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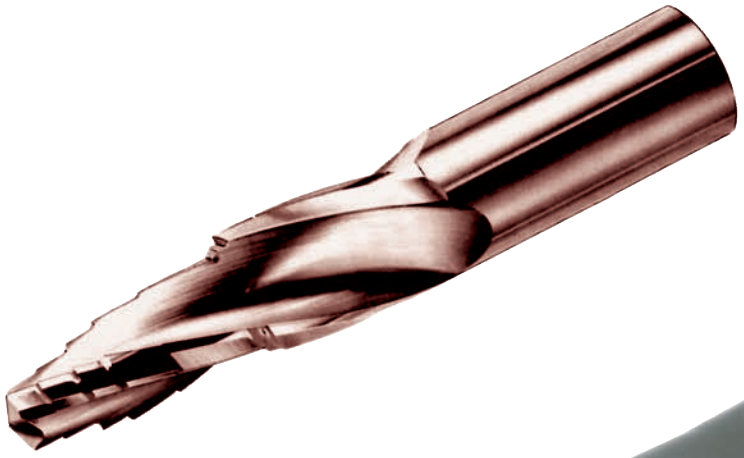
Step drill

With indexable inserts
Without indexable inserts
Step drill



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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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Data sheet for step drills with indexable inserts

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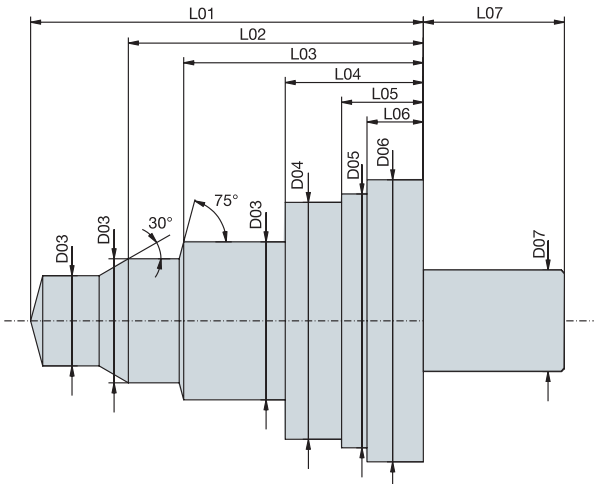
Please define the step drill in this data sheet. We manufacture according your specifications.



Workpiece data

Workpiece drawing no.: _____

Workpiece material: _____

Allowance in mm Ø : _____

Cutting edge length: _____

Machining to be marked in red in the drawing!

Job definition		Machining data		Operating position	
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	❑
Machine adaptation	
Max. length before spindle	
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:	Date:
Handled and followed up by:			

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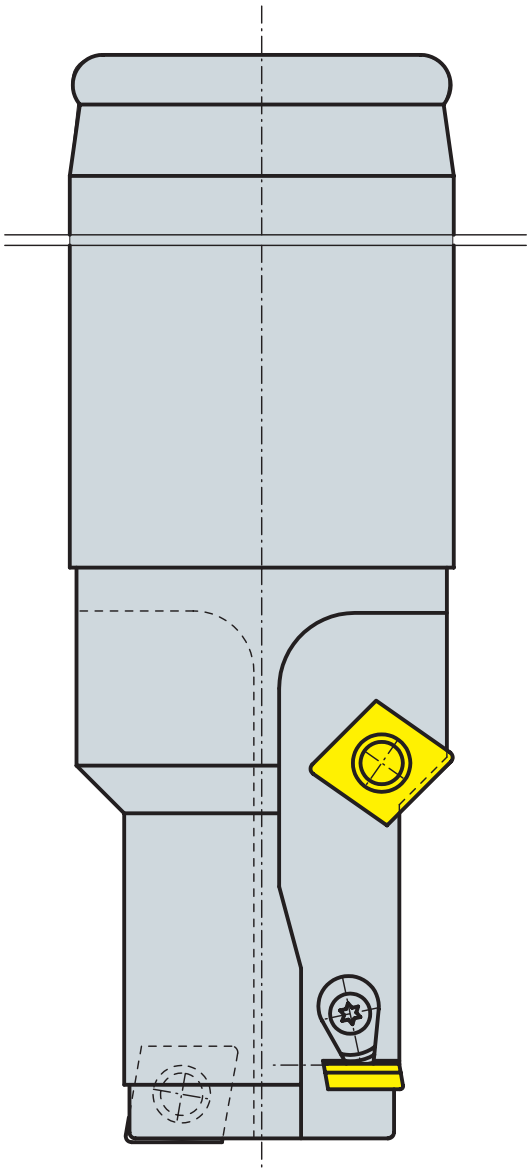
Example: step drill with indexable inserts



