

INOX-24D cooled

HBmicrotec[®]
ACTIONTOOLS & ENGINEERING



TARGET DRILL[®]
by HB microtec INOX-24xD cooled



24xD

24xD drill
from Ø 1.0 k5
to Ø 6.0 k5

in 0.05 mm steps
from Ø 1.0 to Ø 4.0
in 0.10 mm steps from
Ø 4.0 to Ø 6.0

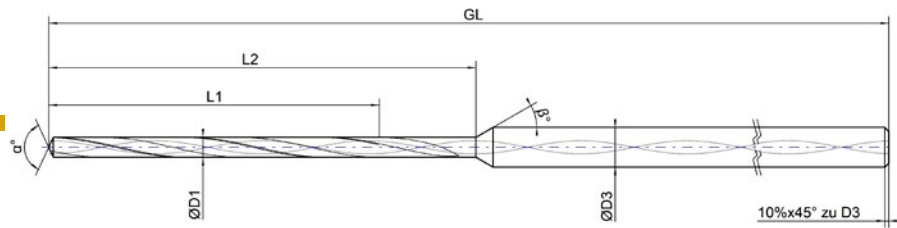
130° INOX
high-performance point geometry
drill Ø in k5 tolerance
with internal cooling (IK)

4 margins ensure perfect
guidance of the twist drill

The α-INOXcronos coating
guarantees long tool life and
prevents the cutting edges from
sticking

Fine-grain solid carbide (high
cutting and feed rates are
possible)

Shaft according to DIN
6535 HA h6 shank Ø tole-
rance



☐ Inquiry

☐ Order

Order number: _____ Other: _____

Dimensions:

D₁: _____ GL: _____ α: _____
D₃: _____ L₁: _____ β: _____
L₂: _____ Z: _____

Coating:

☐ Coated*: _____
☐ Uncoated

Cooling channels:

☐ Yes ☐ No

Cutting direction:

☐ Left ☐ Right

Material to be machined:

Shank shape:

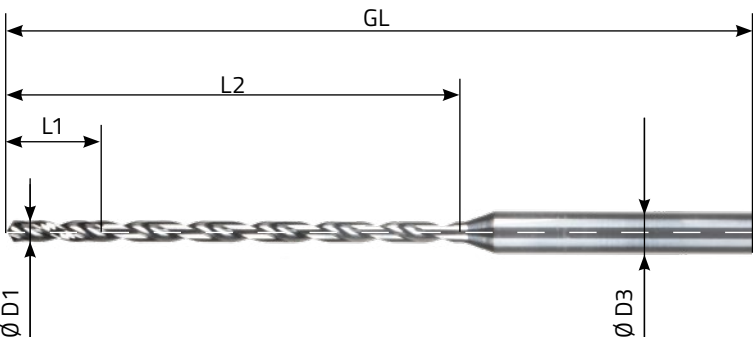
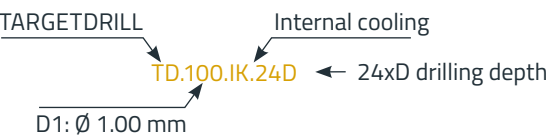
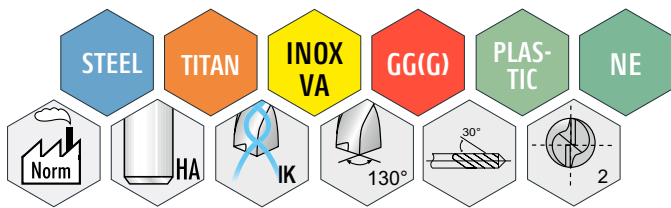
Quantity:

Date, signature & company stamp:

Contact person:

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

INOX-24xD cooled



■ α-INOXcronos coated



5 PRO's of the TARGETDRILL:

- Helical deep hole drill with internal cooling
- Perfect alignment accuracy - 24xD with 4 margins
- High cutting and feed speeds possible
- High performance & positioning accuracy
- A plus for your process reliability and quality

