

Taper pin drills | Drilling and deburring tools | Stepped drill bits | Slabbing cut drill reamers

10899

Taper pin drills

DIN
1898A

1:50

118°

HSS

≤ 1000
N/mm²

HARTNER



Design

- Straight shank with driver in accordance with DIN 1809
- Right cutting
- Cone polished section

Applications

For drilling in steel and steel casting alloyed and unalloyed up to 1000 N/mm² strength, grey cast iron, malleable iron, etc.

For manufacturing tapered bores for taper pins DIN 1 and DIN 7978 in one step.

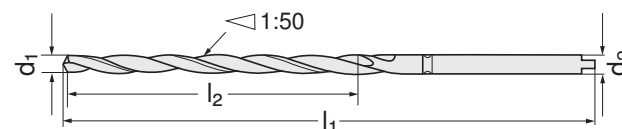
(Use for finish-machining of pin hole reamers art. no. 13432.)

Quality
HSS.

Note:

The diameter d_1 of the pin hole drill bit corresponds to the nominal diameter of the tapered pin.

10899



d ₁ h9 mm	l ₂ mm	l ₁ mm	d ₂ mm	HSS 10899 ...
4	68	112	5.00	105
5	73	122	6.30	106
6	105	160	8.00	107

d ₁ h9 mm	l ₂ mm	l ₁ mm	d ₂ mm	HSS 10899 ...
8	145	207	10.00	108
10	175	245	12.50	109
12	210	290	16.00	110

Al<10%Si	Al>10%Si	Cu	St<520N	St<750N	St<900N	St<1100N	St<1200N	St<1400N	<45HRC	<55HRC	<60HRC	<67HRC	VA<900N	VA>900N	Ti alloy	GG(G)	Plastic
50-60	40-50	30-60	25-28	22-25	20-22	-	-	-	-	-	-	-	-	-	-	20-28	30-40

Info

10918 - 10927 Drilling and deburring tool (stepped drill bit)

Design

Diameter tolerance +/- 0.13 mm.

Applications

For drilling and deburring in sheet metals of almost all metal alloys from 0.4 to 3.0 mm thickness, stainless steel, grey cast iron, aluminium, brass, plastic and fibreglass.

Quality

HSS.

Note:

Coolant stick see art. no. 10937 101.



10918

Drilling and deburring tool set

118°

HSS

≤ 900
N/mm²

Design

Consisting of 1 drilling and deburring tool each size 1/2A/3A, in box.

Quality

HSS.

Note:

Coolant stick see art. no. 10937 101.

10918



Drilling Ø mm	HSS 10918 ...
4 - 30	101



10924

Size	Number of cutting edges	Dimension table for bore diameter mm	Shank Ø mm	up to material thickness mm	HSS 10924	...
1	2	4/5/6/7/8/9/10/11/12	6	5	130	
2	2	12/13/14/15/16/17/18/19/20	9	4	142	NEW
3	2	20/21/22/23/24/25/26/27/28/29/30	12	4	132	
2A	2	4/6/8/10/12/14/16/18/20	8	4	135	
3A	2	6/8/10/12/14/16/18/20/22/24/26/28/30	10	4	143	NEW
4	2	7/12.5 (PG7)/15.2 (PG9)/18.6 (PG11)/20.4 (PG 13.5)/22.5 (PG16)/28.3 (PG21)/30.5/32.6	12	4	137	NEW
5	2	7/12.5 (PG7)/15.2 (PG9)/18.6 (PG11)/20.4 (PG 13.5)/22.5 (PG16)/28.3 (PG21)/33/37 (PG29)/39.6	12	4	138	NEW
13	2	30/31/32/33/34/35/36/37/38/39/40	13	4	139	NEW
14	2	40/41/42/43/44/45/46/47/48/49/50	13	4	140	NEW
15	2	50/51/52/53/54/55/56/57/58/59/60	13	4	141	NEW

Design

With 2 spiral grooves (DBGM) and edge-breaker (DBGM) deburring zone, as well as ROTASTOP (DBGM) comfort shank. Both steps (6 mm for core hole and 3 mm for through hole) on one tool.

