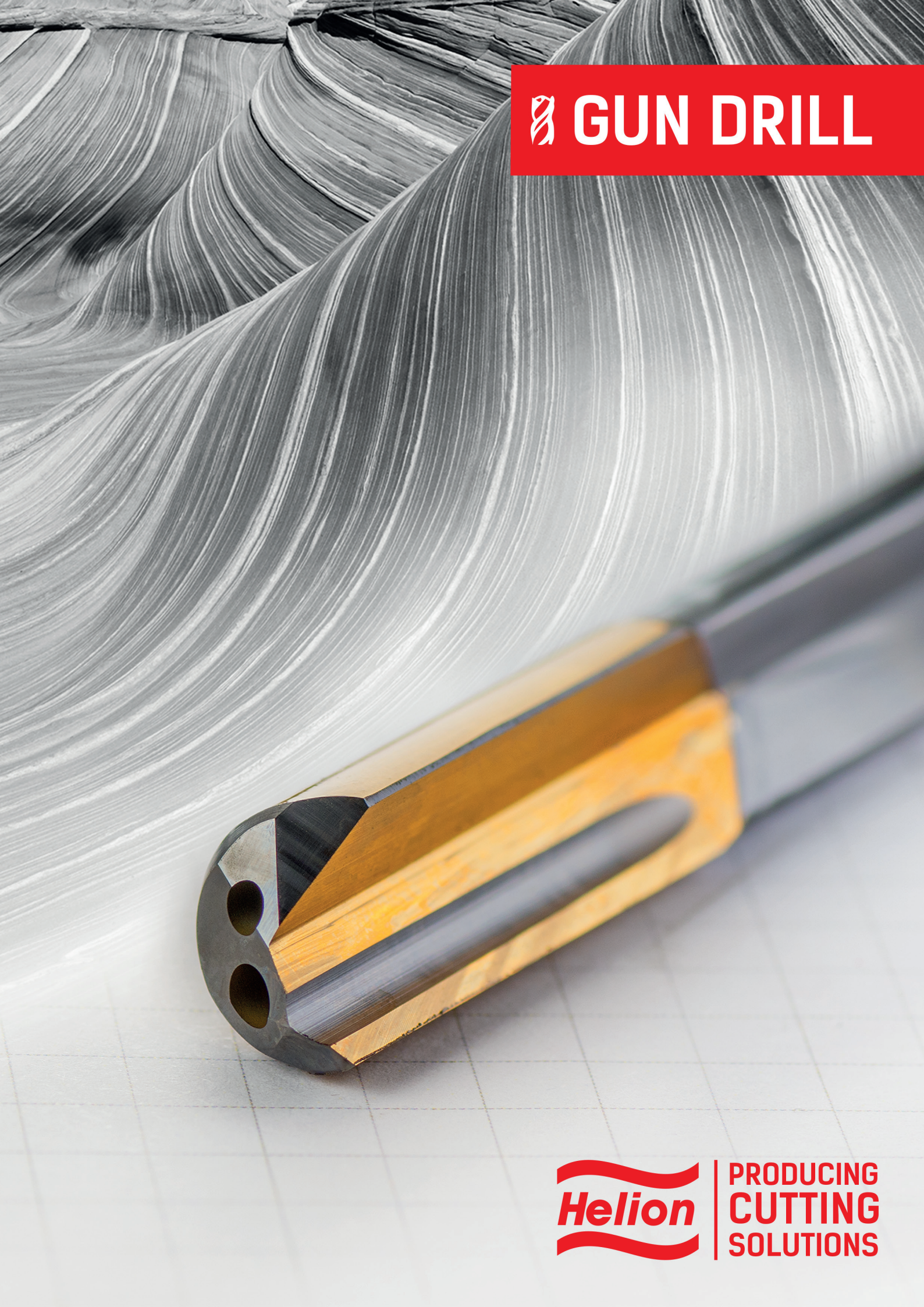
GUN DRILL



Helion

PRODUCING
CUTTING
SOLUTIONS

66.5018

GUN DRILL

Brocas monolabio

SC

600 1200 N/mm²

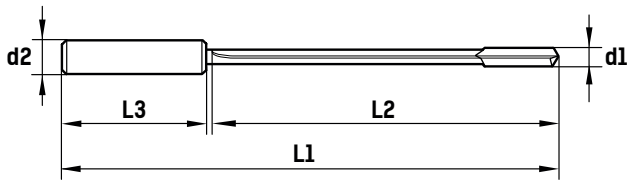
TiN Up

GG(G)

20XD

h5 TOLERANCE

HA

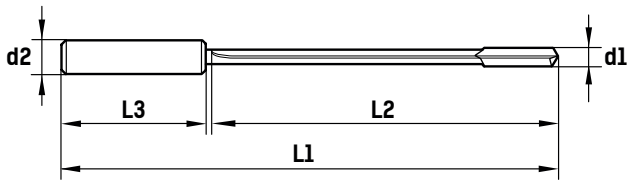


Cod.	d1	d2	L1	L2	L3
66501800400	4,000	12,00	150,00	100,00	45,00
66501800420	4,200	12,00	160,00	110,00	45,00
66501800450	4,500	12,00	170,00	120,00	45,00
66501800500	5,000	16,00	180,00	130,00	48,00
66501800550	5,500	16,00	190,00	140,00	48,00
66501800600	6,000	16,00	210,00	160,00	48,00
66501800650	6,500	16,00	220,00	170,00	48,00
66501800700	7,000	16,00	235,00	185,00	48,00
66501800800	8,000	16,00	260,00	210,00	48,00
66501800900	9,000	16,00	280,00	230,00	48,00
66501801000	10,000	20,00	320,00	260,00	50,00
66501801200	12,000	20,00	370,00	310,00	50,00

GUN DRILL

Brocas monolabio

66.5460



Cod.	d1	d2	L1	L2	L3
66546000400	4,000	12,00	200,00	155,00	45,00
66546000420	4,200	12,00	210,00	165,00	45,00
66546000450	4,500	12,00	220,00	175,00	45,00
66546000500	5,000	16,00	230,00	182,00	48,00
66546000550	5,500	16,00	245,00	197,00	48,00
66546000600	6,000	16,00	260,00	212,00	48,00
66546000650	6,500	16,00	275,00	227,00	48,00
66546000700	7,000	16,00	290,00	242,00	48,00
66546000800	8,000	16,00	320,00	272,00	48,00
66546000900	9,000	16,00	350,00	302,00	48,00
66546001000	10,000	20,00	400,00	350,00	50,00
66546001200	12,000	20,00	450,00	400,00	50,00