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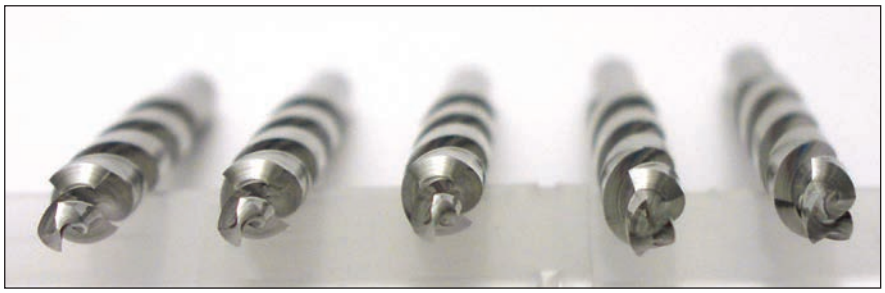
Step drill without cutting inserts, made of HSS or solid carbide.

We manufacture and supply according to customer‘s request.

Product group 06D



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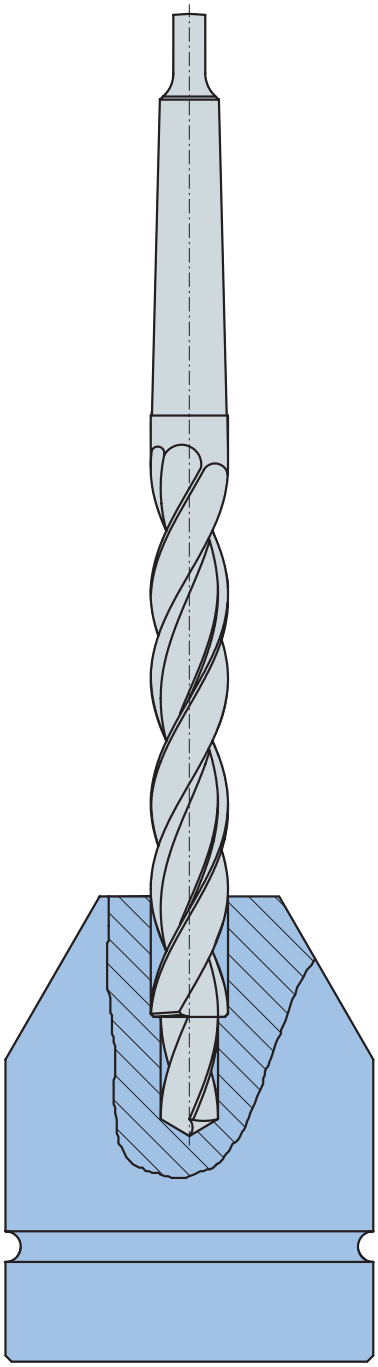
Example: step drill made of HSS or solid carbide



With 2 or 3 cutting edges,
as needed.

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**Data sheet
for step drills
without indexable inserts**

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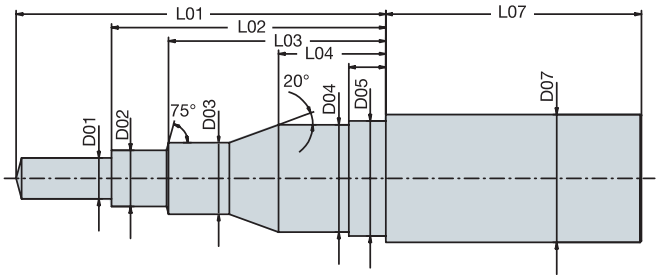
**Please define the step drill in this data sheet.
We manufacture according your specifications.**



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		Machining data		Operating position	
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	❑	
Machine adaptation		
Max. length before spindle		
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.

