DRILLING TOOLS

YG-1 CO., LTD.

Contents

DRILLING TOOLS

YG-1 CO., LTD.

Contents / DRILLING TOOLS

DRILLING TOOLS **APPLICATION TABLE**

	ITEM	MODEL	DESCRIPTION	SIZE		PAGE
				MIN	MAX	
i-Dream Drills	Y03 *		Insert for General Purpose	.4724 (#A)	1.2500 (#J)	**44~49**
	YI3 *		Insert for Stainless Steels	.4724 (#A)	1.2500 (#J)	**44~49**
Spade Drills	S01~S08		HSS M4 Insert	.7031 (#1)	4.5000 (#8)	**242~245**
	S06~S08 (SM08)		Super Cobalt T15 Insert	.3740 (#Y)	4.5000 (#8)	**246~252 262~265**
	S11~S14		Primium cobalt M48 Insert	.3740 (#Y)	1.3780 (#2)	**253~255**
	S21~S23		Carbide C2, C5, C3 Insert	.3740 (#Y)	1.8750 (#3)	**256~260**
	S26~S28 (SM28)		Carbide C5 Insert (P40)	.3740 (#Y)	1.8750 (#3)	**256~260 266~267**
	S16~S18		Carbide C3 Insert (K10)	.3740 (#Y)	1.3780 (#2)	**256~260**
	SF05 SF15		Super Cobalt T15 Flat Bottom	.3750 (#Y)	1.3750 (#2)	**268**

◎ : Excellent ○ : Good

P												M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys	
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎			
○	○		○				○		○		◎			○	○	
○	○	○	○		○		○	○			◎	◎	○	◎	◎	
◎	◎	◎	◎	◎	○	○	◎	◎	○	○	○	○	◎	○	○	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	○	○	
○	○	○	○	○	◎	◎	○	○	○	○	◎	○	○	◎	◎	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	
												◎	◎			
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○	

DRILLING TOOLS **APPLICATION TABLE**

	ITEM	MODEL	INCH / METRIC	LENGTH	SIZE		PAGE
					MIN	MAX	
DREAM DRILLS-GENERAL	DH414		Inch	Stub(3XD)	D1/8	D5/8	**58**
	DH722		Inch	Long(5XD)	D13/64	D1/2	**59**
	DH416 DH711		Inch	Short(3XD)	D1/8	D5/8	**60**
	DH418 DH712		Inch	Long(5XD)	D13/64	D1/2	**62**
	DH404		Metric	Stub(3XD)	D3.0	D20.0	**63**
	DH423		Metric	Short(3XD)	D3.0	D20.0	**65**
	DH424		Metric	Long(5XD)	D1.0	D20.0	**68**
	DH406		Metric	Short(3XD)	D3.0	D20.0	**71**
	DH408		Metric	Long(5XD)	D1.0	D20.0	**74**
	DH421		Metric	Extra Long(8XD)	D3.0	D14.0	**77**
DREAM DRILLS-HIGH FEED	DGR493		Inch	Short(3XD)	D.1969	D.7874	**86**
	DGR495		Inch	Long(5XD)	D.1969	D.7874	**89**
DREAM DRILLS-INOX	DH463 DH714		Inch	Stub(3XD)	D1/8	D5/8	**96**
	DH464 DH715		Inch	Long(5XD)	D13/64	D1/2	**98**
	DH451		Metric	Short(3XD)	D3.0	D20.0	**99**
	DH452		Metric	Long(5XD)	D1.0	D20.0	**102**
	DH453		Metric	Extra Long(8XD)	D3.0	D14.0	**105**
DREAM DRILLS-ALU	DGE466 DGE718		Inch	Long(5XD)	D13/64	D1/2	**112**
	DGE433		Metric	Long(5XD)	D3.0	D20.0	**113**
DREAM DRILLS-CFRP	DI473		Inch	-	D.0980	D.7500	**120**
DREAM DRILLS-MQL TYPE	DH510		Metric	Extra Long(10XD)	D3.0	D14.0	**126**
	DH515		Metric	Extra Long(15XD)	D3.0	D12.0	**127**
	DH520		Metric	Extra Long(20XD)	D3.0	D12.0	**127**
	DHM10		Metric	Extra Long(10XD)	D3.0	D14.0	**128**
	DHM15		Metric	Extra Long(15XD)	D3.0	D12.0	**128**
	DHM20		Metric	Extra Long(20XD)	D3.0	D12.0	**128**
	DHM25		Metric	Extra Long(25XD)	D3.0	D10.0	**129**
	DHM30		Metric	Extra Long(30XD)	D3.0	D8.0	**129**

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					
○	◎	◎				○	○					
○	◎	◎				○	○					
○	◎	◎				○	○					
○	◎	◎				○	○					
○	◎	◎				○	○					
○	◎	◎				○	○					
○	◎	◎				○	○					
○	◎	◎				○	○					
○	◎	◎				○	○					
◎	◎	○					◎	○				
◎	◎	○					◎	○				
◎	◎	○				◎		○				○
◎	◎	○				◎		○				○
◎	◎	○				◎		○				○
◎	◎	○				◎		○				○
◎	◎	○				◎		○				○
								◎				
								◎				
											◎	
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					

DRILLING TOOLS **APPLICATION TABLE**

	ITEM	MODEL	INCH / METRIC	LENGTH	SIZE		PAGE
					MIN	MAX	
DREAM DRILLS For HIGH HARDENED STEELS	DH501		Inch	-	D1/8	D3/4	**134**
	DH500		Metric	-	D1.0	D14.0	**136**
STANDARD CARBIDE DRILLS	D5412		Metric	Jobber	#56	#1	**142**
	D5413		Inch	Jobber	A	Z	**143**
	D5417		Inch	Jobber	D3/64	D1/2	**144**
MULTI-1 DRILLS	CDR405		Inch	-	D3/32	D1/2	**150**
	CDR406		Inch	-	#45	#1	**151**
	CDR407		Inch	-	B	Z	**152**
HPD DRILLS	DJ543		Metric	Stub	D2.0	D13.0	**158**
	DJ544		Metric	Jobber	D2.0	D20.0	**160**
GOLD-P DRILLS	D1GP182 D8182		Inch	Jobber	D3/64	D3/4	**168**
	D1GP139		Inch	Jobber	A	Z	**169**
	D1GP138		Inch	Jobber	#56	#1	**170**
	D2GP185		Inch	Jobber	D3/64	D1/2	**171**
	D2GP186		Inch	Jobber	A	Z	**172**
	D2GP187		Inch	Jobber	#56	#1	**173**
	D2GP511		Inch	Jobber	D5/64	D1/2	**174**
	DLGP513		Inch	Jobber	A	Z	**175**
	DLGP512		Inch	Jobber	#47	#1	**176**
	DLGP195		Metric	Jobber	D1.0	D13.0	**177**
	DLGP506		Metric	Jobber	D2.0	D13.0	**179**
STRAIGHT SHANK DRILLS	D1118		Inch	Screw Machine	D3/64	D1/2	**188**
	D1115		Inch	Screw Machine	A	Z	**189**
	D1119		Inch	Screw Machine	#60	#1	**190**
	D2146 D4146		Inch	Screw Machine	D3/64	D1/2	**191**
	D2147 D4147		Inch	Screw Machine	A	Z	**192**
	D2148 D4148		Inch	Screw Machine	#60	#1	**193**
	DN514		Inch	Screw Machine	D3/32	D1/2	**195**

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
			◎	◎								
			◎	◎								
◎	◎					○	○	○				○
◎	◎					○	○	○				○
◎	◎					○	○	○				○
◎	◎	○				○	○	○				◎
◎	◎	○				○	○	○				◎
◎	◎	○				○	○	○				◎
◎						◎		○	○			○
◎						◎		○	○			○
◎	◎					○		○				○
◎	◎					○		○				○
◎	◎					○		○				○
◎	◎					○		○				○
◎	◎					○		○				○
◎	◎					○		○				○
◎	◎						○	○				
◎	◎						○	○				
◎	◎						○	○				
◎	◎					○		○				○
◎	◎						○	○				
◎	◎					○	○	○				○
◎	◎					○	○	○				○
◎	◎					○	○	○				○
◎	◎					○		○				○
◎	◎					○		○				○
◎	◎					○		○				○
◎	◎						○	○				

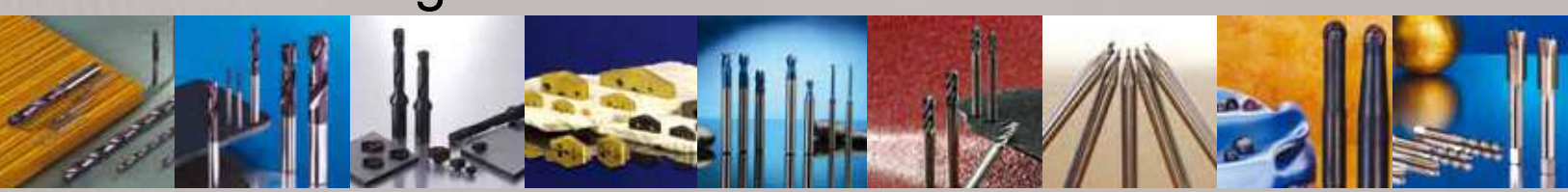
DRILLING TOOLS **APPLICATION TABLE**

	ITEM	MODEL	INCH / METRIC	LENGTH	SIZE		PAGE
					MIN	MAX	
STRAIGHT SHANK DRILLS	DN516		Inch	Screw Machine	A	Z	**196**
	DN515		Inch	Screw Machine	#47	#1	**197**
	DL517 DX517		Inch	Taper Length	D5/64	D1/2	**198**
	D4107		Metric	Screw Machine	D1.0	D31.0	**199**
AIRCRAFT DRILLS	DL601 DL604		Inch	Extension Length	D5/64	D1/2	**200**
	DL602 DL605		Inch	Extension Length	A	Z	**211**
	DL603 DL606		Inch	Extension Length	#43	#1	**212**
	D1631 D1634		Inch	Extension Length	D5/64	D1/2	**213**
	D1632 D1635		Inch	Extension Length	A	Z	**214**
	D1633 D1636		Inch	Extension Length	#43	#1	**215**
SILVER & DEMING DRILLS	D1191		Inch	—	D1/2	D1-1/2	**220**
MORSE TAPER SHANK DRILLS	D1211		Inch	—	D1/2	D2-1/2	**226**
NC SPOTTING DRILLS	D2N90(90˚)		Inch	—	D1/8	D1	**232**
	D2N90(120˚)		Inch	—	D1/8	D1	**232**
COMBINATION DRILL & COUNTER SINK / CENTER DRILL	D1C90		Inch	—	D3/64	D7/32	**238**

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎					○	○				
◎	◎					○	○				
◎	◎					○	○				
◎	◎				○	○	○				○
◎	○				○	○	○	○	○		
◎	○				○	○	○	○	○		
◎	○				○	○	○	○	○		
◎	◎	○			○	○	○	○	○		○
◎	◎	○			○	○	○	○	○		○
◎	◎	○			○	○	○	○	○		○
◎	◎				○	○	○				
◎	◎	○			○	○	○				
◎	◎				○		○		○		
◎	◎				○		○		○		
◎	◎				○	○	○	○	○		○

Global Cutting Tool Leader **YG-1**



YG

Being the best through innovation

CARBIDE INSERT

i-Dream Drills

- For Steels and Stainless Steel Alloys

SELECTION GUIDE

ITEM	MODEL	DESCRIPTION	PAGE
Y03A / Y03B		*i*-***Dream Drills*** General	44
YI3A / YI3B		*i*-***Dream Drills*** INOX	44
Y03B / Y03C		*i*-***Dream Drills*** General	45
YI3B / YI3C		*i*-***Dream Drills*** INOX	45
Y03C / Y03D		*i*-***Dream Drills*** General	46
YI3C / YI3D		*i*-***Dream Drills*** INOX	46
Y03E / Y03F		*i*-***Dream Drills*** General	47
YI3E / YI3F		*i*-***Dream Drills*** INOX	47
Y03G / Y03H		*i*-***Dream Drills*** General	48
YI3G / YI3H		*i*-***Dream Drills*** INOX	48
Y03I / Y03J		*i*-***Dream Drills*** General	49
YI3I / YI3J		*i*-***Dream Drills*** INOX	49
		RECOMMENDED CUTTING CONDITIONS	50

Comparison with Split Point Drill, Spade Drill & Dream Drill

◎ : Excellent ○ : Good

P												M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys	
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎			
○	○		○				○		○		◎			○	○	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎			
○	○		○				○		○		◎			○	○	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎			
○	○		○				○		○		◎			○	○	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎			
○	○		○				○		○		◎			○	○	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎			
○	○		○				○		○		◎			○	○	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎			
○	○		○				○		○		◎			○	○	

i-Dream Drills

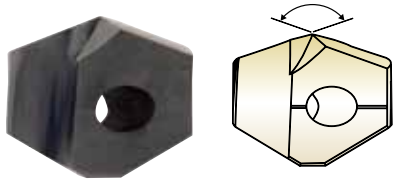
Y03A / YI3A SERIES
Y03B / YI3B SERIES

i-DREAM DRILL INSERTS & HOLDERS

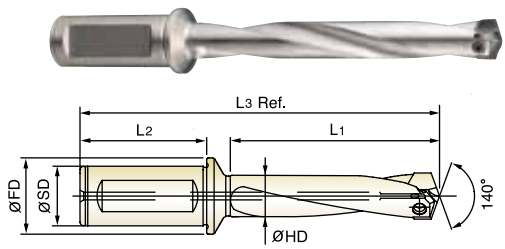
- Features of *i-Dream Drill* Inserts
- Secure and accurate seating resulting in accurate repeatability and concentricity.

i-Dream Drill ***General***
- For most steel materials

i-Dream Drill ***INOX***
- For tough, ductile materials and stainless steels
- Light, sharp cutting edge
- Minimize cutting forces
- Reduce built-up edge



- Features of *i-Dream Drill* Holders
- Special Alloy Steels that maintains its hardness and toughness under high temperatures with generous coolant holes for effective coolant flow.
- Innovative surface treatment that improves wear resistance and reduces corrosion.
- High Performance flute design allowing maximum chip evacuation and minimum interference.