SC

600 1200 N/mm²

TiN Up

GG(G)

30XD

h5 TOLERANCE

HA

66.5022

GUN DRILL

Brocas monolabio

SC

600 1200 N/mm²

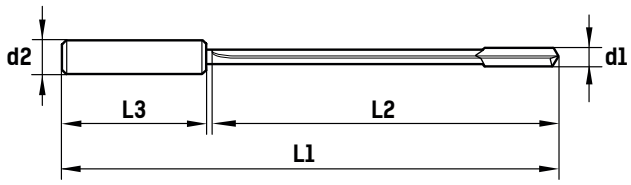
TiN Up

GG(G)

40XD

h5 TOLERANCE

HA

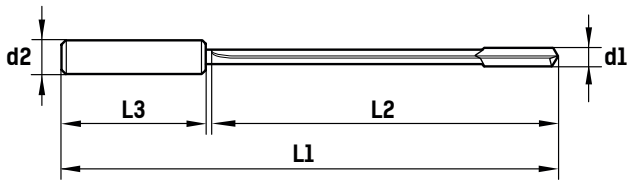


Cod.	d1	d2	L1	L2	L3
66502200400	4,000	12,00	230,00	185,00	45,00
66502200420	4,200	12,00	240,00	195,00	45,00
66502200450	4,500	12,00	250,00	205,00	45,00
66502200500	5,000	16,00	280,00	232,00	48,00
66502200550	5,500	16,00	300,00	252,00	48,00
66502200600	6,000	16,00	320,00	272,00	48,00
66502200650	6,500	16,00	340,00	292,00	48,00
66502200700	7,000	16,00	370,00	322,00	48,00
66502200800	8,000	16,00	420,00	372,00	48,00
66502200900	9,000	16,00	450,00	402,00	48,00
66502201000	10,000	20,00	510,00	460,00	50,00
66502201200	12,000	20,00	600,00	550,00	50,00

GUN DRILL

Brocas monolabio

66.5023



Cod.	d1	d2	L1	L2	L3
66502300495	4,950	16,00	480,00	432,00	48,00
66502300595	5,950	16,00	560,00	512,00	48,00
66502300795	7,950	16,00	740,00	692,00	48,00
66502300995	9,950	20,00	910,00	860,00	50,00
66502301195	11,950	20,00	1080,00	1030,00	50,00

SC

600 1200 N/mm²

TiN Up

GG(G)

80XD

h5 TOLERANCE

HA

66.5639

GUN DRILL

Brocas monolabio

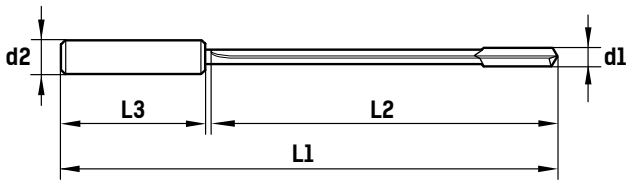
SC

INOX | TITAN INCONELL

SHARK | 20XD

h5 TOLERANCE

HA



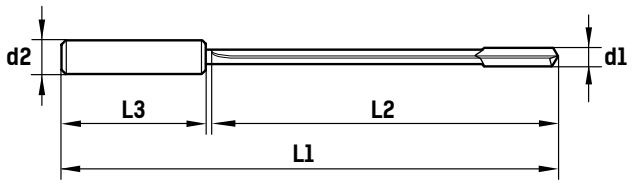
Cod.	d1	d2	L1	L2	L3
66563900397	3,970	10,00	150,00	100,00	40,00
66563900400	4,000	12,00	150,00	100,00	45,00
66563900420	4,200	12,00	160,00	110,00	45,00
66563900450	4,500	12,00	170,00	120,00	45,00
66563900500	5,000	16,00	180,00	130,00	48,00
66563900515	5,156	16,00	180,00	130,00	48,00
66563900550	5,500	16,00	190,00	140,00	48,00
66563900600	6,000	16,00	210,00	160,00	48,00
66563900635	6,350	16,00	220,00	170,00	48,00
66563900650	6,500	16,00	220,00	170,00	48,00
66563900700	7,000	16,00	235,00	185,00	48,00
66563900793	7,938	16,00	260,00	210,00	48,00
66563900800	8,000	16,00	260,00	210,00	48,00
66563900900	9,000	16,00	280,00	230,00	48,00
66563900952	9,525	16,00	290,00	240,00	48,00
66563901000	10,000	20,00	320,00	260,00	50,00
66563901100	11,000	20,00	340,00	290,00	50,00
66563901111	11,113	20,00	340,00	290,00	50,00
66563901200	12,000	20,00	370,00	310,00	50,00
66563901270	12,700	20,00	385,00	330,00	50,00

The BIG JUMP 2023 2024 Helion

GUN DRILL

Brocas monolabio

66.5640



SC

INOX

TITAN INCONELL

SHARK

30XD

h5 TOLERANCE

HA

Cod.	d1	d2	L1	L2	L3
66564000397	3,970	10,00	200,00	155,00	40,00
66564000400	4,000	12,00	200,00	155,00	45,00
66564000420	4,200	12,00	210,00	165,00	45,00
66564000450	4,500	12,00	220,00	175,00	45,00
66564000500	5,000	16,00	230,00	182,00	48,00
66564000515	5,156	16,00	230,00	182,00	48,00
66564000550	5,500	16,00	245,00	197,00	48,00
66564000600	6,000	16,00	260,00	212,00	48,00
66564000635	6,350	16,00	275,00	227,00	48,00
66564000650	6,500	16,00	275,00	227,00	48,00
66564000700	7,000	16,00	290,00	242,00	48,00
66564000793	7,938	16,00	320,00	272,00	48,00
66564000800	8,000	16,00	320,00	272,00	48,00
66564000900	9,000	16,00	350,00	302,00	48,00
66564000952	9,525	16,00	380,00	330,00	48,00
66564001000	10,000	20,00	400,00	350,00	50,00
66564001100	11,000	20,00	430,00	380,00	50,00
66564001111	11,113	20,00	430,00	380,00	50,00
66564001200	12,000	20,00	450,00	400,00	50,00
66564001270	12,700	20,00	500,00	450,00	50,00

