



HARTNER

Precision Cutting Tools

HSS TIN TIP-COATED JOBBER DRILL

NOW AVAILABLE SINGLE
AND IN TAP AND DRILL SETS



+ Optimal performance



HARTNER

Precision Cutting Tools



HSS TiN tip-coated drill

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HSS Countersink 90°

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HSS-E Tap

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Sets

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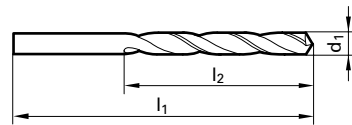
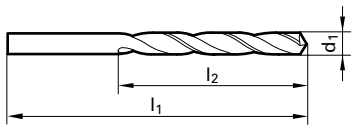
TiN tip-coated HSS drill

Article no. 84406



The design of the TiN tip-coated HSS drill ensures optimal rigidity and stability, therefore, enabling high feed rates. The web thinning offers optimised spotting characteristics, precise centring and an accurate hole tolerance. The open flutes possess an effective spiral geometry for the entire diameter range and allow for efficient chip evacuation and provide maximum rigidity. The TiN-coating at the tip of the tool reduces tool flank and crater wear, provides less friction in the cutting edge area and, therefore, increases performance. The bright flute surface improves the machining of materials where the chips have a tendency to jamming. It is suitable for the machining of steel and cast steel (alloyed and unalloyed), grey cast iron, malleable cast iron, spheroidal graphite iron, sintered iron and graphite.

Standard	DIN 338
Tool material	HSS
Surface	T tip-coated
Type	N
Cutting direction	right-hand
Point grinding	Relieved cone
Point angle °	118
Web thinned	≥ Ø 1.0
Tolerance	h8

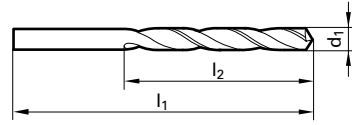
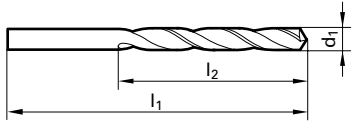


				84406	
				Discount group	
				159	
d1	d1	l1	l2	Availability	
mm	inch	mm	mm		
1.00		34.00	12.00	●	
1.10		36.00	14.00	●	
1.19	3/64	38.00	16.00	●	
1.20		38.00	16.00	●	
1.30		38.00	16.00	●	
1.40		40.00	18.00	●	
1.50		40.00	18.00	●	
1.59	1/16	43.00	20.00	●	
1.60		43.00	20.00	●	
1.70		43.00	20.00	●	
1.80		46.00	22.00	●	
1.90		46.00	22.00	●	
1.98	5/64	49.00	24.00	●	
2.00		49.00	24.00	●	
2.10		49.00	24.00	●	
2.20		53.00	27.00	●	
2.30		53.00	27.00	●	
2.38	3/32	57.00	30.00	●	
2.40		57.00	30.00	●	
2.50		57.00	30.00	●	
2.60		57.00	30.00	●	
2.70		61.00	33.00	●	
2.78		61.00	33.00	●	
2.80		61.00	33.00	●	
2.90		61.00	33.00	●	
3.00		61.00	33.00	●	
3.10		65.00	36.00	●	
3.17	1/8	65.00	36.00	●	
3.20		65.00	36.00	●	
3.30		65.00	36.00	●	
3.40		70.00	39.00	●	
3.50		70.00	39.00	●	
3.57	9/64	70.00	39.00	●	
3.60		70.00	39.00	●	
3.70		70.00	39.00	●	
3.80		75.00	43.00	●	
3.90		75.00	43.00	●	
3.97	5/32	75.00	43.00	●	
4.00		75.00	43.00	●	

