Overview of metal drill bits with recommendation

Steel



Quality	★★★★★	★★★★☆	★★★★★	★★★★☆	★★★★★	★★★★★	★★★★★	★★★★☆	★★★★☆	★★★★☆	★★★★★	★★★★★	★★★★★	★★★★★	★★★★★	★★★★★
DIN Norm	-	-	-	-	355 C	335 C	335 C	335 C	-	-	-	373	-	-	-	-
Product	-	ECO	-	ECO	-	-	-	ECO	-	-	-	-	-	-	-	-
Product material	HSS-Co 5% HSS-G	HSS-Co 5% HSS-G	HSS-Co 5% HSS-G	HSS-Co 5% HSS-G	HSS-Co 5% HSS-G	HSS-Co 5%	HSS-Co 5%	HSS-Co 5% HSS-G	HSS-Co 5% HSS-G	HSS-G	Carbide	HSS-Co 5%	Carbide	HSS-Co 5% HSS-G	HSS-G	Carbide
Type	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Point angle	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Coating	-	-	-	-	-	AlTiN	-	-	-	-	-	-	-	-	-	-
Shank	3 flat shank	3 flat shank	3 flat shank	3 flat shank	3 flat shank	3 flat shank	3 flat shank	Straight	Straight	Hex	Hex	Straight	Weldon Nitto	Weldon	Quickln	Straight
Ø mm	4 - 37	4 - 30	3 - 60	4 - 60	6,3 - 40	6,3 - 31	6,3 - 31	6,3 - 30	2 - 20	6,3 - 20,5	3 - 54	M3 - M12	12 - 60	12 - 60	12 - 60	3 - 16
Series	76600 76000	76700 76100	75600 75000	75700 75100	36500 36100	35900	35700 35800	35600 35000	36600	35300	35400	36X00	38900	38700 38500	38300	70000
Article group	12	12	12	12	15	15	15	15	15	15	15	15	84	84	84	70
Page	150	151	152	153	156	157	158	159	160	161	162	162	164	165	166	172
HD Heavy Duty <1,400 N/mm²													+			+
Steel pipes, -profiles, solid metal	++	++	++	++	+++	+++	+++	++	++	++	+++	+++	+++	+++	+++	+++
Cast iron	++	++	+	+	+++	+++	+++	++	++	++	++	++	+++	++	++	+++
Stainless steel	++	++	++	++	+++	+++	++	++	++		++	+++	+++	+++		+++
Non-ferrous metals	++	++	++	++	+++	++	++	++	+	+	++	+++	+++	+++	+++	+++
Sheet metals	+++	+++	+++	+++	++	++	++	++	++	++			++	++	++	
Aluminum	++	++	++	++	+++	+	++	++	++	++	++	++	++	+++	+++	+++
Acryl glass	+	+	++	++	+	+	+	+	+	+	+	+				
Plastic	++	++	++	++	++	+	+	+	++	++	++	++	++	++	++	++
Wood					+	+	+	+	+	+	++	+				

+++ **recommended** ++ **well-suited** + **suitable**

GOLD ★★★★★ SILVER ★★★★☆ BRONZE ★★★☆☆

CORE DRILL BITS



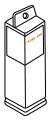
38900 | Core Drill Bits With Weldon Shank 19 mm [3/4"] and Nitto Holder, Tungsten Carbide Teeth



Art.-Group **84**



- Fast and precise drilling due to three different tooth geometries that perfectly match each other
- Carbide toothing ensures maximum lifetime
- Cutting depth 55 mm
- With WelNit shank for mounting in core drills with Weldon shank 19 mm [3/4"] and Nitto universal shank
- High cost and time savings because the core drill bit only drills out a ring and not the entire drill diameter
- Time saving effect can be up to a factor of 10 because time-consuming preparatory work such as pre-centring or pre-drilling and re-drilling is no longer necessary
- The ejector pin (with spring) throws out the drill core
- The core drill bits are used on mobile magnetic core drilling machines or on stationary pillar drilling machines
- For stainless steel, high-alloy steels, non-ferrous metals, aluminum and cast iron



