

**THIEME**

Zerspanen  
Spannen  
Messen

[DE] **Stufenbohren**  
[EN] **Stepdrilling**



**passion for precision**  
[ Leidenschaft für Präzision ]



# Stufenbohrer - Step Drills



## Mini-Kurzstufenbohrer aus VHM

Spezielle Schnittdaten auf Anfrage

Mini Carbide Step Drills

Art.No./Page

<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		90°	VHM	X Cut	Typ N	DIN 6535	HA	<b>623 408</b>	Seite C 01
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## Kurzstufenbohrer aus VHM

Allgemeine Schnittdaten auf Seite Z 09

Carbide Step Drills

Art.No./Page

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## Kurz-/Stufenbohrer aus HSS-E05

Allgemeine Schnittdaten auf Seite Z 09

HSS-E05 Step Drills

Art.No./Page

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## Kernloch-Kurzstufenbohrer aus HSS-E05

Allgemeine Schnittdaten auf Seite Z 09

HSS-E05 Thread Hole Step Drills

Art.No./Page

<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		90°	HSS E05	blank	Typ N	WN	ZYL	<b>123 560</b>	Seite C 04
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### — INFO —



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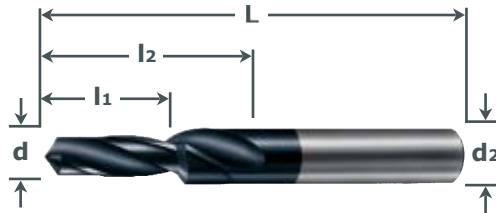
623 408

**Mini-Kurzstufenbohrer aus VHM - 90°**  
**Mini Carbide Step Drills**



- DE:**
- Für Gewindekernlöcher (DIN 336-1)
  - Für Gewinde ab M0,8
  - Fluchtgenaues Einbringen von Bohrung und Senkung in einem Arbeitsgang
  - Senkwinkel 90°
  - Oberfläche X.Cut beschichtet

- EN:**
- For thread holes (DIN 336-1)
  - For threads starting from M0,8
  - Drilling of thread hole and chamfer in one operation with exact alignment
  - Chamfer angle 90°
  - With X.Cut coating



VHM Carb	X Cut
WN	
Typ N	90°
HA	Mini

Spezielle Schnittdaten auf Anfrage

ØM	Ød ±0,01	Ød2 h6	L ±1	l1 +1	l2	α	Art. No.	Stk/pce Euro
0,8	0,60	3	39	2,4	6	90°	6234080080	33,80
0,9	0,70	3	39	2,8	7	90°	6234080090	32,70
1,0	0,75	3	39	2,9	7	90°	6234080100	31,50
1,2	0,95	3	39	3,7	9	90°	6234080120	31,50
1,4	1,10	3	39	4,2	10	90°	6234080140	31,50
1,6	1,25	3	39	4,7	11	90°	6234080160	31,50
2,0	1,50	4	51	5,6	13	90°	6234080200	29,30
2,5	2,05	4	51	7,5	17	90°	6234080250	31,50
3,0	2,50	6	66	8,8	20	90°	6234080300	27,10
4,0	3,30	6	66	11,4	24	90°	6234080400	31,50
5,0	4,20	6	66	13,6	28	90°	6234080500	35,00
6,0	5,00	8	79	16,5	31	90°	6234080600	42,20

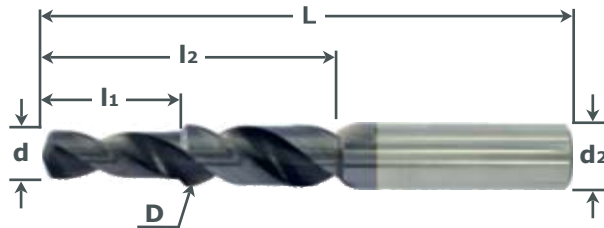
623 407

**Kurzstufenbohrer aus VHM - 90°**  
**Carbide Step Drills**



- DE:**
- Für Gewindekernlöcher (DIN 336-1)
  - Fluchtgenaues Einbringen von Bohrung und Senkung in einem Arbeitsgang
  - Besonders für NC-Maschinen
  - Senkwinkel 90°
  - Oberfläche X.Cut beschichtet

- EN:**
- For thread holes (DIN 336-1)
  - Drilling of thread hole and chamfer in one operation with exact alignment
  - Best suited for nc-machines
  - Chamfer angle 90°
  - With X.Cut coating



