

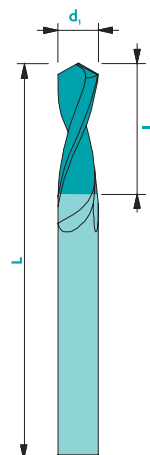
Twist drill - helix 24°

348

Material	Vc uncoated	Vc coated	Uncoated	Coated	Rec. Coating*
Steel < 700 N/mm ²	70	80	□	■	Tisi (BQ)
Steel > 700 N/mm ²	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 d₁; h5



Art. n°	d ₁	l ₁	L	Uncoat.	Solo*
348d0.30	0.30	5.0	30	▲	▲
348d0.35	0.35	5.0	30	▲	▲
348d0.40	0.40	6.0	30	▲	▲
348d0.45	0.45	6.0	30	▲	▲
348d0.50	0.50	6.0	30	▲	▲
348d0.55	0.55	6.0	30	▲	▲
348d0.60	0.60	6.0	30	▲	▲
348d0.65	0.65	6.0	30	▲	▲
348d0.70	0.70	6.0	30	▲	▲
348d0.75	0.75	6.0	30	▲	▲
348d0.80	0.80	7.0	30	▲	▲
348d0.85	0.85	7.0	30	▲	▲
348d0.90	0.90	7.0	30	▲	▲
348d0.95	0.95	7.0	30	▲	▲
348d1.00	1.00	7.0	30	▲	▲
348d1.05	1.05	8.0	30	▲	▲
348d1.10	1.10	8.0	30	▲	▲
348d1.15	1.15	8.0	30	▲	▲
348d1.20	1.20	8.0	30	▲	▲
348d1.25	1.25	8.0	30	▲	▲
348d1.30	1.30	8.0	30	▲	▲
348d1.35	1.35	8.0	30	▲	▲
348d1.40	1.40	8.0	30	▲	▲
348d1.45	1.45	8.0	30	▲	▲
348d1.50	1.50	8.0	30	▲	▲
348d1.55	1.55	9.0	38	▲	▲
348d1.60	1.60	9.0	38	▲	▲
348d1.65	1.65	9.0	38	▲	▲
348d1.70	1.70	9.0	38	▲	▲
348d1.75	1.75	9.0	38	▲	▲

Art. n°	d ₁	l ₁	L	Uncoat.	Solo*
348d1.80	1.80	9.0	38	▲	▲
348d1.85	1.85	9.0	38	▲	▲
348d1.90	1.90	9.0	38	▲	▲
348d1.95	1.95	9.0	38	▲	▲
348d2.00	2.00	9.0	38	▲	▲
348d2.05	2.05	9.0	38	▲	▲
348d2.10	2.10	9.0	38	▲	▲
348d2.15	2.15	10.0	40	▲	▲
348d2.20	2.20	10.0	40	▲	▲
348d2.25	2.25	10.0	40	▲	▲
348d2.30	2.30	10.0	40	▲	▲
348d2.35	2.35	10.0	40	▲	▲
348d2.40	2.40	11.0	43	▲	▲
348d2.45	2.45	11.0	43	▲	▲
348d2.50	2.50	11.0	43	▲	▲
348d2.55	2.55	11.0	43	▲	▲
348d2.60	2.60	11.0	43	▲	▲
348d2.65	2.65	11.0	43	▲	▲
348d2.70	2.70	12.0	46	▲	▲
348d2.75	2.75	12.0	46	▲	▲
348d2.80	2.80	12.0	46	▲	▲
348d2.85	2.85	12.0	46	▲	▲
348d2.90	2.90	12.0	46	▲	▲
348d2.95	2.95	12.0	46	▲	▲
348d3.00	3.00	12.0	46	▲	▲
348d3.05	3.05	14.0	49	▲	▲
348d3.10	3.10	14.0	49	▲	▲
348d3.15	3.15	14.0	49	▲	▲
348d3.20	3.20	14.0	49	▲	▲
348d3.25	3.25	14.0	49	▲	▲

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

Twist drill - helix 24°



Available
uncoated or coated
(see page 308)



