

# Drill Bits & Sets HSSG - STEEL

Full ground drill bits with cross grinding



**NEW**



**VERTRAU BLAU**

Trust In The Blue

- High speed steel twist drill bits
- Suitable for general use on steel, cast steel, grey cast iron, annealed cast iron, bronze, brass, aluminium
- Easy centring, long tool life & good chip removal

# Drill Bits & Sets HSSG - STEEL

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### DIN 338 HSSG N STEEL Drill Bits & Sets

High-performance drilling tools in the STEEL in HSSG (M2) type for industrial uses. Fully ground, right-hand turning version with cross grinding.

They are precision ground both in the chip flute and the guide chamfer as well as at the drill tip. They also have cross grinding. These drills are suitable for highly precise positioning on workpieces and support centring during drilling.

#### Recommendations for use:

- Observe the recommended rotational speed.
- When drilling metals, use a high-quality cutting oil or cooling lubricant, if possible. This facilitates smooth running and extends the drill tool life. Exception: when working on aluminium, use kerosene instead of cutting oil.
- In order to avoid corrosion, remove any particles which develop when working on stainless steel (INOX) from the workpiece. Clean the workpiece chemically or mechanically (etching/polishing, etc.).

#### Suited for:

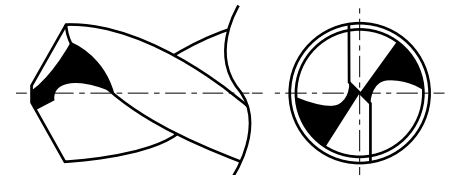
Steel, Aluminium, Brass, Bronze, Cast, Plastics

#### Applications:

Drilling

Tool dia. [mm]	Cutting speeds [m/min]								
	10	15	20	25	30	35	40	50	60
	Rotational speed [RPM]								
1.00	3,200	4,800	6,350	7,950	9,550	11,150	12,750	15,900	19,100
1.50	2,100	3,200	4,250	5,300	6,350	7,450	8,500	10,600	12,750
1.60	2,000	3,000	4,000	5,000	6,000	7,000	8,000	10,000	12,000
2.00	1,600	2,400	3,200	4,000	4,800	5,550	6,350	7,950	9,550
2.50	1,250	1,900	2,550	3,200	3,800	4,450	5,100	6,350	7,650
3.00	1,050	1,600	2,100	2,650	3,200	3,700	4,250	5,300	6,350
3.10	1,000	1,550	2,050	2,600	3,100	3,600	4,100	5,150	6,200
3.30	950	1,450	1,950	2,400	2,900	3,400	3,850	4,850	5,800
3.40	900	1,400	1,900	2,350	2,800	3,300	3,750	4,700	5,600
3.50	900	1,350	1,800	2,300	2,750	3,200	3,650	4,550	5,450
3.60	900	1,350	1,800	2,250	2,650	3,100	3,550	4,450	5,300
4.00	800	1,200	1,600	2,000	2,400	2,800	3,200	4,000	4,800
4.10	800	1,150	1,550	1,950	2,350	2,750	3,100	3,900	4,650
4.20	800	1,150	1,550	1,900	2,300	2,650	3,050	3,800	4,550
4.40	750	1,100	1,450	1,800	2,200	2,550	2,900	3,600	4,350
4.50	700	1,050	1,400	1,750	2,100	2,500	2,850	3,550	4,250
5.00	650	950	1,250	1,600	1,900	2,250	2,550	3,200	3,800
5.10	650	950	1,250	1,550	1,900	2,200	2,500	3,150	3,750
5.20	650	950	1,250	1,550	1,850	2,150	2,450	3,050	3,700
5.30	600	900	1,200	1,500	1,800	2,100	2,400	3,000	3,600
5.50	600	850	1,150	1,450	1,750	2,050	2,300	2,900	3,450
6.00	550	800	1,050	1,350	1,600	1,850	2,100	2,650	3,200
6.50	500	750	1,000	1,250	1,450	1,700	1,950	2,450	2,950
6.80	450	700	950	1,200	1,400	1,650	1,900	2,350	2,800
7.00	450	700	900	1,150	1,350	1,600	1,800	2,300	2,750
7.50	450	650	850	1,050	1,250	1,500	1,700	2,100	2,550
8.00	400	600	800	1,000	1,200	1,400	1,600	2,000	2,400
8.50	400	550	750	950	1,100	1,300	1,500	1,850	2,250
9.00	350	550	700	900	1,050	1,250	1,400	1,750	2,100
9.50	350	500	650	850	1,000	1,150	1,350	1,700	2,000
10.00	300	500	650	800	950	1,100	1,250	1,600	1,900
10.20	300	500	650	800	950	1,100	1,250	1,600	1,900
10.50	300	450	600	750	900	1,050	1,200	1,500	1,800
11.00	300	450	600	700	850	1,000	1,150	1,450	1,750
11.50	300	400	550	700	850	1,000	1,100	1,400	1,700
12.00	250	400	550	650	800	950	1,050	1,350	1,600
12.50	250	400	500	650	800	900	1,000	1,300	1,550
13.00	250	350	500	600	750	850	1,000	1,250	1,450

The grinding finish also applies to the cut at the centre of the drill tip and reduces the feed forces needed during use. PFERD spiral drills have a 118° point angle.



