



Product no. 824 150 1

POLARIS 150 CARBIDE DRILL (3xD)
Short length series
Xtreme coated

| Ø | Shank | Overall Length | Flute Length | Price £ each |
|------|-------|----------------|--------------|--------------|
| 3,0 | 6 | 62 | 20 | 18.21 |
| 3,3 | 6 | 62 | 20 | 18.21 |
| 3,5 | 6 | 62 | 20 | 18.21 |
| 4,0 | 6 | 66 | 24 | 18.21 |
| 4,2 | 6 | 66 | 24 | 18.21 |
| 4,5 | 6 | 66 | 24 | 18.21 |
| 5,0 | 6 | 66 | 28 | 18.21 |
| 5,5 | 6 | 66 | 28 | 18.21 |
| 6,0 | 6 | 66 | 28 | 18.21 |
| 6,5 | 8 | 79 | 34 | 18.21 |
| 6,75 | 8 | 79 | 34 | 18.21 |
| 6,8 | 8 | 79 | 34 | 18.21 |
| 7,0 | 8 | 79 | 34 | 18.21 |
| 7,5 | 8 | 79 | 41 | 18.21 |
| 8,0 | 8 | 79 | 41 | 18.21 |
| 8,5 | 10 | 89 | 47 | 18.21 |
| 9,0 | 10 | 89 | 47 | 20.43 |
| 9,5 | 10 | 89 | 47 | 20.43 |
| 10,0 | 10 | 89 | 47 | 20.43 |
| 10,2 | 12 | 102 | 55 | 30.43 |
| 10,5 | 12 | 102 | 55 | 30.43 |
| 11,0 | 12 | 102 | 55 | 30.43 |
| 11,5 | 12 | 102 | 55 | 30.43 |
| 12,0 | 12 | 102 | 55 | 30.43 |
| 12,5 | 14 | 107 | 60 | 40.86 |
| 13,0 | 14 | 107 | 60 | 40.86 |
| 13,5 | 14 | 107 | 60 | 40.86 |
| 14,0 | 14 | 107 | 60 | 40.86 |
| 14,5 | 16 | 115 | 65 | 52.71 |
| 15,0 | 16 | 115 | 65 | 52.71 |
| 15,5 | 16 | 115 | 65 | 52.71 |
| 16,0 | 16 | 115 | 65 | 52.71 |

Submicron grade carbide

DIN 6537K Solid

Polaris® –
 The economical performance drill

With its very wide application range, high cutting data and longest tool life, Polaris is the ultimate “economical” performance drill.

With tool life increases of around 70% against competitors in this sector we are confident in the superiority of Polaris – why not see for yourself how Polaris can reduce your machining and tool costs.

| | Unalloyed Steel | Heat Treatable Steel | Heat Treatable Steel | | Cast Iron & SG Iron | | |
|------------------|---------------------------|---------------------------|----------------------------|-------------------------|---------------------|-----------|------|
| | 200-400 N/mm ² | 400-900 N/mm ² | 900-1400 N/mm ² | Tool Steels 40 – 50 HRC | Short Chipping | Malleable | |
| Cutting speed | 60 M/min | 60 M/min | 50 M/min | 40 M/min | 60 M/min | 35 M/min | |
| Feed rate mm/rev | Ø3 | 0.06 | 0.06 | 0.06 | 0.04 | 0.03 | |
| | Ø4 | 0.08 | 0.08 | 0.08 | 0.06 | 0.05 | |
| | Ø6 | 0.12 | 0.12 | 0.12 | 0.12 | 0.09 | 0.08 |
| | Ø8 | 0.16 | 0.16 | 0.16 | 0.16 | 0.12 | 0.10 |
| | Ø10 | 0.20 | 0.20 | 0.20 | 0.20 | 0.15 | 0.13 |
| | Ø12 | 0.24 | 0.24 | 0.24 | 0.24 | 0.18 | 0.15 |
| | Ø14 | 0.28 | 0.28 | 0.28 | 0.28 | 0.21 | 0.18 |
| | Ø16 | 0.32 | 0.32 | 0.32 | 0.32 | 0.24 | 0.20 |