

Pilot pins



Pilot pins are essential for the use of annular cutters as they control the flow of oil, centrate the cutter and make for a smooth slug ejection.

Pilot pins are essential for the use of annular cutters, as they provide the following practical uses:

- **Centration of cutter**
- **Control of oil flow**
- **Slug ejection**

As plain as a pilot pin may look, all of these uses require high-precision and extremely low tolerances – just to make sure

the centre is exactly the centre, oil flow starts and stops when you need it to, and the slug does not get stuck inside the cutter.

We offer a wide range of pilot pins that match the lengths, diameters and characteristics of our various annular cutters with exactly the required precision to enhance your drilling job in the best way possible.

Overview

Code	Length pin	Diameter pin	Code	Length pin	Diameter pin
IBC.70	77 mm (3")	6.35 mm (1/4")	IBC.K25 ¹	127 mm (5")	6.35 mm (1/4")
IBC.70/2	77 mm (3")	6.35 mm (1/4")	IBC.K50 ¹	155 mm (6 1/8")	6.35 mm (1/4")
IBC.75	90 mm (3 9/16")	6.35 mm (1/4")	IBC.K75 ¹	177 mm (7")	6.35 mm (1/4")
IBC.80	103 mm (4 1/16")	8 mm (5/16")	IBC.K100 ¹	204 mm (8")	6.35 mm (1/4")
IBC.85	90 mm (3 9/16")	8 mm (5/16")	IBC.K110 ¹	159 mm (6 1/4")	6.35 mm (1/4")
IBC.90	102 mm (4")	6.35 mm (1/4")	IBC.2P-130 ²	130 mm (5 1/8")	8 mm (5/16")
IBC.100	122 mm (4 13/16")	8 mm (5/16")	IBC.2P-144 ²	145 mm (5 11/16")	8 mm (5/16")
IBC.110	159 mm (6 1/4")	6.35 mm (1/4")	IBC.157 ²	159 mm (6 1/4")	8 mm (5/16")
IBC.120	120 mm (4 3/4")	6.35 mm (1/4")	IBC.2P-168 ²	170 mm (6 11/16")	8 mm (5/16")
IBC.130	165 mm (6 1/2")	8 mm (5/16")	IBC.2P-205 ²	206 mm (8 1/16")	8 mm (5/16")
IBC.140	150 mm (5 15/16")	8 mm (5/16")	IBC.2P-256 ²	258 mm (10 3/16")	8 mm (5/16")
IBC.150	252 mm (9 15/16")	8 mm (5/16")			
IBC.160	201 mm (7 15/16")	8 mm (5/16")			

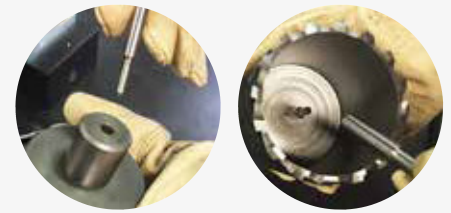
For our IBC.70 and IBC.90 pilot pins we also offer sets:

- 3 x IBC.70 3 x IBC.90
- IBC.70-SET** **IBC.90-SET**

¹ Extended pilot pin

Specifically for use with long cutters and drilling in very thick workpieces. Makes it possible to continue drilling without mid-process replacement. Suitable for use with longer cutters as from 75 mm (3").

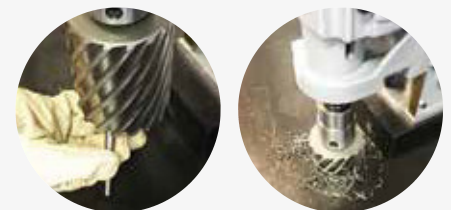
² two-piece pilot pin



Place pilot pin through the shank, and attach extension through the bottom inside of the cutter.



Start drilling. Stop at approx. 50 mm depth.



Remove the extension.

Commence drilling until slug ejection.