VHM Carb	X Cut
WN	
Typ N	90°
HA	

Allgemeine Schnittdaten auf Seite Z 09

ØM	ØD h8	Ød h8	Ød2 h6	L	l1	l2	α	Art. No.	Stk/pce Euro
3	3,4	2,5	6	62	8,8	20	90°	6234070300	29,80
4	4,5	3,3	6	66	11,4	24	90°	6234070400	29,80
5	5,5	4,2	6	66	13,6	28	90°	6234070500	29,80
6	6,6	5,0	8	79	16,5	34	90°	6234070600	45,80
8	9,0	6,8	10	89	21,0	47	90°	6234070800	64,40
10	11,0	8,5	12	102	25,5	55	90°	6234071000	87,50
12	13,5	10,2	14	107	30,0	60	90°	6234071200	110,50

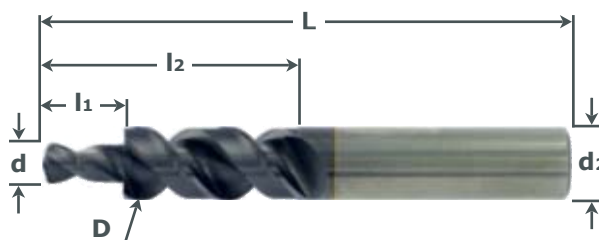
623 417

**Kurzstufenbohrer aus VHM - 180°**  
**Carbide Step Drills**



- DE:**
- Für Schraubendurchgangslöcher (DIN 273) und Senkung (DIN 74)
  - Fluchtgenaues Einbringen von Bohrung und Senkung in einem Arbeitsgang
  - Senkwinkel 180°
  - Oberfläche X.Cut beschichtet

- EN:**
- For through holes (DIN 273) and for screws with chamfer 180°
  - Drilling of thread hole and chamfer in one operation with exact alignment
  - High concentricity
  - With X.Cut coating



VHM Carb	X Cut
WN	
Typ N	180°
HA	

Allgemeine Schnittdaten auf Seite Z 09

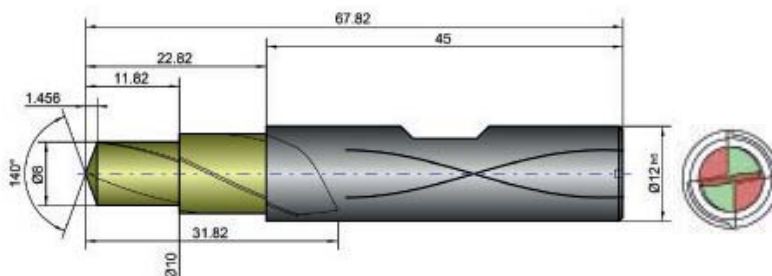
ØM	ØD h8	Ød h8	Ød2 h6	L	l1	l2	α	Art. No.	Stk/pce Euro
3	6	3,4	6	64	9	28	180°	6234170300	<b>30,90</b>
4	8	4,5	8	79	11	37	180°	6234170400	<b>47,60</b>
5	10	5,5	10	89	13	43	180°	6234170500	<b>65,10</b>
6	11	6,6	12	102	15	55	180°	6234170600	<b>88,60</b>
8	15	9,0	16	115	19	60	180°	6234170800	<b>151,10</b>
10	18	11,0	18	123	23	62	180°	6234171000	<b>180,80</b>
12	20	13,5	20	131	27	66	180°	6234171200	<b>220,90</b>

**INFO**

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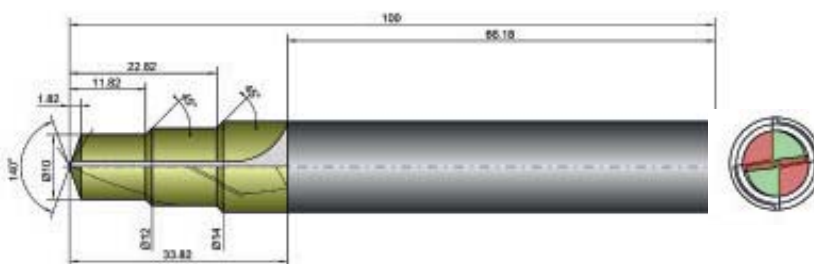
Anfragen an: [technik@sppw.de](mailto:technik@sppw.de)



**We would like to help in your project!**

Our technicians are keen to assist you!

