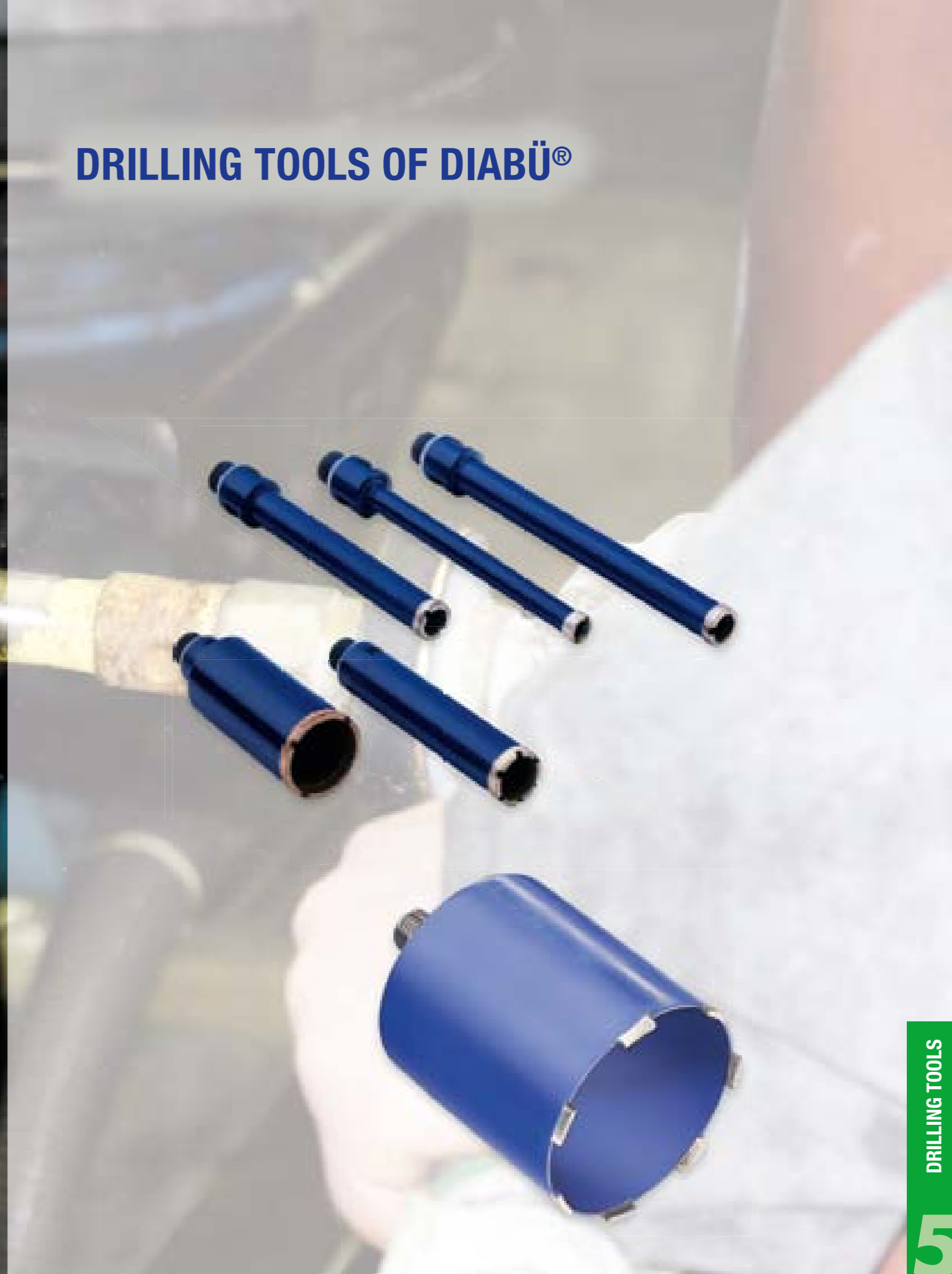




## DRILLING TOOLS OF DIABÜ®

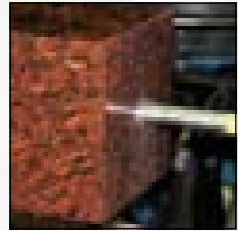




## Drills

### Blind Hole Drills / Diamond Drill for small holes

With crown



Tool body Type	Standard depth of bore (mm)	Ø Outside (mm)	Height (mm)
Hexagon tool body / IG M12x1,5	20	5	10
Hexagon tool body / IG M12x1,5	40	6	10
Hexagon tool body / IG M12x1,5	60	8	10
Hexagon tool body / IG M12x1,5	60	10	10
Hexagon tool body / IG M12x1,5	60	12	10

Further tool bodies:

