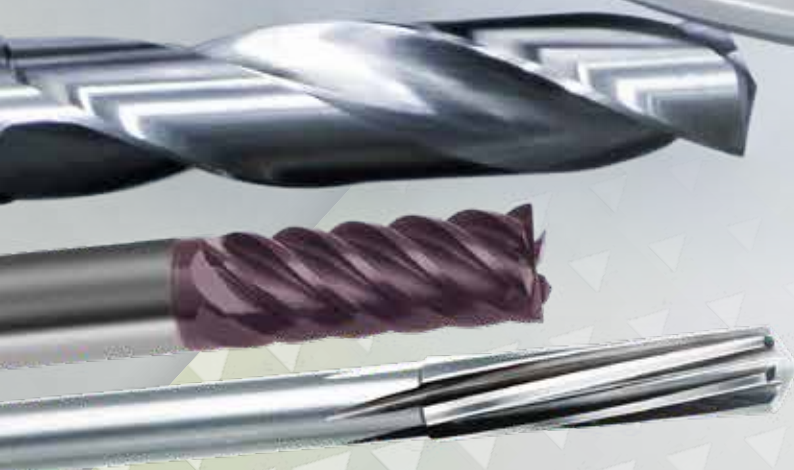




# HARTNER

Precision Cutting Tools



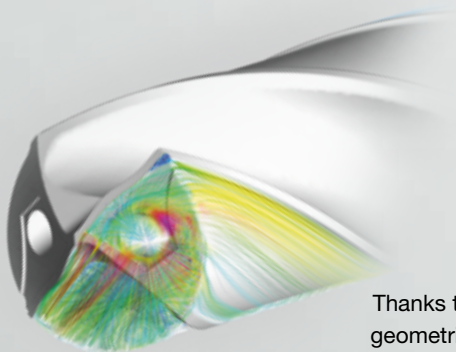
**RE-GRINDING AND  
RE-COATING SERVICE**

Price List 2022

# Maximum economic efficiency thanks to refurbishing to original quality

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Even the most resilient tool will wear at some time when heavily stressed.  
Thanks to refurbishing to original geometries and coatings Hartner succeeds  
in re-producing the original performance of your tools.



## Service with manufacturer's know-how

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Thanks to our comprehensive expertise in the development of cutting materials, geometries and coatings, we have know-how in all fields relevant for tool manufacturing. And thus also in the field of re-conditioning of cutting tools. Globally uniform standards in production and service promise stable quality parameters for your tools.



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## Re-grinding | HSS drills

### BASIC PRICES for re-grinding HSS drills

	Twist drills	NC spotting drills	Centre drills	Core drills Z3
Diameter range	€ / piece	€ / piece	€ / piece	€ / piece
8 - 10	6.30	8.25	9.55	8.00
> 10 - 12	7.15	9.40	10.75	9.15
> 12 - 14	7.90	10.35	11.95	10.10
> 14 - 16	8.35	10.75	12.80	10.80
> 16 - 18	12.25	15.65	on request	15.75
> 18 - 20	14.15	17.70	on request	18.15
> 20 - 30	17.90	19.80	on request	22.90
> 30 - 40	24.60	on request	on request	31.55
> 40 - 50	32.50	on request	on request	42.60
> 50 - 60	40.70	on request	on request	52.20
> 60 - 80	48.30	on request	on request	on request
> 80 - 100	60.35	on request	on request	on request
> 100 - 120	72.10	on request	on request	on request

All prices refer to bright finish tools. For coating, pre- and post-treatment see prices page 12.  
Please observe our minimum order value of € 50.00.

Scope of service and re-grind prices for HSS twist drills to DIN 338, 340, 341, 345, 346, 1869, 1870 and 1897 as well as special designs. If not otherwise requested we manufacture the relieved cone point geometry to DIN with web thinning form A. Other point geometries are of course possible for an additional charge.

Prices apply to standard wear. We reserve the right of assessment of existing wear features. Crumbling and very heavy wear will be invoiced at cost. Inscriptions, marking, special labelling, measuring protocols etc. involves greater expenditure and effort and is also invoiced at cost.

