



**ULTIMATECUT<sup>®</sup>**



FASCINATION  PRECISION<sup>®</sup>



# Welcome to the world's first.

The new RUKO  
**ULTIMATECUT**®  
step drill

- 5 in 1 tool
- Up to 75% time savings
- Ultimate flexibility



# OUT NOW

Information  
and videos



RUna  
TEC



# ULTIMATECUT<sup>®</sup>

↑ 10  
↓ mm

## Unique in every step.

- No **center punching** thanks to specially developed turbo tip.
- No **tool changes** due to pre-drilling and different drill hole diameters, which would occur with for e.g. **twist drills**.
- No problems in **hard-to-reach places**, for e.g. T-beams, where the use of big machines with **core drills** is problematic.
- No problems with **low holding forces** of magnetic stand drilling machines for materials < 10 mm, since it can be drilled with a manual drilling machine.
- No extra **deburring** necessary, the next step takes over this function.





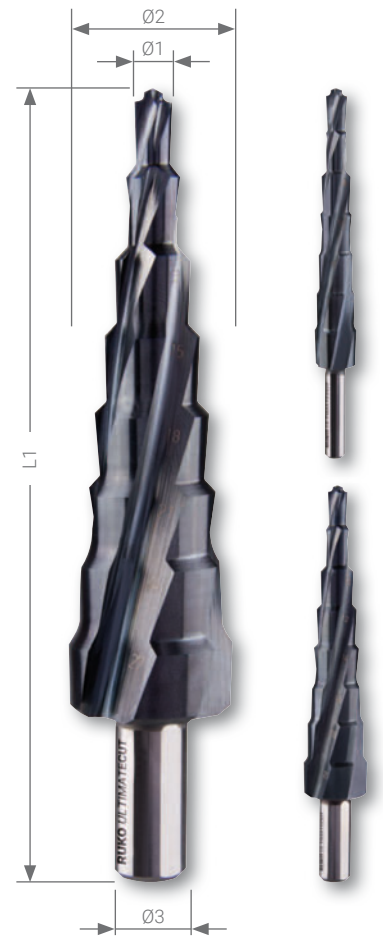
**ULTIMATECUT®**

## ULTIMATECUT Step drills HSS RUnaTEC, spiral fluted with turbo tip

The **ULTIMATECUT** step drill revolutionizes the work process and sets new standards in machining time with time savings of up to 75%. The step drill from RUKO achieves this through its revolutionary cutting edge geometry by combining the most diverse applications and tools. This means less tools needed, no tool changes and ultimate flexibility.

Packing unit: in plastic tubes of 1

- Cooling
- Adjust speed
- Low speeds for hand drills
- Follow table of application for **ULTIMATECUT** step drills
- Pay attention to total length while drilling



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

Size no.	Ø1 - Ø2 mm	Drilling range Ø mm	L1 mm	Steps	Ø3 mm	HSS	RUna TEC	
S1	6,0 - 12,00	6,0 / 7,0 / 8,0 / 9,0 / 10,0 / 11,0 / 12,0	105,0	7	8,0	101 082 P		1
M2	6,0 - 20,00	6,0 / 8,0 / 10,0 / 12,0 / 14,0 / 16,0 / 18,0 / 20,0	120,0	8	10,0	101 083 P		1
L3	6,0 - 27,00	6,0 / 9,0 / 12,0 / 15,0 / 18,0 / 21,0 / 24,0 / 27,0	125,0	8	12,0	101 084 P		1



## ULTIMATECUT Step drill set HSS RUnaTEC, in plastic case

	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
ULTIMATECUT 3-piece set of step drills spiral fluted, sizes S1, M2, L3	101 087 PRO	







**Table of cutting speeds for ULTIMATECUT step drills**

Material	Application	Working step	Hand drill	Pillar drill manual feed	Pillar drill / CNC machine automatic feed
Structural steel (e.g. S235JR) Non-ferrous metals / Plexiglas / Plastics / Wood	■	tapping (drilling through 1st step)	up to 1000 rpm cooling recommended	up to 1000 rpm cooling recommended	approx. 750 rpm f = 0,1mm/rev cooling necessary
		reaming (from 2nd step)	100 - 250 rpm cooling recommended	250- 350 rpm cooling recommended	
Stainless steel up to V2A	□	tapping (drilling through 1st step)	up to 600 rpm cooling necessary	up to 600 rpm cooling necessary	approx. 600 rpm f = 0,05mm/rev cooling necessary
		reaming (from 2nd step)	100 - 200 rpm cooling necessary	200 - 300 rpm cooling necessary	



# Technically perfected.

The new RUKO  
**ULTIMATECUT**®  
Countersink

- Up to 30% time saving
- Twice as many countersink holes
  - Excellent, smooth countersink results



# OUT NOW

Information  
and videos





# ULTIMATECUT®



## **More precise. More powerful. Faster.**

The specially developed flute parameters, such as the angle, the transition radius as well as the extra-wide chip flute, ensures optimal chip and heat removal and therefore enables a high wear resistance. Furthermore, the new geometry prevents material welding and reduces the countersinking force.