- Shaft
- Inside thread M14
- Outside thread R1/2"

Material	Colour
Granite	Blue
Marble	Green
Sandstone	Orange

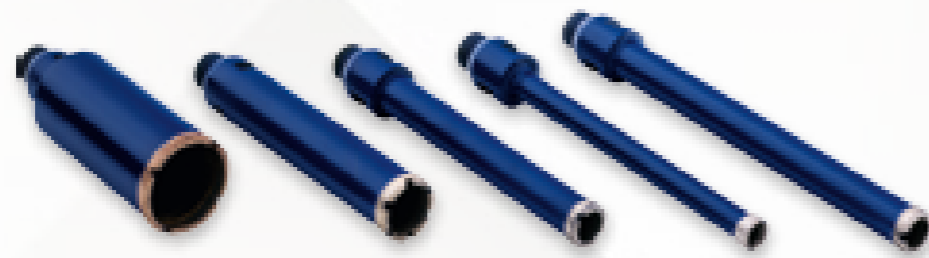


## Core Drills

With ring segment

Tool body Type	Standard depth of bore (mm)	Ring Segment		
		Ø Outside (mm)	Width (mm)	Height (mm)
AG R1/2" / IG M14	60	8	1,5	10
AG R1/2" / IG M14	80	10	1,5	10
AG R1/2" / IG M14	100 / 150	12	1,5	10
AG R1/2" / IG M14	100 / 150	14	2	10
AG R1/2" / IG M14	100 / 150	15	2	10
AG R1/2" / IG M14	100 / 150	16	2	10
AG R1/2" / IG M14	100 / 150	18	2	10
AG R1/2" / IG M14	100 / 150	20	2	10
AG R1/2" / IG M14	100 / 150 / 200	22	2	10
AG R1/2" / IG M14	100 / 150 / 200	24	2	10
AG R1/2" / IG M14	100 / 150 / 200	25	2	10
AG R1/2" / IG M14	100 / 150 / 200	26	2	10
AG R1/2" / IG M14	100 / 150 / 200	27	2	10
AG R1/2" / IG M14	100 / 150 / 200	30	2	10
AG R1/2" / IG M14	100 / 150 / 200	35	2	10
AG R1/2" / IG M14	100 / 150 / 200	38	2	10
AG R1/2" / IG M14	100 / 150 / 200	40	2	10
AG R1/2" / IG M14	100 / 150 / 200	45	2	10
AG R1/2" / IG M14	100 / 150 / 200	50	2	10
AG R1/2" / IG M14	100 / 150 / 200	55	2	10
AG R1/2" / IG M14	100 / 150 / 200	60	2	10
AG R1/2" / IG M14	100 / 150 / 200	65	2	10
AG R1/2" / IG M14	100 / 150 / 200	70	2	10
AG R1/2" / IG M14	100 / 150 / 200	80	2	10

Core Drills: Also available in 2,5 and 3 mm ring width



Please give the following details on your order:

Type for example: Core drills with ring segment  
 Diameter for example: 50 mm  
 Depth of bore for example: 200 mm  
 Tool body for example: AG R1/2" (if shaft is ordered please give diameter of shaft)  
 Material for example: Granite

## Drills

### Core Drills

Segmented

Tool Body Type	Core Drill Ø Outside (mm)	Standard depth of bore (mm)	Segments No. (pcs.)	Segment		
				Length (mm)	Width (mm)	Height (mm)
AG R1/2" / IG M14	25	200	3	18	3,0	7; 10
AG R1/2" / IG M14	30	200	3	18	3,0	7; 10
AG R1/2" / IG M14	35	200	3	18	3,0	7; 10
AG R1/2" / IG M14	40	200	4	18	3,0	7; 10
AG R1/2" / IG M14	50	200	5	18	3,0	7; 10
AG R1/2" / IG M14	61,5	200	5	22; 24	3,0	7; 10
AG R1/2" / IG M14	71,5	200	5	22; 24	3,5	7; 10
AG R1/2" / IG M14	81,5	200	5	22; 24	3,5	7; 10
AG R1/2" / IG M14	91,5	200	6	22; 24	3,5	7; 10
AG R1/2" / IG M14	101,5	200	6	22; 24	3,5	7; 10
AG R1/2" / IG M14	121,5	200	6	22; 24	3,5	7; 10
AG R1/2" / IG M14	151,5	200	6	22; 24	4,0	7; 10
AG R1/2"	202	200	8	22; 24	4,5	7; 10
AG R1/2"	252	200	8	22; 24	4,5	7; 10
AG R1/2"	302	200	10	22; 24	4,5	7; 10



Material	Colour
Granite	Blue
Granite easy cutting	Silver
Granite + Marble Combi	Yellow
Marble	Green
Sandstone	Orange

