

► Twist drill HSS / HSS-Co Steel



	<b>P</b> N/mm <sup>2</sup>	<b>M</b> N/mm <sup>2</sup>	<b>K</b> HB
102000	<850		<200
102050	<1000		<300
102350	<1200	<850	<350

vc = m/min.		
102000	20-40	20-25
102050	16-32	20-32
102350	10-28	8-36

**Versions 102000 and 102050:**  
 - made of HSS  
 - relieved cone  
 - drill point thinning from 14.25 mm  
 - steam tempered

DIN 345	Type N	Teeth 2	118°	MK shank	P	K	
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**Use 102000 and 102050:**

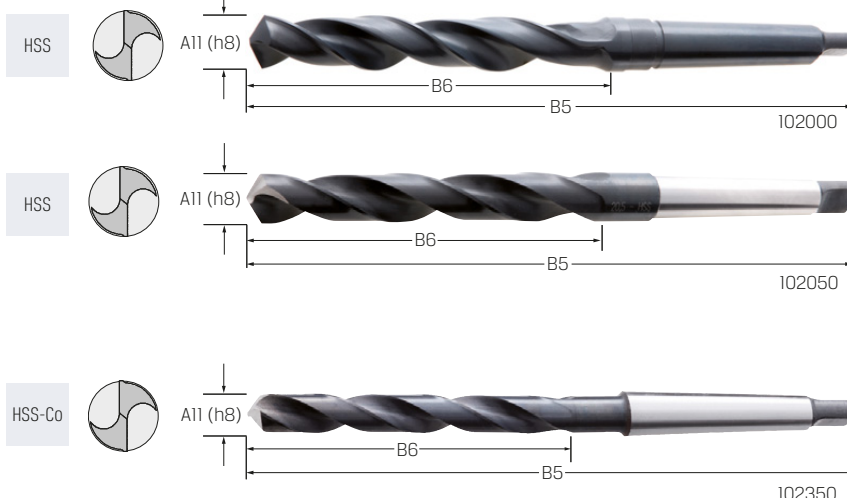
Standard twist drill for general machining of alloyed and unalloyed steel, cast steel, grey cast iron, malleable iron, ductile iron, sintered iron, nickel silver and graphite

**Design 102350:**

- made of HSS-Co  
 - relieved cone  
 - drill point thinning from 10.00 mm  
 - steam tempered

**Use 102350:**

Alloyed and unalloyed steel and cast iron types above 800 N/mm<sup>2</sup>, hot and cold work steels, high alloyed steels, tempered and hardened steel



Item no.	102000 PRETEC HSS, milled	102050 PREMUS HSS	102350 PREMUS HSS-Co	A11 mm	B5 mm	B6 mm	C2	f mm/rev
10,00	●	●	●	10	168	87	MK1	0,160 - 0,250
10,20	●	●	●	10,2	168	87	MK1	0,160 - 0,250
10,25	●	●	●	10,25	168	87	MK1	0,160 - 0,250
10,50	●	●	○	10,5	168	87	MK1	0,160 - 0,250
10,75	●	●	●	10,75	175	94	MK1	0,160 - 0,250
11,00	●	●	●	11	175	94	MK1	0,160 - 0,250
11,25	●	●	●	11,25	175	94	MK1	0,160 - 0,250
11,50	●	●	○	11,5	175	94	MK1	0,160 - 0,250
11,75	●	●	●	11,75	175	94	MK1	0,160 - 0,250
12,00	●	●	●	12	182	101	MK1	0,160 - 0,250
12,25	●	●	●	12,25	182	101	MK1	0,160 - 0,250
12,50	●	●	○	12,5	182	101	MK1	0,160 - 0,250
12,75	●	●	●	12,75	182	101	MK1	0,160 - 0,250
13,00	●	●	●	13	182	101	MK1	0,160 - 0,250
13,25	●	○	●	13,25	189	108	MK1	0,160 - 0,250
13,50	●	●	●	13,5	189	108	MK1	0,160 - 0,250
13,75	●	●	●	13,75	189	108	MK1	0,160 - 0,250
14,00	●	●	●	14	189	108	MK1	0,160 - 0,250
14,25	●	●	●	14,25	212	114	MK2	0,160 - 0,250
14,50	●	●	●	14,5	212	114	MK2	0,160 - 0,250
14,75	●	●	●	14,75	212	114	MK2	0,160 - 0,250
15,00	●	●	●	15	212	114	MK2	0,160 - 0,250
15,25	●	●	○	15,25	218	120	MK2	0,160 - 0,250
15,50	●	●	●	15,5	218	120	MK2	0,160 - 0,250
15,75	●	●	●	15,75	218	120	MK2	0,160 - 0,250
16,00	●	●	●	16	218	120	MK2	0,200 - 0,315
16,25	●	●	○	16,25	223	125	MK2	0,200 - 0,315
16,50	●	●	●	16,5	223	125	MK2	0,200 - 0,315
16,75	●	●	○	16,75	223	125	MK2	0,200 - 0,315
17,00	●	●	●	17	223	125	MK2	0,200 - 0,315
17,25	●	○	●	17,25	228	130	MK2	0,200 - 0,315
17,50	●	●	●	17,5	228	130	MK2	0,200 - 0,315
17,75	●	●	●	17,75	228	130	MK2	0,200 - 0,315
18,00	●	●	●	18	228	130	MK2	0,200 - 0,315
18,25	●	●	●	18,25	233	135	MK2	0,200 - 0,315
18,50	●	●	●	18,5	233	135	MK2	0,200 - 0,315
18,75	●	●	●	18,75	233	135	MK2	0,200 - 0,315
19,00	●	●	●	19	233	135	MK2	0,200 - 0,315
19,25	●	●	●	19,25	238	140	MK2	0,200 - 0,315
19,50	●	●	●	19,5	238	140	MK2	0,200 - 0,315
19,75	●	●	●	19,75	238	140	MK2	0,200 - 0,315
20,00	●	●	●	20	238	140	MK2	0,250 - 0,400
20,25	●	●	●	20,25	243	145	MK2	0,250 - 0,400
20,50	●	●	●	20,5	243	145	MK2	0,250 - 0,400
20,75	●	●	○	20,75	243	145	MK2	0,250 - 0,400
21,00	●	●	●	21	243	145	MK2	0,250 - 0,400
21,50	●	●	○	21,5	243	145	MK2	0,250 - 0,400
21,75	●	●	●	21,75	248	150	MK2	0,250 - 0,400
22,00	●	●	●	22	248	150	MK2	0,250 - 0,400
22,25	●	●	●	22,25	248	150	MK2	0,250 - 0,400
22,50	●	●	○	22,5	248	150	MK2	0,250 - 0,400
22,75	●	●	●	22,75	253	155	MK2	0,250 - 0,400
23,00	●	●	●	23	253	155	MK2	0,250 - 0,400
23,50	●	●	●	23,5	276	155	MK3	0,250 - 0,400
23,75	●	●	●	23,75	281	160	MK3	0,250 - 0,400