### + SURCHARGE protection chamfer, special point geometries or stepped tools

	Step drill 1st countersinking step	each additional countersinking step	Protection chamfer (for cast iron)	Centre and M point
Diameter range	€ / piece	€ / piece	€ / piece	€ / piece
8 - 10	6.90	6.30	2.30	9.05
> 10 - 12	7.85	7.20	2.80	10.10
> 12 - 14	8.55	7.95	2.80	10.55
> 14 - 16	9.40	8.50	2.80	10.55
> 16 - 18	13.70	12.60	3.90	13.00
> 18 - 20	15.65	14.50	3.90	13.00
> 20 - 30	20.20	18.65	4.25	16.30
> 30 - 40	28.25	26.15	4.45	17.90
> 40 - 50	35.80	33.25	5.20	19.80
> 50 - 60	45.10	43.15	5.85	21.70
> 60 - 80	54.10	51.80	6.65	23.90
> 80 - 100	65.05	64.15	7.85	26.40

Scope of service and re-grind prices for step drills with relieved cone point geometry and web thinning form A to DIN 8374, 8375, 8376, 8377 8378 and 8379 as well as special designs. If not requested otherwise we manufacture the relieved cone point geometry to DIN with web thinning form A. Other point geometries are of course possible for an additional charge.

Prices apply to standard wear. We reserve the right of assessment of existing wear features. Crumbling and very heavy wear will be invoiced at cost.

Prices refer to tools with one step. For each additional step we apply a surcharge.



## Re-grinding | Solid carbide drills

### BASIC PRICES for re-grinding solid carbide drills\*

	Solid carbide drills up to 12xD	Solid carbide NC spotting drills	Solid carbide radius drills TS 100 R	Solid carbide deep hole drills TS 100 T up to 40xD
Diameter range	€ / piece	€ / piece	€ / piece	€ / piece
up to 6	14.35	9.75	22.10	39.95
> 6 - 8	15.20	10.70	23.60	53.60
> 8 - 10	16.10	11.55	24.75	57.45
> 10 - 12	19.45	14.05	30.20	61.55
> 12 - 14	25.30	18.45	36.75	66.15
> 14 - 16	27.05	19.90	40.05	72.10
> 16 - 18	28.75	20.75	46.45	-
> 18 - 20	30.50	21.30	49.50	-
> 20 - 30	37.40	-	-	-

All prices refer to bright finish tools. For coating, pre- and post-treatment see prices page 12.  
Please observe our minimum order value of € 50.00.

Scope of service and re-grind prices for solid carbide drills to DIN, TS-Drills TS 100 U, TS 100 H, TS 80 U, TS 100 INOX, TS 150 GG, TS 3 G, TS 100 Alu and solid carbide twist drills as well as similar tools. Other point geometries are of course possible for an additional charge.

Prices apply to standard wear. We reserve the right of assessment of existing wear features. Crumbling and very heavy wear will be invoiced at cost. Customer specific inscriptions, marking, special labelling, measuring protocols etc. involves greater expenditure and effort and is also invoiced at cost.

\* axial metal removal max. 1 mm, the diameter is reduced depending on the back-taper value.  
Please specify the minimum lengths and Ø tolerances in the order.

### + SURCHARGE protection chamfer or stepped tools

	Step drill 1st countersinking step	each additional countersinking step	Protection chamfer (for cast iron)	Centre and M point
Diameter range	€ / piece	€ / piece	€ / piece	€ / piece
up to 6	13.60	12.90	3.40	13.90
> 6 - 8	15.00	14.15	4.40	15.55
> 8 - 10	16.00	15.20	4.40	15.55
> 10 - 12	19.10	18.45	4.40	15.55
> 12 - 14	25.10	23.90	5.95	19.00
> 14 - 16	25.30	24.50	5.95	19.00
> 16 - 18	27.25	26.45	6.40	23.80
> 18 - 20	28.75	27.85	6.85	on request
> 20 - 30	36.25	34.30	7.95	on request

Scope of service and re-grind prices for step drills type TS 80, TS 100 U, TS 150 GG and TS 3 G as well as similar tools.

Other point geometries are of course possible for an additional charge.

Prices apply to standard wear. We reserve the right of assessment of existing wear features.

Crumbling and very heavy wear will be invoiced at cost.

Prices refer to tools with one step. For each additional step we apply a surcharge.

## Re-grinding | Multiplex inserts

### BASIC PRICES for re-grinding Multiplex inserts

	Multiplex interchangeable inserts HSS-E/HSS-E-PM	Multiplex interchangeable inserts Solid carbide	Multiplex HPC interchangeable inserts Solid carbide
Diameter range	€/ piece	€/ piece	€/ piece
> 10 - 12	17.10	24.40	auf Anfrage
> 12 - 14	18.95	29.75	32.95
> 14 - 16	19.70	32.05	35.15
> 16 - 18	21.15	34.30	37.40
> 18 - 20	21.50	36.55	39.70
> 20 - 30	22.95	46.05	48.65
> 30 - 40	23.85	53.50	56.05
> 40 - 50	27.15	on request	-
> 50 - 60	34.40	on request	-
> 60 - 80	42.30	on request	-
> 80 - 100	53.85	-	-
> 100 - 120	on request	-	-

All prices refer to bright finish tools. For coating, pre- and post-treatment see prices page 12.

