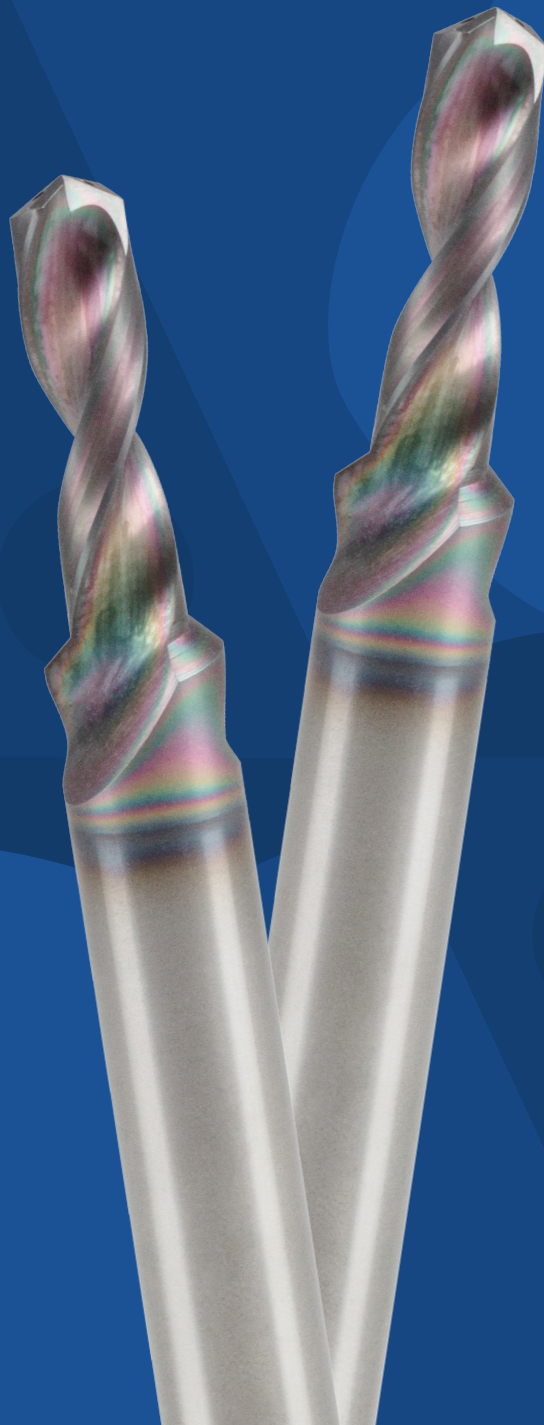




Carbide step drills with & without internal coolant supply

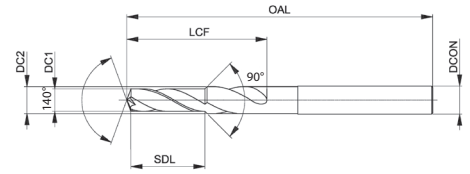
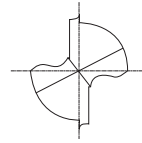
HYP-HP(O)-SC

Volume 1



HYP-HP-SC-3D

Drilling | Solid carbide | 3xD



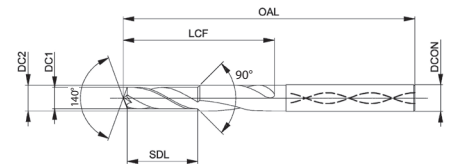
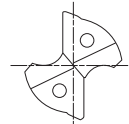
- Carbide step drill with EgiAs coating
- Up to 3xD
- General purpose
- For tap drill holes

P ○ C < 0,2%	P ● 0,25 < C < 0,4	P ● C ≥ 0,45%	P ● SCM	M ○ INOX	K ● GG	K ● GGG	H ● 25-35 HRC	H ○ 35-45 HRC
HYPRO	CARBIDE	EgiAs	30°	SHRINK FIT	140°	h8		

EDP	For threading	DC1	DC2	DCON	SDL	LCF	OAL	Price
EP0201138	M3x0,5	2,5	6	6	9	13	66	
EP0201144	M4x0,7	3,3	6	6	12	16	66	
EP0201149	M5x0,8	4,2	6	6	15	18	66	
EP0201155	M6x1	5	8	8	18	23	79	
EP0201161	M8x1,25	6,8	10	10	24	29	89	
EP0201169	M10x1,5	8,5	12	12	30	35	89	
EP0201179	M12x1,75	10,2	14	14	36	41	112	

Drilling | Solid carbide

HYP-HPO-SC-3D



- Carbide step drill with internal coolant, EgiAs coating
- Up to 3xD
- General purpose
- For tap drill holes

P ○ C < 0,2%	P ● 0,25 < C < 0,4	P ● C ≥ 0,45%	P ● SCM	M ○ INOX	K ● GG	K ● GGG	H ● 25-35 HRC	H ○ 35-45 HRC
HYPRO	CARBIDE	EgiAs	30°	SHRINK FIT	140°	h8		