The variably running relief grinding was specially developed and ensures a very quiet countersinking procedure and a perfect surface quality, which guarantees the best results. (The new RUnATEC coating increases the quality additionally)

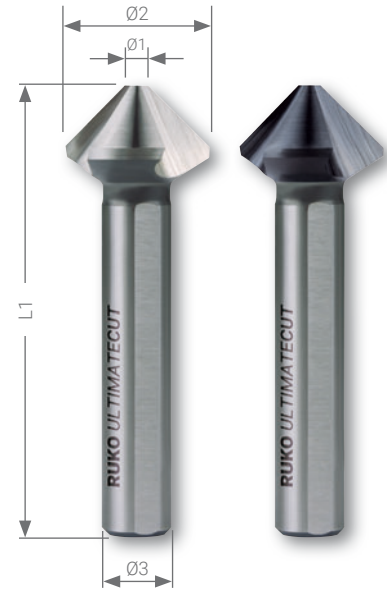




## ULTIMATECUT Taper and deburring countersinker DIN 335 type C 90°

The **ULTIMATECUT** countersink is a high performance tool which stands for best performance: up to 30% time savings, twice as many countersinks as standard tools and excellent, smooth countersinking results in almost all materials.

The specially developed countersink from RUKO achieves this through its unique cutting edge geometry, with the specially developed variably running relief grinding, transition radius and the extra-wide chip flute.



Packing unit: in plastic tubes of 1

- achieves the best performance in almost all materials and applications
- considerably less feed force required
- up to 60% longer service life
- up to 30% faster countersinking
- extremely quiet running
- optimal and smooth surface
- perfect chip removal

Steel (N/mm <sup>2</sup> ) < 900	■	■	■	■
Steel (N/mm <sup>2</sup> ) < 1100		□	■	■
Steel (N/mm <sup>2</sup> ) < 1300			□	■
Rust-resistant steel	□	■	■	■
Aluminium	■	■	■	■

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

Ø2 mm	Ø1 mm	L1 mm	Ø3 mm	Countersinkings as per DIN 74						
6,3	1,5	45,0	5,0	M 3	102 767	102 767 P	102 767 E	102 767 EP	1	
8,3	2,0	50,0	6,0	M 4	102 771	102 771 P	102 771 E	102 771 EP	1	
10,4	2,5	50,0	6,0	M 5	102 774	102 774 P	102 774 E	102 774 EP	1	
12,4	2,8	56,0	8,0	M 6	102 776	102 776 P	102 776 E	102 776 EP	1	
15,0	3,2	60,0	10,0	M 8	102 778	102 778 P	102 778 E	102 778 EP	1	
16,5	3,2	60,0	10,0	M 8	102 779	102 779 P	102 779 E	102 779 EP	1	
19,0	3,5	63,0	10,0	M10	102 780	102 780 P	102 780 E	102 780 EP	1	
20,5	3,5	63,0	10,0	M10	102 781	102 781 P	102 781 E	102 781 EP	1	
23,0	3,8	67,0	10,0	M12	102 782	102 782 P	102 782 E	102 782 EP	1	
25,0	3,8	67,0	10,0	M12	102 783	102 783 P	102 783 E	102 783 EP	1	
31,0	4,2	71,0	12,0	M16	102 785	102 785 P	102 785 E	102 785 EP	1	

## ULTIMATECUT Taper and deburring countersinker sets DIN 335 type C 90° in plastic case

6-piece set of ULTIMATECUT taper and deburring countersinkers (DIN 335) type C 90° Ø 6,3 - 8,3 - 10,4 - 12,4 - 16,5 - 20,5 mm	102 790 RO	102 790 PRO	102 790 ERO	102 790 EPRO
5-piece set of ULTIMATECUT taper and deburring countersinkers (DIN 335) type C 90° Ø 6,3 - 10,4 - 16,5 - 20,5 - 25,0 mm	102 791 RO	102 791 PRO	102 791 ERO	102 791 EPRO