cutting conditions : p.50~51

Unit : Inch

Series Range	Insert EDP No.		Insert O.D.		Length	Holder EDP No.	Diameter	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Torx Screw No.
	TiAlN	TiCN	h7										
(mm)	General	INOX	dec.	inch / mm			HD	SD	L2	FD	L1	L3 Ref.	
A Ø12.00 to Ø13.99 3.6mm Thick	Y03A01	YI3A01	.4724	12.00	3D 5D 7D	ZA0301 ZA0501 ZA0701	.4528	3/4	2	1	1-27/64 2-23/64 3-5/16	4-29/64 5-13/32 6-11/32	TA1213
	Y03A02	YI3A02	.4764	12.10									
	Y03A03	YI3A03	.4803	12.20									
	Y03A04	YI3A04	.4844	31/64									
	Y03A05	YI3A05	.4921	12.50	3D 5D 7D	ZA0302 ZA0502 ZA0702	.4724	3/4	2	1	1-15/32 2-29/64 3-7/16	4-1/2 5-31/64 6-15/32	
	Y03A06	YI3A06	.4961	12.60									
	Y03A07	YI3A07	.5000	1/2									
	Y03A08	YI3A08	.5039	12.80									
	Y03A09	YI3A09	.5079	12.90									
	Y03A10	YI3A10	.5118	13.00	3D 5D 7D	ZA0303 ZA0503 ZA0703	.4921	3/4	2	1	1-17/32 2-9/16 3-37/64	4-37/64 5-19/32 6-5/8	
	Y03A11	YI3A11	.5156	33/64									
	Y03A12	YI3A12	.5197	13.20									
	Y03A13	YI3A13	.5312	17/32									
	Y03A14	YI3A14	.5315	13.50	3D 5D 7D	ZA0304 ZA0504 ZA0704	.5118	3/4	2	1	1-19/32 2-21/32 3-23/32	4-39/64 5-43/64 6-47/64	TA1314
	Y03A15	YI3A15	.5354	13.60									
	Y03A16	YI3A16	.5394	13.70									
	Y03A17	YI3A17	.5433	13.80									
	Y03A18	YI3A18	.5469	35/64									
B Ø14.00 to Ø15.99 4mm Thick	Y03B01	YI3B01	.5512	14.00	3D 5D 7D	ZB0301 ZB0501 ZB0701	.5315	3/4	2	1	1-21/32 2-3/4 3-55/64	4-23/32 5-13/16 6-59/64	TB1415
	Y03B02	YI3B02	.5551	14.10									
	Y03B03	YI3B03	.5591	14.20									
	Y03B04	YI3B04	.5625	9/16									
	Y03B05	YI3B05	.5630	14.30									
	Y03B06	YI3B06	.5669	14.40									

◎ : Excellent ○ : Good

	P											M	K		N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
Y03 *	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎		
YI3 *	○	○		○				○		○		◎			○	○

YG *i*-Dream Drills

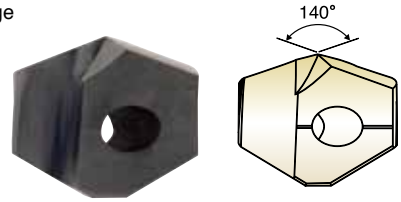
Y03B / YI3B SERIES
Y03C / YI3C SERIES

i-DREAM DRILL INSERTS & HOLDERS

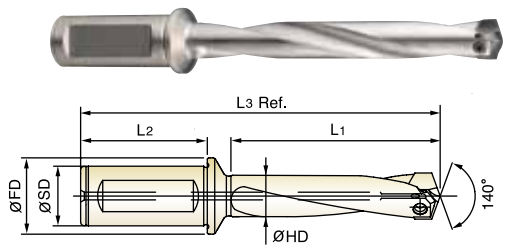
- Features of *i*-*Dream Drill* Inserts
- Secure and accurate seating resulting in accurate repeatability and concentricity.

i-Dream Drill ***General***
- For most steel materials

i-Dream Drill ***INOX***
- For tough, ductile materials and stainless steels
- Light, sharp cutting edge
- Minimize cutting forces
- Reduce built-up edge



- Features of *i*-*Dream Drill* Holders
- Special Alloy Steels that maintains its hardness and toughness under high temperatures with generous coolant holes for effective coolant flow.
- Innovative surface treatment that improves wear resistance and reduces corrosion.
- High Performance flute design allowing maximum chip evacuation and minimum interference.



cutting conditions : p.50~51

Unit : Inch

Series Range	Insert EDP No.		Insert O.D.		Length	Holder EDP No.	Diameter	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Torx Screw No.
	TiAlN	TiCN	h7										
(mm)	General	INOX	dec.	inch / mm			HD	SD	L2	FD	L1	L3 Ref.	
B Ø14.00 to Ø15.99 4mm Thick	Y03B07	YI3B07	.5709	14.50	3D	ZB0302	.5512	3/4	2	1	1-23/32	4-51/64	TB1415
	Y03B08	YI3B08	.5748	14.60	5D	ZB0502					2-55/64	5-15/16	
	Y03B09	YI3B09	.5781	37/64	7D	ZB0702					4	7-5/64	
	Y03B10	YI3B10	.5827	14.80									
	Y03B11	YI3B11	.5906	15.00									TB1516
	Y03B12	YI3B12	.5938	19/32	3D	ZB0303	.5709	3/4	2	1	1-49/64	4-7/8	
	Y03B13	YI3B13	.5945	15.10	5D	ZB0503					2-61/64	6-3/64	
	Y03B14	YI3B14	.5984	15.20	7D	ZB0703					4-9/64	7-15/64	
	Y03B15	YI3B15	.6024	15.30									
	Y03B16	YI3B16	.6094	39/64									
	Y03B17	YI3B17	.6102	15.50									
	Y03B18	YI3B18	.6142	15.60	3D	ZB0304	.5906	3/4	2	1	1-53/64	4-29/32	
	Y03B19	YI3B19	.6181	15.70	5D	ZB0504					3-3/64	6-1/8	
	Y03B20	YI3B20	.6220	15.80	7D	ZB0704					4-17/64	7-11/32	
	Y03B21	YI3B21	.6250	5/8									
C Ø16.00 to Ø17.99 4.5mm Thick	Y03C01	YI3C01	.6299	16.00									TC1617
	Y03C02	YI3C02	.6335	16.09	3D	ZC0301	.6102	3/4	2	1	1-57/64	4-61/64	
	Y03C03	YI3C03	.6378	16.20	5D	ZC0501					3-5/32	6-7/32	
	Y03C04	YI3C04	.6406	41/64	7D	ZC0701					4-13/32	7-15/32	
	Y03C05	YI3C05	.6417	16.30									
	Y03C06	YI3C06	.6496	16.50	3D	ZC0302	.6299	3/4	2	1	1-61/64	5-1/32	
	Y03C07	YI3C07	.6562	21/32	5D	ZC0502					3-1/4	6-21/64	
	Y03C08	YI3C08	.6614	16.80	7D	ZC0702					4-35/64	7-5/8	

◎ : Excellent ○ : Good

	P											M	K			N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
Y03 *	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎		
YI3 *	○	○		○				○		○		◎			○	○

i-DREAM DRILL INSERTS & HOLDERS

- Features of *i-Dream Drill* Inserts

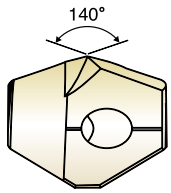
▶ Secure and accurate seating resulting in accurate repeatability and concentricity.

i-Dream Drill ***General***

▶ For most steel materials

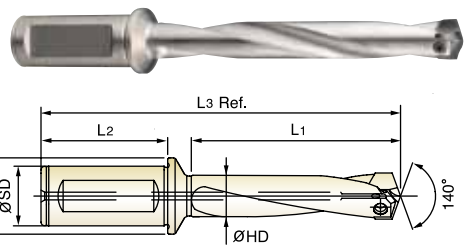
i-Dream Drill ***INOX***

▶ For tough, ductile materials and stainless steels
▶ Light, sharp cutting edge
▶ Minimize cutting forces
▶ Reduce built-up edge



- Features of *i-Dream Drill* Holders

▶ Special Alloy Steels that maintains its hardness and toughness under high temperatures with generous coolant holes for effective coolant flow.
▶ Innovative surface treatment that improves wear resistance and reduces corrosion.
▶ High Performance flute design allowing maximum chip evacuation and minimum interference.



cutting conditions : p.50~51

Unit : Inch

Series Range	Insert EDP No.		Insert O.D.		Length	Holder EDP No.	Diameter	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Torx Screw No.
	TiAlN	TiCN	h7										
(mm)	General	INOX	dec.	inch / mm			HD	SD	L2	FD	L1	L3 Ref.	
C Ø16.00 to Ø17.99 4.5mm Thick	Y03C09	YI3C09	.6693	17.00	3D	ZC0303	.6496	3/4	2	1	2-1/64	5-5/64	TC1718
	Y03C10	YI3C10	.6919	43/64	5D	ZC0503					3-11/32	6-13/32	
	Y03C11	YI3C11	.6875	11/16	7D	ZC0703					4-11/16	7-3/4	
	Y03C12	YI3C12	.6890	17.50	3D	ZC0304	.6693	3/4	2	1	2-1/16	5-5/32	
	Y03C13	YI3C13	.7008	17.80	5D	ZC0504					3-7/16	6-17/32	
	Y03C14	YI3C14	.7031	45/64	7D	ZC0704					4-53/64	7-29/32	
D Ø18.00 to Ø19.99 5mm Thick	Y03D01	YI3D01	.7087	18.00	3D	ZD0301	.6890	1	2-3/16	1-1/4	2-1/8	5-1/2	TD1819
	Y03D02	YI3D02	.7188	23/32	5D	ZD0501					3-35/64	6-59/64	
					7D	ZD0701					4-61/64	8-11/32	
	Y03D03	YI3D03	.7283	18.50	3D	ZD0302	.7087	1	2-3/16	1-1/4	2-3/16	5-35/64	
	Y03D04	YI3D04	.7344	47/64	5D	ZD0502					3-41/64	7	
	Y03D05	YI3D05	.7402	18.80	7D	ZD0702					5-3/32	8-29/64	
	Y03D06	YI3D06	.7480	19.00	3D	ZD0303	.7283	1	2-3/16	1-1/4	2-1/4	5-43/64	TD1920
	Y03D07	YI3D07	.7500	3/4	5D	ZD0503					3-47/64	7-5/32	
	Y03D08	YI3D08	.7587	19.27	7D	ZD0703					5-15/64	8-21/32	
	Y03D09	YI3D09	.7656	49/64									
	Y03D10	YI3D10	.7677	19.50	3D	ZD0304	.7480	1	2-3/16	1-1/4	2-19/64	5-45/64	
	Y03D11	YI3D11	.7795	19.80	5D	ZD0504					3-27/32	7-15/64	
	Y03D12	YI3D12	.7812	25/32	7D	ZD0704					5-3/8	8-25/32	

◎ : Excellent ○ : Good

	P											M	K		N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
Y03 *	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎		
YI3 *	○	○		○				○		○		◎			○	○

YG *i*-Dream Drills

Y03E / YI3E SERIES
Y03F / YI3F SERIES

i-DREAM DRILL INSERTS & HOLDERS

- Features of *i*-*Dream Drill* Inserts

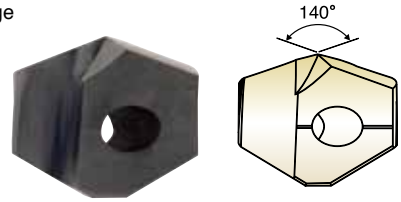
▶ Secure and accurate seating resulting in accurate repeatability and concentricity.

i-Dream Drill ***General***

▶ For most steel materials

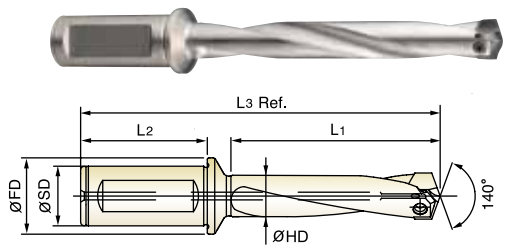
i-Dream Drill ***INOX***

▶ For tough, ductile materials and stainless steels
▶ Light, sharp cutting edge
▶ Minimize cutting forces
▶ Reduce built-up edge



- Features of *i*-*Dream Drill* Holders

▶ Special Alloy Steels that maintains its hardness and toughness under high temperatures with generous coolant holes for effective coolant flow.
▶ Innovative surface treatment that improves wear resistance and reduces corrosion.
▶ High Performance flute design allowing maximum chip evacuation and minimum interference.



cutting conditions : p.50~51

Unit : Inch

Series Range	Insert EDP No.		Insert O.D.		Length	Holder EDP No.	Diameter	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Torx Screw No.
	TiAlN	TiCN	h7										
(mm)	General	INOX	dec.	inch / mm			HD	SD	L2	FD	L1	L3 Ref.	
E Ø20.00 to Ø21.99 5.5mm Thick	Y03E01	YI3E01	.7874	20.00	3D	ZE0301	.7638	1	2-3/16	1-1/4	2-23/64	5-23/32	TE2021
					5D	ZE0501					3-15/16	7-9/32	
	Y03E02	YI3E02	.7969	51/64	7D	ZE0701					5-33/64	8-55/64	
	Y03E03	YI3E03	.8071	20.50	3D	ZE0302	.7835	1	2-3/16	1-1/4	2-27/64	5-51/64	
	Y03E04	YI3E04	.8125	13/16	5D	ZE0502					4-1/32	7-13/32	
	Y03E05	YI3E05	.8150	20.70	7D	ZE0702					5-21/32	9-1/64	
	Y03E06	YI3E06	.8268	21.00	3D	ZE0303	.8031	1	2-3/16	1-1/4	2-31/64	5-7/8	TE2122
	Y03E07	YI3E07	.8281	53/64	5D	ZE0503					4-9/64	7-33/64	
	Y03E08	YI3E08	.8438	27/32	7D	ZE0703					5-25/32	9-11/64	
	Y03E09	YI3E09	.8465	21.50	3D	ZE0304	.8228	1	2-3/16	1-1/4	2-35/64	5-29/32	
	Y03E10	YI3E10	.8543	21.70	5D	ZE0504					4-15/64	7-19/32	
	Y03E11	YI3E11	.8594	55/64	7D	ZE0704					5-59/64	9-19/64	
F Ø22.00 to Ø23.99 6mm Thick	Y03F01	YI3F01	.8661	22.00	3D	ZF0301	.8425	1	2-3/16	1-1/4	2-19/32	5-63/64	TF2223
					5D	ZF0501					4-21/64	7-23/32	
	Y03F02	YI3F02	.8750	7/8	7D	ZF0701					6-1/16	9-29/64	
	Y03F03	YI3F03	.8858	22.50	3D	ZF0302	.8622	1	2-3/16	1-1/4	2-21/32	6-1/32	
	Y03F04	YI3F04	.8906	57/64	5D	ZF0502					4-27/64	7-51/64	
	Y03F05	YI3F05	.8937	22.70	7D	ZF0702					6-13/64	9-9/16	
	Y03F06	YI3F06	.9055	23.00	3D	ZF0303	.8819	1	2-3/16	1-1/4	2-23/32	6-7/64	TF2324
	Y03F07	YI3F07	.9062	29/32	5D	ZF0503					4-17/32	7-29/32	
	Y03F08	YI3F08	.9219	59/64	7D	ZF0703					6-11/32	9-23/32	
	Y03F09	YI3F09	.9252	23.50	3D	ZF0304	.9016	1	2-3/16	1-1/4	2-25/32	6-3/16	
	Y03F10	YI3F10	.9331	23.70	5D	ZF0504					4-5/8	8-1/32	
	Y03F11	YI3F11	.9375	15/16	7D	ZF0704					6-15/32	9-7/8	

