

# Drilling tools for Hardox® wear plate

## General Product Description

High-performance drill developed specifically for drilling Hardox® wear plate. Armour piercing and high-speed steel with 8% cobalt for increased productivity and superior stability thanks to h8 tolerances. It is especially suitable for unstable conditions.

### Key Benefits

- Excellent performance in Hardox® wear plate
- Long lasting
- Possible to re-sharp
- Morse taper shank
- Special grinding of the drill tip for better penetration and flute angle for better chips transport
- Nitrated, steam oxidized gives a black finish for better friction robustness

### Typical Machines

The drilling tool for Hardox® wear plate suits extremely well with manual radial and/or pillar machines. For stable conditions like CNC machines we recommend Solid Carbide drills for better productivity and lower costs.

## Standard Size

### Standard Diameters



Standard range from sizes 15 mm up to 32 mm. Half mm sizes from 15 mm to 20 mm.

Other dimensions are available upon special requests.

Ø D1 mm	L1 mm	L2 mm	MK
15	171	73	2
15,5	175	77	2
16	175	77	2
16,5	178	80	2
17	178	80	2
17,5	182	84	2
18	182	84	2
18,5	203	86	3
19	203	86	3
19,5	207	90	3
20	207	90	3
21	210	93	3
22	213	96	3
23	217	100	3
24	219	102	3
25	219	102	3
26	222	105	3
27	265	120	4
28	265	120	4
29	265	120	4
30	265	120	4
31	265	120	4
32	265	120	4

## Mechanical Properties

Manufacturing properties	
Material	High Speed Steel with 8% Cobalt (M42)
Point angle	130°
Flute angle	10°-16°
Surface	Black surface
Production method	Milling

## Machining recommendations

### Machining recommendations

See Machining recommendations for Strenx™ and Hardox® available at

<https://www.ssab.com/download-center>

Note that coolant is necessary when drilling, therefore not suitable for horizontal drilling, only vertical.

## Delivery Conditions

### Standard package

The tools are delivered in plastic containers in a cardboard box. The package and the tool are clearly marked with item description.

## Other Recommendations

### Safety

Always follow the safety precautions from your machine manufacturer.

Do not use the tools above Hardox® 500 material as the drill may burst and cause injury.

Follow the machine settings recommended (see Machining recommendations above).

## Contact information

[www.ssab.com/contact](http://www.ssab.com/contact)