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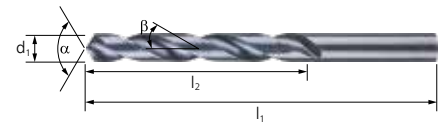


**NEW**



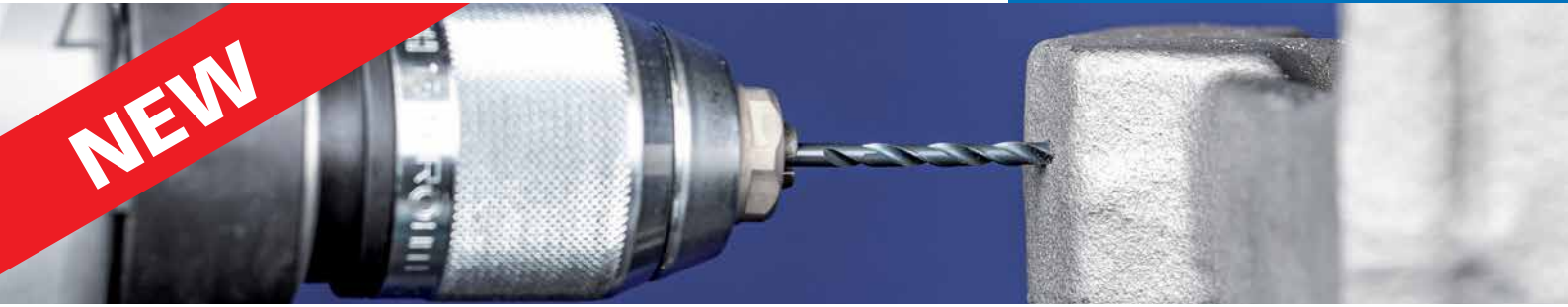
## DIN 338 HSSG N STEEL Drill Bits

Article Number	d <sub>1</sub> [mm]	l <sub>2</sub> [mm]	l <sub>1</sub> [mm]	α	Helix angles β	
25203510	1.00	12	34	118°	25-30°	10
25203511	1.50	18	40	118°	25-30°	10
25203512	1.60	20	43	118°	25-30°	10
25203513	2.00	24	49	118°	25-30°	10
25203514	2.50	30	57	118°	25-30°	10
25203515	3.00	33	61	118°	25-30°	10
25203516	3.10	36	65	118°	25-30°	10
25203517	3.30	36	65	118°	25-30°	10
25203518	3.40	39	70	118°	25-30°	10
25203519	3.50	39	70	118°	25-30°	10
25203520	3.60	39	70	118°	25-30°	10
25203521	4.00	43	75	118°	25-30°	10
25203522	4.10	43	75	118°	25-30°	10
25203523	4.20	43	75	118°	25-30°	10
25203524	4.40	47	80	118°	25-30°	10
25203525	4.50	47	80	118°	25-30°	10
25203526	5.00	52	86	118°	25-30°	10
25203527	5.10	52	86	118°	25-30°	10
25203528	5.20	52	86	118°	25-30°	10
25203529	5.30	52	86	118°	25-30°	10
25203530	5.50	57	93	118°	25-30°	10
25203531	6.00	57	93	118°	25-30°	10
25203532	6.50	63	63	118°	25-30°	10
25203533	6.80	69	109	118°	25-30°	10
25203534	7.00	69	109	118°	25-30°	10
25203535	7.50	69	109	118°	25-30°	10
25203536	8.00	75	117	118°	25-30°	10
25203537	8.50	75	117	118°	25-30°	10
25203538	9.00	75	125	118°	25-30°	10
25203539	9.50	81	125	118°	25-30°	10
25203540	10.00	87	133	118°	25-30°	10
25203541	10.20	87	133	118°	25-30°	5
25203542	10.50	87	133	118°	25-30°	5
25203543	11.00	94	142	118°	25-30°	5
25203544	11.50	94	142	118°	25-30°	5
25203545	12.00	101	151	118°	25-30°	5
25203546	12.50	101	151	118°	25-30°	5
25203547	13.00	101	151	118°	25-30°	5



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## DIN 338 HSSG N STEEL Drill Bit Sets


- Includes a sturdy plastic box that protects the drills
- Easy drill selection & storage

### SPB DIN 338 HSSG N 3-10 STEEL (8 Piece Set)

Article Number	Description	
25203705	<b>SPB DIN 338 HSSG N 3-10 STEEL (8 Piece Set)</b> 8 HSS twist drill bits, STEEL in HSSG (M2) type, Diameter in mm: 3.0, 4.0, 5.0, 6.0, 7.0, 8.0, 9.0, 10.0	1




### SPB DIN 338 HSSG N 1-10 STEEL (19 Piece Set)

Article Number	Description	
25203701	<b>SPB DIN 338 HSSG N 1-10 STEEL (19 Piece Set)</b> 19 HSS twist drill bits, STEEL in HSSG (M2) type, Diameter in mm: 1.0, 1.5, 2.0, 2.5, 3.0, 3.5, 4.0, 4.5, 5.0, 5.5, 6.0, 6.5, 7.0, 7.5, 8.0, 8.5, 9.0, 9.5, 10.0	1



### SPB DIN 338 HSSG N 1-13 STEEL (25 Piece Set)

Article Number	Description	
25203702	<b>SPB DIN 338 HSSG N 1-13 STEEL (25 Piece Set)</b> 25 HSS twist drill bits, STEEL in HSSG (M2) type Diameter in mm: 1.0, 1.5, 2.0, 2.5, 3.0, 3.5, 4.0, 4.5, 5.0, 5.5, 6.0, 6.5, 7.0, 7.5, 8.0, 8.5, 9.0, 9.5, 10.0, 10.5, 11.0, 11.5, 12.0, 12.5, 13.0	1



#### Safety Recommendations



Wear eye protection!



Wear hearing protection!



Wear a dust mask!



Wear gloves!



Follow the safety instructions!



Do not use if damaged!

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