
























<b>Drill Description</b> ▶	<b>Solid Carbide Twist Drill</b>											
DIN ▶	HAM	6539	338	HAM	338	HAM	6539	338	HAM	HAM	HAM	HAM
Drill Length ▶	—	—	—	—	—	—	—	—	—	—	—	—
<b>Part Number</b>	30-1000	30-1081	30-1121	30-1161	30-1201	30-1301	30-1320	30-1361	30-1401	30-1441	30-1481	30-1520
HAM Type	300	304	310	313	314	—	342	322	323	326	385	328
<b>Page Number</b>	10	11	12	14	15	16	17	18	19	20	21	22
Drill Type	N	N	N	W	W	N	N	N	N	N	N	N
Material	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide
Flutes	2	2	2	2	2	2	2	3	3	3	3	2
Coating	—	TA	TA	TA-AL	TA-AL	TA	—	TA	TA	TA	TA	—
Ø in mm	0.5 – 3.0	0.5 – 20.0	1.0 – 16.0	0.5 – 3.0	1.0 – 10.0	0.1 – 3.0	3.0 – 16.0	3.0 – 16.0	4.0 – 16.0	3.0 – 20.0	0.5 – 3.175	2.5 – 15.1
Ø in inch	.02 - .12	.02 - .79	.04 - .63	.02 - 12	.04 - .39	.004 - .12	.12 - .63	.12 - .63	.16 - .63	.12 - .79	.02 - .13	.10 - .59
Internal Coolant	—	—	—	—	—	—	—	—	IC	—	—	—
Direction of Cut	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right
Flute Style	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral
techn. Ausführung ▶												
Point Angle												
							Kevlar					
												
▼ <b>Material Group</b>												
Aluminum	●	○	○	●	●		●	●	●	●	○	●
Aluminum > 9% Si	○	○	○	●	●		○	●	●	●	○	○
Steel < 23 HRC	○	●	●	○	○	●		●	●	●	●	●
Steel < 38 HRC	○	●	●	○	○	●		●	●	●	○	●
Steel < 48 HRC	○	○	○			●		○	○	○		○
Steel < 55 HRC						○						
Steel < 60 HRC												
Steel < 66 HRC												
SST < 23 HRC	○	○	○	○	○	●		○	○	○		○
SST > 23 HRC	○	○	○	○	○	○		○	○	○		○
Cast Iron	○	●	●	○	○	●		●	●	●		●
Nodular, Ductile Iron	○	●	●			○		●	●	●	●	○
Iconel, Super Alloys								○	○	○	○	
Titanium				○	○	●		○	○	○		
Copper, Non-Ferrous	●	○	○	●	●		●	●	●	●		●
Graphite, Composites				○	○		●					
UNI												










































● very suitable ○ suitable

<b>HAM Superdrill</b>						<b>HAM Nirodrill</b>			<b>HAM Multidrill</b>					
6537 K	6537	6537 K	6537	HAM	HAM	6537 K	6537	HAM	HAM	HAM	HAM	HAM	HAM	
3 x D	5 x D	3 x D	5 x D	8 x D	12 x D	3 x D	5 x D	8 x D	3 x D	5 x D	7 x D	12 x D	—	
30-1621	30-1701	30-1741	30-1781	30-1821	30-1861	30-1891	30-1901	30-1941	30-1961	30-2001	30-2041	30-2081	30-2120	
280	283	285	286	292	293	—	270	271	297	298	299	294	296	
24	25	27	29	31	32	34	35	37	40	41	42	43	44	
HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	
Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	
2	2	2	2	2	2	2	2	2	2	2	2	2	2	
TA-C	TA-C	TA-C	TA-C	TA-C	TA-C	TA-CN	TA-CN	TA-CN	TA	TA	TA	TA	—	
2.8 – 20.0	3.0 – 16.0	3.0 – 22.0	3.0 – 20.0	3.0 – 20.0	3.0 – 12.0	2.8 – 16.0	3.0 – 16.0	3.0 – 16.0	4.0 – 20.0	6.8 – 20.0	4.0 – 20.0	4.0 – 16.0	3.3 – 18.9	
.11 - .79	.12 - .63	.12 - .87	.12 - .79	.12 - .79	.12 - .47	.11 - .63	.12 - .63	.12 - .63	.16 - .79	.27 - .79	.16 - .79	.16 - .63	.13 - .74	
—	—	IC	IC	IC	IC	IC	IC	IC	IC	IC	IC	IC	IC	
Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	
Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	None	None	None	None	None	
○	○	○	○	○	○	●	●	●	●	●	●	●	●	
○	○	○	○	○	○	○	○	○	○	○	○	○	○	
●	●	●	●	●	●									
●	●	●	●	●	●									
●	●	●	●	●	●									
●	●	●	●	●	●									
○	○	○	○	○	○	●	●	●						
○	○	○	○	○	○	●	●	●						
●	●	●	●	●	●	○	○	○	●	●	●	●	●	
○	○	●	●	●	●				○	○	○	○	○	
○	○	○	○	○	○	○	○	○						
○	○	○	○	○	○	●	●	●						
						●	●	●	●	●	●	●	●	
						○	○	○						

