

Annular cutter

High Speed Steel Stack



Standard HSS Euroboor annular cutters feature teeth geometry which is optimised for use on single layer workpieces, ensuring the fastest and best drilling performance. The rest material created with the use of these cutters is our signature: the Euroboor slug. The rim on this slug is exactly what prevents our standard HSS cutters from penetrating the second layer of material.

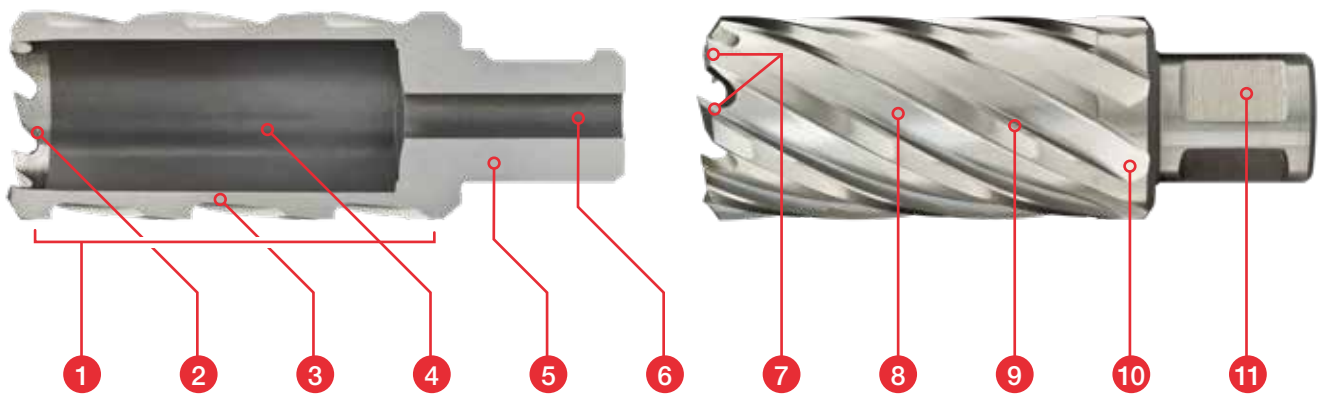
In order to drill multiple layers of material simultaneously, we recommend the use of our annular cutters with stack geometry.

The unique teeth profile ensures safe and stable penetration: layer for layer.

Combined with the standard performance improving characteristics of Euroboor annular cutters this results in smooth layer transitions, precise and clean hole finishes and the time savings you are looking for.

HSS stack material application													
Plastics GRP/CRP	Brass, Copper, Tin	Grey cast iron	Steel					Stainless steel		Aluminium		Exotic materials, Inconnell, Nimonic, HARDOX, Hastelloy	Rails
			< 500N	< 750N	< 900N	< 1,100N	< 1,400N	< 900N	≤ 900N	< 10% Si	≤ 10% Si		
●	○		●	●	○					○			

HSS profile



1. Stage hardening. Combines maximum hardness at the teeth with superior strength at the cutter body, reducing breakage to a minimum.
2. Extra deep inner ground cutting teeth. Helps stable "setting" of the cutter, reduces friction during drilling and helps (multiple) slug ejection.
3. Wall thickness matched to the diameter of the cutter, combining the best possible cutting time with strength.
4. Tapered inside fitment prevents the cutter getting stuck. Guaranteed slug(s) ejection with usage of the correct pilot pin.
5. Precise shank fitment for maximum interchangeability and close tolerance drilling without run-out.
6. Precise pilot pin fitment for perfect centration, hassle-free pin retraction and controlled lubricant flow.
7. Stack teeth geometry ensures stable and precise material penetration with fast cutting performance
8. Well-thought-out spiral flute angles for optimal chip removal.
9. Specially designed blades for optimum stability and heat-reduction.
10. Number of flutes and teeth matched to the diameter of the cutter for the best tooth load and superior cutting speeds.
11. Precision ground shanks for optimum fitment of the cutter itself in the tool holder and of pilot pin in the annular cutter. Increases safety, stability and accurate hole dimensions.

HSS Stack

Weldon shank



Shank sizes

DIA Ø 18 - 32 mm:
19.05 mm (3/4")

DIA Ø 11/16" - 1 1/4":
3/4"

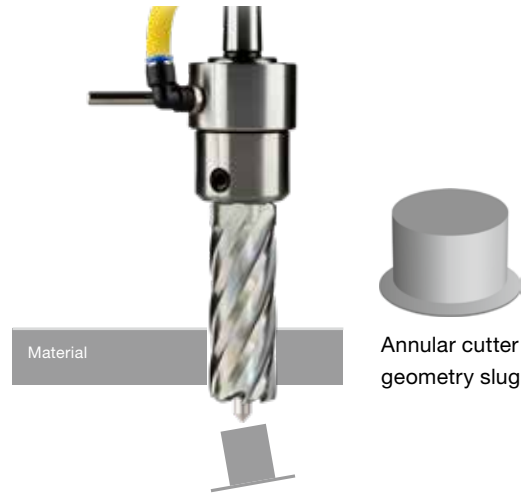


DoC
Depth of Cut measured inside cutter

	DoC 55 mm Weldon	DoC 75 mm Weldon
DIA	Ø 18 - 32 mm	
	Code	Code
Ø 18	HCPL.180	HCPY.180
Ø 19	HCPL.190	HCPY.190
Ø 20	HCPL.200	HCPY.200
Ø 21	HCPL.210	HCPY.210
Ø 22	HCPL.220	HCPY.220
Ø 23	HCPL.230	HCPY.230
Ø 24	HCPL.240	HCPY.240
Ø 25	HCPL.250	HCPY.250
Ø 26	HCPL.260	HCPY.260
Ø 27	HCPL.270	HCPY.270
Ø 28	HCPL.280	HCPY.280
Ø 29	HCPL.290	HCPY.290
Ø 30	HCPL.300	HCPY.300
Ø 31	HCPL.310	HCPY.310
Ø 32	HCPL.320	HCPY.320

	DoC 2" Weldon	DoC 3" Weldon
DIA	Ø 11/16" - 1 1/4"	
	Code	Code
Ø 11/16"	HCPL.11/16"	HCPY.11/16"
Ø 3/4"	HCPL.3/4"	HCPY.3/4"
Ø 13/16"	HCPL.13/16"	HCPY.13/16"
Ø 7/8"	HCPL.7/8"	HCPY.7/8"
Ø 15/16"	HCPL.15/16"	HCPY.15/16"
Ø 1"	HCPL.1"	HCPY.1"
Ø 1 1/16"	HCPL.1-1/16"	HCPY.1-1/16"
Ø 1 1/8"	HCPL.1-1/8"	HCPY.1-1/8"
Ø 1 3/16"	HCPL.1-3/16"	HCPY.1-3/16"
Ø 1 1/4"	HCPL.1-1/4"	HCPY.1-1/4"

Standard



Stack cutting