Pilot pin features

Precise positioning

- Whilst having a perfect fit the Euroboor pilot pin is your guidance to centre the cutter.



Material

Oil flow regulation

- In standstill position with the cutter above the workpiece, the pilot pin prevents the oil from flowing.
- When moving down the cutter with the pilot pin onto the workpiece to commence drilling, the pilot pin is pushed up into the arbor and permits the oil to flow into the cutter for direct cooling and lubricating.



Material

Slug ejection

- When the cutter is through the material, the pilot pin pushes the slug out of the workpiece by means of the strong spring inside the arbor.
- Consequently the oil flow is automatically cut off.



Material

Pilot pin recommendations



HSS metric - 30 mm

HCS (DoC 30 mm)	
Ø 12 - 60 mm IBC.70 (6.35 x 77 mm)	Ø 61 - 100 mm IBC.80 (8.00 x 103 mm)
HCSU (DoC 30 mm)	
Ø 12 - 60 mm IBC.70 (6.35 x 77 mm)	

HSS metric - 55 mm

HCL (DoC 55 mm)	
Ø 12 - 60 mm IBC.90 (6.35 x 102 mm)	Ø 61 - 100 mm IBC.100 (8.00 x 122 mm) IBC.2P-130 (8.00 x 130 mm)
HCLU (DoC 55 mm)	
Ø 12 - 60 mm IBC.90 (6.35 x 102 mm)	

HSS metric - 75 & 100 mm

HCY (DoC 75 mm)	HCX (DoC 100 mm)
Ø 14 - 50 mm IBC.K25 (6.35 x 127 mm)	Ø 18 - 50 mm IBC.K50 (6.35 x 155 mm)

HSS imperial - 1"

HCS (DoC 1")	
Ø 7/16" - 2 5/16" IBC.70 (6.35 x 77 mm)	Ø 2 3/8" - 4" IBC.80 (8.00 x 103 mm)

HSS imperial - 2"

HCL (DoC 2")	
Ø 7/16" - 2 5/16" IBC.90 (6.35 x 102 mm)	Ø 2 3/8" - 4" IBC.100 (8.00 x 122 mm) IBC.2P-130 (8.00 x 130 mm)
HCLU (DoC 2")	
Ø 7/16" - 2 5/16" IBC.90 (6.35 x 102 mm)	

HSS Stack metric - 55 & 75 mm

HCPL (DoC 55 mm)	HCPY (DoC 75 mm)
Ø 18 - 32 mm IBC.90 (6.35 x 102 mm)	Ø 18 - 32 mm IBC.K25 (6.35 x 127 mm)

HSS Stack imperial - 2" & 3"

HCPL (DoC 2")	HCPY (DoC 3")
Ø 11/16" - 1 1/4" IBC.90 (6.35 x 102 mm)	Ø 11/16" - 1 1/4" IBC.K25 (6.35 x 127 mm)

HSS-Cobalt metric - 30 mm

IBS (DoC 30mm)
Ø 12 - 60 mm IBC.70 (6.35 x 77 mm)

HSS-Cobalt metric - 55 mm

IBL (DoC 55 mm)
Ø 12 - 60 mm IBC.90 (6.35 x 102 mm)

HSS-Cobalt imperial - 1"

IBS (DoC 1")
Ø 7/16" - 2 5/16" IBC.70 (6.35 x 77 mm)

HSS-Cobalt imperial - 2"

IBL (DoC 2")
Ø 7/16" - 2 5/16" IBC.90 (6.35 x 102 mm)

HSS-Cobalt imperial - 3"

IBY (DoC 3")
Ø 7/16" - 2 5/16" IBC.K25 (6.35 x 127 mm)