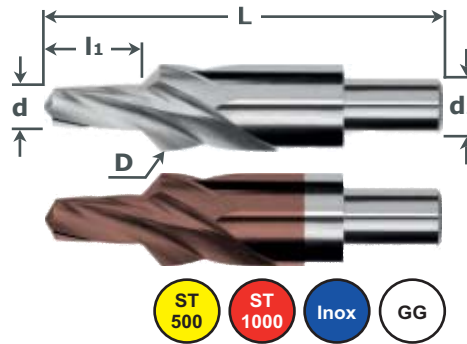
Inquiry: [technik@sppw.de](mailto:technik@sppw.de)



**123 400****123 407****Kurzstufenbohrer aus HSS-E05 - 90°  
HSS-E05 Step Drills**

- DE:**
- Für Schraubendurchgangslöcher (DIN 273) und Senkungen (DIN 74)
  - Fluchtgenaues Einbringen von Bohrung und Senkung in einem Arbeitsgang
  - Ausführung fein, Senkwinkel 90°
  - Oberfläche blank bzw. X5.Cut beschichtet

- EN:**
- For through holes (DIN 273) and for screws with chamfer 90°
  - Drilling of thread hole and chamfer in one operation with exact alignment
  - High concentricity
  - Bright finish or with X5.Cut coating



HSS E05	blank
WN	X5 Cut
Typ N	90°
ZYL	

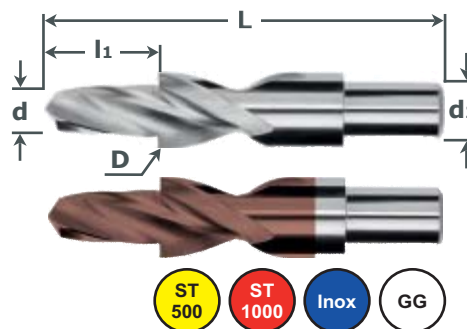
Allgemeine Schnittdaten auf Seite Z 09

Ø M	ØD h9	Ød ±0,05	Ød2 h9	L ±1	l1 +1	α ±1°	Art. No. 123 400	Stk/pce Euro	Art. No. 123 407	Stk/pce Euro
2,0	4,6	2,2	4,6	45	6	90°	1234000200	9,00	1234070200	11,70
2,5	5,7	2,7	5,7	45	7	90°	1234000250	9,00	1234070250	12,30
3,0	6,5	3,2	6,5	45	9	90°	1234000300	9,00	1234070300	12,90
3,5	7,6	3,7	7,6	50	10	90°	1234000350	14,30	1234070350	18,50
4,0	8,6	4,3	8,6	50	11	90°	1234000400	10,50	1234070400	16,00
5,0	10,4	5,3	10,4	55	13	90°	1234000500	11,70	1234070500	18,50
6,0	12,4	6,4	12,4	63	15	90°	1234000600	14,40	1234070600	22,20
8,0	16,4	8,4	12,5	100	19	90°	1234000800	27,70	1234070800	36,90
10,0	20,4	10,5	12,5	110	23	90°	1234001000	40,60	1234071000	51,70
12,0	25,0	13,0	12,5	120	28	90°	1234001200	124,90	1234071200	141,40

**123 410****123 417****Kurzstufenbohrer aus HSS-E05 - 180°  
HSS-E05 Step Drills**

- DE:**
- Für Schraubendurchgangslöcher (DIN 273) und Senkungen (DIN 74)
  - Fluchtgenaues Einbringen von Bohrung und Senkung in einem Arbeitsgang
  - Ausführung fein, Senkwinkel 180°
  - Oberfläche blank bzw. X5.Cut beschichtet

- EN:**
- For through holes (DIN 273) and for screws with chamfer 180°
  - Drilling of thread hole and chamfer in one operation with exact alignment
  - High concentricity
  - Bright finish or with X5.Cut coating



HSS E05	blank
WN	X5 Cut
Typ N	180°
ZYL	

Allgemeine Schnittdaten auf Seite Z 09

Ø M	ØD h9	Ød ±0,05	Ød2 h9	L ±1	l1 +1	α ±1°	Art. No. 123 410	Stk/pce Euro	Art. No. 123 417	Stk/pce Euro
2,0	4,3	2,4	4,3	45	6	180°	1234100200	9,30	1234170200	12,00
2,5	5,0	2,9	5,0	45	7	180°	1234100250	9,30	1234170250	12,30
3,0	6,0	3,4	6,0	45	9	180°	1234100300	9,00	1234170300	12,90
4,0	8,0	4,5	8,0	50	11	180°	1234100400	10,50	1234170400	16,00
5,0	10,0	5,5	10,0	55	13	180°	1234100500	11,60	1234170500	18,50
6,0	11,0	6,6	11,0	63	15	180°	1234100600	14,30	1234170600	22,20
8,0	15,0	9,0	12,5	100	19	180°	1234100800	27,70	1234170800	36,90
10,0	18,0	11,0	12,5	110	23	180°	1234101000	40,60	1234171000	50,50
12,0	20,0	14,0	12,5	110	28	180°	1234101200	53,10	1234171200	64,00
14,0	24,0	16,0	12,5	120	34	180°	1234101400	124,90	1234171400	141,40

