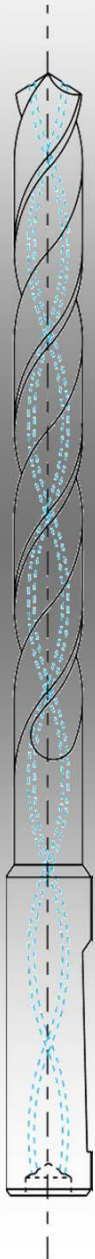
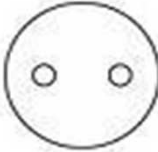
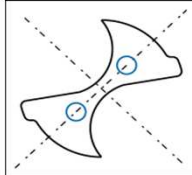

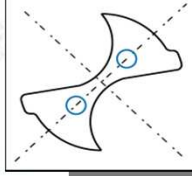

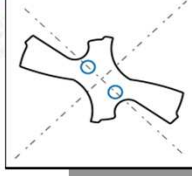

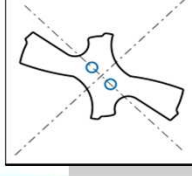
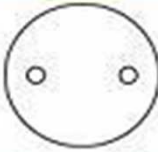
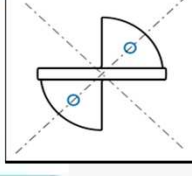




Think **efficiency**, Think **COOLANT FED**

**High Speed Steel bars with 2 twisted or straight holes,  
 for the production of coolant fed & MQL drills**



	ST	
	FE3 80%	
	FE2 65%	
	FE1 50%	
	WO1	

**2 holes bars for drills**

Available grades:

- M2
- M35
- PM30
- Z38CDV5

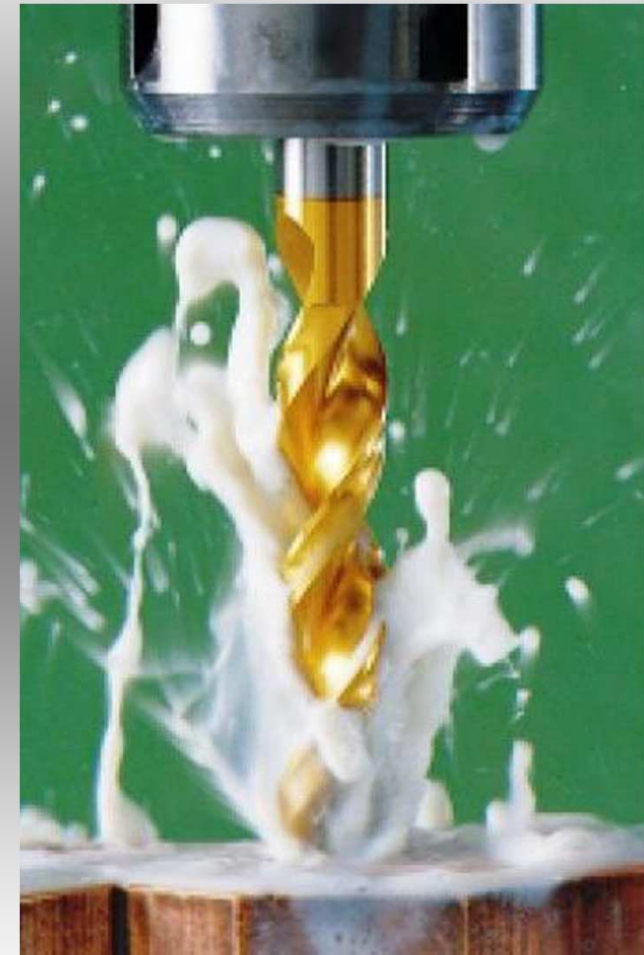
Delivered with twisted or straight holes.  
 We recommend the following helix angles:

