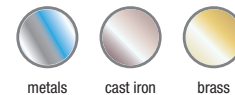


# Vorpa HSS DIN 338

Twist drill bit - up to 800N/m2 tensile strenght



metals cast iron brass

products group



HSS DIN 338

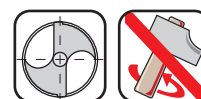
Suitable for

- metal
- cast iron
- brass

Drive



Execution



product code and technical data

Characteristics

- high performance high-speed steel drill bit suitable for metal
- high elasticity due to heat forming
- robust core thickness and distinct hardness
- special surface treatment reducing dust deposition
- reduced danger of breakage thanks to the torsional strength
- particularly suitable for professional use in metal, alloyed and unalloyed steel with a tensile strength up to 800 N/mm<sup>2</sup>, non-iron metal, cast iron and hard plastic

Suggestion for use

- in case of horizontal drilling and drilling depths 5 times bigger than diameter it is necessary to reduce the drilling speed of 20-40%
- 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	Code	Description	Usable length mm
7001	HSS 1 X 34	12	7009	HSS 5 X 86	52
7040	HSS 1,25 X 38	16	7048	HSS 5,25 X 86	52
7002	HSS 1,50 X 40	18	7010	HSS 5,50 X 93	57
7041	HSS 1,75 X 46	23	7049	HSS 5,75 X 93	57
7003	HSS 2 X 49	24	7011	HSS 6 X 93	57
7042	HSS 2,25 X 53	27	7050	HSS 6,25 X 101	63
7004	HSS 2,50 X 57	30	7012	HSS 6,50 X 101	63
7043	HSS 2,75 X 61	33	7051	HSS 6,75 X 109	69
7005	HSS 3 X 61	33	7013	HSS 7 X 109	69
7044	HSS 3,25 X 65	36	7014	HSS 7,50 X 109	69
7006	HSS 3,50 X 70	39	7015	HSS 8 X 117	75
7045	HSS 3,75 X 70	39	7016	HSS 8,50 X 117	75
7007	HSS 4 X 75	43	7017	HSS 9 X 125	81
7046	HSS 4,25 X 75	43	7018	HSS 9,50 X 125	81
7008	HSS 4,50 X 80	47	7019	HSS 10 X 133	87
7047	HSS 4,75 X 80	47	7020	HSS 10,50 X 133	87
			7021	HSS 11 X 142	94
			7022	HSS 11,50 X 142	94
			7023	HSS 12 X 151	101
			7024	HS 12,50 X 151	101
			7025	HSS 13 X 151	101

Examples of applications



Guidelines for the execution of pre-drills to thread according to thread type

M	D
3	2,4 - 2,5
4	3,2 - 3,3
5	4,0 - 4,2
6	4,8 - 5,0
8	6,4 - 6,8
10	7,9 - 8,5
12	9,6 - 10,2