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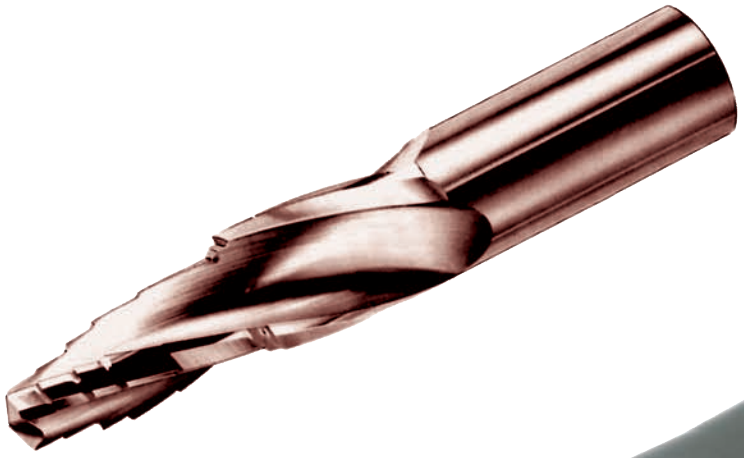
Step drill

With indexable inserts
Without indexable inserts
Step drill



Step drill

Other versions and dimensions upon request.
Design subject to change.
All prices are net in EURO + VAT (value added tax).

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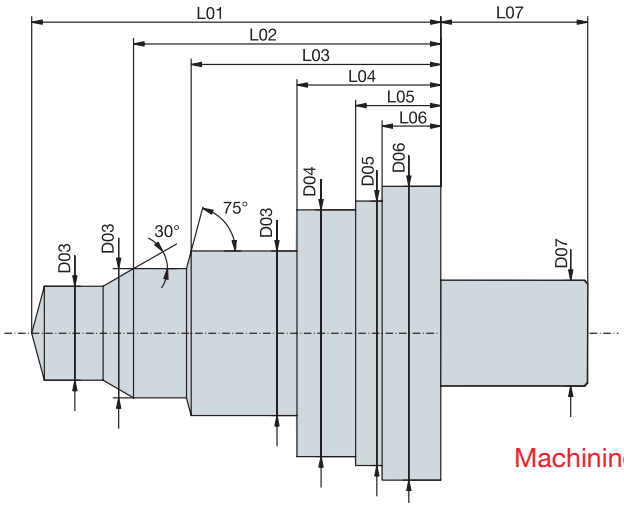
Please define the step drill in this data sheet.
We manufacture according your specifications.



Workpiece data
Workpiece drawing no.:
Workpiece material:
Allowance in mm Ø :
Cutting edge length:

Machining to be marked in red in the drawing!

Data sheet for step drills with indexable inserts

Job definition		
❑ Solid material drilling	❑ Fixed tool	❑ Vertical tool position
❑ Drilling	❑ Rotating tool	❑ Horizontal tool position
❑ Pre-drilling	❑ Counter-rotating tool	❑ Over-head machining
❑ Finish drilling	Power Capacity	❑ Other tool positions
❑ Reaming		

Werkzeugdaten	
❑ Internal coolant	Max. length before spindle
Machine adaptation	Radial indexing

Chart for the individual configuration of your step drill (see sketch)

Length (mm)	Ø (mm)	Cutting material	SWA*	STL*	DWA*	SAR*	R*	L*
L01 =	D01 =							
L02 =	D02 =							
L03 =	D03 =							
L04 =	D04 =							
L05 =	D05 =							
L06 =	D06 =							
L07 =	D07 =							

*SWA = axial cutting angle / *STL = support desired / *DWA = axial angle of twist / *SAR = radial cutting index / *R/L = right / left

If needed, please ask for more data sheets.

KNR:	PNR:	VKG:	Datum:
Handled and followed up by:			

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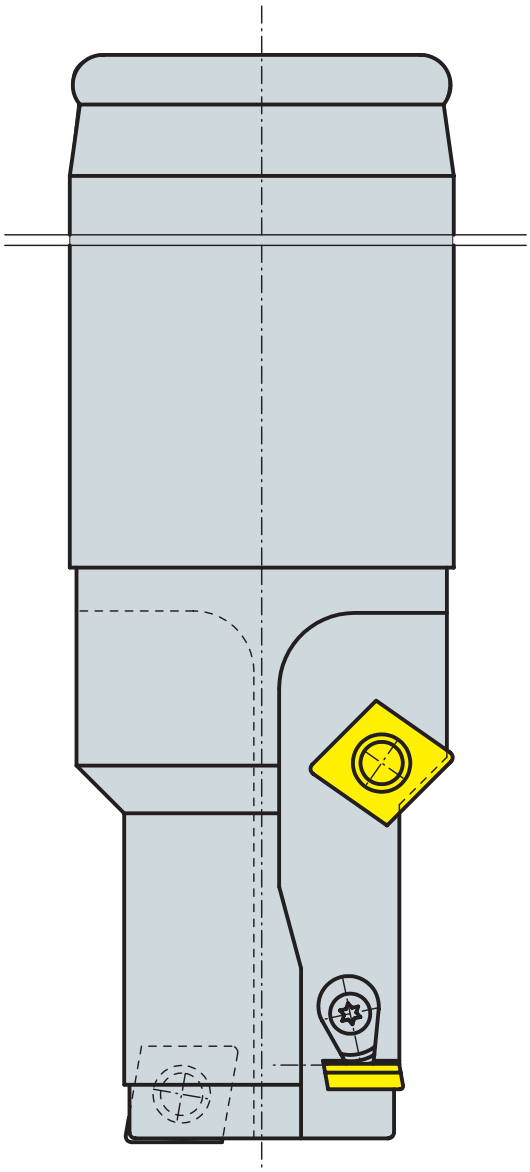
Example: step drill with indexable inserts