The re-conditioning service for Multiplex inserts includes the web thinning at the point and the grinding of clearance angle, flute, chamfer for cast materials and chip breakers if applicable. Please note that repairing of the multiplex inserts can lead to a reduction in diameter.

The maximum limit is defined as 0.2 mm. If this is not sufficient due to wear characteristics, the corner chamfer is enlarged if possible.

Otherwise, the multiplex inserts are marked as rejects.

Customer specific inscription, marking, special labels, measuring protocol etc. is connected with extra expense and charged for at cost.

### + SURCHARGE Radius or corner chamfer

	Radius	Corner chamfer
Diameter range	€/ piece	€/ piece
> 10 - 12	2.55	2.55
> 12 - 14	2.55	2.55
> 14 - 16	2.55	2.55
> 16 - 18	2.55	2.55
> 18 - 20	2.55	2.55
> 20 - 30	2.55	2.55
> 30 - 40	2.55	2.55
> 40 - 50	2.55	2.55
> 50 - 60	2.55	2.55
> 60 - 80	2.55	2.55
> 80 - 100	2.55	2.55
> 100 - 120	on request	on request

## Re-grinding | Gun drills

### BASIC PRICES for re-grinding carbide-tipped gun drills and solid carbide gun drills

	Single-fluted carbide-tipped gun drills E 80	Two-fluted carbide tipped gun drills Z 80	Solid carbide single-fluted gun drills E 100
Diameter range	€/ piece	€/ piece	€/ piece
up to 2	-	-	19.00
> 2 - 6	17.30	19.00	19.00
> 6 - 10	18.45	27.50	20.75
> 10 - 14	21.30	36.00	25.85
> 14 - 18	21.80	43.15	29.35
> 18 - 22	25.85	47.65	on request
> 22 - 26	29.90	on request	on request
> 26 - 30	36.85	on request	on request
> 30 - 40	on request	on request	on request

All prices refer to bright finish tools. For coating, pre- and post-treatment see prices page 12.  
Please observe our minimum order value of € 50.00.

Extra expense for aligning the gun drill is invoiced at cost. Customer specific inscription, marking, special labels, measuring protocol etc.  
is connected with extra expense and charged for at cost.

## Re-grinding | Countersinks

### BASIC PRICES for re-grinding countersinks

	HSS / HSCO countersinks	Solid carbide countersinks*	HSS counterbores / pilot counterbores	Sol.carbide counterbores* / pilot counterbores
Diameter range	€ / piece	€ / piece	€ / piece	€ / piece
up to 6	8.15	13.10	10.10	14.60
> 6 - 8	8.85	14.10	10.80	15.70
> 8 - 10	9.60	15.20	11.65	16.95
> 10 - 12	10.40	16.35	12.50	18.15
> 12 - 14	11.40	17.70	13.50	19.60
> 14 - 16	12.25	19.10	14.55	21.10
> 16 - 18	13.35	20.40	15.70	22.65
> 18 - 20	14.40	21.75	17.10	24.40
> 20 - 30	22.45	34.20	24.15	37.30
> 30 - 40	27.60	42.45	29.65	45.90
> 40 - 50	36.35	55.05	39.45	61.05
> 50 - 60	41.40	on request	44.65	on request
> 60 - 70	47.75	on request	51.45	on request
> 70 - 80	52.95	on request	57.00	on request
> 80 - 90	on request	on request	on request	on request
> 90 - 100	on request	on request	on request	on request

All prices refer to bright finish tools. For coating, pre- and post-treatment see prices page 12.  
Please observe our minimum order value of € 50.00.

Prices apply to standard wear. We reserve the right of assessment of existing wear features. Crumbling and very heavy wear will be invoiced at cost.  
Customer specific inscriptions, marking, special labelling, measuring protocols etc. involves greater expenditure and effort and is also invoiced at cost.

\* axial metal removal max. 1 mm, the diameter is reduced depending on the back-taper value.  
Please specify minimum lengths and Ø-tolerances on order.

