

# Twist drill with coolant holes

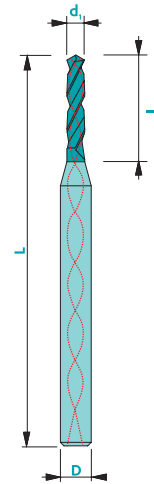


# 344

Material	Vc uncoated [m/min]	Vc coated [m/min]	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<sub>1</sub>: -0.002/-0.004  
D: h5



Art. n°	d <sub>1</sub>	l <sub>1</sub>	D	L	Uncoat. Price
344d0.70	0.70	6.0	3	38	
344d0.75	0.75	6.0	3	38	
344d0.80	0.80	6.0	3	38	
344d0.85	0.85	6.0	3	38	
344d0.90	0.90	6.0	3	38	
344d0.95	0.95	6.0	3	38	
344d1.00	1.00	8.0	3	38	
344d1.10	1.10	8.0	3	38	
344d1.20	1.20	8.0	3	38	
344d1.25	1.25	8.0	3	38	
344d1.30	1.30	8.0	3	38	
344d1.40	1.40	8.0	3	38	
344d1.50	1.50	12.0	3	38	
344d1.60	1.60	12.0	3	38	
344d1.70	1.70	12.0	3	38	
344d1.75	1.75	12.0	3	38	
344d1.80	1.80	12.0	3	38	
344d1.90	1.90	12.0	3	38	
344d2.00	2.00	12.0	3	38	
344d2.10	2.10	12.0	3	38	
344d2.20	2.20	12.0	3	38	
344d2.30	2.30	12.0	3	38	
344d2.40	2.40	12.0	3	38	
344d2.50	2.50	12.0	3	38	
344d2.60	2.60	12.0	3	38	
344d2.70	2.70	12.0	3	38	
344d2.80	2.80	12.0	3	38	
344d2.90	2.90	12.0	3	38	
344d3.00	3.00	12.0	3	38	

Available uncoated or coated (see page 308)

**Z2**

**CARB**

\* Prices for other coatings: contact us!  
To order a coated tool, add the 2-letter coating code to the article number