



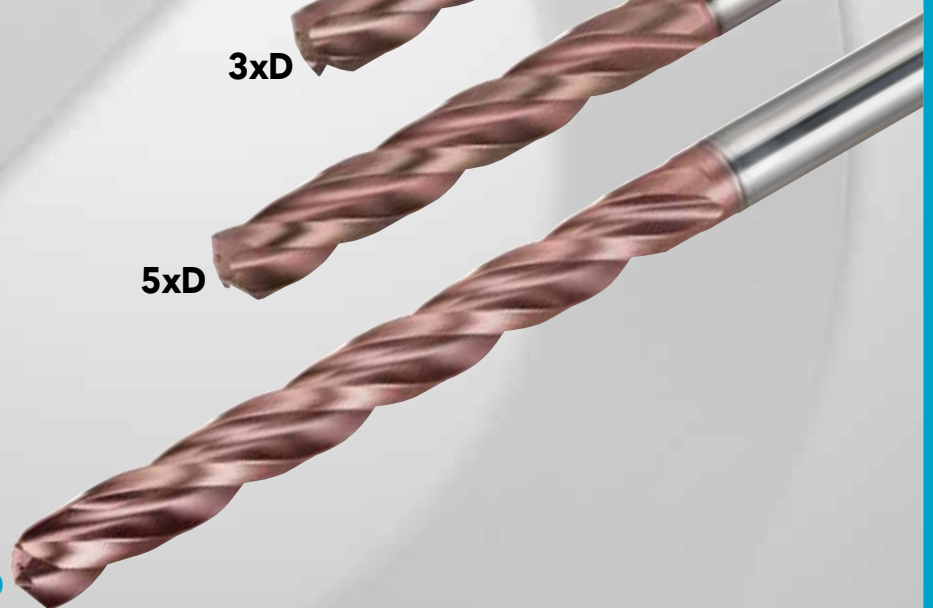
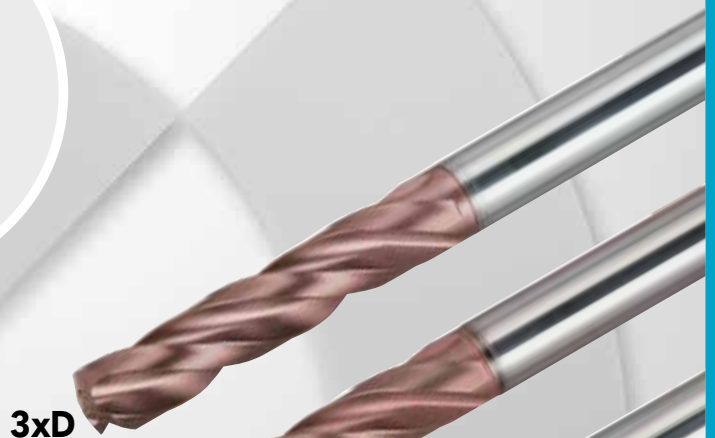
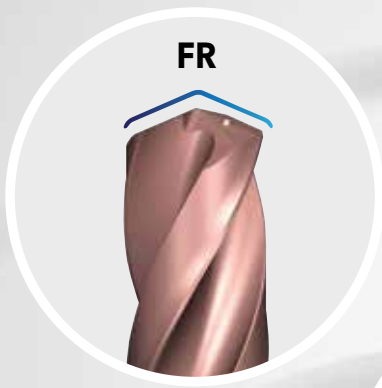
WINSFEED

SOLIDDRILL^B

3 FLUTES SOLID CARBIDE DRILL 8XD

8XD DRILLING DEPTH AND NEW FLAT BOTTOM GEOMETRY

- Drill range: $\varnothing 4.0$ - 12.0 mm (0.5 mm increments)
- 3-flute design improves productivity
- Stable drilling under high cutting conditions
- Polished, optimal geometry flutes enable smooth chip evacuation
- Internal coolant through-type solid carbide drills
- Two machining steps reduced to one



Product Overview

A flat bottom geometry and an 8xD drill for drilling deeper holes are now available in the extremely productive SolidDrill³ range.

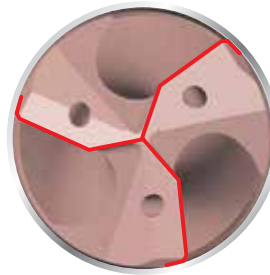
The SolidDrill³ line now includes an 8xD drilling depth option for deeper hole drilling and a flat-bottom geometry type. With three flutes and a unique point design for self-centering, the line outperforms two effective edge drills in terms of productivity.

With the expansion to 8xD, following the current 3xD and 5xD depths, end-users can experience the same high tolerance hole precision at various drilling depths.

