For precision drilling in multiple materials

MULTI-PURPOSE DRILL RANGES

Volume 1

SOMTA
World Class Cutting Tools

KEY FEATURES: MULTI-PURPOSE DRILL RANGES

1. Improved Point and Fluting Geometry Convergence
2. Superior-Quality HSSE New Coating Technology
3. Size Range 3 to 13mm Increment Sizes of 0.1mm
4. Jobber and Stub Length

Improved Manufacturing Process resulting in:

- ▶High Wear Resistance
- ▶Accelerated Chip Evacuation
- ▶Multiple Material Applications
- ▶Improved Quality and Tool Life

4. Parallel shank for stability

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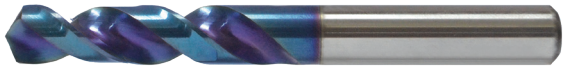
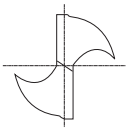
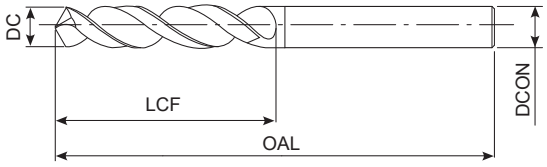
1WNS

Drilling | Stub







- Parallel Shank Multi-purpose Stub HSSE drills
- For precision drilling in multiple materials
- Stub length
- 2 flutes, up to 3xD

P C <0,2% | P 0,25<C<0,4 | P C ≥ 0,45% | P SCM | M INOX | K GG | K GGG | N Cu | H 25-35 HRC | H 35-45 HRC | H 45-52 HRC

HSSE | TiAlN | 120° | DIN 1897 | h8 | 40°

EDP	DC	LCF	OAL
1WNS0300	3	16	46
1WNS0310	3.1	18	49
1WNS0320	3.2	18	49
1WNS0330	3.3	18	49
1WNS0340	3.4	20	52
1WNS0350	3.5	20	52
1WNS0360	3.6	20	52
1WNS0370	3.7	20	52
1WNS0380	3.8	22	55
1WNS0390	3.9	22	55
1WNS0400	4	22	55
1WNS0410	4.1	22	55
1WNS0420	4.2	22	55
1WNS0430	4.3	24	58
1WNS0440	4.4	24	58
1WNS0450	4.5	24	58
1WNS0460	4.6	24	58
1WNS0470	4.7	24	58
1WNS0480	4.8	26	62
1WNS0490	4.9	26	62
1WNS0500	5	26	62
1WNS0510	5.1	26	62
1WNS0520	5.2	26	62
1WNS0530	5.3	26	62
1WNS0540	5.4	28	66
1WNS0550	5.5	28	66
1WNS0560	5.6	28	66
1WNS0570	5.7	28	66
1WNS0580	5.8	28	66
1WNS0590	5.9	28	66
1WNS0600	6	28	66
1WNS0610	6.1	31	70
1WNS0620	6.2	31	70
1WNS0630	6.3	31	70
1WNS0640	6.4	31	70
1WNS0650	6.5	31	70
1WNS0660	6.6	31	70
1WNS0670	6.7	31	70
1WNS0680	6.8	34	74
1WNS0690	6.9	34	74
1WNS0700	7	34	74
1WNS0710	7.1	34	74
1WNS0720	7.2	34	74
1WNS0730	7.3	34	74
1WNS0740	7.4	34	74
1WNS0750	7.5	34	74
1WNS0760	7.6	37	79
1WNS0770	7.7	37	79
1WNS0780	7.8	37	79
1WNS0790	7.9	37	79

