038 F	1	
40,0	19,0	145,0	110,0	108 2040	108 2040 F	1	
41,0	19,0	145,0	110,0	108 2041	108 2041 F	1	
42,0	19,0	145,0	110,0	108 2042	108 2042 F	1	
45,0	19,0	145,0	110,0	108 2045	108 2045 F	1	
50,0	19,0	145,0	110,0	108 2050	108 2050 F	1	



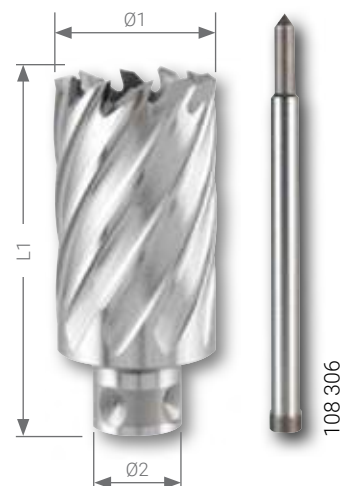
Core drills HSSE-Co 5 with Quick IN-shank, cutting depth 35,0 mm

Ejector pin: Article no. 108 306 (Ø 6,35 x 87,0 mm)
Machine no.: with Quick IN-adaptor

Packing unit: in plastic tubes of 1

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100	■	Bronze	□
Steel (N/mm2) < 1300	□	Plastics	■
Rust-resistant steel	■	Cast iron	□
Aluminium	■	Titanium alloyed	

Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	HSSE Co 5		
12,0	18,0	77,0	35,0	108 912 E		1
13,0	18,0	77,0	35,0	108 913 E		1
14,0	18,0	77,0	35,0	108 914 E		1
15,0	18,0	77,0	35,0	108 915 E		1
16,0	18,0	77,0	35,0	108 916 E		1
17,0	18,0	77,0	35,0	108 917 E		1
18,0	18,0	77,0	35,0	108 918 E		1
19,0	18,0	77,0	35,0	108 919 E		1
20,0	18,0	77,0	35,0	108 920 E		1
21,0	18,0	77,0	35,0	108 921 E		1
22,0	18,0	77,0	35,0	108 922 E		1
23,0	18,0	77,0	35,0	108 923 E		1
24,0	18,0	77,0	35,0	108 924 E		1
25,0	18,0	77,0	35,0	108 925 E		1
26,0	18,0	77,0	35,0	108 926 E		1
27,0	18,0	77,0	35,0	108 927 E		1
28,0	18,0	77,0	35,0	108 928 E		1
29,0	18,0	77,0	35,0	108 929 E		1
30,0	18,0	77,0	35,0	108 930 E		1
32,0	18,0	77,0	35,0	108 932 E		1
35,0	18,0	77,0	35,0	108 935 E		1
36,0	18,0	77,0	35,0	108 936 E		1
40,0	18,0	77,0	35,0	108 940 E		1
45,0	18,0	77,0	35,0	108 945 E		1
50,0	18,0	77,0	35,0	108 950 E		1
55,0	18,0	77,0	35,0	108 955 E		1
60,0	18,0	77,0	35,0	108 960 E		1



Set of core drills HSSE-Co 5 with Quick IN-shank, in plastic case

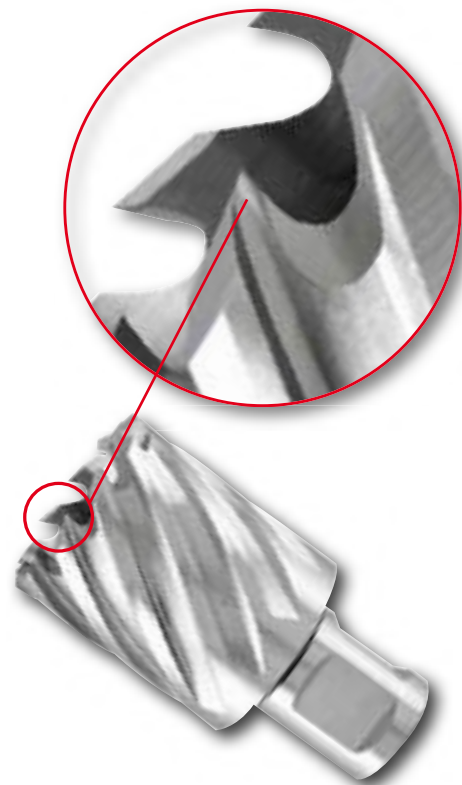
	HSSE Co 5
10-piece set of core drills HSSE-Co 5 with Quick IN-shank 8 core drills HSSE-Co 5 Ø 12,0 mm - 14,0 mm - 16,0 mm - 18,0 mm 20,0 mm - 22,0 mm - 24,0 mm - 26,0 mm + 1 cutting paste 50 g, article no. 101 021 + 1 ejector pin Ø 6,35 x 87,0 mm for cutting depth 35,0 mm, article no. 108 306	108 811 E



The cutting edge is the important thing ...

Considerably improved cutting behaviour was attained by research into the cutting geometry, which has a beneficial effect on cutting performance and drill life.

1. Optimised cutting edge geometry for increased cutting performances and reduced cutting forces.
2. The effective cutting angles are designed for universal use in various sorts of steel.
3. Improved removal of chips thanks to U-shaped recesses. The specific geometry of the recess reduces the thermal load on the HSS core drill as the heat created in cutting is removed with the chips to a very great extent.
4. Reduction of the friction between the HSS core drill and the workpiece thanks to optimised spiral-shaped guide chamfers.



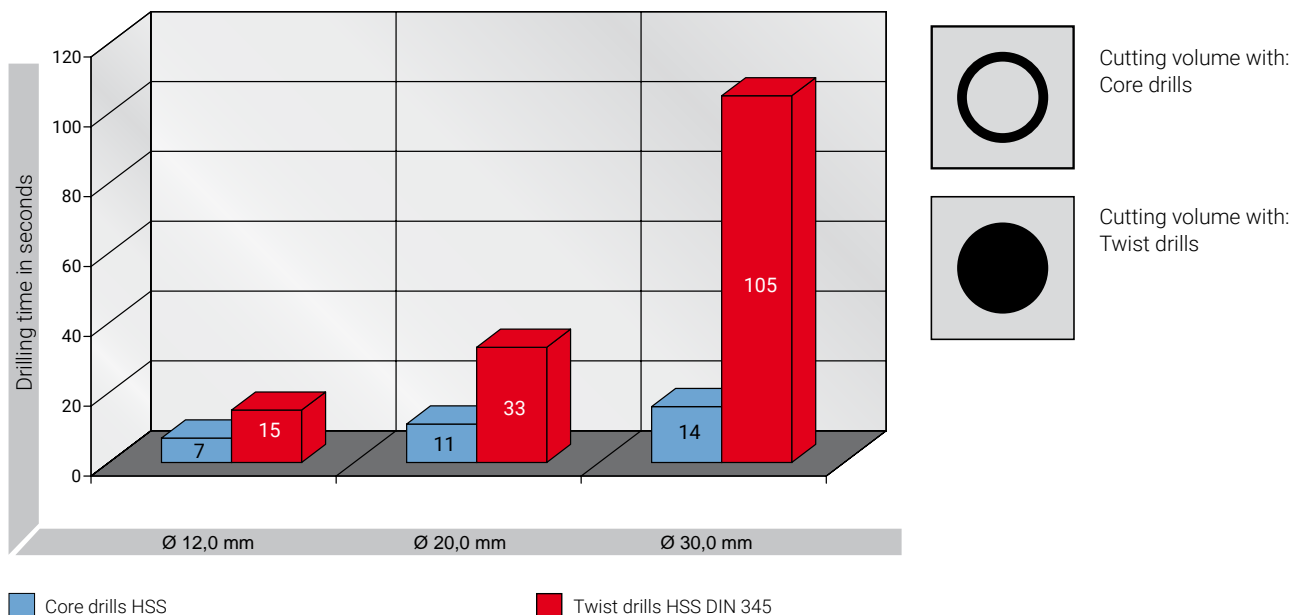
Comparison of cutting times core drills HSS vs. twist drills HSS DIN 345

Work piece: steel girder
Material: construction steel S235JR
Cutting depth: 12,0 mm

Machine: RUKO Magnetic-stand drilling machine RS140
Cutting with twist drills has been made without pilot drilling directly into the material. No cooling or lubrication has been used.

RUKO core drills will save costs and time. As core drills only cut the width of the teeth and as twist drills cut the entire diameter of the hole, core drills are many times faster (see diagram). Centering and pilot drilling are not necessary anymore.

Core drills cut up to ten times faster than twist drills. Core drills only cut the width of the teeth. The core is ejected. Lower energy requirements and less wear result in a longer working life. Twist drills have to machine the entire diameter of the hole. This calls for considerable downward pressure and high driving power.





Product Information

The RUKO core drills with Tecrona coating and hard metal cutting edges can be universally used in non-hardened steels and super alloys (materials with very high alloy percentages of Al,Ti, nickel like inconel, hastelloy, Innox, etc.).

Technical data:

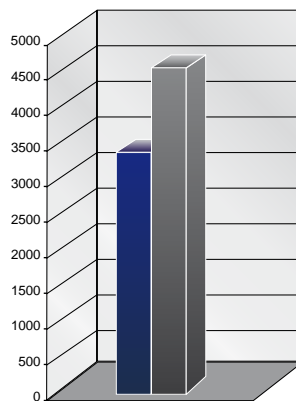
Surface: blue-grey
Hardness: 4200 HV
Thickness: 1µm - 7µm
Coefficient of friction: 0.35

Advantages of the Tecrona coating

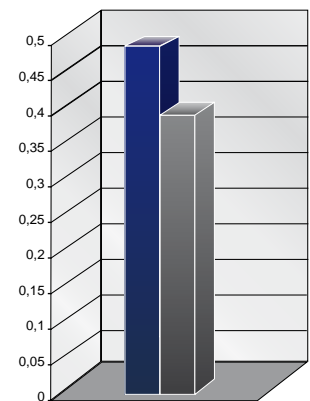
The Tecrona coating is the ideal coating for all drilling works that stress the tool extremely. It adheres very well to the tool, where by the wear-resistant coating increases the surface hardness to approximately 4200 HV. The coefficient of friction is extremely low in this coating, thereby increasing the service life with low wear.

Applications: Particularly for rail tracks, Hardox / Weldox steel, steel, cast iron, high-alloyed chromium steel such as stainless and acid-resistant steel.

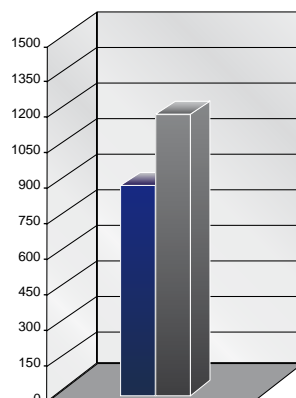
Comparison of hardness



Comparison of coefficients of friction



Temperature resistance



■ TiAlN
■ Tecrona





Core drills with tungsten-carbide cutting edges and weldon shank (3/4"), cutting depth 50,0 mm

Suitable for Hardox / Weldox 400 steel

Ejector pin:

Ø 12,0 mm up to Ø 17,0, Article no. 108 305 (Ø 6,35 x 102,0 mm)

Ø 18,0 mm up to Ø 50,0, Article no. 108 701 (Ø 8,0 x 112,0 mm)



Packing unit: individual plastic pack

Steel (N/mm2) < 900	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Steel (N/mm2) < 1100	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Steel (N/mm2) < 1300	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Rust-resistant steel	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Aluminium	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

Brass	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Bronze	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Plastics	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Cast iron	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Titanium alloyed	<input type="checkbox"/>	<input checked="" type="checkbox"/>

Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	TC	TC	
12,0	19,0	84,0	50,0	108 712	108 712 C	1
13,0	19,0	84,0	50,0	108 713	108 713 C	1
14,0	19,0	84,0	50,0	108 714	108 714 C	1
15,0	19,0	84,0	50,0	108 715	108 715 C	1
16,0	19,0	84,0	50,0	108 716	108 716 C	1
17,0	19,0	84,0	50,0	108 717	108 717 C	1
18,0	19,0	84,0	50,0	108 718	108 718 C	1
19,0	19,0	84,0	50,0	108 719	108 719 C	1
20,0	19,0	84,0	50,0	108 720	108 720 C	1
21,0	19,0	84,0	50,0	108 721	108 721 C	1
22,0	19,0	84,0	50,0	108 722	108 722 C	1
23,0	19,0	84,0	50,0	108 723	108 723 C	1
24,0	19,0	84,0	50,0	108 724	108 724 C	1
25,0	19,0	84,0	50,0	108 725	108 725 C	1
26,0	19,0	84,0	50,0	108 726	108 726 C	1
27,0	19,0	84,0	50,0	108 727	108 727 C	1
28,0	19,0	84,0	50,0	108 728	108 728 C	1
29,0	19,0	84,0	50,0	108 729	108 729 C	1
30,0	19,0	84,0	50,0	108 730	108 730 C	1
31,0	19,0	84,0	50,0	108 731	108 731 C	1
32,0	19,0	84,0	50,0	108 732	108 732 C	1
33,0	19,0	84,0	50,0	108 733	108 733 C	1
34,0	19,0	84,0	50,0	108 734	108 734 C	1
35,0	19,0	84,0	50,0	108 735	108 735 C	1
36,0	19,0	84,0	50,0	108 736	108 736 C	1
37,0	19,0	84,0	50,0	108 737	108 737 C	1
38,0	19,0	84,0	50,0	108 738	108 738 C	1
39,0	19,0	84,0	50,0	108 739	108 739 C	1
40,0	19,0	84,0	50,0	108 740	108 740 C	1
41,0	19,0	84,0	50,0	108 741	108 741 C	1
42,0	19,0	84,0	50,0	108 742	108 742 C	1
43,0	19,0	84,0	50,0	108 743	108 743 C	1
44,0	19,0	84,0	50,0	108 744	108 744 C	1
45,0	19,0	84,0	50,0	108 745	108 745 C	1
46,0	19,0	84,0	50,0	108 746	108 746 C	1
47,0	19,0	84,0	50,0	108 747	108 747 C	1
48,0	19,0	84,0	50,0	108 748	108 748 C	1
49,0	19,0	84,0	50,0	108 749	108 749 C	1
50,0	19,0	84,0	50,0	108 750	108 750 C	1

Core drills with tungsten-carbide and Quick IN-shank, cutting depth 50,0 mm

Ø 12,0 mm up to Ø 32,0 mm with fixed shank.
 Ø 33,0 mm up to Ø 80,0 mm including Quick IN-adapter No. 108 111.




Machine no.: with Quick IN-adapter
 Ejector pin: Ø 12,0 mm up to Ø 32,0 mm, article no. 108 305 (Ø 6,35 x 102,0 mm)
 Ø 33,0 mm up to Ø 80,0 mm, article no. 108 110 (Ø 6,35 x 123,0 mm)



Packing unit: individual plastic pack


Steel (N/mm2) < 900					
Steel (N/mm2) < 1100					
Steel (N/mm2) < 1300					
Rust-resistant steel					
Aluminium					

Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	TC	TC	
12,0	18,0	83,0	50,0	108 1112	108 1112 C	1
13,0	18,0	83,0	50,0	108 1113	108 1113 C	1
14,0	18,0	83,0	50,0	108 1114	108 1114 C	1
15,0	18,0	83,0	50,0	108 1115	108 1115 C	1
16,0	18,0	83,0	50,0	108 1116	108 1116 C	1
17,0	18,0	83,0	50,0	108 1117	108 1117 C	1
18,0	18,0	83,0	50,0	108 1118	108 1118 C	1
19,0	18,0	83,0	50,0	108 1119	108 1119 C	1
20,0	18,0	83,0	50,0	108 1120	108 1120 C	1
21,0	18,0	83,0	50,0	108 1121	108 1121 C	1
22,0	18,0	83,0	50,0	108 1122	108 1122 C	1
23,0	18,0	83,0	50,0	108 1123	108 1123 C	1
24,0	18,0	83,0	50,0	108 1124	108 1124 C	1
25,0	18,0	83,0	50,0	108 1125	108 1125 C	1
26,0	18,0	83,0	50,0	108 1126	108 1126 C	1
27,0	18,0	83,0	50,0	108 1127	108 1127 C	1
28,0	18,0	83,0	50,0	108 1128	108 1128 C	1
29,0	18,0	83,0	50,0	108 1129	108 1129 C	1
30,0	18,0	83,0	50,0	108 1130	108 1130 C	1
31,0	18,0	83,0	50,0	108 1131	108 1131 C	1
32,0	18,0	83,0	50,0	108 1132	108 1132 C	1
33,0	18,0	112,0	50,0	108 1133	108 1133 C	1
34,0	18,0	112,0	50,0	108 1134	108 1134 C	1
35,0	18,0	112,0	50,0	108 1135	108 1135 C	1
36,0	18,0	112,0	50,0	108 1136	108 1136 C	1
37,0	18,0	112,0	50,0	108 1137	108 1137 C	1
38,0	18,0	112,0	50,0	108 1138	108 1138 C	1
39,0	18,0	112,0	50,0	108 1139	108 1139 C	1
40,0	18,0	112,0	50,0	108 1140	108 1140 C	1
41,0	18,0	112,0	50,0	108 1141	108 1141 C	1
42,0	18,0	112,0	50,0	108 1142	108 1142 C	1
43,0	18,0	112,0	50,0	108 1143	108 1143 C	1
44,0	18,0	112,0	50,0	108 1144	108 1144 C	1
45,0	18,0	112,0	50,0	108 1145	108 1145 C	1
46,0	18,0	112,0	50,0	108 1146	108 1146 C	1
47,0	18,0	112,0	50,0	108 1147	108 1147 C	1
48,0	18,0	112,0	50,0	108 1148	108 1148 C	1
49,0	18,0	112,0	50,0	108 1149	108 1149 C	1
50,0	18,0	112,0	50,0	108 1150	108 1150 C	1

Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	TC 	TC 	
51,0	18,0	112,0	50,0	108 1151	108 1151 C	1
52,0	18,0	112,0	50,0	108 1152	108 1152 C	1
53,0	18,0	112,0	50,0	108 1153	108 1153 C	1
54,0	18,0	112,0	50,0	108 1154	108 1154 C	1
55,0	18,0	112,0	50,0	108 1155	108 1155 C	1
60,0	18,0	112,0	50,0	108 1160	108 1160 C	1
61,0	18,0	112,0	50,0	108 1161	108 1161 C	1
63,0	18,0	112,0	50,0	108 1163	108 1163 C	1
65,0	18,0	112,0	50,0	108 1165	108 1165 C	1
68,0	18,0	112,0	50,0	108 1168	108 1168 C	1
70,0	18,0	112,0	50,0	108 1170	108 1170 C	1
71,0	18,0	112,0	50,0	108 1171	108 1171 C	1
75,0	18,0	112,0	50,0	108 1175	108 1175 C	1
80,0	18,0	112,0	50,0	108 1180	108 1180 C	1



Set of core drills with tungsten-carbide cutting edges and Quick IN-shank, in plastic case

	TC 
10-piece set of core drills with tungsten-carbide cutting edges 8 core drills with tungsten-carbide cutting edges and Quick IN-shank Ø 12,0 mm - 14,0 mm - 16,0 mm - 18,0 mm 20,0 mm - 22,0 mm - 24,0 mm - 26,0 mm + 1 cutting paste 50 g, article-no. 101 021 + 1 ejector pin Ø 6,35 x 102,0 mm for cutting depth 50,0 mm article no. 108 305	108 822



Coolants and lubricants

RUKO high performance coolants and lubricants with outstanding cooling and anti-separation qualities. Increases tool life even with hard and brittle materials. High heat resistance ensures good lubrication and cooling, even at high temperatures. Good adhesion quality improves lubrication.

For all standard metal working processes, such as drilling, thread cutting, countersinking, deburring, sawing, turning, milling, grinding.

Perfectly matched for use with RUKO metal working tools.
Section 14 – Page 289


























Core drills with tungsten-carbide cutting edges and threaded retainer, cutting depth 50,0 mm




Ejector pin: article no. 108 110 (Ø 6,35 x 123,0 mm)
Adapter: thread M18 x 6 P1,5







Packing unit: individual plastic pack

					
Steel (N/mm2) < 900			Brass		
Steel (N/mm2) < 1100			Bronze		
Steel (N/mm2) < 1300			Plastics		
Rust-resistant steel			Cast iron		
Aluminium			Titanium alloyed		

Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	TC 	TC 	
12,0	MT 2 / 3	84,0	50,0	108 012	108 012 C	1
13,0	MT 2 / 3	84,0	50,0	108 013	108 013 C	1
14,0	MT 2 / 3	84,0	50,0	108 014	108 014 C	1
15,0	MT 2 / 3	84,0	50,0	108 015	108 015 C	1
16,0	MT 2 / 3	84,0	50,0	108 016	108 016 C	1
17,0	MT 2 / 3	84,0	50,0	108 017	108 017 C	1
18,0	MT 2 / 3	84,0	50,0	108 018	108 018 C	1
19,0	MT 2 / 3	84,0	50,0	108 019	108 019 C	1
20,0	MT 2 / 3	84,0	50,0	108 020	108 020 C	1
21,0	MT 2 / 3	84,0	50,0	108 021	108 021 C	1
22,0	MT 2 / 3	84,0	50,0	108 022	108 022 C	1
23,0	MT 2 / 3	84,0	50,0	108 023	108 023 C	1
24,0	MT 2 / 3	84,0	50,0	108 024	108 024 C	1
25,0	MT 2 / 3	84,0	50,0	108 025	108 025 C	1
26,0	MT 2 / 3	84,0	50,0	108 026	108 026 C	1
27,0	MT 2 / 3	84,0	50,0	108 027	108 027 C	1
28,0	MT 2 / 3	84,0	50,0	108 028	108 028 C	1
29,0	MT 2 / 3	84,0	50,0	108 029	108 029 C	1
30,0	MT 2 / 3	84,0	50,0	108 030	108 030 C	1
31,0	MT 2 / 3	84,0	50,0	108 031	108 031 C	1
32,0	MT 2 / 3	84,0	50,0	108 032	108 032 C	1
33,0	MT 2 / 3	84,0	50,0	108 033	108 033 C	1
34,0	MT 2 / 3	84,0	50,0	108 034	108 034 C	1
35,0	MT 2 / 3	84,0	50,0	108 035	108 035 C	1
36,0	MT 2 / 3	84,0	50,0	108 036	108 036 C	1
37,0	MT 2 / 3	84,0	50,0	108 037	108 037 C	1
38,0	MT 2 / 3	84,0	50,0	108 038	108 038 C	1
39,0	MT 2 / 3	84,0	50,0	108 039	108 039 C	1
40,0	MT 2 / 3	84,0	50,0	108 040	108 040 C	1
41,0	MT 2 / 3	84,0	50,0	108 041	108 041 C	1
42,0	MT 2 / 3	84,0	50,0	108 042	108 042 C	1
43,0	MT 2 / 3	84,0	50,0	108 043	108 043 C	1
44,0	MT 2 / 3	84,0	50,0	108 044	108 044 C	1
45,0	MT 2 / 3	84,0	50,0	108 045	108 045 C	1
46,0	MT 2 / 3	84,0	50,0	108 046	108 046 C	1
47,0	MT 2 / 3	84,0	50,0	108 047	108 047 C	1
48,0	MT 2 / 3	84,0	50,0	108 048	108 048 C	1
49,0	MT 2 / 3	84,0	50,0	108 049	108 049 C	1
50,0	MT 2 / 3	84,0	50,0	108 050	108 050 C	1


Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	TC 	TC 	
51,0	MT 2 / 3	84,0	50,0	108 051	108 051 C	1
52,0	MT 2 / 3	84,0	50,0	108 052	108 052 C	1
53,0	MT 2 / 3	84,0	50,0	108 053	108 053 C	1
54,0	MT 2 / 3	84,0	50,0	108 054	108 054 C	1
55,0	MT 2 / 3	84,0	50,0	108 055	108 055 C	1
60,0	MT 2 / 3	84,0	50,0	108 060	108 060 C	1
61,0	MT 2 / 3	84,0	50,0	108 061	108 061 C	1
63,0	MT 2 / 3	84,0	50,0	108 063	108 063 C	1
65,0	MT 2 / 3	84,0	50,0	108 065	108 065 C	1
68,0	MT 2 / 3	84,0	50,0	108 068	108 068 C	1
70,0	MT 2 / 3	84,0	50,0	108 070	108 070 C	1
71,0	MT 2 / 3	84,0	50,0	108 071	108 071 C	1
75,0	MT 2 / 3	84,0	50,0	108 075	108 075 C	1
80,0	MT 2 / 3	84,0	50,0	108 080	108 080 C	1

TC

RS10 / RS25e / RS40e
RS125e / RS126e / RS140e

Set of core drills with tungsten-carbide cutting edges and threaded retainer in plastic case

	TC 
8-piece set of core drills with tungsten-carbide cutting edges 8 core drills with tungsten-carbide and threaded retainer Ø 12,0 mm - 14,0 mm - 16,0 mm - 18,0 mm 20,0 mm - 22,0 mm - 24,0 mm - 26,0 mm	108 823



Core drills with tungsten-carbide cutting edges and Weldon shank (3/4") for railway tracks, cutting depth 30,0 mm

Can be used on all track drilling machines. The cutting geometry has been specially optimized for heavy duty chip removal from railway tracks, thus makes efficient use possible.

Ejector pin: Article no. 108 1510 (Ø 8,0 x 81,0 mm)



Packing unit: individual plastic pack

Steel (N/mm2) < 900		
Steel (N/mm2) < 1100		
Steel (N/mm2) < 1300		
Rust-resistant steel		
Aluminium		

Brass		
Bronze		
Plastics		
Cast iron		
Titanium alloyed		

Ø1 mm	Ø2 mm	L1 mm	Cutting depth mm	TC	TC	
19,0	19,0	63,0	30,0	108 1519	108 1519 C	1
20,0	19,0	63,0	30,0	108 1520	108 1520 C	1
21,0	19,0	63,0	30,0	108 1521	108 1521 C	1
22,0	19,0	63,0	30,0	108 1522	108 1522 C	1
23,0	19,0	63,0	30,0	108 1523	108 1523 C	1
24,0	19,0	63,0	30,0	108 1524	108 1524 C	1
25,0	19,0	63,0	30,0	108 1525	108 1525 C	1
26,0	19,0	63,0	30,0	108 1526	108 1526 C	1
26,5	19,0	63,0	30,0	108 15265	108 15265 C	1
27,0	19,0	63,0	30,0	108 1527	108 1527 C	1
27,5	19,0	63,0	30,0	108 15275	108 15275 C	1
28,0	19,0	63,0	30,0	108 1528	108 1528 C	1
29,0	19,0	63,0	30,0	108 1529	108 1529 C	1
30,0	19,0	63,0	30,0	108 1530	108 1530 C	1
31,0	19,0	63,0	30,0	108 1531	108 1531 C	1
32,0	19,0	63,0	30,0	108 1532	108 1532 C	1
33,0	19,0	63,0	30,0	108 1533	108 1533 C	1
34,0	19,0	63,0	30,0	108 1534	108 1534 C	1
36,0	19,0	63,0	30,0	108 1536	108 1536 C	1



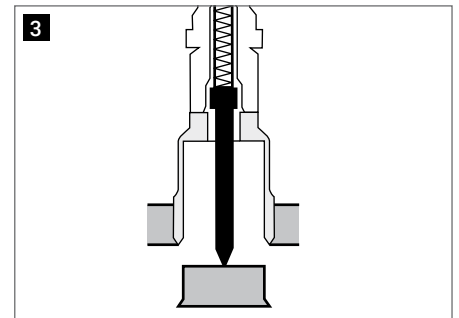
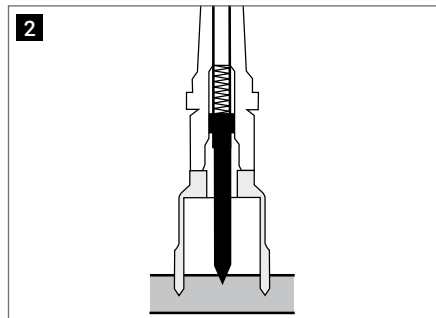
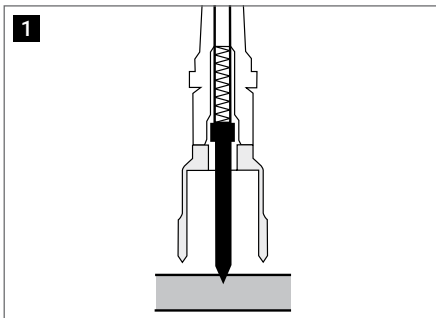
Ejector pins for core drills

Packing unit: individual plastic pack



08





- 1 Centring:**
Position the ejector pin centrally on the centre punch.
Now the machine is in the correct drilling position. Please turn on magnet now.
- 2 Coolant supply:**
The cutting oil is supplied through the ejector pin by the automatic internal lubrication and is issued optimally to the cutting edges.
- 3 Ejecting:**
In the final phase, the drill core is pushed from the borehole by the spring pretensioned ejector pin.



