

®

PRESTO

Elite Super Xtrem Hardox Drill

~~ELITE SUPER Xtrem~~

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8%
**Cobalt
Drills**



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Short flute drills for machining wear-resistant sheet metal plates and HARDOX (up to HARDOX 55, <55HRC plates).

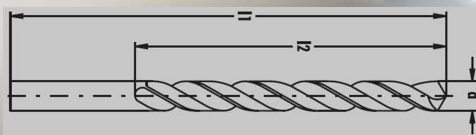
**8%
Cobalt
Drills**

High Alloy Cobalt steel M42 with ALTiN coating
Prevents build up of swarf on cutting edges, whilst improving the removal of chips.

- 135° Special Point
- Reinforced Core Diameter
- Short, Stable flute & cutting edge
- Can be used in hand drills, Pillar drills and CNC machining centres
- Drill Length manufactured to DIN338
- All are packed singularly

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Series No : 01218

Part Number	d1 mm	l1 mm	l2 mm
012183.0	3.00	61.00	16.00
012183.3	3.30	65.00	18.00
012183.5	3.50	70.00	20.00
012184.0	4.00	75.00	22.00
012184.2	4.20	75.00	22.00
012184.5	4.50	80.00	24.00
012185.0	5.00	86.00	26.00
012185.5	5.50	93.00	28.00
012186.0	6.00	93.00	28.00
012186.5	6.50	101.00	31.00
012186.8	6.80	109.00	34.00
012187.0	7.00	109.00	34.00
012187.5	7.50	109.00	34.00
012188.0	8.00	117.00	37.00
012188.5	8.50	117.00	37.00
012189.0	9.00	125.00	40.00
012189.5	9.50	125.00	40.00
0121810.0	10.00	133.00	43.00
0121810.2	10.20	133.00	43.00
0121810.5	10.50	133.00	43.00
0121811.0	11.00	142.00	47.00
0121811.5	11.50	142.00	47.00
0121812.0	12.00	151.00	51.00
0121812.5	12.50	151.00	51.00
0121813.0	13.00	151.00	51.00



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Cutting rate recommendations	Hardox HiTuf	Hardox 400	Hardox 450	Hardox 500
Speed (m/min)	~ 11	~ 8	~ 6	~ 4
Drill Diameter	Feed rate (mm/rev) & revolutions (RPM)			
2.50mm	0.035 / 1400	0.025 / 1000	0.015 / 770	0.005 / 500
3.00mm	0.040 / 1200	0.030 / 850	0.020 / 640	0.010 / 430
4.00mm	0.050 / 900	0.040 / 650	0.030 / 480	0.020 / 320
5.00mm	0.060 / 700	0.050 / 510	0.040 / 400	0.030 / 255
6.00mm	0.070 / 590	0.060 / 430	0.050 / 320	0.040 / 220
7.00mm	0.080 / 500	0.070 / 370	0.060 / 280	0.050 / 190
8.00mm	0.090 / 440	0.080 / 320	0.070 / 240	0.060 / 160
10.00mm	0.110 / 350	0.100 / 260	0.090 / 200	0.080 / 130
13.00mm	0.140 / 270	0.130 / 200	0.120 / 150	0.100 / 100

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