66.5641

GUN DRILL

Brocas monolabio

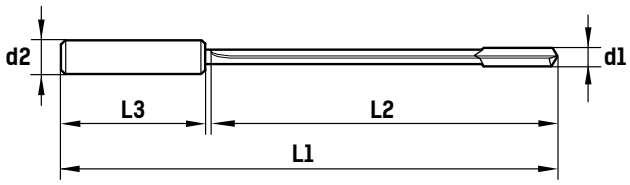
SC

INOX | TITAN INCONELL

SHARK | 40XD

h5 TOLERANCE

HA



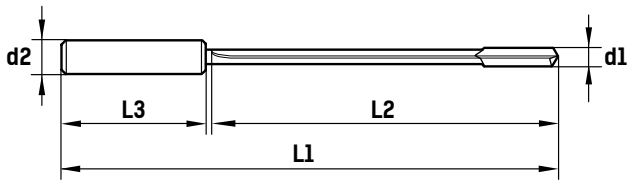
Cod.	d1	d2	L1	L2	L3
66564100397	3,969	10,00	230,00	185,00	40,00
66564100400	4,000	12,00	230,00	185,00	45,00
66564100420	4,200	12,00	240,00	195,00	45,00
66564100450	4,500	12,00	250,00	205,00	45,00
66564100500	5,000	16,00	280,00	232,00	48,00
66564100515	5,159	16,00	280,00	232,00	48,00
66564100550	5,500	16,00	300,00	252,00	48,00
66564100600	6,000	16,00	320,00	272,00	48,00
66564100635	6,350	16,00	340,00	292,00	48,00
66564100650	6,500	16,00	340,00	292,00	48,00
66564100700	7,000	16,00	370,00	322,00	48,00
66564100793	7,938	16,00	420,00	372,00	48,00
66564100800	8,000	16,00	420,00	372,00	48,00
66564100900	9,000	16,00	450,00	402,00	48,00
66564100952	9,525	16,00	490,00	432,00	48,00
66564101000	10,000	20,00	510,00	460,00	50,00
66564101100	11,000	20,00	550,00	500,00	50,00
66564101111	11,113	20,00	550,00	500,00	50,00
66564101200	12,000	20,00	600,00	550,00	50,00
66564101270	12,700	20,00	635,00	585,00	50,00

23 24 The BIG JUMP
Helion

GUN DRILL

Brocas monolabio

66.5642



Cod.	d1	d2	L1	L2	L3
66564200495	4,950	16,00	480,00	432,00	48,00
66564200510	5,106	16,00	480,00	432,00	48,00
66564200545	5,450	16,00	520,00	470,00	48,00
66564200595	5,953	16,00	560,00	512,00	48,00
66564200630	6,300	16,00	590,00	542,00	48,00
66564200645	6,450	16,00	605,00	556,00	48,00
66564200695	6,950	16,00	650,00	602,00	48,00
66564200788	7,888	16,00	740,00	692,00	48,00
66564200795	7,950	16,00	740,00	692,00	48,00
66564200895	8,950	16,00	820,00	772,00	48,00
66564200947	9,475	16,00	870,00	822,00	48,00
66564200995	9,950	20,00	910,00	860,00	50,00
66564201095	10,950	20,00	995,00	945,00	50,00
66564201106	11,063	20,00	995,00	945,00	50,00
66564201195	11,950	20,00	1080,00	1030,00	50,00
66564201265	12,650	20,00	1140,00	1090,00	50,00

SC

INOX

TITAN INCONELL

SHARK

80XD

h5 TOLERANCE

HA

66.5689

GUN DRILL

Brocas monolabio

SC

ALU NE

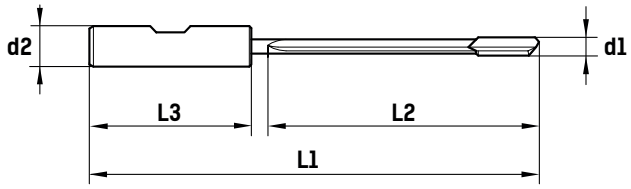
TITAN INCONELL

BRIGHT

40XD

h5 TOLERANCE

HB

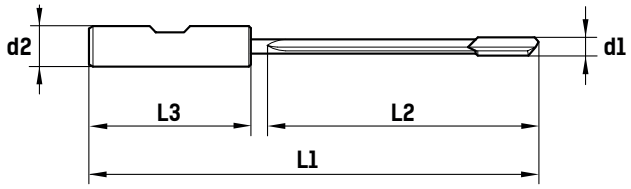


Cod.	d1	d2	L1	L2	L3
66568900400	4,000	12,00	230,00	185,00	45,00
66568900500	5,000	16,00	280,00	232,00	48,00
66568900600	6,000	16,00	320,00	272,00	48,00
66568900700	7,000	16,00	370,00	322,00	48,00
66568900800	8,000	16,00	420,00	372,00	48,00
66568900900	9,000	16,00	450,00	402,00	48,00
66568901000	10,000	20,00	510,00	460,00	50,00
66568901200	12,000	20,00	600,00	550,00	50,00

GUN DRILL

Brocas monolabio

66.5690



Cod.	d1	d2	L1	L2	L3
66569000397	3,969	10,00	390,00	350,00	40,00
66569000495	4,950	16,00	480,00	432,00	48,00
66569000595	5,953	16,00	560,00	512,00	48,00
66569000695	6,950	16,00	740,00	692,00	48,00
66569000795	7,950	16,00	740,00	692,00	48,00
66569000895	8,950	16,00	910,00	860,00	48,00
66569000995	9,950	20,00	910,00	860,00	50,00
66569001195	11,950	20,00	1080,00	1030,00	50,00

SC

ALU NE

TITAN INCONELL

BRIGHT

80XD

h5 TOLERANCE

HB

66.5688

GUN DRILL XXL

Brocas monolabio XXL

SC

600 1200 N/mm²

TiN Up

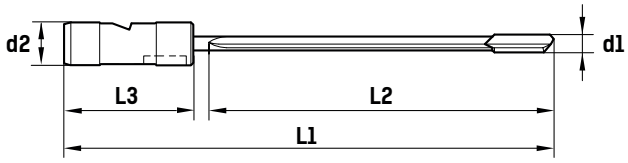
GG(G)