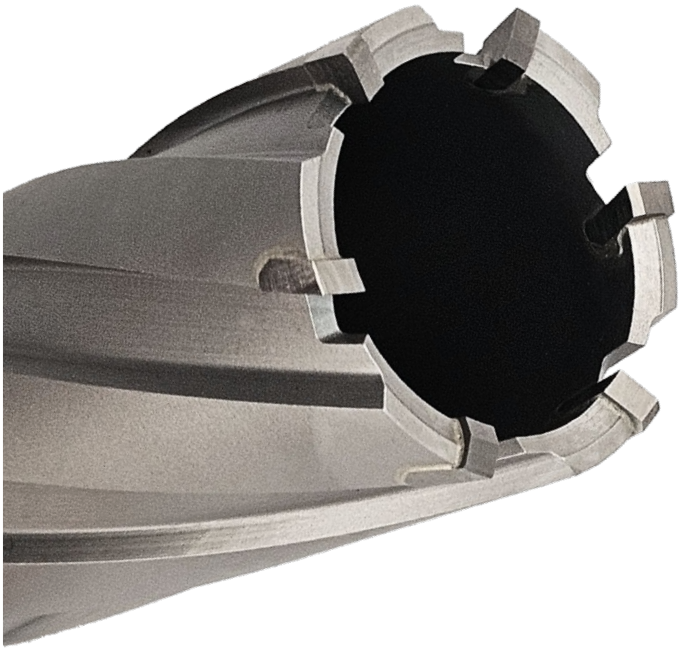
Single packaging with hanger

★★★★★

Ø mm	Cutting Depth mm	Item No.
12.0	55	389 120 55
13.0	55	389 130 55
14.0	55	389 140 55
15.0	55	389 150 55
16.0	55	389 160 55
17.0	55	389 170 55
18.0	55	389 180 55
19.0	55	389 190 55
20.0	55	389 200 55
21.0	55	389 210 55

Ø mm	Cutting Depth mm	Item No.
22.0	55	389 220 55
23.0	55	389 230 55
24.0	55	389 240 55
25.0	55	389 250 55
26.0	55	389 260 55
27.0	55	389 270 55
28.0	55	389 280 55
29.0	55	389 290 55
30.0	55	389 300 55
31.0	55	389 310 55

Ø mm	Cutting Depth mm	Item No.
32.0	55	389 320 55
33.0	55	389 330 55
34.0	55	389 340 55
35.0	55	389 350 55
40.0	55	389 400 55
45.0	55	389 450 55
50.0	55	389 500 55
55.0	55	389 550 55
60.0	55	389 600 55



38700 | Core Drill Bits With Weldon Shank 19 mm [3/4"] HSS-Co 5%



Art.-Group **84**





- Precision-ground core drill bits for accurate, clean and fast drilling
- The core drill bits are made of high-quality High Speed Steel, which ensures excellent wear resistance and durability
- Available in cutting depths of 30 mm and 55 mm
- High cost and time savings because the core drill bit only drills out a ring and not the entire drill diameter
- Time saving effect can be up to a factor of 10 because time-consuming preparatory work such as pre-centring or pre-drilling and re-drilling is no longer necessary
- The ejector pin (with spring) throws out the drill core
- The core drill bits are used on mobile magnetic core drilling machines or on stationary pillar drilling machines
- For the best results, always use coolant and the right rotation speed
- For stainless steel, steel, non-ferrous metals, aluminum, cast iron and plastics



Single packaging with hanger

★★★★★

Ø mm	Cutting Depth mm	Item No.
12.0	30	387 120 30
13.0	30	387 130 30
14.0	30	387 140 30
15.0	30	387 150 30
16.0	30	387 160 30
17.0	30	387 170 30
18.0	30	387 180 30
19.0	30	387 190 30
20.0	30	387 200 30
21.0	30	387 210 30
22.0	30	387 220 30
23.0	30	387 230 30
24.0	30	387 240 30
25.0	30	387 250 30
26.0	30	387 260 30
27.0	30	387 270 30
28.0	30	387 280 30
29.0	30	387 290 30

Ø mm	Cutting Depth mm	Item No.
30.0	30	387 300 30
31.0	30	387 310 30
32.0	30	387 320 30
35.0	30	387 350 30
40.0	30	387 400 30
45.0	30	387 450 30
50.0	30	387 500 30
55.0	30	387 550 30
60.0	30	387 600 30
12.0	55	387 120 55
13.0	55	387 130 55
14.0	55	387 140 55
15.0	55	387 150 55
16.0	55	387 160 55
17.0	55	387 170 55
18.0	55	387 180 55
19.0	55	387 190 55
20.0	55	387 200 55