Applications

For burr-free drilling and reaming for cable glands in accordance with **DIN EN 60423**. For processing cable junction boxes, installation boxes, distributor housings, terminal boxes, switch cabinets, switch and control devices, housings.

HSS



10927 101

HSS-E
TiN

10927 201

HSS-E
TiAIN

10927 301

Thread core hole (6 mm steps) Dia./thread
7.0/-
10.5/M 12 x 1.5
14.5/M 16 x 1.5
18.5/M 20 x 1.5
23.5/M 25 x 1.5
30.5/M 30 x 1.5

Through hole (3 mm steps) Dia./thread
12.5/M 12 x 1.5
16.5/M 16 x 1.5
20.5/M 20 x 1.5
25.5/M 25 x 1.5
32.5/M 30 x 1.5

Quality	10927	...
HSS	101	
TiN-coated	201	
TiAIN-coated	301	

**Design**

- With straight shank
- Drilling range 3–30.5 mm
- Consisting of 1 drill bit in each size: 1, 2 and 3, in plastic case

Applications

For burr- and chatter-free drilling and reaming of holes in thin materials in a single action. For annealed sheet steels, stainless-steel sheets, body panels, non-ferrous metals, thin-walled pipes and plastics such as PVC, Plexiglas, Resopal, among others, as well as hard paper, plywood, etc.

Note:

Bore to the edge possible without deformation!
Coolant stick, see art. no. 10937 101.

10934 201

Quality
HSS-E.

10934 202

Quality
HSS-E/TiN-coated.

HSS-E

10934 201

HSS-E
TiN

10934 202



Quality	10934	...
HSS-E	201	
HSS-E/TiN	202	

10935 - 10937

Slabbing cut drill reamer (sheet metal drill)



Design

- With straight shank

Applications

For burr- and chatter-free drilling and reaming of holes in thin materials in a single action. For annealed sheet steels, stainless-steel sheets, body panels, non-ferrous metals, thin-walled pipes and plastics such as PVC, Plexiglas, Resopal, among others, as well as hard paper, plywood, etc.

Note:

Cooling lubricant!

10935

Quality

HSS-E.

10936

Quality

HSS-E/TiN-coated.

10937

Coolant stick

Design

Without silicone, content 25 ml.

Applications

For lubricating all areas of friction when drilling and thread cutting.

HSS-E



10935

HSS-E
TiN


10936



10937

Size	for hole Ø mm	Shank Ø mm	HSS-E		HSS-E/TiN		Coolant stick	
			10935	...	10936	...	10937	...
1	3-14.0	6			101	101		
2	8-20.0	8			102	102		
3	16-30.5	9			103	103		
4	26-40.0	12			104	104		
5	36-50.0	12			105	105		
6	46-60.0	12			106	106		
7	4-30.5	9			107	107		
-	-	-						101

10940

Universal milling drill

HSS



Design

With straight shank.

Applications

For drilling and cutting out any desired contour in sheets of all kinds, also suitable for wood, Resopal and other plastics.

Quality

HSS.

Note:

Effective rotation speed approx. 1000-1200 rpm.

In the case of lubricating material (zinc, aluminium, etc.) immerse the tool in a lubricant occasionally. For use in electric hand drills.

Coolant stick see art. no. 10937 101.



10940

Ø mm	HSS	
	10940	...
6.35		101

10942

Spot weld cutter

HSS

Design

The core drill is reversible, the cutting depth can be adjusted.

Applications

For loosening spot-welded sheet metal parts without deformation or tearing of the sheet metal. For sheet metal processing plants, body workshops, industry, etc.

Quality

HSS.

Note:

Effective rotation speed approx. 900 rpm.



10942

	Core drill Ø mm	HSS	
		10942	...
Cutter	10		101
Spare core	10		102