118°

Z2

λ
24°

CARB

Art. n°	d ₁	l ₁	L	Uncoat.	Solo*
348d3.30	3.30	14.0	49	▲	▲
348d3.35	3.35	14.0	49	▲	▲
348d3.40	3.40	15.0	52	▲	▲
348d3.45	3.45	15.0	52	▲	▲
348d3.50	3.50	15.0	52	▲	▲
348d3.55	3.55	15.0	52	▲	▲
348d3.60	3.60	15.0	52	▲	▲
348d3.65	3.65	15.0	52	▲	▲
348d3.70	3.70	15.0	52	▲	▲
348d3.75	3.75	15.0	52	▲	▲
348d3.80	3.80	17.0	55	▲	▲
348d3.85	3.85	17.0	55	▲	▲
348d3.90	3.90	17.0	55	▲	▲
348d3.95	3.95	17.0	55	▲	▲
348d4.00	4.00	17.0	55	▲	▲
348d4.05	4.05	17.0	55	▲	▲
348d4.10	4.10	17.0	55	▲	▲
348d4.15	4.15	17.0	55	▲	▲
348d4.20	4.20	17.0	55	▲	▲
348d4.25	4.25	17.0	55	▲	▲
348d4.30	4.30	18.0	58	▲	▲
348d4.35	4.35	18.0	58	▲	▲
348d4.40	4.40	18.0	58	▲	▲
348d4.45	4.45	18.0	58	▲	▲
348d4.50	4.50	18.0	58	▲	▲
348d4.55	4.55	18.0	58	▲	▲
348d4.60	4.60	18.0	58	▲	▲
348d4.65	4.65	18.0	58	▲	▲
348d4.70	4.70	18.0	58	▲	▲
348d4.75	4.75	18.0	58	▲	▲
348d4.80	4.80	20.0	62	▲	▲
348d4.85	4.85	20.0	62	▲	▲
348d4.90	4.90	20.0	62	▲	▲
348d4.95	4.95	20.0	62	▲	▲
348d5.00	5.00	20.0	62	▲	▲
348d5.10	5.10	20.0	62	▲	▲
348d5.20	5.20	20.0	62	▲	▲
348d5.30	5.30	20.0	62	▲	▲
348d5.40	5.40	21.0	66	▲	▲
348d5.50	5.50	21.0	66	▲	▲
348d5.60	5.60	21.0	66	▲	▲
348d5.70	5.70	21.0	66	▲	▲
348d5.80	5.80	21.0	66	▲	▲
348d5.90	5.90	21.0	66	▲	▲
348d6.00	6.00	21.0	66	▲	▲

Art. n°	d ₁	l ₁	L	Uncoat.	Solo*
348d6.10	6.10	23.0	70	▲	▲
348d6.20	6.20	23.0	70	▲	▲
348d6.30	6.30	23.0	70	▲	▲
348d6.40	6.40	23.0	70	▲	▲
348d6.50	6.50	23.0	70	▲	▲
348d6.60	6.60	23.0	70	▲	▲
348d6.70	6.70	23.0	70	▲	▲
348d6.80	6.80	25.0	74	▲	▲
348d6.90	6.90	25.0	74	▲	▲
348d7.00	7.00	25.0	74	▲	▲
348d7.10	7.10	25.0	74	▲	▲
348d7.20	7.20	25.0	74	▲	▲
348d7.30	7.30	25.0	74	▲	▲
348d7.40	7.40	25.0	74	▲	▲
348d7.50	7.50	25.0	74	▲	▲
348d7.60	7.60	27.0	79	▲	▲
348d7.70	7.70	27.0	79	▲	▲
348d7.80	7.80	27.0	79	▲	▲
348d7.90	7.90	27.0	79	▲	▲
348d8.00	8.00	27.0	79	▲	▲
348d8.10	8.10	27.0	79	▲	▲
348d8.20	8.20	27.0	79	▲	▲
348d8.30	8.30	27.0	79	▲	▲
348d8.40	8.40	27.0	79	▲	▲
348d8.50	8.50	27.0	79	▲	▲
348d8.80	8.80	29.0	84	▲	▲
348d9.00	9.00	29.0	84	▲	▲
348d9.20	9.20	29.0	84	▲	▲
348d9.50	9.50	29.0	84	▲	▲
348d9.80	9.80	31.0	89	▲	▲
348d10.00	10.00	31.0	89	▲	▲
348d10.20	10.20	31.0	89	▲	▲
348d10.50	10.50	31.0	89	▲	▲
348d11.00	11.00	33.0	95	▲	▲
348d11.50	11.50	33.0	95	▲	▲
348d12.00	12.00	35.0	102	▲	▲
348d12.50	12.50	35.0	102	▲	▲
348d13.00	13.00	35.0	102	▲	▲
348d13.50	13.50	37.0	107	▲	▲
348d14.00	14.00	37.0	107	▲	▲
348d16.00	16.00	38.0	115	▲	▲

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