Item no.	102000 PRETEC HSS, milled	102050 PREMUS HSS	102350 PREMUS HSS-Co	A11 mm	B5 mm	B6 mm	C2	f mm/rev
24,00	●	●	●	24	281	160	MK3	0,250 - 0,400
24,50	●	●	○	24,5	281	160	MK3	0,250 - 0,400
24,75	●	●	●	24,75	281	160	MK3	0,250 - 0,400
25,00	●	●	●	25	281	160	MK3	0,315 - 0,500
25,50	●	●	●	25,5	286	165	MK3	0,315 - 0,500
25,75	●	●	●	25,75	286	165	MK3	0,315 - 0,500
26,00	●	●	●	26	286	165	MK3	0,315 - 0,500
26,50	●	●	●	26,5	286	165	MK3	0,315 - 0,500
26,75	●	●	●	26,75	291	170	MK3	0,315 - 0,500
27,00	●	●	○	27	291	170	MK3	0,315 - 0,500
27,50	●	●	●	27,5	291	170	MK3	0,315 - 0,500
27,75	●	●	●	27,75	291	170	MK3	0,315 - 0,500
28,00	●	●	●	28	291	170	MK3	0,315 - 0,500
28,50	●	●	●	28,5	296	175	MK3	0,315 - 0,500
28,75	●	●	●	28,75	296	175	MK3	0,315 - 0,500
29,00	●	●	●	29	296	175	MK3	0,315 - 0,500
29,50	●	●	○	29,5	296	175	MK3	0,315 - 0,500
29,75	●	●	●	29,75	296	175	MK3	0,315 - 0,500
30,00	●	●	●	30	296	175	MK3	0,315 - 0,500
30,50	●	●	●	30,5	301	180	MK3	0,315 - 0,500
31,00	●	●	●	31	301	180	MK3	0,315 - 0,500
31,50	●	●	●	31,5	301	180	MK3	0,315 - 0,500
32,00	●	●	●	32	334	185	MK4	0,315 - 0,500
32,50	●	○	●	32,5	334	185	MK4	0,315 - 0,500
33,00	●	●	○	33	334	185	MK4	0,315 - 0,500
33,50	●	●	●	33,5	334	185	MK4	0,315 - 0,500
34,00	●	●	●	34	339	190	MK4	0,315 - 0,500
34,50	●	●	●	34,5	339	190	MK4	0,315 - 0,500
35,00	●	●	○	35	339	190	MK4	0,315 - 0,500
35,50	●	○	●	35,5	339	190	MK4	0,315 - 0,500
36,00	●	●	○	36	334	195	MK4	0,315 - 0,500
37,00	●	○	●	37	334	195	MK4	0,315 - 0,500
37,50	●	●	●	37,5	334	195	MK4	0,315 - 0,500
38,00	●	●	●	38	349	200	MK4	0,315 - 0,500
39,00	●	●	●	39	349	200	MK4	0,315 - 0,500
39,50	●	●	●	39,5	349	200	MK4	0,315 - 0,500
40,00	●	●	○	40	349	200	MK4	0,400 - 0,630
41,00	●	●	●	41	534	205	MK4	0,400 - 0,630
42,00	●	●	●	42	354	205	MK4	0,400 - 0,630
43,00	●	●	●	43	359	210	MK4	0,400 - 0,630
44,00	●	●	●	44	359	210	MK4	0,400 - 0,630
45,00	●	●	●	45	359	210	MK4	0,400 - 0,630
46,00	●	○	●	46	364	215	MK4	0,400 - 0,630
47,00	●	●	●	47	364	215	MK4	0,400 - 0,630
48,00	●	●	●	48	369	220	MK4	0,400 - 0,630
49,00	●	○	●	49	369	220	MK4	0,400 - 0,630
50,00	●	●	●	50	369	220	MK4	0,500 - 0,800
51,00	●	●	●	51	412	225	MK5	0,500 - 0,800
52,00	●	●	●	52	412	225	MK5	0,500 - 0,800
53,00	○	●	●	53	412	225	MK5	0,500 - 0,800
54,00	●	●	●	54	417	230	MK5	0,500 - 0,800
55,00	●	○	●	55	417	230	MK5	0,500 - 0,800
58,00	●	●	●	58	422	235	MK5	0,500 - 0,800
60,00	●	●	●	60	422	235	MK5	0,500 - 0,800
65,00	●	○	●	65	432	245	MK5	0,630 - 1,000