



Product no. 824 170 1

**POLARIS 170 CARBIDE DRILL (5xD)**  
**Standard length series – with coolant feed**  
**xtreme coated**

Ø	Shank	Overall Length	Flute Length	Price £ each
4,0	6	74	36	31.93
4,2	6	74	36	31.93
4,5	6	74	36	31.93
5,0	6	82	44	31.93
5,5	6	82	44	31.93
6,0	6	82	44	31.93
6,5	8	91	53	35.29
6,75	8	91	53	35.29
6,8	8	91	53	35.29
7,0	8	91	53	35.29
7,5	8	91	53	35.29
8,0	8	91	53	35.29
8,5	10	103	61	40.50
9,0	10	103	61	40.50
9,5	10	103	61	40.50
10,0	10	103	61	40.50
10,2	12	118	71	59.07
10,5	12	118	71	59.07
11,0	12	118	71	59.07
11,5	12	118	71	59.07
12,0	12	118	71	59.07
12,5	14	124	77	79.50
13,0	14	124	77	79.50
13,5	14	124	77	79.50
14,0	14	124	77	79.50
14,5	16	133	83	98.07
15,0	16	133	83	98.07
15,5	16	133	83	98.07
16,0	16	133	83	98.07
16,5	18	143	93	157.14
17,0	18	143	93	157.14
17,5	18	143	93	157.14
18,0	18	143	93	157.14
18,5	20	153	101	170.86
19,0	20	153	101	170.86
19,5	20	153	101	170.86
20,0	20	153	101	170.86

Submicron grade carbide

DIN 6537L 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 <sup>2</sup>	400-900 N/mm <sup>2</sup>	900-1400 N/mm <sup>2</sup>	Tool Steels 40 – 50 HRC	Ferric & Martensitic	Austenitic	Short Chipping	Malleable
Cutting speed	70 M/min	70 M/min	60 M/min	48 M/min	35 M/min	30 M/min	65 M/min	45 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