◎ : Excellent ○ : Good

	P											M	K			N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
Y03 *	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎		
YI3 *	○	○		○				○		○		◎			○	○

i-Dream Drills

Y03G / YI3G SERIES
Y03H / YI3H SERIES

i-DREAM DRILL INSERTS & HOLDERS

- Features of *i-Dream Drill* Inserts

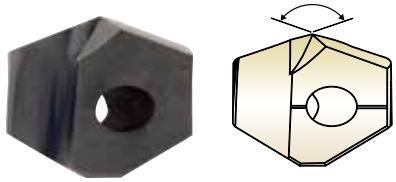
▶ Secure and accurate seating resulting in accurate repeatability and concentricity.

i-Dream Drill ***General***

▶ For most steel materials

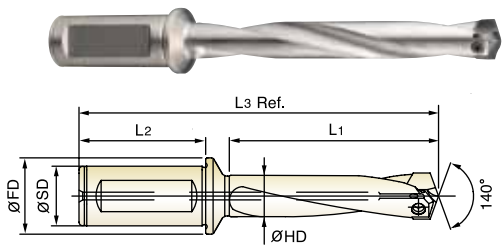
i-Dream Drill ***INOX***

▶ For tough, ductile materials and stainless steels
▶ Light, sharp cutting edge
▶ Minimize cutting forces
▶ Reduce built-up edge



- Features of *i-Dream Drill* Holders

▶ Special Alloy Steels that maintains its hardness and toughness under high temperatures with generous coolant holes for effective coolant flow.
▶ Innovative surface treatment that improves wear resistance and reduces corrosion.
▶ High Performance flute design allowing maximum chip evacuation and minimum interference.



cutting conditions : p.50~51

Unit : Inch

Series Range	Insert EDP No.		Insert O.D.		Length	Holder EDP No.	Diameter	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Torx Screw No.
	TiAlN	TiCN	h7										
(mm)	General	INOX	dec.	inch / mm			HD	SD	L2	FD	L1	L3 Ref.	
G Ø24.00 to Ø25.99 6.5mm Thick	Y03G01	YI3G01	.9449	24.00	3D	ZG0301	.9213	1-1/4	2-3/8	1-15/32	2-53/64	6-1/2	TG2425
					5D	ZG0501					4-23/32	8-25/64	
	Y03G02	YI3G02	.9531	61/64	7D	ZG0701					6-39/64	10-9/32	
	Y03G03	YI3G03	.9646	24.50	3D	ZG0302	.9409	1-1/4	2-3/8	1-15/32	2-57/64	6-17/32	
	Y03G04	YI3G04	.9688	31/32	5D	ZG0502					4-53/64	8-15/32	
	Y03G05	YI3G05	.9724	24.70	7D	ZG0702					6-3/4	10-25/64	
	Y03G06	YI3G06	.9843	63/64	3D	ZG0303	.9606	1-1/4	2-3/8	1-15/32	2-61/64	6-39/64	TG2526
	Y03G07	YI3G07	1.0000	1	5D	ZG0503					4-59/64	8-37/64	
					7D	ZG0703					6-57/64	10-35/64	
	Y03G08	YI3G08	1.0039	25.50	3D	ZG0304	.9803	1-1/4	2-3/8	1-15/32	3-1/64	6-47/64	
	Y03G09	YI3G09	1.0106	25.67	5D	ZG0504					5-1/64	8-47/64	
	Y03G10	YI3G10	1.0118	25.70	7D	ZG0704					7-1/32	10-3/4	
	Y03G11	YI3G11	1.0156	1-1/64									
H Ø26.00 to Ø27.99 7.1mm Thick	Y03H01	YI3H01	1.0236	26.00	3D	ZH0301	1.0000	1-1/4	2-3/8	1-15/32	3-5/64	6-3/4	TH2627
					5D	ZH0501					5-1/8	8-51/64	
	Y03H02	YI3H02	1.0312	1-1/32	7D	ZH0701					7-11/64	10-27/32	
	Y03H03	YI3H03	1.0433	26.50	3D	ZH0302	1.0197	1-1/4	2-3/8	1-15/32	3-1/8	6-51/64	
	Y03H04	YI3H04	1.0469	1-3/64	5D	ZH0502					5- 7/32	8-7/8	
	Y03H05	YI3H05	1.0625	1-1/16	7D	ZH0702					7-19/64	10-31/32	
	Y03H06	YI3H06	1.0630	27.00	3D	ZH0303	1.0394	1-1/4	2-3/8	1-15/32	3-3/16	6-7/8	TH2728
					5D	ZH0503					5-5/16	9	
					7D	ZH0703					7-7/16	11-1/8	
	Y03H07	YI3H07	1.0827	27.50	3D	ZH0304	1.0591	1-1/4	2-3/8	1-15/32	3-1/4	6-29/32	
	Y03H08	YI3H08	1.0938	1-3/32	5D	ZH0504					5-13/32	9-5/64	
					7D	ZH0704					7-37/64	11-15/64	

◎ : Excellent ○ : Good

	P											M	K		N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
Y03 *	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎		
YI3 *	○	○		○				○		○		◎			○	○

YG *i*-Dream Drills

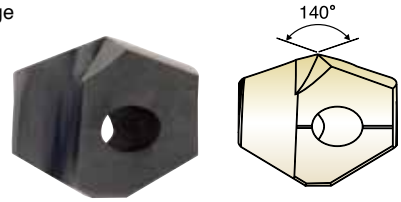
Y03I / YI3I SERIES
Y03J / YI3J SERIES

i-DREAM DRILL INSERTS & HOLDERS

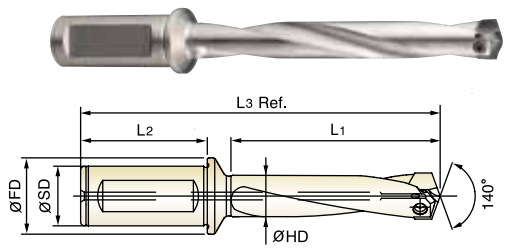
- Features of *i*-*Dream Drill* Inserts
- Secure and accurate seating resulting in accurate repeatability and concentricity.

i-Dream Drill ***General***
- For most steel materials

i-Dream Drill ***INOX***
- For tough, ductile materials and stainless steels
- Light, sharp cutting edge
- Minimize cutting forces
- Reduce built-up edge



- Features of *i*-*Dream Drill* Holders
- Special Alloy Steels that maintains its hardness and toughness under high temperatures with generous coolant holes for effective coolant flow.
- Innovative surface treatment that improves wear resistance and reduces corrosion.
- High Performance flute design allowing maximum chip evacuation and minimum interference.



cutting conditions : p.50~51

Unit : Inch

Series Range	Insert EDP No.		Insert O.D.		Length	Holder EDP No.	Diameter	Shank Dia.	Shank Length	Flange Dia.	Drilling Depth	Overall Length	Torx Screw No.
	TiAlN	TiCN	h7										
(mm)	General	INOX	dec.	inch / mm			HD	SD	L2	FD	L1	L3 Ref.	
I Ø28.00 to Ø29.99 7.7mm Thick	Y03I01	YI3I01	1.1024	28.00	3D	ZI0301	1.0748	1-1/4	2-3/8	1-15/32	3-5/16	7	TI2829
					5D	ZI0501					5-33/64	9-15/64	
	Y03I02	YI3I02	1.1094	1-7/64	7D	ZI0701					7-23/32	11-7/16	
	Y03I03	YI3I03	1.1220	28.50	3D	ZI0302	1.0945	1-1/4	2-3/8	1-15/32	3-23/64	7-1/16	
					5D	ZI0502					5-39/64	9-5/16	
	Y03I04	YI3I04	1.1250	1-1/8	7D	ZI0702					7-55/64	11-9/16	
	Y03I05	YI3I05	1.1417	29.00	3D	ZI0303	1.1142	1-1/4	2-3/8	1-15/32	3-27/64	7-3/16	TI2930
					5D	ZI0503					5-45/64	9-15/32	
	Y03I06	YI3I06	1.1562	1-5/32	7D	ZI0703					7-63/64	11-3/4	
	Y03I07	YI3I07	1.1614	29.50	3D	ZI0304	1.1339	1-1/4	2-3/8	1-15/32	3-31/64	7-7/32	
					5D	ZI0504					5-13/16	9-35/64	
	Y03I08	YI3I08	1.1719	1-11/64	7D	ZI0704					8-1/8	11-7/8	
J Ø30.00 to Ø31.99 8mm Thick	Y03J01	YI3J01	1.1811	30.00	3D	ZJ0301	1.1535	1-1/4	2-3/8	1-15/32	3-35/64	7-21/64	TJ2831
					5D	ZJ0501					5-29/32	9-45/64	
	Y03J02	YI3J02	1.1875	1-3/16	7D	ZJ0701					8-17/64	12-1/16	
	Y03J03	YI3J03	1.2008	30.50	3D	ZJ0302	1.1732	1-1/4	2-3/8	1-15/32	3-39/64	7-3/8	
	Y03J04	YI3J04	1.2031	1-11/64	5D	ZJ0502					6	9-25/32	
	Y03J05	YI3J05	1.2188	1-7/32	7D	ZJ0702					8-13/32	12-11/64	
	Y03J06	YI3J06	1.2205	31.00	3D	ZJ0303	1.1929	1-1/4	2-3/8	1-15/32	3-21/32	7-13/32	TJ3132
					5D	ZJ0503					6-7/64	9-55/64	
					7D	ZJ0703					8-35/64	12-19/64	
	Y03J07	YI3J07	1.2402	31.50	3D	ZJ0304	1.2126	1-1/4	2-3/8	1-15/32	3-23/32	7-17/32	
					5D	ZJ0504					6-13/64	10-1/64	
	Y03J08	YI3J08	1.2500	1-1/4	7D	ZJ0704					8-11/16	12-31/64	

◎ : Excellent ○ : Good

	P											M	K			N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
Y03 *	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		◎	◎		
YI3 *	○	○		○				○		○		◎			○	○

INCH

ISO	Material			Tensile Strength	Hardness		Cutting Speed	Feed [IPR]				
				MPa	HB	HRc	Vc [SFM]	Ø31/64 ~Ø37/64	Ø19/32 ~Ø45/64	Ø23/32 ~Ø55/64	Ø7/8 ~Ø1-1/16	Ø1-3/32 ~Ø1-1/4
P	Non-alloyed steels, Cast steels Free-machining steels	1213, 13L13, 1215, 12L14, 1118 etc	YG3□ / YI3□	~500	100~150		312~394	.006~.011	.008~.014	.011~.016	.013~.020	.015~.022
				500~850	150~250	~24	262~344	.006~.009	.008~.014	.011~.016	.013~.020	.015~.022
	Low-alloyed steels, Cast steels (<5%) Carbon steels	1015, 1020, 1140, 1025, 1035, 1050, 1045, 1055 etc		~450	85~125		295~377	.006~.010	.008~.013	.010~.015	.012~.019	.013~.020
				450~755	125~225	~19	230~295	.005~.008	.007~.011	.009~.013	.012~.018	.013~.019
				755~900	225~265	19~27	197~262	.005~.008	.007~.011	.009~.013	.012~.018	.013~.019
				900~1200	265~350	27~37	180~230	.004~.006	.006~.010	.008~.012	.010~.015	.011~.017
	Alloyed steels	8620, 4130, 4137, 4140, 6150 etc		~600	125~175	~7	262~328	.006~.009	.007~.011	.009~.013	.012~.018	.013~.020
				600~800	175~235	7~22	230~295	.005~.008	.007~.011	.009~.013	.012~.018	.013~.020
				800~950	235~280	22~29	197~262	.005~.008	.006~.010	.009~.013	.012~.018	.013~.020
				950~1110	280~330	29~35	180~230	.004~.006	.005~.008	.008~.012	.010~.015	.011~.017
				1110~1230	330~360	35~39	148~197	.003~.005	.005~.008	.008~.012	.010~.015	.011~.017
	High-alloyed steels	A355, 9840, 4340 etc		600~1020	225~300	19~32	148~197	.005~.008	.006~.010	.008~.012	.008~.012	.009~.014
				1020~1200	300~355	32~38	131~180	.004~.006	.004~.007	.008~.012	.008~.012	.009~.014
				1200~1330	355~390	38~42	131~164	.003~.005	.004~.006	.007~.010	.007~.011	.009~.013
	Structural steels	A36, A516, A182 etc		350~500	100~150		246~312	.006~.009	.008~.014	.011~.015	.011~.017	.013~.019
				500~850	150~250	~24	197~246	.005~.008	.008~.013	.009~.013	.010~.015	.011~.017
				850~1200	250~355	24~38	164~213	.004~.006	.007~.011	.008~.012	.008~.013	.010~.015
	Tool steels	H13, H21, A2, S1 etc		500~705	150~210	~16	164~213	.004~.006	.005~.008	.007~.010	.008~.012	.009~.014
				705~950	210~280	16~29	131~164	.004~.006	.005~.008	.007~.010	.008~.012	.009~.014
M	Stainless steels	Austenitic and Austenitic/ferritic		450~610	135~185	~9	145~197	.004~.006	.005~.007	.006~.008	.006~.011	.007~.011
				610~930	185~275	9~28	89~145	.003~.005	.004~.006	.004~.006	.005~.008	.006~.009
K	Grey cast iron	Pearlitic, Ferritic		500~700	150~210	~16	328~410	.006~.010	.008~.015	.011~.017	.014~.020	.016~.022
		Pearlitic		700~850	210~250	16~24	246~312	.004~.008	.006~.011	.008~.012	.010~.014	.011~.016
	Cast iron nodular	Ferritic		540	165	4	312~394	.005~.009	.007~.012	.008~.013	.011~.016	.013~.017
		Pearlitic		850	250	24	246~312	.004~.008	.006~.010	.007~.011	.010~.014	.011~.016
	Malleable cast iron	Ferritic		450	125		328~410	.005~.009	.007~.012	.008~.013	.011~.016	.013~.017
		Pearlitic		780	230	21	246~312	.004~.007	.006~.010	.007~.011	.010~.014	.011~.016
N	Aluminum alloys (Wrought)	not heat treatable			65		820~1083	.0118~.0157	.0138~.0177	.0157~.0197	.0177~.0217	.0197~.0236
		hardened			150		656~820	.0118~.0157	.0138~.0177	.0157~.0197	.0177~.0217	.0197~.0236
	Aluminum alloys (Cast)	≤12% Si, not heat treatable			75		656~820	.0098~.0138	.0118~.0157	.0138~.0177	.0157~.0197	.0177~.0217
		≤12% Si, hardened			90		492~722	.0098~.0138	.0118~.0157	.0138~.0177	.0157~.0197	.0177~.0217
		>12% Si, not heat treatable			130		328~656	.0079~.0118	.0098~.0138	.0118~.0157	.0138~.0177	.0157~.0197
	Copper alloys	Free machining (Pb>1%)			110		377~476	.006~.011	.009~.014	.011~.014	.015~.018	.016~.019
		Brass			90		476~607	.007~.011	.009~.015	.012~.015	.015~.018	.017~.019
		Electrolitic copper			100		312~394	.002~.004	.004~.005	.004~.005	.006~.007	.007~.009
	Non ferrous material	Duroplastics										
		Fiber plastics										
		Hard rubber										

