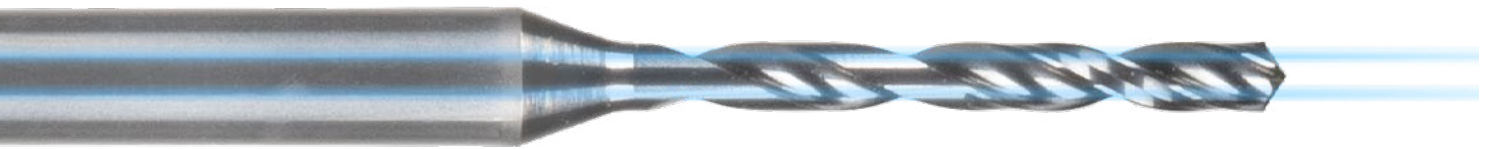
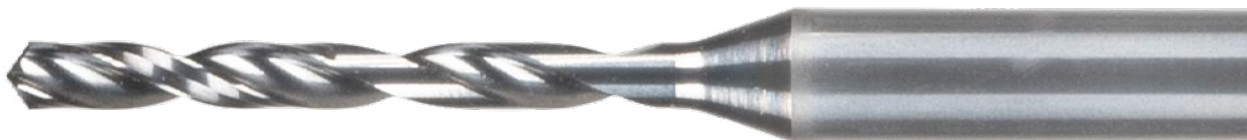


INOX-6D cooled

HBmicrotec[®]
ACTIONTOOLS & ENGINEERING



TARGET DRILL[®]
by HB microtec INOX-6xD cooled



6xD
from Ø 0.75 k5
to Ø 7.2 k5

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

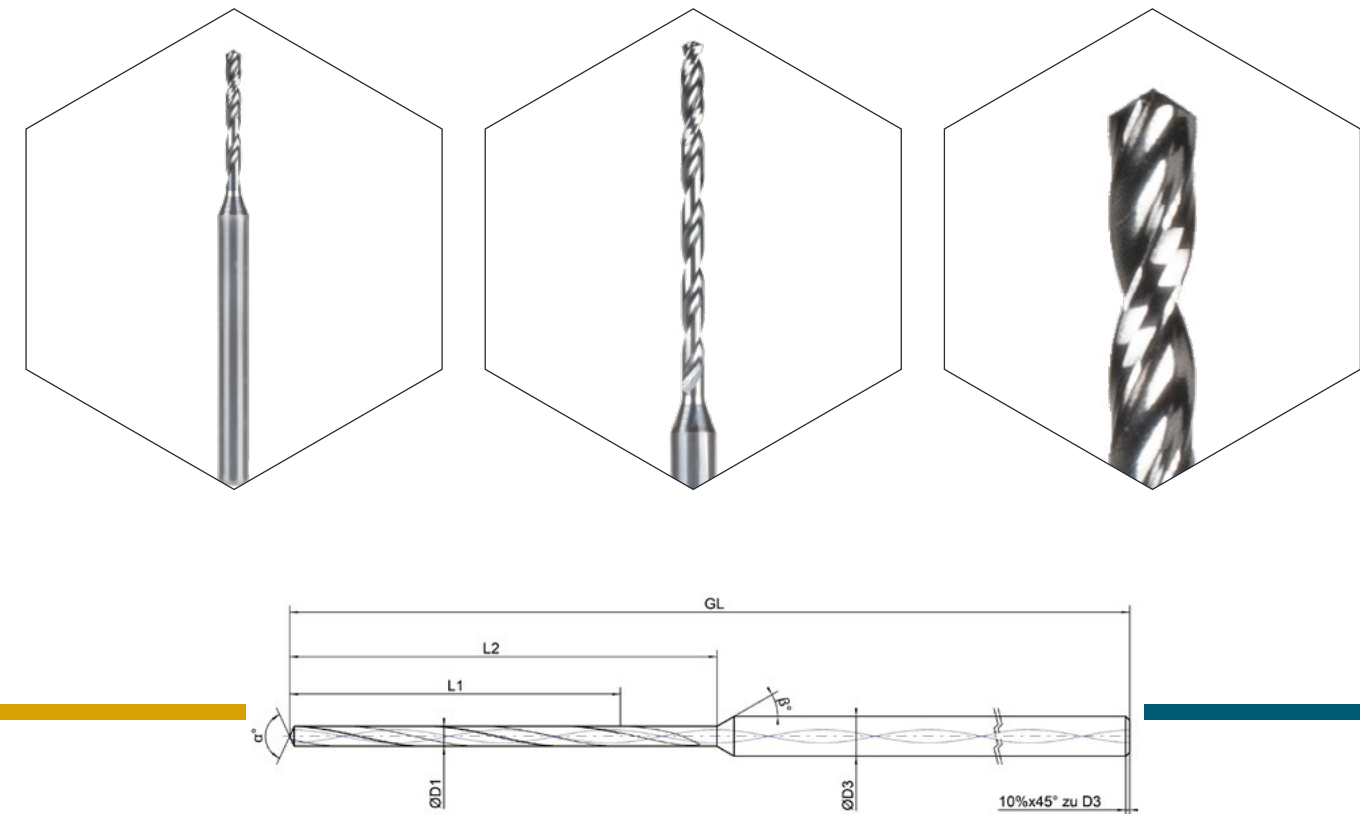
4 margins ensure perfect
guidance of the twist drill

