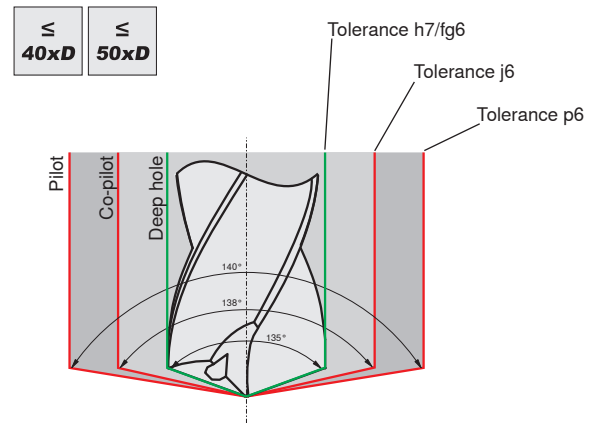
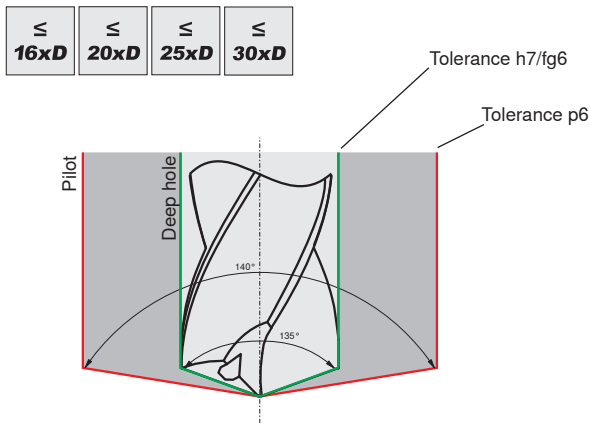


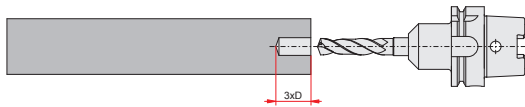
New possibilities in the deep hole drilling process

The special oversize tolerances p6 and j6 can replace your special diameters for pilot hole drilling. Adapted point angles ensure a 'softer' start of the drilling operation which leads to improved tool life. Especially for difficult drilling actions, spe-

cial drill lengths or 'problem' applications, you now have more possibilities of action.

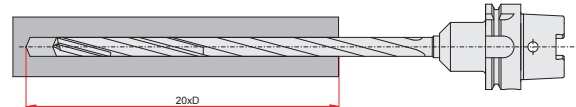


Drill the pilot hole



For the pilot hole, we recommend our W1106 drill (universal machining) or W1206 drill (aluminium). The pilot drill should have 0.02 mm larger diameter (tolerance p6) than the deep hole drill. Please ensure that the pilot hole is precise and has a minimum depth of 3xD.

Drill the co-pilot hole



For holes $\geq 40xD$, we recommend the additional use of our W1121 drill (universal machining). The co-pilot drill should have a larger diameter (tolerance j6) than the deep hole drill. Please ensure that the pilot hole is precise and has a minimum depth of 20xD, and observe the instructions for deep hole drilling up to 40xD.

Your advantages

- ▲ Protection of the cutting edges thanks to the adapted point angles (140°/138°/135°)
- ▲ Special diameters are no longer necessary thanks to the oversize tolerances p6 and j6
- ▲ Optimal drill lengths - pilot drills 5xD / co-pilot drills 20xD
- ▲ High concentricity and improved surface quality thanks to more guide lands

Benefit

- ▲ Low storage costs as special diameters no longer necessary
- ▲ Improved tool life and cutting data for high productivity
- ▲ Secure production processes thanks to increased process security and excellent hole quality