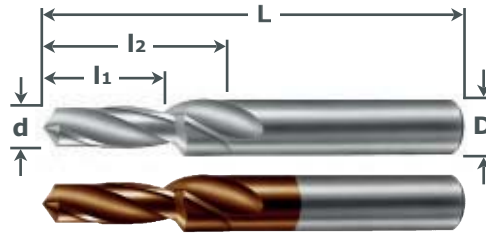
**123 560****123 567**

## Kernloch-Kurzstufenbohrer aus HSS-E05 - 90° HSS-E05 Thread Hole Step Drills



- DE:**
- Für Gewindekernlöcher (DIN 336-1)
  - Hohe Rundlaufgenauigkeit
  - Fluchtgenaues Einbringen von Bohrung und Senkung in einem Arbeitsgang
  - Senkwinkel 90°
  - Oberfläche blank bzw. X5.Cut beschichtet

- EN:**
- For thread holes (DIN 336-1)
  - High concentricity
  - Drilling of thread hole and chamfer in one operation with exact alignment
  - Chamfer angle 90°
  - Bright finish or with X5.Cut coating



HSS E05	blank
WN	X5 Cut
Typ N	90°
ZYL	

Allgemeine Schnittdaten auf Seite Z 09

ØM	ØD h8	Ød ±0,05	L ±1	l1	l2 +1	α ±1°	Art. No. 123 560	Stk/pce Euro	Art. No. 123 567	Stk/pce Euro
3	3,4	2,5	52	8	20	90°	1235600300	<b>10,60</b>	1235670300	<b>13,30</b>
4	4,5	3,3	58	11	24	90°	1235600400	<b>11,20</b>	1235670400	<b>13,90</b>
5	5,5	4,2	66	13	28	90°	1235600500	<b>11,80</b>	1235670500	<b>15,20</b>
6	6,6	5,0	70	16	31	90°	1235600600	<b>12,60</b>	1235670600	<b>16,70</b>
8	9,0	6,8	84	20	40	90°	1235600800	<b>15,10</b>	1235670800	<b>22,90</b>
10	11,0	8,5	95	24	47	90°	1235601000	<b>19,90</b>	1235671000	<b>27,80</b>
12	14,0	10,2	107	29	54	90°	1235601200	<b>26,80</b>	1235671200	<b>36,20</b>
14	16,0	12,0	115	32	56	90°	1235601400	<b>90,90</b>	1235671400	<b>100,60</b>
16	18,0	14,0	135	34	60	90°	1235601600	<b>100,00</b>	1235671600	<b>111,60</b>

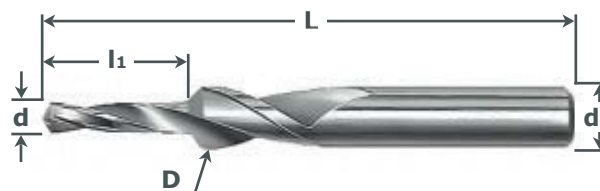
**123 430**

## Stufenbohrer aus HSS-E05 - 90° mit langer Bohrstufe HSS-E05 Step Drills with Long Pilot



- DE:**
- Mit langer Bohrstufe für Schraubendurchgangslöcher (DIN 273) und Senkung (DIN 74)
  - Besonders geeignet für Profilmaterial
  - Senkwinkel 90°
  - Oberfläche blank

- EN:**
- With long pilot drill for through holes (DIN 273) for screws with chamfer 90°
  - Especially suited for profiles
  - High concentricity
  - Bright finish



HSS E05	blank
WN	
Typ N	90°
ZYL	

Allgemeine Schnittdaten auf Seite Z 09

ØM	ØD h9	Ød ±0,05	Ød2 h9	L ±1	l1	α ±1°	Art. No.	Stk/pce Euro
4	8,6	4,3	8,6	110	30	90°	1234300400	<b>32,80</b>
5	10,4	5,3	10,4	110	30	90°	1234300500	<b>32,10</b>
6	12,4	6,4	12,4	110	30	90°	1234300600	<b>36,90</b>
8	16,4	8,4	12,5	110	30	90°	1234300800	<b>54,10</b>
10	20,4	10,5	12,5	110	30	90°	1234301000	<b>68,40</b>

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