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
tolerance

TARGETDRILL[®]
by HB microtec
INOX-6xD cooled



☐ Inquiry

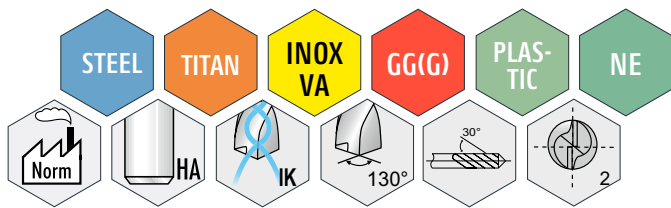
☐ Order

Order number: _____ Other: _____

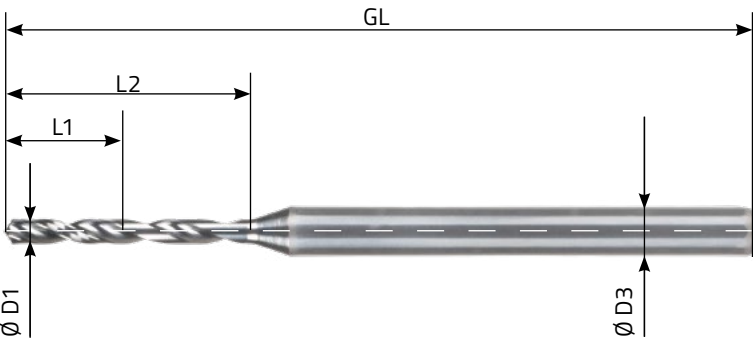
Dimensions: D ₁ : _____ GL: _____ α: _____ D ₃ : _____ L ₁ : _____ β: _____ L ₂ : _____ Z: _____	Coating: ☐ Coated*: _____ ☐ Uncoated	With cooling channels? ☐ Yes ☐ No Cutting direction: ☐ Left ☐ Right
Material to be machined: _____	Shank shape: _____	Quantity: _____
Date, signature & company stamp: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