				84406	
				Discount group	
				159	
d1	d1	l1	l2	Availability	
mm	inch	mm	mm		
4.10		75.00	43.00	●	
4.20		75.00	43.00	●	
4.30		80.00	47.00	●	
4.37	11/64	80.00	47.00	●	
4.40		80.00	47.00	●	
4.50		80.00	47.00	●	
4.60		80.00	47.00	●	
4.70		80.00	47.00	●	
4.76	3/16	86.00	52.00	●	
4.80		86.00	52.00	●	
4.90		86.00	52.00	●	
5.00		86.00	52.00	●	
5.10		86.00	52.00	●	
5.16	13/64	86.00	52.00	●	
5.20		86.00	52.00	●	
5.30		86.00	52.00	●	
5.40		93.00	57.00	●	
5.50		93.00	57.00	●	
5.56	7/32	93.00	57.00	●	
5.60		93.00	57.00	●	
5.70		93.00	57.00	●	
5.80		93.00	57.00	●	
5.90		93.00	57.00	●	
5.95	15/64	93.00	57.00	●	
6.00		93.00	57.00	●	
6.10		101.00	63.00	●	
6.20		101.00	63.00	●	
6.30		101.00	63.00	●	
6.35	1/4	101.00	63.00	●	
6.40		101.00	63.00	●	
6.50		101.00	63.00	●	
6.60		101.00	63.00	●	
6.70		101.00	63.00	●	
6.75	17/64	109.00	69.00	●	
6.80		109.00	69.00	●	
6.90		109.00	69.00	●	
7.00		109.00	69.00	●	
7.10		109.00	69.00	●	
7.14	9/32	109.00	69.00	●	



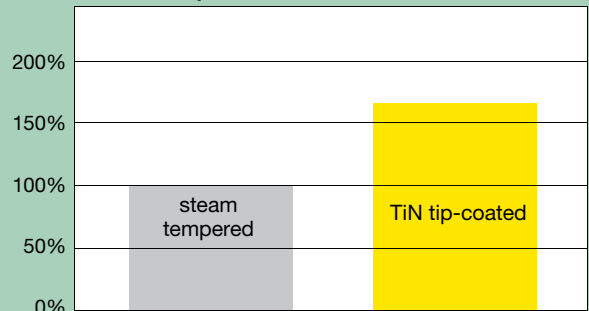
TiN tip-coated HSS drill



				84406	
				Discount group	
				159	
d1	d1	l1	l2	Availability	
mm	inch	mm	mm		
7.20		109.00	69.00	●	
7.30		109.00	69.00	●	
7.40		109.00	69.00	●	
7.50		109.00	69.00	●	
7.54	19/64	117.00	75.00	●	
7.60		117.00	75.00	●	
7.70		117.00	75.00	●	
7.80		117.00	75.00	●	
7.90		117.00	75.00	●	
7.94	5/16	117.00	75.00	●	
8.00		117.00	75.00	●	
8.10		117.00	75.00	●	
8.20		117.00	75.00	●	
8.30		117.00	75.00	●	
8.33	21/64	117.00	75.00	●	
8.40		117.00	75.00	●	
8.50		117.00	75.00	●	
8.60		125.00	81.00	●	
8.70		125.00	81.00	●	
8.73		125.00	81.00	●	
8.80		125.00	81.00	●	
8.90		125.00	81.00	●	
9.00		125.00	81.00	●	
9.10		125.00	81.00	●	
9.13	23/64	125.00	81.00	●	
9.20		125.00	81.00	●	
9.30		125.00	81.00	●	
9.40		125.00	81.00	●	
9.50		125.00	81.00	●	
9.52	3/8	133.00	87.00	●	
9.60		133.00	87.00	●	
9.70		133.00	87.00	●	
9.80		133.00	87.00	●	
9.90		133.00	87.00	●	
9.92	25/64	133.00	87.00	●	
10.00		133.00	87.00	●	
10.10		133.00	87.00	●	
10.20		133.00	87.00	●	
10.30		133.00	87.00	●	
10.32	13/32	133.00	87.00	●	
10.40		133.00	87.00	●	
10.50		133.00	87.00	●	
10.60		133.00	87.00	●	
10.70		142.00	94.00	●	
10.72	27/64	142.00	94.00	●	
10.80		142.00	94.00	●	
10.90		142.00	94.00	●	
11.00		142.00	94.00	●	
11.10		142.00	94.00	●	
11.11	7/16	142.00	94.00	●	
11.20		142.00	94.00	●	
11.30		142.00	94.00	●	
11.40		142.00	94.00	●	
11.50		142.00	94.00	●	
11.51	29/64	142.00	94.00	●	
11.60		142.00	94.00	●	
11.70		142.00	94.00	●	