RPM = revolution per minute (rev/min)
SFM = surface feet per minute (ft/min)
DIA. = diameter of drill (inch)
IPR = feed rate (inch/rev)
IPM = inch per minute penetration rate

*Formulas:

$$SFM = \frac{(RPM) \cdot \pi \cdot (DIA.)}{12}$$

$$IPM = (RPM) \cdot (IPR)$$

$$RPM = \frac{(SFM) \cdot 12}{(\pi) \cdot (DIA.)}$$

▶ The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.
Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.
▶ Recommend you to reduce the feed rate to 85%, 70% when you use 5xD, 7xD holders.
▶ For use of 7xD holder, we recommend to drill a centering pre-hole with equal to or larger than 140° point angle to min. 2/3 cutting diameter.
The use of the centering pre-hole improves hole location, roundness and surface finish.

METRIC

ISO	Material			Tensile Strength	Hardness		Cutting Speed	Feed [mm/rev]				
				[N/mm²]	HB	HRc	Vc [M/min]	Ø12.00 ~Ø14.99	Ø15.00 ~Ø17.99	Ø18.00 ~Ø21.99	Ø22.00 ~Ø26.99	Ø27.00 ~Ø31.99
P	Non-alloyed steels, Cast steels Free-machining steels	9SMn28, 9SMnPb28, 10SPb20 etc	YG03□ / YI3□	~500	100~150		95~120	0.16~0.28	0.21~0.35	0.27~0.40	0.34~0.52	0.37~0.55
				500~850	150~250	~24	80~105	0.14~0.24	0.21~0.35	0.27~0.40	0.34~0.52	0.37~0.55
	Low-alloyed steels, Cast steels (<5%) Carbon steels	C15, C22, 20Mn5, Ck45, C45 etc		~450	85~125		90~115	0.14~0.25	0.20~0.33	0.25~0.39	0.31~0.47	0.34~0.50
				450~755	125~225	~19	70~90	0.12~0.20	0.17~0.28	0.22~0.32	0.30~0.46	0.33~0.49
				755~900	225~265	19~27	60~80	0.12~0.20	0.17~0.28	0.22~0.32	0.30~0.46	0.33~0.49
				900~1200	265~350	27~37	55~70	0.10~0.16	0.15~0.25	0.21~0.30	0.25~0.38	0.29~0.43
	Alloyed steels	45CrMo4, 42CrMo4, 16MnCr5, Ck75, 35CrMo4, 16MnCr5 etc		~600	125~175	~7	80~100	0.14~0.24	0.17~0.28	0.22~0.32	0.30~0.46	0.34~0.50
				600~800	175~235	7~22	70~90	0.12~0.20	0.17~0.28	0.22~0.32	0.30~0.46	0.34~0.50
				800~950	235~280	22~29	60~80	0.12~0.20	0.15~0.25	0.22~0.32	0.30~0.46	0.34~0.50
				950~1110	280~330	29~35	55~70	0.10~0.16	0.13~0.21	0.21~0.30	0.25~0.38	0.29~0.43
				1110~1230	330~360	35~39	45~60	0.08~0.12	0.13~0.21	0.21~0.30	0.25~0.38	0.29~0.43
	High-alloyed steels	36CrNiMo4, 41CrAlMo7 etc		600~1020	225~300	19~32	45~60	0.12~0.20	0.15~0.25	0.21~0.30	0.20~0.31	0.24~0.35
				1020~1200	300~355	32~38	40~55	0.10~0.16	0.11~0.18	0.21~0.30	0.20~0.31	0.24~0.35
				1200~1330	355~390	38~42	40~50	0.08~0.12	0.09~0.14	0.18~0.26	0.19~0.29	0.23~0.34
	Structural steels	St33, St37-2, St44-2, St52, St60 etc		350~500	100~150		75~95	0.14~0.24	0.21~0.35	0.27~0.39	0.29~0.44	0.32~0.47
				500~850	150~250	~24	60~75	0.12~0.20	0.20~0.33	0.22~0.32	0.25~0.38	0.29~0.43
				850~1200	250~355	24~38	50~65	0.10~0.16	0.17~0.28	0.21~0.30	0.21~0.32	0.26~0.38
	Tool steels	102Cr6, 105WCr6, C75W etc		500~705	150~210	~16	50~65	0.10~0.16	0.13~0.21	0.18~0.26	0.20~0.31	0.24~0.35
				705~950	210~280	16~29	40~50	0.10~0.16	0.13~0.21	0.18~0.26	0.20~0.31	0.24~0.35
M	Stainless steels	Austenitic and Austenitic/Ferritic		450~610	135~185	~9	45~60	0.10~0.16	0.12~0.18	0.14~0.20	0.15~0.26	0.18~0.28
				610~930	185~275	9~28	30~45	0.08~0.14	0.09~0.15	0.10~0.16	0.12~0.20	0.14~0.22
K	Grey cast iron	Pearlitic,Ferritic A48-76, 20B, 25B, 30B etc		500~700	150~210	~16	100~125	0.15~0.26	0.20~0.37	0.27~0.42	0.36~0.51	0.40~0.55
		Pearlitic A48-35B, 40B, 50B, 60B etc		700~850	210~250	16~24	75~95	0.11~0.20	0.16~0.29	0.20~0.30	0.25~0.35	0.29~0.40
	Cast iron nodular	Ferritic 60-40-18, 80-55-06 etc		540	165	4	95~120	0.13~0.22	0.17~0.31	0.21~0.32	0.28~0.40	0.32~0.44
		Pearlitic 100-70-03 etc		850	250	24	75~95	0.11~0.20	0.14~0.26	0.19~0.29	0.25~0.35	0.29~0.40
	Malleable cast iron	Ferritic A48-74, A220-76, 32510 etc		450	125		100~125	0.13~0.22	0.17~0.31	0.21~0.32	0.28~0.40	0.32~0.44
		Pearlitic 50005, 70003 etc		780	230	21	75~95	0.11~0.18	0.14~0.26	0.19~0.29	0.25~0.35	0.29~0.40
N	Aluminum alloys (Wrought)	not heat treatable			65		250~330	0.30~0.40	0.35~0.45	0.40~0.50	0.45~0.55	0.50~0.60
		hardened			150		200~250	0.30~0.40	0.35~0.45	0.40~0.50	0.45~0.55	0.50~0.60
	Aluminum alloys (Cast)	≤12% Si, not heat treatable			75		200~50	0.25~0.35	0.30~0.40	0.35~0.45	0.40~0.50	0.45~0.55
		≤12% Si, hardened			90		150~220	0.25~0.35	0.30~0.40	0.35~0.45	0.40~0.50	0.45~0.55
		>12% Si, not heat treatable			130		100~200	0.20~0.30	0.25~0.35	0.30~0.40	0.35~0.45	0.40~0.50
	Copper alloys	Free machining (Pb>1%)			110		115~145	0.16~0.28	0.23~0.36	0.29~0.36	0.37~0.45	0.41~0.48
		Brass			90		145~185	0.17~0.29	0.24~0.37	0.30~0.38	0.38~0.46	0.42~0.49
		Electrolitic copper			100		95~120	0.06~0.09	0.09~0.13	0.11~0.13	0.15~0.18	0.19~0.22
	Non ferrous material	Duroplastics										
		Fiber plastics										
		Hard rubber										

RPM = revolution per minute (rev/min)
M/min = surface meter per minute (M/min)
DIA. = diameter of drill (mm)
mm/rev = feed rate (mm/rev)

*Formulas :

$$\text{M/min} = \frac{(\text{RPM}) \cdot \pi \cdot (\text{DIA.})}{1000}$$

$$\text{mm/min} = (\text{RPM}) \cdot (\text{mm/rev})$$

$$\text{RPM} = \frac{(\text{M/min}) \cdot 1000}{(\pi) \cdot (\text{DIA.})}$$

- The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.
  Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.
- Recommend you to reduce the feed rate to 85%, 70% when you use 5xD, 7xD holders.
- For use of 7xD holder, we recommend to drill a centering pre-hole with equal to or larger than 140° point angle to min. 2/3 cutting diameter.
  The use of the centering pre-hole improves hole location, roundness and surface finish.

Assembly of *i*-Dream Drills

Make sure to clean the insert and insert seat.

Slide the drill insert into the slot of the holder and press down the insert to touch the bottom of the slot.

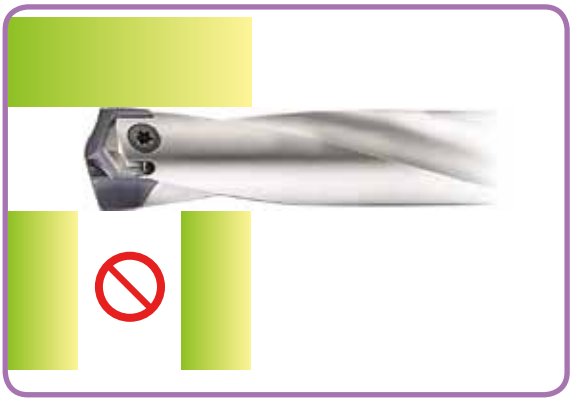
After confirming the insert is pressed down to the bottom of the slot, tighten the screw using anti-seize compound.

WRENCH TYPE	PRODUCT No.	T-HANDLE No.	SERIES
WING TYPE 	TWWT08	—	A
			B
			C
TORX BIT TYPE 	TWBT15	TWH600 	D
	TWBT20		E, F, G
	TWBT25		H, I, J

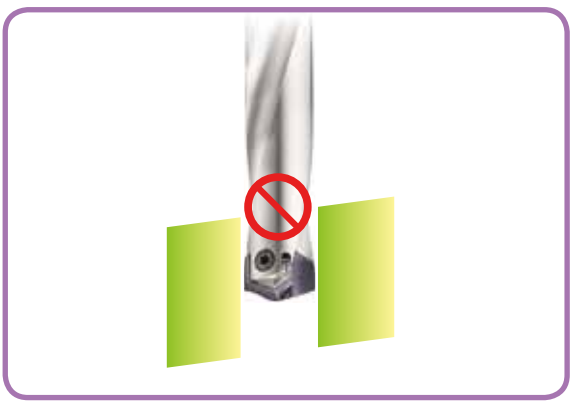
Use the wing type or T-type wrench.

- ▶ Need to use appropriate wrenches and screws as indicated.
- ▶ It's important to tighten up the screw properly.

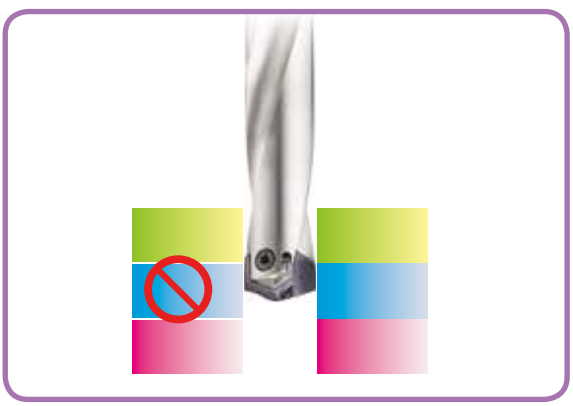
CAUTION-NOT RECOMMENDABLE APPLICATION



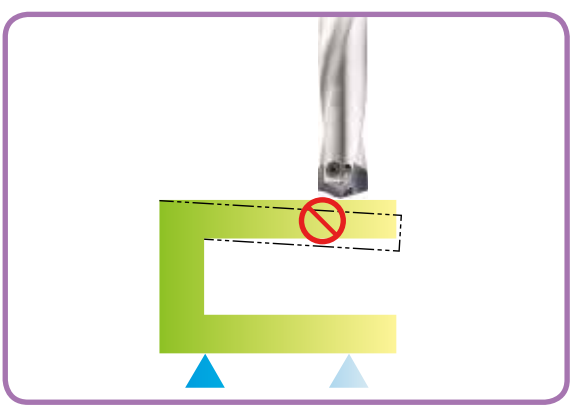
Intersecting cross hole is bigger than the drill insert's Margin Length.



Material with slanting entrance and exit over 7 degree. (If drilling 7 degree or under slanting surface, reduce the feed about 30-50 %)

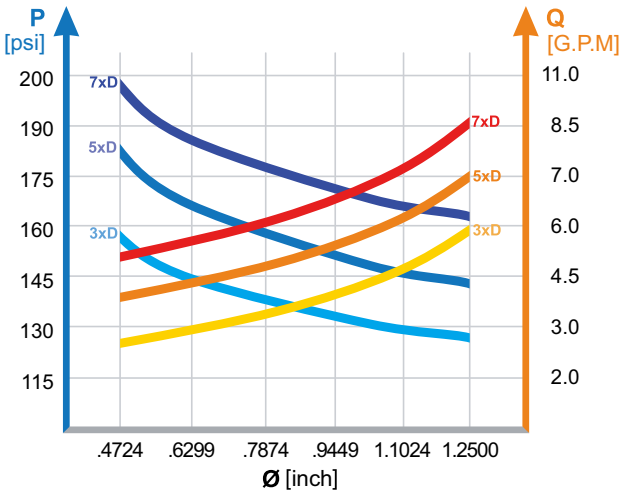


For drilling stacked plates, minimize the space between the plates.
The space stacked plates can cause insert breakage or poor chip control.