● very suitable ○ suitable

<b>Drill Description ▶</b>	<b>Solid Carbide Twist Drill</b>													
DIN ▶	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM
Drill Depth ▶	5 x D	8 x D	12 x D	15 x D	20 x D	15 x D	20 x D	25 x D	30 x D	40 x D	15 x D	20 x D	25 x D	30 x D
<b>Part Number</b>	30-2181	30-2221	30-2261	30-2301	30-2341	30-2381	30-2421	30-2461	30-2501	30-2541	30-2580	30-2620	30-2660	30-2700
HAM Type	—	—	—	—	—	—	—	—	—	—	—	—	—	—
<b>Page Number</b>	47	48	49	50	51	52	52	53	53	54	54	55	55	56
Drill Type	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM	HAM
Material	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide
Flutes	2	2	2	2	2	2	2	2	2	2	2	2	2	2
Coating	TA	TA	TA	TA	TA	TA-C	TA-C	TA-C	TA-C	TA-C	—	—	—	—
Ø in mm	1.0 – 3.0	1.0 – 3.0	1.0 – 3.0	1.0 – 3.0	1.0 – 3.0	3.0 – 14.0	3.0 – 12.0	3.0 – 10.0	3.0 – 8.0	4.0 – 5.0	3.0 – 14.0	3.0 – 12.0	3.0 – 10.0	3.0 – 7.0
Ø in inch	.04 - .12	.04 - .12	.04 - .12	.04 - .12	.04 - .12	.12 - .55	.12 - .47	.12 - .39	.12 - .31	.16 - .20	.12 - .55	.12 - .47	.12 - .39	.12 - .28
Internal Coolant	IC	IC	IC	IC	IC	IC	IC	IC	IC	IC	IC	IC	IC	IC
Direction of Cut	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right
Flute Style	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral
Techn. Application ▶														
Point Angle														
<b>▼ Material Group</b>														
Aluminum											●	●	●	●
Aluminum > 9% Si											●	●	●	●
Steel < 23 HRC	●	●	●	●	●	●	●	●	●	●				
Steel < 38 HRC	●	●	●	●	●	●	●	●	●	●				
Steel < 48 HRC	○	○	○	○	○	○	○	○	○	○				
Steel < 55 HRC														
Steel < 60 HRC														
Steel < 66 HRC														
SST < 23 HRC	●	●	●	●	●	●	●	●	●	●				
SST > 23 HRC	○	○	○	○	○	○	○	○	○	○				
Cast Iron	●	●	●	●	●	●	●	●	●	●				
Nodular, Ductile Iron	●	●	●	●	●	●	●	●	●	●				
Inconel, Hayes, Alloy	○	○	○	○	○	○	○	○	○	○				
Titanium	○	○	○	○	○	○	○	○	○	○				
Copper, Non-Ferrous											●	●	●	●
Graphite, Composites														
UNI														

● very suitable ○ suitable

														
	<b>Center Drill</b>		<b>NC-Center</b>		<b>Sinker</b>	<b>Diamond Drill</b>								
HAM	333 R	333 A	HAM	HAM	335 C	6539	338	338	HAM	HAM	HAM	HAM	HAM	HAM
40 x D	—	—	—	—	—	—	—	—	—	—	—	3 x D	5 x D	—
30-2740	30-2760	30-2800	30-2841	30-2881	30-2921	33-1000	33-1040	33-1080	33-11C	33-1160	33-1C0	33-1240	33-1280	33-1320
—	329	330	331	332	337	3304	3310	3311	3270	3380	3328	3297	3298	3296
56	58	58	59	59	60	62	63	64	64	66	67	67	68	68
HAM	N	N	N	N	HAM	N	N	N	N	N	N	HAM	HAM	HAM
Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	PCD	PCD	PCD	PCD	PCD	PCD	PCD	PCD	PCD
2	2	2	2	2	3	2	2	2	2	2	2	2	2	2
—	—	—	TA	TA	TA	—	—	—	—	—	—	—	—	—
4.0 – 5.0	0.5 – 6.3	0.5 – 6.3	5.0 – 20.0	5.0 – 20.0	6.3 – 31.0	3.0 – 20.0	3.0 – 20.0	8.0 – 20.0	2.5 – 6.35	0.5 – 3.175	3.3 – 13.2	4.0 – 12.0	4.0 – 12.0	4.2 – 13.2
.16 - .20	.02 - .25	.02 - .25	.20 - .79	.20 - .79	.25 - 1.22	.12 - .79	.12 - .79	.31 - .79	.10 - .25	.02 - .13	.13 - .52	.16 - .47	.16 - .47	.17 - .52
IC	—	—	—	—	—	—	—	IC	—	—	—	IC	IC	IC
Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right	Right
Spiral	Spiral	Spiral	Spiral	Spiral	None	Spiral	Spiral	Spiral	Spiral	Spiral	Spiral	None	None	None
														
														
														
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	●	●	●	●	●									
	●	●	●	●	●									
	●	●	○	○	●									
					●									
					○									
	○	○	○	○	○									
	○	○	○	○	○									
	●	●	●	●	●									
	●	●	●	●	●									
	○	○	○	○	○									
	○	○	○	○	○									
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
					○	●	●	●	●	●	●	●	●	●

● very suitable ○ suitable