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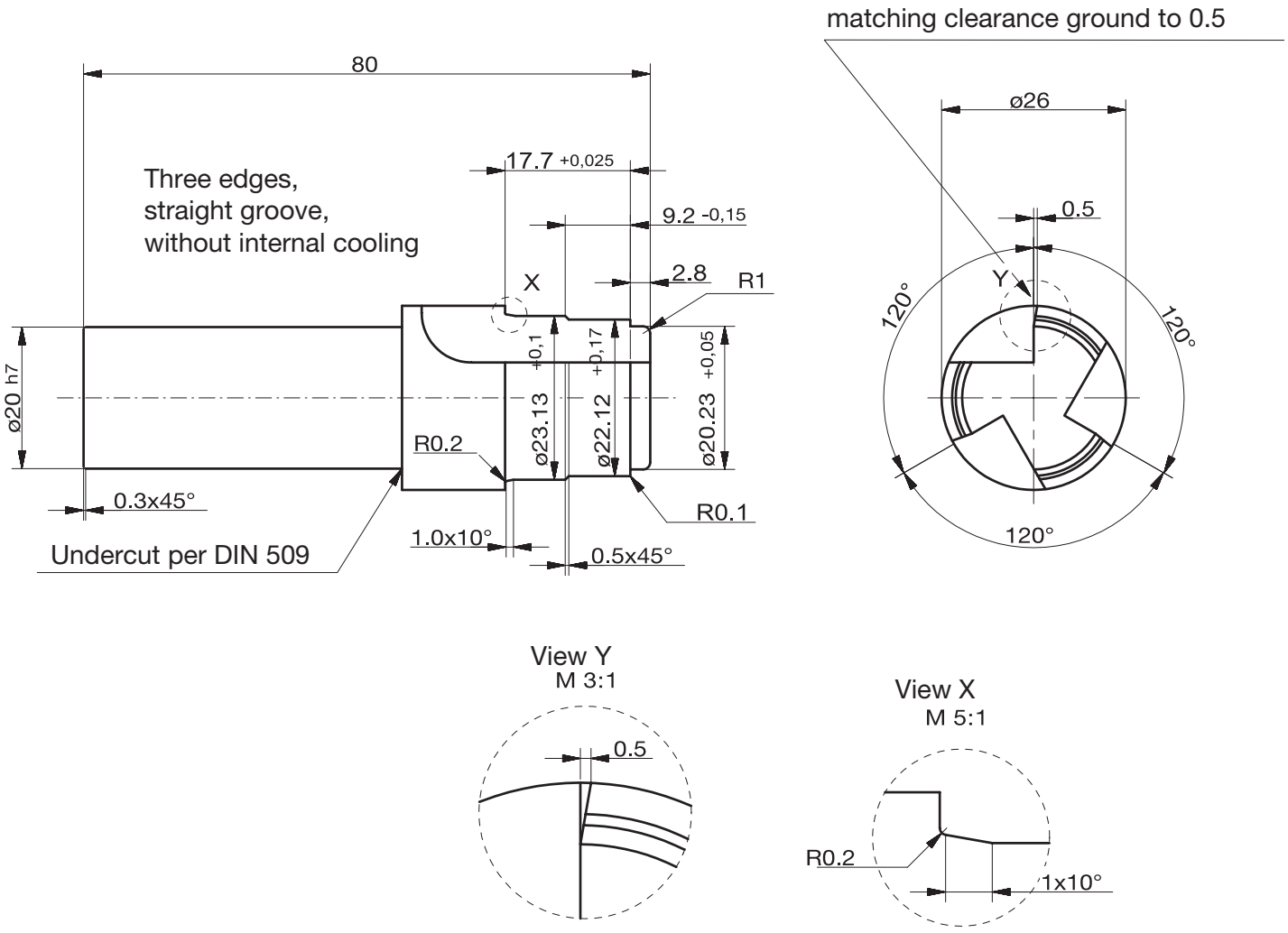
Example: solid carbide step drill



no thru holes, pilot hole ø 18