EDP	DC	LCF	OAL
1WNS0800	8	37	79
1WNS0810	8.1	37	79
1WNS0820	8.2	37	79
1WNS0830	8.3	37	79
1WNS0840	8.4	37	79
1WNS0850	8.5	37	79
1WNS0860	8.6	40	84
1WNS0870	8.7	40	84
1WNS0880	8.8	40	84
1WNS0890	8.9	40	84
1WNS0900	9	40	84
1WNS0910	9.1	40	84
1WNS0920	9.2	40	84
1WNS0930	9.3	40	84
1WNS0940	9.4	40	84
1WNS0950	9.5	40	84
1WNS0960	9.6	43	89
1WNS0970	9.7	43	89
1WNS0980	9.8	43	89
1WNS0990	9.9	43	89
1WNS1000	10	43	89
1WNS1010	10.1	43	89
1WNS1020	10.2	43	89
1WNS1030	10.3	43	89
1WNS1040	10.4	43	89
1WNS1050	10.5	43	89
1WNS1060	10.6	43	89
1WNS1070	10.7	47	95
1WNS1080	10.8	47	95
1WNS1090	10.9	47	95
1WNS1100	11	47	95
1WNS1110	11.1	47	95
1WNS1120	11.2	47	95
1WNS1130	11.3	47	95
1WNS1140	11.4	47	95
1WNS1150	11.5	47	95
1WNS1160	11.6	47	95
1WNS1170	11.7	47	95
1WNS1180	11.8	47	95
1WNS1190	11.9	51	102
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1WNS1240	12.4	51	102
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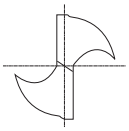
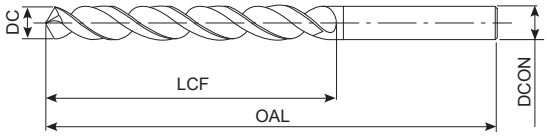
1WNS1260	12.6	51	102
1WNS1270	12.7	51	102
1WNS1280	12.8	51	102
1WNS1290	12.9	51	102
1WNS1300	13	51	102

1WN

Drilling | Jobber





- Parallel Shank Multi-Purpose Jobber HSSE drills
- For precision drilling in multiple materials
- Jobber length
- 2 flutes, up to 5xD

EDP	DC	LCF	OAL
1WN0300	3	33	61
1WN0310	3.1	36	65
1WN0320	3.2	36	65
1WN0330	3.3	36	65
1WN0340	3.4	39	70
1WN0350	3.5	39	70
1WN0360	3.6	39	70
1WN0370	3.7	39	70
1WN0380	3.8	43	75
1WN0390	3.9	43	75
1WN0400	4	43	75
1WN0410	4.1	43	75
1WN0420	4.2	43	75
1WN0430	4.3	47	80
1WN0440	4.4	47	80
1WN0450	4.5	47	80
1WN0460	4.6	47	80
1WN0470	4.7	47	80
1WN0480	4.8	52	86
1WN0490	4.9	52	86
1WN0500	5	52	86
1WN0510	5.1	52	86
1WN0520	5.2	52	86
1WN0530	5.3	52	86
1WN0540	5.4	57	93
1WN0550	5.5	57	93
1WN0560	5.6	57	93
1WN0570	5.7	57	93
1WN0580	5.8	57	93
1WN0590	5.9	57	93
1WN0600	6	57	93
1WN0610	6.1	63	101
1WN0620	6.2	63	101
1WN0630	6.3	63	101
1WN0640	6.4	63	101
1WN0650	6.5	63	101
1WN0660	6.6	63	101
1WN0670	6.7	63	101
1WN0680	6.8	69	109
1WN0690	6.9	69	109
1WN0700	7	69	109
1WN0710	7.1	69	109
1WN0720	7.2	69	109
1WN0730	7.3	69	109
1WN0740	7.4	69	109
1WN0750	7.5	69	109
1WN0760	7.6	75	117
1WN0770	7.7	75	117
1WN0780	7.8	75	117
1WN0790	7.9	75	117

EDP	DC	LCF	OAL
1WN0800	8	75	117
1WN0810	8.1	75	117
1WN0820	8.2	75	117
1WN0830	8.3	75	117
1WN0840	8.4	75	117
1WN0850	8.5	75	117
1WN0860	8.6	81	125
1WN0870	8.7	81	125
1WN0880	8.8	81	125
1WN0890	8.9	81	125
1WN0900	9	81	125
1WN0910	9.1	81	125
1WN0920	9.2	81	125
1WN0930	9.3	81	125
1WN0940	9.4	81	125
1WN0950	9.5	81	125
1WN0960	9.6	87	133
1WN0970	9.7	87	133
1WN0980	9.8	87	133
1WN0990	9.9	87	133
1WN1000	10	87	133
1WN1010	10.1	87	133
1WN1020	10.2	87	133
1WN1030	10.3	87	133
1WN1040	10.4	87	133
1WN1050	10.5	87	133
1WN1060	10.6	87	133
1WN1070	10.7	94	142
1WN1080	10.8	94	142
1WN1090	10.9	94	142
1WN1100	11	94	142
1WN1110	11.1	94	142
1WN1120	11.2	94	142
1WN1130	11.3	94	142
1WN1140	11.4	94	142
1WN1150	11.5	94	142
1WN1160	11.6	94	142
1WN1170	11.7	94	142
1WN1180	11.8	94	142
1WN1190	11.9	101	151
1WN1200	12	101	151
1WN1210	12.1	101	151
1WN1220	12.2	101	151
1WN1230	12.3	101	151
1WN1240	12.4	101	151
1WN1250	12.5	101	151
1WN1260	12.6	101	151
1WN1270	12.7	101	151
1WN1280	12.8	101	151
1WN1290	12.9	101	151
1WN1300	13	101	151