The material needs to be fixtured securely before drilling.

RECOMMENDED COOLANT PRESSURE AND FLOW RATE ON VERTICAL DRILLING



- Recommended emulsion mix is 6% - 8%.
- For Drilling in Stainless and High Strength steels, a mix of 10% is recommended.
- For horizontal drilling, 30% reduction on the coolant pressure and flow rate is possible.
- Dry drilling is possible for 1-2xD drilling. But not recommended.

TROUBLE SHOOTING

1) Heavy flank wear / Fast flank wear
- Reduce cutting speed
- Increase feed

2) Chipping on cutting edge
- Reduce feed
- Check the rigidity of spindle and chuck
- Rigid clamping of workpiece

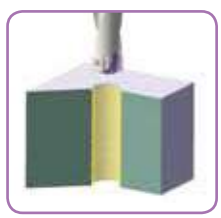
3) Build up on cutting edge
- Increase cutting speed
- Use a coated insert

4) Chipping or break down on outer corner
- Reduce feed
- Rigid clamping of workpiece

5) Wear of land margin
- Rigid clamping of workpiece
- Reduce cutting speed
- Increase coolant flow

6) Unsatisfactory positioning of the hole
- Rigid clamping of workpiece
- Reduce feed during entrance or exit

7) Scratching on holder
- Rigid clamping of workpiece
- Reduce feed
- Increase coolant flow



8) Unsatisfactory surface finish
- Rigid clamping of workpiece
- Increase coolant flow and pressure

CARBIDE

Being the best through innovation

DREAM DRILLS -GENERAL

- WITH & WITHOUT COOLANT HOLES
  General Purpose 30Rc to 50Rc Alloys

SELECTION GUIDE

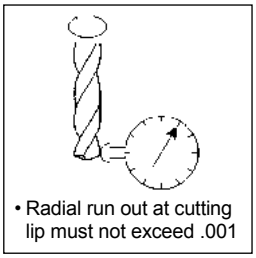
SOLID CARBIDE DREAM DRILLS-GENERAL (with & without Coolant Holes)

General Purpose HRc30 to HRc50 Alloys

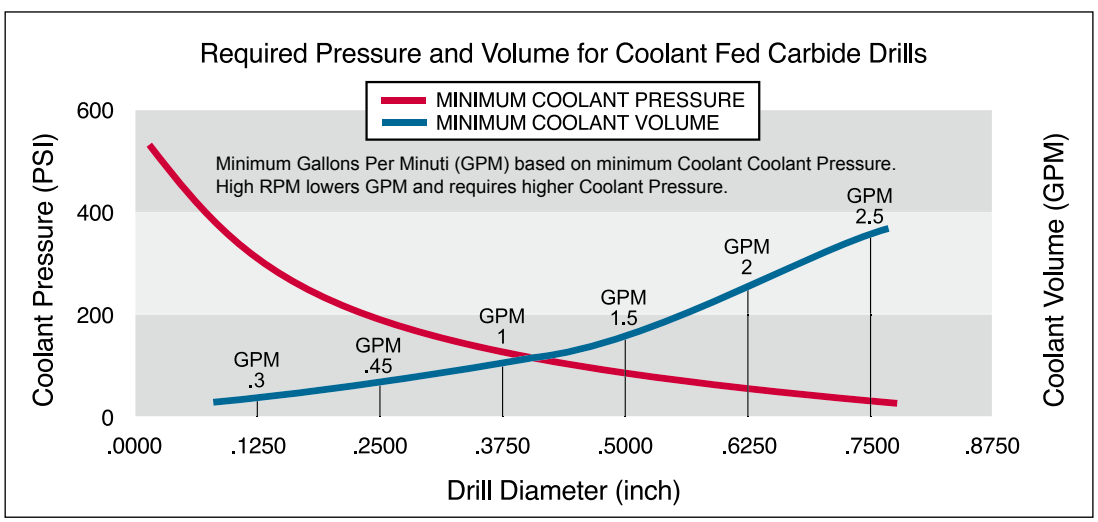
	MODEL		DESCRIPTION		SIZE MIN	SIZE MAX	PAGE
INCH							
3XD	**DH414**		CARBIDE, DREAM DRILLS without COOLANT HOLES	*STUB*	D1/8	D5/8	**58**
5XD	**DH722**		CARBIDE, DREAM DRILLS without COOLANT HOLES	*LONG*	D13/64	D1/2	**59**
3XD	**DH416 DH711**		CARBIDE, DREAM DRILLS with COOLANT HOLES	*SHORT*	D1/8	D5/6	**60**
5XD	**DH418 DH712**		CARBIDE, DREAM DRILLS with COOLANT HOLES	*LONG*	D13/64	D1/2	**62**
METRIC							
3XD	**DH404**		CARBIDE, DREAM DRILLS without COOLANT HOLES	*STUB*	D3.0	D20.0	**63**
3XD	**DH423**		CARBIDE, DREAM DRILLS without COOLANT HOLES	*SHORT*	D3.0	D20.0	**65**
5XD	**DH424**		CARBIDE, DREAM DRILLS without COOLANT HOLES	*LONG*	D1.0	D20.0	**68**
5XD	**DH406**		CARBIDE, DREAM DRILLS with COOLANT HOLES	*SHORT*	D3.0	D20.0	**71**
5XD	**DH408**		CARBIDE, DREAM DRILLS with COOLANT HOLES	*LONG*	D1.0	D20.0	**74**
8XD	**DH421**		CARBIDE, DREAM DRILLS with COOLANT HOLES	*EXTRA LONG*	D3.0	D14.0	**77**
			RECOMMENDED CUTTING CONDITIONS				**80**

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
○	◎	◎			○	○					
○	◎	◎			○	○					
○	◎	◎			○	○					
○	◎	◎			○	○					
○	◎	◎			○	○					
○	◎	◎			○	○					
○	◎	◎			○	○					
○	◎	◎			○	○					
○	◎	◎			○	○					
○	◎	◎			○	○					



• Radial run out at cutting lip must not exceed .001



DREAM DRILLS -GENERAL

DH414 SERIES

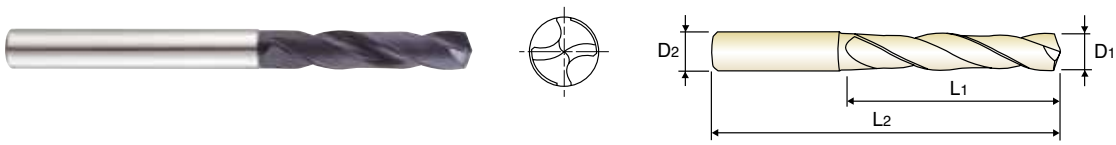
CARBIDE, DREAM DRILLS without COOLANT HOLES

STUB

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling

▶ **Tolerance** : Dia. Tolerance ∅D1: See page 253, Shank Tolerance ∅D2: -.0001 -.0005



MG | h6 | 140° | P.80

$D_1 = D_2$
3 × D

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length	EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal				Fractional	Decimal		
TiAlN	$D_1 = D_2$		L_1	L_2	TiAlN	$D_1 = D_2$		L_1	L_2
0081ATF	**1/8**	**.1250**	45/64	1-59/64	**0221ATF**	**11/32**	**.3438**	2-3/16	3-7/8
0091ATF	**9/64**	**.1406**	25/32	2-3/64	**0231ATF**	**23/64**	**.3594**	2-9/32	4
0101ATF	**5/32**	**.1562**	7/8	2-3/16	**2211ATF**	**U**	**.3680**	2-9/32	4
0111ATF	**11/64**	**.1719**	15/16	2-9/32	**0241ATF**	**3/8**	**.3750**	2-3/8	4-1/8
0121ATF	**3/16**	**.1875**	1	2-7/16	**0251ATF**	**25/64**	**.3906**	2-3/8	4-1/8
0131ATF	**13/64**	**.2031**	1	2-7/16	**0261ATF**	**13/32**	**.4062**	2-5/8	4-13/32
0141ATF	**7/32**	**.2188**	1-1/8	2-5/8	**0271ATF**	**27/64**	**.4219**	2-11/16	4-1/2
0151ATF	**15/64**	**.2344**	1-1/8	2-5/8	**0281ATF**	**7/16**	**.4375**	2-13/16	4-5/8
0161ATF	**1/4**	**.2500**	1-5/8	3-3/16	**0291ATF**	**29/64**	**.4531**	2-7/8	4-3/4
2061ATF	**F**	**.2570**	1-11/16	3-17/64	**0301ATF**	**15/32**	**.4688**	2-7/8	4-3/4
0171ATF	**17/64**	**.2656**	1-11/16	3-17/64	**0311ATF**	**31/64**	**.4844**	3	5-5/16
2091ATF	**I**	**.2720**	1-11/16	3-17/64	**0321ATF**	**1/2**	**.5000**	3-1/16	5-3/8
0181ATF	**9/32**	**.2812**	1-3/4	3-7/16	**0331ATF**	**33/64**	**.5156**	3-11/32	5-11/16
0191ATF	**19/64**	**.2969**	1-7/8	3-9/16	**0341ATF**	**17/32**	**.5312**	3-11/32	5-11/16
0201ATF	**5/16**	**.3125**	1-7/8	3-9/16	**0361ATF**	**9/16**	**.5625**	3-1/2	5-15/16
0211ATF	**21/64**	**.3281**	2-1/16	3-3/4	**0371ATF**	**37/64**	**.5781**	3-37/64	6
2171ATF	**Q**	**.3320**	2-1/16	3-3/4	**0401ATF**	**5/8**	**.6250**	3-25/3	6-19/64

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

DH722 SERIES

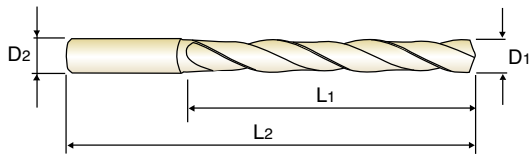
CARBIDE, DREAM DRILLS without COOLANT HOLES

LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling

▶ **Tolerance** : Dia. Tolerance ∅D1: See page 253, Shank Tolerance ∅D2: -.0001 -.0005



MG | h6 | 140° | P.80

5 × D

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH722013	13/64	.2031	1/4	1-3/4	3-15/16
DH722014	7/32	.2188	1/4	1-57/64	3-15/16
DH722015	15/64	.2344	1/4	1-57/64	3-15/16
DH722016	1/4	.2500	1/4	2-3/64	4-19/64
DH722206	F	.2570	5/16	2-13/64	4-19/64
DH722017	17/64	.2656	5/16	2-13/64	4-19/64
DH722209	I	.2720	5/16	2-13/64	4-19/64
DH722018	9/32	.2812	5/16	2-23/64	4-41/64
DH722019	19/64	.2969	5/16	2-33/64	4-41/64
DH722020	5/16	.3125	5/16	2-33/64	4-41/64
DH722021	21/64	.3281	3/8	2-43/64	5
DH722217	Q	.3320	3/8	2-43/64	5

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decim al			
TiAlN	D1		D2	L1	L2
DH722022	11/32	.3438	3/8	2-27/32	5
DH722023	23/64	.3594	3/8	3	5-23/64
DH722221	U	.3680	3/8	3	5-23/64
DH722024	3/8	.3750	3/8	3-5/32	5-23/64
DH722025	25/64	.3906	7/16	3-5/32	5-23/64
DH722026	13/32	.4062	7/16	3-5/16	5-7/8
DH722027	27/64	.4219	7/16	3-15/32	5-7/8
DH722028	7/16	.4375	7/16	3-5/8	6-7/32
DH722029	29/64	.4531	1/2	3-25/32	6-7/32
DH722030	15/32	.4688	1/2	3-25/32	6-7/32
DH722031	31/64	.4844	1/2	3-15/16	6-37/64
DH722032	1/2	.5000	1/2	4-3/32	6-37/64

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

DH416, DH711 SERIES

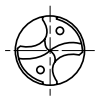
CARBIDE, DREAM DRILLS with COOLANT HOLES

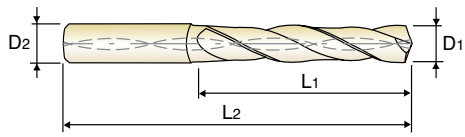
SHORT

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic

▶ **Advantage** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling

▶ **Tolerance** : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005





MG | h6 | 140° | 20 bar  P.80

3 × D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH711008	1/8	.1250	3/16	1.102	2.992
0081BTF	1/8	.1250	15/64	1.102	2.992
DH711011	11/64	.1719	3/16	1.417	3.386
0111BTF	11/64	.1719	15/64	1.417	3.386
DH711012	3/16	.1875	3/16	1.575	3.543
0121BTF	3/16	.1875	15/64	1.575	3.543
0131BTF	13/64	.2031	15/64	1.082	3.228
DH711013	13/64	.2031	1/4	1.082	3.228
0141BTF	7/32	.2188	15/64	1.181	3.228
DH711014	7/32	.2188	1/4	1.181	3.228
0151BTF	15/64	.2344	15/64	1.181	3.228
DH711015	15/64	.2344	1/4	1.181	3.228
DH711016	1/4	.2500	1/4	1.279	3.465
0161BTF	1/4	.2500	17/64	1.279	3.465
2061BTF	F	.2570	17/64	1.279	3.465
DH711206	F	.2570	5/16	1.279	3.465
0171BTF	17/64	.2656	17/64	1.378	3.465
DH711017	17/64	.2656	5/16	1.378	3.465
2091BTF	I	.2720	.2720	1.378	3.465
DH711209	I	.2720	5/16	1.378	3.465
0181BTF	9/32	.2812	5/16	1.476	3.701
0191BTF	19/64	.2969	5/16	1.476	3.701
0201BTF	5/16	.3125	5/16	1.575	3.701
0211BTF	21/64	.3281	11/32	1.673	3.937
DH711021	21/64	.3281	3/8	1.673	3.937
2171BTF	Q	.3320	11/32	1.673	3.937