### + SURCHARGE for special forms

	from 4 cutting edges
Diameter range	€ / piece
up to 6	3.80
> 6 - 8	3.80
> 8 - 10	3.80
> 10 - 12	4.00
> 12 - 14	4.25
> 14 - 16	4.45
> 16 - 18	4.80
> 18 - 20	5.35
> 20 - 30	6.10
> 30 - 40	7.05
> 40 - 50	9.65
> 50 - 60	10.95
> 60 - 70	13.35
> 70 - 80	15.35
> 80 - 90	16.30
> 90 - 100	17.60



## Re-grinding | Reamers

### BASIC PRICES for re-grinding reamers

	HSS reamers	Solid carbide reamers*	Solid carbide high-performance reamers TR 300 HP*
Diameter range	€ / piece	€ / piece	€ / piece
up to 6	18.55	25.10	37.40
> 6 - 8	18.55	25.10	39.75
> 8 - 10	18.55	25.10	40.95
> 10 - 12	19.65	26.45	42.05
> 12 - 14	20.20	27.35	42.70
> 14 - 16	20.85	28.20	43.85
> 16 - 18	21.45	28.90	44.25
> 18 - 20	22.05	29.70	45.00
> 20 - 30	26.45	35.70	54.20
> 30 - 40	27.15	36.85	59.25
> 40 - 50	36.85	49.75	on request
> 50 - 60	44.75	60.25	on request
> 60 - 80	56.35	76.35	on request

All prices refer to bright finish tools. For coating, pre- and post-treatment see prices page 12.  
 All coated reamers receive a standard de-coating. Please see our de-coating prices on page 12.  
 The diameter of all reamers is checked during the refurbishment process.

Please observe our minimum order value of € 50.00.

Prices apply to standard wear. We reserve the right of assessment of existing wear features. Crumbling and very heavy wear will be invoiced at cost.  
 Customer specific inscriptions, marking, special labelling, measuring protocols etc. involves greater expenditure and effort and is also invoiced at cost.

\* Axial metal removal max. 1 mm. Always face ground on CNC machines.

## Re-grinding | Taps and thread milling cutters

### BASIC PRICES for re-grinding machine taps and solid carbide thread milling cutters

	HSS / HSS-E taps	Carbide / Solid Carbide taps
Diameter range	€ / piece	€ / piece
up to 10	11.45	13.60
> 10 - 14	15.55	15.55
> 14 - 20	18.65	19.60
> 20 - 24	23.25	25.10
> 24 - 30	25.65	29.15
> 30 - 36	34.40	37.65
> 36 - 40	36.85	42.45
> 40 - 70	on request	on request

All prices refer to bright finish tools. For coating, pre- and post-treatment see prices page 12.  
Please observe our minimum order value of € 50.00.

Prices apply to standard wear. We reserve the right of assessment of existing wear features. Crumbling and very heavy wear will be invoiced at cost.  
Customer specific inscriptions, marking, special labelling, measuring protocols etc. involves greater expenditure and effort and is also invoiced at cost.

## Re-grinding | Solid carbide milling cutters

### BASIC PRICES for re-grinding solid carbide milling cutters

	Solid carbide end mills with up to 4 flutes	Solid carbide end mills TF 100 with up to 4 flutes	Solid carbide end mills TF 100 MULTI-MILL/MASTER-MILL	Solid carbide ball nose milling cutters	Solid carbide cham- fering milling cutters
Diameter range	€ / piece	€ / piece	€ / piece	€ / piece	€ / piece
6 - 8	10.85	14.70	18.15	21.30	14.10
> 8 - 10	13.10	17.80	21.75	22.45	15.20
> 10 - 12	17.30	22.90	27.40	23.60	16.35
> 12 - 14	18.75	25.10	29.55	28.75	17.70
> 14 - 16	20.40	27.25	32.40	28.75	19.10
> 16 - 18	22.10	29.65	34.90	38.00	20.40
> 18 - 20	23.60	31.65	38.00	38.00	21.75
> 20 - 25	34.40	45.90	55.10	43.15	on request
> 25 - 40	39.75	52.30	on request	48.90	on request

All prices refer to bright finish tools. For coating, pre- and post-treatment see prices page 12.  
Please observe our minimum order value of € 50.00.

Prices apply to standard wear. We reserve the right of assessment of existing wear features. Crumbling and very heavy wear will be invoiced at cost.  
Customer specific inscriptions, marking, special labelling, measuring protocols etc. involves greater expenditure and effort and is also invoiced at cost.