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

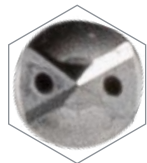
INOX-6xD cooled



TARGETDRILL
TD.100.IK.6D
D1: Ø 1.00 mm
Internal cooling
6xD drilling depth



■ α-INOXcronos coated



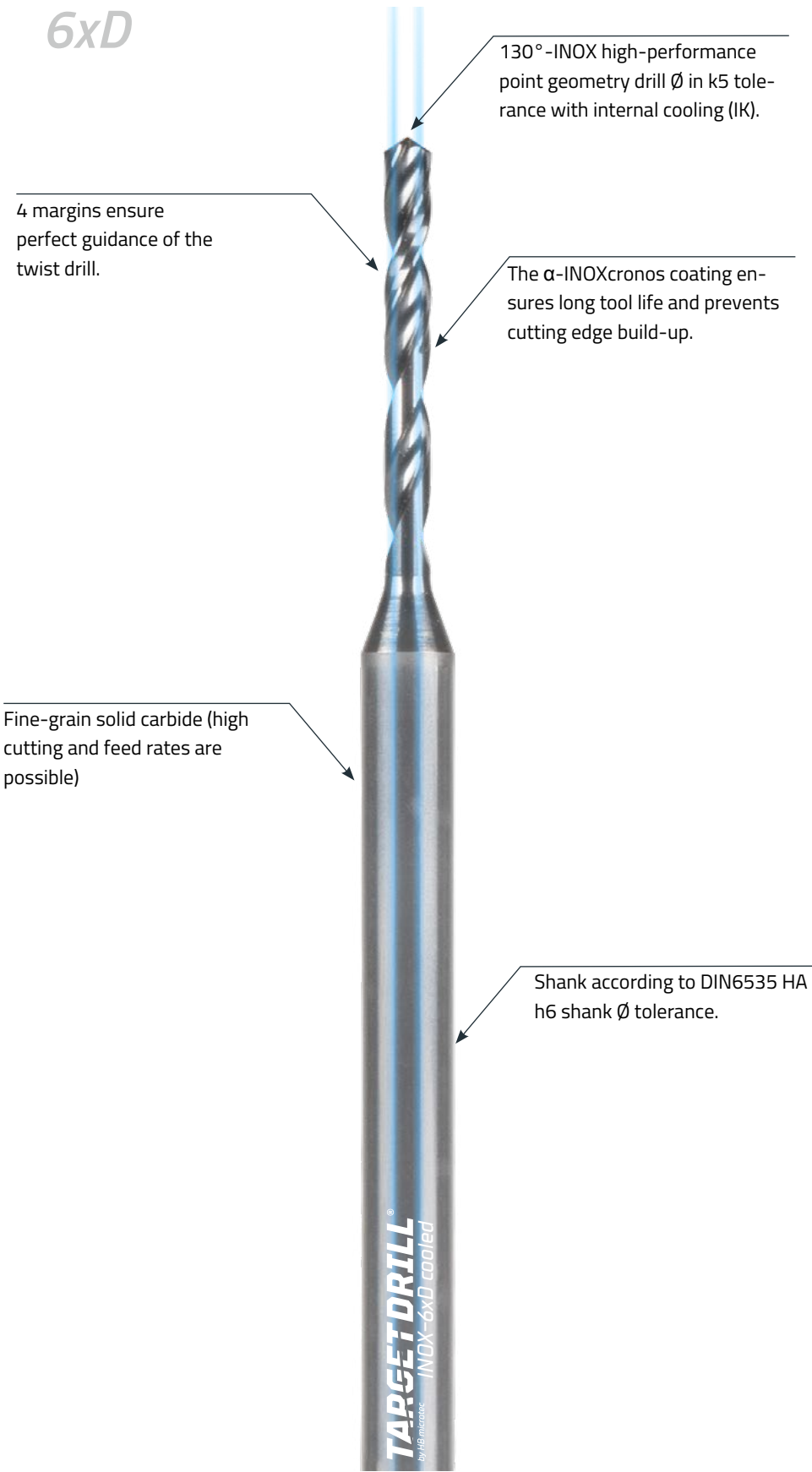
5 PRO's of the TARGETDRILL:

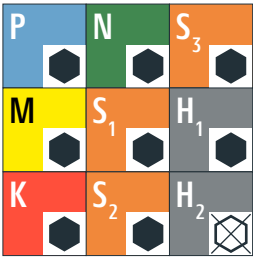
- Self-centering
- Perfect alignment accuracy - 6xD with 4 margins
- High cutting and feed speeds possible
- High performance & positioning accuracy
- A plus for your process reliability and quality