				84406	
				Discount group	
				159	
d1	d1	l1	l2	Availability	
mm	inch	mm	mm		
11.70		142.00	94.00	●	
11.80		142.00	94.00	●	
11.90		151.00	101.00	●	
11.91	15/32	151.00	101.00	●	
12.00		151.00	101.00	●	
12.10		151.00	101.00	●	
12.20		151.00	101.00	●	
12.30	31/64	151.00	101.00	●	
12.40		151.00	101.00	●	
12.50		151.00	101.00	●	
12.60		151.00	101.00	●	
12.70	1/2	151.00	101.00	●	
12.80		151.00	101.00	●	
12.90		151.00	101.00	●	
13.00		151.00	101.00	●	
13.10	33/64	151.00	101.00	●	
13.20		151.00	101.00	●	
13.25		160.00	108.00	●	
13.30		160.00	108.00	●	
13.40		160.00	108.00	●	
13.49	17/32	160.00	108.00	●	
13.50		160.00	108.00	●	
13.60		160.00	108.00	●	
13.70		160.00	108.00	●	
13.75		160.00	108.00	●	
13.80		160.00	108.00	●	
13.89	35/64	160.00	108.00	●	
13.90		160.00	108.00	●	
14.00		160.00	108.00	●	
14.25		169.00	114.00	●	
14.29	9/16	169.00	114.00	●	
14.50		169.00	114.00	●	
14.68	37/64	169.00	114.00	●	
14.75		169.00	114.00	●	
15.00		169.00	114.00	●	
15.08	19/32	178.00	120.00	●	
15.25		178.00	120.00	●	
15.48	39/64	178.00	120.00	●	
15.50		178.00	120.00	●	
15.75		178.00	120.00	●	
16.00		178.00	120.00	●	

Tool life comparison:





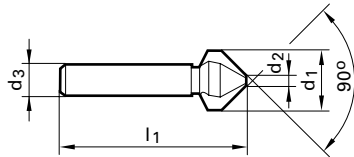
Countersink 90°

Article no. 88200



The three-edged countersink has a radial relief geometry and is suitable for general purpose chamfering, deburring and countersinking, e.g. for tapping size holes. The shank is cylindrical. It is notable for its chatter-free operation in common steels up to a tensile strength of 850 N/mm² as well as in non-ferrous metals and plastics.

- Standard DIN 335
- Tool material **HSS**
- Surface ○
- Form C
- Cutting direction right-hand



88200

Discount group

105

Availability

Code no.	d1 mm	d3 mm	l1 mm	l2 mm	Z	Availability
4.300	4.300	4.000	40.00	1.300	3	●
5.000	5.000	4.000	40.00	1.500	3	●
5.300	5.300	4.000	40.00	1.500	3	●
5.800	5.800	5.000	45.00	1.500	3	●
6.000	6.000	5.000	45.00	1.500	3	●
6.300	6.300	5.000	45.00	1.500	3	●
7.000	7.000	6.000	50.00	1.800	3	●
7.300	7.300	6.000	50.00	1.800	3	●
8.000	8.000	6.000	50.00	2.000	3	●
8.300	8.300	6.000	50.00	2.000	3	●
9.400	9.400	6.000	50.00	2.200	3	●
10.000	10.000	6.000	50.00	2.500	3	●
10.400	10.400	6.000	50.00	2.500	3	●
11.500	11.500	8.000	56.00	2.800	3	●
12.400	12.400	8.000	56.00	2.800	3	●
13.400	13.400	8.000	56.00	2.900	3	●
15.000	15.000	10.000	60.00	3.200	3	●
16.500	16.500	10.000	60.00	3.200	3	●
19.000	19.000	10.000	63.00	3.500	3	●
20.500	20.500	10.000	63.00	3.500	3	●
23.000	23.000	10.000	67.00	3.800	3	●
25.000	25.000	10.000	67.00	3.800	3	●
26.000	26.000	10.000	67.00	3.800	3	●
28.000	28.000	12.000	71.00	4.000	3	●
30.000	30.000	12.000	71.00	4.200	3	●
31.000	31.000	12.000	71.00	4.200	3	●