CUTTING DATA

Parameters based on ideal conditions. Please adjust parameters accordingly to real applications.

◉ Recommended
○ Suitable

Material			Ø	1	2	3	4	5	6	8
			Vc m/min	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	◉ 1.1 Free Cutting Steel	< 120 HB	35	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
	◉ 1.2 Structural Steel	< 200 HB	28	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
	◉ 1.3 Plain Carbon Steel	< 250 HB	22	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
	◉ 1.4 Alloy Steel	< 250 HB	20	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
	○ 1.5 Low Alloy Steel	250 - 350 HB	15	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238
M	◉ 2.1 Free Machining Stainless Steel	< 250 HB	20	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173
	◉ 2.2 Austenitic Stainless Steel	< 320 HB	15	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173
	◉ 2.3 Ferritic and Martensitic Stainless Steel	< 300 HB	15	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123
K	◉ 3.1 Lamellar Graphite Cast Iron	< 150 HB	35	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
	◉ 3.2 Lamellar Graphite Cast Iron	150 - 300 HB	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
	○ 3.3 Nodular Graphite, Malleable Cast Iron	< 200 HB	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
Cu	◉ 6.1 Copper	< 100 HB	35	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173
	◉ 6.2 Beta Brass, Bronze	< 200 HB	30	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173
N	◉ 7.1 Aluminium Magnesium unalloyed	< 100 HB	75	0.071-0.118	0.129-0.215	0.188-0.313	0.244-0.406	0.300-0.500	0.400-0.666	0.600-1.000
	◉ 7.2 Aluminium Alloy < 5% Si	< 150 HB	70	0.071-0.118	0.129-0.215	0.188-0.313	0.244-0.406	0.300-0.500	0.400-0.666	0.600-1.000
	○ 7.3 Aluminium Alloy 5 to 10% Si	< 120 HB	65	0.071-0.118	0.129-0.215	0.188-0.313	0.244-0.406	0.300-0.500	0.400-0.666	0.600-1.000
H	◉ 9.1 Hardened Steel	< 32 HRC	12	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238
	○ 9.2 Hardened Steel	33 - 41 HRC	10	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238

Material			Ø	10	12	15
			Vc m/min	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	◉ 1.1 Free Cutting Steel	< 120 HB	35	0.199-0.331	0.210-0.350	0.233-0.388
	◉ 1.2 Structural Steel	< 200 HB	28	0.199-0.331	0.210-0.350	0.233-0.388
	◉ 1.3 Plain Carbon Steel	< 250 HB	22	0.199-0.331	0.210-0.350	0.233-0.388
	◉ 1.4 Alloy Steel	< 250 HB	20	0.199-0.331	0.210-0.350	0.233-0.388
	○ 1.5 Low Alloy Steel	250 - 350 HB	15	0.171-0.285	0.182-0.304	0.203-0.339
M	◉ 2.1 Free Machining Stainless Steel	< 250 HB	20	0.124-0.206	0.134-0.223	0.152-0.253
	◉ 2.2 Austenitic Stainless Steel	< 320 HB	15	0.124-0.206	0.134-0.223	0.152-0.253
	◉ 2.3 Ferritic and Martensitic Stainless Steel	< 300 HB	15	0.089-0.149	0.098-0.163	0.112-0.186
K	◉ 3.1 Lamellar Graphite Cast Iron	< 150 HB	35	0.199-0.331	0.210-0.350	0.233-0.388
	◉ 3.2 Lamellar Graphite Cast Iron	150 - 300 HB	30	0.199-0.331	0.210-0.350	0.233-0.388
	○ 3.3 Nodular Graphite, Malleable Cast Iron	< 200 HB	30	0.199-0.331	0.210-0.350	0.233-0.388
Cu	◉ 6.1 Copper	< 100 HB	35	0.124-0.206	0.134-0.223	0.152-0.253
	◉ 6.2 Beta Brass, Bronze	< 200 HB	30	0.124-0.206	0.134-0.223	0.152-0.253
N	◉ 7.1 Aluminium Magnesium unalloyed	< 100 HB	75	0.750-1.250	0.825-1.375	0.881-1.469
	◉ 7.2 Aluminium Alloy < 5% Si	< 150 HB	70	0.750-1.250	0.825-1.375	0.881-1.469
	○ 7.3 Aluminium Alloy 5 to 10% Si	< 120 HB	65	0.750-1.250	0.825-1.375	0.881-1.469
H	◉ 9.1 Hardened Steel	< 32 HRC	12	0.171-0.285	0.182-0.304	0.203-0.339
	○ 9.2 Hardened Steel	33 - 41 HRC	10	0.171-0.285	0.182-0.304	0.203-0.339