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.075.IK.6D	Ø 0.75	-	Ø 3.00	3.30	6.75	50.00
TD.080.IK.6D	Ø 0.80	-	Ø 3.00	3.52	7.20	50.00
TD.085.IK.6D	Ø 0.85	-	Ø 3.00	3.74	7.65	50.00
TD.090.IK.6D	Ø 0.90	-	Ø 3.00	3.96	8.10	50.00
TD.095.IK.6D	Ø 0.95	-	Ø 3.00	4.18	8.55	50.00
TD.100.IK.6D	Ø 1.00	-	Ø 3.00	4.40	9.30	50.00
TD.105.IK.6D	Ø 1.05	-	Ø 3.00	4.65	9.80	50.00
TD.110.IK.6D	Ø 1.10	-	Ø 3.00	4.85	10.25	50.00
TD.115.IK.6D	Ø 1.15	-	Ø 3.00	5.10	10.70	50.00
TD.120.IK.6D	Ø 1.20	-	Ø 3.00	5.30	11.20	50.00
TD.125.IK.6D	Ø 1.25	-	Ø 3.00	5.50	11.65	50.00
TD.130.IK.6D	Ø 1.30	-	Ø 3.00	5.75	12.10	52.00
TD.135.IK.6D	Ø 1.35	-	Ø 3.00	5.95	12.60	52.00
TD.140.IK.6D	Ø 1.40	-	Ø 3.00	6.20	13.05	52.00
TD.145.IK.6D	Ø 1.45	-	Ø 3.00	6.40	13.50	52.00
TD.150.IK.6D	Ø 1.50	-	Ø 3.00	6.60	13.95	52.00
TD.155.IK.6D	Ø 1.55	-	Ø 3.00	6.85	14.45	55.00
TD.1588.IK.6D	Ø 1.588	1/16"	Ø 3.00	7.00	14.30	55.00
TD.160.IK.6D	Ø 1.60	-	Ø 3.00	7.05	14.90	55.00
TD.165.IK.6D	Ø 1.65	-	Ø 3.00	7.30	15.35	55.00
TD.170.IK.6D	Ø 1.70	-	Ø 3.00	7.50	15.85	55.00
TD.175.IK.6D	Ø 1.75	-	Ø 3.00	7.70	16.30	55.00
TD.180.IK.6D	Ø 1.80	-	Ø 3.00	7.95	16.75	57.00
TD.185.IK.6D	Ø 1.85	-	Ø 3.00	8.15	17.25	57.00
TD.190.IK.6D	Ø 1.90	-	Ø 3.00	8.40	17.70	57.00
TD.195.IK.6D	Ø 1.95	-	Ø 3.00	8.60	18.15	57.00
TD.200.IK.6D	Ø 2.00	-	Ø 4.00	8.80	18.60	57.00
TD.203.IK.6D	Ø 2.03	-	Ø 4.00	9.05	19.10	60.00
TD.205.IK.6D	Ø 2.05	-	Ø 4.00	9.05	19.10	60.00
TD.210.IK.6D	Ø 2.10	-	Ø 4.00	9.25	19.55	60.00
TD.215.IK.6D	Ø 2.15	-	Ø 4.00	9.50	20.00	60.00
TD.220.IK.6D	Ø 2.20	-	Ø 4.00	9.70	20.50	60.00
TD.225.IK.6D	Ø 2.25	-	Ø 4.00	9.90	20.95	60.00
TD.230.IK.6D	Ø 2.30	-	Ø 4.00	10.15	21.40	62.00
TD.233.IK.6D	Ø 2.33	-	Ø 4.00	10.35	21.90	62.00
TD.235.IK.6D	Ø 2.35	-	Ø 4.00	10.35	21.90	62.00
TD.2381.IK.6D	Ø 2.381	3/32"	Ø 4.00	10.5	21.40	62.00
TD.240.IK.6D	Ø 2.40	-	Ø 4.00	10.60	22.35	62.00
TD.245.IK.6D	Ø 2.45	-	Ø 4.00	10.80	22.80	62.00
TD.250.IK.6D	Ø 2.50	-	Ø 4.00	11.00	23.25	62.00
TD.255.IK.6D	Ø 2.55	-	Ø 4.00	11.25	23.75	65.00
TD.260.IK.6D	Ø 2.60	-	Ø 4.00	11.45	24.20	65.00
TD.265.IK.6D	Ø 2.65	-	Ø 4.00	11.70	24.65	65.00
TD.270.IK.6D	Ø 2.70	-	Ø 4.00	11.90	25.15	65.00
TD.275.IK.6D	Ø 2.75	-	Ø 4.00	12.10	25.60	65.00
TD.280.IK.6D	Ø 2.80	-	Ø 4.00	12.35	26.05	67.00
TD.285.IK.6D	Ø 2.85	-	Ø 4.00	12.55	26.55	67.00
TD.290.IK.6D	Ø 2.90	-	Ø 4.00	12.80	27.00	67.00
TD.295.IK.6D	Ø 2.95	-	Ø 4.00	13.00	27.45	67.00
TD.300.IK.6D	Ø 3.00	-	Ø 6.00	13.20	27.90	70.00
TD.305.IK.6D	Ø 3.05	-	Ø 6.00	13.45	28.40	70.00
TD.310.IK.6D	Ø 3.10	-	Ø 6.00	13.65	28.85	70.00
TD.315.IK.6D	Ø 3.15	-	Ø 6.00	13.90	29.30	70.00
TD.3175.IK.6D	Ø 3.175	1/8"	Ø 6.00	14.00	28.60	70.00