0°(NT), 15°, 25°, 35°

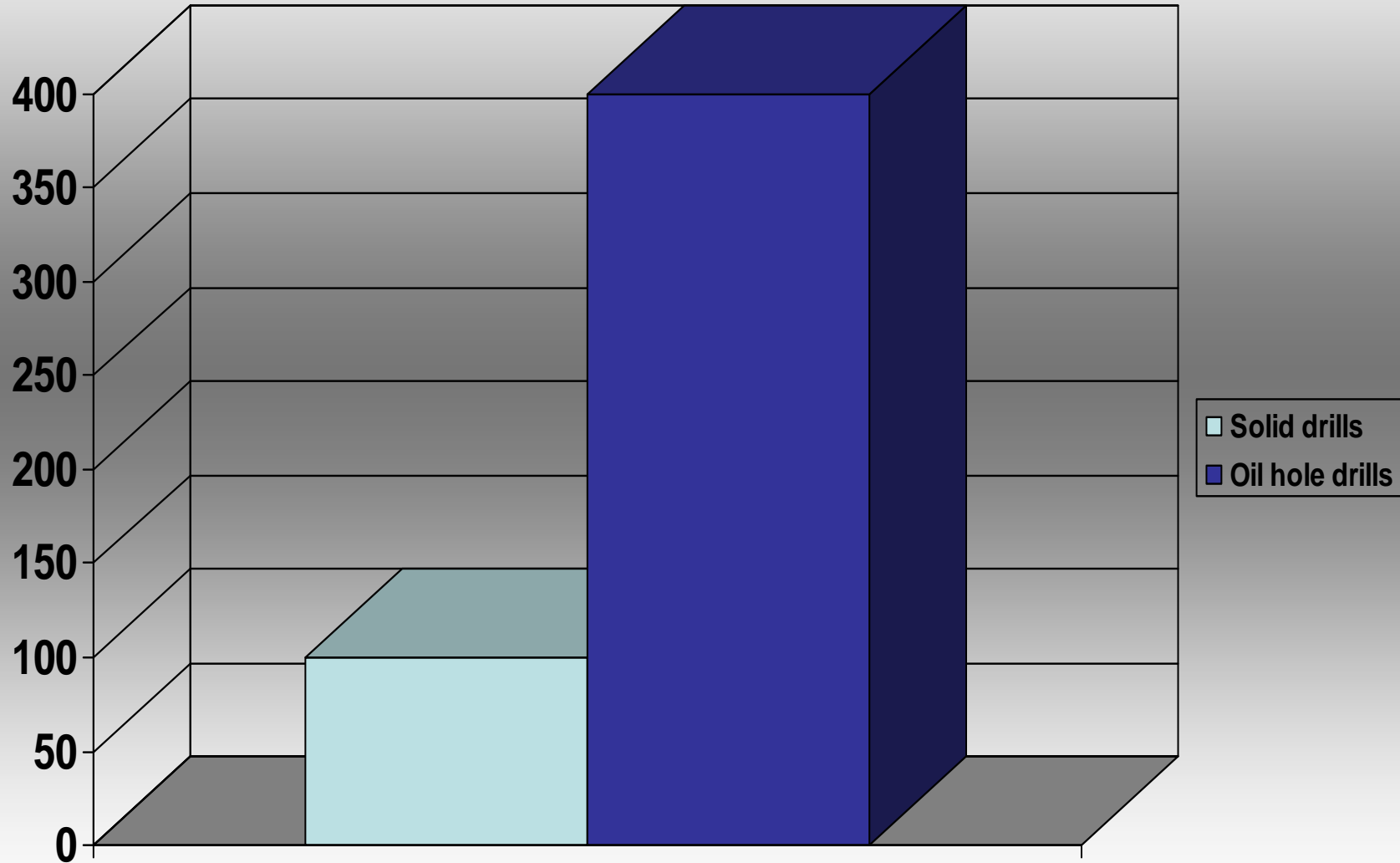
Other helix angles can be obtained from 0 to 45° on order.

## *The advantages of oil hole*

- *Prevents chip chip welding*
- *Breaks up chips*
- *Prevents damaging chemical reactions that occur at high temperatures*
- *Avoids quenching*
- *Extends tool life ( up to 300%)*
- *Allows an increase of cutting speeds by speeds more than 30%*
- *Improves surface finish*
- *Reduces cycle time*
- *Safety in drilling*

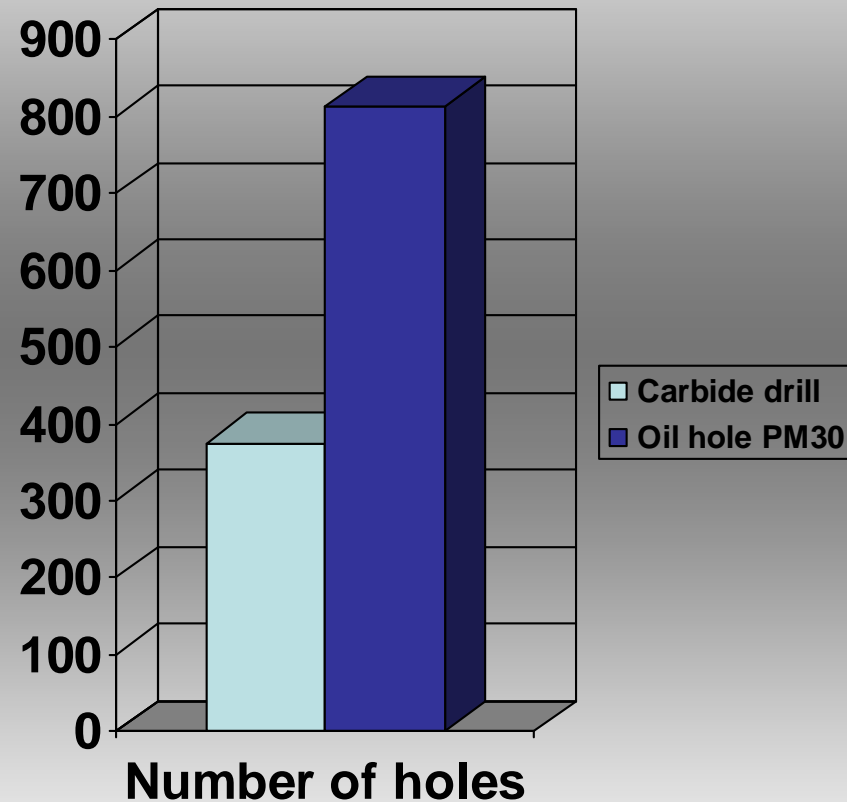


# Comparison of tool life



**Carbide drill vs. HSS coated drill PM30 drilling cast iron ATF 25**

- ◆ Hole  $\varnothing$  8.25mm L 80 mm
- ◆ Cutting speed = 60m/mn
- ◆ Feed = 0.25 mm/ r
- ◆ Service life of carbide drill:  
375 holes
- ◆ Service life of HSS PM30  
drill: 812 holes



***Cost per hole reduced by 65%***



Think **SECURITY**, Think **COOLANT FED**