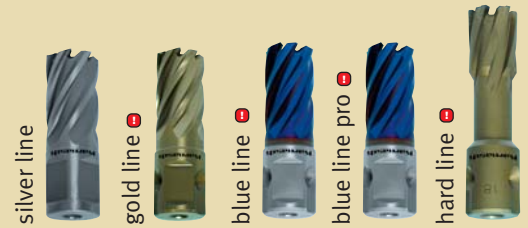


Product information core drill qualities



	<p>Made of high-alloy HSS-XE special steel. For extreme hardness at the top edge (up to 68 HRC). This way high capacity of resistance to wear and durability.</p>	✓	✓	✓		
	<p>Made of ASP powdered steel to drill also most difficult materials such as railroad tracks, stainless steels, exotic alloys. Always applicable anywhere where highest resistance to wear and longest durability are required.</p>				✓	
	<p>Only a few manufacturers are able to produce HSS core drills which are hardened in steps. For Karnasch this is a "standard product". Only this way, we are achieving extremely hard top edges (68 HRC) and nonetheless a flexible core drill.</p>	✓	✓	✓	✓	
	<p>Completely sharpened HSS-XE / ASP core drills of the full material. This finishing grinding increases the chipping performance by reducing the friction at the same time. For a longer durability.</p>		✓	✓	✓	
	<p>Gold-Tech surface treatment. The special treatment for longer durability.</p>		✓			
	<p>Our core drills HSS-XE/ASP + full drills of highest quality are having the unique and patented Durablue coating. Extreme surface hardness and smoothness are resulting in extremely long durability also if the working conditions are not optimum for instance if you need to work "upside down" for dry drilling, etc.</p>			✓	✓	
	<p>For HSS-XE / ASP core drills we are not content with one edge geometry. Five geometries had been specially optimally adapted to the different diameters and cutting depths. You always receive the perfect geometry.</p>	✓	✓	✓	✓	
	<p>Karnasch carbide-tipped cored drills (Hard-Line) are manufactured with an elaborated pre-middle rethreading geometry. This results in: rattle-free, smooth and easy chipping at longest durability.</p>					✓
	<p>Karnasch carbide-tipped core drills (Hard-Line) are manufactured with a conical spiral for: proper chip flow and highest chipping power also for difficult materials.</p>					✓
	<p>Karnasch carbide-tipped core drills (Hard-Line) are exclusively tipped using Sandvik carbide teeth. We think: Only the best hard metal is just good enough for Karnasch core drills.</p>					✓

! The core drills of the series gold line, blue line, blue line pro and hard line can not be used offhand for Metalkraft quick-action fixtures, which had been sold before the introduction of this catalog. With the introduction of the catalog 2008 Metalkraft is generally changing over to quick-action fixtures where you can also use such core drill types. Please consult your specialized dealer accordingly. For the drilling machines with magnetic base without quick-action fixtures you can use all core drill types of this catalog.

Which drill for which material

Accuracy of the drills (standard values):
input + 0.10 mm / output ± 0 mm

- Optimum ●●●
- Good ●●
- Possible ●



Type	silver-line	gold-line	blue-line	blue-line pro	hard-line
Steel < 500 N	●●●	●●●	●●●	●●●	●●●
Steel < 750 N	●●	●●●	●●●	●●●	●●●
Steel < 900 N	●	●●	●●●	●●●	●●●
Steel < 1100 N		●	●●	●●●	●●●
Stahl · Steel · Acier Acero · Acciaio · < 1400 N			●	●●●	●●●
Stainless steel < 900 N			●●	●●●	●●●
Stainless steel > 900 N			●	●●●	●●●
Aluminum < 10% Si	●	●●	●●●	●●●	●●●
Aluminum > 10% Si		●	●●	●●●	●●●
Copper, brass, nickel, tin				●●	●●●
Plastic materials GFK/CFK				●	●●●
Grey cast iron		●●	●●●	●●●	●●●
Graphite				●	●●●
Hardox, Hastelloy, Inconel, Nimonic, exotic materials			●	●●●	●●●
Rails			●	●●●	●●

! The core drills of the series gold line, blue line, blue line pro and hard line can not be used offhand for Metallkraft quick-action fixtures, which had been sold before the introduction of this catalog. With the introduction of the catalog 2008 Metallkraft is generally changing over to quick-action fixtures where you can also use such core drill types. Please consult your specialized dealer accordingly. For the drilling machines with magnetic base without quick-action fixtures you can use all core drill types of this catalog.

Feed mm/rev.

Feed for HSS-XE / ASP
Core drills: Silver-Line, Gold-Line,
Blue-Line, Blue-Line Pro
Feed standard values for
HM core drills Hard-Line

	Steel < 500 N	0.15	0.10
	Steel < 750 N	0.18	0.10
	Steel < 900 N	0.16	0.10-0.12
	Steel < 1200 N	0.16	0.10-0.15
	Steel < 1400 N	0.17	0.16
	Stainless steel	0.10	0.13
	Aluminum	0.25	0.24
	Grey cast iron	0.16	0.08-0.13
	Bronze	0.18	0.12
	Copper	0.21	0.12











Grey cast cutter cooling: dry / compressed air
For all other materials cutting oil is being recommended (see page 88)

Application notes:






- Center-punching for core drills. For core drills diameter from 12 to 15mm it is absolutely necessary to set a big punching point. Make sure that the tip of the ejector pin is exactly positioned in the center of the center drill. This procedure is also highly recommended for all other diameters.
- Speeds for core drills. For HSS core drills from 12 to 15mm a minimum speed of 450 rpm needs to be applied. For HM core drills a minimum speed of about 600 rpm would be optimum. If this is not possible, you need to work using half the recommended feed.
- Feed. Imperatively start drilling carefully and slowly a depth of 5mm. Then you can continue working with the recommended feed. **Please heed this advice. It will considerably increase the durability of the drill.**
- Drilling. Depending on the chip flow, you need to discharge the drill more often. This particularly applies for cutting depths from about 25mm on. If you feel e.g. an increasing resistance or rattling, please immediately proceed as follows:
 - Extract the drill from the drilling hole keeping it running.
 - Clean the drill and the drilling hole from chips (e.g. using a pressure pump)
 - Fill the drilling hole with coolant or lubricating emulsion (refer to cutting oils on page 88).
 - Insert the drill in running status slowly and carefully into the already existing hole. During this whole procedure you must not change the site of the machine or of the workpiece.
 - Depending on the chip flow and the drilling depth repeat this procedure several times.
- Cooling. Only use super-speed steel cutting oils (for cutting oils please refer to page 88). From about 35mm Ø on, please use Morse taper fixtures with automatic internal cooling.

Speeds

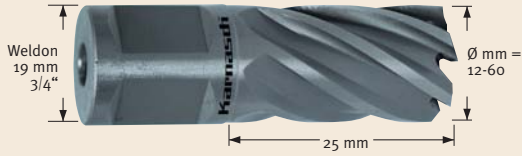
Speeds for HSS-XE / ASP core drills
Silver-Line. Gold-Line. Blue-Line. Blue-Line Pro

mm Inch	12-18	19-25	26-32	33-39	40-46	47-53	54-60	61-70	71-80	81-90	91-100	101-112	113-124	125-136	137-150
	7/16" - 11/16"	3/4" - 1"	1 1/16" - 1 1/4"	1 5/16" - 1 9/16"	1 5/8" - 1 13/16"	1 7/8" - 2 1/16"	2 1/8" - 2 3/8"	2 13/32" - 2 3/4"	2 51/64" - 3 5/32"	3 3/16" - 3 9/16"	3 19/32" - 3 15/16"	3 31/32" - 4 13/32"	4 15/32" - 4 7/8"	4 15/16" - 5 11/32"	5 13/32" - 5 29/32"
 Steel < 500 N	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
	440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
 Steel < 750 N	530	340	245	195	160	135	115	163	87	77	68	62	55	50	45
	350	250	200	165	140	120	105	90	78	70	63	56	51	46	42
 Steel < 900 N	340	250	185	145	120	100	88	78	67	58	52	47	41	38	34
	265	190	150	125	105	90	80	68	59	53	48	42	39	35	31
 Steel < 1200 N	265	165	125	95	79	67	58	52	44	39	34	31	27	25	22
	175	130	100	80	70	60	53	45	40	35	32	28	26	23	21
 Steel < 1400 N	185	117	85	67	55	47	41	36	30	26	23	21	18	16	16
	125	90	70	57	48	42	37	31	27	24	22	19	17		14
 Stainless steel	320	200	145	115	90	80	70	62	53	46	41	37	32	29	27
	210	150	120	95	85	72	63	54	47	42	38	33	30	28	25
 Aluminum	980	620	455	360	295	250	220	193	165	145	129	116	104	94	85
	655	470	370	305	255	225	195	170	150	130	117	105	95	86	78
 Grey cast iron	480	300	200	175	143	122	106	93	80	70	62	56	50	45	41
	320	230	180	147	125	108	95	81	71	63	57	51	46	42	38
 Bronze	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
	440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
 Copper	1060	670	490	390	320	270	235	205	178	157	138	127	110	100	90
	700	510	400	330	280	240	210	180	160	140	130	115	105	95	85

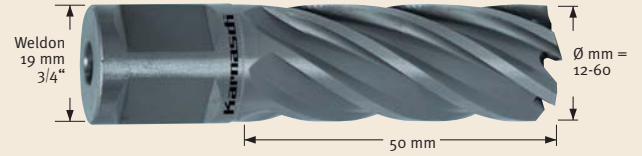
Speed standard values for HM core drills
Hard-Line

mm Inch	12-18	19-25	26-32	33-39	40-46	47-53	54-60	61-70	71-80	81-90	91-100	101-112	113-124	125-136	137-150
	7/16" - 11/16"	3/4" - 1"	1 1/16" - 1 1/4"	1 5/16" - 1 9/16"	1 5/8" - 1 13/16"	1 7/8" - 2 1/16"	2 1/8" - 2 3/8"	2 13/32" - 2 3/4"	2 51/64" - 3 5/32"	3 3/16" - 3 9/16"	3 19/32" - 3 15/16"	3 31/32" - 4 13/32"	4 15/32" - 4 7/8"	4 15/16" - 5 11/32"	5 13/32" - 5 29/32"
 Steel < 500 N	1060	670	490	390	320	270	235	205	178	157	138	127	110	100	90
	700	510	400	330	280	240	210	180	160	140	130	115	105	95	85
 Steel < 750 N	980	620	450	360	295	250	220	193	165	145	129	115	104	94	85
	655	470	370	300	260	225	195	170	150	130	120	105	95	87	78
 Steel < 900 N	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
	620	450	340	285	240	210	185	160	140	125	110	100	90	81	75
 Steel < 1200 N	795	500	370	290	240	200	175	155	135	117	104	94	84	76	69
	530	380	300	245	265	180	160	135	120	105	95	85	77	70	63
 Steel < 1400 N	660	420	305	240	195	165	145	125	110	95	85	75	68	63	57
	440	320	250	200	170	150	130	115	100	90	80	70	65	58	50
Stainless steel	530	340	245	195	160	135	115	103	87	77	68	62	55	56	45
	350	250	200	165	140	120	105	90	78	70	63	56	51	46	42
Aluminum	2390	1510	1100	870	715	610	530	470	405	355	315	283	253	229	209
	1590	1150	895	735	625	540	480	410	360	320	285	255	230	210	190
Grey cast iron	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
	620	450	340	285	240	210	185	160	140	125	110	100	90	81	75
Bronze	1325	840	615	490	400	340	295	260	225	195	174	157	140	127	116
	885	635	500	410	345	300	265	230	200	175	160	145	130	117	105
Copper	930	590	430	335	280	239	205	182	155	137	122	108	98	89	80
	620	450	340	285	240	210	185	160	140	125	110	100	90	81	75