Ejector pins for core drills HSS

	Core drills cutting depth mm		
Ejector pin Ø 6,35 x 77,0 mm for core drills HSS with Weldon shank (¾")	30,0	108 304	1
Ejector pin Ø 6,35 x 87,0 mm for core drills HSS / TC with Quick IN-shank	35,0 / 50,0	108 306	1
Ejector pin Ø 6,35 x 102,0 mm for core drills HSS / TC with Weldon shank (¾")	55,0	108 305	1
Ejector pin Ø 8,0 x 155,0 mm for core drills HSS with Weldon shank (¾")	110,0	108 2000	1
Ejector pin Ø 6,35 x 70,0 mm for core drills HSS with Weldon shank (¾") for RS5e	30,0	108 344	1

Ejector pins for core drills TC

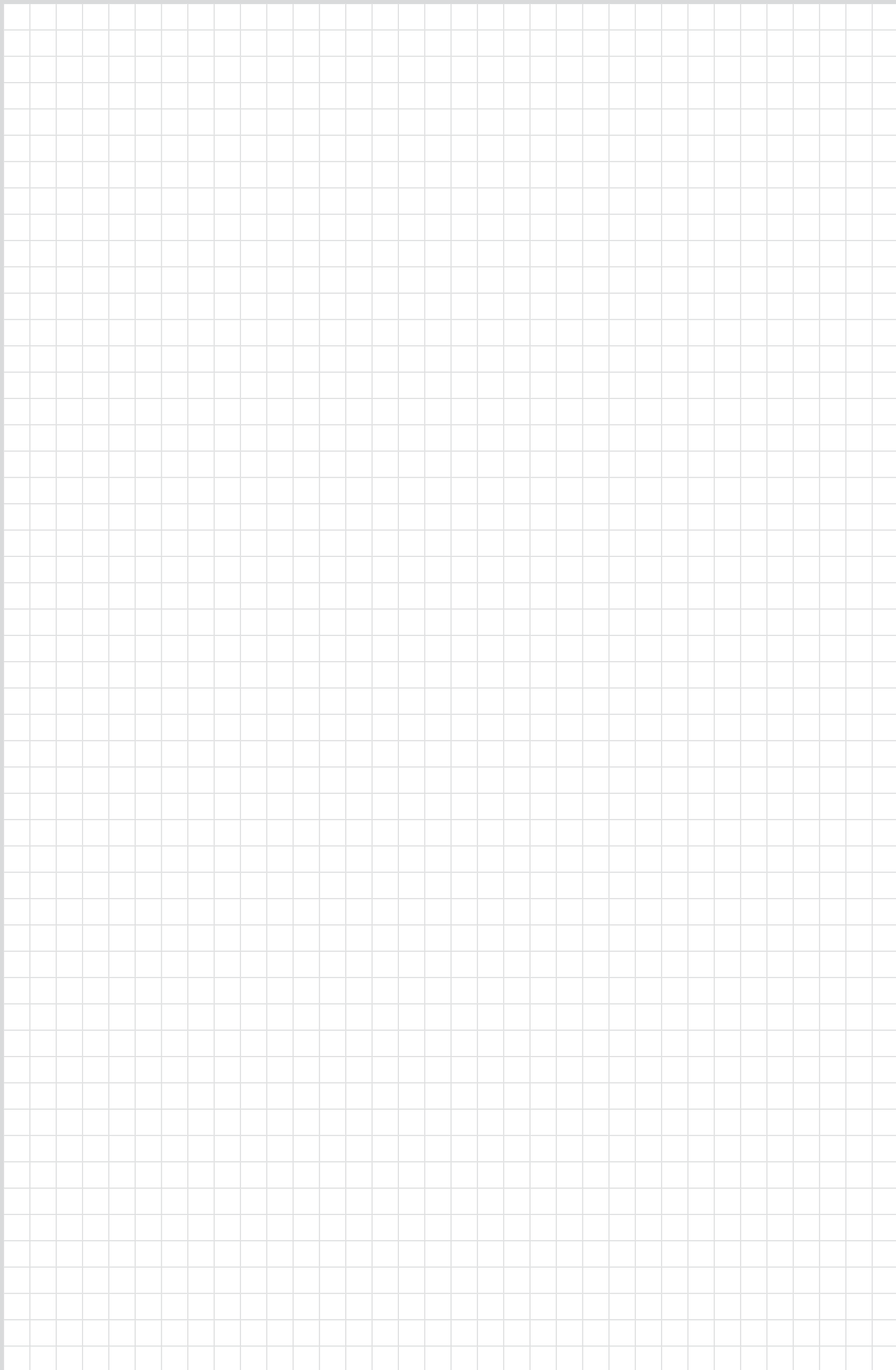
	Core drills cutting depth mm		
Ejector pin Ø 8,0 x 81,0 mm for core drills TC with Weldon shank (¾") for railway tracks	30,0	108 1510	1
Ejector pin Ø 6,35 x 87,0 mm for core drills HSS / TC with Quick IN-shank	35,0 / 50,0	108 306	1
Ejector pin Ø 8,0 x 112,0 mm for core drills TC with Weldon shank (¾")	50,0	108 701	1
Ejector pin Ø 6,35 x 123,0 mm for core drills TC with Weldon- (¾") and Quick IN-shank	50,0 + Adapter	108 110	1
Ejector pin Ø 6,35 x 102,0 mm for core drills HSS / TC with Weldon shank (¾")	55,0	108 305	1

Recommended cutting speeds for HSS core drills

Material:		High carbon struc. steel up to 700 N/mm²	Alloyed steel up to 1000 N/mm²	Cast iron over 250 N/mm²	CuZn- alloy brittle	CuZn- alloy tough	Aluminium alloy up to 11% Si	Thermo- plastics	Duro- plastics
Vc = m/min		30	20	10	60	35	30	20	15
Coolant:		Cutting spray	Cutting spray	Compressed air	Compressed air	Compressed air	Cutting spray	Water	Compressed air
Ø mm	Ø inch	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.
12,0	15/32	796	531	265	1592	929	796	531	398
13,0	33/64	735	490	245	1470	857	735	490	367
14,0	35/64	682	455	227	1365	796	682	455	341
15,0	19/32	637	425	212	1274	743	637	425	318
16,0	5/8	597	398	199	1194	697	597	398	299
17,0	43/64	562	375	187	1124	656	562	375	281
18,0	45/64	531	354	177	1062	619	531	354	265
19,0	3/4	503	335	168	1006	587	503	335	251
20,0	25/32	478	318	159	955	557	478	318	239
21,0	53/64	455	303	152	910	531	455	303	227
22,0	7/8	434	290	145	869	507	434	290	217
23,0	29/32	415	277	138	831	485	415	277	208
24,0	15/16	398	265	133	796	464	398	265	199
25,0	63/64	382	255	127	764	446	382	255	191
26,0	1 1/32	367	245	122	735	429	367	245	184
27,0	1 1/16	354	236	118	708	413	354	236	177
28,0	1 3/32	341	227	114	682	398	341	227	171
29,0	1 9/64	329	220	110	659	384	329	220	165
30,0	1 3/16	318	212	106	637	372	318	212	159
31,0	1 7/32	308	205	103	616	360	308	205	154
32,0	1 17/64	299	199	100	597	348	299	199	149
33,0	1 19/64	290	193	97	579	338	290	193	145
34,0	1 11/32	281	187	94	562	328	281	187	141
35,0	1 3/8	273	182	91	546	318	273	182	136
36,0	1 27/64	265	177	88	531	310	265	177	133
37,0	1 29/64	258	172	86	516	301	258	172	129
38,0	1 1/2	251	168	84	503	293	251	168	126
39,0	1 17/32	245	163	82	490	286	245	163	122
40,0	1 37/64	239	159	80	478	279	239	159	119
41,0	1 39/64	233	155	78	466	272	233	155	117
42,0	1 21/32	227	152	76	455	265	227	152	114
43,0	1 11/16	222	148	74	444	259	222	148	111
44,0	1 47/64	217	145	72	434	253	217	145	109
45,0	1 25/32	212	142	71	425	248	212	142	106
46,0	1 13/16	208	138	69	415	242	208	138	104
47,0	1 55/64	203	136	68	407	237	203	136	102
48,0	1 57/64	199	133	66	398	232	199	133	100
49,0	1 15/16	195	130	65	390	227	195	130	97
50,0	1 31/32	191	127	64	382	223	191	127	96
51,0	2	187	125	62	375	219	187	125	94
52,0	2 3/64	184	122	61	367	214	184	122	92
53,0	2 3/32	180	120	60	361	210	180	120	90
54,0	2 1/8	177	118	59	354	206	177	118	88
55,0	2 5/32	174	116	58	347	203	174	116	87
60,0	2 3/8	159	106	53	318	186	159	106	80
								</	

Recommended cutting speeds for tungsten-carbide core drills

Material:		High carbon struc. steel up to 700 N/mm ²	Alloyed steel up to 1000 N/mm ²	Cast iron over 250 N/mm ²	CuZn- alloy brittle	CuZn- alloy tough	Aluminium alloy up to 11% Si	Thermo- plastics	Duro- plastics
V _c = m/min		50	35	40	60	40	60	45	40
Coolant:		Cutting spray	Cutting spray	Compressed air	Compressed air	Compressed air	Cutting spray	Water	Compressed air
Ø mm	Ø inch	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.
12,0	15/32	1327	929	1062	1592	265	1592	1194	1062
13,0	33/64	1225	857	980	1470	245	1470	1102	980
14,0	35/64	1137	796	910	1365	227	1365	1024	910
15,0	19/32	1062	743	849	1274	212	1274	955	849
16,0	5/8	995	697	796	1194	199	1194	896	796
17,0	34/64	937	656	749	1124	187	1124	843	749
18,0	45/64	885	619	708	1062	177	1062	796	708
19,0	3/4	838	587	670	1006	168	1006	754	670
20,0	25/32	796	557	637	955	159	955	717	637
21,0	3/4	758	531	607	910	152	910	682	607
22,0	7/8	724	507	579	869	145	869	651	579
23,0	13/16	692	485	554	831	138	831	623	554
24,0	15/16	663	464	531	796	133	796	597	531
25,0	63/64	637	446	510	764	127	764	573	510
26,0	1 1/32	612	429	490	735	122	735	551	490
27,0	1 1/16	590	413	472	708	118	708	531	472
28,0	1 3/32	569	398	455	682	114	682	512	455
29,0	1 9/64	549	384	439	659	110	659	494	439
30,0	1 3/16	531	372	425	637	106	637	478	425
31,0	1 7/32	514	360	411	616	103	616	462	411
32,0	1 17/64	498	348	398	597	100	597	448	398
33,0	1 19/64	483	338	386	579	97	579	434	386
34,0	1 11/32	468	328	375	562	94	562	422	375
35,0	1 3/8	455	318	364	546	91	546	409	364
36,0	1 27/64	442	310	354	531	88	531	398	354
37,0	1 29/64	430	301	344	516	86	516	387	344
38,0	1 1/2	419	293	335	503	84	503	377	335
39,0	1 17/32	408	286	327	490	82	490	367	327
40,0	1 37/64	398	279	318	478	80	478	358	318
41,0	1 39/64	388	272	311	466	78	466	350	311
42,0	1 21/32	379	265	303	455	76	455	341	303
43,0	1 11/16	370	259	296	444	74	444	333	296
44,0	1 47/64	362	253	290	434	72	434	326	290
45,0	1 25/32	354	248	283	425	71	425	318	283
46,0	1 13/16	346	242	277	415	69	415	312	277
47,0	1 55/64	339	237	271	407	68	407	305	271
48,0	1 57/64	332	232	265	398	66	398	299	265
49,0	1 15/16	325	227	260	390	65	390	292	260
50,0	1 31/32	318	223	255	382	64	382	287	255
51,0	2	312	219	250	375	62	375	281	250
52,0	2 3/64	306	214	245	367	61	367	276	245
53,0	2 3/32	300	210	240	361	60	361	270	240
54,0	2 1/8	295	206	236	354	59	354	265	236
55,0	2 5/32	290	203	232	347	58	347	261	232
60,0	2 3/8	265	186	212	318	53	318	239	212
61,0	2 13/32	261	183	209	313	52	313	235	209
65,0	2 9/16	245	171	196	294	49	294	220	196
68,0	2 43/64	234	164	187	281	47	281	211	187
70,0	2 3/4	227	159	182	273	45	273	205	182
71,0	2 51/64	224	157	179	269	45	269	202	179
75,0	2 61/64	212	149	170	255	42	255	191	170
80,0	3 5/32	199	139	159	239	40	239	179	159
85,0	3 11/32	187	131	150	225	37	225	169	150
90,0	3 35/64	177	124	142	212	35	212	159	142
95,0	3 47/64	168	117	134	201	34	201	151	134
100,0	3 15/16	159	111	127	191	32	191	143	127















ROTARY BURRS

FASCINATION FOR PRECISION®

Range and applications overview:



Material	Surface	DIN	Shape		Toothing	Shank	Ø mm	Article no.	Page
TC		DIN 8033	A	ZYA	CT 4		3,0 - 16,0	116 010 116 046	216
TC	TiCN	DIN 8033	A	ZYA	CT 4		6,0 - 16,0	116 010 TC 116 014 TC	216
TC		DIN 8033	B	ZYAS	CT 4		3,0 - 16,0	116 015 116 047	216
TC	TiCN	DIN 8033	B	ZYAS	CT 4		6,0 - 16,0	116 015 TC 116 019 TC	216
TC		DIN 8033	B	ZYAS	ALU		6,0 - 12,0	116 015 A 116 018 A	216
TC		DIN 8033	C	WRC	CT 4		3,0 - 16,0	116 020 116 048	217
TC	TiCN	DIN 8033	C	WRC	CT 4		6,0 - 16,0	116 020 TC 116 024 TC	217
TC		DIN 8033	C	WRC	ALU		6,0 - 12,0	116 020 A 116 023 A	217
TC		DIN 8033	D	KUD	CT 4		3,0 - 16,0	116 041 116 052	217
TC	TiCN	DIN 8033	D	KUD	CT 4		6,0 - 16,0	116 041 TC 116 045 TC	217
TC		DIN 8033	D	KUD	ALU		6,0 - 12,0	116 041 A 116 044 A	217
TC		DIN 8033	E	TRE	CT 4		3,0 - 16,0	116 210 116 215	218
TC		DIN 8033	F	RBF	CT 4		3,0 - 16,0	116 030 116 050	218
TC	TiCN	DIN 8033	F	RBF	CT 4		6,0 - 16,0	116 030 TC 116 034 TC	218
TC		DIN 8033	F	RBF	ALU		6,0 - 12,0	116 030 A 116 033 A	218
TC		DIN 8033	G	SPG	CT 4		3,0 - 16,0	116 025 116 049	219
TC	TiCN	DIN 8033	G	SPG	CT 4		6,0 - 16,0	116 025 TC 116 029 TC	219
TC		DIN 8033	G	SPG	ALU		6,0 - 12,0	116 025 A 116 028 A	219
TC		DIN 8033	H	FLH	CT 4		3,0 - 16,0	116 216 116 221	219
TC		DIN 8033	J	KSJ	CT 4		3,0 - 16,0	116 222 116 226	220
TC		DIN 8033	K	KSK	CT 4		3,0 - 16,0	116 227 116 231	220
TC		DIN 8033	L	KEL	CT 4		3,0 - 16,0	116 232 116 237	221
TC		DIN 8033	L	KEL	ALU		6,0 - 12,0	116 233 A 116 236 A	221
TC		DIN 8033	M	SKM	CT 4		3,0 - 16,0	116 035 116 051	221
TC	TiCN	DIN 8033	M	SKM	CT 4		6,0 - 16,0	116 035 TC 116 039 TC	221
TC		DIN 8033	N	WKN	CT 4		3,0 - 16,0	116 238 116 242	222

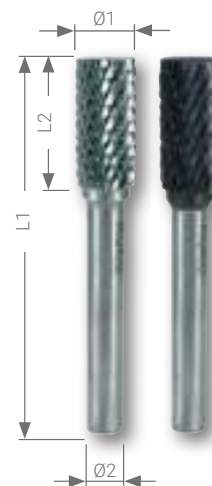
Steel (N/mm ²) < 900 	Steel (N/mm ²) < 1100 	Steel (N/mm ²) < 1300 	Stainless steel 	Aluminium 	Brass 	Bronze 	Plastics 	Cast iron 	Titanium alloyed 
■	■	■	■		■			■	■
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Tungsten carbide rotary burrs shape A cylinder (ZYA) without end tothing

Packing unit: each in plastic packaging

	CT 4	CT 4		CT 4	CT 4
Steel (N/mm2) < 900	■	■	Brass	■	■
Steel (N/mm2) < 1100	■	■	Bronze		
Steel (N/mm2) < 1300	■	■	Plastics		
Stainless steel	■	■	Cast iron	■	■
Aluminium			Titanium alloyed	■	■



Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TICN	CT 4	
3,0	14,0	38,0	3,0	—		116 046	—	—			1
6,0	18,0	58,0	6,0	—		116 010	116 010 TC	—			1
8,0	18,0	60,0	6,0	—		116 011	116 011 TC	—			1
10,0	20,0	60,0	6,0	—		116 012	116 012 TC	—			1
12,0	25,0	65,0	6,0	—		116 013	116 013 TC	—			1
16,0	25,0	65,0	6,0	—		116 014	116 014 TC	—			1



Tungsten carbide rotary burrs shape B cylinder (ZYAS) with end tothing

Packing unit: each in plastic packaging

	ALU	CT 4	CT 4		ALU	CT 4	CT 4
Steel (N/mm2) < 900		■	■	Brass		■	■
Steel (N/mm2) < 1100		■	■	Bronze	■		
Steel (N/mm2) < 1300		■	■	Plastics	■		
Stainless steel		■	■	Cast iron		■	■
Aluminium	■			Titanium alloyed		■	■



Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TICN	CT 4	
3,0	14,0	38,0	3,0	—		116 047	—	—			1
6,0	18,0	58,0	6,0	116 015 A		116 015	116 015 TC	—			1
8,0	18,0	60,0	6,0	—		116 016	116 016 TC	—			1
10,0	20,0	60,0	6,0	—		116 017	116 017 TC	—			1
12,0	25,0	65,0	6,0	116 018 A		116 018	116 018 TC	—			1
16,0	25,0	65,0	6,0	—		116 019	116 019 TC	—			1



Tungsten carbide rotary burrs shape C oval (WRC)

Packing unit: each in plastic packaging

	ALU	CT 4	CT 4
Steel (N/mm2) < 900		■	■
Steel (N/mm2) < 1100		■	■
Steel (N/mm2) < 1300		■	■
Stainless steel		■	■
Aluminium	■		

	ALU	CT 4	CT 4
Brass		■	■
Bronze	■		
Plastics	■		
Cast iron		■	■
Titanium alloyed		■	■



Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TiCN	CT 4	
3,0	14,0	43,0	3,0	—		116 048		—			1
6,0	16,0	56,0	6,0	116 020 A		116 020		116 020 TC			1
8,0	16,0	56,0	6,0	—		116 021		116 021 TC			1
10,0	20,0	60,0	6,0	—		116 022		116 022 TC			1
12,0	25,0	65,0	6,0	116 023 A		116 023		116 023 TC			1
16,0	25,0	65,0	6,0	—		116 024		116 024 TC			1



Tungsten carbide rotary burrs shape D ball type (KUD)

Packing unit: each in plastic packaging

	ALU	CT 4	CT 4
Steel (N/mm2) < 900		■	■
Steel (N/mm2) < 1100		■	■
Steel (N/mm2) < 1300		■	■
Stainless steel		■	■
Aluminium	■		

	ALU	CT 4	CT 4
Brass		■	■
Bronze	■		
Plastics	■		
Cast iron		■	■
Titanium alloyed		■	■



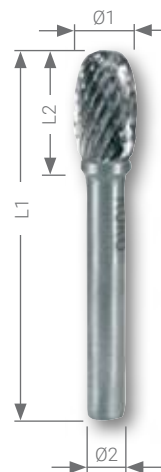
Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TiCN	CT 4	
3,0	2,7	33,0	3,0	—		116 052		—			1
6,0	5,4	45,0	6,0	116 041 A		116 041		116 041 TC			1
8,0	7,2	47,0	6,0	—		116 042		116 042 TC			1
10,0	9,0	49,0	6,0	—		116 043		116 043 TC			1
12,0	11,0	51,0	6,0	116 044 A		116 044		116 044 TC			1
16,0	14,4	54,0	6,0	—		116 045		116 045 TC			1



Tungsten carbide rotary burrs shape E tear drop (TRE)

Packing unit: each in plastic packaging

	CT 4		CT 4
Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100	■	Bronze	
Steel (N/mm2) < 1300	■	Plastics	
Stainless steel	■	Cast iron	■
Aluminium		Titanium alloyed	■



Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TiCN	CT 4	
3,0	7,0	37,0	3,0	—		116 210		—			1
6,0	10,0	50,0	6,0	—		116 211		—			1
8,0	13,0	53,0	6,0	—		116 212		—			1
10,0	16,0	56,0	6,0	—		116 213		—			1
12,0	20,0	60,0	6,0	—		116 214		—			1
16,0	25,0	65,0	6,0	—		116 215		—			1



Tungsten carbide rotary burrs shape F ball nose tree (RBF)

Packing unit: each in plastic packaging

	ALU	CT 4	CT 4		ALU	CT 4	CT 4
Steel (N/mm2) < 900		■	■	Brass		■	■
Steel (N/mm2) < 1100		■	■	Bronze	■		
Steel (N/mm2) < 1300		■	■	Plastics	■		
Stainless steel		■	■	Cast iron		■	■
Aluminium	■			Titanium alloyed		■	■



Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TiCN	CT 4	
3,0	7,0	37,0	3,0	—		116 050		—			1
6,0	18,0	58,0	6,0	116 030 A		116 030		116 030 TC			1
8,0	18,0	60,0	6,0	—		116 031		116 031 TC			1
10,0	20,0	60,0	6,0	—		116 032		116 032 TC			1
12,0	25,0	65,0	6,0	116 033 A		116 033		116 033 TC			1
16,0	30,0	70,0	6,0	—		116 034		116 034 TC			1



Tungsten carbide rotary burrs shape G tree (SPG)

Packing unit: each in plastic packaging

	ALU	CT4	CT4
Steel (N/mm2) < 900		■	■
Steel (N/mm2) < 1100		■	■
Steel (N/mm2) < 1300		■	■
Stainless steel		■	■
Aluminium	■		

	ALU	CT4	CT4
Brass		■	■
Bronze	■		
Plastics	■		
Cast iron		■	■
Titanium alloyed		■	■



Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT4	TC	TICN	CT4	
3,0	13,0	38,0	3,0	—		116 049		—			1
6,0	18,0	58,0	6,0	116 025 A		116 025		116 025 TC			1
8,0	18,0	60,0	6,0	—		116 026		116 026 TC			1
10,0	20,0	60,0	6,0	—		116 027		116 027 TC			1
12,0	25,0	65,0	6,0	116 028 A		116 028		116 028 TC			1
16,0	25,0	70,0	6,0	—		116 029		116 029 TC			1

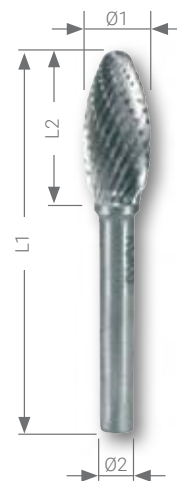


Tungsten carbide rotary burrs shape H flame (FLH)

Packing unit: each in plastic packaging

	CT4
Steel (N/mm2) < 900	■
Steel (N/mm2) < 1100	■
Steel (N/mm2) < 1300	■
Stainless steel	■
Aluminium	

	CT4
Brass	■
Bronze	
Plastics	
Cast iron	■
Titanium alloyed	■



Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT4	TC	TICN	CT4	
3,0	14,0	38,0	3,0	—		116 216		—			1
6,0	13,0	50,0	6,0	—		116 217		—			1
8,0	20,0	65,0	6,0	—		116 218		—			1
10,0	20,0	65,0	6,0	—		116 219		—			1
12,0	30,0	75,0	6,0	—		116 220		—			1
16,0	35,0	80,0	6,0	—		116 221		—			1

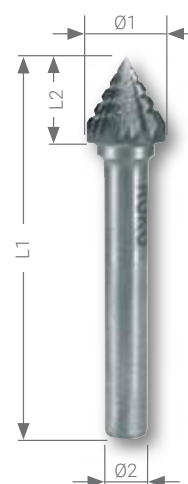


Tungsten carbide rotary burrs shape J cone 60° (KSJ)

Packing unit: each in plastic packaging

	CT 4		CT 4
Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100	■	Bronze	
Steel (N/mm ²) < 1300	■	Plastics	
Stainless steel	■	Cast iron	■
Aluminium		Titanium alloyed	■

Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TiCN	CT 4	
3,0	3,0	38,0	3,0	—		116 222		—			1
6,0	5,0	50,0	6,0	—		116 223		—			1
10,0	8,7	53,0	6,0	—		116 224		—			1
12,0	11,0	60,0	6,0	—		116 225		—			1
16,0	13,8	65,0	6,0	—		116 226		—			1

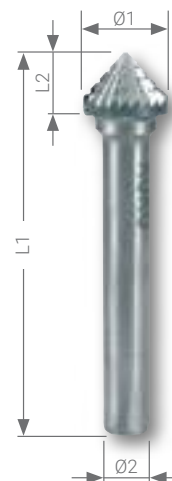


Tungsten carbide rotary burrs shape K cone 90° (KSK)

Packing unit: each in plastic packaging

	CT 4		CT 4
Steel (N/mm ²) < 900	■	Brass	■
Steel (N/mm ²) < 1100	■	Bronze	
Steel (N/mm ²) < 1300	■	Plastics	
Stainless steel	■	Cast iron	■
Aluminium		Titanium alloyed	■

Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TiCN	CT 4	
3,0	3,0	38,0	3,0	—		116 227		—			1
6,0	5,0	50,0	6,0	—		116 228		—			1
10,0	5,0	50,0	6,0	—		116 229		—			1
12,0	8,0	53,0	6,0	—		116 230		—			1
16,0	8,0	53,0	6,0	—		116 231		—			1



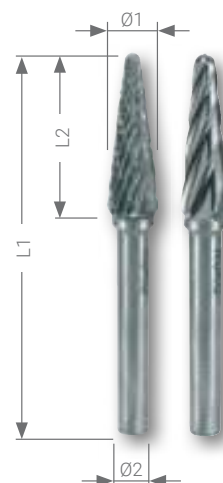


Tungsten carbide rotary burrs shape L round cone (KEL)

Packing unit: each in plastic packaging

	ALU	CT 4		ALU	CT 4
Steel (N/mm ²) < 900		■	Brass		■
Steel (N/mm ²) < 1100		■	Bronze	■	
Steel (N/mm ²) < 1300		■	Plastics	■	
Stainless steel		■	Cast iron		■
Aluminium	■		Titanium alloyed		■

Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TICN	CT 4	
3,0	12,0	38,0	3,0	—		116 232		—			1
6,0	18,0	52,0	6,0	116 233 A		116 233		—			1
8,0	20,0	60,0	6,0	—		116 234		—			1
10,0	20,0	60,0	6,0	116 235 A		116 235		—			1
12,0	30,0	70,0	6,0	116 236 A		116 236		—			1
16,0	30,0	70,0	6,0	—		116 237		—			1

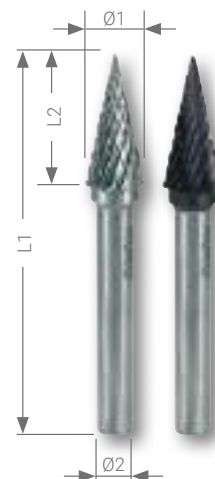


Tungsten carbide rotary burrs shape M cone (SKM)

Packing unit: each in plastic packaging

	CT 4	CT 4		CT 4	CT 4
Steel (N/mm ²) < 900	■	■	Brass	■	■
Steel (N/mm ²) < 1100	■	■	Bronze		
Steel (N/mm ²) < 1300	■	■	Plastics		
Stainless steel	■	■	Cast iron	■	■
Aluminium			Titanium alloyed	■	■

Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC	ALU	TC	CT 4	TC	TICN	CT 4	
3,0	11,0	41,0	3,0	—		116 051		—			1
6,0	18,0	58,0	6,0	—		116 035		116 035 TC			1
8,0	20,0	60,0	6,0	—		116 036		116 036 TC			1
10,0	20,0	60,0	6,0	—		116 037		116 037 TC			1
12,0	25,0	65,0	6,0	—		116 038		116 038 TC			1
16,0	25,0	65,0	6,0	—		116 039		116 039 TC			1






Tungsten carbide rotary burrs

shape N angle (WKN)

Packing unit: each in plastic packaging

			
Steel (N/mm2) < 900		Brass	
Steel (N/mm2) < 1100		Bronze	
Steel (N/mm2) < 1300		Plastics	
Stainless steel		Cast iron	
Aluminium		Titanium alloyed	

Ø1 mm	L2 mm	L1 mm	Ø2 mm	TC		ALU	TC		CT 4	TC	TiCN	CT 4	
3,0	7,0	37,0	3,0	—			116 238			—			1
6,0	7,0	47,0	6,0	—			116 239			—			1
10,0	13,0	53,0	6,0	—			116 240			—			1
12,0	13,0	53,0	6,0	—			116 241			—			1
16,0	13,0	53,0	6,0	—			116 242			—			1



Sets of tungsten carbide rotary burrs in steel case

TC	10-piece set of tungsten carbide rotary burrs TC	116 003
CT 4	2 x shape A, cylinder (ZYA) without end toothing Ø D1 10,0 / 12,0 mm 2 x shape C, oval (WRC) Ø D1 10,0 / 12,0 mm 2 x shape G, tree (SPG) Ø D1 10,0 / 12,0 mm 2 x shape F, ball nose tree (RBF) Ø D1 10,0 / 12,0 mm 1 x shape M, cone (SKM) Ø D1 12,0 mm 1 x shape D, ball type (KUD) Ø D1 12,0 mm	
TC	10-piece set of tungsten carbide rotary burrs TiCN	116 003 TC
TiCN	2 x shape A, cylinder (ZYA) without end toothing Ø D1 10,0 / 12,0 mm 2 x shape C, oval (WRC) Ø D1 10,0 / 12,0 mm 2 x shape G, tree (SPG) Ø D1 10,0 / 12,0 mm 2 x shape F, ball nose tree (RBF) Ø D1 10,0 / 12,0 mm 1 x shape M, cone (SKM) Ø D1 12,0 mm 1 x shape D, ball type (KUD) Ø D1 12,0 mm	
TC	10-piece set of tungsten carbide rotary burrs ALU	116 103 A
ALU	2 x shape B, cylinder (ZYAS) with end toothing Ø D1 6,0 / 12,0 mm 2 x shape C, oval (WRC) Ø D1 6,0 / 12,0 mm 2 x shape G, tree (SPG) Ø D1 6,0 / 12,0 mm 2 x shape F, ball nose tree (RBF) Ø D1 6,0 / 12,0 mm 2 x shape D, ball type (KUD) Ø D1 6,0 / 12,0 mm	



116 003



116 003 TC

Sets of tungsten carbide rotary burrs in plastic case

TC	10-piece set of tungsten carbide rotary burrs TC	116 003 RO
CT 4	2 x shape A, cylinder (ZYA) without end toothing Ø D1 10,0 / 12,0 mm 2 x shape C, oval (WRC) Ø D1 10,0 / 12,0 mm 2 x shape G, tree (SPG) Ø D1 10,0 / 12,0 mm 2 x shape F, ball nose tree (RBF) Ø D1 10,0 / 12,0 mm 1 x shape M, cone (SKM) Ø D1 12,0 mm 1 x shape D, ball type (KUD) Ø D1 12,0 mm	
TC	10-piece set of tungsten carbide rotary burrs TiCN	116 003 TCRO
TiCN	2 x shape A, cylinder (ZYA) without end toothing Ø D1 10,0 / 12,0 mm 2 x shape C, oval (WRC) Ø D1 10,0 / 12,0 mm 2 x shape G, tree (SPG) Ø D1 10,0 / 12,0 mm 2 x shape F, ball nose tree (RBF) Ø D1 10,0 / 12,0 mm 1 x shape M, cone (SKM) Ø D1 12,0 mm 1 x shape D, ball type (KUD) Ø D1 12,0 mm	
TC	10-piece set of tungsten carbide rotary burrs ALU	116 103 ARO
ALU	2 x shape B, cylinder (ZYAS) with end toothing Ø D1 6,0 / 12,0 mm 2 x shape C, oval (WRC) Ø D1 6,0 / 12,0 mm 2 x shape G, tree (SPG) Ø D1 6,0 / 12,0 mm 2 x shape F, ball nose tree (RBF) Ø D1 6,0 / 12,0 mm 2 x shape D, ball type (KUD) Ø D1 6,0 / 12,0 mm	







116 003 RO



116 003 TCRO



Sets of tungsten carbide rotary burrs in a lockable counter display

 	<p>35-piece set of tungsten carbide rotary burrs TC in a convenient table display each 1 x Ø D1 6,0 mm + 8,0 mm + 10,0 mm + 12,0 mm + 16,0 mm</p> <p>5 TC rotary burrs shape A, cylinder (ZYA) without end toothing 5 TC rotary burrs shape B, cylinder (ZYAS) with end toothing 5 TC rotary burrs shape C, oval (WRC) 5 TC rotary burrs shape G, tree (SPG) 5 TC rotary burrs shape F, ball nose tree (RBF) 5 TC rotary burrs shape M, cone (SKM) 5 TC rotary burrs shape D, ball type (KUD)</p>	116 008
 	<p>35-piece set of tungsten carbide rotary burrs TiCN in a convenient table display each 1 x Ø D1 6,0 mm + 8,0 mm + 10,0 mm + 12,0 mm + 16,0 mm</p> <p>5 TC rotary burrs shape A, cylinder (ZYA) without end toothing 5 TC rotary burrs shape B, cylinder (ZYAS) with end toothing 5 TC rotary burrs shape C, oval (WRC) 5 TC rotary burrs shape G, tree (SPG) 5 TC rotary burrs shape F, ball nose tree (RBF) 5 TC rotary burrs shape M, cone (SKM) 5 TC rotary burrs shape D, ball type (KUD)</p>	116 008 TC









116 008



116 008 TC



Set of tungsten carbide rotary burrs in mini-box

 	<p>3-piece set of tungsten carbide rotary burrs in mini-box each 1 x Ø D1 10,0 mm</p> <p>1 TC rotary burr shape B, cylinder (ZYAS) with end toothing 1 TC rotary burr shape G, pionted arch (SPG) 1 TC rotary burr shape D, cone (KUD)</p>	116 001
 	<p>10-piece set of tungsten carbide rotary burrs in mini-box each 1 x Ø D1 6,0 mm + Ø D1 12,0 mm</p> <p>2 TC rotary burrs shape B, cylinder (ZYAS) with end toothing 2 TC rotary burrs shape C, oval (WRC) 2 TC rotary burrs shape G, tree (SPG) 2 TC rotary burrs shape F, ball nose tree (RBF) 2 TC rotary burrs shape D, ball type (KUD)</p>	116 002
 	<p>5-piece set of tungsten carbide rotary burrs in mini-box each 1 x Ø D1 10,0 mm</p> <p>1 TC rotary burr shape B, cylinder (ZYAS) with end toothing 1 TC rotary burr shape C, oval (WRC) 1 TC rotary burr shape G, tree (SPG) 1 TC rotary burr shape F, ball nose tree (RBF) 1 TC rotary burr shape D, ball type (KUD)</p>	116 004



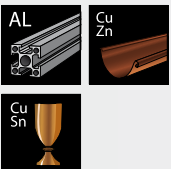




116 002



116 004

Table of recommended cutting speeds for rotary burrs

Material groups			Machining application	Cutting speed
Steel, Cast steel 	Unhardened, untempered steels up to 1200 N/mm ² (< 38 HRC)	Structural steels, carbon steels, tool steels, unalloyed steels, case hardening steels, cast steel	Coarse machining = High material removal	250 - 350 m/min
	Hardened, tempered steels up to 1200 N/mm ² (> 38 HRC)	Tool steels, heat-treatable steels, alloyed steels, cast steel		250 - 350 m/min
Stainless steel (INOX) 	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	Coarse machining = High material removal	250 - 350 m/min
Nonferrous metals 	Soft nonferrous metals Nonferrous heavy metals	Aluminium alloys, brass, Copper, zinc	Coarse machining = High material removal	600 - 900 m/min
	Hard nonferrous metals	Bronze, titanium/titanium alloys, hard aluminium alloys (high silicon content)		250 - 350 m/min
	Highly heat-resistant Materials	Nickel-based and cobalt-based alloys (engine and turbine construction)		300 - 450 m/min
Cast iron 	Grey cast iron, white cast iron	Cast iron with lamellar graphite, with nodular/spheroidal graphite white malleable (cast) iron black malleable (cast) iron	Coarse machining = High material removal	600 - 900 m/min
Plastics, other materials 	Fibre-reinforced plastics, thermoplastics, hard rubber		Coarse machining = High material removal	500 - 1.100 m/min
			Fine machining = Low material removal	

Cutting speed V _c = m/min	250	300	350	400	450	500	600	900
Ø mm	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.
3,0	27.000	32.000	37.000	44.000	48.000	54.000	64.000	95.000
4,0	20.000	24.000	28.000	32.000	36.000	40.000	48.000	72.000
6,0	13.000	16.000	19.000	21.000	24.000	27.000	32.000	48.000
8,0	10.000	12.000	14.000	16.000	18.000	20.000	24.000	36.000
10,0	8.000	10.000	11.000	13.000	14.000	16.000	19.000	29.000
12,0	7.000	8.000	9.000	11.000	12.000	13.000	16.000	24.000
16,0	5.000	6.000	7.000	8.000	9.000	10.000	12.000	18.000



Pneumatic grinder (short)

The RUKO pneumatic grinder in the short design - The compact, fast tool for deburring, polishing and machining welding seams!

The RUKO pneumatic grinder has a rubberised, non-slip handle, which absorbs vibration and protects the user from slipping off whilst working. The speed can be adjusted by a governor on top of the handle. It has a tool adapter made of hardened steel. The exhaust air is directed backwards through the handle by means of a 360° rotational principle. The RUKO pneumatic grinder features an integrated air filter, which protects the motor from dirt that could get into the inside with the compressed air.

Connection adapter included!

Packing unit: individual cartons

	L1 mm	Ø	Article no.	
Pneumatic grinder (short)	157,0	G 1/4"	116 100 L	1



Pneumatic grinder (90° angle head)

The RUKO pneumatic grinder with 90° angle head - The compact, fast tool for deburring, polishing and machining welding seams!

The RUKO pneumatic grinder has a rubberised, non-slip handle, which absorbs vibration and protects the user from slipping off whilst working. The speed can be adjusted by a governor on top of the handle. It has a tool adapter made of hardened steel. The exhaust air is directed backwards through the handle by means of a 360° rotational principle. The RUKO pneumatic grinder features an integrated air filter, which protects the motor from dirt that could get into the inside with the compressed air. The 90° angle head makes it easier to work in tight and difficult to reach places.

Connection adapter included!