ALU NE

GL 600

h5 TOLERANCE

TBM-SEH

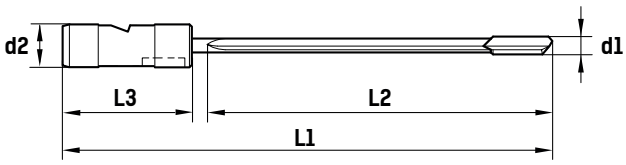


Cod.	d1	d2	L1	L2	L3
66568800300	3,000	25,00	600,00	500,00	70,00
66568800400	4,000	25,00	600,00	500,00	70,00
66568800500	5,000	25,00	600,00	500,00	70,00
66568800600	6,000	25,00	600,00	500,00	70,00
66568800700	7,000	25,00	600,00	500,00	70,00
66568800800	8,000	25,00	600,00	500,00	70,00
66568800900	9,000	25,00	600,00	500,00	70,00
66568801000	10,000	25,00	600,00	500,00	70,00
66568801100	11,000	25,00	600,00	500,00	70,00
66568801150	11,500	25,00	600,00	500,00	70,00
66568801200	12,000	25,00	600,00	500,00	70,00
66568801300	13,000	25,00	600,00	500,00	70,00
66568801400	14,000	25,00	600,00	500,00	70,00
66568801500	15,000	25,00	600,00	500,00	70,00
66568801600	16,000	25,00	600,00	500,00	70,00
66568801700	17,000	25,00	600,00	500,00	70,00
66568801800	18,000	25,00	600,00	500,00	70,00
66568801900	19,000	25,00	600,00	500,00	70,00
66568802000	20,000	25,00	600,00	500,00	70,00
66568802100	21,000	25,00	600,00	500,00	70,00
66568802200	22,000	25,00	600,00	500,00	70,00
66568802300	23,000	25,00	600,00	500,00	70,00
66568802400	24,000	25,00	600,00	500,00	70,00
66568802500	25,000	25,00	600,00	500,00	70,00

GUN DRILL XXL

Brocas monolabio XXL

66.5691



SC

600 1200 N/mm²

TiN Up

GG(G)

ALU NE

GL 800

h5 TOLERANCE

TBM-SEH

Cod.	d1	d2	L1	L2	L3
66569100300	3,000	25,00	800,00	700,00	70,00
66569100400	4,000	25,00	800,00	700,00	70,00
66569100500	5,000	25,00	800,00	700,00	70,00
66569100600	6,000	25,00	800,00	700,00	70,00
66569100700	7,000	25,00	800,00	700,00	70,00
66569100800	8,000	25,00	800,00	700,00	70,00
66569100900	9,000	25,00	800,00	700,00	70,00
66569101000	10,000	25,00	800,00	700,00	70,00
66569101100	11,000	25,00	800,00	700,00	70,00
66569101150	11,500	25,00	800,00	700,00	70,00
66569101200	12,000	25,00	800,00	700,00	70,00
66569101300	13,000	25,00	800,00	700,00	70,00
66569101400	14,000	25,00	800,00	700,00	70,00
66569101500	15,000	25,00	800,00	700,00	70,00
66569101600	16,000	25,00	800,00	700,00	70,00
66569101700	17,000	25,00	800,00	700,00	70,00
66569101800	18,000	25,00	800,00	700,00	70,00
66569101900	19,000	25,00	800,00	700,00	70,00
66569102000	20,000	25,00	800,00	700,00	70,00
66569102100	21,000	25,00	800,00	700,00	70,00
66569102200	22,000	25,00	800,00	700,00	70,00
66569102300	23,000	25,00	800,00	700,00	70,00
66569102400	24,000	25,00	800,00	700,00	70,00
66569102500	25,000	25,00	800,00	700,00	70,00

66.5164

GUN DRILL XXL

Brocas monolabio XXL

SC

600 1200 N/mm²

TiN Up

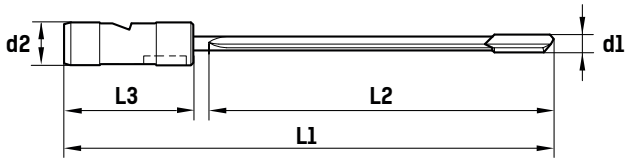
GG(G)

ALU NE

GL 1000

h5 TOLERANCE

TBM-SEH

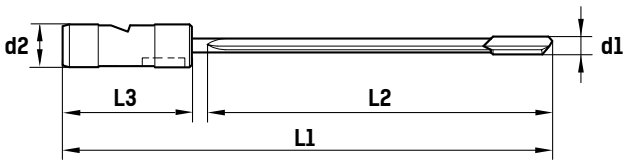


Cod.	d1	d2	L1	L2	L3
66516400300	3,000	25,00	1000,00	900,00	70,00
66516400400	4,000	25,00	1000,00	900,00	70,00
66516400500	5,000	25,00	1000,00	900,00	70,00
66516400600	6,000	25,00	1100,00	900,00	70,00
66516400700	7,000	25,00	1100,00	900,00	70,00
66516400800	8,000	25,00	1100,00	900,00	70,00
66516400900	9,000	25,00	1000,00	900,00	70,00
66516401000	10,000	25,00	1100,00	900,00	70,00
66516401100	11,000	25,00	1000,00	900,00	70,00
66516401150	11,500	25,00	1000,00	900,00	70,00
66516401200	12,000	25,00	1100,00	900,00	70,00
66516401300	13,000	25,00	1000,00	900,00	70,00
66516401400	14,000	25,00	1000,00	900,00	70,00
66516401500	15,000	25,00	1000,00	900,00	70,00
66516401600	16,000	25,00	1100,00	900,00	70,00
66516401700	17,000	25,00	1000,00	900,00	70,00
66516401800	18,000	25,00	1000,00	900,00	70,00
66516401900	19,000	25,00	1000,00	900,00	70,00
66516402000	20,000	25,00	1100,00	900,00	70,00
66516402100	21,000	25,00	1000,00	900,00	70,00
66516402200	22,000	25,00	1100,00	900,00	70,00
66516402300	23,000	25,00	1000,00	900,00	70,00
66516402400	24,000	25,00	1000,00	900,00	70,00
66516402500	25,000	25,00	1000,00	900,00	70,00

GUN DRILL XXL

Brocas monolabio XXL

66.5692



SC

600 1200 N/mm²

TiN Up

GG(G)

