



SEGMENT APPLICATION GUIDELINES

Metalcutting Applications



ISO Material Classification	P Steel	M Stainless Steel	K Cast Iron	N Aluminum	S Heat-Resistant Material	H Hardened Steel
HB-2			○	○		
HB-3				○		○
HB-110	○	○	○	○	○	○
HB-512		○				○



RECOMMENDED



INCREASE WEAR RESISTANCE



INCREASE TRANSVERSE RUPTURE STRENGTH

NOTE:

GRADES HB-2 AND HB-3 ARE INDUSTRY LEADING APPROVED SUBSTRATES FOR CVD COATING APPLICATIONS

ALUMINUM WITH LOW SILICONE CONTENT BELOW 14% = RECOMMEND GRADE **HB-110**

FOR HIGH SILICON CONTENT MORE THAN 14% = RECOMMEND GRADE **HB-3**



H.B. Carbide®

H.B. CARBIDE DRILLING MAXIMUMS

DRILL DIAMETER (Inches)	MAXIMUM BLINDHOLE DEPTH (Holding .010 hole drift)
.016	.350"
.025	4.00"
.030	5.50"
.040	5.50"
.050	7.00"
.060	8.00"
.080	10.00"
.100+	12.00"

DRILL DIAMETER (mm)	MAXIMUM BLINDHOLE DEPTH (Holding .25 mm hole drift)
.40	8.9 mm
.64	101 mm
.76	140 mm
1.00	140 mm
1.27	178 mm
1.50	203 mm
2.00	254 mm
2.50+	305 mm

Maximum Mill travel: Tool length + Blindhole depth = < 30" (762 mm)

Maximum tool length with through hole 20" (508 mm)

The longest drill body we keep in stock is 12.5" (317 mm)

PLEASE CALL IF ANY HOLES ARE REQUIRED OUTSIDE OF THESE PARAMETERS