Packing unit: individual cartons

	L1 mm	Ø	Article no.	
Pneumatic grinder (90°)	162,0	G 1/4"	116 110 L	1





Pneumatic grinder (115° angle head)

The RUKO pneumatic grinder with 115° angle head - The compact, fast tool for deburring, polishing and machining welding seams!

The RUKO pneumatic grinder has a rubberised, non-slip handle, which absorbs vibration and protects the user from slipping off whilst working. The speed can be adjusted by a governor on top of the handle. It has a tool adapter made of hardened steel. The exhaust air is directed backwards through the handle by means of a 360° rotational principle. The RUKO pneumatic grinder features an integrated air filter, which protects the motor from dirt that could get into the inside with the compressed air. The 115° angle head makes it easier to work in tight and difficult to reach places.

Connection adapter included!

Packing unit: individual cartons

	L1 mm	Ø	Article no.	
Pneumatic grinder (115°)	201,0	G 1/4"	116 120 L	1



Pneumatic grinder (long)

The RUKO pneumatic grinder in the long design - The compact, fast tool for deburring, polishing and machining welding seams!

The RUKO pneumatic grinder has a rubberised, non-slip handle, which absorbs vibration and protects the user from slipping off whilst working. The speed can be adjusted by a governor on top of the handle. It has a tool adapter made of hardened steel. The exhaust air is directed backwards through the handle by means of a 360° rotational principle. The RUKO pneumatic grinder features an integrated air filter, which protects the motor from dirt that could get into the inside with the compressed air. The tool extension makes it possible to work in tight, difficult to reach and deep places.

Connection adapter included!

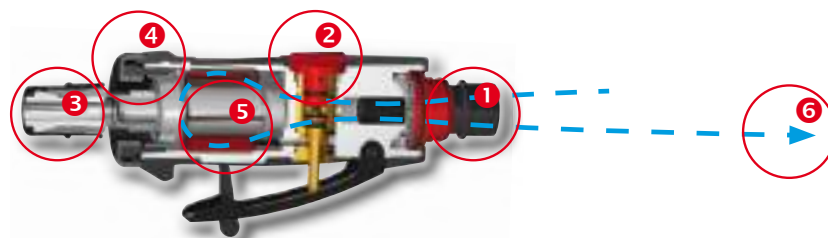
Packing unit: individual cartons

	L1 mm	Ø	Article no.	
Pneumatic grinder (long)	257,0	G 1/4"	116 130 L	1

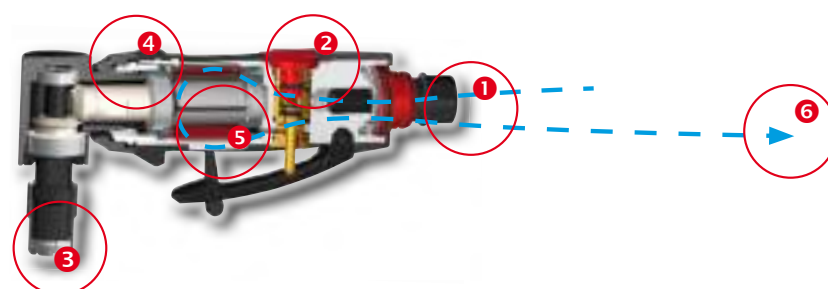


Technical drawings:

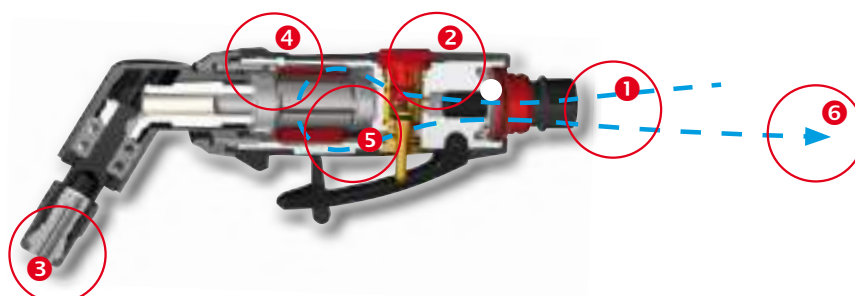
Pneumatic grinder (short)
116 100 L



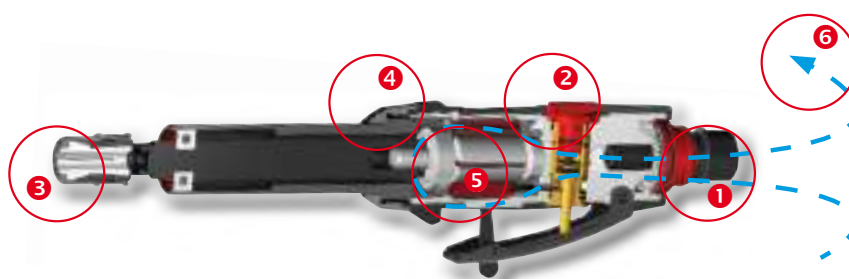
Pneumatic grinder (90°)
116 110 L



Pneumatic grinder (115°)
116 120 L



Pneumatic grinder (long)
116 130 L



- ❶ Air filter
- ❷ Speed control
- ❸ Adapter made of hardened steel
- ❹ Rubberised, non-slip handle
- ❺ Heavy-duty vane motor
- ❻ Exhaust air directed through the handle by means of 360° rotational principle



Compressed air grinder set with coupling plug incl. set of rotary burrs TC in plastic case

	Article no.
12-piece set of compressed air grinder 1 Compressed air grinder + Set of tungsten carbide rotary burrs in mini-box, 10 pcs. each 1x Ø D1 6,0 + 12,0 mm 2 TC rotary burrs shape B, cylinder (ZYAS) with end toothing 2 TC rotary burrs shape C, oval (WRC) 2 TC rotary burrs shape G, tree (SPG) 2 TC rotary burrs shape F, ball nose tree (RBF) 2 TC rotary burrs shape D, ball type (KUD) + Coupling plug for compressed air grinder	116 100
5-piece set of compressed air grinder 1 Compressed air grinder + Set of tungsten carbide rotary burrs in mini-box, 3 pcs. each 1x Ø D1 10,0 mm 1 TC rotary burr shape B, cylinder (ZYAS) with end toothing 1 TC rotary burr shape G, pionted arch (SPG) 1 TC rotary burr shape D, cone (KUD) + Coupling plug for compressed air grinder	116 113



116 100



116 113

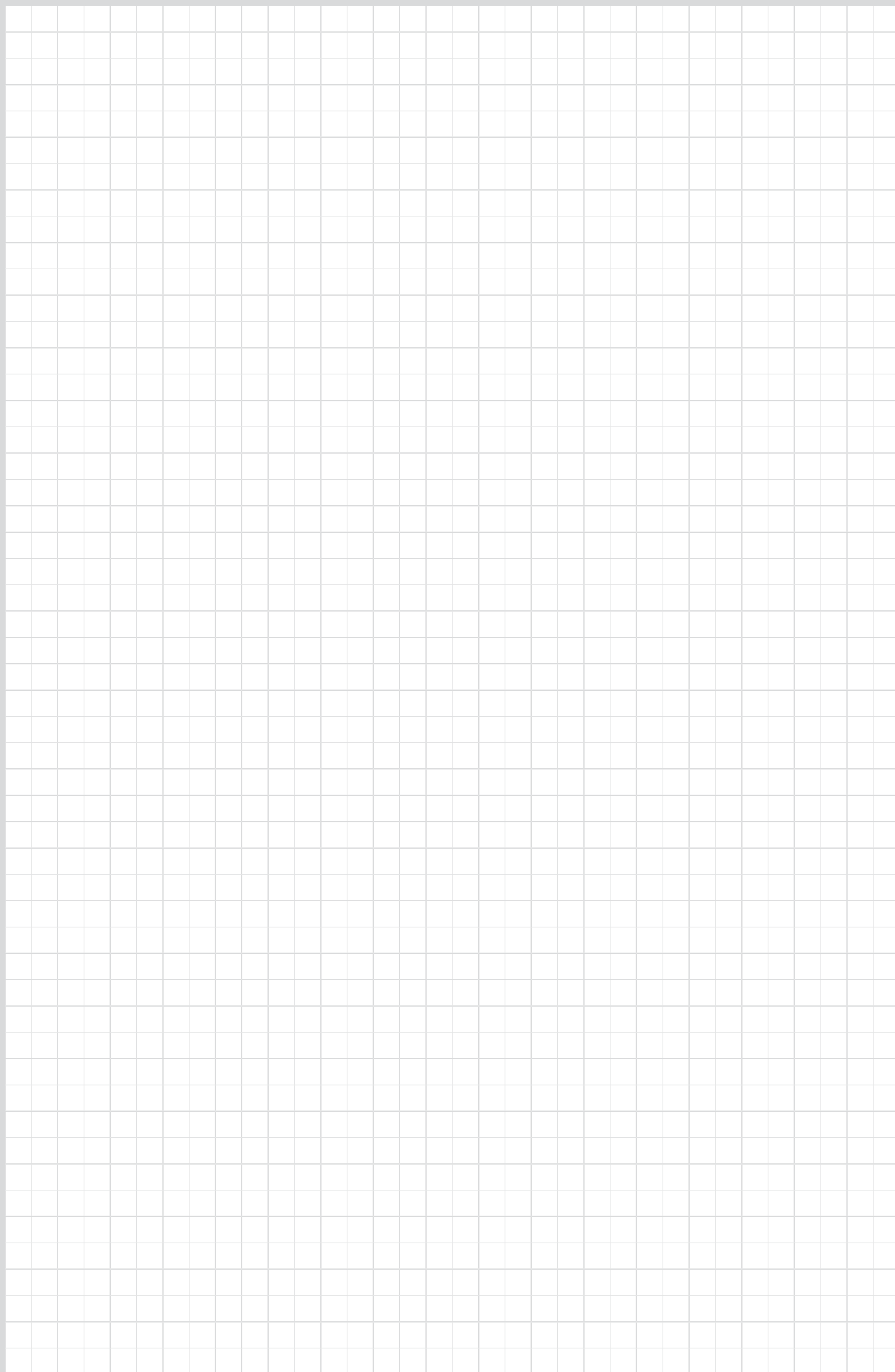
Accessories for compressed air grinder set

Packing unit: each in plastic packaging

	Article no.
Compressed air grinder solo 116 100 L + Coupling plug 116 101 L	116 100 S
Rotor replacement for compressed air grinder	116 100-1
Coupling plug, nominal size 7,2 mm, external thread G 1/4"	116 101 L
Collet 3,0 mm for compressed air grinder	116 121
Collet 1/4" for compressed air grinder	116 119



116 101 L





HOLE SAWS

FASCINATION FOR PRECISION®

Range and applications overview:



Surface	Cutting edges	Ø tolerance	Cutting depth	Material thickness	Shank	Ø mm	Article no.	Page
						12,0 - 80,0	128 035 - 128 080	233
						16,0 - 120,0	105 016 - 105 120	234 - 235
						15,0 - 100,0	113 015 - 113 100	236
						14,0 - 210,0	106 014 - 106 200	238 - 239
						14,0 - 210,0	126 014 - 126 200	238 - 239



Steel (N/mm ²) < 900	Steel (N/mm ²) < 1100	Steel (N/mm ²) < 1300	Stainless steel	Aluminium	Brass	Bronze	Plastics	Cast iron	Titanium alloyed



HSS-G hole saws

Packing unit: individual plastic pack

Steel (N/mm2) < 900	■	Brass	■
Steel (N/mm2) < 1100		Bronze	□
Steel (N/mm2) < 1300		Plastics	■
Stainless steel		Cast iron	□
Aluminium	■	Titanium alloyed	



Ø1 mm	Ø inch	PG	Tube dimensions inch	Ø2 mm	HSS		
12,0	15/32			8,0	128 012	1	
13,0				8,0	128 013	1	
14,0	9/16			8,0	128 014	1	
15,0				10,0	128 015	1	
16,0	5/8	PG 9		10,0	128 016	1	
17,0				10,0	128 017	1	
18,0				10,0	128 018	1	
19,0	3/4		3/8	10,0	128 019	1	
20,0				10,0	128 020	1	
21,0				10,0	128 021	1	
22,0			1/2	10,0	128 022	1	
23,0				10,0	128 023	1	
24,0	15/16			10,0	128 024	1	
25,0				10,0	128 025	1	
26,0				10,0	128 026	1	
27,0	1 1/16			10,0	128 027	1	
28,0	1 3/32			10,0	128 028	1	
29,0			3/4	10,0	128 029	1	
30,0	1 3/16			10,0	128 030	1	
31,0	1 7/32			10,0	128 031	1	
32,0	1 1/4			10,0	128 032	1	
33,0				10,0	128 033	1	
34,0				10,0	128 034	1	

Ø1 mm	Ø inch	PG	Tube dimensions inch	Ø2 mm	HSS		
35,0	1 3/8		1	10,0	128 035	1	
36,0				10,0	128 036	1	
37,0	1 7/16	PG 29		10,0	128 037	1	
38,0	1 1/2			10,0	128 038	1	
39,0				10,0	128 039	1	
40,0	1 9/16			10,0	128 040	1	
41,0	1 5/8			10,0	128 041	1	
42,0				10,0	128 042	1	
43,0	1 11/16			10,0	128 043	1	
44,0	1 3/4		1 1/4	10,0	128 044	1	
45,0				10,0	128 045	1	
46,0				10,0	128 046	1	
47,0	1 7/8	PG 36		10,0	128 047	1	
48,0				10,0	128 048	1	
49,0				10,0	128 049	1	
50,0	1 31/32			10,0	128 050	1	
55,0				12,0	128 055	1	
60,0	2 3/8	PG 48		12,0	128 060	1	
65,0				12,0	128 065	1	
70,0	2 3/4			12,0	128 070	1	
75,0				12,0	128 075	1	
80,0				12,0	128 080	1	

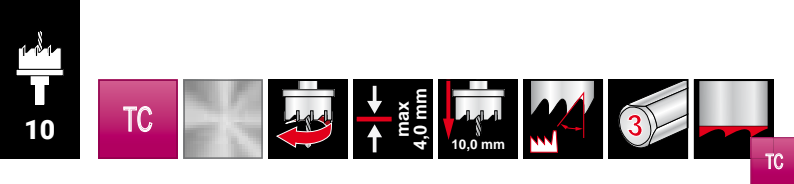


Accessories

Packing unit: individual plastic pack



	For hole saws Ø mm	Shank	Magnetic-stand drilling machine	HSS		
Arbor holder including pilot drill M 10 x 1,25 mm	12,0 - 14,0	Ø 8,0 mm	RS10	128 211	1	
Arbor holder including pilot drill M 12 x 1,25 mm	15,0 - 34,0	Ø 10,0 mm	RS10	128 212	1	
Arbor holder including pilot drill M 14 x 1,50 mm	35,0 - 50,0	Ø 10,0 mm	RS20 - RS40e	128 213	1	
Arbor holder including pilot drill M 16 x 1,50 mm	51,0 - 100,0	Ø 12,0 mm	RS20 - RS40e	128 214	1	
Pilot pin Ø 6,0 x 52,0 mm	12,0 - 100,0	-	-	128 215	1	
Ejector spring	Ø > 20,0	-	-	128 216	1	



Tungsten carbide hole saws, shallow cut

Packing unit: individual carton

Steel (N/mm2) < 900	
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Stainless steel	
Aluminium	

Brass	
Bronze	
Plastics	
Cast iron	
Titanium alloyed	



Ø1 mm	Ø inch	M + PG	Tube dimensions inch	Ø2 mm	TC		
16,0	5/8	~ PG 9		10,0	105 016	1	
16,5		M 16		10,0	105 165	1	
17,0				10,0	105 017	1	
18,0				10,0	105 018	1	
18,6		PG 11		10,0	105 186	1	
19,0	3/4		3/8	10,0	105 019	1	
20,0				10,0	105 020	1	
20,4	13/16	M 20 / PG 13,5		10,0	105 204	1	
21,0				10,0	105 021	1	
22,0			1/2	10,0	105 022	1	
22,5	7/8	PG 16		10,0	105 225	1	
23,0				10,0	105 023	1	
24,0	15/16			10,0	105 024	1	
25,0				10,0	105 025	1	
25,5	1	M 25		10,0	105 255	1	
26,0				10,0	105 026	1	
27,0	1 1/16			10,0	105 027	1	
28,0	1 3/32			10,0	105 028	1	
28,3	1 1/8	PG 21		10,0	105 283	1	
29,0			3/4	10,0	105 029	1	
30,0	1 3/16			10,0	105 030	1	
32,0	1 1/4			10,0	105 032	1	
32,5		M 32		10,0	105 325	1	
34,0				10,0	105 034	1	
35,0	1 3/8		1	10,0	105 035	1	
36,0				10,0	105 036	1	
37,0	1 7/16	PG 29		10,0	105 037	1	
38,0	1 1/2			10,0	105 038	1	

Ø1 mm	Ø inch	M + PG	Tube dimensions inch	Ø2 mm	TC		
40,0	1 9/16			10,0	105 040	1	
40,5		M 40		10,0	105 405	1	
41,0	1 5/8			10,0	105 041	1	
42,0				10,0	105 042	1	
43,0	1 11/16			10,0	105 043	1	
44,0	1 3/4		1 1/4	10,0	105 044	1	
45,0				10,0	105 045	1	
48,0				10,0	105 048	1	
50,0	1 31/32			10,0	105 050	1	
50,5		M 50		10,0	105 505	1	
51,0	2		1 1/2	13,0	105 051	1	
52,0				13,0	105 052	1	
54,0	2 1/8	PG 42		13,0	105 054	1	
55,0				13,0	105 055	1	
57,0	2 1/4			13,0	105 057	1	
60,0	2 3/8	~ PG 48		13,0	105 060	1	
63,5	2 1/2	M 63	2	13,0	105 635	1	
65,0				13,0	105 065	1	
68,0				13,0	105 068	1	
70,0	2 3/4			13,0	105 070	1	
75,0				13,0	105 075	1	
80,0				13,0	105 080	1	
85,0				13,0	105 085	1	
90,0				13,0	105 090	1	
95,0	3 3/4			13,0	105 095	1	
100,0				13,0	105 100	1	
110,0				13,0	105 110	1	
120,0				13,0	105 120	1	

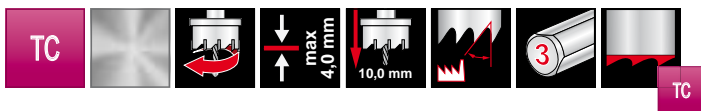


Accessories


Packing unit: individual plastic pack




Ø mm	Length mm	For hole saws Ø mm	For hole saws cutting depth	HSSE Co 5	TC	
6,0	52,0	16,0 - 70,0	10,0 mm	105 170	105 172	1
8,0	52,0	75,0 - 150,0	10,0 mm	105 171	105 173	1
Ejector spring				105 174		1

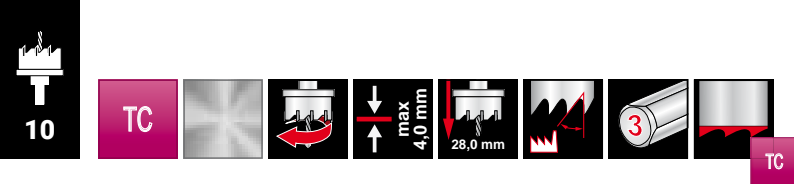


Sets of tungsten carbide hole saws, shallow cut in plastic case

	TC 
7-piece set of tungsten carbide hole saws with 5 tungsten carbide hole saws, shallow cut Ø 20,0 mm - 22,0 mm - 25,0 mm - 32,0 mm - 35,0 mm 1 cutting paste 50 g, article no. 101 021 1 extra pilot drill 6,0 mm HSSE-Co 5 article no. 105 170	105 300
6-piece set of tungsten carbide hole saws with 4 tungsten carbide hole saws, shallow cut Ø 16,5 mm ≈ M 16, Ø 20,4 mm ≈ M 20 / PG 13,5, Ø 25,5 mm ≈ M 25, Ø 32,5 mm ≈ M 32 1 cutting paste 50 g, article no. 101 021 1 extra pilot drill 6,0 mm HSSE-Co 5 article no. 105 170	105 302



 If possible, do not use automatic feed motion, since otherwise the risk of fracture increases.



Tungsten carbide multigrade hole saws MHS

Ø 15,0 up to 30,0 mm hole saw MHS and shank in one piece. Complete with pilot pin and wrench.

Ø 31,0 up to 100,0 mm hole saws MHS without arbor.

Ø 65,0 up to 100,0 mm on we recommend to use our morse taper holder
article no. 113 203, 108 102 - 108 105.

Adapter: thread M 18 x 6 P1,5

Packing unit: individual carton



Cutting depth in steel and
VA steel max. up to 20.0 mm.

In soft and non-ferrous metals
max. up to 28.0 mm.

Steel (N/mm2) < 900	
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Stainless steel	
Aluminium	

Brass	
Bronze	
Plastics	
Cast iron	
Titanium alloyed	

Ø1 mm	Ø inch	Tube dimen- sions inch	Ø2 mm	TC		
15,0			13,0 mm	113 015	1	
16,0	5/8		13,0 mm	113 016	1	
17,0			13,0 mm	113 017	1	
18,0			13,0 mm	113 018	1	
19,0	3/4	3/8	13,0 mm	113 019	1	
20,0			13,0 mm	113 020	1	
21,0			13,0 mm	113 021	1	
22,0	7/8	1/2	13,0 mm	113 022	1	
23,0			13,0 mm	113 023	1	
24,0	15/16		13,0 mm	113 024	1	
25,0	1		13,0 mm	113 025	1	
26,0			13,0 mm	113 026	1	
27,0	1 1/16		13,0 mm	113 027	1	
28,0	1 3/32		13,0 mm	113 028	1	
29,0	1 1/8	3/4	13,0 mm	113 029	1	
30,0	1 3/16		13,0 mm	113 030	1	
32,0	1 1/4		13,0 mm / MT 2/3	113 032	1	

Ø1 mm	Ø inch	Tube dimen- sions inch	Ø2 mm	TC		
34,0			13,0 mm / MT 2/3	113 034	1	
35,0	1 3/8	1	13,0 mm / MT 2/3	113 035	1	
36,0			13,0 mm / MT 2/3	113 036	1	
38,0	1 1/2		13,0 mm / MT 2/3	113 038	1	
40,0			13,0 mm / MT 2/3	113 040	1	
42,0			13,0 mm / MT 2/3	113 042	1	
44,0	1 3/4	1 1/4	13,0 mm / MT 2/3	113 044	1	
45,0			13,0 mm / MT 2/3	113 045	1	
50,0			13,0 mm / MT 2/3	113 050	1	
55,0			13,0 mm / MT 2/3	113 055	1	
60,0	2 3/8		13,0 mm / MT 2/3	113 060	1	
65,0			13,0 mm / MT 2/3	113 065	1	
68,0			13,0 mm / MT 2/3	113 068	1	
70,0	2 3/4		13,0 mm / MT 2/3	113 070	1	
75,0			13,0 mm / MT 2/3	113 075	1	
80,0			13,0 mm / MT 2/3	113 080	1	
100,0			13,0 mm / MT 2/3	113 100	1	



Accessories

Packing unit: individual plastic pack





Ø mm	Length mm	For hole saws MHS Ø mm	HSSE Co 5	TC	
6,0	80,0	15,0 - 100,0	113 216	-	1
6,0	72,0	15,0 - 100,0	-	113 217	1
Ejector spring			113 218		1

Arbor holders for tungsten carbide multigrade hole saws MHS with threaded retainer M18 x 6 P1,5

Packing unit: individual plastic pack




	For hole saws MHS Ø mm	Shank	Magnetic-stand drilling machine	Article no.	
Arbor holder including pilot drill article no. 113 216	31,0 - 100,0	Ø 13,0 mm	RS10	113 201	1
Arbor holder including pilot drill article no. 113 216	31,0 - 100,0	MT 2	RS20 / RS25e	113 203	1

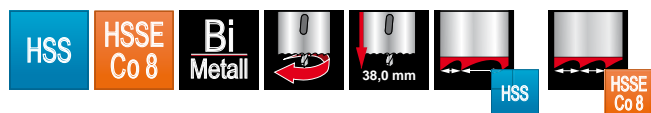
	For hole saws MHS Ø mm	Shank morse taper	Magnetic-stand drilling machine	Article no.	
Arbor holder including adapter article no. 108 108, pilot pin article no. 108 110 and cooling bottle article no. 108 101	31,0 - 100,0	MT 2	RS20 / RS25e	108 102	1
Arbor holder with interior cooling including adapter article no. 108 108 and pilot pin article no. 108 110	31,0 - 100,0	MT 2	RS20 / RS25e	108 104	1
Arbor holder including adapter article no. 108 108, pilot pin article no. 108 110 and cooling bottle article no. 108 101	31,0 - 100,0	MT 3	RS30e / RS40e	108 103	1
Arbor holder with interior cooling including adapter article no. 108 108 and pilot pin article no. 108 110	31,0 - 100,0	MT 3	RS30e / RS40e	108 105	1

Adapter for tungsten carbide multigrade hole saws MHS with threaded retainer M18 x 6 P1,5

Packing unit: individual plastic pack



	For hole saws MHS Ø mm	Article no.	
Adapter with Weldon shank 3/4"	31,0 - 100,0	108 108	1
Ejector pin Ø 6,35 x 118,0 mm	31,0 - 100,0	108 110	1








Jacket: special steel

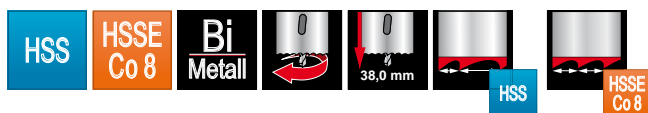
Bi-metal hole saws HSS with variable pitch toothting / HSSE-Co 8 with regular fine pitch toothting

Packing unit: individual carton

							
Steel (N/mm2) < 900				Brass			
Steel (N/mm2) < 1100				Bronze			
Steel (N/mm2) < 1300				Plastics			
Stainless steel				Cast iron			
Aluminium				Titanium alloyed			



Ø mm	Ø inch	PG	Tube dimensions inch	For arbor holders					
14,0	9/16			A1 / A4 / A5	106 014	126 014			1
16,0	5/8	~ PG 9		A1 / A4 / A5	106 016	126 016			1
17,0				A1 / A4 / A5	106 017	126 017			1
19,0	3/4	~ PG 11	3/8	A1 / A4 / A5	106 019	126 019			1
20,0				A1 / A4 / A5	106 020	126 020			1
21,0		~ PG 13,5		A1 / A4 / A5	106 021	126 021			1
22,0	7/8		1/2	A1 / A4 / A5	106 022	126 022			1
24,0	15/16	~ PG 16		A1 / A4 / A5	106 024	126 024			1
25,0	1			A1 / A4 / A5	106 025	126 025			1
27,0	1 1/16			A1 / A4 / A5	106 027	126 027			1
28,0	1 3/32			A1 / A4 / A5	106 028	126 028			1
29,0	1 1/8	~ PG 21	3/4	A1 / A4 / A5	106 029	126 029			1
30,0	1 3/16			A1 / A4 / A5	106 030	126 030			1
32,0	1 1/4			A2 / A6 / A7	106 032	126 032			1
33,0				A2 / A6 / A7	106 033	126 033			1
35,0	1 3/8		1	A2 / A6 / A7	106 035	126 035			1
36,0				A2 / A6 / A7	106 036	126 036			1
37,0		PG 29		A2 / A6 / A7	106 037	126 037			1
38,0	1 1/2			A2 / A6 / A7	106 038	126 038			1
40,0				A2 / A6 / A7	106 040	126 040			1
41,0	1 5/8			A2 / A6 / A7	106 041	126 041			1
43,0	1 11/16			A2 / A6 / A7	106 043	126 043			1
44,0	1 3/4		1 1/4	A2 / A6 / A7	106 044	126 044			1
46,0	1 13/16			A2 / A6 / A7	106 046	126 046			1
48,0	1 7/8	~ PG 36		A2 / A6 / A7	106 048	126 048			1
50,0				A2 / A6 / A7	106 050	126 050			1
51,0	2		1 1/2	A2 / A6 / A7	106 051	126 051			1
52,0				A2 / A6 / A7	106 052	126 052			1
54,0	2 1/8	PG 42		A2 / A6 / A7	106 054	126 054			1
55,0				A2 / A6 / A7	106 055	126 055			1
57,0	2 1/4			A2 / A6 / A7	106 057	126 057			1
59,0				A2 / A6 / A7	106 059	126 059			1
60,0	2 3/8	~ PG 48		A2 / A6 / A7	106 060	126 060			1
63,0				A2 / A6 / A7	106 063	126 063			1
64,0	2 1/2		2	A2 / A6 / A7	106 064	126 064			1
65,0				A2 / A6 / A7	106 065	126 065			1
67,0	2 5/8			A2 / A6 / A7	106 067	126 067			1
68,0				A2 / A6 / A7	106 068	126 068			1
70,0	2 3/4			A2 / A6 / A7	106 070	126 070			1
73,0	2 7/8			A2 / A6 / A7	106 073	126 073			1
76,0	3		2 1/2	A2 / A6 / A7	106 076	126 076			1
79,0	3 1/8			A2 / A6 / A7	106 079	126 079			1
83,0	3 1/4			A2 / A6 / A7	106 083	126 083			1
86,0	3 3/8			A2 / A6 / A7	106 086	126 086			1
89,0	3 1/2			A2 / A6 / A7	106 089	126 089			1
92,0	3 5/8		3	A2 / A6 / A7	106 092	126 092			1
95,0	3 3/4			A2 / A6 / A7	106 095	126 095			1
98,0	3 7/8			A2 / A6 / A7	106 098	126 098			1
102,0	4			A2 / A6 / A7	106 102	126 102			1
105,0			3 1/2	A2 / A6 / A7	106 105	126 105			1
108,0	4 1/4			A2 / A6 / A7	106 108	126 108			1
111,0	4 3/8			A2 / A6 / A7	106 111	126 111			1
114,0	4 1/2		4	A2 / A6 / A7	106 114	126 114			1
121,0	4 3/4			A2 / A6 / A7	106 121	126 121			1
127,0	5			A2 / A6 / A7	106 127	126 127			1
133,0				A2 / A6 / A7	106 133	126 133			1
140,0	5 1/2			A2 / A6 / A7	106 140	126 140			1
152,0	6			A2 / A6 / A7	106 152	126 152			1
160,0	6 5/16			A2 / A6 / A7	106 160	126 160			1
168,0	6 5/8			A2 / A6 / A7	106 168	126 168			1
177,0				A2 / A6 / A7	106 177	126 177			1
210,0	8 1/4			A2 / A6 / A7	106 200	126 200			1



Jacket: special steel

Sets of bi-metal hole saws HSS / HSSE-Co 8 in plastic cases




		HSS	HSSE Co 8
PK 1	8- piece set of bi-metal hole saws for plumbers 6 bi-metal hole saws Ø 19,0 - 22,0 - 29,0 - 38,0 - 44,0 - 57,0 mm + 2 arbor holders A2 and A4	106 301	126 301
PK 2	11- piece set of bi-metal hole saws for plumbers 9 bi-metal hole saws Ø 19,0 - 22,0 - 29,0 - 35,0 - 38,0 - 44,0 - 51,0 - 57,0 - 64,0 mm + 2 arbor holders A2 and A4	106 306	126 306
EK 1	8- piece set of bi-metal hole saws for electricians 6 bi-metal hole saws Ø 22,0 - 29,0 - 35,0 - 44,0 - 51,0 - 64,0 mm + 2 arbor holders A2 and A4	106 305	126 305
EK 2	8- piece set of bi-metal hole saws for electricians 6 bi-metal hole saws Ø 22,0 - 29,0 - 35,0 - 44,0 - 51,0 - 68,0 mm + 2 arbor holders A2 and A4	106 302	126 302
Universal	12- piece set of bi-metal hole saws Ø 19,0 - 22,0 - 25,0 - 29,0 - 35,0 - 38,0 - 44,0 - 51,0 - 57,0 - 64,0 mm + 2 arbor holders A2 and A4	106 303	126 303
Super	12- piece set of bi-metal hole saws Ø 22,0 - 25,0 - 32,0 - 35,0 - 41,0 - 44,0 - 51,0 - 54,0 - 60,0 - 68,0 mm + 2 arbor holders A2 and A4	106 304	126 304
Premium	19- piece set of bi-metal hole saws Ø 16,0 - 19,0 - 21,0 - 24,0 - 25,0 - 29,0 - 32,0 - 37,0 - 40,0 - 48,0 - 51,0 - 54,0 - 60,0 - 73,0 - 83,0 mm + 2 arbor holders A1 and A2 + 1 Pilot drill HSS Ø 6,35 mm x 82,0 mm + 1 Extension 300,0 mm, arbors for A1 and A2	106 318	126 318



Arbor holders including pilot drill for bi-metal hole saws HSS and HSSE-Co 8

Packing unit: individual carton




Hole saws Ø mm	Arbor holders Type	Shank Ø mm	Shank shape	Thread			
14,0 - 30,0	A1	11,0	⬡	1/2" x 20	106 201	126 201	1
32,0 - 210,0	A2	11,0	⬡	5/8" x 18	106 202	126 202	1
14,0 - 30,0	A4	6,0	○	1/2" x 20	106 204	126 204	1
14,0 - 30,0	A5	9,5	⬡	1/2" x 20	106 210	126 210	1
32,0 - 210,0	A6	9,5	⬡	5/8" x 18	106 209	126 209	1
32,0 - 210,0	A7	10,0	SDS-Plus	5/8" x 18	106 211	126 211	1

Accessories for bi-metal hole saws HSS and HSSE-Co 8

Packing unit: individual plastic pack



	Arbor holders type			
Adapter to support HSS and HSSE-Co 8 bi-metal hole saws from Ø 32,0 to Ø 210,0 mm	A1 / A4 / A5	106 212	—	1
Pilot drill HSS / HSSE-Co 5, ground, Ø 6,35 x 102,0 mm and split point in accordance with DIN 1412 C	A4	106 207	126 207	1
Pilot drill HSS / HSSE-Co 5, ground, Ø 6,35 x 82,0 mm and split point in accordance with DIN 1412 C	A1 / A2 / A5 / A6 / A7	106 206	126 206	1
Extension 300,0 mm, shank shape ⬡ 11,0 mm	A1 / A2	106 205	—	1
Ejector spring	—	106 208	—	1