ALU NE

GL 1200

h5 TOLERANCE

TBM-SEH

Cod.	d1	d2	L1	L2	L3
66569200300	3,000	25,00	1200,00	1100,00	70,00
66569200400	4,000	25,00	1200,00	1100,00	70,00
66569200500	5,000	25,00	1200,00	1100,00	70,00
66569200600	6,000	25,00	1200,00	1100,00	70,00
66569200700	7,000	25,00	1200,00	1100,00	70,00
66569200800	8,000	25,00	1200,00	1100,00	70,00
66569200900	9,000	25,00	1200,00	1100,00	70,00
66569201000	10,000	25,00	1200,00	1100,00	70,00
66569201100	11,000	25,00	1200,00	1100,00	70,00
66569201150	11,500	25,00	1200,00	1100,00	70,00
66569201200	12,000	25,00	1200,00	1100,00	70,00
66569201300	13,000	25,00	1200,00	1100,00	70,00
66569201400	14,000	25,00	1200,00	1100,00	70,00
66569201500	15,000	25,00	1200,00	1100,00	70,00
66569201600	16,000	25,00	1200,00	1100,00	70,00
66569201700	17,000	25,00	1200,00	1100,00	70,00
66569201800	18,000	25,00	1200,00	1100,00	70,00
66569201900	19,000	25,00	1200,00	1100,00	70,00
66569202000	20,000	25,00	1200,00	1100,00	70,00
66569202100	21,000	25,00	1200,00	1100,00	70,00
66569202200	22,000	25,00	1200,00	1100,00	70,00
66569202300	23,000	25,00	1200,00	1100,00	70,00
66569202400	24,000	25,00	1200,00	1100,00	70,00
66569202500	25,000	25,00	1200,00	1100,00	70,00

66.5681

GUN DRILL XXL

Brocas monolabio XXL

SC

600 1200 N/mm²

TiN Up

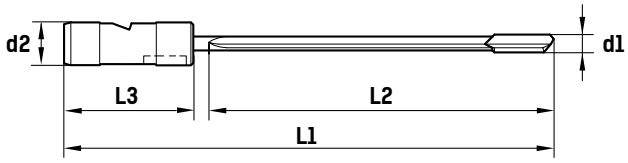
GG(G)

ALU NE

GL 1400

h5 TOLERANCE

TBM-SEH



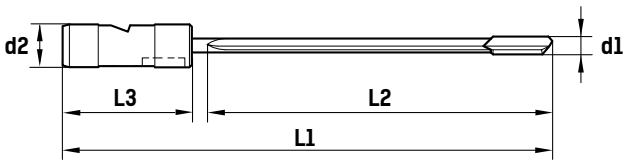
Cod.	d1	d2	L1	L2	L3
66568100400	4,000	25,00	1400,00	1300,00	70,00
66568100500	5,000	25,00	1400,00	1300,00	70,00
66568100600	6,000	25,00	1400,00	1300,00	70,00
66568100700	7,000	25,00	1400,00	1300,00	70,00
66568100800	8,000	25,00	1400,00	1300,00	70,00
66568100900	9,000	25,00	1400,00	1300,00	70,00
66568101000	10,000	25,00	1400,00	1300,00	70,00
66568101100	11,000	25,00	1400,00	1300,00	70,00
66568101150	11,500	25,00	1400,00	1300,00	70,00
66568101200	12,000	25,00	1400,00	1300,00	70,00
66568101300	13,000	25,00	1400,00	1300,00	70,00
66568101400	14,000	25,00	1400,00	1300,00	70,00
66568101500	15,000	25,00	1400,00	1300,00	70,00
66568101600	16,000	25,00	1400,00	1300,00	70,00
66568101700	17,000	25,00	1400,00	1300,00	70,00
66568101800	18,000	25,00	1400,00	1300,00	70,00
66568101900	19,000	25,00	1400,00	1300,00	70,00
66568102000	20,000	25,00	1400,00	1300,00	70,00
66568102100	21,000	25,00	1400,00	1300,00	70,00
66568102200	22,000	25,00	1400,00	1300,00	70,00
66568102300	23,000	25,00	1400,00	1300,00	70,00
66568102400	24,000	25,00	1400,00	1300,00	70,00
66568102500	25,000	25,00	1400,00	1300,00	70,00

23 24 The BIG JUMP Helion

GUN DRILL XXL

Brocas monolabio XXL

66.5693



SC

600 1200 N/mm²

TiN Up

GG(G)

ALU NE

GL 1600

h5 TOLERANCE

TBM-SEH

Cod.	d1	d2	L1	L2	L3
66569300400	4,000	25,00	1600,00	1500,00	70,00
66569300500	5,000	25,00	1600,00	1500,00	70,00
66569300550	5,500	25,00	1600,00	1500,00	70,00
66569300600	6,000	25,00	1600,00	1500,00	70,00
66569300650	6,500	25,00	1600,00	1500,00	70,00
66569300700	7,000	25,00	1600,00	1500,00	70,00
66569300750	7,500	25,00	1600,00	1500,00	70,00
66569300800	8,000	25,00	1600,00	1500,00	70,00
66569300900	9,000	25,00	1600,00	1500,00	70,00
66569300950	9,500	25,00	1600,00	1500,00	70,00
66569301000	10,000	25,00	1600,00	1500,00	70,00
66569301100	11,000	25,00	1600,00	1500,00	70,00
66569301150	11,500	25,00	1600,00	1500,00	70,00
66569301200	12,000	25,00	1600,00	1500,00	70,00
66569301300	13,000	25,00	1600,00	1500,00	70,00
66569301400	14,000	25,00	1600,00	1500,00	70,00
66569301500	15,000	25,00	1600,00	1500,00	70,00
66569301600	16,000	25,00	1600,00	1500,00	70,00
66569301700	17,000	25,00	1600,00	1500,00	70,00
66569301800	18,000	25,00	1600,00	1500,00	70,00
66569301900	19,000	25,00	1600,00	1500,00	70,00
66569302000	20,000	25,00	1600,00	1500,00	70,00
66569302100	21,000	25,00	1600,00	1500,00	70,00
66569302200	22,000	25,00	1600,00	1500,00	70,00
66569302300	23,000	25,00	1600,00	1500,00	70,00
66569302400	24,000	25,00	1600,00	1500,00	70,00
66569302500	25,000	25,00	1600,00	1500,00	70,00

