



# HARTNER

Precision Cutting Tools



## MULTI-STEP

TWIST DRILL FOR MAXIMUM PERFECTION



# MULTI-STEP

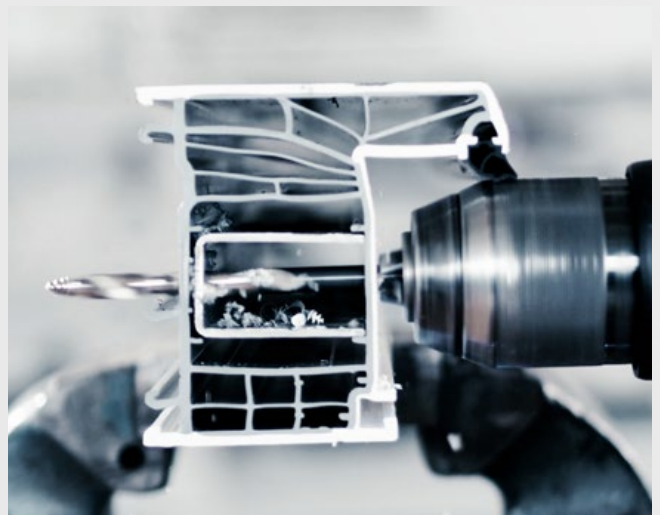
Twist drill for use in hand drilling operations. Quick, safe and reliable drilling with best hole quality thanks to the innovative multi-step point geometry.

## 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/MM<sup>2</sup>

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

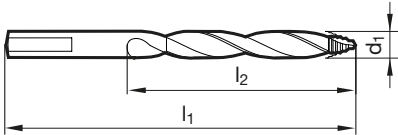
Article no. 81001



|   |   |   |   |   |   |
|---|---|---|---|---|---|
| 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<br>mm | l1<br>mm | l2<br>mm | d1<br>mm | l1<br>mm | l2<br>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   |          |          |          |



# HARTNER

## 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  
 • 3-flats on shank prevent slipping in the chuck • exact, circular holes • perfect for hand drills

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

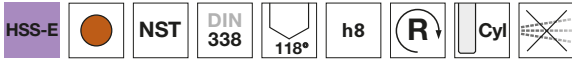


## Jobber drills

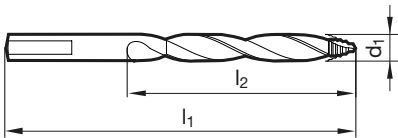
Article no. 81003



|   |   |   |   |   |   |
|---|---|---|---|---|---|
| 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<br>mm | l1<br>mm | l2<br>mm | d1<br>mm | l1<br>mm | l2<br>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 |
| • | • | • | ○ | ○ |   |



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<br>mm | increasing by<br>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

## HARTNER GMBH

P.O. Box 10 04 27 | 72425 Albstadt | Germany  
Tel. +49 74 31 125-0 | Fax +49 74 31 125-21 547

[www.hartner.de](http://www.hartner.de)

No liability can be accepted for printing errors or technical changes of any kind.  
Our Conditions of Sale and Terms of Payment apply. Available on request.

2024