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH711217	Q	.3320	3/8	1.673	3.937
0221BTF	11/32	.3438	11/32	1.772	3.937
DH711022	11/32	.3438	3/8	1.772	3.937
DH711023	23/64	.3594	3/8	1.87	4.174
0231BTF	23/64	.3594	25/64	1.870	4.174
DH711221	U	.3680	3/8	1.87	4.174
2211BTF	U	.3680	25/64	1.870	4.174
DH711024	3/8	.3750	3/8	1.969	4.174
0241BTF	3/8	.3750	25/64	1.969	4.174
0251BTF	25/64	.3906	25/64	1.969	4.174
DH711025	25/64	.3906	7/16	1.969	4.174
0261BTF	13/32	.4062	27/64	2.067	4.567
DH711026	13/32	.4062	7/16	2.067	4.567
0271BTF	27/64	.4219	27/64	2.165	4.567
DH711027	27/64	.4219	7/16	2.165	4.567
DH711028	7/16	.4375	7/16	2.264	4.803
0281BTF	7/16	.4375	15/32	2.264	4.803
0291BTF	29/64	.4531	15/32	2.264	4.803
DH711029	29/64	.4531	1/2	2.264	4.803
0301BTF	15/32	.4688	15/32	2.362	4.803
DH711030	15/32	.4688	1/2	2.362	4.803
0311BTF	31/64	.4844	1/2	2.461	5.039
0321BTF	1/2	.5000	1/2	2.559	5.039
0331BTF	33/64	.5156	35/64	2.657	5.276
DH711033	33/64	.5156	9/16	2.657	5.276
0341BTF	17/32	.5312	35/64	2.756	5.276

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

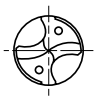
CARBIDE, DREAM DRILLS with COOLANT HOLES

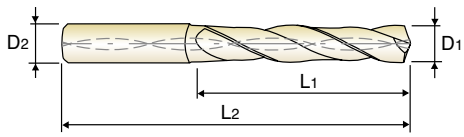
SHORT

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic

▶ **Advantage** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling

▶ **Tolerance** : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005





P.80

3 × D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal					Fractional	Decimal			
TiAlN	D1		D2	L1	L2	TiAlN	D1		D2	L1	L2
DH711034	**17/32**	**.5312**	9/16	2.756	5.276	**0371BTF**	**37/64**	**.5781**	37/64	2.953	5.512
0351BTF	**35/64**	**.5469**	35/64	2.756	5.276	**DH711037**	**37/64**	**.5781**	5/8	2.953	5.512
DH711035	**35/64**	**.5469**	9/16	2.756	5.276	**0381BTF**	**19/32**	**.5937**	5/8	3.051	5.709
DH711036	**9/16**	**.5625**	9/16	2.854	5.512	**0391BTF**	**39/64**	**.6094**	5/8	3.051	5.709
0361BTF	**9/16**	**.5625**	37/64	2.854	5.512	**0401BTF**	**5/8**	**.6250**	5/8	3.150	5.709

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

DH418, DH712 SERIES

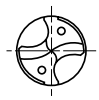
CARBIDE, DREAM DRILLS with COOLANT HOLES

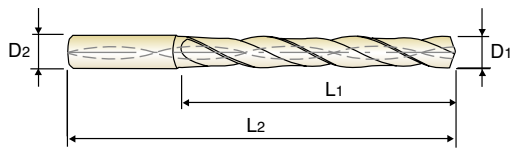
LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic

▶ **Advantage** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling

▶ **Tolerance** : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005





MG | h6 | 140° | 20 bar P.80

5 × D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
0131CTF	13/64	.2031	15/64	1-3/4	3-15/16
DH712013	13/64	.2031	1/4	1-3/4	3-15/16
0141CTF	7/32	.2188	15/64	1-57/64	3-15/16
DH712014	7/32	.2188	1/4	1-57/64	3-15/16
0151CTF	15/64	.2344	15/64	1-57/64	3-15/16
DH712015	15/64	.2344	1/4	1-57/64	3-15/16
DH712016	1/4	.2500	1/4	2-3/64	4-19/64
0161CTF	1/4	.2500	17/64	2-3/64	4-19/64
2061CTF	F	.2570	17/64	2-13/64	4-19/64
DH712206	F	.2570	5/16	2-13/64	4-19/64
0171CTF	17/64	.2656	17/64	2-13/64	4-19/64
DH712017	17/64	.2656	5/16	2-13/64	4-19/64
2091CTF	I	.2720	.2720	2-13/64	4-19/64
DH712209	I	.2720	5/16	2-13/64	4-19/64
0181CTF	9/32	.2812	5/16	2-23/64	4-41/64
0191CTF	19/64	.2969	5/16	2-33/64	4-41/64
0201CTF	5/16	.3125	5/16	2-33/64	4-41/64
0211CTF	21/64	.3281	11/32	2-43/64	5
DH712021	21/64	.3281	3/8	2-43/64	5
2171CTF	Q	.3320	11/32	2-43/64	5
DH712217	Q	.3320	3/8	2-43/64	5
0221CTF	11/32	.3438	11/32	2-27/32	5

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH712022	11/32	.3438	3/8	2-27/32	5
DH712023	23/64	.3594	3/8	3	5-23/64
0231CTF	23/64	.3594	25/64	3	5-23/64
DH712221	U	.3680	3/8	3	5-23/64
2211CTF	U	.3680	25/64	3	5-23/64
DH712024	3/8	.3750	3/8	3-5/32	5-23/64
0241CTF	3/8	.3750	25/64	3-5/32	5-23/64
0251CTF	25/64	.3906	25/64	3-5/32	5-23/64
DH712025	25/64	.3906	7/16	3-5/32	5-23/64
0261CTF	13/32	.4062	27/64	3-5/16	5-7/8
DH712026	13/32	.4062	7/16	3-5/16	5-7/8
0271CTF	27/64	.4219	27/64	3-15/32	5-7/8
DH712027	27/64	.4219	7/16	3-15/32	5-7/8
DH712028	7/16	.4375	7/16	3-5/8	6-7/32
0281CTF	7/16	.4375	15/32	3-5/8	6-7/32
0291CTF	29/64	.4531	15/32	3-25/32	6-7/32
DH712029	29/64	.4531	1/2	3-25/32	6-7/32
0301CTF	15/32	.4688	15/32	3-25/32	6-7/32
DH712030	15/32	.4688	1/2	3-25/32	6-7/32
0311CTF	31/64	.4844	1/2	3-15/16	6-37/64
0321CTF	1/2	.5000	1/2	4-3/32	6-37/64

◎ : Excellent ○ : Good

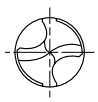
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

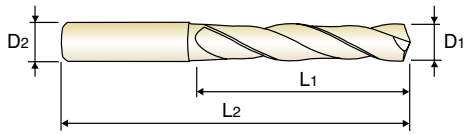
CARBIDE, DREAM DRILLS without COOLANT HOLES

STUB

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special design - reaming is not required
- good chip removal
- powerful drilling





DIN 6539 | MG | h6 | h7 | 140° | P.81

$D_1 = D_2$

3 × D

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal		
TiAlN	$D_1 = D_2$		L_1	L_2
DH404030	3.0	.1181	16	46
DH404031	3.1	.1220	18	49
DH404032	3.2	.1260	18	49
DH404033	3.3	.1299	18	49
DH404034	3.4	.1339	20	52
DH404035	3.5	.1378	20	52
DH404036	3.6	.1417	20	52
DH404037	3.7	.1457	20	52
DH404038	3.8	.1496	22	55
DH404039	3.9	.1535	22	55
DH404040	4.0	.1575	22	55
DH404041	4.1	.1614	22	55
DH404042	4.2	.1654	22	55
DH404043	4.3	.1693	24	58
DH404044	4.4	.1732	24	58
DH404045	4.5	.1772	24	58
DH404046	4.6	.1811	24	58
DH404047	4.7	.1850	24	58
DH404048	4.8	.1890	26	62
DH404049	4.9	.1929	26	62
DH404050	5.0	.1969	26	62
DH404051	5.1	.2008	26	62
DH404052	5.2	.2047	26	62
DH404053	5.3	.2087	26	62
DH404054	5.4	.2126	28	66
DH404055	5.5	.2165	28	66
DH404056	5.6	.2205	28	66

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiAlN	$D_1 = D_2$		L_1	L_2
DH404057	5.7	.2244	28	66
DH404058	5.8	.2283	28	66
DH404059	5.9	.2323	28	66
DH404060	6.0	.2362	28	66
DH404061	6.1	.2402	31	70
DH404062	6.2	.2441	31	70
DH404063	6.3	.2480	31	70
DH404064	6.4	.2520	31	70
DH404065	6.5	.2559	31	70
DH404066	6.6	.2598	31	70
DH404067	6.7	.2638	31	70
DH404068	6.8	.2677	34	74
DH404069	6.9	.2717	34	74
DH404070	7.0	.2756	34	74
DH404071	7.1	.2795	34	74
DH404072	7.2	.2835	34	74
DH404073	7.3	.2874	34	74
DH404074	7.4	.2913	34	74
DH404075	7.5	.2953	34	74
DH404076	7.6	.2992	37	79
DH404077	7.7	.3031	37	79
DH404078	7.8	.3071	37	79
DH404079	7.9	.3110	37	79
DH404080	8.0	.3150	37	79
DH404081	8.1	.3189	37	79
DH404082	8.2	.3228	37	79
DH404083	8.3	.3268	37	79

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

YG DREAM DRILLS -GENERAL

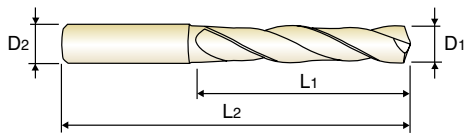
DH404 SERIES

CARBIDE, DREAM DRILLS without COOLANT HOLES

STUB

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special design - reaming is not required
- good chip removal
- powerful drilling



DIN 6539 | MG | h6 | h7 | 140° | P.81

$D_1 = D_2$
3 × D

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiAlN	$D_1 = D_2$		L_1	L_2
DH404084	8.4	.3307	37	79
DH404085	8.5	.3346	37	79
DH404086	8.6	.3386	40	84
DH404087	8.7	.3425	40	84
DH404088	8.8	.3465	40	84
DH404089	8.9	.3504	40	84
DH404090	9.0	.3543	40	84
DH404091	9.1	.3583	40	84
DH404092	9.2	.3622	40	84
DH404093	9.3	.3661	40	84
DH404094	9.4	.3701	40	84
DH404095	9.5	.3740	40	84
DH404096	9.6	.3780	43	89
DH404097	9.7	.3819	43	89
DH404098	9.8	.3858	43	89
DH404099	9.9	.3898	43	89
DH404100	10.0	.3937	43	89
DH404102	10.2	.4016	43	89
DH404105	10.5	.4134	43	89

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiAlN	$D_1 = D_2$		L_1	L_2
DH404110	11.0	.4331	47	95
DH404115	11.5	.4528	47	95
DH404120	12.0	.4724	51	102
DH404130	13.0	.5118	51	102
DH404135	13.5	.5314	54	107
DH404140	14.0	.5512	54	107
DH404145	14.5	.5708	56	111
DH404150	15.0	.5905	56	111
DH404155	15.5	.6102	58	115
DH404160	16.0	.6299	58	115
DH404165	16.5	.6495	60	119
DH404170	17.0	.6692	60	119
DH404175	17.5	.6889	62	123
DH404180	18.0	.7087	62	123
DH404185	18.5	.7283	64	127
DH404190	19.0	.7480	64	127
DH404195	19.5	.7676	66	131
DH404200	20.0	.7874	66	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

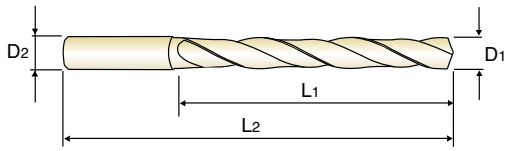
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

CARBIDE, DREAM DRILLS without COOLANT HOLES

SHORT

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special design - reaming is not required
- good chip removal
- powerful drilling



DIN 6537 | MG | h6 | m7 | 140° | P.81

3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH423030	3.0		.1181	6	20	62	DH423051	5.1		.2008	6	28	66
DH423031	3.1		.1220	6	20	62	DH423013F	5.159	13/64	.2031	6	28	66
DH423008F	3.175	1/8	.1250	6	20	62	DH423052	5.2		.2047	6	28	66
DH423032	3.2		.1260	6	20	62	DH423053	5.3		.2087	6	28	66
DH423033	3.3		.1299	6	20	62	DH423054	5.4		.2126	6	28	66
DH423034	3.4		.1339	6	20	62	DH423055	5.5		.2165	6	28	66
DH423035	3.5		.1378	6	20	62	DH423014F	5.556	7/32	.2188	6	28	66
DH423009F	3.572	9/64	.1406	6	20	62	DH423056	5.6		.2205	6	28	66
DH423036	3.6		.1417	6	20	62	DH423057	5.7		.2244	6	28	66
DH423037	3.7		.1457	6	20	62	DH423058	5.8		.2283	6	28	66
DH423038	3.8		.1496	6	24	66	DH423059	5.9		.2323	6	28	66
DH423039	3.9		.1535	6	24	66	DH423015F	5.953	15/64	.2344	6	28	66
DH423010F	3.969	5/32	.1563	6	24	66	DH423060	6.0		.2362	6	28	66
DH423040	4.0		.1575	6	24	66	DH423061	6.1		.2402	8	34	79
DH423041	4.1		.1614	6	24	66	DH423062	6.2		.2441	8	34	79
DH423042	4.2		.1654	6	24	66	DH423063	6.3		.2480	8	34	79
DH423043	4.3		.1693	6	24	66	DH423016F	6.350	1/4	.2500	8	34	79
DH423011F	4.366	11/64	.1719	6	24	66	DH423064	6.4		.2520	8	34	79
DH423044	4.4		.1732	6	24	66	DH423065	6.5		.2559	8	34	79
DH423045	4.5		.1772	6	24	66	DH423066	6.6		.2598	8	34	79
DH423046	4.6		.1811	6	24	66	DH423067	6.7		.2638	8	34	79
DH423047	4.7		.1850	6	24	66	DH423017F	6.747	17/64	.2656	8	34	79
DH423012F	4.763	3/16	.1875	6	24	66	DH423068	6.8		.2677	8	34	79
DH423048	4.8		.1890	6	28	66	DH423069	6.9		.2717	8	34	79
DH423049	4.9		.1929	6	28	66	DH423070	7.0		.2756	8	34	79
DH423050	5.0		.1969	6	28	66	DH423071	7.1		.2795	8	41	79