○ bright



Taps for ISO metric threads


Article no. 80730

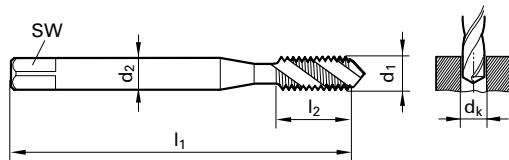


Blind holes

Taps for universal application in materials < 1000 N/mm² such as common structural steels, free cutting steels, case-hardening steels, unalloyed heat-treatable steels, nitriding steels, stainless and acid resistant-steels as well as aluminium and aluminium-alloys.

BASICline

Type TG 100 U
 Standard DIN 371 / DIN 376
 DIN 2184-1
 Tool material HSS-E
 Surface 
 Form C
 Tolerance ISO2/6H



80730

Discount group

156

Availability

d1	P	d2	SW	dk	l1	l2
	mm	mm		mm	mm	mm
M 2	0.40	2.800	2.10	1.600	45.00	4.50
M 3	0.50	3.500	2.70	2.500	56.00	6.00
M 4	0.70	4.500	3.40	3.300	63.00	7.50
M 5	0.80	6.000	4.90	4.200	70.00	8.50
M 6	1.00	6.000	4.90	5.000	80.00	11.00
M 8	1.25	8.000	6.20	6.800	90.00	14.00
M10	1.50	10.000	8.00	8.500	100.00	16.00
M12	1.75	9.000	7.00	10.200	110.00	18.50
M14	2.00	11.000	9.00	12.000	110.00	20.00
M16	2.00	12.000	9.00	14.000	110.00	20.00
M20	2.50	16.000	12.00	17.500	140.00	25.00
M22	2.50	18.000	14.50	19.500	140.00	27.00
M24	3.00	18.000	14.50	21.000	160.00	30.00
M27	3.00	20.000	16.00	24.000	160.00	30.00
M30	3.50	22.000	18.00	26.500	180.00	35.00
M36	4.00	28.000	22.00	32.000	200.00	40.00





Sets in plastic cases

Jobber drill sets

HSS jobber drill sets with TiN tip-coating in plastic case. Containing article 84406.

Ø range mm	in incr. of mm	Drill pieces	Set in case Code no.
1.0 - 5.9	0.1	50	6.015
6.0 - 10.0	0.1	41	6.016
1.0 - 10.5	0.5	24*	6.018
1.0 - 13.0	0.5	25	6.014

* incl. Ø 3.3/4.2/6.8/10.2 mm

88016
Discount group
159
Availability
●
●
●
●



Standard DIN 338
 Tool material **HSS**
 Surface **T** tip-coated
 Type N
 Cutting direction right-hand
 Point grinding Relieved cone
 Point angle ° 118
 Web thinned ≥ Ø 1,0
 Tolerance h8

Set of taps, core hole jobber drills and countersinks

Tap sets with core hole jobber drills and countersinks in plastic case. Containing articles 84406, 80730 and 88200.

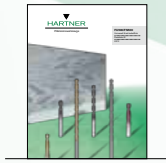
Drill 84406	Tap 80730	Countersink 88200	Set in case Code no.
2.50	M3		1.000
3.30	M4		
4.20	M5	6.3	
5.00	M6	12.4	
6.80	M8		
8.50	M10		

88020
Discount group
156
Availability
●



Standard DIN 371/376/338/335
 Tool material **HSS** **HSS-E**
 Surface ○ ● **T**
 Cutting direction right-hand

Our programme:



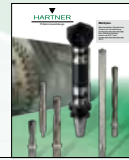
FU 500/FN500



Gun Drills



INOX Drills



Multiplex



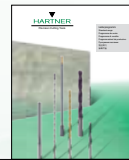
Micro Precision Drills



Multiplex HPC



TS-Drills



Standard Range



Highlights



TM Vending Machines



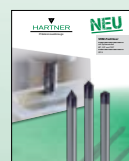
Threading Tools



Solid Carbide
High Performance Milling Cutters



De-burring Tools



Chamfering Milling Cutters



TF 100 Multi-Mill

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