SILVER-LINE 25



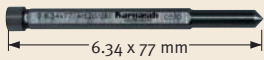
SILPUR-LINE 50



Ø mm	387 20.1255	€	Ø mm	387 20.1255	€
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13	387 20.1255 13	13.80	38	387 20.1255 38	34.25
14	387 20.1255 14	14.05	39	387 20.1255 39	34.25
15	387 20.1255 15	14.05	40	387 20.1255 40	37.60
16	387 20.1255 16	14.90	41	387 20.1255 41	37.60
17	387 20.1255 17	14.90	42	387 20.1255 42	40.55
18	387 20.1255 18	15.60	43	387 20.1255 43	40.55
19	387 20.1255 19	15.60	44	387 20.1255 44	44.55
20	387 20.1255 20	16.45	45	387 20.1255 45	44.55
21	387 20.1255 21	16.45	46	387 20.1255 46	47.85
22	387 20.1255 22	20.15	47	387 20.1255 47	47.90
23	387 20.1255 23	20.15	48	387 20.1255 48	50.55
24	387 20.1255 24	20.90	49	387 20.1255 49	50.55
25	387 20.1255 25	20.90	50	387 20.1255 50	54.00
26	387 20.1255 26	22.65	51	387 20.1255 51	54.00
27	387 20.1255 27	22.70	52	387 20.1255 52	57.50
28	387 20.1255 28	24.35	53	387 20.1255 53	59.30
29	387 20.1255 29	24.35	54	387 20.1255 54	61.15
30	387 20.1255-30	25.55	55	387 20.1255 55	62.60
31	387 20.1255-31	25.55	56	387 20.1255 56	64.85
32	387 20.1255-32	26.70	57	387 20.1255 57	67.15
33	387 20.1255-33	26.70	58	387 20.1255 58	68.85
34	387 20.1255-34	28.15	59	387 20.1255 59	71.00
35	387 20.1255-35	28.15	60	387 20.1255 60	73.15
36	387 20.1255-36	31.90			

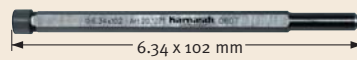
Ø mm	387 20.1265	€	Ø mm	387 20.1265	€
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13	387 20.1265 13	18.00	38	387 20.1265 38	43.50
14	387 20.1265 14	18.60	39	387 20.1265 39	43.50
15	387 20.1265 15	18.60	40	387 20.1265 40	47.60
16	387 20.1265 16	19.15	41	387 20.1265 41	47.60
17	387 20.1265 17	19.15	42	387 20.1265 42	51.50
18	387 20.1265 18	20.70	43	387 20.1265 43	51.50
19	387 20.1265 19	20.70	44	387 20.1265 44	56.55
20	387 20.1265 20	21.65	45	387 20.1265 45	56.55
21	387 20.1265 21	21.65	46	387 20.1265 46	60.80
22	387 20.1265 22	24.35	47	387 20.1265 47	60.80
23	387 20.1265 23	24.35	48	387 20.1265 48	64.15
24	387 20.1265 24	25.75	49	387 20.1265 49	64.15
25	387 20.1265 25	25.75	50	387 20.1265 50	72.40
26	387 20.1265 26	27.75	51	387 20.1265 51	72.40
27	387 20.1265 27	27.80	52	387 20.1265 52	74.45
28	387 20.1265 28	30.20	53	387 20.1265 53	76.80
29	387 20.1265 29	30.20	54	387 20.1265 54	79.35
30	387 20.1265 30	31.70	55	387 20.1265 55	81.50
31	387 20.1265 31	31.70	56	387 20.1265 56	83.95
32	387 20.1265 32	33.95	57	387 20.1265 57	86.00
33	387 20.1265 33	33.95	58	387 20.1265 58	88.35
34	387 20.1265 34	36.15	59	387 20.1265 59	90.40
35	387 20.1265 35	36.15	60	387 20.1265 60	92.90
36	387 20.1265 36	40.95			

Ejector pin



€ 3.30
387 20.1261

Ejector pin



€ 3.85
387 20.1271

SILPUR-LINEKIT 25



Contents	Ø mm	€
	14. 16. 18. 20. 22. 26	135.50
+ 4 ejector pins		387 20.1474

SILPUR-LINE KIT 50



Contents	Ø mm	€
	14. 16. 18. 20. 22. 26	166.10
+ 4 ejector pins		387 20.1475

Appropriate for core drilling machines

Metallkraft. Alfa-Rotabest + Alfa Rota-Quick. BDS + BDS Keyless. Bektop. Bux. Euroboor. Evolution. Hougen. Jancy. Magbroach. Magtron. Magnetor. Nitto. Promag. Rotabroach. Ruko + Ruko Easy Lock. Universal...

All prices are quoted as net prices plus the applicable legal value added tax.