Recommended cutting speeds for bi-metal hole saws HSS and HSSE-Co 8

Material:		High carbon struc. steel up to 700 N/mm ²	Alloyed steel up to 1000 N/mm ²	Cast iron over 250 N/mm ²	CuZn alloy	Aluminium alloy up to 11% Si	Thermo- plastics	Duro- plastics	Wood
Vc = m/min		30	20	10	35	30	20	15	40
Coolant:		Cutting spray	Cutting spray	Compressed air	Compressed air	Cutting spray	Water	Compressed air	Compressed air
Ø mm	Ø inch	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.
14,0	9/16	682	455	227	796	682	455	341	910
16,0	5/8	597	398	199	697	597	398	299	796
17,0		562	375	187	656	562	375	281	749
19,0	3/4	503	335	168	587	503	335	251	670
21,0		455	303	152	531	455	303	227	607
22,0	7/8	434	290	145	507	434	290	217	579
24,0	15/16	398	265	133	464	398	265	199	531
25,0	1	382	255	127	446	382	255	191	510
27,0	1 1/16	354	236	118	413	354	236	177	472
28,0	1 3/32	341	227	114	398	341	227	171	455
29,0	1 1/8	329	220	110	384	329	220	165	439
30,0	1 3/16	318	212	106	372	318	212	159	425
32,0	1 1/4	299	199	100	348	299	199	149	398
33,0		290	193	97	338	290	193	145	386
35,0	1 3/8	273	182	91	318	273	182	136	364
36,0		265	177	88	310	265	177	133	354
37,0		258	172	86	301	258	172	129	344
38,0	1 1/2	251	168	84	293	251	168	126	335
40,0		239	159	80	279	239	159	119	318
41,0	1 5/8	233	155	78	272	233	155	117	311
43,0	1 11/16	222	148	74	259	222	148	111	296
44,0	1 3/4	217	145	72	253	217	145	109	290
46,0	1 3/4	208	138	69	242	208	138	104	277
48,0	1 7/8	199	133	66	232	199	133	100	265
50,0	1 31/32	190	128	64	225	194	129	97	257
51,0	2	187	125	62	219	187	125	94	250
52,0		184	122	61	214	184	122	92	245
54,0	2 1/8	177	118	59	206	177	118	88	236
57,0	2 1/4	168	112	56	196	168	112	84	223
59,0		162	108	54	189	162	108	81	216
60,0	2 3/8	159	106	53	186	159	106	80	212
63,0		152	101	51	177	152	101	76	202
64,0	2 1/2	149	100	50	174	149	100	75	199
65,0		147	98	49	171	147	98	73	196
67,0	2 5/8	143	95	48	166	143	95	71	190
68,0		141	94	47	164	141	94	70	187
70,0	2 3/4	136	91	45	159	136	91	68	182
73,0	2 7/8	131	87	44	153	131	87	65	175
76,0	3	126	84	42	147	126	84	63	168
79,0	3 1/8	121	81	40	141	121	81	60	161
83,0	3 1/4	115	77	38	134	115	77	58	153
86,0	3 3/8	111	74	37	130	111	74	56	148
89,0	3 1/2	107	72	36	125	107	72	54	143
92,0	3 5/8	104	69	35	121	104	69	52	138
95,0	3 3/4	101	67	34	117	101	67	50	134
98,0	3 7/8	97	65	32	114	97	65	49	130
102,0	4	94	62	31	109	94	62	47	125
105,0		91	61	30	106	91	61	45	121
108,0	4 1/4	88	59	29	103	88	59	44	118
111,0	4 3/8	86	57	29	100	86	57	43	115
114,0	4 1/2	84	56	28	98	84	56	42	112
121,0	4 3/4	79	53	26	92	79	53	39	105
127,0	5	75	50	25	88	75	50	38	100
140,0	5 1/2	68	45	23	80	68	45	34	91
152,0	6	63	42	21	73	63	42	31	84
160,0	6 5/16	60	40	20	70	60	40	30	80
168,0	6 5/8	57	38	19	66	57	38	28	76
177,0		54	36	18	63	54	36	27	72
210,0	8 9/32	45	30	15	53	45	30	23	61

Recommended cutting speeds for tungsten carbide hole saws

Material:		High carbon struc. steel up to 700 N/mm ²	Alloyed steel up to 1000 N/mm ²	Cast iron over 250 N/mm ²	CuZn alloy	Aluminium alloy up to 11% Si	Thermo- plastics	Duro- plastics	Wood
Vc = m/min		30	20	10	60	35	30	20	15
Coolant:		Cutting spray	Cutting spray	Compressed air	Compressed air	Cutting spray	Water	Compressed air	Compressed air
Ø mm	Ø inch	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.	r.p.m.
16,0	5/8	995	697	796	1194	1194	896	796	995
16,5		965	676	772	1158	1158	869	772	965
17,0		937	656	749	1124	1124	843	749	937
18,0		885	619	708	1062	1062	796	708	885
18,6		856	599	685	1027	1027	770	685	856
19,0	3/4	838	587	670	1006	1006	754	670	838
20,0		796	557	637	955	955	717	637	796
20,4	13/16	781	546	624	937	937	703	624	781
21,0		758	531	607	910	910	682	607	758
22,0		724	507	579	869	869	651	579	724
22,5	7/8	708	495	566	849	849	637	566	708
23,0		692	485	554	831	831	623	554	692
24,0	15/16	663	464	531	796	796	597	531	663
25,0		637	446	510	764	764	573	510	637
25,5	1	624	437	500	749	749	562	500	624
26,0		612	429	490	735	735	551	490	612
27,0	1 1/16	590	413	472	708	708	531	472	590
28,0	1 3/32	569	398	455	682	682	512	455	569
28,3	1 1/8	563	394	450	675	675	506	450	563
29,0		549	384	439	659	659	494	439	549
30,0	1 3/16	531	372	425	637	637	478	425	531
31,0	1 7/32	514	360	411	616	616	462	411	514
32,0	1 1/4	498	348	398	597	597	448	398	498
32,5		490	343	392	588	588	441	392	490
33,0		483	338	386	579	579	434	386	483
34,0		468	328	375	562	562	422	375	468
35,0	1 3/8	455	318	364	546	546	409	364	455
36,0		442	310	354	531	531	398	354	442
37,0	1 7/16	430	301	344	516	516	387	344	430
38,0	1 1/2	419	293	335	503	503	377	335	419
39,0		408	286	327	490	490	367	327	408
40,0	1 9/16	398	279	318	478	478	358	318	398
40,5		393	275	315	472	472	354	315	393
41,0	1 5/8	388	272	311	466	466	350	311	388
42,0		379	265	303	455	455	341	303	379
43,0	1 11/16	370	259	296	444	444	333	296	370
44,0	1 3/4	362	253	290	434	434	326	290	362
45,0		354	248	283	425	425	318	283	354
46,0		346	242	277	415	415	312	277	346
47,0	1 7/8	339	237	271	407	407	305	271	339
48,0		332	232	265	398	398	299	265	332
49,0		325	227	260	390	390	292	260	325
50,0	1 31/32	318	223	255	382	382	287	255	318
50,5		315	221	252	378	378	284	252	315
51,0	2	312	219	250	375	375	281	250	312
52,0		306	214	245	367	367	276	245	306
53,0		300	210	240	361	361	270	240	300
54,0	2 1/8	295	206	236	354	354	265	236	295
55,0		290	203	232	347	347	261	232	290
56,0		284	199	227	341	341	256	227	284
57,0	2 1/4	279	196	223	335	335	251	223	279
58,0		275	192	220	329	329	247	220	275
59,0		270	189	216	324	324	243	216	270
60,0	2 3/8	265	186	212	318	318	239	212	265
63,5	2 1/2	251	176	201	301	301	226	201	251
65,0		245	171	196	294	294	220	196	245
70,0	2 3/4	227	159	182	273	273	205	182	227
75,0		212	149	170	255	255	191	170	212
80,0		199	139	159	239	239	179	159	199
85,0		187	131	150	225	225	169	150	187
90,0		177	124	142	212	212	159	142	177
95,0	3 3/4	168	117	134	201	201	151	134	168
100,0		159	111	127	191	191	143	127	159
110,0		145	101	116	174	174	130	116	145
120,0		133	93	106	159	159	119	106	133
130,0	5 1/8	122	86	98	147	147	110	98	122
140,0	5 1/2	114	80	91	136	136	102	91	114
150,0		106	74	85	127	127	96	85	106





















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Range and applications overview:





















Material	Surface	Miscellaneous	Description	Length mm	Height mm	Thickness mm	Tooth spacing teeth per mm	Tooth spacing teeth per inch	Article no.	Page
HSS			RUKO 8011	77,0	7,5	1,0	2,0	13 Tpi	321 8011 323 8011	248
HSS			RUKO 8009	75,0	6,0	1,0	1,2	21 Tpi	321 8009 323 8009	248
HSS			RUKO 8010	77,0	7,7	1,0	1,2	21 Tpi	321 8010 323 8010	248
HSS			RUKO 8012	77,0	7,6	1,0	0,7	36 Tpi	321 8012 323 8012	249
HSS			RUKO 8013	100,0	7,7	1,0	3,0	8 Tpi	321 8013 323 8013	249
HSS			RUKO 8017	132,0	7,7	1,25	2,0	13 Tpi	321 8017 323 8017	249
HSS			RUKO 8016	130,0	7,9	1,0	1,2	21 Tpi	321 8016 323 8016	250
HSS			RUKO 8028	77,0	7,7	1,0	2,0	13 Tpi	321 8028 323 8028	250
HSS			RUKO 8033	77,0	7,5	1,0	1,2	21 Tpi	321 8033 323 8033	250
HSS			RUKO 8020	132,0	7,7	1,0	1,8	14 Tpi	321 8020 323 8020	251
HSS			RUKO 8019	132,0	7,7	1,0	1,1	23 Tpi	321 8019 323 8019	251
HSS			RUKO 8021	100,0	7,5	1,25	4,0	6 Tpi	321 8021 323 8021	251
HCS			RUKO 8005	77,0	7,8	1,0	2,0	13 Tpi	321 8005 323 8005	252
HCS			RUKO 8007	100,0	7,9	1,3	4,0	6 Tpi	321 8007 323 8007	252
HCS			RUKO 8002	100,0	7,5	1,5	4,0	6 Tpi	321 8002 323 8002	252
HCS			RUKO 8006	100,0	7,9	1,3	4,0	6 Tpi	321 8006 323 8006	253
HCS			RUKO 8072	100,0	6,2	1,25	4,0	6 Tpi	321 8072 323 8072	253
HCS			RUKO 8070	100,0	7,9	1,2	3,0	8 Tpi	321 8070 323 8070	253
HCS			RUKO 8001	100,0	7,9	1,3	2,5	10 Tpi	321 8001 323 8001	254
HCS			RUKO 8018	100,0	7,3	1,2	2,7	9 Tpi	321 8018 323 8018	254
HCS			RUKO 8023	117,0	7,5	1,2	4,0	6 Tpi	321 8023 323 8023	254
HCS			RUKO 8024	130,0	7,9	1,3	4,0	6 Tpi	321 8024 323 8024	255
HSS			RUKO 8814	96,0	12,0	0,65	1,8	14 Tpi	321 8814	256
HSS			RUKO 8824	96,0	12,7	0,6	1,0	25 Tpi	321 8824	256
HSS			RUKO 8832	96,0	11,8	0,65	0,8	32 Tpi	321 8832	256
HSS			RUKO 8811	91,5	12,7	0,6	1,0	25 Tpi	321 8811	257
HSS			RUKO 8812	91,5	12,7	0,6	0,8	32 Tpi	321 8812	257

Steel Iron	Aluminium	Non-ferrous metals	Sheet steel	Stainless steel	Laminated / coated boards	Plastics	Profiled section	Sandwich materials	Profiled cuts	Wood with nails embedded	Hardwoods and softwoods	Chipboard	Blockboard	Plywood	Straight cuts	Clean cuts	Right-angled cuts
																	
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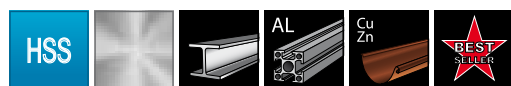
Range and applications overview:



Material	Surface	Miscellaneous	Description	Length mm	Height mm	Thickness mm	Tooth spacing teeth per mm	Tooth spacing teeth per inch	Article no.	Page
TC			RUKO 8939	115,0	19,0	1,0	1,4	18 Tpi	331 89395	258
HSS		Bi Metall	RUKO 8915	152,0	18,0	0,9	2,0	14 Tpi	331 89155	258
HSS		Bi Metall	RUKO 8940	152,0	18,0	0,9	1,45-3,4	8-18 Tpi	331 89405	258
HSS		Bi Metall	RUKO 8908	150,0	18,0	0,9	1,4	18 Tpi	331 89085	259
HSS		Bi Metall	RUKO 8906	152,0	18,4	0,9	1,0	24 Tpi	331 89065	259
HSS		Bi Metall	RUKO 8918	203,0	17,8	1,25	1,8-2,6	10-14 Tpi	331 89185	259
HSS		Bi Metall	RUKO 8916	228,0	18,4	0,9	2,0	14 Tpi	331 89165	260
HSS		Bi Metall	RUKO 8913	228,0	18,4	0,9	1,4	18 Tpi	331 89135	260
HSS		Bi Metall	RUKO 8985	152,0	21,0	1,6	4,2	6 Tpi	331 89855	260
HSS		Bi Metall	RUKO 8986	152,0	21,0	1,6	2,54-3,18	8-10 Tpi	331 89865	261
HSS		Bi Metall	RUKO 8988	228,0	21,0	1,6	4,25	6 Tpi	331 89885	261
HSS		Bi Metall	RUKO 8989	228,0	21,0	1,6	2,54-3,18	8-10 Tpi	331 89895	261
HSS		Bi Metall	RUKO 8917	152,0	18,0	1,25	4,2	6 Tpi	331 89175	262
HSS		Bi Metall	RUKO 8901	152,0	18,0	0,9	2,5	10 Tpi	331 89015	262
HSS		Bi Metall	RUKO 8943	203,0	18,0	1,25	2,1-4,3	6-12 Tpi	331 89435	262
HSS		Bi Metall	RUKO 8909	203,0	18,0	0,9	2,5	10 Tpi	331 89095	263
HSS		Bi Metall	RUKO 8936	228,0	18,0	1,25	4,25	6 Tpi	331 89365	263
HSS		Bi Metall	RUKO 8945	228,0	18,0	0,9	2,54	10 Tpi	331 89455	263
HSS		Bi Metall	RUKO 8933	228,0	18,0	1,25	1,8-2,6	10-14 Tpi	331 89335	264
HSS		Bi Metall	RUKO 8928	228,0	18,0	0,9	1,8-2,6	10-14 Tpi	33189285	264
HSS		Bi Metall	RUKO 8937	305,0	18,0	1,25	4,2	6 Tpi	33189375	264
HSS		Bi Metall	RUKO 8910	305,0	18,0	0,9	1,8-2,4	10-14 Tpi	331 89105	265
HSS		Bi Metall	RUKO 8929	305,0	18,0	1,25	1,8-2,4	10-14 Tpi	331 89295	265
HCS			RUKO 8905	152,0	18,35	1,25	1,8-2,4	10-14 Tpi	331 89055	265
HCS			RUKO 8903	152,0	18,35	1,0	4,2	6 Tpi	331 89035	266
HCS			RUKO 8924	152,0	18,1	1,25	4,0	6 Tpi	331 89245	266
HCS			RUKO 8944	203,0	18,1	1,25	2,4-4,0	6-10 Tpi	331 89445	266
HCS			RUKO 8923	225,0	18,0	1,25	8,5	3 Tpi	331 89235	267
HCS			RUKO 8922	240,0	18,0	1,6	4,0-6,5	5 Tpi	331 89225	267
HCS			RUKO 8904	300,0	18,0	1,25	4,2	6 Tpi	331 89045	267

Steel Iron	Aluminium	Non-ferrous metals	Sheet steel	Stainless steel	Pipe	Plastics	Profiled section	Porous concrete	Pruning	Wood with nails embedded	Hardwoods and softwoods	Chipboard	Blockboard	Plywood	Profiled cuts	Clean cuts	Right-angled cuts
																	
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T-shank jig-saw blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.









Blades to replace *
Bosch® T 118 B | Metabo® 23 638
MPS® 3113 | Wilpu® MG 12 | AEG® 254-064

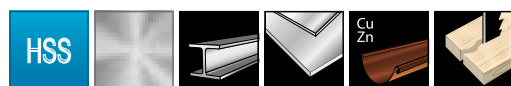
RUKO 8011 HSS steel

Standard saw blade, wavy set.

Application range: St 37 up to 4,0 mm thickness, non-ferrous metals, aluminium 3,0 - 10,0 mm cooled with RUKO cutting spray. Hard plastics, acrylic glass 3,0 - 8,0 mm, Pertinax, Resitex. Asbestos cement 2,0 - 4,0 mm. Eternit up to 10,0 mm, cooled with water.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
77,0	7,5	1,0	2,0	13 Tpi	321 8011	5

	
323 8011	20

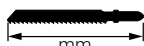








Blades to replace *
Bosch® T 218 A | Metabo® 23 647
MPS® 3112 | Wilpu® MG 21 | AEG® 254-063

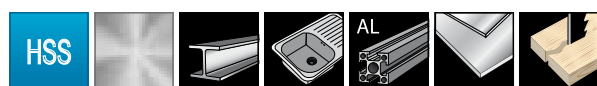
RUKO 8009 HSS steel

Standard saw blade, wavy set. Narrow blade suitable for profiled cuts.

Application range: St 37, non-ferrous metals. Suitable for profiled cuts. Suitable for glass-fibre reinforced plastics up to 4,0 mm thickness, acrylic glass up to 8,0 mm, cooled with water. Pressed materials, hard fabrics, insulation materials up 8,0 mm thickness, cooled with water.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
75,0	6,0	1,0	1,2	21 Tpi	321 8009	5

	
323 8009	20

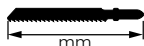








Blades to replace *
Bosch® T 118 A | Metabo® 23 637
MPS® 3111 | Wilpu® MG 11 | AEG® 254-063

RUKO 8010 HSS steel

Standard saw blade, wavy set. Narrow blade suitable for profiled cuts.

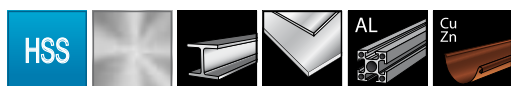
Application range: St 37, non-ferrous metals, aluminium up to 4,0 mm thick, high-alloyed chromium steel such as stainless and acid-resistant steel sheet up to 2,0 mm. Hard and softwood, insulation material up to 8,0 mm. Suitable for glassfibre reinforced plastics up to 2,0 mm, acrylic glass, pressed materials, hard fabrics, cooled with water.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
77,0	7,7	1,0	1,2	21 Tpi	321 8010	5

	
323 8010	20



T-shank jig-saw blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® T 118 G | Metabo® 23 636
MP.S® 3110 | Wilpu® MG 107 | AEG® 274-652




RUKO 8012 HSS steel




Standard saw blade, wavy set. For thin sheet steel.

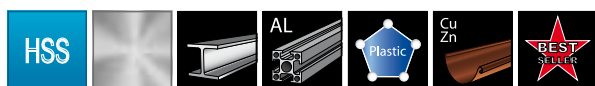
Application range:

Thin-gauged sheet and profiled section less than 1,0 mm. St 37, non-ferrous metals, aluminium up to 2,0 mm. Armoured plastics, acrylic glass, cooled with water.

Thin-gauged hard fabrics, insulation materials, cooled with water.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
77,0	7,6	1,0	0,7	36 Tpi	321 8012	5						

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
323 8012	20											



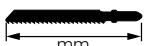


Blades to replace *
Bosch® T 127 D | Metabo® 23 639
MP.S® 3118 | Wilpu® K 14 | AEG® 274-315




RUKO 8013 HSS steel

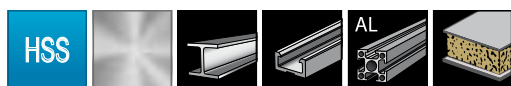
Standard saw blade, side set.

Application range:

Mild steel 3,0 - 6,0 mm, non-ferrous metals, aluminium and aluminium alloys 3,0 - 15,0 mm, cooled with RUKO cutting spray. Plastics, armoured plastics. Asbestos cement, eternit and hard materials.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
100,0	7,7	1,0	3,0	8 Tpi	321 8013	5						

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
323 8013	20											



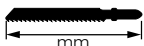


Blades to replace *
Bosch® T 318 B | Metabo® 23 697
MP.S® 3115 | Wilpu® MG 32 bi | AEG® 274-653

RUKO 8017 HSS steel

Standard saw blade, extra long, wavy set.

Application range:

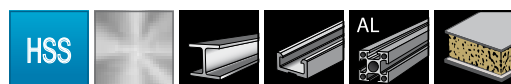
Profiled section, mild steel, aluminium 2,0 - 10,0 mm, composite materials, sandwich materials up to 70,0 mm. Insulation materials.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
132,0	7,7	1,25	2,0	13 Tpi	321 8017	5						

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
323 8017	20											



T-shank jig-saw blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® T 318 A | Metabo® 23 629
MP.S® 3114 | Wilpu® MG 31 bi | AEG® 274-654



RUKO 8016 HSS steel




Standard saw blade, extra long, wavy set.

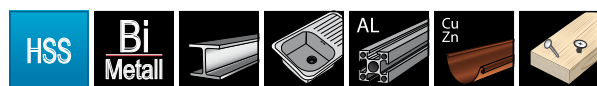
Application range:

Profiled section, mild steel, aluminium 1,5 - 4,0 mm, composite materials, sandwich materials up to 70,0 mm.
Insulation materials.



	mm		mm	mm	mm	mm	mm
130,0	7,9	1,0	1,2	21Tpi	321 8016	5	

		
323 8016	20	



Blades to replace *
Bosch® T 118 BF | Metabo® 23 973
MP.S® 3113 F | Wilpu® MG 12 bi | AEG® 340-012

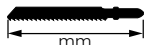

RUKO 8028 HSS bi-metal

Saw blade wavy set.

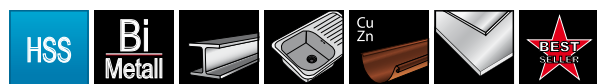
Application range:

Mild steel, non-ferrous metals 3,0 - 10,0 mm thickness as well as sheet high-alloyed chromium steel
such as stainless and acid-resistant steel, wood with nails, acrylic glass.



	mm		mm	mm	mm	mm	mm
77,0	7,7	1,0	2,0	13 Tpi	321 8028	5	

		
323 8028	20	



Blades to replace *
Bosch® T 118 AF | Metabo® 23 971
MP.S® 3111 F | Wilpu® MG 11 bi | AEG® 340-011

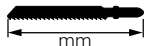

RUKO 8033 HSS bi-metal




Saw blade wavy set.

Application range:

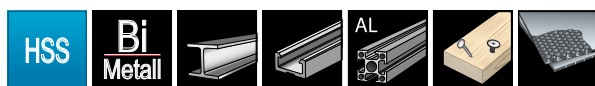
Mild steel, non-ferrous metals, aluminium and aluminium alloys 1,5 - 4,0 mm thickness,
sheet high-alloyed chromium steel such as stainless and acid-resistant steel.



	mm		mm	mm	mm	mm	mm
77,0	7,5	1,0	1,2	21 Tpi	321 8033	5	

		
323 8033	20	

T-shank jig-saw blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® T 318 BF | Metabo® 23 979
MP.S® 3115 F | Wilpu® MG 32 bi | AEG 274-653

RUKO 8020 HSS bi-metal




Standard saw blade, side set.

Application range:

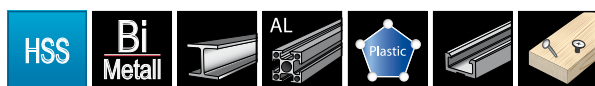
Profiled section, pipe up to Ø 60,0 mm with wall thickness 3,0 - 10,0 mm, non-ferrous metals, high-alloyed chromium steel such as stainless and acid-resistant steel.

Wood with nails, acrylic glass, armoured plastics.



	mm		mm	Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
132,0	7,7	1,0	1,8	14 Tpi	321 8020	5		

HSS	Bi Metall	
323 8020	20	



Blades to replace *
Bosch® T 318 AF | Metabo® 23 978
MP.S® 3114 F | Wilpu® MG 31 bi | AEG 274-654

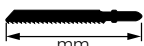


RUKO 8019 HSS bi-metal

Saw blade wavy set.

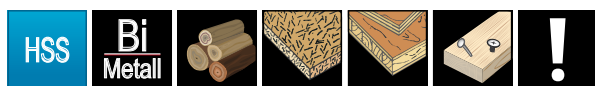
Application range:

Profiled section, pipe up to Ø 60,0 mm with wall thickness 1,4 - 4,0 mm, high-alloyed chromium steel such as stainless and acid-resistant steel.



	mm		mm	Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
132,0	7,7	1,0	1,1	23 Tpi	321 8019	5		

HSS	Bi Metall	
323 8019	20	



Blades to replace *
Bosch® T 144 DF | Metabo® 23 978
MP.S® 3104 F | Wilpu® HGS 14 bi | AEG 373 391

RUKO 8021 HSS bi-metal

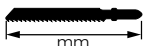


Blade sharpened, teeth side set.

Application range:

Hardwood and softwood up to 60,0 mm, rough cut, high cutting performance (can take heavy cuts).

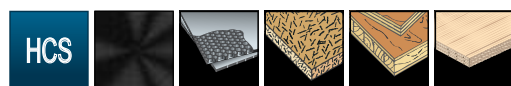
Suitable for wood with nails.



	mm		mm	Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
100,0	7,5	1,25	4,0	6 Tpi	321 8021	5		

HSS	Bi Metall	
323 8021	20	

T-shank jig-saw blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



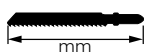


Blades to replace *
Bosch® T 119 B | Metabo® 23 631
MP.S® 3108 | Wilpu® HW 12 | AEG® 274-353


RUKO 8005 HCS

Standard saw blade, wavy set.

Application range:

Plywood and wood-fibre board up to 30,0 mm thickness. Insulating materials, acrylic glass up to 6,0 mm, cooled with water. Pressed material, hard fabric up to 4,0 mm thickness, cardboard, linoleum up to 6,0 mm thickness, cooled with water.

			mm	mm	mm	mm	mm	mm	mm	mm	mm
77,0	7,8	1,0	2,0	13 Tpi	321 8005	5					

			mm	mm	mm	mm	mm	mm	mm	mm	mm
323 8005	20										



Blades to replace *
Bosch® T 101 D | Metabo® 23 635
MP.S® 3105 | Wilpu® HGS 24 | AEG® 274-351

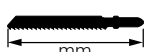


RUKO 8007 HCS

Tapered blade, ground teeth.

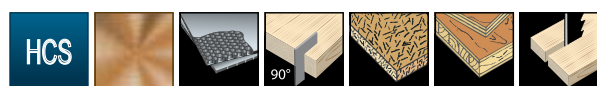
Fast and rough cut. Narrow blade suitable for profiled cuts.

Application range:

Hardwood, softwood, plywood and wood-fibre boards up to 50,0 mm thickness, clean cut, suitable for slots and grooves. Various soft plastics up to 30,0 mm, clean cuts.

			mm	mm	mm	mm	mm	mm	mm	mm	mm
100,0	7,9	1,3	4,0	6 Tpi	321 8007	5					

			mm	mm	mm	mm	mm	mm	mm	mm	mm
323 8007	20										



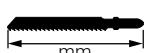


Blades to replace *
Bosch® T 101 DP | Metabo® 23 971
MP.S® 3111 F | Wilpu® MG 11 bi | AEG® 340-011




RUKO 8002 HCS

Tapered blade, ground teeth. Clean and fast cut.

Application range:

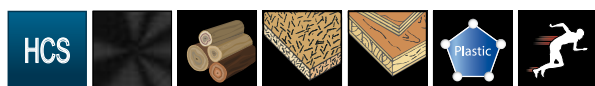
Hardwood, softwood, plywood and wood-fibre board up to 60,0 mm. Parallel cuts and clean cuts. Various soft plastics up to 25,0 mm thickness, clean cuts.

			mm	mm	mm	mm	mm	mm	mm	mm	mm
100,0	7,5	1,5	4,0	6 Tpi	321 8002	5					

			mm	mm	mm	mm	mm	mm	mm	mm	mm
323 8002	20										



T-shank jig-saw blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.









Blades to replace *
Bosch® T 144 D | Metabo® 23 633
MP.S® 3104 | Wilpu® HGS 14 | AEG® 213-116

RUKO 8006 HCS

Blade sharpened and side set. Fast and rough cut.

Application range:

Hardwood and softwood up to 60,0 mm thickness. Fast and rough cut. Polystyrene, polyamide, soft plastics up to 50,0 mm thickness and plexiglas up to 30,0 mm thickness, cooled with water. Hard fabric, insulation material and cardboard.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch			
100,0	7,9	1,3	4,0	6 Tpi	321 8006	5	

		
323 8006	20	



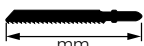





Blades to replace *
Bosch® T 244 D | Metabo® 23 649
MP.S® 3105 | Wilpu® HGS 24 | AEG® 346-078




RUKO 8072 HCS

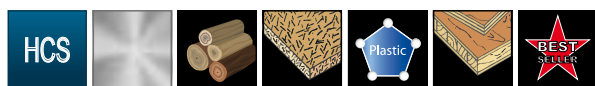
Blade side set and sharpened. Suitable for profiled cuts.

Application range:

Hardwoods and softwoods up to 60,0 mm thickness, rough cut, especially suitable for profiled cuts. Polystyrene, polyamide, soft plastics up to 50,0 mm.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch			
100,0	6,2	1,25	4,0	6 Tpi	321 8072	5	

		
323 8072	20	



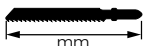





Blades to replace *
Bosch® T 111 C | Metabo® 23 632
MP.S® - | Wilpu® HG 13 | AEG® 254-071




RUKO 8070 HCS

Saw blade side set. Rough cut with high cutting performance.

Application range:

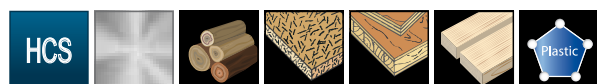
Hardwoods and softwoods up to 60,0 mm thickness, rough cut, high cutting performance (can take heavy cuts). Polystyrene, polyamide, soft plastics up to 30,0 mm thickness.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch			
100,0	7,9	1,2	3,0	8 Tpi	321 8070	5	

		
323 8070	20	



T-shank jig-saw blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® T 101 B | Metabo® 23 634
MP.S® 3101 | Wilpu® HC 12 | AEG® 254-061

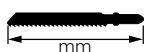




RUKO 8001 HCS

Tapered blade, ground teeth. Clean and fast cut.

Application range:

Hardwood, softwood, plywood and wood-fibre board up to 50,0 mm thickness.

Suitable for slots and grooves. Various soft plastics up to 20,0 mm thickness.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
100,0	7,9	1,3	2,5	10 Tpi	321 8001	5

	
323 8001	20



Blades to replace *
Bosch® T 101 BR | Metabo® 23 650
MP.S® 3102 | Wilpu® HC 12 R | AEG® 346-079

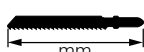




RUKO 8018 HCS


Tapered blade, ground teeth. Clean cut. Reversed cutting direction.

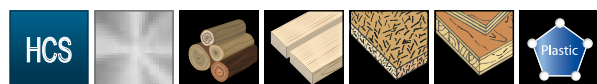
Application range:

Hardwoods and softwoods, plywood, wood-fibre boards up to 60,0 mm.

Formica and laminated / coated boards. Soft plastics.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
100,0	7,3	1,2	2,7	9 Tpi	321 8018	5

	
323 8018	20



Blades to replace *
Bosch® T 301 D | Metabo® 23 654
MP.S® 3101 L

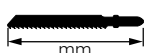




RUKO 8023 HCS

Tapered blade, ground teeth.

Application range:

Hardwood and softwood, plywood and wood-fibre boards up to 70,0 mm, clean cut, suitable for slots and grooves.

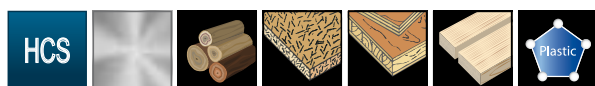
Various soft plastics up to 40,0 mm, clean cut.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
117,0	7,5	1,2	4,0	6 Tpi	321 8023	5

	
323 8023	20



T-shank jig-saw blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® T 301 DL | MP.S® 3104 L
Wilpu® HGS 34

RUKO 8024 HCS

Tapered blade, ground teeth. Very clean and fast cut.

Application range:

Hardwood and softwood, plywood and wood-fibre boards up to 70,0 mm, clean and fast cut, suitable for slots and grooves. Various soft plastics up to 40,0 mm, clean cut.



			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
130,0	7,9	1,3	4,0	6 Tpi	321 8024	5

323 8024	20	

Reference table for RUKO jig-saw blades

Competitive blades may vary from our specifications.