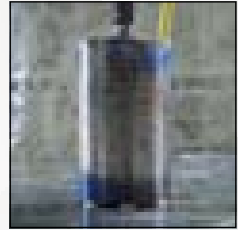
Please give the following details on your order:

Type for example: Core drills, segmented  
 Diameter for example: 101,5 mm  
 Depth of bore for example: 200 mm  
 Tool body for example: AG R1/2" (if shaft is ordered please give diameter of shaft)  
 Material for example: Granite



## Segments / Rings for Drills

Crowns for Diamond Blind Hole Drills



Ø Outside (mm)	Height (mm)
5	10
6	10
8	10
10	10
12	10

Material
Granite
Marble
Sandstone



Ring Segments for Core Drills

Ring segment		
Ø Outside (mm)	Width (mm)	Height (mm)
8	1,5	10
10	1,5	10
12	1,5	10
14	2	10
15	2	10
16	2	10
18	2	10
20	2	10
22	2	10
24	2	10
25	2	10
26	2	10
27	2	10
30	2	10
35	2	10
38	2	10
40	2	10
45	2	10
50	2	10
55	2	10
60	2	10
65	2	10
70	2	10
80	2	10



Core Drills: Also available in 2,5 and 3 mm ring width

Segments for Core Drills

Drill hole Diameter (mm)	Segment		
	Length (mm)	Width (mm)	Height (mm)
25	18	3	7; 10
30	18	3	7; 10
35	18	3	7; 10
40	18	3	7; 10
50	18	3	7; 10
61,5	22; 24	3	7; 10
71,5	22; 24	3,5	7; 10
81,5	22; 24	3,5	7; 10
91,5	22; 24	3,5	7; 10
101,5	22; 24	3,5	7; 10
121,5	22; 24	3,5	7; 10
151,5	22; 24	4	7; 10
202	22; 24	4,5	7; 10
252	22; 24	4,5	7; 10
302	22; 24	4,5	7; 10

Material
Granite
Granite easy cutting
Granite + Marble Combi
Marble
Sandstone



Please give the following details on your order:

Finish for example: Segment  
 Size for example: 24x4,5x10 mm  
 Material for example: Granite

## Recommended Parameters

Blind Hole Drills and Core Drills

Diameter (mm)	Speed range at 2 – 4 m/s (U/min)	Speed range at 1 – 1,5 m/s (U/min)	Generated power (kW)	Amount of coolant (l/min)
6	6300 – 12500	3150 – 4800	1	2
8	5000 – 10000	2500 – 3600	1	2
10	4000 – 8000	2000 – 2900	1	3
12	3200 – 6400	1600 – 2400	1	3
14	2800 – 5500	1400 – 2100	1	3
16	2400 – 4800	1200 – 1800	1	3
18	2100 – 4250	1050 – 1600	1	3
20	1900 – 3800	950 – 1500	1	3
22	1750 – 3500	875 – 1300	1	3
24	1600 – 3200	800 – 1200	1	3
25	1500 – 3000	750 – 1200	1	3
26	1500 – 3000	750 – 1100	1	3
29	1300 – 2600	650 – 1000	1	3
30	1250 – 2500	625 – 950	1	3,5
35	1100 – 2200	550 – 850	1	3,5
40	1000 – 1900	500 – 750	1	3,5
45	850 – 1700	425 – 650	1	4
50	750 – 1500	375 – 600	1	4,5
60	650 – 1250	325 – 500	1,5	5,5
70	550 – 1100	275 – 425	1,5	6
75	500 – 1000	250 – 400	1,5	6,5
80	480 – 960	240 – 360	1,5	7
90	430 – 850	215 – 320	1,5	8
100	380 – 760	180 – 300	1,5	8,5
120	400	200 – 250	2	9,5
140	350	210	2	10,5
160	320	180	2	12
180	270	160	3	13
200	230	150	3	15
250	190	120	3	17
300	160	100	68	20

Peripheral speed

	Hard stone	Soft stone
Core drills	1 – 1,5 m/s	2 – 4 m/s
Blind hole drills	2 – 3 m/s	

Recommendations:

- Keep within the recommended speed range of the machine; that way the tools cut well and work economically.
- Pay attention to sufficient water supply; during working/cutting the water should permanently flow out of the bore hole.
- Do not work with high pressure.
- Interrupt traverse feed again and again for a short time; particularly important with deeper holes or extremely muddy/abrasive materials; too high or continuous drill pressure stop cooling and washing away of the abrasive mud.
- Recharge exhausted cooling water slots, because otherwise damages by insufficient supply of cooling water can occur.
- When cutting effects decreases, sharpen tools with a few drills in sandstone.