GOLD-LINE 30



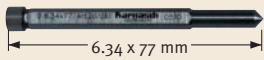
GOLD-LINE 55



Ø mm	387 20.1260U	€	Ø mm	387 20.1260U	€
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13	387 20.1260U 13	15.85	35	387 20.1260U 35	30.30
13.5	387 20.1260U 13.5	16.10	36	387 20.1260U 36	34.35
14	387 20.1260U 14	16.20	37	387 20.1260U 37	34.35
15	387 20.1260U 15	16.20	38	387 20.1260U 38	36.85
15.5	387 20.1260U 15.5	16.60	39	387 20.1260U 39	36.85
16	387 20.1260U 16	16.95	40	387 20.1260U 40	40.40
17	387 20.1260U 17	16.95	41	387 20.1260U 41	40.40
17.5	387 20.1260U 17.5	17.35	42	387 20.1260U 42	43.65
18	387 20.1260U 18	17.75	43	387 20.1260U 43	43.65
19	387 20.1260U 19	17.75	44	387 20.1260U 44	47.90
19.5	387 20.1260U 19.5	18.20	45	387 20.1260U 45	47.90
20	387 20.1260U 20	18.65	46	387 20.1260U 46	51.50
21	387 20.1260U 21	18.65	47	387 20.1260U 47	51.50
22	387 20.1260U 22	22.15	48	387 20.1260U 48	54.35
23	387 20.1260U 23	22.15	49	387 20.1260U 49	54.35
24	387 20.1260U 24	23.00	50	387 20.1260U 50	58.05
25	387 20.1260U 25	23.00	51	387 20.1260U 51	58.05
26	387 20.1260U 26	24.35	52	387 20.1260U 52	61.80
26.5	387 20.1260U 26.5	24.35	53	387 20.1260U 53	63.75
27	387 20.1260U 27	24.35	54	387 20.1260U 54	65.75
28	387 20.1260U 28	26.25	55	387 20.1260U 55	67.30
29	387 20.1260U 29	26.25	56	387 20.1260U 56	69.75
30	387 20.1260U 30	27.50	57	387 20.1260U 57	72.25
31	387 20.1260U 31	27.50	58	387 20.1260U 58	74.05
32	387 20.1260U 32	28.75	59	387 20.1260U 59	76.35
33	387 20.1260U 33	28.75	60	387 20.1260U 60	78.65

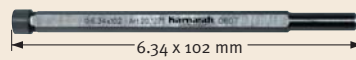
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13	387 20.1270U 13	19.85	35	387 20.1270U 35	38.20
13.5	387 20.1270U 13.5	20.40	36	387 20.1270U 36	43.25
14	387 20.1270U 14	20.70	37	387 20.1270U 37	43.25
15	387 20.1270U 15	20.70	38	387 20.1270U 38	45.90
15.5	387 20.1270U 15.5	21.00	39	387 20.1270U 39	45.90
16	387 20.1270U 16	21.30	40	387 20.1270U 40	50.20
17	387 20.1270U 17	21.30	41	387 20.1270U 41	50.20
17.5	387 20.1270U 17.5	21.75	42	387 20.1270U 42	54.30
18	387 20.1270U 18	22.15	43	387 20.1270U 43	54.30
19	387 20.1270U 19	22.15	44	387 20.1270U 44	59.65
19.5	387 20.1270U 19.5	22.60	45	387 20.1270U 45	59.65
20	387 20.1270U 20	23.10	46	387 20.1270U 46	64.15
21	387 20.1270U 21	23.10	47	387 20.1270U 47	64.15
22	387 20.1270U 22	26.25	48	387 20.1270U 48	67.70
23	387 20.1270U 23	26.25	49	387 20.1270U 49	67.70
24	387 20.1270U 24	27.75	50	387 20.1270U 50	76.40
25	387 20.1270U 25	27.75	51	387 20.1270U 51	76.40
26	387 20.1270U 26	29.25	52	387 20.1270U 52	78.55
26.5	387 20.1270U 26.5	29.25	53	387 20.1270U 53	81.05
27	387 20.1270U 27	29.30	54	387 20.1270U 54	83.75
28	387 20.1270U 28	31.90	55	387 20.1270U 55	86.00
29	387 20.1270U 29	31.90	56	387 20.1270U 56	88.65
30	387 20.1270U 30	33.50	57	387 20.1270U 57	90.75
31	387 20.1270U 31	33.50	58	387 20.1270U 58	93.25
32	387 20.1270U 32	35.85	59	387 20.1270U 59	95.40
33	387 20.1270U 33	35.85	60	387 20.1270U 60	98.05

Ejector pin



€ 3.30
387 20.1261

Ejector pin



€ 3.85
387 20.1271

GOLD-LINEKIT 30



Contents	Ø mm 14. 16. 18. 20. 22. 26	€ 147.70 387 20.1322
+ 4 ejector pins		

GOLD-LINE KIT 55



Contents	Ø mm 14. 16. 18. 20. 22. 26	€ 176.60 387 20.1332
+ 4 ejector pins		

Appropriate for core drilling machines

Metalkraft. Alfa-Rotabest + Alfa Rota-Quick. BDS + BDS Keyless. Bektop. Bux. Euroboor. Evolution. Hougen. Jancy. Magbroach. Magtron. Magnetor. Nittons Promag. Rotabroach. Ruko + Ruko Easy Lock. Universal...

All prices are quoted as net prices plus the applicable legal value added tax.