	Bosch®	D+N®	Gematic®	Hawera®	Lenox®	Metabo®	MP.S®	Wilpu®	Atlas Copco® AEG®	Holz-Her®	Festo®
321 8001	T 101 B	3 22 25	10 2255	240 515	F 450 S	23 634	3101	HC 12	254-061	Ho 75 F	S 75/2,5
321 8002	T 101 DP	3 29 40	10 2258	240 516	F 456 S	23 655	3103	HC 14 D	274-351	—	S 75/4
321 8005	T 119 B	3 20 20	10 2249	144 212	F 410 S	23 631	3108	HW 12	274-353	SP 50 G	—
321 8006	T 144 D	3 23 40	10 2270	240 520	F 406 S	23 633	3104	HGS 14	213-116	HW 75 G	S75/4
321 8007	T 101 D	3 22 40	—	240 521	F 416 SC	23 635	3105	HGS 24	274-351	HO 75 G	—
321 8009	T 218 A	3 13 12	10 2104	240 523	F 324 S	23 647	3112	MG 21	254-063	ME 50 M	—
321 8010	T 118 A	3 10 12	—	—	F 318 SC	23 637	3111	MG 11	254-063	AK 50 M	HS 50/1.2
321 8011	T 118 B	3 10 20	10 2107	240 525	F 340 SV	23 638	3113	MG 12	254-064	ME 50 G	HS 50/2
321 8012	T 118 G	3 10 07	10 2101	240 526	—	23 636	3110	MG 107	274-652	ME 50 F	—
321 8013	T 127 D	3 10 30	10 2110	240 528	F 410 S	23 639	3118	K 14	274-315	AL 75 G	HS 75/3
321 8016	T 318 A	3 11 12	10 2113	240 527	F 518 S	23 629	3114	MG 31 bi	274-654	AK 100 M	—
321 8017	T 318 B	3 11 20	10 2116	240 534	F 410 S	23 697	3115	MG 32 bi	274-653	ME 100 G	—
321 8018	T 101 BR	3 26 25	10 2264	240 545	F 450 SR	23 650	3102	HC 12 R	346-079	—	—
321 8019	T 318 AF	3 15 12	—	144 223	F 324 S	23 978	—	MG 31 bi	274-654	HS 105 / 1,2 bi	—
321 8020	T 318 BF	3 15 20	—	144 227	—	23 979	3115 F	MG 32 bi	274-653	HS 105 / 2,0 bi	—
321 8021	T 144 DF	3 33 40	—	144 220	F 456 S	23 976 23 933	3104 F	HGS 14 bi	373 391	—	HS 75/4 bi
321 8023	T 301 D	3 27 40	—	—	F 410 S	23 654	3101 L	—	—	HO 90 G	—
321 8024	T 301 DL	3 40 40	10 2253	144 213	F 686 S	—	3104 L	HGS 34	—	—	—
321 8028	T 118 BF	3 14 20	10 2322	144 225	F 314 S	23 973	3113 F	MG 12 bi	340-012	—	—
321 8033	T 118 AF	3 14 12	10 2319	240 503	F 324 S	23 971	3111 F	MG 11 bi	340-011	—	—
321 8070	T 111 C	3 20 30	—	—	—	23 632	—	HG 13	254-071	HO 75 R	S 75/3
321 8072	T 244 D	3 24 40	—	—	—	23 649	3105	HGS 24	346-078	HW 75 K	S 75/4 K

* Competitive blades may vary from our specifications.

Jig-saw blades for pneumatic body saws by SIG®, FLEX® and Wieländer+Schill®



Blades to replace *
CS 118 BF

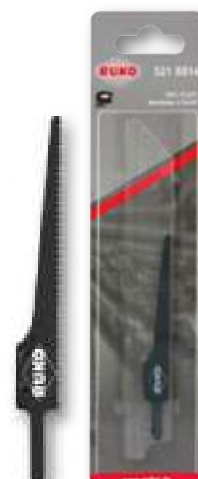
RUKO 8814 HSS bi-metal

For thin steel sheet such as car body panels.

Application range:

St 37, non-ferrous metals up to 2,5 mm thickness. Wood, plastics, hard fabrics.

	mm		mm	Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
96,0	12		0,65	1,8	14 Tpi			5



Blades to replace *
CS 118 AF

RUKO 8824 HSS bi-metal

For thin steel sheet such as car body panels.

Application range: St 37, high-alloyed chromium steel such as stainless and

acid-resistant steel, non-ferrous metals up to 2,0 mm thickness. Suitable for profiled cuts.

	mm		mm	Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
96,0	12,7		0,6	1,0	25 Tpi			5



Blades to replace *
CS 118 6F

RUKO 8832 HSS bi-metal

For thin steel sheet such as car body panels.

Application range: St 37, high-alloyed chromium steel such as stainless and

acid-resistant steel, non-ferrous metals up to 1,0 mm thickness. Suitable for profiled cuts.

	mm		mm	Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
96,0	11,8		0,65	0,8	32 Tpi			5



Jig-saw blades for pneumatic body saws by Ober®, Chicago Pneumatic®, Shinano®, Facom® and Pneutec®

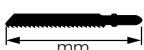






Blades to replace *
CC 118 AF

RUKO 8811 HSS bi-metal

For thin steel sheet such as car body panels.

Application range: St 37, high-alloyed chromium steel such as stainless and acid-resistant steel, non-ferrous metals up to 2,0 mm thickness. Suitable for profiled cuts.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
91,5	12,7	0,6	1,0	25 Tpi	321 8811	5

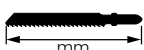






Blades to replace *
CC 118 GF

RUKO 8812 HSS bi-metal

For thin steel sheet such as car body panels.

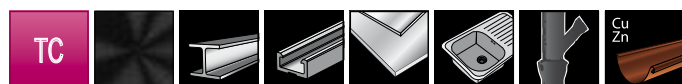
Application range: St 37, high-alloyed chromium steel such as stainless and acid-resistant steel, non-ferrous metals up to 1,0 mm thickness. Suitable for profiled cuts.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
91,5	12,7	0,6	0,8	32 Tpi	321 8812	5



* Competitive blades may vary from pour specifications.

Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® S 518 EHM

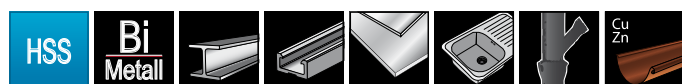
RUKO 8939 TC

Toothing ground.

Application range:

Inox sheeting from 2,0 - 4,0 mm material thickness, Inox profiles from Ø 2,0 - 50,0 mm, FRP / epoxy from 2,0 - 15,0 mm. For material with reduced stroke rate and cooling, work without oscillation.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
115,0	19,0	1,0	1,4	18 Tpi	331 89395	5



Blades to replace *
Bosch® S 922 | Metabo® 31130
MP.S® 4411 | Wilpu® 3013-150 | AEG® 354-789

RUKO 8915 HSS bi-metal

Toothing crossed and milled.

Application range:

Thick sheeting from 3,0 - 8,0 mm material thickness, solid pipes and profiles Ø 10,0 - 100,0 mm, fast cutting.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
152,0	18,0	0,9	2,0	14 Tpi	331 89155	5



Blades to replace *
Bosch® S 123 XF | MP.S® 4446

RUKO 8940 HSS bi-metal

Toothing crossed and milled.

Application range:

Thick sheeting from 3,0 - 8,0 mm material thickness, solid pipes and profiles Ø 10,0 - 100,0 mm, fast cutting.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
152,0	18,0	0,9	1,45 - 3,4	8 - 18 Tpi	331 89405	5



Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® S 922 EF | Metabo® 31132
MP.S® 4401 | Wilpu® 3014-150 | AEG® 354-792

RUKO 8908 HSS bi-metal

Toothings crossed and milled.

Application range:

Thin sheeting from 1,5 - 4,0 mm material thickness, pipes and profiles Ø 5,0 - 100,0 mm.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
150,0	18,0	0,9	1,4	18 Tpi	331 89085	5						



Blades to replace *
Bosch® S 922 AF | Metabo® 31129
MP.S® 4405 | Wilpu® 3015-150 | AEG® 354-796

RUKO 8906 HSS bi-metal

Toothings crossed and milled.

Application range:

Thin sheeting from 0,7 - 3,0 mm material thickness, fine pipes and profiles from Ø 5,0 - 10,0 mm. Easy, fine cut.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
152,0	18,4	0,9	1,0	24 Tpi	331 89065	5						



Blades to replace *
Bosch® S 1025 VF

RUKO 8918 HSS bi-metal

Toothings crossed and milled.

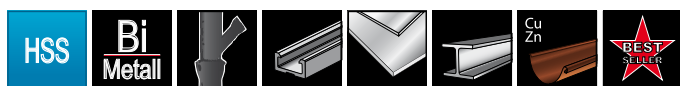
Application range:

Medium to thick sheeting from 2,0 - 12,0 mm material thickness, solid pipes and profiles from Ø 10,0 - 150,0 mm. Easy, fine cut.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
203,0	17,8	1,25	1,8 - 2,6	10 - 14 Tpi	331 89185	5						



Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® S 1122 BF | Metabo® 31135 / 31485
MP.S® 4415 | AEG® 354-790 | Wilpu® 3013-250

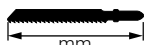


RUKO 8916 HSS bi-metal

Toothings crossed and milled.

Application range:

Thin sheeting from 3,0 - 8,0 mm material thickness, solid pipes and profiles from Ø 10,0 - 175,0 mm.

Flexible, flush and fast cut.

			mm	mm	mm	mm	mm
228,0	18,4	0,9	2,0	14 Tpi	331 89165	5	



Blades to replace *
Bosch® S 1122 EF | Metabo® 31133 / 31483
MP.S® 4402 | AEG® 354-793 | Wilpu® 3014-200

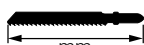


RUKO 8913 HSS bi-metal

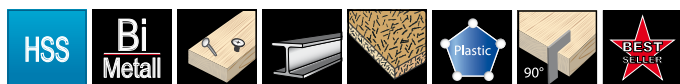
Toothings crossed and milled.

Application range:

Thin sheeting from 1,5 - 4,0 mm material thickness, pipes and profiles Ø 5,0 - 175,0 mm.

Flexible, flush cut.

			mm	mm	mm	mm	mm
228,0	18,4	0,9	1,4	18 Tpi	331 89135	5	



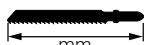


Blades to replace *
Bosch® S 610 DF | Metabo® 31925
AEG® 373-243 | Wilpu® 3055-150

RUKO 8985 HSS bi-metal

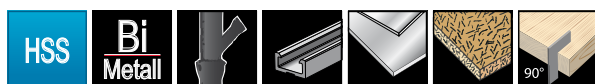
Toothings crossed and milled.

Application range:

Wood with nails, metal, chipboard from 10,0 - 100,0 mm material thickness, plastic profiles from Ø 5,0 - 100,0 mm, solid plastics / FRP from 8,0 - 50,0 mm, wood and metal window frames. Especially suitable for plunge cuts.

			mm	mm	mm	mm	mm
152,0	21,0	1,6	4,2	6 Tpi	331 89855	5	

Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® S 920 CF | AEG® 373-247

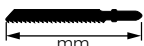


RUKO 8986 HSS bi-metal

Toothings crossed and milled.

Application range:

Plates from 4,0 - 10,0 mm, solid pipes and profiles from Ø 20,0 - 100,0 mm.

Ideal for pipe cutting equipment, rescue and demolition work. Powerful, coarse cut.

			mm	mm	mm	mm	mm
152,0	21,0	1,6	2,54 - 3,18	8 - 10 Tpi	331 89865	5	



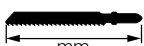


Blades to replace *
Bosch® S 1110 DF | Metabo® 31926
Wilpu® 3055-225 | AEG® 373-244

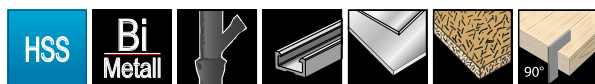
RUKO 8988 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails, metal, chipboard from 10,0 - 175,0 mm material thickness, solid plastics / FRP from 8,0 - 50,0 mm, wood and metal wall pieces to 150,0 mm. For rescue and demolition work.

			mm	mm	mm	mm	mm
228,0	21,0	1,6	4,25	6 Tpi	331 89885	5	



Blades to replace *
Bosch® S 1120 CF | Metabo® 31993
Wilpu® 3055-225 | AEG® 373-244

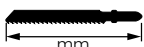


RUKO 8989 HSS bi-metal

Toothings crossed and milled.

Application range:

Plates from 4,0 - 10,0 mm, solid pipes and profiles from Ø 20,0 - 175,0 mm.

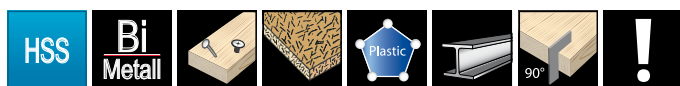
Ideal for pipe cutting equipment, rescue and demolition work. Powerful, coarse cut.

			mm	mm	mm	mm	mm
228,0	21,0	1,6	2,54 - 3,18	8 - 10 Tpi	331 89895	5	



* Competitive blades may vary from pour specifications.

Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® S 611 DF | Metabo® 31985
MP.S® 4016 | AEG® 354-775 | Wilpu® 3021/150bi

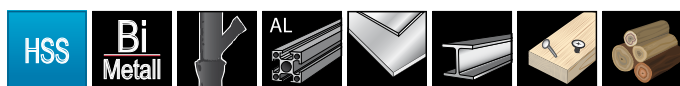
RUKO 8917 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails, metal, chipboard from 10,0 - 100,0 mm material thickness, plastic profiles from Ø 5,0 - 100,0 mm, solid plastics/ FRP from 8,0 - 50,0 mm, wood and metal window frames. Especially suitable for plunge cuts.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
152,0	18,0	1,25	4,2	6 Tpi	331 89175	5	



Blades to replace *
Bosch® S 922 HF | Metabo® 31131
MP.S® 4430 | AEG® 318-127 | Wilpu® 3018/150

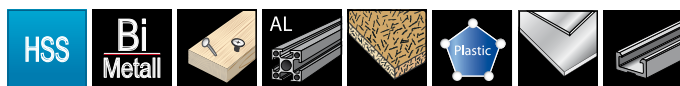
RUKO 8901 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails and metal from 5,0 - 100,0 mm material thickness, metal sheeting, pipes, aluminium profiles from 3,0 - 12,0 mm and pallets.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
152,0	18,0	0,9	2,5	10 Tpi	331 89015	5	



Blades to replace *
Bosch® S 3456 XF | Metabo® 31915
MP.S® 4447

RUKO 8943 HSS bi-metal

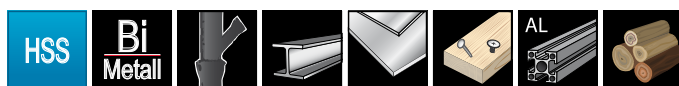
Toothings crossed and milled.

Application range:

Wood with nails and metal, chipboard from 5,0 - 150,0 mm material thickness, metal sheeting, aluminium profiles from 3,0 - 18,0 mm, plastics / FRP and profiles Ø 5,0 - 150,0 mm.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS	Bi Metall	
203,0	18,0	1,25	2,1 - 4,3	6 - 12 Tpi	331 89435	5	

Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



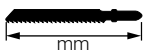


Blades to replace *
Bosch® S 1022 HF | Metabo® 31932
Wilpu® 3018-200 | MP.S® 4431

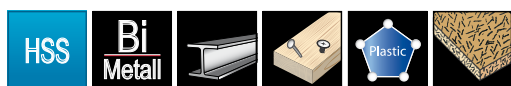
RUKO 8909 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails and metal from 5,0 - 150,0 mm material thickness,
metal sheeting, pipes, aluminium profiles from 3,0 - 12,0 mm and pallets.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
203,0	18,0	0,9	2,5	10 Tpi	331 89095	5						



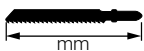


Blades to replace *
Bosch® S 1111 DF | AEG® 318-125

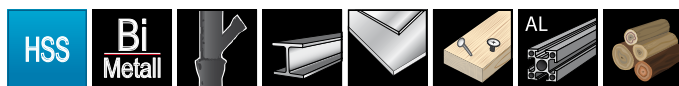
RUKO 8936 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails and metal, chipboard from 10,0 - 175,0 mm material thickness,
plastic profiles from Ø 5,0 - 175,0 mm, solid plastics / FRP from 8,0 - 50,0 mm.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
228,0	18,0	1,25	4,25	6 Tpi	331 89365	5						






Blades to replace *
Bosch® S 1122 HF

RUKO 8945 HSS bi-metal

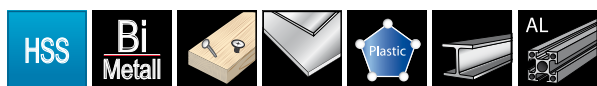
Toothings crossed and milled.

Application range:

Wood with nails and metal from 5,0 - 175,0 mm material thickness, metal sheeting, pipes,
aluminium profiles from 3,0 - 12,0 mm and for pallet repairs. Flexible, flush cut.

			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
228,0	18,0	0,9	2,54	10 Tpi	331 89455	5						

Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



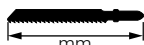








Blades to replace *
Bosch® S 1125 VF | AEG® 323-813

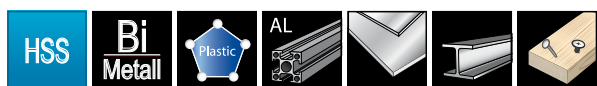
RUKO 8933 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails and metal from 5,0 - 175,0 mm material thickness, metal sheeting, aluminium profiles from 3,0 - 10,0 mm and plastic profiles from Ø 3,0 - 175,0 mm.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch			
228,0	18,0	1,25	1,8 - 2,6	10 - 14 Tpi			
					331 89335		5



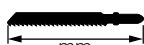








Blades to replace *
Bosch® S 1122 VF | AEG® 323-813

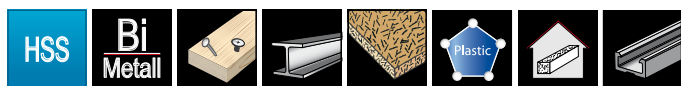
RUKO 8928 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails and metal from 5,0 - 175,0 mm material thickness, metal sheeting, aluminium profiles from 3,0 - 10,0 mm and plastic profiles from Ø 3,0 - 175,0 mm. Flexible, flush cut.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch			
228,0	18,0	0,9	1,8 - 2,6	10 - 14 Tpi			
					331 89285		5



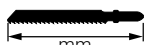








Blades to replace *
Bosch® S 1411 DF | Wilpu® 3021-300 bi

RUKO 8937 HSS bi-metal

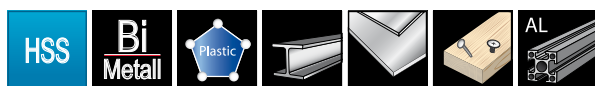
Toothings crossed and milled.

Application range:

Wood with nails, metal and chipboard from 10,0 - 250,0 mm material thickness, gas concrete from 10,0 - 250,0 mm, plastics / FRP and profiles from 5,0 - 60,0 mm.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch			
305,0	18,0	1,25	4,2	6 Tpi			
					331 89375		5

Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® S 1222 VF | Metabo® 31125 / 31475
MP.S® 4432 | AEG® 354-778 | Wilpu® 3021/300 bi

RUKO 8910 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails and metal from 5,0 - 250,0 mm material thickness, metal sheeting, aluminium profiles from 3,0 - 10,0 mm and plastic profiles from Ø 3,0 - 250,0 mm. Flexible, flush cut.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS Bi-Metal	
305,0	18,0	0,9	1,8 - 2,4	10 - 14 Tpi	331 89105	5



Blades to replace *
Bosch® S 1225 VF | Metabo® 31124 / 31474
MP.S® 4422

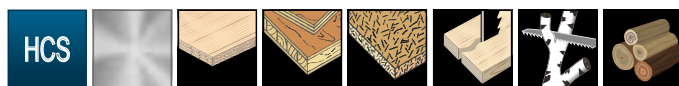
RUKO 8929 HSS bi-metal

Toothings crossed and milled.

Application range:

Wood with nails and metal from 5,0 - 250,0 mm material thickness, metal sheeting, aluminium profiles from 3,0 - 10,0 mm and plastic profiles from Ø 3,0 - 250,0 mm.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch	HSS Bi-Metal	
305,0	18,0	1,25	1,8 - 2,4	10 - 14 Tpi	331 89295	5



Blades to replace *
Bosch® S 617 K | Metabo® 28241
MP.S® 4021 | Wilpu® 3019-150 | AEG® 354 779

RUKO 8905 HCS

Toothings crossed and milled.

Application range:

Coarse and nail-free wood from 20,0 - 100,0 mm, living wood, prune to Ø 100,0 mm. Especially suitable for curved cuts and plunge cuts.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch	HCS	
152,0	18,35	1,25	8,5	3 Tpi	331 89055	5

Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.



Blades to replace *
Bosch® S 828 D I Metabo® 31136
MP.S® 4014/4060 I Wilpu® 3025-150 I AEG® 318-131

RUKO 8903 HCS

Toothing crossed.

Application range:
Specifically for various plaster and Rigips panels from 8,0 - 100,0 mm.
Wood, Eternit and plastics.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
152,0	18,35	1,0	4,2	6 Tpi	331 89035	5



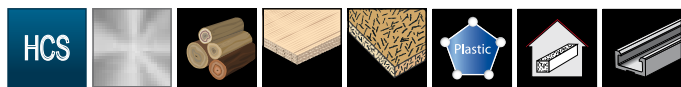
Blades to replace *
Bosch® S 644 D I Metabo® 31120 / 31470
MP.S® 4011/4012 I AEG® 323-800 I Wilpu® 3021-150

RUKO 8924 HCS

Toothing crossed and ground.

Application range:
Structural wood, plywood and plastics from 6,0 - 100,0 mm, wooden wall to 75,0 mm, chipboard and MDF from 6,0 - 60,0 mm. Especially suitable for plunge cuts.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
152,0	18,1	1,25	4,0	6 Tpi	331 89245	5



Blades to replace *
Bosch® S 2345 X I Metabo® 31910/31913
MP.S® 4046 I Wilpu® 3023/150-240

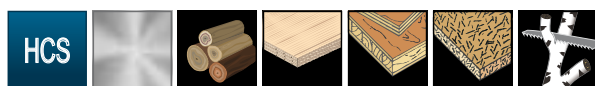
RUKO 8944 HCS

Toothing crossed and ground.

Application range:
Structural wood, plywood and plastics from 6,0 - 150,0 mm, wooden walls up to 175,0 mm,
Chipboard and MDF from 6,0 - 60,0 mm.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
203,0	18,1	1,25	2,4 - 4,0	6 - 10 Tpi	331 89445	5

Reciprocating blades for power tools by Bosch®, Metabo®, MP.S®, Wilpu®, Atlas Copco® / AEG® etc.

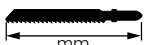






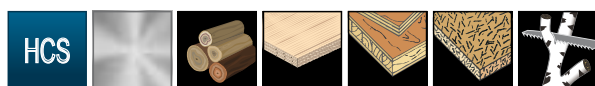
Blades to replace *
Bosch® S 1111 K | Metabo® 31125 / 31475
MP.S® 4432 | AEG® 354-778 | Wilpu® 3021/300 bi

RUKO 8923 HCS

Toothings crossed and milled.

Application range:
Coarse and nail-free wood from 20,0 - 175,0 mm, firewood from Ø 20,0 - 175,0 mm.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
225,0	18,0	1,25	8,5	3 Tpi	331 89235	5

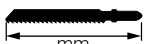






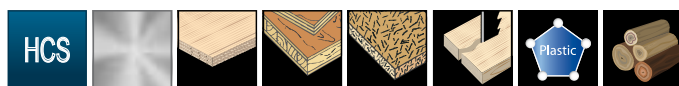
Blades to replace *
Bosch® S 1531 L | Metabo® 31139 / 31488
MP.S® 4052 | AEG® 323-803 | Wilpu® 3030-225

RUKO 8922 HCS

Toothings crossed and ground.

Application range:
Coarse and nail-free wood from 15,0 - 190,0 mm, living wood, pruned to Ø 190,0 mm,
firewood from Ø 15,0 - 190,0 mm.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
240,0	18,0	1,6	4,0 - 6,5	5 Tpi	331 89225	5

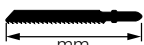






Blades to replace *
Bosch® S 1344 D | Metabo® 31122 / 31472
MP.S® 4015 | AEG® 323-802 | Wilpu® 3021-300

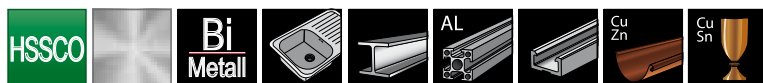
RUKO 8904 HCS

Toothings crossed and ground.

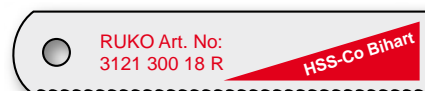
Application range:
Structural wood, wooden wall, chipboard, MDF, plywood, plastics.

			Tooth spacing teeth per mm	Tooth spacing teeth per inch		
300,0	18,0	1,25	4,2	6 Tpi	331 89045	5

HSS-Co Bihart cobalt hacksaw blade



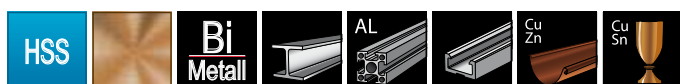
This HSS bi-metallic hacksaw blade is made of two different types of steel. The cutting edge is made of hard HSS molybdenum steel and the saw blade body is made of alloyed heat-treated steel. The combination of the two types of steel in one saw blade makes the hacksaw blade extremely wear-resistant, unbreakable and gives it outstanding cutting durability. Suitable for all common materials. The ideal blade for high demands.



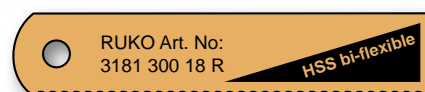
Packing unit: 100 blades per carton (10 x 10 pieces)

						Tooth spacing teeth per inch	Tooth spacing teeth per cm		
300,0	13,0	0,65	12	1/2	0.025	18 Tpi	8	3121 300 18 R	100
300,0	13,0	0,65	12	1/2	0.025	24 Tpi	10	3121 300 24 R	100
300,0	13,0	0,65	12	1/2	0.025	32 Tpi	12	3121 300 32 R	100

HSS bi-flexible hacksaw blade



Due to a special heat treatment, this HSS all-steel saw blade combines two seemingly incompatible properties: hardness and elasticity. Only the teeth are hardened whilst the HSS saw blade body remains flexible. Because of these two hardness zones, the hacksaw blade virtually features the properties of an HSS bi-metallic hacksaw blade. The ideal blade for the craftsman.



Packing unit: 100 blades per carton (10 x 10 pieces)

						Tooth spacing teeth per inch	Tooth spacing teeth per cm		
300,0	13,0	0,65	12	1/2	0.025	18 Tpi	8	3181 300 18 R	100
300,0	13,0	0,65	12	1/2	0.025	24 Tpi	10	3181 300 24 R	100
300,0	13,0	0,65	12	1/2	0.025	32 Tpi	12	3181 300 32 R	100

Compact 33 hacksaw frame

Handle made from lacquered light-metal pressure-die casting.
Frame made from polished chrome-plated square tube.
Suitable for 300,0 mm saw blades.
Includes 1 Bihart cobalt saw blade with 24 teeth per inch.



420,0	130,0	580 g	317 000 33 R	1

Reference table for RUKO reciprocating blades

Competitive blades may vary from our specifications.

	Bosch®	D+N®	Gematic®	Hawera®	Metabo®	MPS®	Fein®	Alfra®
33189015	S 922 HF	11 10 18	11 5346	144248	31131	4430	48015	30 058
33189035	S 828 D	11 20 41	11 5222	121605	31136	4014 / 4060	56012	30 082
33189045	S 1344 D	11 20 46	11 5210	144235	31122 / 31472	4015	—	30 079
33189055	S 617 K	11 20 40	11 5207	121590	28241	4021	50011	30 076
33189065	S 922 AF	11 10 21	11 5354	144239	31129	4405	—	30 061
33189085	S 922 EF	11 10 20	11 5352	144242	31132	4401	—	30 060
33189095	S 1022 HF	11 10 24	11 5361	144249	31932	4431	52013	30 063
33189105	S 1222 VF	11 10 31	—	—	31125 / 31475	4432	—	30 071
33189135	S 1122 EF	11 10 26	11 5367	144243	31133 / 31483 / 31493	4402	59018	30 065
33189155	S 922 BF	11 10 19	11 5349	144245	31130	4411	47017	30 059
33189165	S 1122 BF	11 10 25	11 5364	—	31135 / 31485	4415	51010	30 064
33189175	S 611 DF	11 22 70	11 5328	—	31985	4016	—	—
33189185	S 1025 VF	—	—	—	31991	—	—	—
33189225	S 1531 L	11 20 51	11 5219	121611	31139 / 31488	4052	—	—
33189235	S 1111 K	—	—	—	—	—	—	—
33189245	S 644 D	11 20 44	11 5201	121600	31120 / 31470	4011	55019	—
33189285	S 1122 VF	11 10 35	—	—	—	—	—	—
33189295	S 1225 VF	11 10 32	11 5379	—	31124 / 31474	4422	—	—
33189335	S 1125 VF	11 10 34	—	—	—	—	—	—
33189365	S 1111 DF	11 22 71	—	—	—	—	—	—
33189375	S 1411 DF	11 22 72	—	—	—	—	—	—
33189395	S 518 EHM	—	—	—	—	—	—	—
33189405	S 123 XF	—	—	—	—	—	—	—
33189435	S 3456 XF	—	—	—	—	—	—	—
33189445	S 2345 X	—	—	—	31910 / 31913	4046	—	—
33189455	S 1122 HF	—	—	—	—	—	—	—
33189855	S 610 DF	—	—	—	—	—	—	—
33189865	S 920 CF	—	—	—	—	—	—	—
33189885	S 1110 DF	—	—	—	31926	—	—	—
33189895	S 1120 CF	—	—	—	—	—	—	—

Reference table for RUKO reciprocating blades

Competitive blades may vary from our specifications.

	Flex®	Wilpu®	Atlas Copco® AEG®	Makita® Hitachi®	Milford® Rockwell®	Lenox®	Rothenberger®
33189015	—	3018-150	318-127	—	M 88176 / R12415	20562-610R	—
33189035	200.786	3025-150	318-131 / 323-801	M 0.30.20 / H 983 605 Z	M 87945	20560-606R	—
33189045	201.936	3021-300	318-125 / 323-802	M 0.30.21	M 88010 / R12403	20585-156R	—
33189055	200.751	3019-150	354-779	M 0.30.19	M 87936	—	—
33189065	200.743	3015-150	354-796	M 0.30.07 / H 983 603 Z	M 88179 / R 12433	20568-624R	86.5784
33189085	200.735	3014-150	354-792	M 0.30.06 / H 983 602 Z	M 88178 / R12454	20566-618R	86.5785
33189095	—	—	—	—	M 88174	20580-810R	—
33189105	201.928	3018-280	323-813	M 0.30.18	M 88208 / M 12418	—	—
33189135	217.751	3014-200	354-789	M 0.30.09	M 88187 / R 12420	20578-818R	86.5787
33189155	200.727	3013-150	323-810	M 0.30.13	M 88177 / M 12451	205654-614R	86.5786
33189165	217.190	3013-200	354-790	M 0.30.08 / H 983 601 Z	M 88186 / R 12419	—	86.5788
33189175	—	3021-150 bi	354-775	—	—	20570-636RP	—
33189185	—	—	—	—	—	—	—
33189225	250.056	3030-225	323-803	M 0.30.29	—	—	—
33189235	—	—	—	—	—	—	—
33189245	—	3021-150	318-126 / 323-800	—	M 88000 / R 12400	20572-656R	—
33189285	—	—	323-813	—	—	—	—
33189295	—	—	—	—	M 88218 / R 12457	20583-110R	86.5789
33189335	—	—	323-813	—	—	—	—
33189365	—	—	318-125	—	—	—	—
33189375	—	3021-300 bi	—	—	—	—	—
33189395	—	—	—	—	—	—	—
33189405	—	—	—	—	—	—	—
33189435	—	—	—	—	—	—	—
33189445	—	3023 / 150-240	—	—	—	—	—
33189455	—	—	—	—	—	—	—
33189855	—	3055-225	373-244	—	—	—	—
33189865	—	—	—	—	—	—	—
33189885	—	—	—	—	—	—	—
33189895	—	—	—	—	—	—	—



















DEBURRING PROGRAM

FASCINATION  PRECISION®

Range and applications overview.



Material	Surface	Type	Description	Material thickness mm	Packing unit	Article no.	Page
HSS		B10	Unigrat B 10		10	107 012	274
HSS		B20	Unigrat B 20		10	107 014	274
HSS		B30	Unigrat B 30	4,0	10	107 015	274
TC		B50	Unigrat B 50		1	107 016	274
HSS		B60	Unigrat B 60	20,0	10	107 017	274
TC		B70	Unigrat B 70	3,0	1	107 018	274
HSS		C40	Unigrat C 40	4,0	1	107 020	274
HSS		C42	Unigrat C 42	8,0	1	107 021	274
TC		D80	Unigrat D 80	3,0	1	107 023	275
TC		D82	Unigrat D 82	8,0	1	107 024	275
HSS		E100	Unigrat E 100		10	107 026	275
HSS		E200	Unigrat E 200		10	107 027	275
HSS		E300	Unigrat E 300	4,0	10	107 028	275
HSS		E350	Unigrat E 350		10	107 029	275
HSS		E600	Unigrat E 600	20,0	5	107 030	275
HSS		F12	Unigrat F 12	Ø 12,0	1	107 032	275
HSS		F20	Unigrat F 20	Ø 20,0	1	107 033	275
HSS		F30	Unigrat F 30	Ø 30,0	1	107 034	275
HSS			Rapid deburrer		1	107 052 107 054	276
HSS		N	Groove deburrer		1	107 062 107 063	277
HSS			Double deburrer	10,0	1	107 060 107 061	277
HSS			Tube deburrer	Ø 4,0 - 36,0	1	107 053	277

Rust-resistant steel	Steel	Sheet metal	Cast iron	Aluminium	Copper	Brass	Polyacetal	Polyamid (PA)	Polyvinyl chlorid (PVC)	Polyphenylene oxide	Polyethylene	Polypropylene	Poly carbonate	Polytetrafluoroethylene	Polystyrene
															
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A Unigrat „Universal Handle”

This handle fits all holders B-C-D-E-F.

With the locking head withdrawn, the steel holders can be adjusted up to 100,0 mm in length and can be locked in any position. The replacement blades fit in the bottom cavity of the handle.