▶ NEXT PAGE

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium	
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~									
○	◎	◎				○	○						

DREAM DRILLS -GENERAL

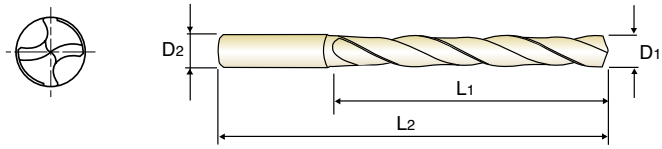
DH423 SERIES

CARBIDE, DREAM DRILLS without COOLANT HOLES

SHORT

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special design - reaming is not required
- good chip removal
- powerful drilling



DIN 6537 | MG | h6 | m7 | 140° | P.81

3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH423018F	7.144	9/32	.2812	8	41	79	DH423092	9.2		.3622	10	47	89
DH423072	7.2		.2835	8	41	79	DH423093	9.3		.3661	10	47	89
DH423073	7.3		.2874	8	41	79	DH423094	9.4		.3701	10	47	89
DH423074	7.4		.2913	8	41	79	DH423095	9.5		.3740	10	47	89
DH423075	7.5		.2953	8	41	79	DH423024F	9.525	3/8	.3750	10	47	89
DH423019F	7.541	19/64	.2969	8	41	79	DH423096	9.6		.3780	10	47	89
DH423076	7.6		.2992	8	41	79	DH423097	9.7		.3819	10	47	89
DH423077	7.7		.3031	8	41	79	DH423098	9.8		.3858	10	47	89
DH423078	7.8		.3071	8	41	79	DH423099	9.9		.3898	10	47	89
DH423079	7.9		.3110	8	41	79	DH423025F	9.922	25/64	.3906	10	47	89
DH423020F	7.938	5/16	.3125	8	41	79	DH423100	10.0		.3937	10	47	89
DH423080	8.0		.3150	8	41	79	DH423101	10.1		.3976	12	55	102
DH423081	8.1		.3189	10	47	89	DH423102	10.2		.4016	12	55	102
DH423082	8.2		.3228	10	47	89	DH423103	10.3		.4055	12	55	102
DH423083	8.3		.3268	10	47	89	DH423026F	10.319	13/32	.4062	12	55	102
DH423021F	8.334	21/64	.3281	10	47	89	DH423104	10.4		.4094	12	55	102
DH423084	8.4		.3307	10	47	89	DH423105	10.5		.4134	12	55	102
DH423085	8.5		.3346	10	47	89	DH423106	10.6		.4173	12	55	102
DH423086	8.6		.3386	10	47	89	DH423107	10.7		.4213	12	55	102
DH423087	8.7		.3425	10	47	89	DH423027F	10.716	27/64	.4219	12	55	102
DH423022F	8.731	11/32	.3438	10	47	89	DH423108	10.8		.4252	12	55	102
DH423088	8.8		.3465	10	47	89	DH423109	10.9		.4291	12	55	102
DH423089	8.9		.3504	10	47	89	DH423110	11.0		.4331	12	55	102
DH423090	9.0		.3543	10	47	89	DH423111	11.1		.4370	12	55	102
DH423091	9.1		.3583	10	47	89	DH423028F	11.113	7/16	.4375	12	55	102
DH423023F	9.128	23/64	.3594	10	47	89	DH423112	11.2		.4409	12	55	102

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

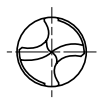
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

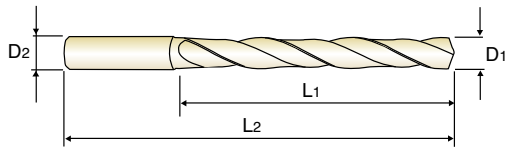
CARBIDE, DREAM DRILLS without COOLANT HOLES

SHORT

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special design - reaming is not required
- good chip removal
- powerful drilling





DIN 6537 | MG | h6 | m7 | 140° | P.81

3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH423113	11.3		.4449	12	55	102
DH423114	11.4		.4488	12	55	102
DH423115	11.5		.4528	12	55	102
DH423029F	11.509	29/64	.4531	12	55	102
DH423116	11.6		.4567	12	55	102
DH423117	11.7		.4606	12	55	102
DH423118	11.8		.4646	12	55	102
DH423119	11.9		.4685	12	55	102
DH423030F	11.906	15/32	.4688	12	55	102
DH423120	12.0		.4724	12	55	102
DH423123	12.3		.4843	14	60	107
DH423031F	12.303	31/64	.4844	14	60	107
DH423125	12.5		.4921	14	60	107
DH423032F	12.7	1/2	.5000	14	60	107
DH423128	12.8		.5039	14	60	107
DH423130	13.0		.5118	14	60	107
DH423135	13.5		.5315	14	60	107
DH423138	13.8		.5433	14	60	107
DH423140	14.0		.5512	14	60	107
DH423036F	14.288	9/16	.5625	16	65	115

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH423145	14.5		.5708	16	65	115
DH423148	14.8		.5827	16	65	115
DH423150	15.0		.5905	16	65	115
DH423155	15.5		.6102	16	65	115
DH423158	15.8		.6220	16	65	115
DH423040F	15.875	5/8	.6250	16	65	115
DH423160	16.0		.6299	16	65	115
DH423165	16.5		.6495	18	73	123
DH423168	16.8		.6614	18	73	123
DH423170	17.0		.6692	18	73	123
DH423044F	17.463	11/16	.6875	18	73	123
DH423175	17.5		.6889	18	73	123
DH423178	17.8		.7008	18	73	123
DH423180	18.0		.7087	18	73	123
DH423185	18.5		.7283	20	79	131
DH423190	19.0		.7480	20	79	131
DH423048F	19.05	3/4	.7500	20	79	131
DH423195	19.5		.7676	20	79	131
DH423198	19.8		.7795	20	79	131
DH423200	20.0		.7874	20	79	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

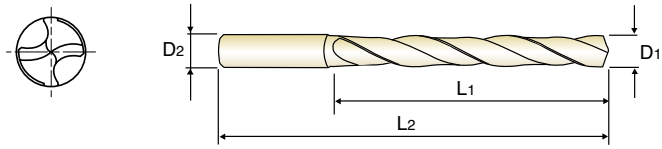
DH424 SERIES

CARBIDE, DREAM DRILLS without COOLANT HOLES

LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special design - reaming is not required
- good chip removal
- powerful drilling



DIN 6537 | MG | h6 | m7 | 140° | P.81

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH424010	1.0		.0394	3	8	55	DH424033	3.3		.1299	6	28	66
DH424011	1.1		.0433	3	12	55	DH424034	3.4		.1339	6	28	66
DH424012	1.2		.0472	3	12	55	DH424035	3.5		.1378	6	28	66
DH424013	1.3		.0512	3	12	55	DH424009F	3.572	9/64	.1406	6	28	66
DH424014	1.4		.0551	3	12	55	DH424036	3.6		.1417	6	28	66
DH424015	1.5		.0591	3	16	55	DH424037	3.7		.1457	6	28	66
DH424004F	1.588	1/16	.0625	3	16	55	DH424038	3.8		.1496	6	36	74
DH424016	1.6		.0630	3	16	55	DH424039	3.9		.1535	6	36	74
DH424017	1.7		.0669	3	16	55	DH424010F	3.969	5/32	.1563	6	36	74
DH424018	1.8		.0709	3	16	55	DH424040	4.0		.1575	6	36	74
DH424019	1.9		.0748	3	16	55	DH424041	4.1		.1614	6	36	74
DH424005F	1.984	5/64	.0781	3	16	55	DH424042	4.2		.1654	6	36	74
DH424020	2.0		.0787	4	21	57	DH424043	4.3		.1693	6	36	74
DH424021	2.1		.0827	4	21	57	DH424011F	4.366	11/64	.1719	6	36	74
DH424022	2.2		.0866	4	21	57	DH424044	4.4		.1732	6	36	74
DH424023	2.3		.0906	4	21	57	DH424045	4.5		.1772	6	36	74
DH424006F	2.381	3/32	.0938	4	21	57	DH424046	4.6		.1811	6	36	74
DH424024	2.4		.0945	4	21	57	DH424047	4.7		.1850	6	36	74
DH424025	2.5		.0984	4	21	57	DH424012F	4.763	3/16	.1875	6	36	74
DH424026	2.6		.1024	4	21	57	DH424048	4.8		.1890	6	44	82
DH424027	2.7		.1063	4	21	57	DH424049	4.9		.1929	6	44	82
DH424007F	2.778	7/64	.1094	4	21	57	DH424050	5.0		.1969	6	44	82
DH424028	2.8		.1102	4	21	57	DH424051	5.1		.2008	6	44	82
DH424029	2.9		.1142	4	21	57	DH424013F	5.159	13/64	.2031	6	44	82
DH424030	3.0		.1181	6	28	66	DH424052	5.2		.2047	6	44	82
DH424031	3.1		.1220	6	28	66	DH424053	5.3		.2087	6	44	82
DH424008F	3.175	1/8	.1250	6	28	66	DH424054	5.4		.2126	6	44	82
DH424032	3.2		.1260	6	28	66	DH424055	5.5		.2165	6	44	82

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium	
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~									
○	◎	◎				○	○						

DREAM DRILLS -GENERAL

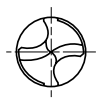
DH424 SERIES

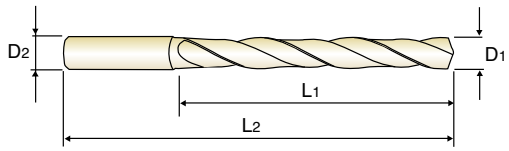
CARBIDE, DREAM DRILLS without COOLANT HOLES

LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special design - reaming is not required
- good chip removal
- powerful drilling





DIN 6537 | MG | h6 | m7 | 140° | P.81

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH424014F	5.556	7/32	.2188	6	44	82
DH424056	5.6		.2205	6	44	82
DH424057	5.7		.2244	6	44	82
DH424058	5.8		.2283	6	44	82
DH424059	5.9		.2323	6	44	82
DH424015F	5.953	15/64	.2344	6	44	82
DH424060	6.0		.2362	6	44	82
DH424061	6.1		.2402	8	53	91
DH424062	6.2		.2441	8	53	91
DH424063	6.3		.2480	8	53	91
DH424016F	6.35	1/4	.2500	8	53	91
DH424064	6.4		.2520	8	53	91
DH424065	6.5		.2559	8	53	91
DH424066	6.6		.2598	8	53	91
DH424067	6.7		.2638	8	53	91
DH424017F	6.747	17/64	.2656	8	53	91
DH424068	6.8		.2677	8	53	91
DH424069	6.9		.2717	8	53	91
DH424070	7.0		.2756	8	53	91
DH424071	7.1		.2795	8	53	91
DH424018F	7.144	9/32	.2812	8	53	91
DH424072	7.2		.2835	8	53	91
DH424073	7.3		.2874	8	53	91
DH424074	7.4		.2913	8	53	91
DH424075	7.5		.2953	8	53	91
DH424019F	7.541	19/64	.2969	8	53	91
DH424076	7.6		.2992	8	53	91
DH424077	7.7		.3031	8	53	91

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH424078	7.8		.3071	8	53	91
DH424079	7.9		.3110	8	53	91
DH424020F	7.938	5/16	.3125	8	53	91
DH424080	8.0		.3150	8	53	91
DH424081	8.1		.3189	10	61	103
DH424082	8.2		.3228	10	61	103
DH424083	8.3		.3268	10	61	103
DH424021F	8.334	21/64	.3281	10	61	103
DH424084	8.4		.3307	10	61	103
DH424085	8.5		.3346	10	61	103
DH424086	8.6		.3386	10	61	103
DH424087	8.7		.3425	10	61	103
DH424022F	8.731	11/32	.3438	10	61	103
DH424088	8.8		.3465	10	61	103
DH424089	8.9		.3504	10	61	103
DH424090	9.0		.3543	10	61	103
DH424091	9.1		.3583	10	61	103
DH424023F	9.128	23/64	.3594	10	61	103
DH424092	9.2		.3622	10	61	103
DH424093	9.3		.3661	10	61	103
DH424094	9.4		.3701	10	61	103
DH424095	9.5		.3740	10	61	103
DH424024F	9.525	3/8	.3750	10	61	103
DH424096	9.6		.3780	10	61	103
DH424097	9.7		.3819	10	61	103
DH424098	9.8		.3858	10	61	103
DH424099	9.9		.3898	10	61	103
DH424025F	9.922	25/64	.3906	10	61	103

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

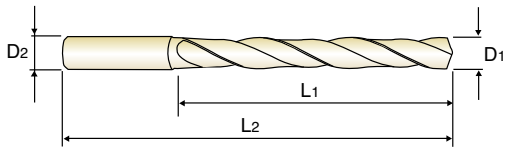
DH424 SERIES

CARBIDE, DREAM DRILLS without COOLANT HOLES

LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special design - reaming is not required
- good chip removal
- powerful drilling



DIN 6537 | MG | h6 | m7 | 140° | P.81

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH424100	10.0		.3937	10	61	103
DH424101	10.1		.3976	12	71	118
DH424102	10.2		.4016	12	71	118
DH424103	10.3		.4055	12	71	118
DH424026F	10.319	13/32	.4062	12	71	118
DH424104	10.4		.4094	12	71	118
DH424105	10.5		.4134	12	71	118
DH424106	10.6		.4173	12	71	118
DH424107	10.7		.4213	12	71	118
DH424027F	10.716	27/64	.4219	12	71	118
DH424108	10.8		.4252	12	71	118
DH424109	10.9		.4291	12	71	118
DH424110	11.0		.4331	12	71	118
DH424111	11.1		.4370	12	71	118
DH424028F	11.113	7/16	.4375	12	71	118
DH424112	11.2		.4409	12	71	118
DH424113	11.3		.4449	12	71	118
DH424114	11.4		.4488	12	71	118
DH424115	11.5		.4528	12	71	118
DH424029F	11.509	29/64	.4531	12	71	118
DH424116	11.6		.4567	12	71	118
DH424117	11.7		.4606	12	71	118
DH424118	11.8		.4646	12	71	118
DH424119	11.9		.4685	12	71	118
DH424030F	11.906	15/32	.4688	12	71	118
DH424120	12.0		.4724	12	71	118
DH424123	12.3		.4843	14	77	124
DH424031F	12.303	31/64	.4844	14	77	124