BLUE-LINE 30



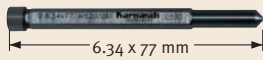
BLUE-LINE 55



Ø mm	387 20.1312	€	Ø mm	387 20.1312	€
12	387 20.1312 12	21.55	37	387 20.1312 37	49.55
13	387 20.1312 13	21.55	38	387 20.1312 38	52.05
14	387 20.1312 14	21.90	39	387 20.1312 39	52.05
15	387 20.1312 15	21.90	40	387 20.1312 40	55.60
16	387 20.1312 16	22.65	41	387 20.1312 41	55.60
17	387 20.1312 17	22.65	42	387 20.1312 42	58.85
18	387 20.1312 18	23.45	43	387 20.1312 43	58.85
19	387 20.1312 19	23.45	44	387 20.1312 44	63.10
20	387 20.1312 20	24.35	45	387 20.1312 45	63.10
21	387 20.1312 21	25.05	46	387 20.1312 46	66.70
22	387 20.1312 22	28.50	47	387 20.1312 47	66.70
23	387 20.1312 23	28.50	48	387 20.1312 48	69.55
24	387 20.1312 24	29.35	49	387 20.1312 49	69.55
25	387 20.1312 25	29.35	50	387 20.1312 50	73.25
26	387 20.1312 26	30.75	51	387 20.1312 51	73.25
27	387 20.1312 27	30.75	52	387 20.1312 52	77.00
28	387 20.1312 28	32.60	53	387 20.1312 53	78.95
29	387 20.1312 29	32.60	54	387 20.1312 54	80.95
30	387 20.1312 30	33.90	55	387 20.1312 55	82.50
31	387 20.1312 31	33.90	56	387 20.1312 56	84.95
32	387 20.1312 32	35.15	57	387 20.1312 57	87.45
33	387 20.1312 33	35.15	58	387 20.1312 58	89.25
34	387 20.1312 34	36.70	59	387 20.1312 59	91.55
35	387 20.1312 35	36.70	60	387 20.1312 60	93.85
36	387 20.1312 36	40.75			

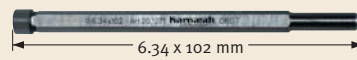
Ø mm	387 20.1313	€	Ø mm	387 20.1313	€
12	387 20.1313 12	25.55	37	387 20.1313 37	58.45
13	387 20.1313 13	25.55	38	387 20.1313 38	61.10
14	387 20.1313 14	26.40	39	387 20.1313 39	61.10
15	387 20.1313 15	26.40	40	387 20.1313 40	65.40
16	387 20.1313 16	27.00	41	387 20.1313 41	65.40
17	387 20.1313 17	27.00	42	387 20.1313 42	69.50
18	387 20.1313 18	27.85	43	387 20.1313 43	69.50
19	387 20.1313 19	27.85	44	387 20.1313 44	74.85
20	387 20.1313 20	28.80	45	387 20.1313 45	74.85
21	387 20.1313 21	29.45	46	387 20.1313 46	79.35
22	387 20.1313 22	32.60	47	387 20.1313 47	79.35
23	387 20.1313 23	32.60	48	387 20.1313 48	82.90
24	387 20.1313 24	34.15	49	387 20.1313 49	82.90
25	387 20.1313 25	34.15	50	387 20.1313 50	91.60
26	387 20.1313 26	35.65	51	387 20.1313 51	91.60
27	387 20.1313 27	35.65	52	387 20.1313 52	93.75
28	387 20.1313 28	38.25	53	387 20.1313 53	96.25
29	387 20.1313 29	38.25	54	387 20.1313 54	98.95
30	387 20.1313 30	39.90	55	387 20.1313 55	101.20
31	387 20.1313 31	39.90	56	387 20.1313 56	103.85
32	387 20.1313 32	42.20	57	387 20.1313 57	105.95
33	387 20.1313 33	42.20	58	387 20.1313 58	108.45
34	387 20.1313 34	44.60	59	387 20.1313 59	110.60
35	387 20.1313 35	44.60	60	387 20.1313 60	113.25
36	387 20.1313 36	49.65			

Ejector pin



€ 3.30
387 20.1261

Ejector pins



€ 3.85
387 20.1271

BLUE-LINE KIT 30



Contents	Ø mm	€
	14. 16. 18. 20. 22. 26	182.30
+ 4 ejector pins		387 20.1325

BLUE-LINE KIT 55



Contents	Ø mm	€
	14. 16. 18. 20. 22. 26	212.20
+ 4 ejector pins		387 20.1328

BLUE-LINE PRO 30



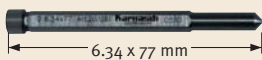
BLUE-LINE PRO 55



Ø mm	387 20.1284	€	Ø mm	387 20.1284	€
12	387 20.1284 12	41.45	25	387 20.1284 25	56.45
13	387 20.1284 13	41.45	26	387 20.1284 26	64.35
14	387 20.1284 14	41.45	27	387 20.1284 27	64.40
15	387 20.1284 15	45.10	28	387 20.1284 28	71.15
16	387 20.1284 16	45.10	29	387 20.1284 29	72.30
17	387 20.1284 17	45.10	30	387 20.1284 30	74.05
18	387 20.1284 18	45.10	31	387 20.1284 31	76.10
19	387 20.1284 19	45.10	32	387 20.1284 32	79.30
20	387 20.1284 20	47.50	33	387 20.1284 33	84.00
21	387 20.1284 21	48.50	34	387 20.1284 34	84.00
22	387 20.1284 22	50.90	35	387 20.1284 35	87.25
23	387 20.1284 23	52.85	36	387 20.1284 36	95.80
24	387 20.1284 24	56.45			

Ø mm	387 20.1317	€	Ø mm	387 20.1317	€
12	387 20.1317 12	52.70	25	387 20.1317 25	71.15
13	387 20.1317 13	52.70	26	387 20.1317 26	76.90
14	387 20.1317 14	52.70	27	387 20.1317 27	80.15
15	387 20.1317 15	55.75	28	387 20.1317 28	90.10
16	387 20.1317 16	55.75	29	387 20.1317 29	91.45
17	387 20.1317 17	55.75	30	387 20.1317 30	92.80
18	387 20.1317 18	55.75	31	387 20.1317 31	95.15
19	387 20.1317 19	55.75	32	387 20.1317 32	99.55
20	387 20.1317 20	59.40	33	387 20.1317 33	105.80
21	387 20.1317 21	62.35	34	387 20.1317 34	105.80
22	387 20.1317 22	63.50	35	387 20.1317 35	110.50
23	387 20.1317 23	65.80	36	387 20.1317 36	121.50
24	387 20.1317 24	71.15			