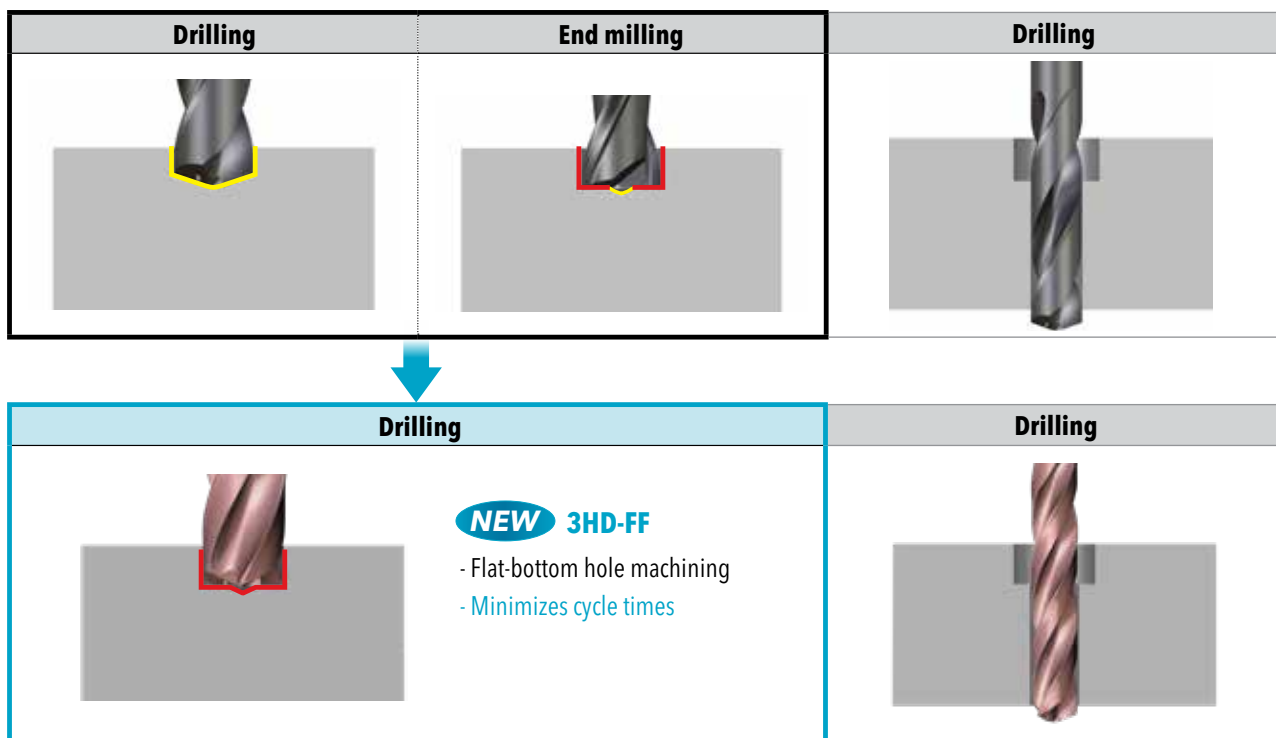
The new flat bottom design of the SolidDrill³ is ideal for drilling cavities in bolts and ensures excellent performance in both cast iron and steel applications.

Technical Features & Advantages

- Drill range: Ø4.0-12.0 mm (0.5 mm increments)
- 3-flute design improves productivity
- Stable drilling under high cutting conditions
- Polished, optimal geometry flutes enable smooth chip evacuation
- Internal coolant through-type solid carbide drills



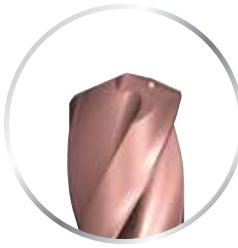



Two steps reduced to one



Technical Features




3 flute solid carbide drill for deep hole drilling (3HD-FR8)

- Drilling depth: 3xD, 5xD and 8xD
- Symmetric point design enables drilling without a pre-hole

Head shape	Drill	
<p>3HD-FR</p> 	3xD	
	5xD	
	8xD NEW	

3 flute solid carbide drill for flat-bottom hole drilling (3HD-FF)

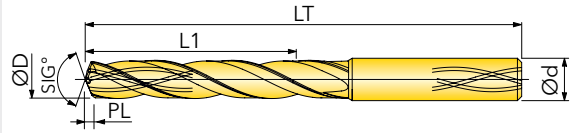
- Drilling depth: 3xD, 5xD
- Premium hole precision and excellent performance in flat bottom hole applications
- Reduced cycle time for improved productivity and cost reduction