TEST RESULTS

10mm in **M200 Alloy Steel** drilling 5xD 50mm blind hole with coolant
Vc = 20m/min (637rpm), Feed = 0.200mm/rev (127mm/min)

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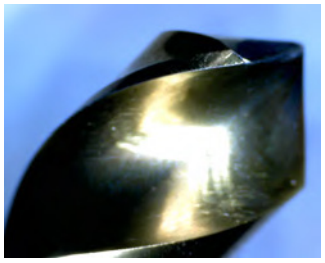
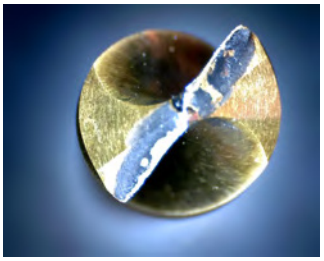
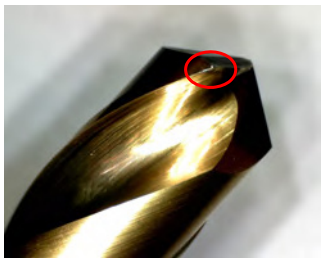
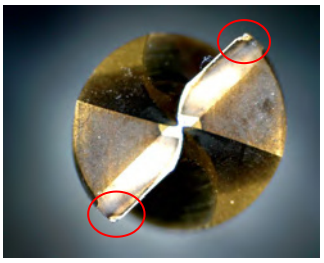




After 100 holes, tool has slight wear on point.
After 200 holes, wear visible on both sides of primary cutting lip. No chips.
After 300 holes, wear visible on chisel and corner of primary cutting lip has wear on both sides.
Hole size maintained.
Load consistent.

Competitor





Drilled 66 holes.
Drill has damage on point and is chipped on chisel and edge of primary cutting lip on both sides.

6mm in **304 Stainless Steel** drilling 3xD 18mm blind hole with coolant
Vc = 12m/min (637rpm), Feed = 0.120mm/rev (76mm/min)

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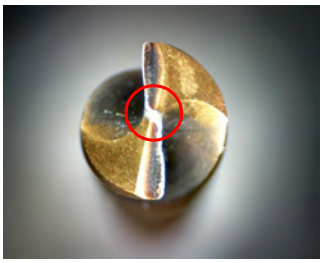
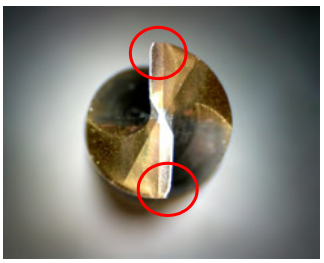


After 100 holes, slight wear visible on primary cutting lip.
After 200 holes, wear more visible. Hole size still fine.
After 300 holes, the point has a chip on edge of primary cutting lip on one side and chisel is wearing.
Hole size maintained.
Consistent load.

Competitor



After 50 holes, tool has chip on primary cutting lip on one side.
After 100 holes, tool is chipped on both sides of primary cutting lip.
Ran a total of 147 holes, stopped test. Point damaged.
Hole size shrinking.

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shaping your dreams

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