Ejector pin



€ 3.30
387 20.1261

Ejector pin



€ 3.85
387 20.1271

BLUE-LINE PRO KIT 30



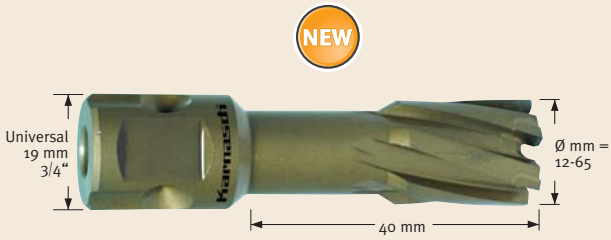
Contents	Ø mm	€
	14. 16. 18. 20. 22. 26	326.10
+ 4 ejector pins		387 20.1331

BLUE-LINE PRO KIT 55



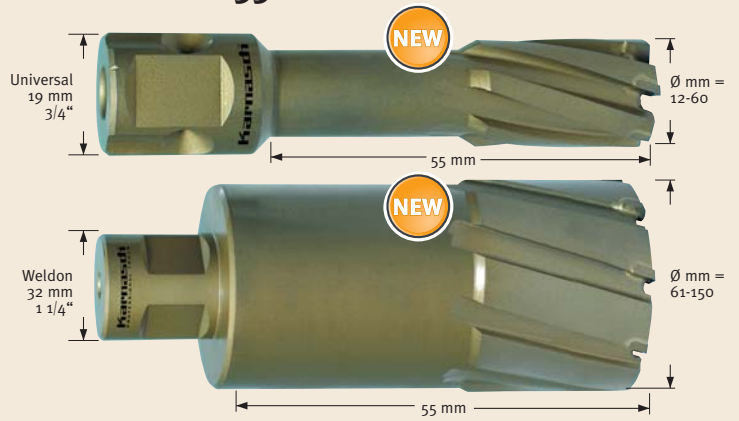
Contents	Ø mm	€
	14. 16. 18. 20. 22. 26	397.90
+ 4 ejector pins		387 20.1334

HARD-LINE 40



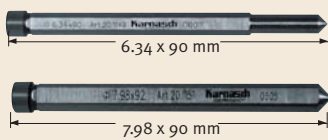
Ø mm	387 20.1315	€	Ø mm	387 20.1315	€
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13	387 20.1315 13	26.65	40	387 20.1315 40	41.40
14	387 20.1315 14	28.20	41	387 20.1315 41	49.95
15	387 20.1315 15	28.20	42	387 20.1315 42	49.95
16	387 20.1315 16	28.20	43	387 20.1315 43	49.95
17	387 20.1315 17	28.20	44	387 20.1315 44	49.95
18	387 20.1315 18	28.20	45	387 20.1315 45	49.95
19	387 20.1315 19	28.20	46	387 20.1315 46	53.60
20	387 20.1315 20	28.20	47	387 20.1315 47	53.60
21	387 20.1315 21	29.00	48	387 20.1315 48	53.60
22	387 20.1315 22	29.00	49	387 20.1315 49	53.60
23	387 20.1315 23	29.00	50	387 20.1315 50	56.75
24	387 20.1315 24	29.00	51	387 20.1315 51	61.55
25	387 20.1315 25	29.00	52	387 20.1315 52	63.00
26	387 20.1315 26	30.55	53	387 20.1315 53	64.90
27	387 20.1315 27	30.60	54	387 20.1315 54	67.05
28	387 20.1315 28	30.60	55	387 20.1315 55	68.50
29	387 20.1315 29	30.60	56	387 20.1315 56	70.95
30	387 20.1315 30	30.60	57	387 20.1315 57	72.62
31	387 20.1315 31	36.15	58	387 20.1315 58	73.95
32	387 20.1315 32	36.15	59	387 20.1315 59	75.30
33	387 20.1315 33	36.15	60	387 20.1315 60	76.55
34	387 20.1315 34	36.15	61	387 20.1315 61	78.90
35	387 20.1315 35	36.15	62	387 20.1315 62	81.65
36	387 20.1315 36	41.35	63	387 20.1315 63	84.70
37	387 20.1315 37	41.40	64	387 20.1315 64	87.50
38	387 20.1315 38	41.40	65	387 20.1315 65	90.35