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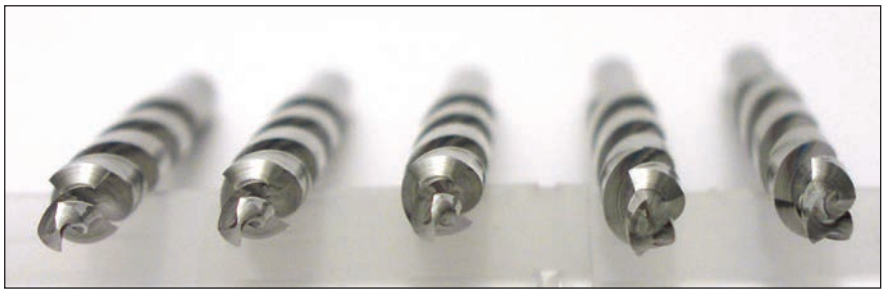
Step drill without cutting inserts, made of HSS or solid carbide.

We manufacture and supply according to customer‘s request.

Product group 06D



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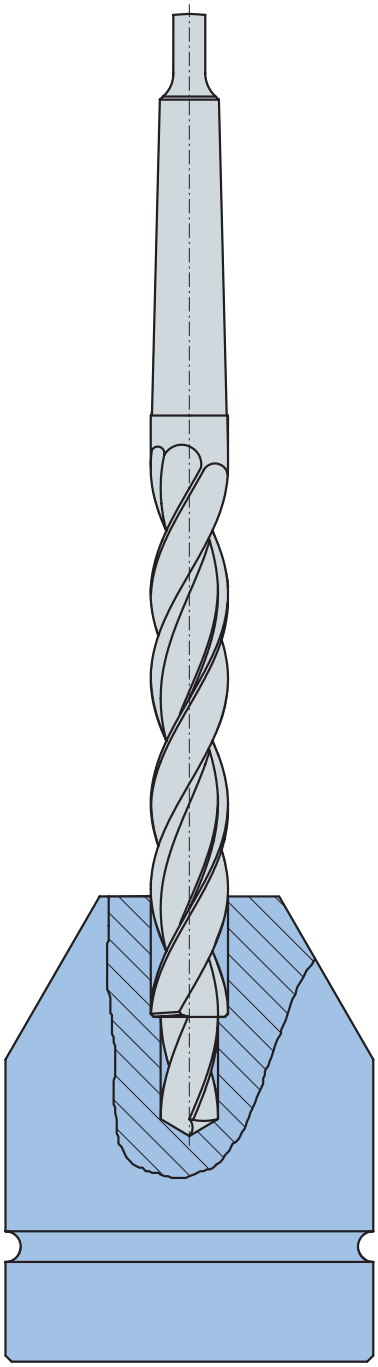
Example: step drill made of HSS or solid carbide



With 2 or 3 cutting edges,
as needed.

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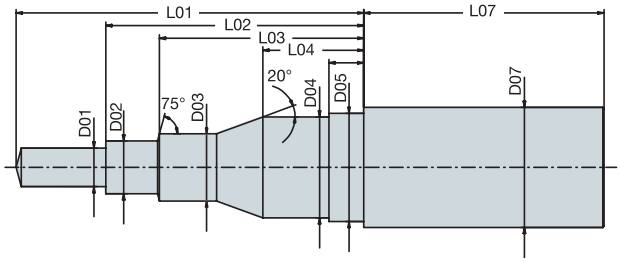
Please define the step drill in this data sheet.
We manufacture according your specifications.



Workpiece data
Workpiece drawing no.:
Workpiece material:
Allowance in mm Ø :
Cutting edge length:

Machining to be marked in red in the drawing!

