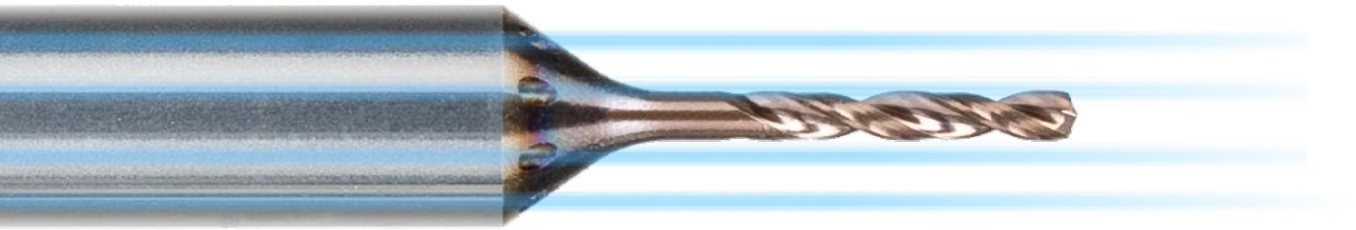
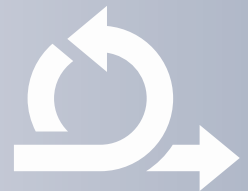


INOX - 8xD cooled

HBmicrotec[®]
ACTIONTOOLS & ENGINEERING



ACTIONDRILL[®]
by HB microtec
INOX-8xD cooled



from Ø 0.25 k6
to Ø 2.381 k6

in 0.05 mm steps
from Ø 0.25 to
Ø 2.381

140° ^{+40°}/_{-2°} α-INOX
high-performance point geometry,
self-centering

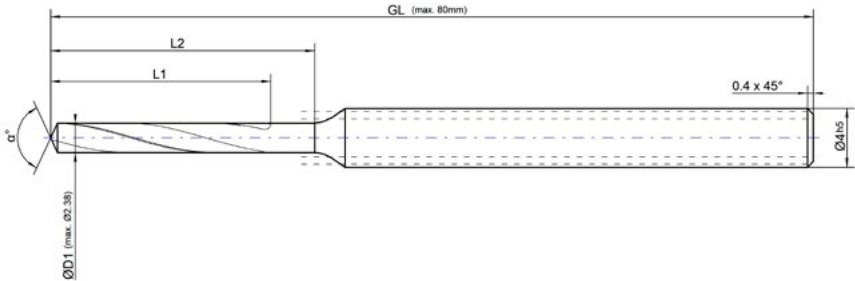
Integrated cooling channels protect
the tool from overheating and flush
away all chips

The high-performance α-INOX
coating guarantees a long tool life
and prevents the cutting edges from
sticking

The reinforced shank in h5 quality
combined with an optimized working
length makes the tool robust and
vibration-free.

High feed and cutting speeds
are made possible by the use
of ultra-fine-grained solid
carbide with high fracture
toughness.





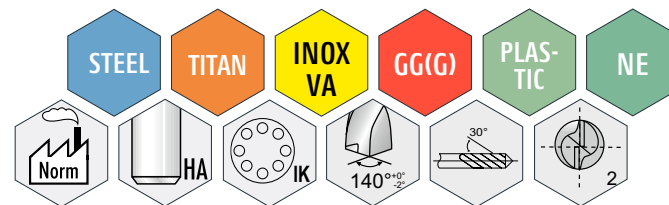
☐ Inquiry

☐ Order Order number: _____ Other: _____

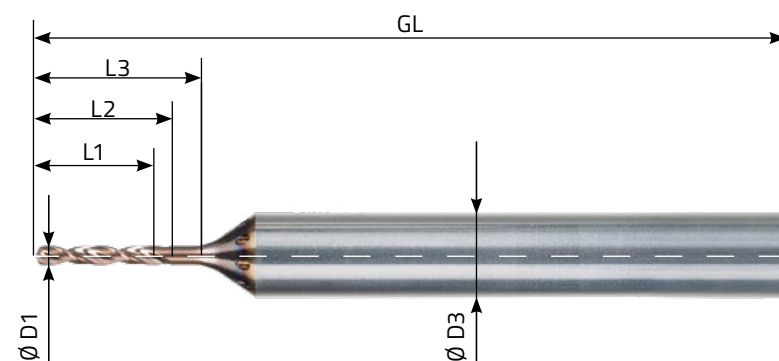
Dimensions: D ₁ : _____ GL: _____ α: _____ D ₂ : _____ L ₁ : _____ β: _____ D ₃ : _____ L ₂ : _____ γ: _____ Z: _____	Coating: ☐ Coated*: _____ ☐ Uncoated	Cooling channels: ☐ No ☐ Yes Cutting direction: ☐ Right ☐ Left
Material to be machined: _____	Shank shape: _____	Quantity: _____
Date, signature & company stamp: _____		Contact person: _____

* Without further information, the most suitable coating will be used.