66.5682

GUN DRILL XXL

Brocas monolabio XXL

SC

600 1200 N/mm²

TiN Up

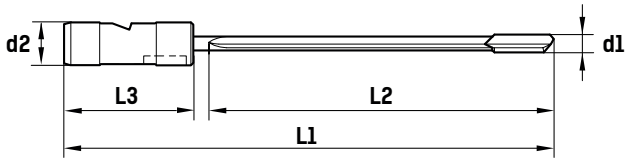
GG(G)

ALU NE

GL 1800

h5 TOLERANCE

TBM-SEH

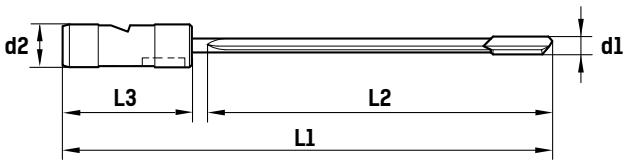


Cod.	d1	d2	L1	L2	L3
66568200400	4,000	25,00	1800,00	1700,00	70,00
66568200500	5,000	25,00	1800,00	1700,00	70,00
66568200600	6,000	25,00	1800,00	1700,00	70,00
66568200700	7,000	25,00	1800,00	1700,00	70,00
66568200800	8,000	25,00	1800,00	1700,00	70,00
66568200900	9,000	25,00	1800,00	1700,00	70,00
66568201000	10,000	25,00	1800,00	1700,00	70,00
66568201100	11,000	25,00	1800,00	1700,00	70,00
66568201150	11,500	25,00	1800,00	1700,00	70,00
66568201200	12,000	25,00	1800,00	1700,00	70,00
66568201300	13,000	25,00	1800,00	1700,00	70,00
66568201400	14,000	25,00	1800,00	1700,00	70,00
66568201500	15,000	25,00	1800,00	1700,00	70,00
66568201600	16,000	25,00	1800,00	1700,00	70,00
66568201700	17,000	25,00	1800,00	1700,00	70,00
66568201800	18,000	25,00	1800,00	1700,00	70,00
66568201900	19,000	25,00	1800,00	1700,00	70,00
66568202000	20,000	25,00	1800,00	1700,00	70,00
66568202100	21,000	25,00	1800,00	1700,00	70,00
66568202200	22,000	25,00	1800,00	1700,00	70,00
66568202300	23,000	25,00	1800,00	1700,00	70,00
66568202400	24,000	25,00	1800,00	1700,00	70,00
66568202500	25,000	25,00	1800,00	1700,00	70,00
66568202600	26,000	25,00	1800,00	1695,00	70,00
66568202700	27,000	25,00	1800,00	1695,00	70,00
66568202800	28,000	25,00	1800,00	1695,00	70,00
66568202900	29,000	25,00	1800,00	1695,00	70,00
66568203000	30,000	25,00	1800,00	1695,00	70,00
66568203100	31,000	25,00	1800,00	1695,00	70,00
66568203200	32,000	25,00	1800,00	1695,00	70,00

GUN DRILL XXL

Brocas monolabio XXL

66.5694



SC

600 1200 N/mm²

TiN Up

GG(G)

ALU NE

GL 2000

h5 TOLERANCE

TBM-SEH

Cod.	d1	d2	L1	L2	L3
66569400400	4,000	25,00	2000,00	1900,00	70,00
66569400500	5,000	25,00	2000,00	1900,00	70,00
66569400600	6,000	25,00	2000,00	1900,00	70,00
66569400700	7,000	25,00	2000,00	1900,00	70,00
66569400800	8,000	25,00	2000,00	1900,00	70,00
66569400900	9,000	25,00	2000,00	1900,00	70,00
66569401000	10,000	25,00	2000,00	1900,00	70,00
66569401100	11,000	25,00	2000,00	1900,00	70,00
66569401150	11,500	25,00	2000,00	1900,00	70,00
66569401200	12,000	25,00	2000,00	1900,00	70,00
66569401300	13,000	25,00	2000,00	1900,00	70,00
66569401400	14,000	25,00	2000,00	1900,00	70,00
66569401500	15,000	25,00	2000,00	1900,00	70,00
66569401600	16,000	25,00	2000,00	1900,00	70,00
66569401700	17,000	25,00	2000,00	1900,00	70,00
66569401800	18,000	25,00	2000,00	1900,00	70,00
66569401900	19,000	25,00	2000,00	1900,00	70,00
66569402000	20,000	25,00	2000,00	1900,00	70,00
66569402100	21,000	25,00	2000,00	1900,00	70,00
66569402200	22,000	25,00	2000,00	1900,00	70,00
66569402300	23,000	25,00	2000,00	1900,00	70,00
66569402400	24,000	25,00	2000,00	1900,00	70,00
66569402500	25,000	25,00	2000,00	1900,00	70,00
66569402600	26,000	25,00	2000,00	1895,00	70,00
66569402700	27,000	25,00	2000,00	1895,00	70,00
66569402800	28,000	25,00	2000,00	1895,00	70,00
66569402900	29,000	25,00	2000,00	1895,00	70,00
66569403000	30,000	25,00	2000,00	1895,00	70,00
66569403100	31,000	25,00	2000,00	1895,00	70,00
66569403200	32,000	25,00	2000,00	1895,00	70,00

CUTTING CONDITIONS • CONDICIONES DE CORTE

	Código de serie de avances									
Brocas	**20**	19	18	17	16	15	14	13	12	11
Ø mm	f (mm/vuelta)									
1,0	**50**	30	22	15	10	6	4	3	2	1
1,5	**75**	50	45	32	20	12	8	6	4	2
2,0	**100**	60	55	46	28	16	10	7	5	3
2,5	**125**	75	70	54	30	18	12	8	6	4
4,0	**240**	120	85	65	43	25	16	10	7	5
6,0	**360**	180	120	85	61	35	24	13	9	7
8,0	**480**	240	150	100	68	45	32	22	14	10
10,0	**600**	300	160	120	75	55	40	28	16	12
14,0	**700**	350	180	130	85	65	50	35	25	20
20,0	**800**	400	250	180	110	80	60	45	35	26
24,0	**900**	450	300	185	130	85	65	47	36	27
30,0	**1,050**	500	400	200	150	100	70	50	40	30
35,0	**1,100**	600	450	250	180	120	75	55	45	35
40,0	**1,200**	700	500	300	200	150	80	60	50	40
52,0	**1,300**	800	550	350	230	180	100	70	60	50

Refrigerante según material:
○ aire
● aceite
● emulsión

*Los valores de avance se refieren siempre a las herramientas con el recubrimiento recomendado.
En algunos casos, el funcionamiento de las herramientas sin recubrimiento no se puede garantizar.