Packing unit: in plastic pack

	L1 mm	Article no.	
Universal handle A	150,0	107 010	1



B Unigrat „Blade B”


Packing unit: in plastic pack

		Article no.	
B10	The HSS blade most commonly used for internal and external deburring work on long-chipping materials such as steel, aluminium, plastics etc.	107 012	10
B20	This HSS blade is used for short-chipping materials such as brass and cast iron. Can be used in both directions.	107 014	10
B30	This HSS blade is suitable for the simultaneous deburring of inside and outside bores in material up to 4,0 mm thickness.	107 015	10
B50	Scriber with carbide-tipped point, regrindable.	107 016	1
B60	This HSS blade removes burrs from the back of material up to 20,0 mm thickness.	107 017	10
B70	This carbide-tipped blade deburs workpieces made of material up to 3,0 mm thickness.	107 018	1



C Unigrat „Blade C”


Packing unit: in plastic pack

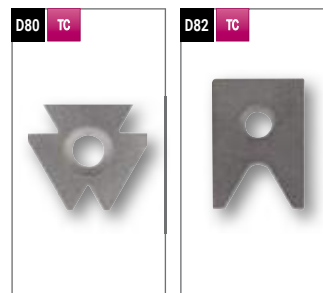
		Article no.	
C40	Small HSS triangular scraper 4,0 x 20,0 mm for precision work on surfaces up to 4 mm width.	107 020	1
C42	Large HSS triangular scraper 8,0 x 30,0 mm for standard work on surfaces up to 8,0 mm width.	107 021	1



D Unigrat „Blade D"


Packing unit: in plastic pack

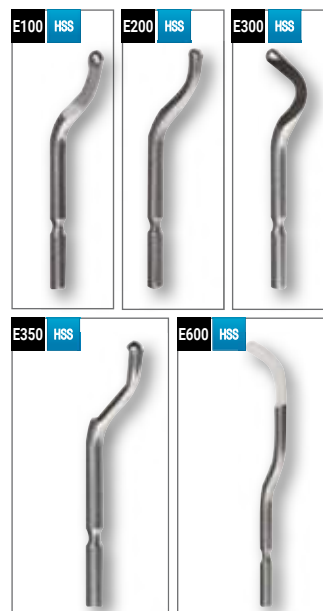
		Article no.	
D80	Reversible tungsten-carbide insert for blunt scraping and deburring sheet metal up to 3,0 mm thickness. 6 cutting edges.	107 023	1
D82	Reversible tungsten-carbide insert for deburring sheet metal up to 8,0 mm thickness. 2 cutting edges.	107 024	1



E Unigrat „Blade E"

Packing unit: in plastic pack

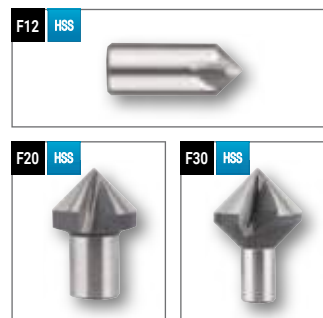
		Article no.	
E100	HSS blade with B 10 cutting edge, long shank only. For internal and external deburring work on long-chipping materials such as steel, aluminium, plastics etc.	107 026	10
E200	HSS blade with B 20 cutting edge, long shank only. For short-chipping materials such as brass and cast iron. Usable in both directions.	107 027	10
E300	HSS blade with B 30 cutting edge, long shank only. For simultaneous deburring of internal and external bores in materials up to 4,0 mm thickness.	107 028	10
E350	This HSS blade is suitable for deburring straight edges, keyways etc.	107 029	10
E600	This HSS blade is suitable for deburring from behind in materials up to 20,0 mm thickness.	107 030	5



F Unigrat „Blade F"


Packing unit: in plastic pack

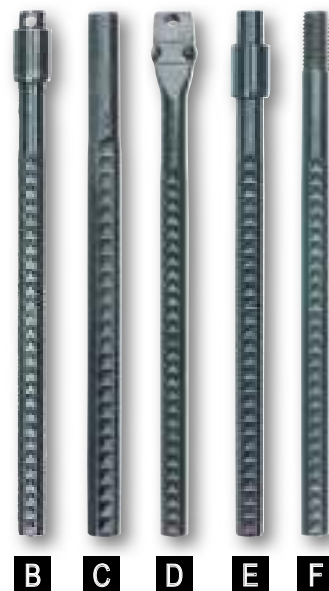
		Article no.	
F12	HSS countersinker for deburring bores up to Ø 12,0 mm.	107 032	1
F20	HSS countersinker for deburring bores up to Ø 20,0 mm.	107 033	1
F30	HSS countersinker for deburring bores up to Ø 30,0 mm.	107 034	1



Unigrat „Steel holder”

Packing unit: in plastic pack


	Article no.	
Steel holder B	107 011	1
Steel holder C	107 019	1
Steel holder D	107 022	1
Steel holder E	107 025	1
Steel holder F	107 031	1



Edge trimmer with HSS blades

- Plastic handle with removable back for spare blade storage.
- Exchangeable blades.
- Ideal for trimming edges, tubes, steel, aluminium, brass and copper sheets, cast iron and plastic sheets.

Packing unit: in plastic pack


	Article no.	
Edge trimmer A1 complete with E 100 HSS blade	107 050	1
4-piece set of edge trimmer A3 complete with 3 HSS blades	107 051	1



Rapid deburrer with HSS blade

- Hexagonal aluminium handle.
- Small and handy.
- Pocket-sized for permanent readiness.

Packing unit: in plastic bags of 1 each


	Article no.	
Rapid deburrer with non-exchangeable E 100 HSS blade	107 052	1
Rapid deburrer with exchangeable E 100 HSS blade	107 054	1



Groove deburrer set "N" with HSS disk blade

- Plastic handle.
- Exchangeable HSS disk blade.
- Ideal for grooves from 2,4 - 11,0 mm width.
- Especially suitable for deburring shaft keyways and bores in steel and aluminium.

Packing unit: in plastic pack


	Article no.	
3-piece set of groove deburrer "N" 3 pieces with RUKO universal handle A	107 062	1
1 replacement steel holder N	107 037	1
1 replacement HSS disk blade	107 063	1



Double deburrer with HSS disk blades

- Plastic handle with hand protector and 2 HSS blades.
- Exchangeable HSS disk blades.
- The disk blades can be turned when the cutting surfaces become worn, enabling the whole blade circumference to be utilized.
- The distance between the disk blades can be adjusted.
- Suitable for double-sided deburring of steel, aluminium, brass, copper and plastic sheets up to 10,0 mm thickness.

Packing unit: in plastic pack


	Article no.	
Double deburrer, complete	107 060	1
Replacement HSS disk blade	107 061	2



Tube deburrer with HSS cutting edges

- Ideal for internal tube deburring.
- Ideal for external tube deburring.
- Suitable for tube diameters from 4,0 to 36,0 mm.

Packing unit: in plastic pack

	Article no.	
Tube deburrer	107 053	1

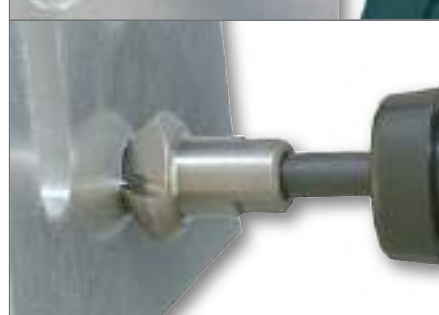
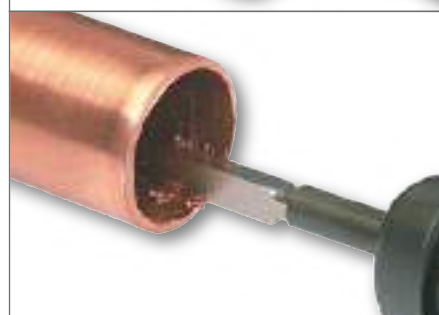


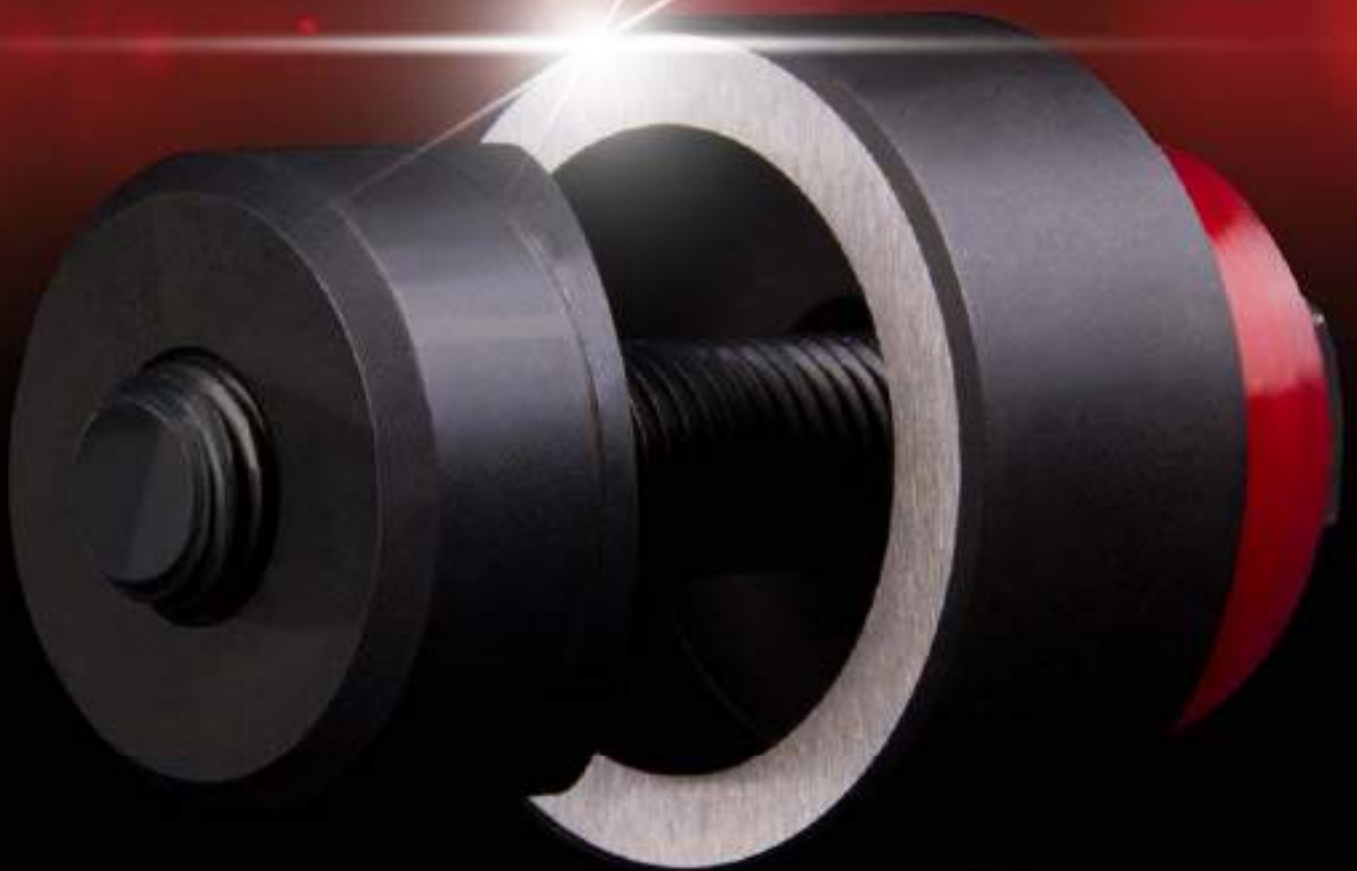
Unigrat sets

A rational deburring system for all deburring work that has to be done by hand.
The wide selection of blades provides a wide range of deburring possibilities for bores and edges.
The various blades enable you to debur bores from inside, outside or on both sides, as the blade itself adapts to the contours.

Packing unit: in plastic packs

	Article no.
4-piece set of unigrat deburrer "B" 	107 003
3-piece set of unigrat deburrer "C" 	107 004
4-piece set of unigrat deburrer "D" 	107 005
5-piece set of unigrat deburrer "E" 	107 006
3-piece set of unigrat deburrer "F" 	107 007





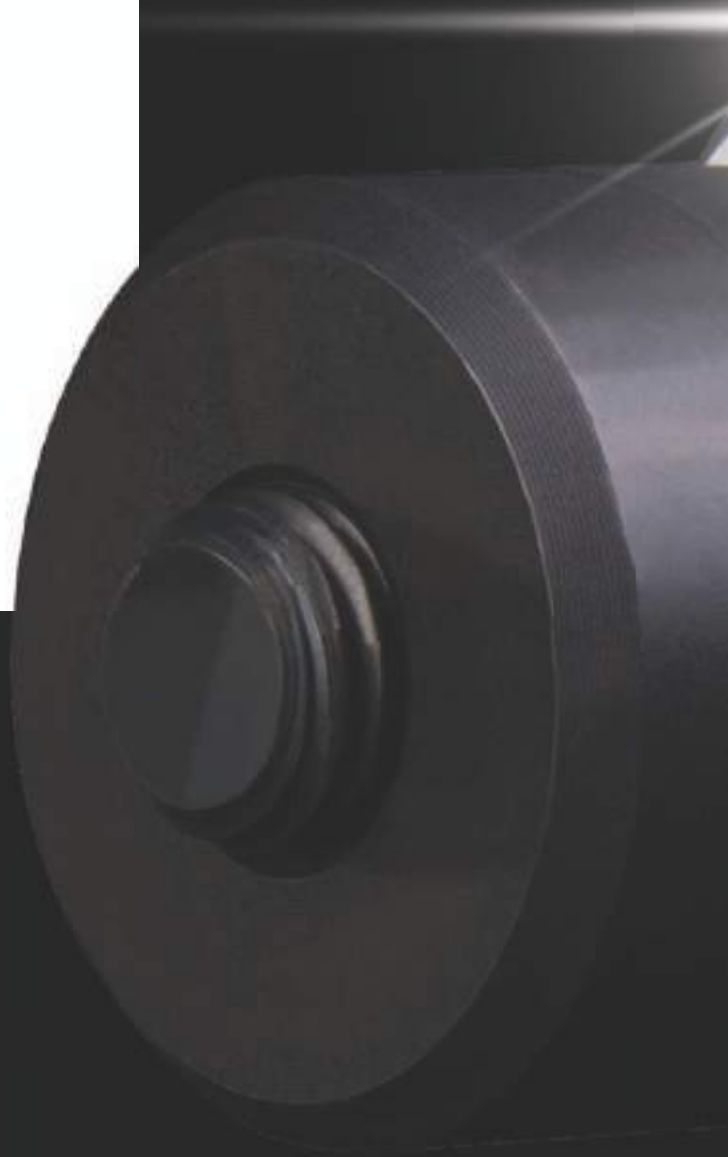
SCREW HOLE PUNCHES

FASCINATION  PRECISION®

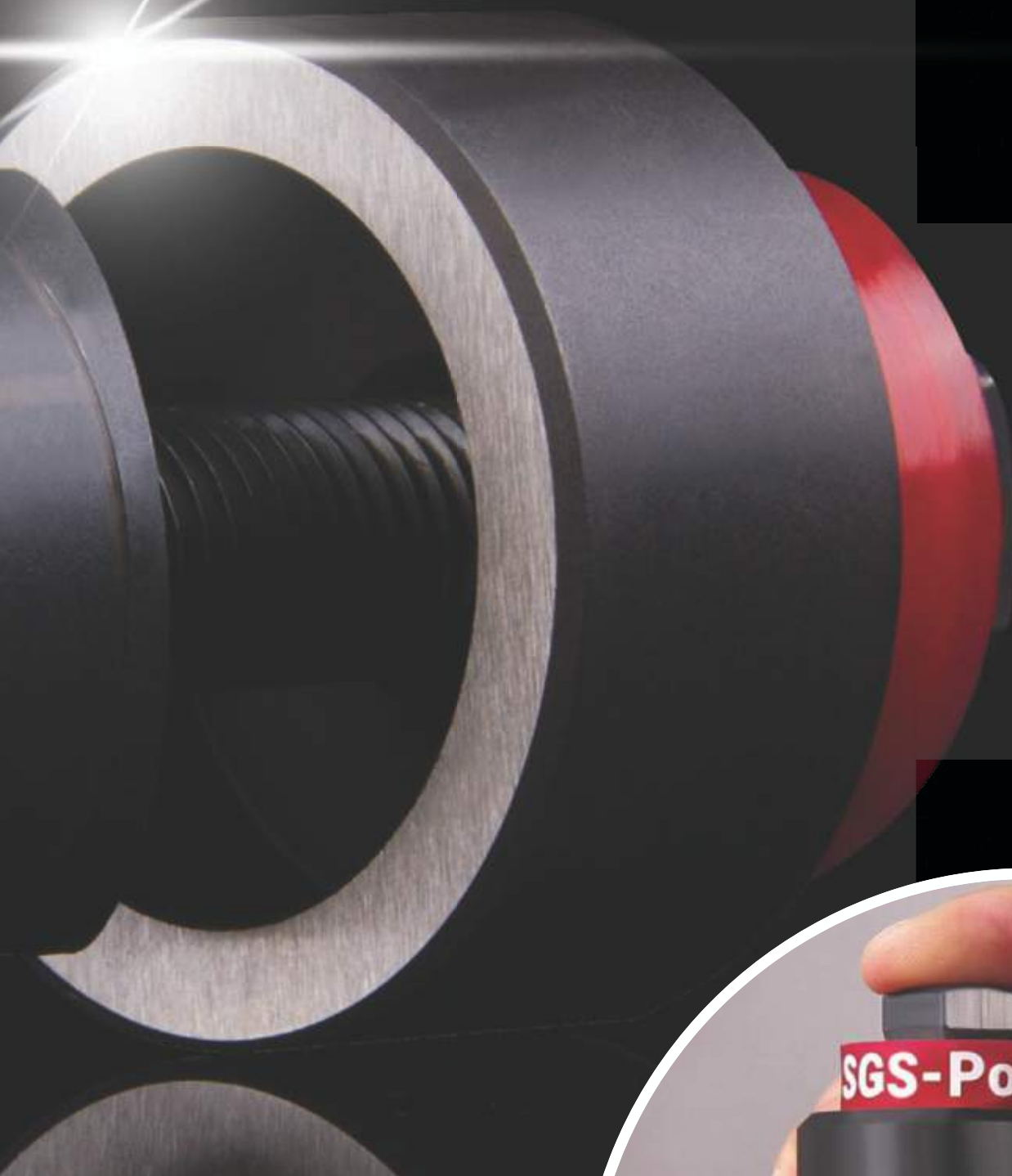
Powerful can be that simple.

The RUKO screw hole punch
DuoCut SGS-Power

- + Up to 70% less effort required**
- + More holes due to less wear & tear**
- + Significantly improved holes**



DuoCut SGS-Power



Strong Performance.

The perfect solution for stainless steel sheet, mild steel sheet, non-ferrous and light metals and plastics.

Ideal for plumbers, sheet metal workers and general fabrication.



Information
and videos





Screw hole punches DuoCut and DuoCut SGS-Power with two point cutting tip

Die: two point cutting tip
Material: special steel
Draw-in bolt: metric fine-threads


The perfect solution for stainless steel sheet, mild steel sheet, non-ferrous and light metals and plastics.
Ideal for plumbers, sheet metal workers and general fabrication.



Packing unit: individual cartons


2-point punch with ball bearing:

- Up to 70% less power required
- Less wear and tear
- More precise punching



Precision ground female tool punch:

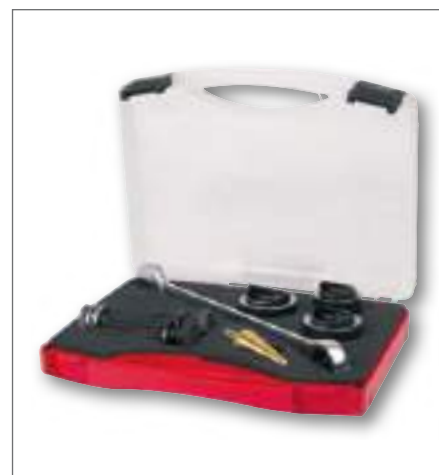
- Better punching results
- Improved surface coating on workpiece



Ø mm	Through dimensions		Conduit & Pipe Size	Ø inch	Draw-in bolt MF	Art. no standard	Art. no	
	M	PG					ball-bearing SGS-Power	
12,7	M 12	PG 7		1/2"	MF 8	109 2 127	—	1
15,2		PG 9			MF 10	109 2 152	109 2 152 K	1
16,5	M 16				MF 10	109 2 165	109 2 165 K	1
18,6		PG 11			MF 10	109 2 186	109 2 186 K	1
20,4	M 20	PG 13,5			MF 10	109 2 204	109 2 204 K	1
22,5		PG 16	1/2"	7/8"	MF 10	109 2 225	109 2 225 K	1
25,4	M 25			1"	MF 10	109 2 254	109 2 254 K	1
28,3		PG 21	3/4"		MF 12	109 2 283	109 2 283 K	1
32,0					MF 12	109 2 320	109 2 320 K	1
32,5	M 32				MF 12	109 2 325	109 2 325 K	1
35,0				1 3/8"	MF 12	109 2 350	109 2 350 K	1
37,0		PG 29			MF 12	109 2 370	109 2 370 K	1
40,5					MF 16	109 2 405	109 2 405 K	1
47,0		PG 36			MF 16	109 2 470	109 2 470 K	1
50,5	M 50				MF 16	109 2 505	109 2 505 K	1
54,0		PG 42		2 1/8"	MF 16	109 2 540	109 2 540 K	1

Screw hole punches set DuoCut SGS-Power with two point cutting tip for plumbing in plastic case

	Art. no
8-piece set of screw hole punches 3 screw hole punches Ø 28,3 (PG21) - 32,0 - 35,0 mm	109 010
+ 1 tube and sheet drill HSS-TiN size 2 + 2 replacement bolt MF 12 x 1,5 + 1 replacement bolt with ball-bearing MF 12 x 1,5 + 1 ring-open end spanner size 19,0 mm	



Screw hole punches sets DuoCut and DuoCut SGS-Power with two point cutting tip in plastic cases

		Art. no standard	Art. no ball-bearing
			SGS-Power
Set 1 DuoCut	11- piece set of screw hole punches 6 screw hole punches Ø 15,2 (PG 9) - 18,6 (PG 11) - 20,4 (M 20 / PG 13,5) - 22,5 (PG 16) - 28,3 (PG 21) - 32,0 mm + 1 tube and sheet drill HSS size 1 + 1 cutting paste 30 g + 2 replacement bolts MF 10 x 1,0 + 1 replacement bolt MF 12 x 1,5	109 2 002	109 2 002 K
Set 2 DuoCut	13- piece set of screw hole punches 8 screw hole punches Ø 15,2 (PG 9) - 18,6 (PG 11) - 20,4 (M 20 / PG 13,5) - 22,5 (PG 16) - 28,3 (PG 21) - 37,0 (PG 29) - 47,0 (PG 36) + 54,0 mm (PG 42) + 1 tube and sheet drill HSS size 2 + 1 cutting paste 30 g + 1 replacement bolt MF 10 x 1,0 + 1 replacement bolt MF 12 x 1,5 + 1 replacement bolt MF 16 x 1,5	109 2 003	109 2 003 K
Set 3 DuoCut	10- piece set of screw hole punches 5 screw hole punches Ø 16,5 (M 16) - 20,4 (M 20 / PG 13,5) - 25,4 (M 25) - 32,5 (M 32) + 40,5 mm (M 40) + 1 tube and sheet drill HSS size 2 + 1 cutting paste 30 g + 1 replacement bolt MF 10 x 1,0 + 1 replacement bolt MF 12 x 1,5 + 1 replacement bolt MF 16 x 1,5	109 2 006	109 2 006 K





Screw hole punches with three point cutting tip

Die: three point cutting tip
Material: special steel
Draw-in bolt: metric fine-threads

Suitable for sheet steel, stainless-steel sheets, non-ferrous and light metals, plastics.
Ideal for switchgear manufacturers, electricians, plumbers, industry and handicrafts.




Packing unit: individual cartons



The through hole should be only slightly bigger than the diameter (+ 1.0 mm) of the traction bolt. Apply (spread) RUKO lubricating paste on the cutting edges and the traction bolt. This reduces wear and thus increases the service life of the screw hole punch.



Ø mm	Through dimensions		Conduit & Pipe Size	Ø inch	Draw-in bolt MF	Art. no standard	Art. no ball-bearing	
M	PG							
12,7	M 12	PG 7		1/2"	MF 8	109 127	—	1
15,2		PG 9			MF 10	109 152	109 152 K	1
16,0					MF 10	109 160	109 160 K	1
16,5	M 16				MF 10	109 165	109 165 K	1
18,0					MF 10	109 180	109 180 K	1
18,6		PG 11			MF 10	109 186	109 186 K	1
19,0				3/4"	MF 10	109 190	109 190 K	1
20,0					MF 10	109 200	109 200 K	1
20,4	M 20	PG 13,5			MF 10	109 204	109 204 K	1
21,0					MF 10	109 210	109 210 K	1
22,0					MF 10	109 220	109 220 K	1
22,5		PG 16	1/2"	7/8"	MF 10	109 225	109 225 K	1
23,0					MF 10	109 230	109 230 K	1
24,0					MF 10	109 240	109 240 K	1
25,0					MF 10	109 250	109 250 K	1
25,4	M 25			1"	MF 10	109 254	109 254 K	1
26,0					MF 10	109 260	109 260 K	1
27,0					MF 10	109 270	109 270 K	1
28,3		PG 21	3/4"		MF 12	109 283	109 283 K	1
29,0					MF 12	109 290	109 290 K	1
30,0					MF 12	109 300	109 300 K	1
30,5				1 7/32"	MF 12	109 305	109 305 K	1
31,0					MF 12	109 310	109 310 K	1
32,0					MF 12	109 320	109 320 K	1
32,5	M 32				MF 12	109 325	109 325 K	1
33,0					MF 12	109 330	109 330 K	1
34,0					MF 12	109 340	109 340 K	1
35,0				1 3/8"	MF 12	109 350	109 350 K	1
36,0					MF 12	109 360	109 360 K	1
37,0		PG 29			MF 12	109 370	109 370 K	1
38,0				1 1/2"	MF 12	109 380	109 380 K	1
40,0	M 40				MF 12	109 400	109 400 K	1
40,5					MF 16	109 405	109 405 K	1
42,0					MF 16	109 420	109 420 K	1
43,0			1 1/4"		MF 16	109 430	109 430 K	1
45,0					MF 16	109 450	109 450 K	1
47,0		PG 36			MF 16	109 470	109 470 K	1
50,0			1 1/2"		MF 16	109 500	109 500 K	1
50,5	M 50				MF 16	109 505	109 505 K	1
51,0					MF 16	109 510	109 510 K	1
53,0					MF 16	109 530	109 530 K	1
54,0		PG 42		2 1/8"	MF 16	109 540	109 540 K	1
55,0					MF 16	109 550	109 550 K	1
60,0		PG ~ 48			MF 16	109 600	109 600 K	1
61,5			2"	2 3/8"	MF 16	109 615	109 615 K	1
63,5	M 63			2 1/2"	MF 16	109 635	109 635 K	1

Sets of screw hole punches with three point cutting tip in plastic cases

		Art. no standard	Art. no ball-bearing
Set 1	11 - piece set of screw hole punches 6 screw hole punches Ø 15,2 (PG 9) - 18,6 (PG 11) - 20,4 (M 20 / PG 13,5) - 22,5 (PG 16) - 28,3 (PG 21) + 32,0 mm + 1 tube and sheet drill HSS size 1 + 1 cutting paste 30 g + 2 replacement bolts MF 10 x 1,0 + 1 replacement bolt MF 12 x 1,5	109 002	109 002 K
Set 2	13 - piece set of screw hole punches 8 screw hole punches Ø 15,2 (PG 9) - 18,6 (PG 11) - 20,4 (M 20 / PG 13,5) - 22,5 (PG 16) - 28,3 (PG 21) 37,0 (PG 29) - 47,0 (PG 36) + 54,0 mm (PG 42) + 1 tube and sheet drill HSS size 2 + 1 cutting paste 30 g + 1 replacement bolt MF 10 x 1,0 + 1 replacement bolt MF 12 x 1,5 + 1 replacement bolt MF 16 x 1,5	109 003	109 003 K
Set 3	10 - piece set of screw hole punches 5 screw hole punches Ø 16,5 (M 16) - 20,4 (M 20 / PG 13,5) - 25,4 (M 25) - 32,5 (M 32) + 40,5 mm (M 40) + 1 tube and sheet drill HSS size 2 + 1 cutting paste 30 g + 1 replacement bolt MF 10 x 1,0 + 1 replacement bolt MF 12 x 1,5 + 1 replacement bolt MF 16 x 1,5	109 006	109 006 K
Set 4	12 - piece set of screw hole punches 7 screw hole punches Ø 16,5 (M 16) - 20,4 (M 20 / PG 13,5) - 25,4 (M 25) - 32,5 (M 32) - 40,5 (M 40) 50,5 (M 50) + 63,5 mm (M 63) + 1 tube and sheet drill HSS size 2 + 1 cutting paste 30 g + 1 replacement bolt MF 10 x 1,0 + 1 replacement bolt MF 12 x 1,5 + 1 replacement bolt MF 16 x 1,5	109 008	109 008 K



Set of foot-operated hydraulic punch in plastic case

	Article no.
Foot-operated hydraulic punch, complete + 1 distance sleeve + 1 adapter bolt MF 10 x 1,0, 3/4" UNF fitting + 1 adapter bolt MF 12 x 1,5, 3/4" UNF fitting + 1 adapter bolt MF 16 x 1,5, 3/4" UNF fitting pulling power 50 kN	109 301



Set of manual hydraulic punch in plastic case

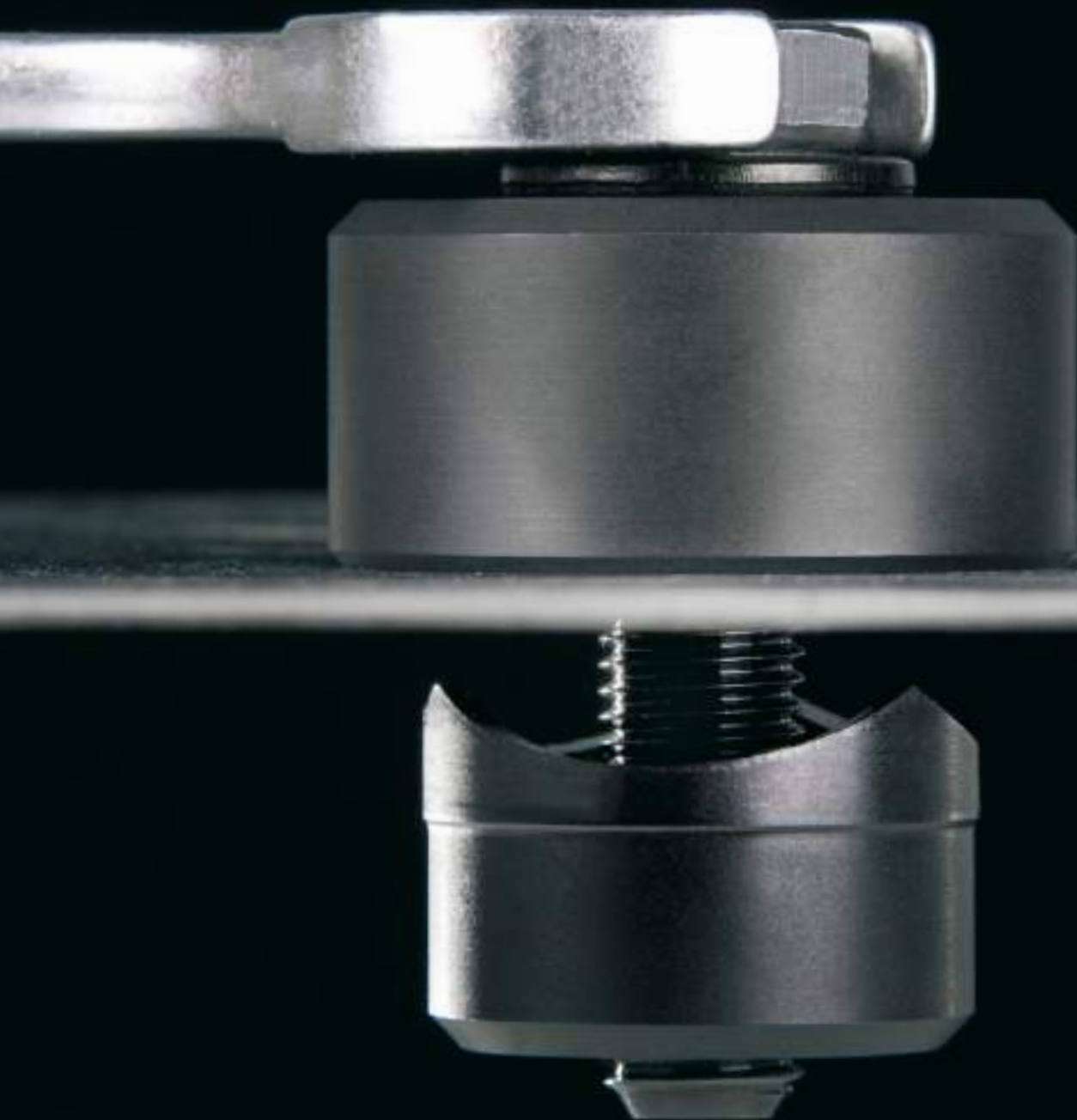
	Article no.
Compact manual hydraulic punch, complete + 1 distance sleeve + 1 adapter bolt MF 10 x 1,0, 3/4" UNF fitting + 1 adapter bolt MF 12 x 1,5, 3/4" UNF fitting + 1 adapter bolt MF 16 x 1,5, 3/4" UNF fitting pulling power 50 kN	109 101
Manual hydraulic punch, complete + 1 distance sleeve + 1 adapter bolt MF 10 x 1,0, 3/4" UNF fitting + 1 adapter bolt MF 12 x 1,5, 3/4" UNF fitting + 1 adapter bolt MF 16 x 1,5, 3/4" UNF fitting pulling power 50 kN	109 201



Set of screw hole punches with compact manual hydraulic punch in plastic case

	Article no.
13-piece set of screw hole punches with compact manual hydraulic punch 1 compact manual hydraulic punch + 6 screw hole punches Ø 16,5 (M 16) - 20,4 (M 20 / PG 13,5) - 25,4 (M 25) - 32,5 (M 32) - 40,5 (M 40) + 50,5 mm (M 50) + 1 tube and sheet drill HSS size 2 + 1 cutting paste 30 g + 1 distance sleeve + 1 adapter bolt MF 10 x 1,0, 3/4" UNF fitting + 1 adapter bolt MF 12 x 1,5, 3/4" UNF fitting + 1 adapter bolt MF 16 x 1,5, 3/4" UNF fitting pulling power 50 kN	109 009
15-piece set of screw hole punches with compact manual hydraulic punch 1 compact manual hydraulic punch + 8 screw hole punches Ø 15,2 (PG 9) - 18,6 (PG 11) - 20,4 (M 20 / PG 13,5) - 22,5 (PG 16) - 28,3 (PG 21) - 37,0 (PG 29) - 47,0 (PG 36) + 54,0 mm (PG 42) + 1 tube and sheet drill HSS size 2 + 1 cutting paste 30 g + 1 distance sleeve + 1 adapter bolt MF 10 x 1,0, 3/4" UNF fitting + 1 adapter bolt MF 12 x 1,5, 3/4" UNF fitting + 1 adapter bolt MF 16 x 1,5, 3/4" UNF fitting pulling power 50 kN	109 004





Recommendations for the use of screw hole punches

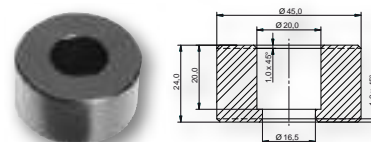
Ø mm	Draw-in bolt	Sheet steel	Stainless-steel sheets	Non-ferrous and light metals	Plastics
12,7	MF 8 x 1,0 mm	2,0 mm	1,0 mm	4,0 mm	4,0 mm
15,2 - 27,0	MF 10 x 1,0 mm	2,0 mm	1,0 mm	4,0 mm	4,0 mm
28,3 - 40,0	MF 12 x 1,5 mm	3,0 mm	1,5 mm	4,0 mm	4,0 mm
40,5 - 63,5	MF 16 x 1,5 mm	3,0 mm	1,5 mm	4,0 mm	4,0 mm



Spare parts

The adapter bolts may be used on all standard hydraulic punches.