INOX-8xD cooled



ACTIONDRILL
AD.030.140.IK.8D
D1: Ø 0.3 mm
Integrated cooling
8xD drilling depth
140° Point angle



■ α-INOX coated



5 PRO's of the ACTIONDRILL:

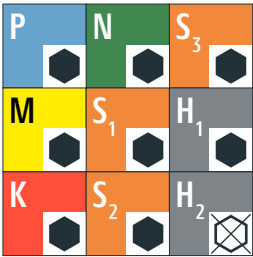
- 8xD "micro" drill with integrated cooling from Ø 0.25
- Matched to our INOX-3xD Pilot cooled
- Perfect positional accuracy
- Shorter process times and high process reliability
- Long chips are flushed out through the integrated cooling

channels without retracting

Article number	D1 k5 (mm)	D1 (inch)	D3 h5 (mm)	L1 (8xD1 / mm)	L2 (9xD1 / mm)	L3 (10xD1 / mm)	GL (mm)
AD.025.140.IK.8D	Ø 0.250	-	Ø 4.00	2.00	2.25	2.50	40.00
AD.030.140.IK.8D	Ø 0.300	-	Ø 4.00	2.40	2.70	3.00	40.00
AD.035.140.IK.8D	Ø 0.350	-	Ø 4.00	2.80	3.15	3.50	40.00
AD.040.140.IK.8D	Ø 0.400	-	Ø 4.00	3.20	3.60	4.00	40.00
AD.045.140.IK.8D	Ø 0.450	-	Ø 4.00	3.60	4.05	4.50	40.00
AD.050.140.IK.8D	Ø 0.500	-	Ø 4.00	4.00	4.50	5.00	40.00
AD.055.140.IK.8D	Ø 0.550	-	Ø 4.00	4.40	4.95	5.50	40.00
AD.060.140.IK.8D	Ø 0.600	-	Ø 4.00	4.80	5.40	6.00	40.00
AD.065.140.IK.8D	Ø 0.650	-	Ø 4.00	5.20	5.85	6.50	40.00
AD.070.140.IK.8D	Ø 0.700	-	Ø 4.00	5.60	6.30	7.00	40.00
AD.075.140.IK.8D	Ø 0.750	-	Ø 4.00	6.00	6.75	7.50	40.00
AD.080.140.IK.8D	Ø 0.800	-	Ø 4.00	6.40	7.20	8.00	40.00
AD.085.140.IK.8D	Ø 0.850	-	Ø 4.00	6.80	7.65	8.50	40.00
AD.090.140.IK.8D	Ø 0.900	-	Ø 4.00	7.20	8.10	9.00	40.00
AD.095.140.IK.8D	Ø 0.950	-	Ø 4.00	7.60	8.55	9.50	40.00
AD.100.140.IK.8D	Ø 1.000	-	Ø 4.00	8.00	9.00	10.00	50.00
AD.105.140.IK.8D	Ø 1.050	-	Ø 4.00	8.40	9.45	10.50	50.00
AD.110.140.IK.8D	Ø 1.100	-	Ø 4.00	8.80	9.90	11.00	50.00
AD.115.140.IK.8D	Ø 1.150	-	Ø 4.00	9.20	10.35	11.50	50.00
AD.120.140.IK.8D	Ø 1.200	-	Ø 4.00	9.60	10.80	12.00	50.00
AD.125.140.IK.8D	Ø 1.250	-	Ø 4.00	10.00	11.25	12.50	50.00
AD.130.140.IK.8D	Ø 1.300	-	Ø 4.00	10.40	11.70	13.00	50.00
AD.135.140.IK.8D	Ø 1.350	-	Ø 4.00	10.80	12.15	13.50	50.00
AD.140.140.IK.8D	Ø 1.400	-	Ø 4.00	11.20	12.60	14.00	50.00
AD.145.140.IK.8D	Ø 1.450	-	Ø 4.00	11.60	13.05	14.50	50.00
AD.150.140.IK.8D	Ø 1.500	-	Ø 4.00	12.00	13.50	15.00	50.00
AD.155.140.IK.8D	Ø 1.550	-	Ø 4.00	12.40	13.95	15.50	50.00
AD.1587.140.IK.8D	Ø 1.587	1/16"	Ø 4.00	12.70	14.28	15.87	50.00
AD.160.140.IK.8D	Ø 1.600	-	Ø 4.00	12.80	14.40	16.00	50.00
AD.165.140.IK.8D	Ø 1.650	-	Ø 4.00	13.20	14.85	16.50	50.00
AD.170.140.IK.8D	Ø 1.700	-	Ø 4.00	13.60	15.30	17.00	50.00
AD.175.140.IK.8D	Ø 1.750	-	Ø 4.00	14.00	15.75	17.50	50.00
AD.180.140.IK.8D	Ø 1.800	-	Ø 4.00	14.40	16.20	18.00	50.00
AD.185.140.IK.8D	Ø 1.850	-	Ø 4.00	14.80	16.65	18.50	50.00
AD.190.140.IK.8D	Ø 1.900	-	Ø 4.00	15.20	17.10	19.00	50.00
AD.195.140.IK.8D	Ø 1.950	-	Ø 4.00	15.60	17.55	19.50	50.00
AD.200.140.IK.8D	Ø 2.000	-	Ø 4.00	16.00	18.00	20.00	60.00
AD.2381.140.IK.8D	Ø 2.381	3/32"	Ø 4.00	19.05	21.50	24.00	60.00

