



TUBE AND SHEET DRILLS

FASCINATION FOR PRECISION®

Range and applications overview:



Material	Surface	Shape	Point angle	Cone angle	Shank	Ø mm	Article no.	Page
HSS						3,0 - 61,0	101 001 - 101 022	85 - 86
HSSE Co 5						3,0 - 31,0	101 001 E - 101 008 E	85 - 86
HSS	TiN					3,0 - 40,0	101 001 T - 101 008 T	85 - 86
HSS						5,0 - 20,0	101 049 H	85
HSS						2,0 - 11,8	101 041 - 101 045-1	87

Steel (N/mm ²) < 900	Steel (N/mm ²) < 1100	Steel (N/mm ²) < 1300	Stainless steel	Aluminium	Brass	Bronze	Plastics	Cast iron	Titanium alloyed





Tube and sheet drills HSS and HSSE-Co 5 with split point

The CBN ground flutes guarantee quiet running and high cutting performance. The relief angle on the underside of the tool enables easier removal from the material.

Packing unit: in plastic boxes



Steel (N/mm2) < 900	■	■	■
Steel (N/mm2) < 1100		■	□
Steel (N/mm2) < 1300			
Stainless steel		■	□
Aluminium	■	■	

Brass	■	■	■
Bronze	□	□	□
Plastics	■	■	■
Cast iron	□	□	□
Titanium alloyed			

Size no.	Ø1 - Ø2 mm	L1 mm	Ø3 mm					
1	3,0 - 14,0	58,0	6,0	101 001	101 001 E	101 001 T		1
2	4,0 - 20,0	71,0	8,0	101 002	101 002 E	101 002 T		1
3	16,0 - 30,5	76,0	9,0	101 003	101 003 E	101 003 T		1
4	24,0 - 40,0	89,0	10,0	101 004	—	101 004 T		1
5	36,0 - 50,0	97,0	12,0	101 005	—	—		1
6	40,0 - 61,0	103,0	13,0	101 006	—	—		1
7	5,0 - 25,4	87,0	10,0	101 007	—	—		1
8	5,0 - 31,0	103,0	9,0	101 008	101 008 E	101 008 T		1
9	5,0 - 22,5	79,0	8,0	101 022	—	—		1



Tube and sheet drill bits HSS, 1/4" with split point

The CBN ground flutes guarantee quiet running and high cutting performance. The relief angle on the underside of the tool enables easier removal from the material.

Packing unit: in plastic boxes



Steel (N/mm2) < 900	■
Steel (N/mm2) < 1100	
Steel (N/mm2) < 1300	
Stainless steel	
Aluminium	■

Brass	■
Bronze	□
Plastics	■
Cast iron	□
Titanium alloyed	

Size no.	Ø1 - Ø2 mm	L1 mm	Ø3 mm	Ø3 inch		
2	5,0 - 20,0	78,0	6,35 x 27,0	1/4"	101 049 H	1



Tube and sheet drill sets HSS and HSSE-Co 5 in steel case

	HSS	HSSE Co 5	HSS TIN
4-piece set of tube and sheet drills sizes 1, 2, 3 and 1 cutting paste 50 g in polystyrene case	101 009	—	—
4-piece set of tube and sheet drills sizes 1, 2, 3 and 1 cutting paste 30 g in steel case	101 020	101 020 E	101 020 T



Tube and sheet drill sets HSS and HSSE-Co 5 in plastic case

	HSS	HSSE Co 5	HSS TIN
4-piece set of tube and sheet drills sizes 1, 2, 3 and 1 cutting paste 30 g	101 020 RO	101 020 ERO	101 020 TRO





Tube and sheet drills HSS with stopper and spot facer for cavity sealing, with split point

The CBN ground flutes guarantee quiet running and high cutting performance.

Packing unit: in plastic boxes

Steel (N/mm ²) < 900	<input checked="" type="checkbox"/>	Brass	<input checked="" type="checkbox"/>
Steel (N/mm ²) < 1100	<input type="checkbox"/>	Bronze	<input type="checkbox"/>
Steel (N/mm ²) < 1300	<input type="checkbox"/>	Plastics	<input checked="" type="checkbox"/>
Stainless steel	<input type="checkbox"/>	Cast iron	<input type="checkbox"/>
Aluminium	<input checked="" type="checkbox"/>	Titanium alloyed	<input type="checkbox"/>

Size no.	Ø1 - Ø2 mm	L1 mm	Ø3 mm	HSS		
1	3,0 - 7,8	48,0	6,0	101 041	1	
2	3,0 - 10,2	52,0	6,0	101 042	1	
3	3,0 - 11,8	56,0	6,0	101 043	1	
5	2,0 - 7,8	48,0	6,0	101 045-1	1	



Magnetic bit holder for 1/4" hexagonal shank tools

Packing unit: in plastic boxes

	Article no.	
Magnetic bit holder	270 013	1



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Coolants and lubricants

RUKO high performance coolants and lubricants with outstanding cooling and anti-separation qualities. Increases tool life even with hard and brittle materials. High heat resistance ensures good lubrication and cooling, even at high temperatures. Good adhesion quality improves lubrication.

For all standard metal working processes, such as drilling, thread cutting, countersinking, deburring, sawing, turning, milling, grinding.

Perfectly matched for use with RUKO metal working tools.
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Table of cutting speeds for tube and sheet drills

Material:		High carbon struc. steel	High carbon struc. steel	Alloyed steel	Cast iron	Cast iron	CuZn-alloy	CuZn-alloy	Al-alloy	Thermo-plastics	Duro-plastics
		up to 700 N/mm ²	over 700 N/mm ²	over 1000 N/mm ²	up to 250 N/mm ²	over 250 N/mm ²	brittle	tough	up to 11% Si		
Sheet thickness:		up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0
Vc = m/min		30	20	20	15	10	60	35	30	20	15
Cooling lubricant:		Cutting spray	Cutting spray	Cutting spray	Cutting spray	Air	Air	Air	Cutting spray	Water	Air
Size	Ø mm	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.
No. 1	3,0-14,0	3185-682	2123-455	2123-455	1592-341	1062-227	6369-1365	3715-796	3185-682	2123-455	1592-341
No. 2	4,0-20,0	1911-478	1274-318	1274-318	955-239	637-159	3822- 955	2229-557	1911-478	1274-318	955-239
No. 3	16,0-30,5	597-313	398-209	398-209	299-157	199-104	1194- 627	697-365	597-313	398-209	299-157
No. 4	24,0-40,0	398-239	265-159	265-159	199-119	133- 80	796- 478	464-279	398-239	265-159	199-119
No. 5	36,0-50,0	265-191	177-127	177-127	133- 96	88- 64	531- 382	310-223	265-191	177-127	133- 96
No. 6	40,0-61,0	239-157	159-104	159-104	119- 78	80- 52	478- 313	279-183	239-157	159-104	119- 78
No. 7	5,0-25,4	1911-376	1274-251	1274-251	955-188	637-125	3822- 752	2229-439	1911-376	1274-251	955-188
No. 8	5,0-31,0	1911-308	1274-205	1274-205	955-154	637-103	3822- 616	2229-360	1911-308	1274-205	955-154
No. 9	5,0-22,5	1911-425	1274-283	1274-283	955-212	637-142	3822- 849	2229-495	1911-425	1274-283	955-212