HARD-LINE 55



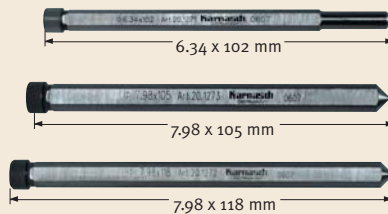
Ø mm	387 20.1316	€	Ø mm	387 20.1316	€	Ø mm	387 20.1316	€
12	387 20.1316 12	31.15	37	387 20.1316 37	45.85	61	387 20.1316 61	87.50
13	387 20.1316 13	31.15	38	387 20.1316 38	45.85	62	387 20.1316 62	90.55
14	387 20.1316 14	31.15	39	387 20.1316 39	45.85	63	387 20.1316 63	93.95
15	387 20.1316 15	31.15	40	387 20.1316 40	45.85	64	387 20.1316 64	97.00
16	387 20.1316 16	31.15	41	387 20.1316 41	55.30	65	387 20.1316 65	100.20
17	387 20.1316 17	31.15	42	387 20.1316 42	55.30	66	387 20.1316 66	104.05
18	387 20.1316 18	31.15	43	387 20.1316 43	55.30	67	387 20.1316 67	106.30
19	387 20.1316 19	31.15	44	387 20.1316 44	55.30	68	387 20.1316 68	108.40
20	387 20.1316 20	31.15	45	387 20.1316 45	55.30	69	387 20.1316 69	110.15
21	387 20.1316 21	32.15	46	387 20.1316 46	59.45	70	387 20.1316 70	113.40
22	387 20.1316 22	32.15	47	387 20.1316 47	59.45	75	387 20.1316 75	120.75
23	387 20.1316 23	32.15	48	387 20.1316 48	59.45	80	387 20.1316 80	129.15
24	387 20.1316 24	32.15	49	387 20.1316 49	59.45	85	387 20.1316 85	144.75
25	387 20.1316 25	32.15	50	387 20.1316 50	62.95	90	387 20.1316 90	167.55
26	387 20.1316 26	34.05	51	387 20.1316 51	68.25	95	387 20.1316 95	191.85
27	387 20.1316 27	34.10	52	387 20.1316 52	69.85	100	387 20.1316 100	214.70
28	387 20.1316 28	34.10	53	387 20.1316 53	71.95	105	387 20.1316 105	249.70
29	387 20.1316 29	34.10	54	387 20.1316 54	74.40	110	387 20.1316 110	275.95
30	387 20.1316 30	34.10	55	387 20.1316 55	76.00	115	387 20.1316 115	310.00
31	387 20.1316 31	40.10	56	387 20.1316 56	78.65	120	387 20.1316 120	345.40
32	387 20.1316 32	40.10	57	387 20.1316 57	80.55	125	387 20.1316 125	383.95
33	387 20.1316 33	40.10	58	387 20.1316 58	82.05	130	387 20.1316 130	422.25
34	387 20.1316 34	40.10	59	387 20.1316 59	83.50	135	387 20.1316 135	460.80
35	387 20.1316 35	40.10	60	387 20.1316 60	84.90	140	387 20.1316 140	502.00
36	387 20.1316 36	45.75				145	387 20.1316 145	541.85
						150	387 20.1316 150	584.55

Ejector pin



Ø 12-17 mm	€ 3.95	387 20.1149
Ø 18-65 mm	€ 4.05	387 20.1151

Ejector pin



Ø 12-17 mm	€ 3.85	387 20.1271
Ø 18-60 mm	€ 6.30	387 20.1273
Ø 61-150 mm	€ 6.95	387 20.1272

HARD-LINE KIT 40



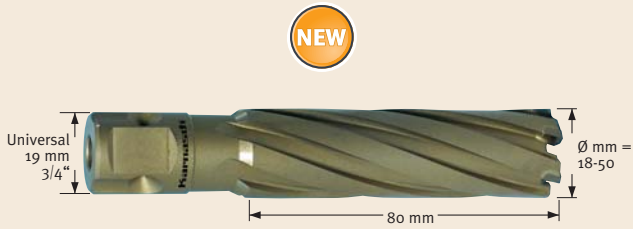
Contents	Ø mm 14. 16. 18. 20. 22. 26	€ 206.80
+ 4 ejector pins		387 20.1336

HARD-LINE KIT 55



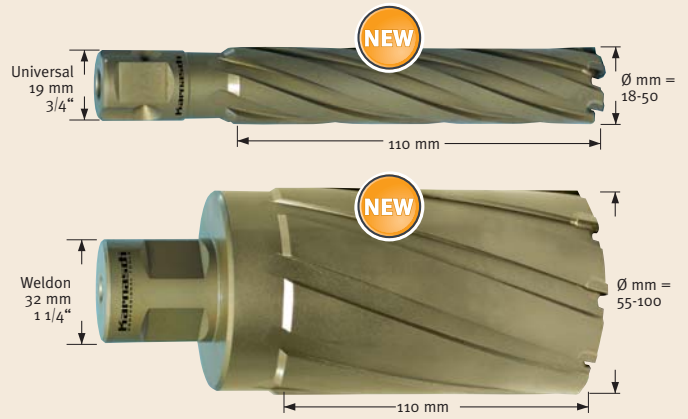
Contents	Ø mm 14. 16. 18. 20. 22. 26	€ 229.55
+ 4 ejector pins		387 20.1339

HARD-LINE 80



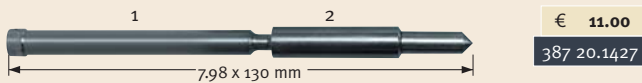
Ø mm	387 20.1650	€	Ø mm	387 20.1650	€
18	387 20.1650 18	51.45	29	387 20.1650 29	56.10
19	387 20.1650 19	51.45	30	387 20.1650 30	56.10
20	387 20.1650 20	51.45	32	387 20.1650 32	67.75
21	387 20.1650 21	51.45	33	387 20.1650 33	67.75
22	387 20.1650 22	51.45	35	387 20.1650 35	67.75
23	387 20.1650 23	51.45	36	387 20.1650 36	77.30
24	387 20.1650 24	51.45	38	387 20.1650 38	77.30
25	387 20.1650 25	51.45	40	387 20.1650 40	77.30
26	387 20.1650 26	56.10	45	387 20.1650 45	93.40
27	387 20.1650 27	56.10	50	387 20.1650 50	106.50
28	387 20.1650 28	56.10			

HARD-LINE 110



Ø mm	387 20.1660	€	Ø mm	387 20.1660	€	Ø mm	387 20.1660	€
18	38720.1660 18	65.50	29	38720.1660 29	71.40	55	38720.1660 55	160.15
19	38720.1660 19	65.50	30	38720.1660 30	71.40	57	38720.1660 57	170.10
20	38720.1660 20	65.50	32	38720.1660 32	86.00	60	38720.1660 60	179.25
21	38720.1660 21	65.50	33	38720.1660 33	86.00	64	38720.1660 64	204.65
22	38720.1660 22	65.50	35	38720.1660 35	86.00	65	38720.1660 65	211.25
23	38720.1660 23	65.50	36	38720.1660 36	98.50	67	38720.1660 67	224.60
24	38720.1660 24	65.50	38	38720.1660 38	98.50	70	38720.1660 70	239.10
25	38720.1660 25	65.50	40	38720.1660 40	98.50	75	38720.1660 75	254.80
26	38720.1660 26	71.40	45	38720.1660 45	118.85	80	38720.1660 80	272.50
27	38720.1660 27	71.40	50	38720.1660 50	135.40	85	38720.1660 85	305.35
28	38720.1660 28	71.40				90	38720.1660 90	353.65
						95	38720.1660 95	404.50
						100	38720.1660 100	453.10

Ejector pin 2-pc.



