





Help table for tool selection

| Ø mm | Machining | | | | | | | | | |
|--|---|------------|---|--|---|------------|-------------|--|----------------------|------------|
| | through hole | blind hole | uneven | angled start and drilling out, interrupted cut | convex | cross bore | divided cut | large hole offset | stack plate drilling | adjustable |
| 24 - 215 | ● | ● | ● | ● | ● | ● | ● | ● | 80° | ● |
| 30 - 215 | ● | ● | ● | ● | ● | ● | | ● | 80° | ● |
| 22 - 82 | ● | ● | ● | ● | ● | ● | | ● | 80° | ● |
| 14 - 44 | ● | ● | ● | ● | ● | ● | | ● | 80° | |
| 196 - 401 | ● | ● | ● | ● | ● | ● | | ● | 80° | ● |
| > 206 - 1000 larger diameters on request | ● | ● | ● | ● | ● | ● | | | | ● |
| 10 - 48 | ● | ● | ● | ● | ● | ● | | ● | | |
| 16,5 - 37 |  for producing the 90° and 60° countersinks | |  for milling of trapezoidal slots | |  for circular milling on machining centres | | |  for chamfering on machining centres | | |

| Coolant | | Tool | | Material | | | | | | Connection | |
|----------|----------|----------|----------|----------|---|---|---|---|---|-------------|-------------------|
| Emulsion | | MQL | | P | M | K | N | S | H | right | |
| internal | external | internal | external | | | | | | | ABS | Cylindrical shank |
| ● | ● | ● | ◐* | ● | ● | ● | ● | | | 2.14 - 2.35 | |
| ● | ● | ● | ◐* | ● | ● | ● | ● | | | 2.36 - 2.37 | |
| ● | ● | ● | ◐* | ● | ● | ● | ● | | | 2.41 | |
| ● | ● | ● | ◐* | | | | | | | Kapitel 4 | |
| ● | ● | ● | ◐* | ● | ● | ● | ● | | | 2.16 - 2.35 | |
| ● | ● | ● | ◐* | ● | ● | ● | ● | ● | ○ | 2.38 - 2.39 | |
| ● | ● | ● | ◐* | ● | ● | ● | ● | ● | ○ | | 2.42 |
| | | | | ● | ● | ● | ● | ● | ○ | | 2.44 |