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.320.IK.6D	Ø 3.20	-	Ø 6.00	14.10	29.80	70.00
TD.325.IK.6D	Ø 3.25	-	Ø 6.00	14.30	30.25	70.00
TD.330.IK.6D	Ø 3.30	-	Ø 6.00	14.55	30.70	72.00
TD.335.IK.6D	Ø 3.35	-	Ø 6.00	14.75	31.20	72.00
TD.340.IK.6D	Ø 3.40	-	Ø 6.00	15.00	31.65	72.00
TD.345.IK.6D	Ø 3.45	-	Ø 6.00	15.20	32.10	72.00
TD.350.IK.6D	Ø 3.50	-	Ø 6.00	15.40	32.55	72.00
TD.355.IK.6D	Ø 3.55	-	Ø 6.00	15.65	33.05	75.00
TD.360.IK.6D	Ø 3.60	-	Ø 6.00	15.85	33.50	75.00
TD.365.IK.6D	Ø 3.65	-	Ø 6.00	16.10	33.95	75.00
TD.370.IK.6D	Ø 3.70	-	Ø 6.00	16.30	34.45	75.00
TD.375.IK.6D	Ø 3.75	-	Ø 6.00	16.50	34.90	75.00
TD.380.IK.6D	Ø 3.80	-	Ø 6.00	16.75	35.35	77.00
TD.385.IK.6D	Ø 3.85	-	Ø 6.00	16.95	35.85	77.00
TD.390.IK.6D	Ø 3.90	-	Ø 6.00	17.20	36.30	77.00
TD.395.IK.6D	Ø 3.95	-	Ø 6.00	17.40	36.75	77.00
TD.3969.IK.6D	Ø3.969	5/32"	Ø 6.00	17.50	35.70	80.00
TD.400.IK.6D	Ø 4.00	-	Ø 6.00	17.60	37.20	80.00
TD.410.IK.6D	Ø 4.10	-	Ø 6.00	18.05	38.15	80.00
TD.420.IK.6D	Ø 4.20	-	Ø 6.00	18.50	39.10	80.00
TD.430.IK.6D	Ø 4.30	-	Ø 6.00	18.95	40.00	80.00
TD.440.IK.6D	Ø 4.40	-	Ø 6.00	19.40	40.95	80.00
TD.450.IK.6D	Ø 4.50	-	Ø 6.00	19.80	41.85	80.00
TD.460.IK.6D	Ø 4.60	-	Ø 6.00	20.25	42.80	85.00
TD.465.IK.6D	Ø 4.65	-	Ø 6.00	20.46	41.85	85.00
TD.470.IK.6D	Ø 4.70	-	Ø 6.00	20.70	43.75	85.00
TD.4763.IK.6D	Ø 4.763	3/16"	Ø 6.00	21.00	42.90	85.00
TD.480.IK.6D	Ø 4.80	-	Ø 6.00	21.15	44.65	85.00
TD.490.IK.6D	Ø 4.90	-	Ø 6.00	21.60	45.60	85.00
TD.500.IK.6D	Ø 5.00	-	Ø 6.00	22.00	46.50	85.00
TD.510.IK.6D	Ø 5.10	-	Ø 6.00	22.45	47.45	90.00
TD.520.IK.6D	Ø 5.20	-	Ø 6.00	22.90	48.40	90.00
TD.530.IK.6D	Ø 5.30	-	Ø 6.00	23.35	49.30	90.00
TD.540.IK.6D	Ø 5.40	-	Ø 6.00	23.80	50.25	90.00
TD.550.IK.6D	Ø 5.50	-	Ø 6.00	24.20	51.15	90.00
TD.5556.IK.6D	Ø 5.556	7/32"	Ø 6.00	24.50	50.00	95.00
TD.560.IK.6D	Ø 5.60	-	Ø 6.00	24.65	52.10	95.00
TD.570.IK.6D	Ø 5.70	-	Ø 6.00	25.10	53.05	95.00
TD.580.IK.6D	Ø 5.80	-	Ø 6.00	25.55	53.95	95.00
TD.590.IK.6D	Ø 5.90	-	Ø 6.00	26.00	54.90	95.00
TD.600.IK.6D	Ø 6.00	-	Ø 6.00	26.40	55.80	95.00
TD.620.IK.6D	Ø 6.20	-	Ø 6.00	28.00	57.20	95.00
TD.6350.IK.6D	Ø6.35	1/4"	Ø 6.00	28.00	57.20	95.00
TD.660.IK.6D	Ø6.60	-	Ø 6.00	28.00	57.20	95.00
TD.670.IK.6D	Ø6.70	-	Ø 6.00	28.00	57.20	95.00
TD.680.IK.6D	Ø6.80	-	Ø 6.00	28.00	57.20	95.00
TD.690.IK.6D	Ø6.90	-	Ø 6.00	28.00	57.20	95.00
TD.700.IK.6D	Ø7.00	-	Ø 6.00	28.00	57.20	95.00
TD.720.IK.6D	Ø7.20	-	Ø 6.00	28.00	57.20	95.00

