

## HSCo8 AlCrN annular cutter

High-performance core drill bits with 55-mm cutting depth, AlCrN-multilayer coating and 8% cobalt alloy for high service life and versatile use with almost all materials such as in conventional steels, cast iron, titanium, stainless steels, heat-resistant and high-strength steels up to 1400 N/mm<sup>2</sup> in strength. Also suitable for non-ferrous metals, such as aluminium, aluminium alloys, magnesium alloys, brass, bronze and plastics.



### Outstanding performance compared to similar uncoated core drill bits

- Significantly higher service life
- Up to 60% greater cutting speed
- Considerably faster drilling progress

### AlCrN multilayer wear-protection coating and 8% cobalt alloy

- Extremely high temperature resistance of up to 1050°C
- Very high coating hardness of 3000 HV
- Multilayer construction for optimum chip removal and improved cutting properties (prevents material wear)

### For process reliability in almost all materials

#### Exact guidance, no slippage

Problem-free drilling on curved surfaces and pipes

#### No predrilling required, no formation of burrs

Eliminates need for pre- and post-machining

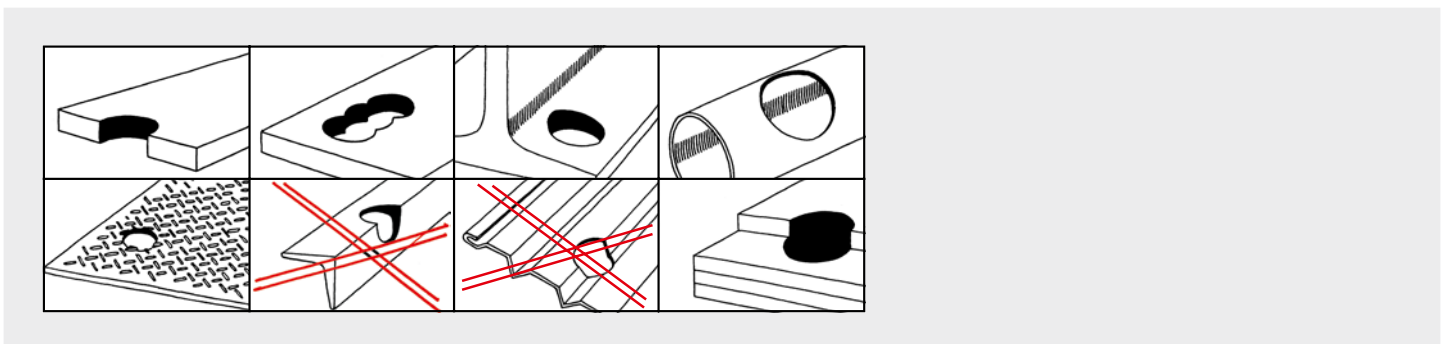
Quality	ZEBRA-Premium
Cutting depth	55 mm
Length	84.6 mm
Material to be processed	Steel, Stainless steel, Cast metal, Non-ferrous metal, Hard and tough material
Shank style	Weldon
Surface	AlCrN
Cutting material	HSCo8
Service life	●●●●
Drilling speed (point system)	●●●●
Bore hole quality (point system)	●●●●
Versatility	●●●●
Drilling behaviour (point system)	●●●●
Type	Longlife

Diameter	Art. no.	P. Qty.
12 mm	0630 942 612	1
13 mm	0630 942 613	1

Diameter	Art. no.	P. Qty.
14 mm	0630 942 614	1
15 mm	0630 942 615	1
16 mm	0630 942 616	1
18 mm	0630 942 618	1
20 mm	0630 942 620	1
22 mm	0630 942 622	1
24 mm	0630 942 624	1
25 mm	0630 942 625	1
26 mm	0630 942 626	1
28 mm	0630 942 628	1
30 mm	0630 942 630	1
32 mm	0630 942 632	1
35 mm	0630 942 635	1
36 mm	0630 942 636	1
40 mm	0630 942 640	1
50 mm	0630 942 650	1

### Details/Application

- With Weldon shank  $\varnothing$  19 mm for use on mobile magnetic drills or stationary drills for creating large holes up to 50 mm in diameter and a cutting depth of max. 55 mm
- Fein drills with QuickIn mount can be used with an adapter
- Application on stationary drills with Morse taper is possible using the appropriate mount holder



### Instructions

- Insert the ejector pin into the core drill bit
- Push the core drill bit into the mount holder of the drill unit and tighten the hexagon socket screws
- The core drill bit is automatically locked into place when using quick-action mounts
- Make sure the core drill bit is sitting cleanly in the mount

- Putting the drill under lateral load during use may cause the tool to break
- Fix the drill unit into the right position for drilling – make sure the drill unit has a stable footing
- If necessary, secure the drill unit before drilling using a safety strap, especially for use on vertical surfaces and overhead work
- Pay attention to the speed table and use coolant
- Drill carefully (without centre punching and pre-drilling), pay attention to an even feed and even rotation speed throughout the entire drilling process
- Remove chips and drill core after each drilling operation
- Caution: Risk of injury, chips and drill core may be very hot and sharp

### Notice

- Unlike the twist drill, the core drill bit does not machine the entire bore diameter, but rather only a thin material ring. The drill core is ejected by an ejector pin using spring tension; this is not included in the scope of delivery. The drilling times of core drill bits are therefore up to ten times shorter than those of twist drills.
- Sufficient continuous cooling during the entire drilling process considerably increases the service life of the core drill. Do not use in a dry state.
- See the overview tables for core drill bits/material assignments as well as cutting values
- Wear appropriate protective equipment when using the sanding tip, such as Eye protection, hearing protection, protective gloves
- Set aside loose clothing or jewellery that could get caught in moving parts
- The core drill bits must not be used manually
- Before use, please ensure that the tool rotates properly and that the clamping function on the tool drive works correctly

Related products	Art. no.
Ejector pin	0630 940 001
Holder, HSS core drill bit MK 2; Lubrication Manual	0630 930 002
Holder, HSS core drill bit MK 2; Lubrication Automatic	0630 930 003
Holder, HSS core drill bit MK 3; Lubrication Manual	0630 930 004
Holder, HSS core drill bit MK 3; Lubrication Automatic	0630 930 005
Adapter for annular cutter with Weldon shank on Fein QuickIN shank	5709 200 002