*Todas las brocas cañón se tienen que guiar al iniciar el taladro. Las brocas para agujeros profundos no se deben mover nunca a plena velocidad libremente en el espacio de la máquina.

CUTTING CONDITIONS • CONDICIONES DE CORTE

Grupo de materiales	Ejemplos de materiales Cifras en negrita = N° de material según DIN EN	Resist. N/mm2	Dureza	Ref.	Coat.	Broca monolabio 2,000 ... 4,000 ≥35xD Vc m/min	≥35xD Código avance	>35xD Vc m/min	>35xD Código avance
Aceros de constr. generales	**1.0035** S185(St33), **1.0486** P275N(StE285), **1.0345** **1.0050** E295 (St50-2), **1.0070** E360 (St70-2), **1.8937**	≤500 ≤1000		●● ●●	BRIGHT	100 85	14 14	95 80	13 13
Aceros automáticos	**1.0718** 11SMnPb30 (9SMnPb28), **1.0736** 11SMn37 **1.0727** 46S20 (45S20), **1.0728** (60S20), **1.0757** 46SPb2	≤850 ≤1000		●● ●●	TiN Up	90 80	14 14	85 75	13 13
Aceros de bonific. no aleados	**1.0402** C22, **1.1178** C30E (Ck30) **1.0503** C45, **1.1191** C45E (Ck45) **1.0601** C60, **1.1221** C60E (Ck60)	≤700 ≤850 ≤1000		●● ●● ●●	TiN Up	90 80 75	13 13 13	85 75 70	12 12 12
Aceros de bonificación aleados	**1.5131** 50MnSi4, **1.7003** 38Cr2, **1.7030** 28Cr4 **1.5710** 36NiCr6, **1.7035** 41Cr4, **1.7225** 42CrMo4	≤1000 ≤1400		●● ●●	TiN Up	75 65	13 13	70 60	12 12
Aceros cement. no aleados	**1.0301** (C10), **1.1121** C10E (Ck10)	≤850		●●	TiN Up	80	14	75	13
Aceros cementación aleados	**1.7276** 10CrMo11, **1.5125** 11MnSi6 **1.5752** 15NiCr13, **1.7131** 16MnCr5, **1.7264** 20CrMo5	≤1000 ≤1400		● ●	TiN Up	75 65	13 13	70 60	12 12
Aceros nitrurados	**1.8504** 34CrAl6 **1.8519** 31CrMoV9, **1.8550** 34CrAlNi7	≤1000 ≤1400		●● ●	SHARK	75 65	13 13	70 60	12 12
Aceros para herramientas	**1.1750** C75W, **1.2067** 102Cr6, **1.2307** 29CrMoV9 **1.2080** X210Cr12, **1.2083** X42Cr13, **1.2419** 105WCr6	≤850 ≤1400		●● ●	SHARK	75 65	12 12	70 60	11 11
Aceros rápido	**1.3243** S 6-5-2-5, **1.3343** S 6-5-2, **1.3344** S 6-5-3	≤1400		●	SHARK	55	11	50	11
Aceros para muelles	**1.5026** 55Si7, **1.7176** 55Cr3, **1.8159** 51CrV4 (51CrV4)		≤350 HB	●	SHARK	65	12	60	12
Aceros endurecidos			– ≤48 HRC ≤66 HRC	● ●	SHARK	30 25	12 11	25 20	11 11
Hierro fundido	**0.6010** EN-GJL-100 (GG10), **0.6020** EN-GJL-200 (GG20) **0.6025** EN-GJL-250 (GG25), **0.6035** EN-GJL-350 (GG35)		≤240 HB ≤350 HB	●○ ●○	TiN Up	85 80	15 15	80 75	14 14
Grafito de bola y fundición templada	**0.7050** EN-GJS-500-7 (GGG50), **0.8035** **0.7070** EN-GJS-700-2 (GGG70), **0.8170** EN-GJMB-700-2		≤240 HB ≤350 HB	● ●	TiN Up	80 70	14 14	75 65	13 13
Hierro fundido			≤350 HB	●	TiN Up	55	13	50	12
Nuevos mat. de fundición GGV	**EN-GJV250** (GGV25), **EN-GJV350** (GGV35) **EN-GJV400** (GGV40), **EN-GJV500** (GGV50), SiMo 6		≤220 HB ≤300 HB	● ●	TiN Up	60 50	13 13	60 50	12 12
Nuevos mat. de fundición ADI	**EN-GJS-800-8** (ADI800), **EN-GJS-1000-5** (ADI1000) **EN-GJS-1200-2** (ADI1200), **EN-GJS-1400-1** (ADI1400)	≤1000 ≤1400		● ●	TiN Up	60 50	13 13	60 50	12 12
Aluminio y aleaciones de Al	**3.0255** Al99,5, **3.2315** AlMgSi1, **3.3515** AlMg1	≤400		●	SHARK	150	16	140	15
Aleaciones maleables de Al	**3.0615** AlMgSiPb, **3.1325** AlCuMg1, **3.3245** AlMg3Si	≤650		●	BRIGHT	120	15	115	14
Aleaciones Al y fund. ≤ 10 % Si / ≤ 24 % Si	**3.2131** G-AlSi5Cu1, **3.2153** G-AlSi7Cu3, **3.2573** G-AlSi9 **3.2581** G-AlSi12, **3.2583** G-AlSi12Cu, - G-AlSi12CuNiMg	≤600 ≤600		● ●	BRIGHT	150 130	16 16	140 120	15 15
Aleaciones de magnesio	**3.5200** MgMn2, **3.5812.05** G-MgAl8Zn1, **3.5612.05**	≤400		●	BRIGHT	110	16	100	15
Cobre de baja aleación	**2.0070** SE-Cu, **2.1020** CuSn6, **2.1096** G-CuSn5ZnPb	≤500		●	SHARK	75	14	70	13
Latón, viruta corta / viruta larga	**2.0380** CuZn39Pb2, **2.0401** CuZn39Pb3, **2.0410** **2.0250** CuZn20, 2.**0280** CuZn33, **2.0332** CuZn37Pb0,5	≤600 ≤600		●○ ●○	BRIGHT	120 90	17 17	115 85	16 16
Bronces, viruta corta	**2.1090** CuSn7ZnPb, **2.1170** CuPb5Sn5, **2.1176** **2.0790** CuNi18Zn19Pb	≤600 ≤850		●● ●	BRIGHT	95 75	16 16	90 70	15 15
Bronces, viruta larga	**2.0916** CuAl5, **2.0960** CuAl9Mn, **2.1050** CuSn10 **2.0980** CuAl11Ni, **2.1247** CuBe2	≤850 ≤1000		● ●	BRIGHT	70 60	16 16	65 55	15 15
Aceros inoxidables, sulfurados austeníticos mateníticos	**1.4005** X12CrS13, **1.4104** X14CrMoS17, **1.4105** **1.4301** X5CrNi18-10 (V2A), **1.4541** X6CrNiTi18-10 **1.4057** X20CrNi172 (X17CrNi16-2), **1.4122**	≤900 ≤1100 ≤1500		● ● ●	SHARK	55 45 35	13 13 13	50 40 35	12 12 12
Aleaciones especiales	Nimonic, Inconel, Monel, Hastelloy	≤2000		●	SHARK	20	11	20	11
Titanio y aleaciones de titanio	**3.7024** Ti99,5, **3.7114** TiAl5Sn2,5, **3.7124** TiCu2 **3.7154** TiAl6Zr5, **3.7165** TiAl6V4, **3.7184** TiAl4Mo4Sn2,5	≤850 ≤1400		● ●	BRIGHT	35 30	11 11	30 25	11 11
Duroplásticos	Bakelit, Resopal, Pertinax, Moltopren	≤150		●	BRIGHT	75	14	70	13
Termoplásticos	Plexiglás, Hostalen, Novodur, Makralon	≤100		●	BRIGHT	70	14	65	13
Materiales sintéticos	Kevlar	≤1000		○	BRIGHT	60	13	55	12
Fibras de vidrio / carbón	GFK/CFK	≤1000		○	BRIGHT	50	13	45	12

