



Product no. 824 160 1

POLARIS 160 CARBIDE DRILL (3xD)
Short length series – with coolant feed
xtreme coated

Ø	Shank	Overall Length	Flute Length	Price £ each
4,0	6	66	24	24.86
4,2	6	66	24	24.86
4,5	6	66	24	24.86
5,0	6	66	28	24.86
5,5	6	66	28	24.86
6,0	6	66	28	24.86
6,5	8	79	34	33.79
6,75	8	79	34	33.79
6,8	8	79	34	33.79
7,0	8	79	34	33.79
7,5	8	79	41	33.79
8,0	8	79	41	33.79
8,5	10	89	47	37.86
9,0	10	89	47	37.86
9,5	10	89	47	37.86
10,0	10	89	47	37.86
10,2	12	102	55	54.21
10,5	12	102	55	54.21
11,0	12	102	55	54.21
11,5	12	102	55	54.21
12,0	12	102	55	54.21
12,5	14	107	60	75.79
13,0	14	107	60	75.79
13,5	14	107	60	75.79
14,0	14	107	60	75.79
14,5	16	115	65	92.50
15,0	16	115	65	92.50
15,5	16	115	65	92.50
16,0	16	115	65	92.50
16,5	18	123	73	148.57
17,0	18	123	73	148.57
17,5	18	123	73	148.57
18,0	18	123	73	148.57
18,5	20	131	79	162.29
19,0	20	131	79	162.29
19,5	20	131	79	162.29
20,0	20	131	79	162.29

Submicron grade carbide

DIN 6537K with coolant feed

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		Stainless 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	Ferric & Martensitic	Austenitic	Short Chipping	Malleable
Cutting speed	80 M/min	80 M/min	70 M/min	60 M/min	50 M/min	40 M/min	70 M/min	50 M/min
Feed rate mm/rev	Ø4	0.08	0.08	0.08	0.05	0.04	0.06	0.05
	Ø6	0.12	0.12	0.12	0.08	0.06	0.09	0.08
	Ø8	0.16	0.16	0.16	0.10	0.08	0.12	0.10
	Ø10	0.20	0.20	0.20	0.13	0.10	0.15	0.13
	Ø12	0.24	0.24	0.24	0.15	0.12	0.18	0.15
	Ø14	0.28	0.28	0.28	0.18	0.14	0.21	0.18
	Ø16	0.32	0.32	0.32	0.20	0.16	0.24	0.20
	Ø18	0.36	0.36	0.36	0.23	0.18	0.27	0.23
	Ø20	0.40	0.40	0.40	0.25	0.20	0.30	0.25