

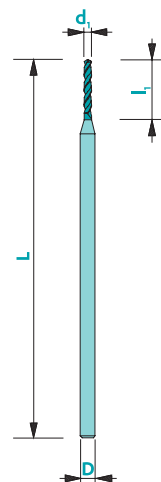
# Micro twist drill - helix 24°

339

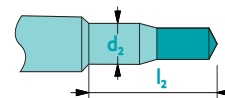
| Material                      | Vc uncoated | Vc coated | Uncoated | Coated | Rec. Coating* |
|-------------------------------|-------------|-----------|----------|--------|---------------|
| Steel < 700 N/mm <sup>2</sup> | 70          | 80        | □        | ■      | Tisi (BQ)     |
| Steel > 700 N/mm <sup>2</sup> | 60          | 70        | □        | ■      | Tisi (BQ)     |
| Stainless steel               | 20          | 40        | □        | □      | Tisi (BQ)     |
| Cast iron                     | 60          | 70        | □        | ■      | Tisi (BQ)     |
| Copper                        | 100         | 130       | □        | □      | Solo (DA)     |
| Brass - Bronze                | 80          | 120       | ■        | ■      | Solo (DA)     |
| Aluminium                     | 100         | 120       | □        | ■      | Solo (DA)     |
| Gold - Silver                 | 80          | 100       | ■        | ■      | Solo (DA)     |
| Platinum - Palladium          | -           | 20        | -        | □      | Solo (DA)     |
| Superalloys                   | -           | 25        | -        | ■      | Trio (PO)     |
| Titanium                      | 40          | 60        | □        | □      | Rico (ZB)     |

not adapted - adapted □ highly adapted ■

Tolerances  $d_1$ : -0.002/-0.004  
D: h5



Upon request



| Art. n°  | $d_1$ | $l_1$ | D | L  | Uncoat. | Solo* | Art. n°  | $d_1$ | $l_1$ | D | L  | Uncoat. | Solo* |
|----------|-------|-------|---|----|---------|-------|----------|-------|-------|---|----|---------|-------|
| 339d0.05 | 0.05  | 0.35  | 1 | 30 | ▲       | ▲     | 339d0.34 | 0.34  | 1.50  | 1 | 30 | ▲       | ▲     |
| 339d0.06 | 0.06  | 0.40  | 1 | 30 | ▲       | ▲     | 339d0.35 | 0.35  | 1.50  | 1 | 30 | ▲       | ▲     |
| 339d0.07 | 0.07  | 0.50  | 1 | 30 | ▲       | ▲     | 339d0.36 | 0.36  | 1.50  | 1 | 30 | ▲       | ▲     |
| 339d0.08 | 0.08  | 0.60  | 1 | 30 | ▲       | ▲     | 339d0.37 | 0.37  | 1.50  | 1 | 30 | ▲       | ▲     |
| 339d0.09 | 0.09  | 0.65  | 1 | 30 | ▲       | ▲     | 339d0.38 | 0.38  | 1.50  | 1 | 30 | ▲       | ▲     |
| 339d0.10 | 0.10  | 0.70  | 1 | 30 | ▲       | ▲     | 339d0.39 | 0.39  | 1.50  | 1 | 30 | ▲       | ▲     |
| 339d0.11 | 0.11  | 0.70  | 1 | 30 | ▲       | ▲     | 339d0.40 | 0.40  | 2.00  | 1 | 30 | ▲       | ▲     |
| 339d0.12 | 0.12  | 0.70  | 1 | 30 | ▲       | ▲     | 339d0.41 | 0.41  | 2.00  | 1 | 30 | ▲       | ▲     |
| 339d0.13 | 0.13  | 0.70  | 1 | 30 | ▲       | ▲     | 339d0.42 | 0.42  | 2.00  | 1 | 30 | ▲       | ▲     |
| 339d0.14 | 0.14  | 0.70  | 1 | 30 | ▲       | ▲     | 339d0.43 | 0.43  | 2.00  | 1 | 30 | ▲       | ▲     |
| 339d0.15 | 0.15  | 1.00  | 1 | 30 | ▲       | ▲     | 339d0.44 | 0.44  | 2.00  | 1 | 30 | ▲       | ▲     |
| 339d0.16 | 0.16  | 1.00  | 1 | 30 | ▲       | ▲     | 339d0.45 | 0.45  | 3.50  | 1 | 30 | ▲       | ▲     |
| 339d0.17 | 0.17  | 1.00  | 1 | 30 | ▲       | ▲     | 339d0.46 | 0.46  | 3.50  | 1 | 30 | ▲       | ▲     |
| 339d0.18 | 0.18  | 1.00  | 1 | 30 | ▲       | ▲     | 339d0.47 | 0.47  | 3.50  | 1 | 30 | ▲       | ▲     |
| 339d0.19 | 0.19  | 1.00  | 1 | 30 | ▲       | ▲     | 339d0.48 | 0.48  | 3.50  | 1 | 30 | ▲       | ▲     |
| 339d0.20 | 0.20  | 1.00  | 1 | 30 | ▲       | ▲     | 339d0.49 | 0.49  | 4.00  | 1 | 30 | ▲       | ▲     |
| 339d0.21 | 0.21  | 1.00  | 1 | 30 | ▲       | ▲     | 339d0.50 | 0.50  | 4.00  | 1 | 30 | ▲       | ▲     |
| 339d0.22 | 0.22  | 1.00  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.23 | 0.23  | 1.00  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.24 | 0.24  | 1.00  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.25 | 0.25  | 1.00  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.26 | 0.26  | 1.00  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.27 | 0.27  | 1.00  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.28 | 0.28  | 1.00  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.29 | 0.29  | 1.00  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.30 | 0.30  | 1.50  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.31 | 0.31  | 1.50  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.32 | 0.32  | 1.50  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |
| 339d0.33 | 0.33  | 1.50  | 1 | 30 | ▲       | ▲     |          |       |       |   |    |         |       |

Available uncoated or coated (see page 308)



118°

Z2



λ  
24°

CARB

\* Prices for other coatings: contact us!

To order a coated tool, add the 2-letter coating code to the article number