Head shape	Drill	
<p>3HD-FF</p> 	3xD NEW	
	5xD NEW	



SOLIDDRILL³ SOLID CARBIDE DRILL 8D Z=3 Ø4,0-12,0

ADAPTION ACC. TO DIN 6535 HA



Grade	P	M	K	N_(K)	S_(M)	H _(PK)		D	m7
IN2205	+		+					d	d6

first choice
 second choice
 ▼ roughing
 ▼▼ semi-finishing
 ▼▼▼ finishing



Designation	D	d	LT	L1	PL	I	Z	IK	kg
FR0400036T7R01	4	6	74	17	0,17	140	3	✓	0,022
FR0450036T7R01	4,5	6	74	17	0,19	140	3	✓	0,023
FR0500048T7R01	5	6	82	20	0,21	140	3	✓	0,023
FR0550048T7R01	5,5	6	82	20	0,23	140	3	✓	0,025
FR0600048T7R01	6	6	82	20	0,23	140	3	✓	0,030
FR0650064TOR01	6,5	8	91	24	0,28	140	3	✓	0,047
FR0700064TOR01	7	8	91	24	0,28	140	3	✓	0,049
FR0750064TOR01	7,5	8	91	29	0,32	140	3	✓	0,052
FR0800064TOR01	8	8	91	29	0,32	140	3	✓	0,055
FR0850080T1R01	8,5	10	103	35	0,36	130	3	✓	0,086
FR0900080T1R01	9	10	103	35	0,36	130	3	✓	0,090
FR0950080T1R01	9,5	10	103	35	0,39	130	3	✓	0,094
FR1000080T1R01	10	10	103	35	0,39	130	3	✓	0,105
FR1050096T2R01	10,5	12	118	40	0,43	130	3	✓	0,142
FR1100096T2R01	11	12	118	40	0,43	130	3	✓	0,146
FR1150096R2T01	11,5	12	118	40	0,46	130	3	✓	0,151
FR1200096T2R01	12	12	118	40	0,46	130	3	✓	0,158

Recommended Cutting Conditions

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Cutting speed V _c (m/min)	Feed (mm/rev) vs. drill diameter					
						Ø4 - Ø5	Ø5.1 - Ø6	Ø6.1 - Ø8	Ø8.1 - Ø10	Ø10.1 - Ø12	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	80-140	0.15-0.25	0.20-0.35	0.25-0.45	0.30-0.55	0.35-0.60
		≥0.25%C	Annealed	650	190	80-130	0.15-0.25	0.20-0.35	0.25-0.45	0.30-0.55	0.35-0.60
		<0.55%C	Quenched/tempered	850	250	80-120	0.15-0.25	0.20-0.35	0.25-0.45	0.30-0.55	0.35-0.60
		≥0.55%C	Annealed	750	220	70-110	0.15-0.25	0.20-0.35	0.25-0.45	0.30-0.55	0.35-0.60
			Quenched/tempered	1000	300	50-90	0.15-0.25	0.20-0.35	0.25-0.45	0.30-0.55	0.35-0.60
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	80-120	0.15-0.25	0.20-0.35	0.25-0.40	0.30-0.50	0.35-0.55	
		Quenched and tempered	930	275	70-110	0.15-0.25	0.20-0.35	0.25-0.40	0.30-0.50	0.35-0.55	
			1000	300	50-90	0.15-0.25	0.20-0.35	0.25-0.40	0.30-0.50	0.35-0.55	
			1200	350	40-70	0.15-0.25	0.20-0.35	0.25-0.40	0.30-0.50	0.35-0.55	
	High alloy steel, cast steel and tool steel	Annealed	680	200	50-90	0.15-0.20	0.20-0.30	0.25-0.35	0.30-0.45	0.35-0.50	
		Quenched/tempered	1100	325	40-80	0.15-0.20	0.20-0.30	0.25-0.35	0.30-0.45	0.35-0.50	
	K	Gray cast iron (GG)	Ferritic	-	160	80-140	0.20-0.30	0.25-0.45	0.35-0.55	0.40-0.60	0.45-0.65
Pearlitic			-	250	70-120	0.20-0.30	0.25-0.45	0.35-0.55	0.40-0.60	0.45-0.65	
Cast iron nodular (GGG)		Ferritic		180	80-120	0.20-0.30	0.20-0.40	0.30-0.50	0.35-0.55	0.40-0.60	
		Pearlitic		260	70-110	0.20-0.30	0.20-0.40	0.30-0.50	0.35-0.55	0.40-0.60	
Malleable cast iron		Ferritic		130	80-120	0.20-0.30	0.20-0.40	0.30-0.50	0.35-0.55	0.40-0.60	
		Pearlitic		230	70-110	0.20-0.30	0.20-0.40	0.30-0.50	0.35-0.55	0.40-0.60	

Steel Cast iron

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