Ø mm	Cutting Depth mm	Item No.
21.0	55	387 210 55
22.0	55	387 220 55
23.0	55	387 230 55
24.0	55	387 240 55
25.0	55	387 250 55
26.0	55	387 260 55
27.0	55	387 270 55
28.0	55	387 280 55
29.0	55	387 290 55
30.0	55	387 300 55
31.0	55	387 310 55
32.0	55	387 320 55
35.0	55	387 350 55
40.0	55	387 400 55
45.0	55	387 450 55
50.0	55	387 500 55
55.0	55	387 550 55
60.0	55	387 600 55

Sets

Art.-Group **16**



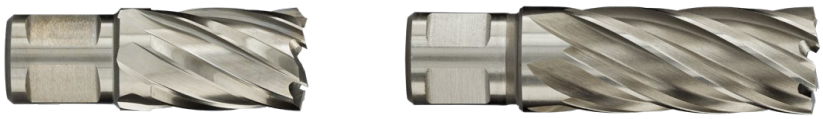
★★★★★

Content	Pieces	Packaging	Item No.
Ø 12 - 14 - 16 - 18 - 20 - 22 mm including ejector pin Cutting depth 30 mm	7	Metal box	60 039

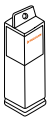
38500 | Core Drill Bits With Weldon Shank 19 mm [3/4"] HSS-G



Art.-Group **84**



- Precision-ground core drill bits for accurate, clean and fast drilling
- The core drill bits are made of high-quality High Speed Steel, which ensures excellent wear resistance and durability
- Available in cutting depths of 30 mm and 55 mm
- High cost and time savings because the core drill bit only drills out a ring and not the entire drill diameter
- Time saving effect can be up to a factor of 10 because time-consuming preparatory work such as pre-centring or pre-drilling and re-drilling is no longer necessary
- The ejector pin (with spring) throws out the drill core
- The core drill bits are used on mobile magnetic core drilling machines or on stationary pillar drilling machines
- For the best results, always use coolant and the right rotation speed
- For steel, non-ferrous metals, aluminum, cast iron and plastics



Single packaging with hanger

★★★★★

Ø mm	Cutting Depth mm	Item No.
12.0	30	385 120 30
13.0	30	385 130 30
14.0	30	385 140 30
15.0	30	385 150 30
16.0	30	385 160 30
17.0	30	385 170 30
18.0	30	385 180 30
19.0	30	385 190 30
20.0	30	385 200 30
21.0	30	385 210 30
22.0	30	385 220 30
23.0	30	385 230 30
24.0	30	385 240 30
25.0	30	385 250 30
26.0	30	385 260 30
27.0	30	385 270 30
28.0	30	385 280 30
29.0	30	385 290 30

Ø mm	Cutting Depth mm	Item No.
30.0	30	385 300 30
31.0	30	385 310 30
32.0	30	385 320 30
35.0	30	385 350 30
40.0	30	385 400 30
45.0	30	385 450 30
50.0	30	385 500 30
55.0	30	385 550 30
60.0	30	385 600 30
12.0	55	385 120 55
13.0	55	385 130 55
14.0	55	385 140 55
15.0	55	385 150 55
16.0	55	385 160 55
17.0	55	385 170 55
18.0	55	385 180 55
19.0	55	385 190 55
20.0	55	385 200 55

Ø mm	Cutting Depth mm	Item No.
21.0	55	385 210 55
22.0	55	385 220 55
23.0	55	385 230 55
24.0	55	385 240 55
25.0	55	385 250 55
26.0	55	385 260 55
27.0	55	385 270 55
28.0	55	385 280 55
29.0	55	385 290 55
30.0	55	385 300 55
31.0	55	385 310 55
32.0	55	385 320 55
35.0	55	385 350 55
40.0	55	385 400 55
45.0	55	385 450 55
50.0	55	385 500 55
55.0	55	385 550 55
60.0	55	385 600 55

Sets

Art.-Group **16**



★★★★★

Content	Pieces	Packaging	Item No.
Ø 12 - 14 - 16 - 18 - 20 - 22 mm including ejector pin Cutting depth 30 mm	7	Metal box	60 038

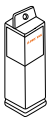
38100 | Core Drill Bits With QuickIN Shank HSS-G



