

# Vorpa HSS CO 5% DIN 338

5% cobalt twist drill bit - above 800N/m<sup>2</sup> tensile strenght



products group



HSS CO 5%

**Suitable for**

- stainless steel A2
- stainless steel A4
- special alloys
- alloyed steel

**Drive**



**Execution**



product code and technical data

**Characteristics**

- cross-ground finish to DIN 1412 C (5% cobalt from Ø3,0mm). 135° conical section
- direct drilling without prior centering or drilling of a pilot hole
- safe pilot hole drilling, even in slanting surfaces, in pipes and/or welds
- the feeding power is reduced by up to 50%
- even chip removal and reduction of chip friction
- extremely true running and precise round holes
- the drill bit facilitates an increase in drilling progress by up to 45%
- no jamming of the main cutting edge and no slipping of the drill bit for through-holes
- high fracture strength and long life
- reduced friction due to external diameter tapering in the shank direction
- fast drilling progress through chemical thermal method of hardening and accurate cross-ground finish
- due to the alloying addition of 5% Co these drill bits are well-suited for workpieces with a tensile strength of more than 800N/mm<sup>2</sup>.
- extra high temperature strength to cope with suboptimal supply of coolant
- up to 20% higher durability than identically constructed HSS drill bits used under the same operating conditions

**Suggestion for use**

- use special drilling oils in case of extremely hard alloy and heat resistant materials
- use normal freezing mixtures for standard steel or low adhesiveness materials
- dry-drilling in case of short chips, brass and cast iron
- lift the drill bit for time to time in order that the oil can penetrate into the material
- sharpen the cutting edges regularly
- do not use drill bits with rotopercussion

**Examples of applications**



Code	Description	Usable length mm	Shank diameter mm
7100	HSS Co 5%	1x34	12
7101	HSS Co 5%	1,5x40	18
7102	HSS Co 5%	2x40	24
7103	HSS Co 5%	2,5x57	30
7104	HSS Co 5%	3x61	33
7105	HSS Co 5%	3,2x65	36
7106	HSS Co 5%	3,5x70	39
7107	HSS Co 5%	4x75	43
7108	HSS Co 5%	4,2x75	43
7109	HSS Co 5%	4,5x80	47
7110	HSS Co 5%	5x86	52
7111	HSS Co 5%	5,5x93	57
7112	HSS Co 5%	6x93	57
7113	HSS Co 5%	6,5x101	63
7114	HSS Co 5%	7x109	69
7115	HSS Co 5%	7,5x109	69
7116	HSS Co 5%	8x117	75
7117	HSS Co 5%	8,5x117	75
7118	HSS Co 5%	9x125	81
7119	HSS Co 5%	9,5x125	81
7120	HSS Co 5%	10x133	87
7121	HSS Co 5%	0,5x133	87
7122	HSS Co 5%	11x142	94
7123	HSS Co 5%	11,5x142	94
7124	HSS Co 5%	12x151	101
7125	HSS Co 5%	12,5x151	101
7126	HSS Co 5%	13x151	101