Available from stock





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 - 7.2 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	0.042 - 0.066	60-130	0.122 - 0.128	60-130	0.130 - 0.182	60-140	0.128 - 0.232	60-160	0.220 - 0.280
60-120	0.042 - 0.056	60-120	0.120 - 0.122	60-130	0.130 - 0.182	60-120	0.128 - 0.202	60-150	0.200 - 0.260
50-120	0.025 - 0.04	50-120	0.043 - 0.055	50-120	0.060 - 0.080	50-100	0.074 - 0.098	50-120	0.115 - 0.185
50-80	0.02 - 0.038	50-80	0.040 - 0.068	50-90	0.050 - 0.070	50-90	0.072 - 0.084	50-100	0.115 - 0.175
80-140	0.030 - 0.042	80-140	0.06 - 0.115	80-160	0.126 - 0.135	80-160	0.100 - 0.145	80-180	0.145 - 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 - 0.045	15 - 50	0.049 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.10
15 - 50	0.025 - 0.045	15 - 50	0.048 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.10
15 - 50	0.020 - 0.024	15 - 50	0.05 - 0.060	15 - 50	0.055 - 0.07	15 - 60	0.052 - 0.08	15 - 75	0.076 - 0.10
15-32	0.006 - 0.009	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.009 - 0.014	15-40	0.009 - 0.018
15-32	0.006 - 0.009	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.009 - 0.014	15-40	0.009 - 0.018

TARGET DRILL[®]

by HB microtec *INOX-6xD cooled*



HB^{micro}tec[®]
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