Art.-Group **84**



- Precision-ground core drill bits for accurate, clean and fast drilling
- The core drill bits are made of high-quality High Speed Steel, which ensures excellent wear resistance and durability
- Cutting depth 35 mm
- High cost and time savings because the core drill bit only drills out a ring and not the entire drill diameter
- Time saving effect can be up to a factor of 10 because time-consuming preparatory work such as pre-centring or pre-drilling and re-drilling is no longer necessary
- The ejector pin (with spring) throws out the drill core
- The core drill bits are used on mobile magnetic core drilling machines or on stationary pillar drilling machines
- For the best results, always use coolant and the right rotation speed
- For steel, non-ferrous metals, aluminum, cast iron and plastics



Single packaging with hanger

★★★★★

Ø mm	Cutting Depth mm	Item No.
12.0	35	381 120 35
13.0	35	381 130 35
14.0	35	381 140 35
15.0	35	381 150 35
16.0	35	381 160 35
17.0	35	381 170 35
18.0	35	381 180 35
19.0	35	381 190 35
20.0	35	381 200 35

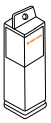
Ø mm	Cutting Depth mm	Item No.
21.0	35	381 210 35
22.0	35	381 220 35
23.0	35	381 230 35
24.0	35	381 240 35
25.0	35	381 250 35
26.0	35	381 260 35
27.0	35	381 270 35
28.0	35	381 280 35
29.0	35	381 290 35

Ø mm	Cutting Depth mm	Item No.
30.0	35	381 300 35
31.0	35	381 310 35
32.0	35	381 320 35
35.0	35	381 350 35
40.0	35	381 400 35
45.0	35	381 450 35
50.0	35	381 500 35
55.0	35	381 550 35
60.0	35	381 600 35

Rotation speed overview for core drill bits HSS-G and HSS-Co 5%. It is recommended to always use a suitable coolant.

Material	Unalloyed steel up to 700 N/mm²	Alloyed steels up to 1,000 N/mm²	Aluminum Alloy
Not suitable for automatic feed!			
Ø mm	**rpm**	**rpm**	**rpm**
12	780	530	790
13	730	480	740
14	690	450	680
15	630	420	640
16	590	390	600
17	550	360	560
18	520	340	540
19	500	320	510
20	480	320	480
21	440	300	460
22	430	280	440
23	400	260	410
24	390	250	400
25	360	240	380
26	340	230	370
27	330	220	350
28	320	210	340
29	310	200	330
30	290	180	310
31	280	170	300
32	270	160	290
35	260	150	280
40	240	140	260
45	220	130	240
50	200	120	210
55	180	110	190
60	150	100	160

38500 | Centering and Ejector Pins for Core Drill Bits



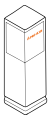
Single packaging with hanger



★★★★★

Description	Ø mm	L mm	Item No.
For core drill bits with a cutting depth of 30 mm	6.3	77	385 030 01
For HSS core drill bits with a cutting depth of 55 mm -For carbide core drill bits with a cutting depth of 55 mm and Ø ≤ 17 mm	6.3	102	385 030 02
For core drill bits with a cutting depth of 35 mm	6.3	90	385 030 05
For carbide core drill bits with a cutting depth of 55 mm and Ø ≥ 18 mm	8.0	103	389 055 02

38500 | Core Drill Bit Adapter



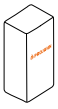
Single packaging with hanger

★★★★★

Description	Item No.
Quick change adapter MK 2 to weldon shank 19 mm with automatic internal lubrication for core drill bits. Quick tool change without a chuck key. Version with hose and quick-release coupling.	385 000 02
Quick change adapter MK 3 to weldon shank 19 mm with automatic internal lubrication for core drill bits. Quick tool change without a chuck key. Version with hose and quick-release coupling.	385 000 03
Adapter from MK 2 to 19 mm weldon shank with automatic internal lubrication	385 020 02
Adapter from MK 3 to 19 mm weldon shank with automatic internal lubrication	385 020 03
Adapter from MK 2 to 19 mm weldon shank with manual internal lubrication	385 010 02
Adapter from MK 3 to 19 mm weldon shank with manual internal lubrication	385 010 03
Adapter from 18 mm QuikIN shank to 19 mm weldon shank including two ejector pins	385 050 01
Drill chuck adapter from 19 mm weldon shank to 12.5 [1/2"] - 20 UNF	385 040 01



38500 | Magnetic Stick



Single packaging with hanger

★★★★★

Description	Item No.
Collects drilling chips and similar metallic waste with strong magnetic force	385 090 03