### + SURCHARGE for special dimensions, special forms, radii

	from 5 flutes	Roughing cutters	Corner radius per flute	Neck clearance
Diameter range	€ / piece	€ / piece	€ / piece	€ / piece
6 - 8	2.50	4.55	1.30	5.20
> 8 - 10	3.20	4.55	1.50	5.20
> 10 - 12	4.00	4.55	1.95	5.20
> 12 - 14	4.95	4.55	2.40	5.20
> 14 - 16	5.95	4.70	2.60	5.20
> 16 - 18	6.30	4.70	2.80	5.20
> 18 - 20	6.65	4.70	2.80	5.20
> 20 - 25	7.30	5.20	3.15	5.20
> 25 - 40	13.25	5.20	-	-

#### Please pay attention to:

Services for re-grinding solid carbide milling cutters

- flute geometry is not re-qualified. Re-qualification is carried out on request, invoiced at cost.
- Finishing cutters = grinding of fluting, face and diameter
- Roughing cutters = grinding of fluting and face
- Ball nose milling cutters = grinding of ball nose, not diameter, diameter on request, invoiced at cost.

See table for minimum diameter for tools (with straight face and corner radius):

Nominal diameter	Finishing cutters (smooth cutting)		Roughing cutters (knuckle-type)	
	minimum diameter (mm)		(others-) minimal width of body clearance (mm)	
	2 to 10 teeth	max. metal removal per side	3 to 5 teeth	6 to 8 teeth
6	5.3	0.35	1.0	0.8
8	7.1	0.45	1.0	0.8
10	8.9	0.55	1.5	1.2
12	10.7	0.65	1.5	1.2
14	12.5	0.75	2.0	1.6
16	14.2	0.90	2.0	1.6
18	16.0	1.00	3.0	2.0
20	17.8	1.10	3.0	2.0
25	22.3	1.35	4.0	3.0
30	26.7	1.65	5.0	4.0
32	28.5	1.75	5.0	4.0

## Re-coating

### + SURCHARGE for pre- and post-treatment

	De-coating	Polishing
Diameter range	€/ piece	€/ piece
up to 6	3.80	5.20
> 6 - 8	3.80	5.20
> 8 - 10	3.80	5.20
> 10 - 12	3.80	5.75
> 12 - 14	5.50	6.30
> 14 - 16	5.50	6.90
> 16 - 18	5.50	9.25
> 18 - 20	5.50	9.75
> 20 - 30	5.50	11.55
> 30 - 40	5.50	15.75
> 40 - 50	5.75	16.70
> 50 - 60	on request	on request
> 60 - 80	on request	on request
> 80 - 100	on request	on request

De-coating of extra length tools is invoiced at cost.

### + SURCHARGE for coating

	Standard coatings *	Special coatings **	Head coating up to 12xD ***	Head coating up to 20xD ***	Head coating up to 40xD ***
Diameter range	€/ piece	€/ piece	€/ piece	€/ piece	€/ piece
up to 6	5.35	9.25	9.55	14.30	18.60
> 6 - 8	5.35	9.25	9.55	14.30	18.60
> 8 - 10	5.35	9.25	9.55	14.30	18.60
> 10 - 12	6.10	10.55	11.05	16.55	20.00
> 12 - 14	6.80	11.75	12.25	18.50	21.25
> 14 - 16	7.30	12.70	13.25	19.85	22.15
> 16 - 18	9.85	17.05	17.80	26.75	26.65
> 18 - 20	10.65	18.45	19.20	28.85	27.95
> 20 - 30	12.90	22.35	-	-	-
> 30 - 40	13.60	23.90	-	-	-
> 40 - 50	14.85	on request	-	-	-
> 50 - 60	on request	on request	-	-	-
> 60 - 80	on request	on request	-	-	-
> 80 - 100	on request	on request	-	-	-

\* TiN, TiCN, TiAlN, FIRE, AlTiN, AlTiN nano

\*\* TiAlSiN, AlTiZrN, TiSiN

\*\*\* TiN, TiCN, TiAlN, FIRE, TiAlSiN

Differing coatings on request.

Coating of extra length tools is invoiced at cost.

Head coatings larger than 40xD is invoiced at cost.

Tools re-coated without prior de-coating have a larger diameter.

Please observe our minimum order value of € 50.00.

## Repair service for hydraulic expansion chucks

### REPAIR SERVICE for hydraulic expansion chucks

Description	Article no.	Repair/calibration	Recommendation	€ / piece
Hydraulic chucks	all	Clamping function Hartner product or comparable products		86.30
		Clamping function and length setting Hartner product	with loss of clamping force	138.15
		or comparable products		
Clamping force measuring instrument	89780	Calibration	Once a year inspection / calibration	250.30
		Repairs (quote at cost)		

Please observe our minimum order value of € 50.00.









# HARTNER

Precision Cutting Tools

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