Packing unit: individual plastic packing



	Article no.
Distance sleeve	109 000
Adapter bolt MF 10 x 1,0, 3/4" UNF fitting	109 110
Adapter bolt MF 12 x 1,5, 3/4" UNF fitting	109 112
Adapter bolt MF 16 x 1,5, 3/4" UNF fitting	109 116
Replacement bolt MF 8 x 1,0 x 40	103 108
Replacement bolt MF 10 x 1,0 x 45	103 110
Replacement bolt MF 12 x 1,5 x 55	103 112
Replacement bolt MF 16 x 1,5 x 60	103 116
Replacement bolt with ball-bearing MF 10 x 1,0 x 50	103 110 K
Replacement bolt with ball-bearing MF 12 x 1,5 x 60	103 112 K
Replacement bolt with ball-bearing MF 16 x 1,5 x 70	103 116 K






COOLANTS AND LUBRICANTS

FASCINATION FOR PRECISION®

Cutting pastes

High performance cutting paste with outstanding separation and cooling effect. Increases tool life even with hard and brittle materials. High heat resistance ensures good lubrication and cooling even at high temperatures. Good adhesion improves lubrication.

For all standard metal working processes such as thread cutting, grinding, sawing, drilling, countersinking, deburring, turning, stamping and milling. Cutting spray including 360° valve!


	Article no.	
Cutting paste, 50 g	101 021	1
Cutting paste, 30 g	101 035	1



Cutting spray cans

High performance cutting spray with outstanding separation and cooling effect. Increases tool life even with hard and brittle materials. High heat resistance ensures good lubrication and cooling even at high temperatures. Good adhesion improves lubrication.

For all standard metal working processes such as thread cutting, grinding, sawing, drilling, countersinking, deburring, turning, stamping and milling.


	Article no.	
Cutting spray, 50 ml	101 010	12
Cutting spray, 200 ml	101 025	12
Cutting spray, 400 ml	101 036	12



Universal cutting oil concentrate

Excellent lubricating and cooling effect. Increases tool life by excellent lubricity, even at low concentration. Transparent solution does not stick, prevents corrosion, clear view of machine, work-piece and tool. Skin friendly, free of PCBs, formaldehyde, sulfur and sodium nitrite, organically stable, corresponds to TRGS 611.

For all conventional metal processing methods in unalloyed and alloyed steels, when thread-cutting, reaming, sawing, drilling, turning, milling and grinding. Boron and amine-free. Application concentration in water depending on work process: 5 % - 15 % cation concentration in water.

	Article no.	
Universal cutting oil concentrate, 1 L bottle	101 034	1
Universal cutting oil concentrate, 5 L canister	101 033	1















CONCRETE DRILLS

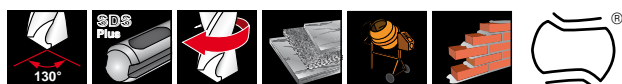
FASCINATION FOR PRECISION®

Range and applications overview:



Surface	DIN	right hand cutting	Point angle	Cutting edges	Shank	Ø mm	Drilling depth	Article no.	Page
						3,5 mm 26,0 mm	50,0 mm 950,0 mm	211 035 211 260	294 295
						5,0 mm 14,0 mm	50,0 mm 400,0 mm	213 050 213 144	296 297
	DIN 8039			TC		3,0 mm 20,0 mm	40,0 mm 200,0 mm	221 030 221 200	298
	DIN 8039			TC		3,0 mm 20,0 mm	40,0 mm 100,0 mm	209 030 209 200	299
	DIN 8039			TC		5,0 mm 12,0 mm	90,0 mm 150,0 mm	210 050 210 120	299
	DIN 8039			TC		8,0 mm 20,0 mm	350,0 mm	218 080 218 200	300
						16,0 mm 30,0 mm	200,0 mm 400,0 mm	224 160 224 300	300
				 		12,0 mm 40,0 mm	200,0 mm 1200,0 mm	225 120 225 403	301
				TC		5,0 mm 12,0 mm	50,0 mm 90,0 mm	223 050 223 120	302
				TC		3,0 mm 12,0 mm	80,0 mm 100,0 mm	223 003 223 012	302
				 	 	30,0 mm 100,0 mm	50,0 mm	226 0301 226 1001	303
						10,0 mm	250,0 mm	227 001 227 006	304
						18,0 mm	280,0 mm 600,0 mm	227 010 227 018	304

Concrete	Masonry	Granite and marble	Tiles	Bricks	Lightweight material	Concrete reinforcement	Plastics	Non-ferrous metals	Glass
									
■	■	■	■	■		■			
■	■	■	■	■		■			
■	■	■		■	■	■			
■	■	■	■	■	■				
■	■	■		■	■				
■	■		■	■					
■	■		■	■					
■	■	■			■	■			
	■		■	■	■	■	■	■	
			■				■		■
■	■	■	■	■	■				
■	■	■	■	■	■				
■	■	■	■	■	■				



SDS-plus hammer drills

Longer service life in concrete and reinforcement thanks to the stabilised head geometry and rounded cutting edges. Patented double-edge cutting design according to the bionic principle.

Innovative Twinmax 3D spiral profile provides the ideal removal of drill dust. Certified by the Prüfungsgemeinschaft Mauerbohrer (PGM) in accordance with the requirements of the Deutsches Institut für Bautechnik. (DIBt).

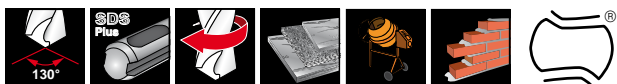
Fields of application: for granite, concrete, concrete reinforcement, clinker, stone, brickwork and marble. In all hammer drills with SDS-plus adaptor and 2-groove adaptor such as Hilti TE 10-22.

Packaging: in plastic clip of 1 each





Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
3,5	9/64	110,0	50,0	211 035	1
4,0	5/32	110,0	50,0	211 040	1
4,0	5/32	160,0	100,0	211 041	1
5,0	3/16	110,0	50,0	211 050	1
5,0	3/16	160,0	100,0	211 051	1
5,0	3/16	210,0	150,0	211 052	1
5,5	7/32	110,0	50,0	211 055	1
5,5	7/32	160,0	100,0	211 056	1
6,0	15/64	110,0	50,0	211 060	1
6,0	15/64	160,0	100,0	211 061	1
6,0	15/64	210,0	150,0	211 062	1
6,0	15/64	260,0	200,0	211 063	1
6,0	15/64	460,0	* 400,0	211 068	1
6,5	8/32	110,0	50,0	211 065	1
6,5	8/32	160,0	100,0	211 066	1
6,5	8/32	210,0	150,0	211 067	1
6,5	8/32	260,0	200,0	211 069	1
7,0	9/32	110,0	50,0	211 070	1
7,0	9/32	160,0	100,0	211 071	1
7,0	9/32	210,0	150,0	211 072	1
8,0	5/16	110,0	50,0	211 080	1
8,0	5/16	160,0	100,0	211 081	1
8,0	5/16	210,0	150,0	211 082	1
8,0	5/16	260,0	200,0	211 083	1
8,0	5/16	310,0	250,0	211 085	1
8,0	5/16	460,0	* 400,0	211 084	1
8,0	5/16	610,0	* 550,0	211 086	1
9,0	11/32	160,0	100,0	211 090	1
9,0	11/32	210,0	150,0	211 091	1
10,0	3/8	110,0	50,0	211 105	1
10,0	3/8	160,0	100,0	211 100	1
10,0	3/8	210,0	150,0	211 101	1
10,0	3/8	260,0	200,0	211 102	1
10,0	3/8	310,0	250,0	211 104	1
10,0	3/8	360,0	300,0	211 103	1
10,0	3/8	460,0	* 400,0	211 106	1
10,0	3/8	610,0	* 550,0	211 107	1
10,0	3/8	1000,0	* 950,0	211 108	1
11,0	7/16	160,0	100,0	211 110	1
11,0	7/16	210,0	150,0	211 111	1
11,0	7/16	260,0	200,0	211 112	1
12,0	15/32	160,0	100,0	211 120	1
12,0	15/32	210,0	150,0	211 122	1
12,0	15/32	260,0	200,0	211 121	1

Ø mm	Ø Inch	L1 mm	L2 mm	Article no.	
12,0	15/32	310,0	250,0	211 124	1
12,0	15/32	460,0	* 400,0	211 123	1
12,0	15/32	600,0	* 550,0	211 125	1
12,0	15/32	1000,0	* 950,0	211 126	1
13,0	1/2	160,0	100,0	211 130	1
13,0	1/2	210,0	150,0	211 133	1
13,0	1/2	260,0	200,0	211 131	1
13,0	1/2	310,0	250,0	211 132	1
14,0	9/16	160,0	100,0	211 140	1
14,0	9/16	210,0	150,0	211 141	1
14,0	9/16	260,0	200,0	211 142	1
14,0	9/16	310,0	250,0	211 143	1
14,0	9/16	460,0	* 400,0	211 144	1
14,0	9/16	600,0	* 550,0	211 145	1
14,0	9/16	1000,0	* 950,0	211 146	1
15,0	19/32	160,0	100,0	211 150	1
15,0	19/32	210,0	150,0	211 152	1
15,0	19/32	260,0	200,0	211 151	1
15,0	19/32	450,0	* 400,0	211 153	1
16,0	5/8	160,0	100,0	211 162	1
16,0	5/8	210,0	150,0	211 160	1
16,0	5/8	250,0	200,0	211 163	1
16,0	5/8	310,0	250,0	211 164	1
16,0	5/8	450,0	* 400,0	211 161	1
16,0	5/8	600,0	* 550,0	211 165	1
16,0	5/8	800,0	* 750,0	211 166	1
16,0	5/8	1000,0	* 950,0	211 167	1
17,0	43/64	210,0	150,0	211 170	1
18,0	11/16	200,0	150,0	211 180	1
18,0	11/16	250,0	200,0	211 184	1
18,0	11/16	300,0	250,0	211 183	1
18,0	11/16	450,0	* 400,0	211 181	1
18,0	11/16	600,0	* 550,0	211 185	1
18,0	11/16	1000,0	* 950,0	211 182	1
19,0	3/4	200,0	150,0	211 190	1
19,0	3/4	450,0	* 400,0	211 191	1
20,0	25/32	200,0	150,0	211 200	1
20,0	25/32	300,0	250,0	211 201	1
20,0	25/32	450,0	* 400,0	211 202	1
20,0	25/32	600,0	* 550,0	211 203	1
20,0	25/32	1000,0	* 950,0	211 204	1
22,0	7/8	250,0	200,0	211 221	1
22,0	7/8	300,0	250,0	211 222	1
22,0	7/8	450,0	* 400,0	211 220	1




SDS-plus hammer drills

Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
22,0	7/8	600,0	* 550,0	211 223	1
22,0	7/8	1000,0	* 950,0	211 224	1
24,0	15/16	250,0	200,0	211 240	1
24,0	15/16	450,0	* 400,0	211 241	1
25,0	63/64	250,0	200,0	211 251	1

Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
25,0	63/64	300,0	250,0	211 252	1
25,0	63/64	450,0	* 400,0	211 250	1
25,0	63/64	1000,0	* 950,0	211 253	1
26,0	1 3/16	250,0	200,0	211 261	1
26,0	1 3/16	450,0	* 400,0	211 260	1

* Please note when using these bits it is recommended to pre-drill with a shorter hammer drill of a same diameter.

SDS-plus hammer drills in hanging plastic box

Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
5,0	3/16	110,0	50,0	211 050 K	10
5,0	3/16	160,0	100,0	211 051 K	10
6,0	15/64	110,0	50,0	211 060 K	10
6,0	15/64	160,0	100,0	211 061 K	10
8,0	5/16	110,0	50,0	211 080 K	10
8,0	5/16	160,0	100,0	211 081 K	10
8,0	5/16	210,0	150,0	211 082 K	10
10,0	3/8	110,0	50,0	211 105 K	10
10,0	3/8	160,0	100,0	211 100 K	10
12,0	15/32	160,0	100,0	211 120 K	10
12,0	15/32	210,0	150,0	211 122 K	10
14,0	9/16	160,0	100,0	211 140 K	5
14,0	9/16	210,0	150,0	211 141 K	5



SDS-plus hammer drill sets

Fields of application: for granite, concrete, concrete reinforcement, clinker, stone, brickwork and marble. In all hammer drills with SDS-plus adaptor and 2-groove adaptor such as Hilti TE 10-22.

	Article no.
7-piece set of SDS-plus hammer drills in steel case Ø 5,0 - 6,0 - 8,0 x 110,0 mm and Ø 6,0 - 8,0 - 10,0 - 12,0 x 160,0 mm	205 246
7-piece set of SDS-plus hammer drills in plastic case Ø 5,0 - 6,0 - 8,0 x 110,0 mm and Ø 6,0 - 8,0 - 10,0 - 12,0 x 160,0 mm	205 246 RO



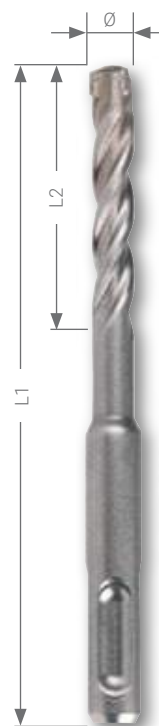



SDS-plus hammer drills with 3 cutters

Impeller cutting edge with 3 blades for more effective material removal; increased power transmission thanks to shaft-form head design; extremely long service life thanks to extremely wear-resistant single-phase tungsten carbide alloy; stable head geometry due to embedded tungsten carbide head; optimised low-vibration triple spiral; DuraTec hardening technique; certified by the Prüfgemeinschaft Mauerbohrer (PGM) in accordance with the requirements of the Deutsches Institut für Bautechnik. (DIBt).

Fields of application: for granite, concrete, clinker, stone, brickwork and marble.
In all hammer drills with SDS-plus adaptor and 2-groove adaptor such as Hilti TE 10-22.

Packaging: in plastic clip of 1 each



Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
5,0	3/16	110,0	50,0	213 050	1
5,0	3/16	160,0	100,0	213 051	1
5,0	3/16	210,0	150,0	213 052	1
5,5	7/32	110,0	50,0	213 055	1
5,5	7/32	160,0	100,0	213 056	1
6,0	15/64	110,0	50,0	213 060	1
6,0	15/64	160,0	100,0	213 061	1
6,0	15/64	210,0	150,0	213 062	1
6,0	15/64	260,0	200,0	213 063	1
6,5	8/32	110,0	50,0	213 065	1
6,5	8/32	160,0	100,0	213 066	1
6,5	8/32	260,0	200,0	213 067	1
8,0	5/16	110,0	50,0	213 080	1
8,0	5/16	160,0	100,0	213 081	1
8,0	5/16	210,0	150,0	213 082	1
8,0	5/16	260,0	200,0	213 083	1
8,0	5/16	360,0	300,0	213 084	1
8,0	5/16	460,0	400,0	213 085	1
10,0	3/8	110,0	50,0	213 100	1
10,0	3/8	160,0	100,0	213 101	1
10,0	3/8	210,0	150,0	213 102	1
10,0	3/8	260,0	200,0	213 103	1
10,0	3/8	360,0	300,0	213 104	1
10,0	3/8	460,0	400,0	213 105	1
12,0	15/32	160,0	100,0	213 120	1
12,0	15/32	210,0	150,0	213 121	1
12,0	15/32	260,0	200,0	213 122	1
12,0	15/32	350,0	300,0	213 123	1
12,0	15/32	450,0	400,0	213 124	1
14,0	9/16	160,0	100,0	213 140	1
14,0	9/16	200,0	150,0	213 141	1
14,0	9/16	250,0	200,0	213 142	1
14,0	9/16	350,0	300,0	213 143	1
14,0	9/16	450,0	400,0	213 144	1




SDS-plus hammer drill sets with 3 cutters

	Article no.
7-piece set of SDS-plus hammer drills in steel case Ø 5,0 - 6,0 - 8,0 x 110,0 mm and Ø 6,0 - 8,0 - 10,0 - 12,0 x 160,0 mm	213 246
77-piece set of SDS-plus hammer drills in plastic case Ø 5,0 - 6,0 - 8,0 x 110,0 mm and Ø 6,0 - 8,0 - 10,0 - 12,0 x 160,0 mm	213 246 RO



213 246

SDS-plus hammer drills with 3 cutters in hanging plastic box

Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
5,0	3/16	110,0	50,0	213 050 K	10
5,0	3/16	160,0	100,0	213 051 K	10
6,0	15/64	110,0	50,0	213 060 K	10
6,0	15/64	160,0	100,0	213 061 K	10
8,0	5/16	110,0	50,0	213 080 K	10
8,0	5/16	160,0	100,0	213 081 K	10
8,0	5/16	210,0	150,0	213 082 K	10
10,0	3/8	110,0	50,0	213 100 K	10
10,0	3/8	160,0	100,0	213 101 K	10
12,0	15/32	160,0	100,0	213 120 K	10
12,0	15/32	210,0	150,0	213 121 K	10
14,0	9/16	160,0	100,0	213 140 K	5
14,0	9/16	200,0	150,0	213 141 K	5



213 100 K





Concrete drills with carbide cutting edge and straight shank

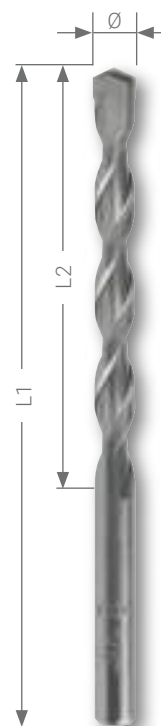
Long service life due to ideal tungsten carbide geometry with large carbide tip angle; wide Twin-max-G2 spirals; special surface hardening technique by blasting guarantees extreme breaking strength.

Fields of application: for granite, concrete, clinker, stone, brickwork, wall tiles and marble.
Application: in light hammer drills and strong impact drills with chuck adaptor.

Packing unit:

Art.- No. 221... in plastic bags of 1

Art.- No. 221... K in plastic box



Ø mm	Ø inch	L1 mm	L2 mm	Article no.		Article no.	
3,0	1/8	70,0	40,0	221 030	1	-	-
4,0	5/32	75,0	40,0	221 040	1	221 040 K	10
5,0	3/16	85,0	50,0	221 050	1	221 050 K	10
5,0	3/16	150,0	90,0	221 051	1	-	-
6,0	15/64	100,0	60,0	221 060	1	221 060 K	10
6,0	15/64	150,0	90,0	221 061	1	-	-
6,5	1/4	100,0	60,0	221 065	1	-	-
6,5	1/4	150,0	90,0	221 066	1	-	-
7,0	9/32	100,0	60,0	221 070	1	-	-
8,0	5/16	120,0	80,0	221 080	1	221 080 K	10
10,0	3/8	120,0	80,0	221 100	1	221 100 K	10
12,0	15/32	150,0	90,0	221 120	1	221 120 K	5
12,0	15/32	250,0	200,0	221 121	1	-	-
13,0	1/2	150,0	90,0	221 130	1	-	-
14,0	9/16	150,0	90,0	221 140	1	221 140 K	5
14,0	9/16	250,0	200,0	221 141	1	-	-
16,0	5/8	160,0	100,0	221 160	1	-	-
18,0	11/16	160,0	100,0	221 180	1	-	-

Concrete drill sets with carbide cutting edge and straight shank

	Article no.
7-piece set of concrete drills with carbide cutting edge and straight shank in steel case Ø 4,0 x 75,0 mm - 5,0 x 85,0 mm - 6,0 x 100,0 mm - 6,0 x 100,0 mm Ø 8,0 x 120,0 mm - 10,0 x 120,0 mm - 12,0 x 150,0 mm	205 255
7-piece set of concrete drills with carbide cutting edge and straight shank in plastic case Ø 4,0 x 75,0 mm - 5,0 x 85,0 mm - 6,0 x 100,0 mm - 6,0 x 100,0 mm Ø 8,0 x 120,0 mm - 10,0 x 120,0 mm - 12,0 x 150,0 mm	205 255 RO

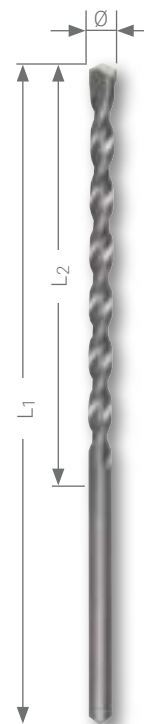




Percussion drills with carbide cutting edge and straight shank

Percussion drill made from premium coated special steel with high tenacity.
Very good drilling properties even in high stress applications.
Special tungsten carbide tips for multiple hard material drilling.

Applications: rotary drilling in concrete, clinker, stone and general masonry.
Suitable for impact drilling machines with 3 jaw chuck.



Packing unit:

Art.- No. 209... in plastic bags of 1

Art.- No. 209... K in plastic box

Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
3,0	1/8	70,0	40,0	209 030	1
4,0	5/32	75,0	40,0	209 040	1
5,0	3/16	85,0	50,0	209 050	1
5,0	3/16	150,0	90,0	210 050	1
6,0	15/64	100,0	60,0	209 060	1
6,0	15/64	150,0	90,0	210 060	1
6,5	1/4	100,0	60,0	209 065	1
6,5	1/4	150,0	90,0	210 065	1
7,0	9/32	100,0	60,0	209 070	1
8,0	5/16	120,0	80,0	209 080	1
8,0	5/16	200,0	150,0	210 080	1
10,0	3/8	150,0	80,0	209 100	1
10,0	3/8	200,0	150,0	210 100	1
12,0	15/32	150,0	90,0	209 120	1
12,0	15/32	200,0	150,0	210 120	1
13,0	1/2	150,0	90,0	209 130	1
14,0	9/16	150,0	90,0	209 140	1
15,0	19/32	160,0	100,0	209 150	1
16,0	5/8	160,0	100,0	209 160	1
18,0	11/16	160,0	100,0	209 180	1
20,0	25/32	160,0	100,0	209 200	1

Article no.	
-	-
209 040 K	10
209 050 K	10
-	-
209 060 K	10
-	-
-	-
-	-
-	-
209 080 K	10
-	-
209 100 K	10
-	-
209 120 K	5
-	-
-	-
209 140 K	5
-	-
-	-
-	-
-	-

Percussion drill set with carbide cutting edge and straight shank

	Article no.
7-piece set of percussion drills with carbide cutting edge and straight shank in steel case Ø 4,0 x 75,0 mm - 5,0 x 85,0 mm - 6,0 x 100,0 mm - 6,0 x 100,0 mm Ø 8,0 x 120,0 mm - 10,0 x 150,0 mm - 12,0 x 150,0 mm	205 256
7-piece set of percussion drills with carbide cutting edge and straight shank in plastic case Ø 4,0 x 75,0 mm - 5,0 x 85,0 mm - 6,0 x 100,0 mm - 6,0 x 100,0 mm Ø 8,0 x 120,0 mm - 10,0 x 150,0 mm - 12,0 x 150,0 mm	205 256 RO





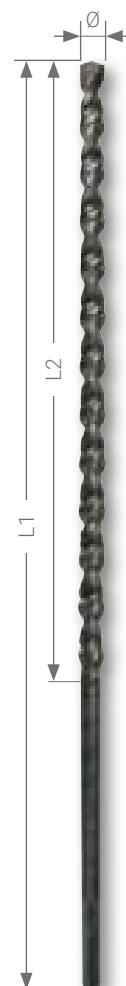
Masonry drills extra long with carbide cutting edge

Masonry drill made from premium coated special steel with high tenacity. Very good drilling properties even in high stress applications.

Well suited for deep hole drilling in various masonry materials. Special tungsten carbide tips for multiple hard material drilling.

Packing unit: in plastic bags of 1

	Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
	8,0	5/16	400,0	350,0	218 080	1
	10,0	3/8	400,0	350,0	218 100	1
	12,0	15/32	400,0	350,0	218 120	1
	14,0	9/16	400,0	350,0	218 140	1
	16,0	5/8	400,0	350,0	218 160	1
	18,0	11/16	400,0	350,0	218 180	1
	20,0	25/32	400,0	350,0	218 200	1



SDS-plus concrete hammer drills with 3 cutters

3D cutting edge profile in Y-shape for exact positioning and ideal starting; long service life and low probability of breakage, even on impact with reinforcements thanks to the highly effective technique of hardening by blasting; high drilling speed due to wide Twinmax spirals; vibration-optimised drilling performance; certified by the Prüfgemeinschaft Mauerbohrer (PGM) in accordance with the requirements of the Deutsches Institut für Bautechnik. (DIBt).

Application: in all hammer drills with SDS-plus adaptor and 2-groove adaptor such as Hilti TE 10-22.

Packaging: in plastic bags of 1 each

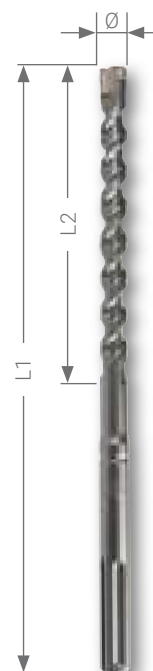
Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
16,0	5/8	250,0	200,0	224 161	1
16,0	5/8	450,0	* 400,0	224 160	1
18,0	11/16	250,0	200,0	224 180	1
18,0	11/16	450,0	* 400,0	224 181	1
20,0	25/32	250,0	200,0	224 200	1
20,0	25/32	450,0	* 400,0	224 201	1
22,0	7/8	450,0	* 400,0	224 220	1
24,0	15/16	450,0	* 400,0	224 240	1
25,0	63/64	450,0	* 400,0	224 250	1
28,0	1 1/8	450,0	* 400,0	224 280	1
30,0	1 3/16	450,0	* 400,0	224 300	1






SDS-max concrete hammer drills

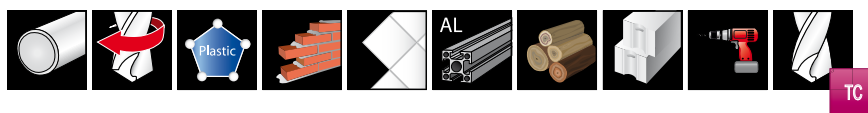
3D cutting edge profile in Y-shape for exact positioning and ideal starting; long service life and low probability of breakage, even on impact with reinforcements thanks to the highly effective technique of hardening by blasting; high drilling speed due to wide Twinmax spirals; vibration-optimised drilling performance; certified by the Prüfgemeinschaft Mauerbohrer (PGM) in accordance with the requirements of the Deutsches Institut für Bautechnik. (DIBt).



Packaging: in plastic bags of 1 each

Ø mm	Ø inch	L1 mm	L2 mm	Quantity of cutters	Article no.	
12,0	15/32	340,0	200,0	2	225 120	1
12,0	15/32	540,0	* 400,0	2	225 121	1
14,0	9/16	340,0	200,0	2	225 140	1
14,0	9/16	540,0	* 400,0	2	225 141	1
15,0	19/32	340,0	200,0	2	225 150	1
15,0	19/32	540,0	* 400,0	2	225 151	1
16,0	5/8	340,0	200,0	4	225 160	1
16,0	5/8	540,0	* 400,0	4	225 161	1
18,0	11/16	340,0	200,0	4	225 180	1
18,0	11/16	540,0	* 400,0	4	225 181	1
18,0	11/16	940,0	* 800,0	4	225 182	1
20,0	25/32	320,0	200,0	4	225 200	1
20,0	25/32	520,0	* 400,0	4	225 201	1
20,0	25/32	920,0	* 800,0	4	225 202	1
22,0	7/8	320,0	200,0	4	225 220	1
22,0	7/8	520,0	* 400,0	4	225 221	1
22,0	7/8	920,0	* 800,0	4	225 222	1
24,0	15/16	320,0	200,0	4	225 240	1
24,0	15/16	520,0	* 400,0	4	225 241	1
25,0	63/64	320,0	200,0	4	225 250	1
25,0	63/64	520,0	* 400,0	4	225 251	1
25,0	63/64	920,0	* 800,0	4	225 252	1
25,0	93/64	1320,0	* 1200,0	2	225 253	1
28,0	1 1/8	520,0	400,0	4	225 281	1
32,0	1 17/64	920,0	* 800,0	4	225 322	1
32,0	1 17/64	1320,0	* 1200,0	2	225 323	1
35,0	1 3/8	520,0	400,0	4	225 351	1
40,0	1 37/64	920,0	* 800,0	4	225 402	1
40,0	1 37/64	1320,0	* 1200,0	2	225 403	1

* Please note when using these bits it is recommended to pre-drill with a shorter hammer drill of a same diameter.

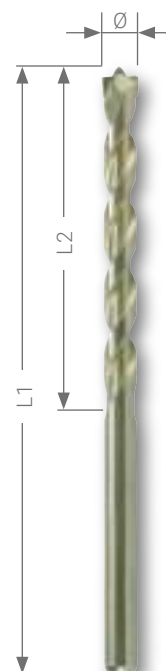


Universal drills with carbide cutting edge and straight shank

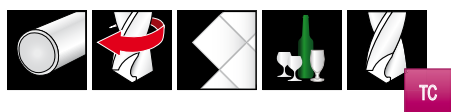
Special alloyed steel construction provides extended tool life. Special tungsten carbide tip with centre point design enables precise drilling and non-splintering on hard masonry materials.

Applications: for drilling in tiles, clinker, stone, general masonry, plastics, non-ferrous metals, soft and hardwood and lightweight construction materials. Only recommended for use in percussion drilling machines.

Packing unit: in plastic bags of 1



Ø mm	Ø inch	L1 mm	L2 mm	Article no.	
5,0	3/16	95,0	50,0	223 050	1
6,0	15/64	100,0	60,0	223 060	1
8,0	5/16	120,0	80,0	223 080	1
10,0	3/8	120,0	80,0	223 100	1
12,0	15/32	150,0	90,0	223 120	1

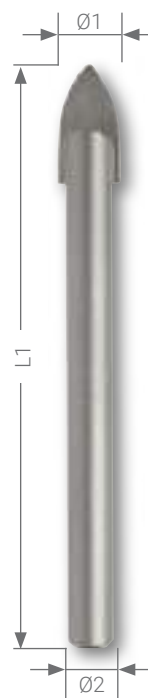


Glass and tile drills with carbide cutting edge and straight shank

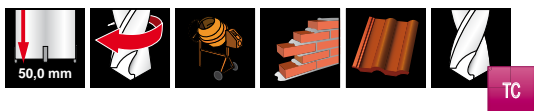
Suitable for drilling glass (windows), mirror glass, bottles, porcelain tiles, ceramics etc. For best results, use low speeds (rpm) with plenty of cooling fluid, such as water, vinegar, turpentine or kerosene.

Cutting edge: special tungsten carbide tips
Tip fitment: high performance braze to secure tips into twist drill body

Packing unit: in plastic bags of 1



Ø mm	Ø inch	L1 mm	L1 mm	Article no.	
3,0	1/8	3,0	80,0	223 003	1
4,0	5/32	3,0	90,0	223 004	1
5,0	3/16	4,0	90,0	223 005	1
6,0	15/64	5,0	100,0	223 006	1
8,0	5/16	6,0	100,0	223 008	1
10,0	3/8	6,0	100,0	223 010	1
12,0	15/32	8,0	100,0	223 012	1



Hammer percussion drill bits with carbide cutting edges

Suitable for drilling larger diameter holes in masonry materials.
Thin wall body can drill concrete, stone, general masonry including bricks.


Suits hammer drills up to 4,0 Kg with an SDS-plus adaptor.
Can also be used in impact drilling machines which can hold a hexagon shank (3 jaw chuck).

Ø 50,0 mm diameter drills require min. 600 watt machine. Larger drill diameters – up to Ø 65,0mm will require a more powerful machine with at least 800 watt.
Supplied without centre drill and arbor adaptor.