EDP	For threading	DC1	DC2	DCON	SDL	LCF	OAL	Price
EP0202144	M4x0,7	3,3	6	6	12	16	66	
EP0202149	M5x0,8	4,2	6	6	15	18	66	
EP0202155	M6x1	5	8	8	18	23	79	
EP0202161	M8x1,25	6,8	10	10	24	29	89	
EP0202169	M10x1,5	8,5	12	12	30	35	89	
EP0202179	M12x1,75	10,2	14	14	36	41	112	

3xD

CUTTING CONDITIONS

Drilling | Solid | Cutting conditions

HYP-HP(O)-SC-3D

Standard drilling

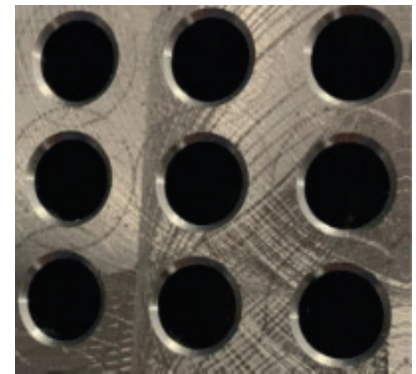
Vc	Steel			Cu	A5052 /A7075	Al < 13% Si < 130 HB
	< 700 N/mm ²	< 850 N/mm ²	< 1000 N/mm ²			
Vc	100 ~ 150 m/min	80 ~ 120 m/min	70 ~ 110 m/min	50 ~ 90 m/min	60 ~ 110 m/min	120 ~ 220 m/min
Ø	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
3	0,09~0,12	0,09~0,12	0,09~0,12	0,02~0,03	0,09~0,20	0,09~0,28
4	0,10~0,15	0,10~0,15	0,10~0,15	0,02~0,04	0,10~0,24	0,10~0,38
5	0,12~0,18	0,12~0,18	0,12~0,18	0,03~0,05	0,12~0,28	0,12~0,40
6	0,14~0,20	0,14~0,20	0,14~0,20	0,03~0,06	0,14~0,34	0,14~0,48
8	0,16~0,24	0,16~0,24	0,16~0,24	0,04~0,08	0,16~0,38	0,16~0,53
10	0,18~0,27	0,18~0,27	0,18~0,27	0,05~0,10	0,18~0,45	0,18~0,63
12	0,20~0,30	0,20~0,30	0,20~0,30	0,06~0,12	0,20~0,53	0,20~0,75
14	0,22~0,35	0,22~0,35	0,22~0,35	0,08~0,16	0,22~0,57	0,22~0,81
16	0,25~0,36	0,25~0,36	0,25~0,36	0,10~0,18	0,25~0,61	0,25~0,85
18	0,28~0,38	0,28~0,38	0,28~0,38	0,12~0,20	0,28~0,63	0,28~0,90
20	0,30~0,40	0,30~0,40	0,30~0,40	0,20~0,28	0,28~0,68	0,30~0,98

Vc	GG (G)	Stainless Steel	High-Alloy Steel	Special Alloys	Hardened Steel	
	< 180 HB	< 300 HB	< 820 HB	< 1200 N/mm ²	< 30 HRC	< 60 HRC
Vc	150 ~ 200 m/min	100 ~ 150 m/min	40 ~ 50 m/min	50 ~ 60 m/min	15 ~ 25 m/min	15 ~ 25 m/min
Ø	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
3	0,12~0,15	0,12~0,15	0,09~0,12	0,07~0,11	0,05~0,09	0,03~0,05
4	0,13~0,18	0,13~0,18	0,10~0,15	0,08~0,13	0,06~0,10	0,04~0,06
5	0,15~0,22	0,15~0,22	0,12~0,18	0,10~0,15	0,08~0,12	0,05~0,07
6	0,18~0,25	0,18~0,25	0,14~0,20	0,12~0,18	0,09~0,15	0,05~0,07
8	0,20~0,30	0,20~0,30	0,16~0,24	0,14~0,22	0,12~0,20	0,06~0,08
10	0,23~0,33	0,23~0,33	0,18~0,27	0,15~0,25	0,13~0,23	0,07~0,10
12	0,25~0,38	0,25~0,38	0,20~0,30	0,17~0,26	0,14~0,24	0,09~0,12
14	0,30~0,43	0,30~0,43	0,22~0,35	0,18~0,30	0,15~0,26	0,10~0,13
16	0,35~0,50	0,35~0,50	0,25~0,36	0,20~0,32	0,16~0,26	0,10~0,13
18	0,38~0,55	0,38~0,55	0,28~0,38	0,23~0,33	0,18~0,28	0,12~0,16
20	0,40~0,63	0,40~0,63	0,30~0,40	0,25~0,35	0,20~0,30	0,14~0,18

CUTTING DATA

HYP-HPO-SC-3D Ø6,8

Material	C45
Drilling depth	26mm
S	4.681 rev/min
Vc	100m/min
f	0,2mm/rev
Coolant	Emulsion 8% internal
Machine	Horizontal machining center





shaping your dreams

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