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.100.IK.24D	Ø1.00	-	Ø3.00	4.40	27.30	64.00
TD.105.IK.24D	Ø1.05	-	Ø3.00	4.65	28.70	64.00
TD.110.IK.24D	Ø1.10	-	Ø3.00	4.85	30.00	64.00
TD.115.IK.24D	Ø1.15	-	Ø3.00	5.10	31.40	64.00
TD.120.IK.24D	Ø1.20	-	Ø3.00	5.30	32.80	64.00
TD.125.IK.24D	Ø1.25	-	Ø3.00	5.50	34.20	64.00
TD.130.IK.24D	Ø1.30	-	Ø3.00	5.75	35.50	72.00
TD.135.IK.24D	Ø1.35	-	Ø3.00	5.95	36.90	72.00
TD.140.IK.24D	Ø1.40	-	Ø3.00	6.20	38.20	72.00
TD.145.IK.24D	Ø1.45	-	Ø3.00	6.40	39.60	72.00
TD.150.IK.24D	Ø1.50	-	Ø3.00	6.60	41.00	72.00
TD.155.IK.24D	Ø1.55	-	Ø3.00	6.85	42.30	80.00
TD.1588.IK.24D	Ø1.588	1/16"	Ø3.00	7.00	43.40	80.00
TD.160.IK.24D	Ø1.60	-	Ø3.00	7.05	43.70	80.00
TD.165.IK.24D	Ø1.65	-	Ø3.00	7.30	45.10	80.00
TD.170.IK.24D	Ø1.70	-	Ø3.00	7.50	46.40	80.00
TD.175.IK.24D	Ø1.75	-	Ø3.00	7.70	47.80	80.00
TD.180.IK.24D	Ø1.80	-	Ø3.00	7.95	49.20	88.00
TD.185.IK.24D	Ø1.85	-	Ø3.00	8.15	50.50	88.00
TD.190.IK.24D	Ø1.90	-	Ø3.00	8.40	51.90	88.00
TD.195.IK.24D	Ø1.95	-	Ø3.00	8.60	53.30	88.00
TD.200.IK.24D	Ø2.00	-	Ø4.00	8.80	54.60	88.00
TD.205.IK.24D	Ø2.05	-	Ø4.00	9.05	56.00	94.00
TD.210.IK.24D	Ø2.10	-	Ø4.00	9.25	57.40	94.00
TD.215.IK.24D	Ø2.15	-	Ø4.00	9.50	58.70	94.00
TD.220.IK.24D	Ø2.20	-	Ø4.00	9.70	60.10	94.00
TD.225.IK.24D	Ø2.25	-	Ø4.00	9.90	61.50	94.00
TD.230.IK.24D	Ø2.30	-	Ø4.00	10.15	63.00	100.00
TD.235.IK.24D	Ø2.35	-	Ø4.00	10.35	64.20	100.00
TD.2381.IK.24D	Ø2.381	3/32"	Ø4.00	10.50	65.00	100.00
TD.240.IK.24D	Ø2.40	-	Ø4.00	10.60	65.60	100.00
TD.245.IK.24D	Ø2.45	-	Ø4.00	10.80	66.90	100.00
TD.250.IK.24D	Ø2.50	-	Ø4.00	11.00	68.30	100.00
TD.255.IK.24D	Ø2.55	-	Ø4.00	11.25	69.60	106.00
TD.260.IK.24D	Ø2.60	-	Ø4.00	11.45	71.00	106.00
TD.265.IK.24D	Ø2.65	-	Ø4.00	11.70	72.40	106.00
TD.270.IK.24D	Ø2.70	-	Ø4.00	11.90	73.70	106.00
TD.275.IK.24D	Ø2.75	-	Ø4.00	12.10	75.10	106.00
TD.280.IK.24D	Ø2.80	-	Ø4.00	12.35	76.50	110.00
TD.285.IK.24D	Ø2.85	-	Ø4.00	12.55	77.80	110.00
TD.290.IK.24D	Ø2.90	-	Ø4.00	12.80	79.20	110.00
TD.295.IK.24D	Ø2.95	-	Ø4.00	13.00	80.60	110.00
TD.300.IK.24D	Ø3.00	-	Ø6.00	13.20	81.90	114.00
TD.305.IK.24D	Ø3.05	-	Ø6.00	13.45	83.30	114.00
TD.310.IK.24D	Ø3.10	-	Ø6.00	13.65	84.70	114.00
TD.315.IK.24D	Ø3.15	-	Ø6.00	13.90	86.00	114.00
TD.3175.IK.24D	Ø3.175	1/8"	Ø6.00	14.00	86.70	125.00
TD.320.IK.24D	Ø3.20	-	Ø6.00	14.10	87.40	125.00