Application:

Insert part -1- into the shank of the core drill.
Shift part -2- on part -1-. Drill up to about 50mm cutting depth. Then remove part -2- and continue drilling.

Ejector pin 2-pc.



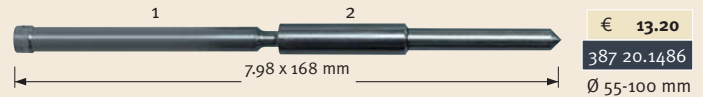
Together with tool fixture code: 387 20.1291 (on page 86) you can use this one-piece ejector pin. Using this pin you can drill up to 110 mm cutting depth in one operation without replugging. Solid and simple.

Ejector pin

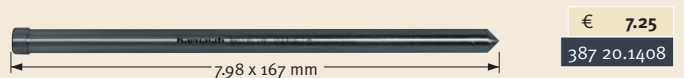


Application:

Insert part -1- into the shank of the core drill.
Shift part -2- on part -1-. Drill up to about 50mm cutting depth. Then remove part -2- and continue drilling.



Ejector pin



Together with tool fixture code: 387 20.1291 (on page 86) you can use this one-piece ejector pin. Using this pin you can drill up to 110 mm cutting depth in one operation without replugging. Solid and simple.

Tool holders

Quick-Change tool holder **with** automatic internal cooling.
Appropriate for all Weldon shank/universal shank 19 mm (3/4") core drills.

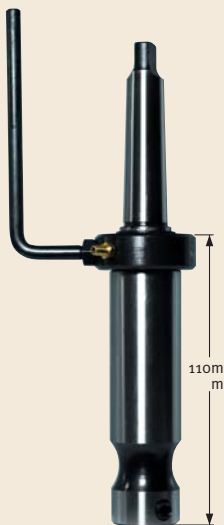


Morse taper 2	Replacement of core drill without tools within seconds	€ 90.05
		387 20.1303
		NEW
Morse taper 3	Replacement of core drill without tools within seconds	€ 92.90
		387 20.1307
		NEW

Quick-Change tool holder **without** automatic internal cooling.
Appropriate for all Weldon shank/universal shank 19 mm (3/4") core drills.



Morse taper 2	Replacement of core drill without tools within seconds	€ 66.20
		387 20.1301
		NEW
Morse taper 3	Replacement of core drill without tools within seconds	€ 69.55
		387 20.1437
		NEW



Morse taper 3	Extra long tool holder with automatic coolant supply particularly for all extra long core drills such as the series: Gold-Line 80+110. Blue-Line 80+110. Hard-Line 80+110 with universal shank 19 mm (3/4"). When using these tool holders the replugging of 2-piece ejector pins is being omitted. You can continuously drill in one operation up to a drilling depth of 110 mm.	€ 96.55
		387 20.1291

Tool holders

Tool holder **with** automatic internal cooling.
Appropriate for all Weldon shank/universal shank 19 mm (3/4") core drills.



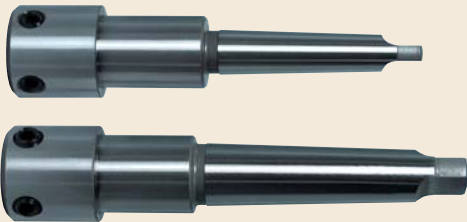
Morse taper 2	€ 73.20 387 20.1287
Morse taper 3	€ 77.45 387 20.1289

Tool holder **with** automatic internal cooling.
Appropriate for all Weldon shank/universal shank 32 mm (1 1/4") core drills.



Morse taper 3	€ 87.25 387 20.1290
Morse taper 4	€ 81.25 387 20.1292

Tool holder **without** automatic internal cooling.
Appropriate for all Weldon shank/universal shank 19 mm (3/4") core drills.



Morse taper 2	€ 38.25 387 20.1283
Morse taper 3	€ 41.05 387 20.1293

Tool holder **without** automatic internal cooling.
Appropriate for all Weldon shank/universal shank 32 mm (1 1/4") core drills.



Morse taper 3	€ 35.30 387 20.1286
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Lubricants + cutting oils



10 kg

2.5 kg

Super-speed steel cutting oil "MECUTOIL 100". To be mixed with water.
 5% oil = for standard construction steels as well as all NE metals. 10% oil = for steels of high solidity, also stainless steels.
 For most difficult chipping problems you can mix up to 50% oil into the water. You can also use the oil undiluted.

Ideal oil for all chipping tasks. To fill in, e.g. in Karnasch coolant pressure pumps.

2.5 kg		10 kg	
387 60.110025	€ 24.50	387 60.110010	€ 98.00



High-speed steel cutting spray "MECUTSPRAY". Propellant-free due to manual pumping mechanism. Contents 500 ml. The ideal spray for chipping tasks with all types of steel + NE metals. Biodegradable according to CEC-L-33-T82.

500 ml	
387 60.1150	€ 12.30



750 g

Universal cutting paste. The paste sticks to the tool. Ideal for working in difficult conditions, such as e.g. when working "upside down". For chipping tasks in all types of steel as well NE metals. Chlorine-free.

387 60.1157	€ 11.95
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Special cutting wax: specially for NE metals such as aluminum, copper, brass. The wax sticks to the tool. Ideal when working in difficult conditions such as e.g. when working upside down. Chlorine-free.

350 g	
387 60.1200	€ 7.20