

HSS SHEET METAL CONICAL DRILL BIT



- CBN (cubical boron nitride), deep ground
- For universal use
- Stepless drilling and widening of holes within the diameter range of 3–61 mm
- With two cutting edges
- Also suitable for drilling very thin sheets
- No countersinking or pre-drilling required
- Speed table included
- Burr-free drilling without causing the sheet metal to deform. Excellent heat conductivity for longer service life thanks to axial and radial CBN relief grinding
- Mounting shank with three-phase grinding
- With laser scale for easy identification of the required drilling hole diameter

Additional articles:

Eco-drill and cutting oil Art. No. 0893 050 10

eco-cutting paste Art. No. 0893 860

Size	Drilling dia. mm	Total length in mm	Shank dia. mm	HSS	Titanium nitride	P. Qty.
				Art. no.	Art. No. HSS	
1	3 - 14	58	6	0694 024 14	0694 025 14	1
2	5 - 20	71	8	0694 024 20	0694 025 20	1
3	16 - 30.5	76	9	0694 024 30	0694 025 30	1
4	24 - 40	89	10	0694 024 40	0694 025 40	1
5	36 - 50	97	12	0694 024 50	0694 025 50	1
6	40 - 61	103	13	0694 024 61	0694 025 61	1
8	4 - 31	103	9	0694 024 31	0694 025 31	1

Titanium nitride

- CBN (cubical boron nitride), deep ground
- Cutting speed and feed increase by up to 100%
- Service life is doubled or even quadrupled



1 HSS sheet metal conical drill bit box

Art. no. 0694 024 01

Contents: One each of size 1, 2 and 3,
Dia. range 3 - 30.5 mm

2 HSS sheet metal conical drill bit box, titanium nitride

Art. no. 0694 025 01

Contents: One each of size 1, 2 and 3,
Dia. range 3 - 30.5 mm



Standard speed values for sheet metal conical drill bit

	Material	Non-ferrous metals	Stainless-steel sheets Nirosta, A2	Plastics, duroplastics, thermoplastics	Soft sheet steel, like St14 – St37
	Plate thickness	0.1 – 6 mm	0.1 – 2 mm	up to 10 mm	0.1 – 4 mm
Size	Dia. mm	n = rpm	n = rpm	n = rpm	n = rpm
1	3 - 14.0	2,000 - 1,500	600 - 400	3,000 - 2,000	800 - 500
2	4 - 20.0	1,500 - 800	400 - 200	2,000 - 1,500	600 - 300
3	16 - 30.5	1,000 - 500	200 - 100	1,500 - 1,000	400 - 200
4	24 - 40.0	500 - 300	100 - 80	1,000 - 500	300 - 150
5	36 - 50.0	300 - 200	50 - 80	500 - 200	200 - 100
6	40 - 61.0	200 - 100	50 - 25	300 - 150	100 - 50
8	4 - 31.0	1,000 - 500	200 - 100	1,500 - 1,000	400 - 200