Cutting edge: special tungsten carbide tips
Tip fitment: high performance braze to secure tips into drill body
Adaptor: M16 thread



Packaging: in plastic bags of 1 each

Examples for applications	Ø mm	L1 mm	Drilling depth L2 mm	Quantity of teeth TC	Article no.	
Sanitation and heating tubes	30,0	72,0	50,0	4	226 0301	1
Sanitation and heating tubes	35,0	72,0	50,0	4	226 0351	1
Waste, water and heating tubes	40,0	72,0	50,0	4	226 0401	1
Waste, water and heating tubes	50,0	72,0	50,0	6	226 0501	1
Switch boxes	68,0	72,0	50,0	6	226 0651	1
Branch and distribution boxes	82,0	72,0	50,0	6	226 0801	1
Branch, distribution and ventilating tubes	90,0	72,0	50,0	6	226 0901	1
Ventilating tubes	100,0	72,0	50,0	6	226 1001	1

Accessoires for percussion drill bits

	Article no.	
Center drill with carbide cutting edge Ø 8,0 mm total length 120,0 mm	226 200	1
Adaptor with hexagon shank span of jaw 12,0 mm total length 95,0 mm	226 201	1
Adaptor SDS-plus total length 110,0 mm	226 203	1



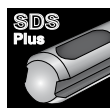
SDS-plus and SDS-max chisels

Impact resistant chisel, forged in a single piece, with high surface hardness for long life.
Special design enables maximum energy transmission for maximum cutting action to chisel edge.

Applications: for chiselling in concrete, general masonry including bricks, stone etc.
Suitable for use in all hammer drills with SDS-plus/SDS – max adaptors and 2-groove adaptor with rotating stop. Use eye protection.

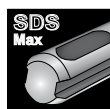
Material: high-quality special steel
Surface: heat treated to provide hardness and durability

Packaging: in plastic bags of 1 each



SDS-plus chisels

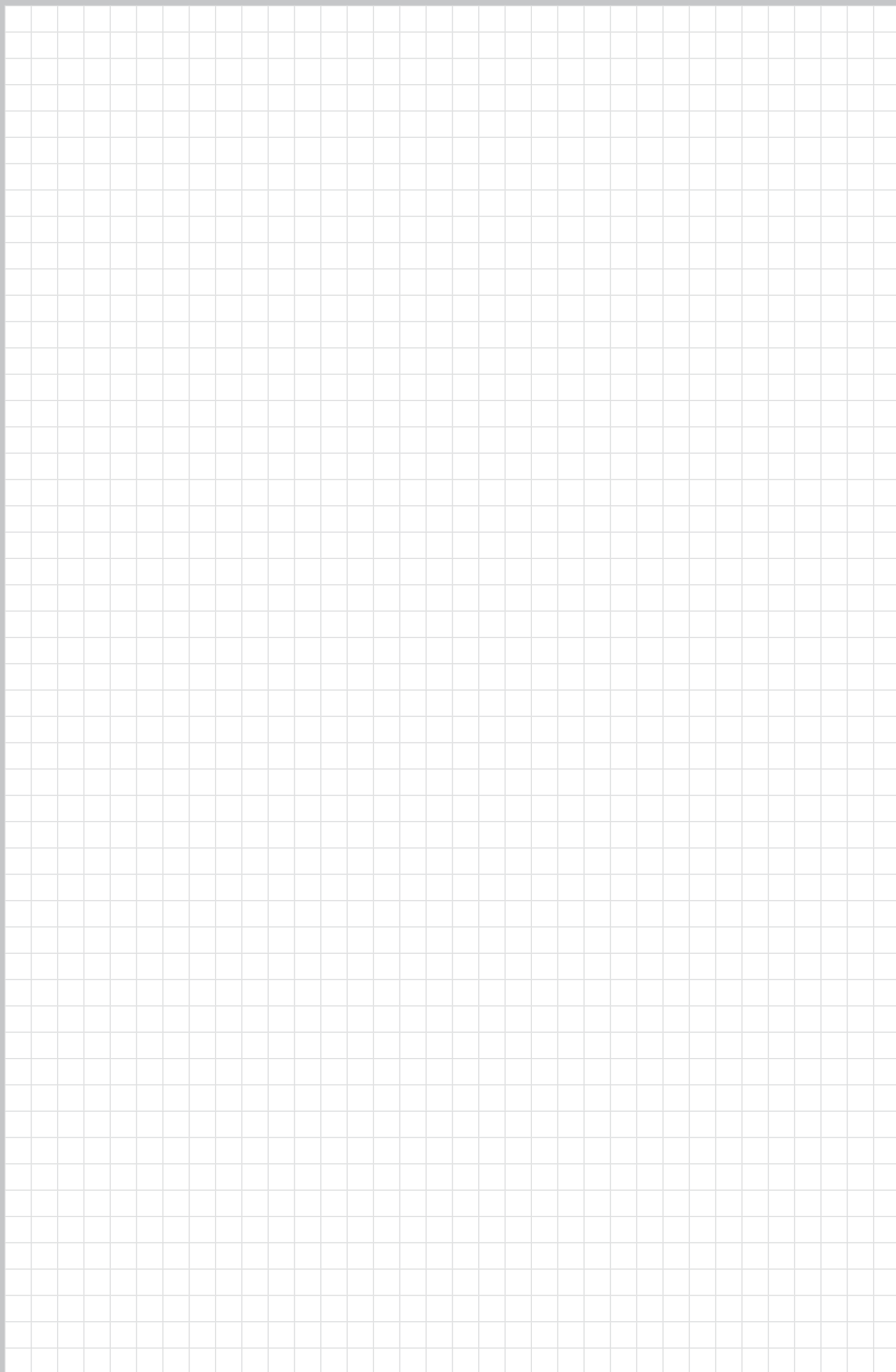
	Length L1 mm	Breath B1 mm	Shank Ø mm	Article no.	
Pointed chisel	250,0	-	10,0	227 001	1
Flat chisel	250,0	20,0	-	227 003	1
Spade chisel	250,0	40,0	-	227 004	1
Channel chisel	250,0	22,0	-	227 005	1
Comb chisel	250,0	27,0	-	227 006	1



SDS-max chisels

	Length L1 mm	Breath B1 mm	Shank Ø mm	Article no.	
Pointed chisel, round version	280,0	-	18,0	227 010	1
Pointed chisel, round version	400,0	-	18,0	227 011	1
Pointed chisel, round version	600,0	-	18,0	227 012	1
Flat chisel	280,0	25,0	-	227 013	1
Flat chisel	400,0	25,0	-	227 014	1
Flat chisel	600,0	25,0	-	227 015	1
Spade chisel	400,0	50,0	-	227 016	1
Spade chisel	300,0	75,0	-	227 017	1
Channel chisel	300,0	26,0	-	227 018	1

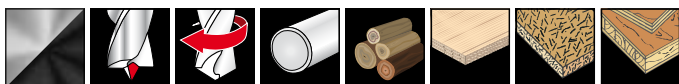






WOOD DRILLS

FASCINATION FOR PRECISION®




Wood twist drills for Machines – chrome vanadium steel

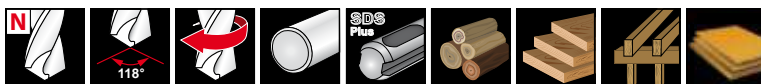
Highly efficient wood drill made of abrasion resistant chrome vanadium steel. The sharp centre point enables precise locating and drilling. Sharp cutting edges on the drills shoulders provide non-splintering drilling. Ideally suited for dowel drilling applications. Other suitable drilling applications include: softwood, hardwood, manmade wood, plywood, hardboards, veneer etc.

Point cut: centre point with 2 shoulder cutting edges

Packing unit: in plastic bags of 1

Ø mm	L1 mm	L2 mm	Article no.	
3,0	61,0	46,0	208 030	1
4,0	73,0	52,0	208 040	1
5,0	86,0	60,0	208 050	1
6,0	91,0	66,0	208 060	1
7,0	107,0	72,0	208 070	1
8,0	116,0	80,0	208 080	1
9,0	124,0	84,0	208 090	1
10,0	132,0	90,0	208 100	1
11,0	132,0	100,0	208 110	1
12,0	150,0	102,0	208 120	1
13,0	152,0	112,0	208 130	1
14,0	159,0	112,0	208 140	1
15,0	167,0	112,0	208 150	1
16,0	168,0	112,0	208 160	1
18,0	184,0	130,0	208 180	1
20,0	200,0	130,0	208 200	1
22,0	200,0	130,0	208 220	1
24,0	200,0	130,0	208 240	1
26,0	200,0	130,0	208 260	1
28,0	200,0	130,0	208 280	1
30,0	200,0	130,0	208 300	1

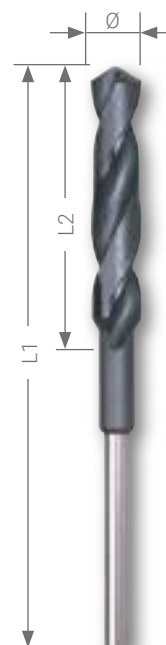




Formwork Drills – chrome vanadium steel

Formwork drills (installation drills) made of abrasion resistant chrome vanadium steel. Flute design provides optimum chip clearance and removal.

Screwed in shank design guarantees high concentric running. German Professional Organisation for woodworking recommends this drill to be suitable for all relevant drilling in construction. Ideally suited for drilling applications in: softwood, hardwood, thin manmade boards, plaster/gypsum boards, light building boards, insulation and heat insulation materials. Various length options and SDS – plus or straight shank options available.



Packing unit: in plastic bags of 1

Ø mm	L1 mm	L2 mm	Shank	Article no.	
6,0	400,0	67,0	round	208 706	1
8,0	400,0	75,0	round	208 708	1
10,0	400,0	87,0	round	208 710	1
12,0	400,0	100,0	round	208 712	1
14,0	400,0	110,0	round	208 714	1
16,0	400,0	100,0	round	208 716	1
18,0	400,0	100,0	round	208 718	1
20,0	400,0	100,0	round	208 720	1
22,0	400,0	100,0	round	208 722	1
24,0	400,0	100,0	round	208 724	1
26,0	400,0	100,0	round	208 726	1
28,0	400,0	100,0	round	208 728	1
30,0	400,0	100,0	round	208 730	1
8,0	600,0	75,0	round	208 808	1
10,0	600,0	87,0	round	208 810	1
12,0	600,0	100,0	round	208 812	1
14,0	600,0	110,0	round	208 814	1
16,0	600,0	100,0	round	208 816	1
18,0	600,0	100,0	round	208 818	1
20,0	600,0	100,0	round	208 820	1
22,0	600,0	100,0	round	208 822	1
24,0	600,0	100,0	round	208 824	1
26,0	600,0	100,0	round	208 826	1
28,0	600,0	100,0	round	208 828	1
30,0	600,0	100,0	round	208 830	1
8,0	800,0	75,0	round	208 850	1
10,0	800,0	87,0	round	208 851	1
12,0	800,0	100,0	round	208 852	1
14,0	800,0	110,0	round	208 854	1
16,0	800,0	100,0	round	208 856	1
18,0	800,0	100,0	round	208 858	1
20,0	800,0	100,0	round	208 860	1
22,0	800,0	100,0	round	208 862	1
24,0	800,0	100,0	round	208 864	1
26,0	800,0	100,0	round	208 868	1
28,0	800,0	100,0	round	208 870	1
30,0	800,0	100,0	round	208 871	1
10,0	400,0	87,0	SDS-plus	208 910	1
12,0	400,0	100,0	SDS-plus	208 912	1
14,0	400,0	110,0	SDS-plus	208 914	1
16,0	400,0	100,0	SDS-plus	208 916	1
18,0	400,0	100,0	SDS-plus	208 918	1
20,0	400,0	100,0	SDS-plus	208 920	1
22,0	400,0	100,0	SDS-plus	208 922	1
24,0	400,0	100,0	SDS-plus	208 924	1
26,0	400,0	100,0	SDS-plus	208 926	1
28,0	400,0	100,0	SDS-plus	208 928	1
30,0	400,0	100,0	SDS-plus	208 930	1




Twist Augers – chrome vanadium steel

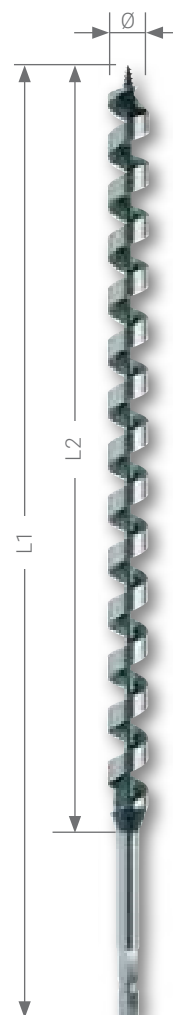
Highly efficient twist augers made of abrasion resistant chrome vanadium steel. The self lead-in screw point enables precise locating and drilling. Sharp cutting edges on the drills shoulders provide non-splintering drilling. Hardened tip and leading edge provides longevity. LEWIS-spiral design provides optimum chip clearance and removal. Ideally suited for drilling applications in: softwood, hardwood, manmade wood, plywood, hardboards, veneer etc.

Point: threaded centre point

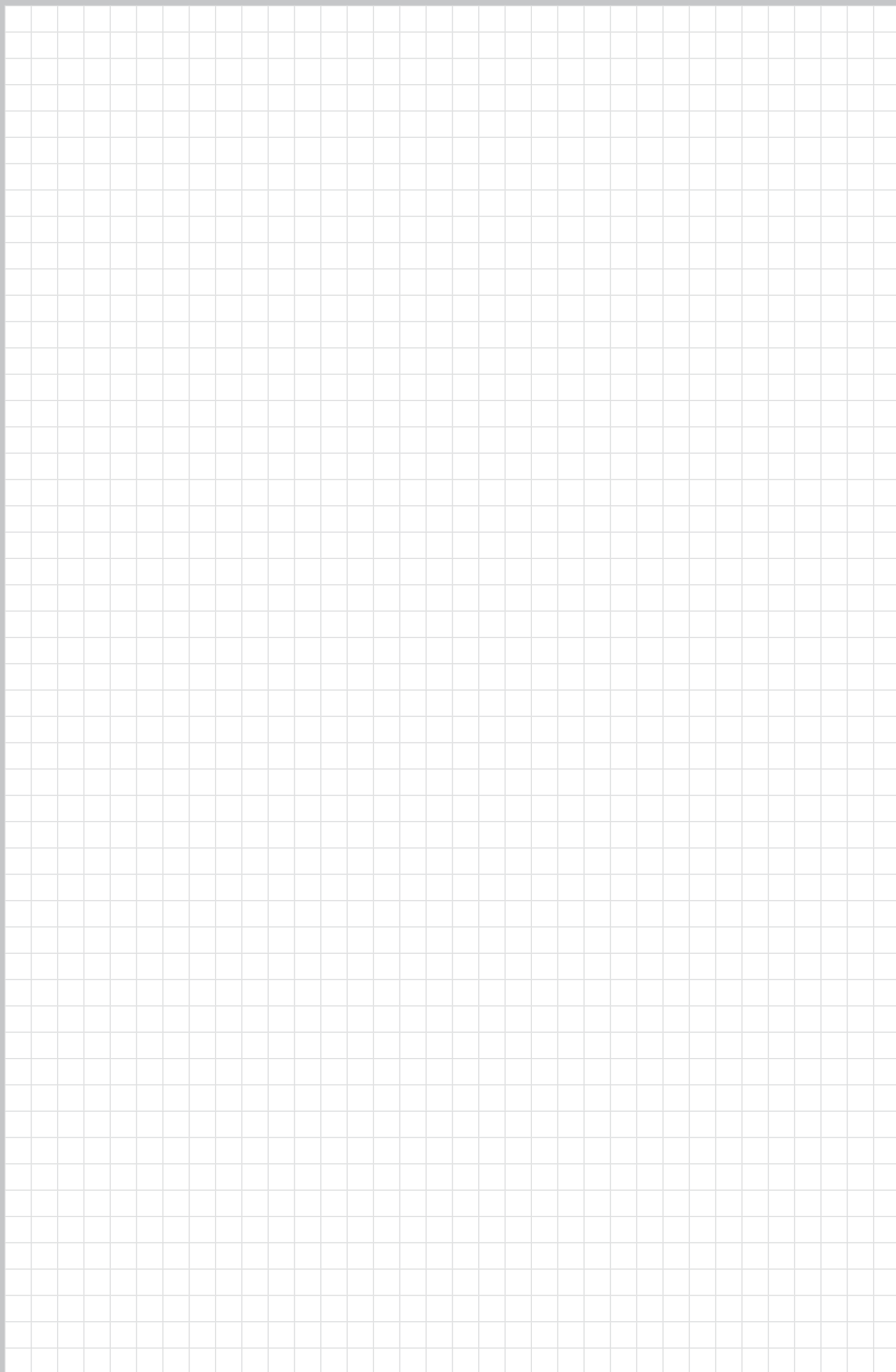
Shank: hexagon shank max. 12,0mm – suitable for use in 3 jaw chuck

Packaging: in plastic bags of 1 each

Ø mm	L1 mm	L2 mm	Article no.	
6,0	230,0	160,0	208 406	1
8,0	230,0	160,0	208 408	1
10,0	230,0	160,0	208 410	1
12,0	230,0	160,0	208 412	1
14,0	230,0	160,0	208 414	1
16,0	230,0	160,0	208 416	1
18,0	230,0	160,0	208 418	1
20,0	230,0	160,0	208 420	1
22,0	230,0	160,0	208 422	1
24,0	230,0	160,0	208 424	1
26,0	230,0	160,0	208 426	1
28,0	230,0	160,0	208 428	1
30,0	230,0	160,0	208 430	1
32,0	230,0	160,0	208 432	1
8,0	460,0	360,0	208 508	1
10,0	460,0	360,0	208 510	1
12,0	460,0	360,0	208 512	1
14,0	460,0	360,0	208 514	1
16,0	460,0	360,0	208 516	1
18,0	460,0	360,0	208 518	1
20,0	460,0	360,0	208 520	1
22,0	460,0	360,0	208 522	1
24,0	460,0	360,0	208 524	1
26,0	460,0	360,0	208 526	1
28,0	460,0	360,0	208 528	1
30,0	460,0	360,0	208 530	1
32,0	460,0	360,0	208 532	1
8,0	600,0	530,0	208 608	1
10,0	600,0	530,0	208 610	1
12,0	600,0	530,0	208 612	1
14,0	600,0	530,0	208 614	1
16,0	600,0	530,0	208 616	1
18,0	600,0	530,0	208 618	1
20,0	600,0	530,0	208 620	1
22,0	600,0	530,0	208 622	1
24,0	600,0	530,0	208 624	1
26,0	600,0	530,0	208 626	1
28,0	600,0	530,0	208 628	1
30,0	600,0	530,0	208 630	1
32,0	600,0	530,0	208 632	1

















































Overview of symbols













01. Twist drills

 HSS	High-speed steel	 HSS-G	High-speed steel, ground	 HSS-R	High-speed steel rolled
 HSSE Co 8	High-speed steel with 8 % Cobalt content, ground	 HSSE Co 5	High-speed steel with 5 % Cobalt content, ground	 TC	Tungsten carbide
	Bright		Gold / black oxidized surface	 TiAlN	TiAlN coating
	Gold surface		bright / black surface	 Tecrona	TECRONA coating
	Black surface	 TiN	TiN coating		
	Right hand cutting		left hand cutting		Drilling depth e.g. 5 x diameter
	Point angle e.g. 130°		Helix angle e.g. 40°		Centre angle e.g. 60°
	Tolerance e.g. h8		Shank: cylindrical		Shank: reduced
	Shank: 3-way clamping surface		Shank: Weldon		Shank: Morse taper
	Very suitable for all-purpose use in drilling machines and cordless drills				
















02. Special drills

 HSS	High-speed steel	 HSSE Co 5	High-speed steel with 5 % Cobalt content, ground	 TC	Tungsten carbide
	Bright surface		Bright / black surface		Black surface
	TiCN coating	 TiN	TiN coating	 AlTiN	AlTiN coating
	Right hand cutting		Shape N: Helical point normal ground		Centre point
	Point angle e.g. 180°		Helix angle e.g. 25-30°		Tolerance e.g. h8



















03. Tube and sheet drills

 High-speed steel	 High-speed steel with 5 % Cobalt content, ground	 TiN coating
 Bright surface	 Point angle: 118°	 Shape C: split point
 Right hand cutting	 Point cut: work's specification	 Cone angle: 20-30°
 Ø tolerance: work's specification	 Shank: 3-way clamping surface	 Bit shank: 6,35 mm x 27,0 mm

04. Step drills

 High-speed steel	 High-speed steel with 5 % Cobalt content, ground	 TiAlN coating
 Bright surface	 TiN coating	 RUnaTEC coating
 Shape C: split point	 Step angle, e.g. 90°	 3 cutting edges
 Right hand cutting	 Point angle: 118°	 Point cut: work's specification
 Shank: 3-way clamping surface	 Bit shank: 6,35 mm x 27,0 mm	 Ø tolerance: work's specification

05. Taper and deburring countersinkers

 High-speed steel	 Uncoated surface	 TiAlN coating
 High-speed steel with 5% Cobalt content, ground	 Black surface	 TiN coating
 Tungsten carbide	 RUnaTEC coating	 For aluminium
 Countersink angle: 90°	 Cutting edges: 3	 Helical point normal ground
 Point angle: 118°	 Cutting edges: diagonal slot	 Tolerance: h8
 Countersink angle: 180°	 Cutting edges: 1	 Right hand cutting



Shank: Morse taper



Bit shank:
6,35 mm x 27,0 mm



Shank:
cylindrical



Fast cuts



Shank:
3-way clamping surface

06. Thread-cutting tools



High-speed steel



High-speed steel
with 5% Cobalt content, ground



Left hand cutting



Right hand cutting



Blind hole



Metric,
DIN ISO 13



Metric fine,
DIN ISO 13



British Standard Whitworth thread
according to BS 84



British Standard Fine thread
according to BS 84



DIN ISO 228 "G"
(cylindrical pipe thread)



Bright surface



Black surface



Type B,
4 - 5 threads with progressive tap



Type C / 35° right-hand spiral flutes,
2 - 3 threads



Type D,
4 - 6 threads



Interrupted threads for machining
soft materials



Through hole



American UNC coarse thread
ANSI / ASME B 1.1



American UNF fine thread
ANSI / ASME B 1.1



American conical pipe thread to
ANSI B.1.20.1



DIN 2999 "Rp"
Whitworth pipe thread



DIN 40 430 steel
conduit thread



TiAlN coating



TiN coating



Thread tolerance for American
threads for internal threads



Thread tolerance for American
threads for external threads



Thread tolerance for metric and
metric fine threads according to
DIN ISO 13 for internal threads



Thread tolerance for metric and
metric fine threads according to
DIN ISO 13 for external threads



Ø tolerance:
work's specification



Machine taps
with reinforced shank



Machine taps
with overflow shank



Tenacity classes



Thread angle



Coloured ring mark



















Bit shank:
6,35 mm x 27,0 mm















Shank:
square as per DIN 10














07. Thread repair tool

 HSS	High-speed steel	 $\geq \varnothing 2,0 \text{ mm}$	Shape C: Split point	 4	Shank: square as per DIN 10
 M	Metric, DIN ISO 13		right hand cutting		Shank: cylindrical
 60°	Thread angle		Bright surface	 118°	Point angle: 118°
 N	Type N	 800 N/mm²	Tenacity classes	 25-30°	Helix angle e.g. 25-30°
	Right hand cutting	 ISO 2 6H	Thread tolerance for metric and metric fine threads according to DIN ISO 13 for internal threads	 h8	Tolerance e.g. h8
 5 x \varnothing	Drilling depth e.g. 5 x diameter				

08. Core drills

 HSS	High-speed steel		Bright surface		Weldon shank
 HSSE Co 5	High-speed steel with 5 % Cobalt content, ground	 TiAlN	TiAlN coating		Quick IN-adaptor
 TC	Tungsten carbide	 Tecrona	Tecrona coating		Threaded retainer
 30,0 mm	Drilling depth e.g. 30,0 mm		Right hand cutting		Ø tolerance: work's specification

09. Rotary burrs

 TC	Tungsten carbide		Bright surface	 CT 4	Cross toothing CT 4
	Shank: cylindrical	 TiCN	TiCN coating	 ALU	Toothing ALU
 max. min.	Speed		Average air consumption	 bar	Air pressure
	Tool adaptor		Hose size	 dB (A)	Noise level
 kg	Weight				

10. Hole saws



High-speed steel



High-speed steel
with 5 % Cobalt content, ground



Tungsten carbide



Ø tolerance:
work's specification



Right hand cutting



Bright surface



Bi-metal



Shank:
3-way clamping surface



Material thickness:
up to 2,5 mm



Cutting depth:
up to max. 10,0 mm



HSS
with varied toothing



HSSE-Co 8
with fine toothing



Cutting edges
hole saws

11. Saw program



Steel, iron



Sheet steel



Stainless steel



Aluminium



Non-ferrous metals



Wood with nails
embedded



Plastics



Fast cuts



Eternit (asbestos cement) plates



Hardwoods and
softwoods



Chipboard



Blockboard



Sandwich materials



Profiled section



Porous concrete



Special technology



Pipe



Profiled cuts



Clean cuts



Straight cuts



Plywood



Right-angled cuts



Pruning



Laminated /
coated boards

12. Deburring program



High-speed steel



Tungsten carbide



Bright surface

13. Screw-hole punches



Black surface



2 cutting edges



Metric fine,
DIN ISO 13



Material thickness:
up to 4,0 mm

15. Concrete drills



Right hand cutting



Point angle
e.g. 130°



Drilling depth:
up to 60,0 mm



Shank:
SDS-Plus



Shank:
SDS-Max



Tiles



Hardwoods and
softwoods



Shank:
cylindrical



Hexagon shank



ISO 5468



DIN 8039



Concrete



Bricks



Accumulator machines



Non-ferrous metals



Plastics



Glass



Masonry



Granite and marble



Lightweight material

16. Wood drills



Right hand cutting



Point angle: 118°



Shape N:
Helical point normal ground



Centre point



≈ DIN 7483 G



Beams



Shank:
cylindrical



Hexagon shank



Shank:
SDS-Plus



Black surface



Bright / black
surface



Form board



Plastics



Hardwoods and
softwoods



Plywood



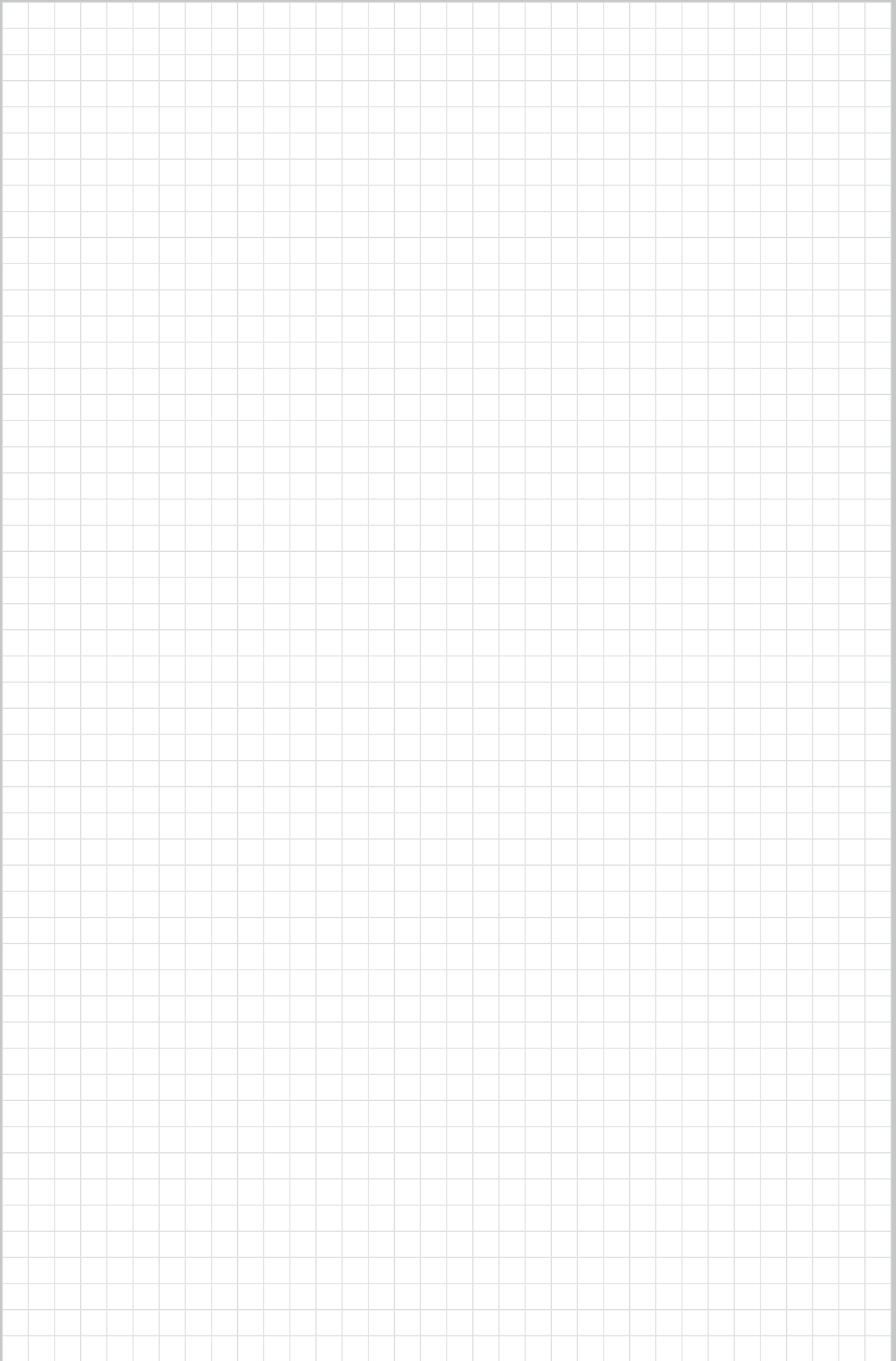
Chipboard



Wood core plywood



Insulation materials



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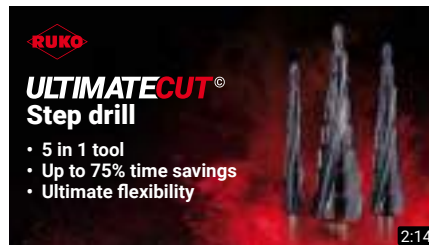
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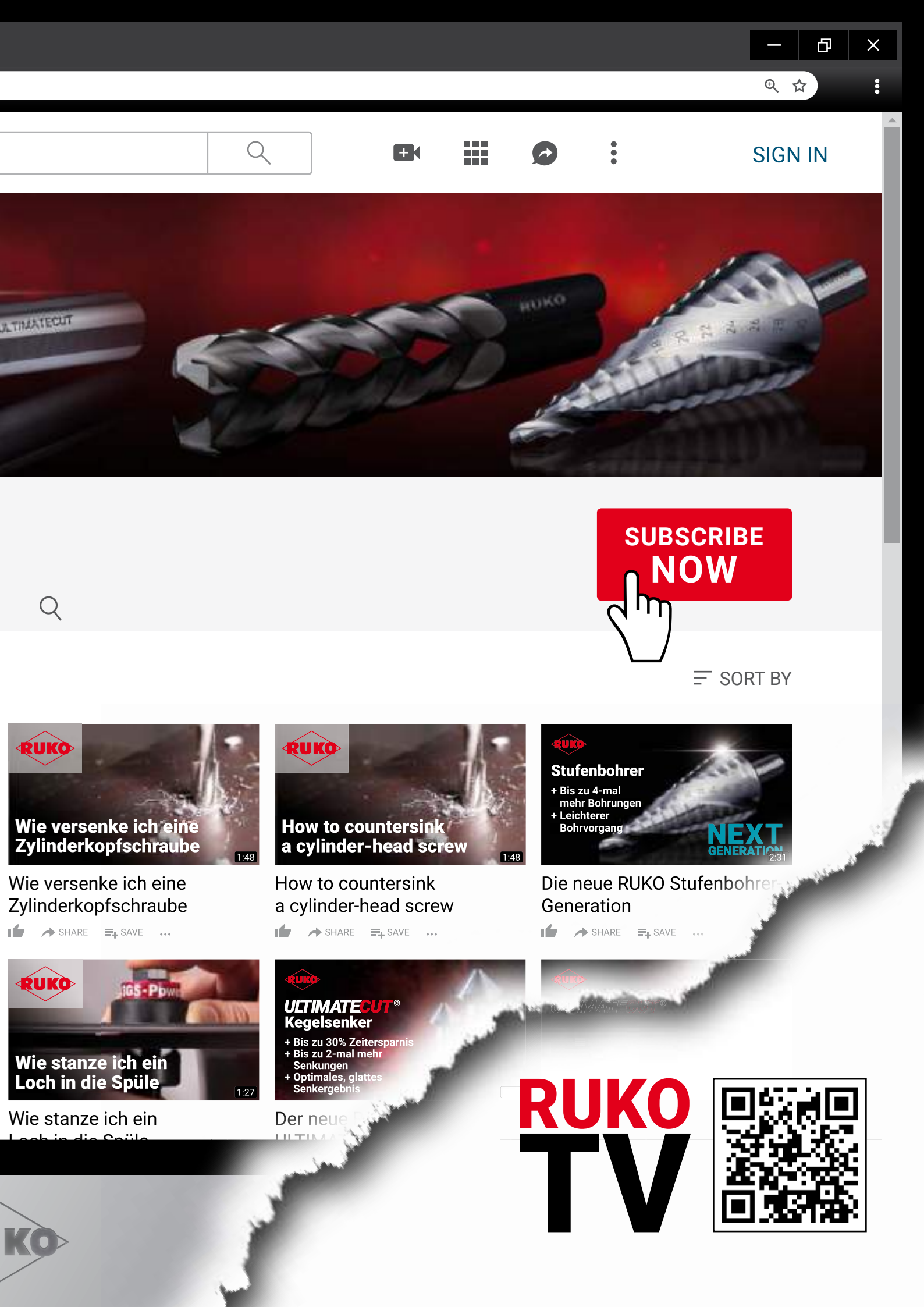


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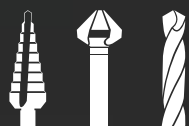


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