TCT metric - 35 mm

HMS (DoC 35 mm)	
Ø 12 - 17 mm	Ø 18 - 100 mm
IBC.75 (6.35 x 90 mm)	IBC.80 (8.00 x 103 mm)
HMSU (DoC 35 mm)	
Ø 12 - 17 mm	Ø 18 - 60 mm
IBC.75 (6.35 x 90 mm)	IBC.80 (8.00 x 103 mm)

TCT metric - 55 mm

HML (DoC 55 mm)	
Ø 12 - 17 mm	Ø 61 - 200 mm
IBC.90 (6.35 x 102 mm)	IBC.100 (8.00 x 122 mm)
Ø 18 - 60 mm	IBC.2P-144 (8.00 x 145 mm)
IBC.80 (8.00 x 103 mm)	
HMLU (DoC 55 mm)	
Ø 12 - 17 mm	Ø 18 - 60 mm
IBC.90 (6.35 x 102 mm)	IBC.80 (8.00 x 103 mm)

TCT metric - 75 & 100 mm

HMV (DoC 75 mm)	HMX (DoC 100 mm)
Ø 12 - 17 mm	Ø 12 - 17 mm
IBC.K25 (6.35 x 127 mm)	IBC.110 (6.35 x 159 mm)
Ø 18 - 50 mm	Ø 18 - 200 mm
IBC.140 (8.00 x 150 mm)	IBC.130 (8.00 x 165 mm)
IBC.157 (8.00 x 159 mm)	IBC.2P-168 (8.00 x 170 mm)

TCT metric - 150 & 200 mm

HMW (DoC 150 mm)	HMV (DoC 200 mm)
Ø 22 - 200 mm	Ø 22 - 200 mm
IBC.160 (8.00 x 201 mm)	IBC.150 (8.00 x 252 mm)
IBC.2P-205 (8.00 x 206 mm)	IBC.2P-256 (8.00 x 258 mm)

TCT imperial - 1"

HMS (DoC 1")	
Ø 7/16" - 11/16"	3/4" - 4"
IBC.75 (6.35 x 90 mm)	IBC.80 (8.00 x 103 mm)
HMSU (DoC 1")	
Ø 7/16" - 11/16"	Ø 3/4" - 2 5/16"
IBC.75 (6.35 x 90 mm)	IBC.80 (8.00 x 103 mm)

TCT imperial - 2"

HML (DoC 2")	
Ø 7/16" - 11/16"	Ø 2 3/8" - 8"
IBC.90 (6.35 x 102 mm)	IBC.100 (8.00 x 122 mm)
3/4" - 2 5/16"	IBC.2P-144 (8.00 x 145 mm)
IBC.80 (8.00 x 103 mm)	
HMLU (DoC 2")	
7/16" - 11/16"	
IBC.90 (6.35 x 102 mm)	
3/4" - 2 15/16"	
IBC.80 (8.00 x 103 mm)	

TCT imperial - 3" & 4"

HMV (DoC 3")	HMX (DoC 4")
Ø 7/16" - 11/16"	Ø 7/16" - 11/16"
IBC.K25 (6.35 x 127 mm)	IBC.110 (6.35 x 159 mm)
Ø 3/4" - 3"	Ø 3/4" - 8"
IBC.140 (8.00 x 150 mm)	IBC.130 (8.00 x 165 mm)
IBC.157 (8.00 x 159 mm)	IBC.2P-168 (8.00 x 170 mm)

TCT imperial - 6" & 8"

HMW (DoC 6")	HMV (DoC 8")
Ø 7/8" - 8"	Ø 7/8" - 8"
IBC.160 (8.00 x 201 mm)	IBC.150 (8.00 x 252 mm)
IBC.2P-205 (8.00 x 206 mm)	IBC.2P-256 (8.00 x 258 mm)

TCT Rail metric - 25 & 35 mm

TRCS (DoC 25 mm)	TRCS (DoC 35 mm)
Ø 17 - 36 mm	Ø 17 - 36 mm
IBC.70 (6.35 x 77 mm)	IBC.75 (6.35 x 90 mm)