masonry and HSS drills

Vorpa **HSS CO 5% DIN 338**

5% cobal twist drill bit - above 800N/m2 tensile strenght









A2 - A4

special allovs

alloyed stee

products group



HSS CO 5%

Suitable for

- stainless steel A2
- stainless steel A4
- · special alloysi
- · alloyed steel

Drive





product code and technical data

Characteristics

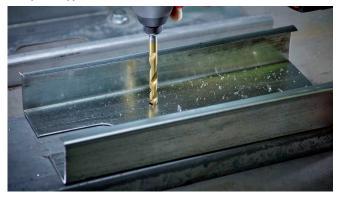
- cross-ground finish to DIN 1412 C (5% cobalt from Ø3,0mm). 135° conical section
- direct drilling without prior centering or drilling of a pilot hole
- safe pilot hole drilling, even in slanting surfaces, in pipes and/or welds
- the feeding power is reduced by up to 50%
- · even chip removal and reduction 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/mm2.
- 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

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

Examples of applications



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