

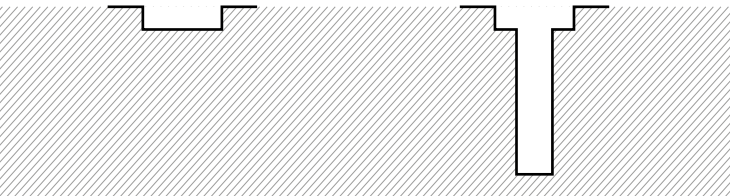
A Practical Guide to perfect processing

Expert tip:

Always use carbide-tipped tools and follow the recommended parameters – this will help you avoid damage to the material and achieve the best results!

Step 1. Lower

Step 2. Drilling



WHAT TOOLS?

Always the right tool - available to order from **KRAIBURG STRAIL** too



Lower order no. 02352200

- Forstner drill bit
- Countersink Ø 23 mm, depth 20–30 mm
- Carry this out **BEFORE** drilling!

Drill bit order no. 02352300

- HSS drill bits recommended
- Ø 19.5 mm for SS8 screws

Repair set order no. 02677800

- EBA – Approved repair kit from KRAIBURG STRAIL
- ~50 ml per standard hole (Ø 19.5 / 150 mm deep)

Cutting

Widia saw blade or carbide saw chain

Please refer to the user manuals for detailed technical specifications.

FREE WORKSHOP ON-SITE!

Learn from our experts right on site.

- Hands-on demonstration of all processing steps
- Tool expertise right on your doorstep
- Your questions – our answers
- For your entire team

Book a workshop now:

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PROCESSING-GUIDE FOR THE CONSTRUCTION SITE

Professional processing.
Maximum precision.

Your Practical Guide to Perfect Results

RECOMMENDATIONS FOR USE

Feeds & Speeds

Processing	Feed	Rotational speed
Drilling	900 mm/min	700 U/min
Milling	4.000 mm/min	3.000 U/min

Important information

- Ensure adequate ventilation of the drill hole
Ventilate each drill hole 1–2 times
- Remove chips regularly; chips and machining waste can be disposed of in the yellow bin
- Take cooling breaks during continuous drilling
- Apply moderate pressure to prevent material deformation

THAT WON'T WORK!

Dont's – Please avoid

- Wood drill bits – use carbide-tipped bits only!
- Rail nails (wooden pins, expansion nails, spikes) – not permitted!
- Excessive down pressure
 - leads to a blunt tool
 - material deformation



DRILL HOLES & FASTENING

Recommended borehole diameters

Screw type	Drilled hole + countersink	Tightening torque
SS8	Ø 19,5 mm Ø 23 mm	500 Nm
FV 23/135	16/23 mm (konisch)	220-270 Nm
FV 21/135	16/22 mm (konisch)	350-400 Nm

Rule of thumb

Drill hole diameter = inner diameter of screw + 3,5 mm

Keep your distance!

- Minimum distance from the edge of the threshold: 30 mm
- Minimum distance from the cut edge: 80 mm
- Failure to comply may result in material spalling!

Note

In our experience, a drill bit or countersink lasts for between 80 and 150 holes.



VIDEOS & HANDBOOK

Experience the editing process live!

Book a workshop or visit our YouTube channel for step-by-step guides:

STRAILWAY on YouTube:

- Drilling, step by step
- Milling & planing in practice
- Repair methods in detail
- Expert tips straight from the factory

Complete User Manual

Full details on safety, materials and permitted machining operations:

- Complete safety instructions
- Material properties & fire classes
- Permissible processing limits
- Storage, transport & markings

Download: www.strail.com