notes · notas

SALES TERM · CONDICIONES DE VENTA

Payment · Pago

Payment shall be made in accordance with terms and conditions notified to the buyer. In case of not payment on the agreed date, we will apply the delay interest. El pago se efectuará de conformidad con los términos y condiciones notificadas al comprador. En caso de impago en la fecha acordada, se devengará el interés legal de demora.

Passing of property · Reserva de dominio

The property of the goods does not pass to the buyer until it becomes entirely his payment. The Company reserves the right to repossess any goods in respect on which payment is overdue and the buyer shallco-operate in the event of the Company notifying its intentions of repossess. La propiedad de los bienes no se transmitirá al comprador hasta que se haga efectivo por completo su pago. La Empresa se reserva el derecho de tomar posesión de los bienes respecto de los cuales exista mora en el pago.

Transport · Transporte

Will be payed by the buyer. Será a cargo del comprador.

Return Policy · Política de devolución

The customer will get 5 days from the reception of the goods to inform to HELION TOOLS about any claim of the goods supplied. Passed that period the goods will be considered as accepted by the customer. El cliente dispondrá de un plazo de 5 días a partir de la recepción del producto para enviar a HELION TOOLS cualquier reclamación en relación con el producto suministrado. Después de ese plazo los productos serán considerados como conformes por el cliente.

The claim will must do it through · La reclamación deberá realizarse a través de:

Logistics Division · Departamento de logística logistics@helion-tools.com +34 93 877 08 69
Comercial Division · Departamento comercial export@helion-tools.com +34 93 877 08 69

HELION TOOLS is not responsible and reserves the rights to refuse returns If the goods are in bad conditions due to improper use or transport damages. HT no se hace responsable y se reserva el derecho de rechazar posibles devoluciones en caso de mercancía en mal estado por uso indebido o daños de transporte.

* Will be accepted material just in following case · Solo se aceptará devolución de material en los siguientes casos:

a) The return of the good non-defective, as a rule, will be not accepted. Anyway, in special situations and as an exception will be accepted the return with previous conformity of HELION TOOLS and once the material will be in HELION TOOLS have been controlled that all the requirements of the goods be correct. Then in the return will be apply an surcharge of 15% of the value of the goods as expenses of management and administration. The transportation cost will be at the customer's expense. La devolución de mercancía no defectuosa como norma no se acepta. Aun así, en casos especiales y como excepción se acepta la devolución, pero siempre con la previa aprobación de HT, y la posterior confirmación una vez recibida la mercancía de que reúne los requisitos exigidos. En estos casos de devolución se aplicará un recargo por gastos de gestión y administración del 15% del valor de la mercancía. Los gastos de transporte irán a cargo del comprador.

b) Material defective at the moment of the reception of it: If the material is defective in the origin, must be informed to HELION TOOLS and once assigned the return number the goods will be dispatched to HELION TOOLS with her original packaging. Will be not accepted the return of goods that are not according with the following specifications: original packaging and materials without using. Material defectuoso al momento de la recepción de este: Si el material está defectuoso de origen, se deberá realizar la comunicación a HT, y una vez asignado el nº de devolución, el producto será enviado a HT con su embalaje original. No se aceptarán devoluciones que no cumplan estos requisitos: embalaje original y sin usar.

All the returns must be together with the invoice or delivery note. Toda devolución debe ir acompañada de la factura o albarán de compra.

* Delivery · Entrega

Once received the purchase order, we proceed with the production process to supply the order in a short time as possible. Then we will not accept cancellations or modifications in purchase orders of special tools manufactured according with the specifications of the customer. Una vez recibido un pedido, procedemos a la ejecución de este en el plazo más breve posible y a partir de ese momento no se aceptarán cancelaciones ni modificaciones de un pedido que contenga herramientas especiales o fabricadas por petición del cliente.

Garantía · Warranty

The guarantee of all our products will be established by HELION TOOLS. There is no guarantee for products manipulated or modified The responsibility of HELION TOOLS is limited just to the cost amount of the product and is not liable of damages and their consequences, nor of losses due lost profit of the buyer. La garantía de todos nuestros productos será la establecida por HT. No existe garantía de los productos que hayan sido manipulados o modificados. La responsabilidad de HT queda en todo caso limitada al importe del producto y no se hace responsable de daños y sus consecuencias, ni de pérdidas por lucro cesante del comprador.

Jurisdiction · Jurisdicción

In case of dispute yhe Customer Will be subject to the jurisdiction of the courts of Manresa – Barcelona – Spain. En caso de litigio, el cliente estará sujeto a la jurisdicción de los tribunales de Manresa – Barcelona – España.

Web: E-shop

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