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.325.IK.24D	Ø3.25	-	Ø6.00	14.30	88.80	125.00
TD.330.IK.24D	Ø3.30	-	Ø6.00	14.55	90.10	125.00
TD.335.IK.24D	Ø3.35	-	Ø6.00	14.75	91.50	125.00
TD.340.IK.24D	Ø3.40	-	Ø6.00	15.00	92.90	125.00
TD.345.IK.24D	Ø3.45	-	Ø6.00	15.20	94.20	125.00
TD.350.IK.24D	Ø3.50	-	Ø6.00	15.40	95.60	125.00
TD.355.IK.24D	Ø3.55	-	Ø6.00	15.65	97.00	125.00
TD.360.IK.24D	Ø3.60	-	Ø6.00	15.85	98.30	145.00
TD.365.IK.24D	Ø3.65	-	Ø6.00	16.10	99.70	145.00
TD.370.IK.24D	Ø3.70	-	Ø6.00	16.30	101.00	145.00
TD.375.IK.24D	Ø3.75	-	Ø6.00	16.50	102.40	145.00
TD.380.IK.24D	Ø3.80	-	Ø6.00	16.75	103.80	145.00
TD.385.IK.24D	Ø3.85	-	Ø6.00	16.95	105.10	145.00
TD.390.IK.24D	Ø3.90	-	Ø6.00	17.20	106.50	145.00
TD.395.IK.24D	Ø3.95	-	Ø6.00	17.40	107.90	145.00
TD.3969.IK.24D	Ø3.969	5/32"	Ø6.00	17.50	108.40	145.00
TD.400.IK.24D	Ø4.00	-	Ø6.00	17.60	109.20	145.00
TD.410.IK.24D	Ø4.10	-	Ø6.00	18.05	112.00	145.00
TD.420.IK.24D	Ø4.20	-	Ø6.00	18.50	114.70	145.00
TD.430.IK.24D	Ø4.30	-	Ø6.00	18.95	117.40	145.00
TD.440.IK.24D	Ø4.40	-	Ø6.00	19.40	120.20	165.00
TD.450.IK.24D	Ø4.50	-	Ø6.00	19.80	122.90	165.00
TD.460.IK.24D	Ø4.60	-	Ø6.00	20.25	125.60	165.00
TD.470.IK.24D	Ø4.70	-	Ø6.00	20.70	128.40	165.00
TD.4763.IK.24D	Ø4.763	3/16"	Ø6.00	21.00	130.00	165.00
TD.480.IK.24D	Ø4.80	-	Ø6.00	21.15	131.10	165.00
TD.490.IK.24D	Ø4.90	-	Ø6.00	21.60	133.80	165.00
TD.500.IK.24D	Ø5.00	-	Ø6.00	22.00	136.50	165.00
TD.510.IK.24D	Ø5.10	-	Ø6.00	22.45	139.30	200.00
TD.520.IK.24D	Ø5.20	-	Ø6.00	22.90	142.00	200.00
TD.530.IK.24D	Ø5.30	-	Ø6.00	23.35	144.70	200.00
TD.540.IK.24D	Ø5.40	-	Ø6.00	23.80	147.50	200.00
TD.550.IK.24D	Ø5.50	-	Ø6.00	24.20	150.20	200.00
TD.5556.IK.24D	Ø5.556	7/32"	Ø6.00	24.50	151.70	200.00
TD.560.IK.24D	Ø5.60	-	Ø6.00	24.65	152.90	200.00
TD.570.IK.24D	Ø5.70	-	Ø6.00	25.10	155.60	200.00
TD.580.IK.24D	Ø5.80	-	Ø6.00	25.55	158.40	200.00
TD.590.IK.24D	Ø5.90	-	Ø6.00	26.00	161.10	200.00
TD.600.IK.24D	Ø6.00	-	Ø6.00	26.40	163.80	200.00
TD.6350.IK.24D	Ø6.35	1/4"	Ø8.00	28.00	173.40	220.00