Available from stock

Cutting data - ACTIONDRILL INOX-8xD cooled



Material group	Material group	Mat. no.	DIN	AISI/ASTM/UNS
P	Steels up to RM < 1200N/mm²	1.0044	S275JR	AISI 1020
		1.0715	11SMn30	AISI 1215
		1.7131	16MnCr5	AISI 5115
		1.3505	100Cr6	AISI 52100
		1.7225	42CrMo4	AISI 4140
M	Stainless steels: ferritic, martensitic, austenitic	1.4034	X46Cr13	AISI 420C
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH
		1.4301	X5CrNi 18-10	AISI 304
		1.4435	X2CrNiMo 18-14-3	AISI 316L
K	Cast iron	0.6020	GG20	ASTM 30
		0.6030	GG30	ASTM 40B
		0.7040	GGG40	ASTM 60-40-18
		0.7060	GGG60	ASTM 80-60-03
N	Non-ferrous metals	3.2315	AlMgSi1	ASTM 6351
		2.0065	Cu-ETP / CW004A	UNS C11000
		2.0321	CuZn37 CW508L	UNS C27400
		2.0401	CuZn39Pb3 / CW614N	UNS C38500
		2.0966	CuAl10Ni5Fe4	UNS C63000
S (S1, S2, S3)	Heat-resistant steels, titanium, CrCo	2.4617	NiMo28	Hastelloy B-2
		2.4665	NiCr22Fe18Mo	Hastelloy X
		3.7165	TiAl6V4	ASTM B348 / F136
		9.9367	TiAl6Nb7	ASTM F1295
		2.4964	CoCr20W15Ni	Haynes 25
H	Hardened steels ≥ 55 HRC		CrCoMo28	ASTM F1537
		1.2510	100MnCrMoW4	AISI O1
		1.2379	X153CrMoV12	AISI D2

Recommended use Highly suitable Partially suitable Not recommended

Ø 0.25 - 0.4 mm		Ø 0.5 - 0.8 mm		Ø 1.0 - 1.2 mm		Ø 1.5 - 2.381 mm	
vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]
60-120	0.008 - 0.01	60-120	0.012- 0.046	60-130	0.042- 0.066	60-130	0.040 - 0.12
60-100	0.08 - 0.01	60-100	0.018- 0.026	60-120	0.042- 0.056	60-130	0.040 - 0.12
50-100	0.08 - 0.01	50-100	0.009 - 0.016	50-120	0.025 - 0.04	50-120	0.040 - 0.080
50-80	0.08 - 0.01	50-80	0.008 - 0.020	50-80	0.02 - 0.038	50-90	0.040 - 0.070
80-140	0.010 - 0.014	80-140	0.012 - 0.042	80-140	0.030 - 0.042	80-160	0.08 - 0.135
80-160	0.012 - 0.016	80-160	0.012 - 0.046	80-160	0.042 - 0.066	80-160	0.08 - 0.18
80-140	0.012 - 0.016	80-140	0.026 - 0.068	80-140	0.046 - 0.088	80-160	0.08 - 0.210
80-120	0.012 - 0.014	80-120	0.024 - 0.048	80-120	0.032 - 0.088	80-140	0.085 - 0.120
15 - 50	0.08 - 0.01	15 - 50	0.025 - 0.045	15 - 50	0.025 - 0.045	15 - 60	0.060 - 0.092
15 - 50	0.08 - 0.01	15 - 50	0.025 - 0.045	15 - 50	0.025 - 0.045	15 - 60	0.060 - 0.120
15 - 50	0.08 - 0.01	15 - 50	0.020 - 0.024	15 - 50	0.020 - 0.024	15 - 50	0.055 - 0.092
15-32	0.006 - 0.009	15-32	0.006 - 0.009	15-32	0.006 - 0.009	15-32	0.006 - 0.012
no data available							

ACTIONDRILL®
by HB microtec *INOX-8xD cooled*



HB microtec®
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