Data sheet for step drills without indexable inserts

Job definition		
❑ Solid material drilling	❑ Fixed tool	❑ Vertical tool position
❑ Drilling	❑ Rotating tool	❑ Horizontal tool position
❑ Pre-drilling	❑ Counter-rotating tool	❑ Over-head machining
❑ Finish drilling	Power Capacity	❑ Other tool positions
❑ Reaming		

Tool data	
❑ Internal coolant	Max. length before spindle
Machine adaptation	Radial indexing

Chart for the individual configuration of your step drill (see sketch)

Length (mm)	Ø (mm)	Cutting material	SWA*	STL*	DWA*	SAR*	R*	L*
L01 =	D01 =							
L02 =	D02 =							
L03 =	D03 =							
L04 =	D04 =							
L05 =	D05 =							
L06 =	D06 =							
L07 =	D07 =							

*SWA = axial cutting angle / *STL = support desired / *DWA = axial angle of twist / *SAR = radial cutting index / *R/L = right / left

If needed, please ask for more data sheets.

KNR:	PNR:	VKG:	Datum:
Handled and followed up by:			

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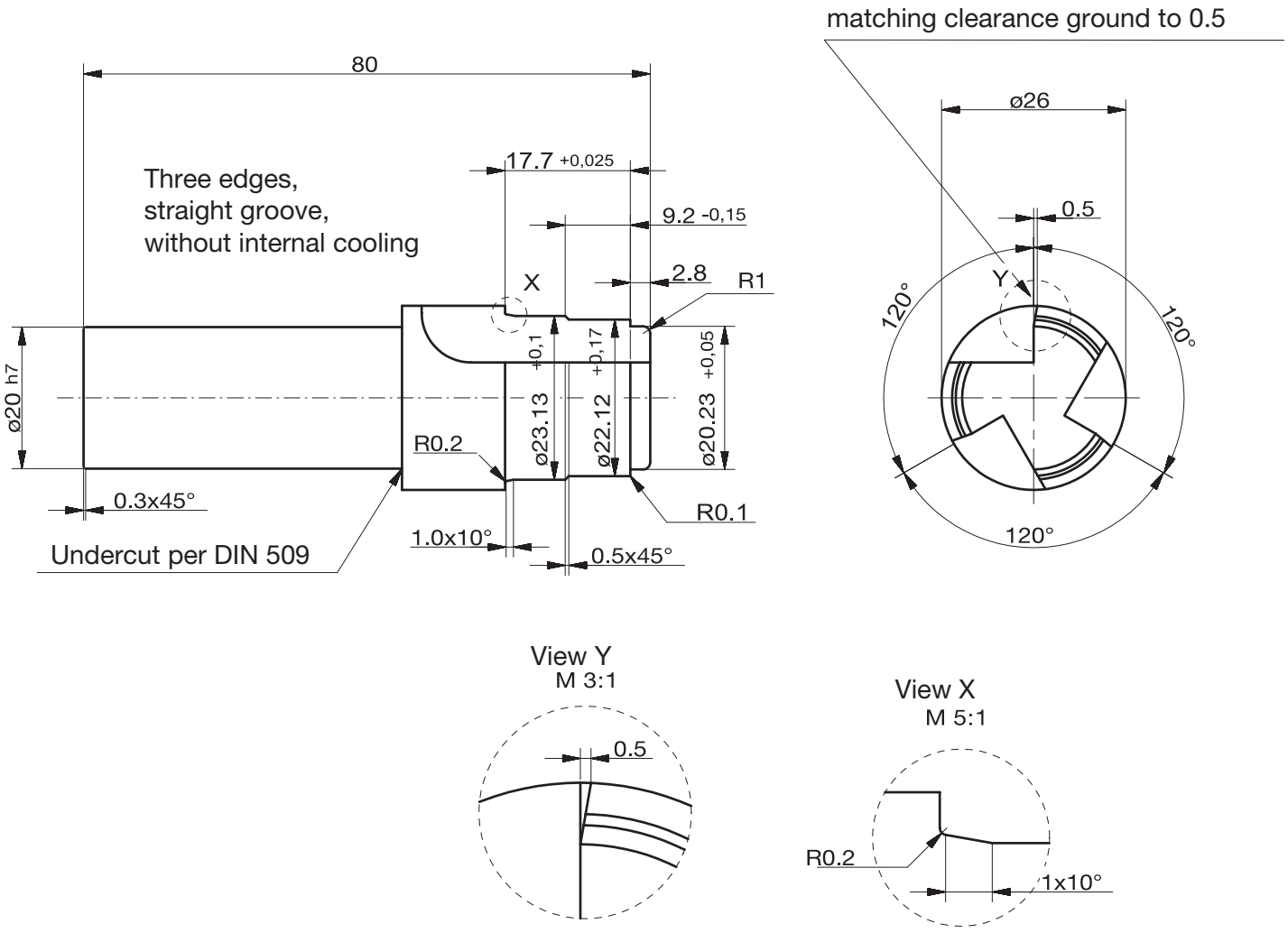
Example: solid carbide step drill



no thru holes, pilot hole ø 18