Available from stock

24xD

4 margins ensure perfect guidance of the twist drill.

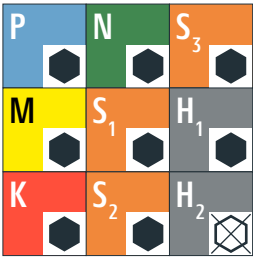
130°-INOX high-performance point geometry drill Ø in k5 tolerance with internal cooling (IK).

The α-INOXcronos coating ensures long tool life and prevents cutting edge build-up.

Fine-grain solid carbide (high cutting and feed rates are possible)

Shank according to DIN6535 HA h6 shank Ø tolerance.





Material group	Material group	Mat. no.	DIN	AISI/ASTM/UNS
P	Steels up to RM < 1200N/mm ²	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 ≥ 60 HRC		CrCoMo28	ASTM F1537
		1.2510	100MnCrMoW4	AISI O1
		1.2379	X153CrMoV12	AISI D2

Recommended use Highly suitable Partially suitable Not recommended

Ø 1.0 - 1.2 mm		Ø 1.5 - 1.8 mm		Ø 2.0 - 2.5 mm		Ø 3.0 - 4.0 mm		Ø 5.0 - 6.0 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]	vc [m/min]	f [mm/U]
60-130	0.05- 0.066	60-130	0.122 - 0.128	60-130	0.130 - 0.182	60-140	0.128 - 0.232	60-160	0.150 - 0.280
60-120	0.05- 0.056	60-120	0.120 - 0.122	60-130	0.130 - 0.182	60-120	0.128 - 0.202	60-150	0.150 - 0.260
50-120	0.03 - 0.04	50-120	0.043 - 0.055	50-120	0.060 - 0.080	50-100	0.074 - 0.098	50-120	0.10 - 0.185
50-80	0.025 - 0.038	50-80	0.040 - 0.068	50-90	0.050 - 0.070	50-90	0.072 - 0.084	50-100	0.10 - 0.175
80-140	0.035 - 0.042	80-140	0.06 - 0.115	80-160	0.126 - 0.135	80-160	0.100 - 0.145	80-180	0.110 - 0.210
80-160	0.042 - 0.066	80-160	0.096 - 0.122	80-160	0.132 - 0.18	80-160	0.136 - 0.172	80-180	0.200 - 0.250
80-140	0.046 - 0.088	80-140	0.098 - 0.122	80-160	0.132 - 0.210	80-160	0.134 - 0.164	80-180	0.200 - 0.252
80-120	0.032 - 0.088	80-120	0.066 - 0.122	80-140	0.085 - 0.120	80-120	0.132 - 0.162	80-160	0.195 - 0.242
15 - 50	0.025 - 0.05	15 - 50	0.049 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.12
15 - 50	0.025 - 0.05	15 - 50	0.048 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.12
15 - 50	0.020 - 0.04	15 - 50	0.05 - 0.060	15 - 50	0.055 - 0.07	15 - 60	0.052 - 0.08	15 - 75	0.076 - 0.12
15-32	0.006 - 0.01	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.006 - 0.014	15-40	0.009 - 0.018
15-32	0.006 - 0.01	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.006 - 0.014	15-40	0.009 - 0.018

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