



HARTNER

Precision Cutting Tools



MULTI-STEP

TWIST DRILL FOR MAXIMUM PERFECTION



MULTI-STEP

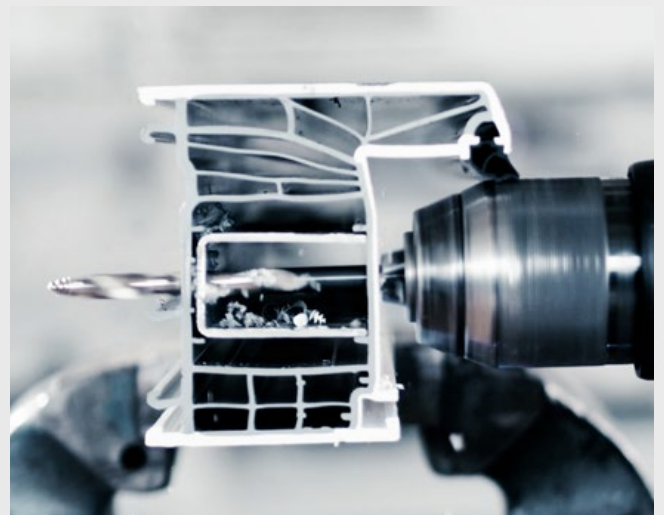
Twist drill for use in hand drilling operations. Quick, safe and reliable drilling with best hole quality thanks to the innovative multi-step point geometry.

AREA OF APPLICATION

- hand drilling (cordless electric drills etc.)
- pillars and pillar drill machines
- ideal for exact, round through holes e.g. in materials such as sheet metals, flat materials, hollow-walled (aluminium / window) profiles
- also suitable for blind holes
- spotting on round or oblique surfaces e.g. pipes is possible without any difficulties
- core drilling of an existing hole
- ideal for reboring of bolts or rivets

HIGHLIGHTS

Exact, circular holes with almost burr-free hole exits with minimum effort and fastest drilling progress. Comfortable and easy handling – without hooking in of the drill at the hole exit or spinning of the drill in the clamping chuck.



FOR UNIVERSAL APPLICATION IN STEEL < 1,200 N/MM²

CAST MATERIAL, ALUMINIUM, PLASTICS (E.G. ACRYLIC GLASS),
HARDWOOD AND SOFTWOOD

cutting material: HSS

DIN 338 dimensions

optimised split point
 $\varnothing \geq 1.00$ mm

step geometry
 $\varnothing \geq 2.50$ mm

3-flats on shank
 $\varnothing \geq 4.00$ mm



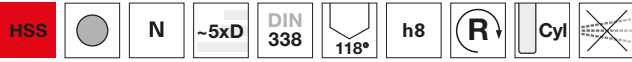


Jobber drills

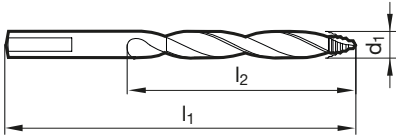
Article no. 81001



P	M	K	N	S	H
●	○	●	○		



novel multi step drill with up to 6 steps • 118° point geometry with an optimised split point geometry for precise centring and easy cutting
 • 3-flats on shank prevent slipping in the chuck • exact, circular holes • perfect for hand drills



d1 mm	l1 mm	l2 mm	d1 mm	l1 mm	l2 mm
1.000	34.000	12.000	6.500	101.000	63.000
1.500	40.000	18.000	6.800	109.000	69.000
2.000	49.000	24.000	7.000	109.000	69.000
2.500	57.000	30.000	7.500	109.000	69.000
3.000	61.000	33.000	8.000	117.000	75.000
3.200	65.000	36.000	8.500	117.000	75.000
3.300	65.000	36.000	9.000	125.000	81.000
3.500	70.000	39.000	9.500	125.000	81.000
4.000	75.000	43.000	10.000	133.000	87.000
4.100	75.000	43.000	10.200	133.000	87.000
4.200	75.000	43.000	10.500	133.000	87.000
4.500	80.000	47.000	11.000	142.000	94.000
4.900	86.000	52.000	11.500	142.000	94.000
5.000	86.000	52.000	12.000	151.000	101.000
5.100	86.000	52.000	12.500	151.000	101.000
5.200	86.000	52.000	13.000	151.000	101.000
5.500	93.000	57.000			
6.000	93.000	57.000			



Twist drill sets

Article no. 81002

P	M	K	N	S	H
•	○	•	○		



novel multi step drill with up to 6 steps • 118° point geometry with an optimised split point geometry for precise centring and easy cutting
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d1 mm	increasing by mm	Pieces/set	Code no.
1.0-10.0	0.5	19	0.013
1.0-13.0	0.5	25	0.014

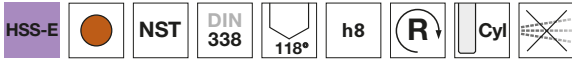


Jobber drills

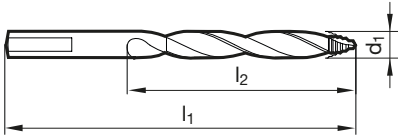
Article no. 81003



P	M	K	N	S	H
•	•	•	○	○	



novel multi step drill with up to 6 steps • 118° point geometry with an optimised split point geometry for precise centring and easy cutting
 • 3-flats on shank prevent slipping in the chuck • 5% cobalt-HSCo steel for high wear resistance • exact, circular holes • perfect for hand drills



d1 mm	l1 mm	l2 mm	d1 mm	l1 mm	l2 mm
1.000	34.000	12.000	6.500	101.000	63.000
1.500	40.000	18.000	6.800	109.000	69.000
2.000	49.000	24.000	7.000	109.000	69.000
2.500	57.000	30.000	7.500	109.000	69.000
3.000	61.000	33.000	8.000	117.000	75.000
3.200	65.000	36.000	8.500	117.000	75.000
3.300	65.000	36.000	9.000	125.000	81.000
3.500	70.000	39.000	9.500	125.000	81.000
4.000	75.000	43.000	10.000	133.000	87.000
4.100	75.000	43.000	10.200	133.000	87.000
4.200	75.000	43.000	10.500	133.000	87.000
4.500	80.000	47.000	11.000	142.000	94.000
4.900	86.000	52.000	11.500	142.000	94.000
5.000	86.000	52.000	12.000	151.000	101.000
5.100	86.000	52.000	12.500	151.000	101.000
5.200	86.000	52.000	13.000	151.000	101.000
5.500	93.000	57.000			
6.000	93.000	57.000			



Twist drill sets

Article no. 81004

P	M	K	N	S	H
•	•	•	○	○	



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d1 mm	increasing by mm	Pieces/set	Code no.
1.0-10.0	0.5	19	0.013
1.0-13.0	0.5	25	0.014

THE HARTNER PROGRAMME



▼ DRILLING TOOLS



▼ MULTISTEP



▼ COUNTERSINKS



▼ MICRO-PRECISION DRILLS



▼ THREADING TOOLS



▼ TS-DRILLS



▼ THREAD MILLING CUTTERS



▼ SOLID CARBIDE MILLING CUTTERS



▼ REAMERS



▼ MULTIPLEX



▼ MULTIPLEX HPC



▼ TM VENDING MACHINES

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