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH424125	12.5		.4921	14	77	124
DH424032F	12.7	1/2	.5000	14	77	124
DH424128	12. 8		.5039	14	77	124
DH424130	13.0		.5118	14	77	124
DH424135	13.5		.5315	14	77	124
DH424138	13.8		.5433	14	77	124
DH424140	14.0		.5512	14	77	124
DH424036F	14.288	9/16	.5625	16	83	133
DH424145	14.5		.5708	16	83	133
DH424148	14.8		.5827	16	83	133
DH424150	15.0		.5905	16	83	133
DH424155	15.5		.6102	16	83	133
DH424158	15.8		.6220	16	83	133
DH424040F	15.875	5/8	.6250	16	83	133
DH424160	16.0		.6299	16	83	133
DH424165	16.5		.6495	18	93	143
DH424168	16.8		.6614	18	93	143
DH424170	17.0		.6692	18	93	143
DH424175	17.5		.6889	18	93	143
DH424178	17.8		.7008	18	93	143
DH424180	18.0		.7087	18	93	143
DH424185	18.5		.7283	20	101	153
DH424190	19.0		.7480	20	101	153
DH424048F	19.05	3/4	.7500	20	101	153
DH424195	19.5		.7676	20	101	153
DH424198	19.8		.7795	20	101	153
DH424200	20.0		.7874	20	101	153

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

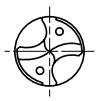
DH406 SERIES

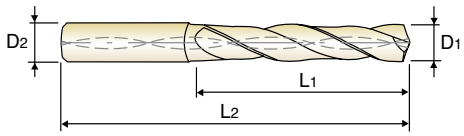
CARBIDE, DREAM DRILLS with COOLANT HOLES

SHORT

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.82

3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH406030	3.0		.1181	6	20	62
DH406031	3.1		.1220	6	20	62
DH406008F	3.175	1/8	.1250	6	20	62
DH406032	3.2		.1260	6	20	62
DH406033	3.3		.1299	6	20	62
DH406034	3.4		.1339	6	20	62
DH406035	3.5		.1378	6	20	62
DH406009F	3.572	9/64	.1406	6	20	62
DH406036	3.6		.1417	6	20	62
DH406037	3.7		.1457	6	20	62
DH406038	3.8		.1496	6	24	66
DH406039	3.9		.1535	6	24	66
DH406010F	3.969	5/32	.1563	6	24	66
DH406040	4.0		.1575	6	24	66
DH406041	4.1		.1614	6	24	66
DH406042	4.2		.1654	6	24	66
DH406043	4.3		.1693	6	24	66
DH406011F	4.366	11/64	.1719	6	24	66
DH406044	4.4		.1732	6	24	66
DH406045	4.5		.1772	6	24	66
DH406046	4.6		.1811	6	24	66
DH406047	4.7		.1850	6	24	66
DH406012F	4.763	3/16	.1875	6	24	66
DH406048	4.8		.1890	6	28	66
DH406049	4.9		.1929	6	28	66
DH406050	5.0		.1969	6	28	66
DH406051	5.1		.2008	6	28	66
DH406013F	5.159	13/64	.2031	6	28	66

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH406052	5.2		.2047	6	28	66
DH406053	5.3		.2087	6	28	66
DH406054	5.4		.2126	6	28	66
DH406055	5.5		.2165	6	28	66
DH406014F	5.556	7/32	.2188	6	28	66
DH406056	5.6		.2205	6	28	66
DH406057	5.7		.2244	6	28	66
DH406058	5.8		.2283	6	28	66
DH406059	5.9		.2323	6	28	66
DH406015F	5.953	15/64	.2344	6	28	66
DH406060	6.0		.2362	6	28	66
DH406061	6.1		.2402	8	34	79
DH406062	6.2		.2441	8	34	79
DH406063	6.3		.2480	8	34	79
DH406016F	6.35	1/4	.2500	8	34	79
DH406064	6.4		.2520	8	34	79
DH406065	6.5		.2559	8	34	79
DH406066	6.6		.2598	8	34	79
DH406067	6.7		.2638	8	34	79
DH406017F	6.747	17/64	.2656	8	34	79
DH406068	6.8		.2677	8	34	79
DH406069	6.9		.2717	8	34	79
DH406070	7.0		.2756	8	34	79
DH406071	7.1		.2795	8	41	79
DH406018F	7.144	9/32	.2812	8	41	79
DH406072	7.2		.2835	8	41	79
DH406073	7.3		.2874	8	41	79
DH406074	7.4		.2913	8	41	79

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

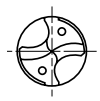
DH406 SERIES

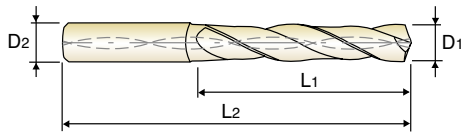
CARBIDE, DREAM DRILLS with COOLANT HOLES

SHORT

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.82

3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH406075	7.5		.2953	8	41	79
DH406019F	7.541	19/64	.2969	8	41	79
DH406076	7.6		.2992	8	41	79
DH406077	7.7		.3031	8	41	79
DH406078	7.8		.3071	8	41	79
DH406079	7.9		.3110	8	41	79
DH406020F	7.938	5/16	.3125	8	41	79
DH406080	8.0		.3150	8	41	79
DH406081	8.1		.3189	10	47	89
DH406082	8.2		.3228	10	47	89
DH406083	8.3		.3268	10	47	89
DH406021F	8.334	21/64	.3281	10	47	89
DH406084	8.4		.3307	10	47	89
DH406085	8.5		.3346	10	47	89
DH406086	8.6		.3386	10	47	89
DH406087	8.7		.3425	10	47	89
DH406022F	8.731	11/32	.3438	10	47	89
DH406088	8.8		.3465	10	47	89
DH406089	8.9		.3504	10	47	89
DH406090	9.0		.3543	10	47	89
DH406091	9.1		.3583	10	47	89
DH406023F	9.128	23/64	.3594	10	47	89
DH406092	9.2		.3622	10	47	89
DH406093	9.3		.3661	10	47	89
DH406094	9.4		.3701	10	47	89
DH406095	9.5		.3740	10	47	89
DH406024F	9.525	3/8	.3750	10	47	89
DH406096	9.6		.3780	10	47	89

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH406097	9.7		.3819	10	47	89
DH406098	9.8		.3858	10	47	89
DH406099	9.9		.3898	10	47	89
DH406025F	9.922	25/64	.3906	10	47	89
DH406100	10.0		.3937	10	47	89
DH406101	10.1		.3976	12	55	102
DH406102	10.2		.4016	12	55	102
DH406103	10.3		.4055	12	55	102
DH406026F	10.319	13/32	.4062	12	55	102
DH406104	10.4		.4094	12	55	102
DH406105	10.5		.4134	12	55	102
DH406106	10.6		.4173	12	55	102
DH406107	10.7		.4212	12	55	102
DH406027F	10.716	27/64	.4219	12	55	102
DH406108	10.8		.4252	12	55	102
DH406109	10.9		.4291	12	55	102
DH406110	11.0		.4330	12	55	102
DH406111	11.1		.4370	12	55	102
DH406028F	11.113	7/16	.4375	12	55	102
DH406112	11.2		.4409	12	55	102
DH406113	11.3		.4448	12	55	102
DH406114	11.4		.4488	12	55	102
DH406115	11.5		.4527	12	55	102
DH406029F	11.509	29/64	.4531	12	55	102
DH406116	11.6		.4566	12	55	102
DH406117	11.7		.4606	12	55	102
DH406118	11.8		.4645	12	55	102
DH406119	11.9		.4685	12	55	102

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

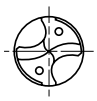
DH406 SERIES

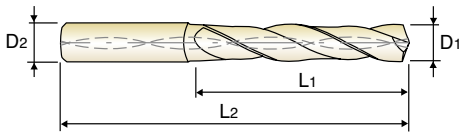
CARBIDE, DREAM DRILLS with COOLANT HOLES

SHORT

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling





DIN 6537 | MG | h6 | m7 | 140° | 20 bar | P.82

3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH406030F	11.906	15/32	.4688	12	55	102
DH406120	12.0		.4724	12	55	102
DH406031F	12.303	31/64	.4844	14	60	107
DH406125	12.5		.4921	14	60	107
DH406032F	12.7	1/2	.5000	14	60	107
DH406130	13.0		.5118	14	60	107
DH406135	13.5		.5314	14	60	107
DH406140	14.0		.5512	14	60	107
DH406036F	14.288	9/16	.5625	16	65	115
DH406145	14.5		.5708	16	65	115
DH406150	15.0		.5905	16	65	115
DH406155	15.5		.6102	16	65	115

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH406040F	15.875	5/8	.6250	16	65	115
DH406160	16.0		.6299	16	65	115
DH406165	16.5		.6495	18	73	123
DH406170	17.0		.6692	18	73	123
DH406044F	17.463	11/16	.6875	18	73	123
DH406175	17.5		.6889	18	73	123
DH406180	18.0		.7087	18	73	123
DH406185	18.5		.7283	20	79	131
DH406190	19.0		.7480	20	79	131
DH406048F	19.05	3/4	.7500	20	79	131
DH406195	19.5		.7676	20	79	131
DH406200	20.0		.7874	20	79	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

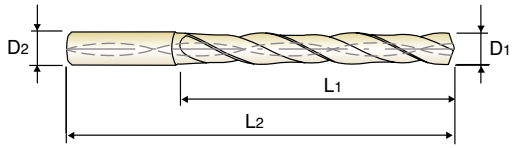
DH408 SERIES

CARBIDE, DREAM DRILLS with COOLANT HOLES

LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.82

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH408010	1.0		.0394	3	8	55	DH408033	3.3		.1299	6	28	66
DH408011	1.1		.0433	3	12	55	DH408034	3.4		.1339	6	28	66
DH408012	1.2		.0472	3	12	55	DH408035	3.5		.1378	6	28	66
DH408013	1.3		.0512	3	12	55	DH408009F	3.572	9/64	.1406	6	28	66
DH408014	1.4		.0551	3	12	55	DH408036	3.6		.1417	6	28	66
DH408015	1.5		.0591	3	16	55	DH408037	3.7		.1457	6	28	66
DH408004F	1.588	1/16	.0625	3	16	55	DH408038	3.8		.1496	6	36	74
DH408016	1.6		.0630	3	16	55	DH408039	3.9		.1535	6	36	74
DH408017	1.7		.0669	3	16	55	DH408010F	3.969	5/32	.1563	6	36	74
DH408018	1.8		.0709	3	16	55	DH408040	4.0		.1575	6	36	74
DH408019	1.9		.0748	3	16	55	DH408041	4.1		.1614	6	36	74
DH408005F	1.984	5/64	.0781	3	16	55	DH408042	4.2		.1654	6	36	74
DH408020	2.0		.0787	4	21	57	DH408043	4.3		.1693	6	36	74
DH408021	2.1		.0827	4	21	57	DH408011F	4.366	11/64	.1719	6	36	74
DH408022	2.2		.0866	4	21	57	DH408044	4.4		.1732	6	36	74
DH408023	2.3		.0906	4	21	57	DH408045	4.5		.1772	6	36	74
DH408006F	2.381	3/32	.0938	4	21	57	DH408046	4.6		.1811	6	36	74
DH408024	2.4		.0945	4	21	57	DH408047	4.7		.1850	6	36	74
DH408025	2.5		.0984	4	21	57	DH408012F	4.763	3/16	.1875	6	36	74
DH408026	2.6		.1024	4	21	57	DH408048	4.8		.1890	6	44	82
DH408027	2.7		.1063	4	21	57	DH408049	4.9		.1929	6	44	82
DH408007F	2.778	7/64	.1094	4	21	57	DH408050	5.0		.1969	6	44	82
DH408028	2.8		.1102	4	21	57	DH408051	5.1		.2008	6	44	82
DH408029	2.9		.1142	4	21	57	DH408013F	5.159	13/64	.2031	6	44	82
DH408030	3.0		.1181	6	28	66	DH408052	5.2		.2047	6	44	82
DH408031	3.1		.1220	6	28	66	DH408053	5.3		.2087	6	44	82
DH408008F	3.175	1/8	.1250	6	28	66	DH408054	5.4		.2126	6	44	82
DH408032	3.2		.1260	6	28	66	DH408055	5.5		.2165	6	44	82

▶ NEXT PAGE

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP		Titanium
~HB225	HB225~325	HRc30~45	HRc45~55		HRc55~								
○	◎	◎				○	○						

DREAM DRILLS -GENERAL

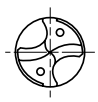
DH408 SERIES

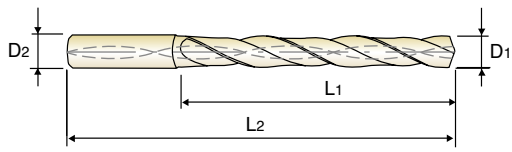
CARBIDE, DREAM DRILLS with COOLANT HOLES

LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.82

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH408014F	5.556	7/32	.2188	6	44	82
DH408056	5.6		.2205	6	44	82
DH408057	5.7		.2244	6	44	82
DH408058	5.8		.2283	6	44	82
DH408059	5.9		.2323	6	44	82
DH408015F	5.953	15/64	.2344	6	44	82
DH408060	6.0		.2362	6	44	82
DH408061	6.1		.2402	8	53	91
DH408062	6.2		.2441	8	53	91
DH408063	6.3		.2480	8	53	91
DH408016F	6.35	1/4	.2500	8	53	91
DH408064	6.4		.2520	8	53	91
DH408065	6.5		.2559	8	53	91
DH408066	6.6		.2598	8	53	91
DH408067	6.7		.2638	8	53	91
DH408017F	6.747	17/64	.2656	8	53	91
DH408068	6.8		.2677	8	53	91
DH408069	6.9		.2717	8	53	91
DH408070	7.0		.2756	8	53	91
DH408071	7.1		.2795	8	53	91
DH408018F	7.144	9/32	.2812	8	53	91
DH408072	7.2		.2835	8	53	91
DH408073	7.3		.2874	8	53	91
DH408074	7.4		.2913	8	53	91
DH408075	7.5		.2953	8	53	91
DH408019F	7.541	19/64	.2969	8	53	91
DH408076	7.6		.2992	8	53	91
DH408077	7.7		.3031	8	53	91

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH408078	7.8		.3071	8	53	91
DH408079	7.9		.3110	8	53	91
DH408020F	7.938	5/16	.3125	8	53	91
DH408080	8.0		.3150	8	53	91
DH408081	8.1		.3189	10	61	103
DH408082	8.2		.3228	10	61	103
DH408083	8.3		.3268	10	61	103
DH408021F	8.334	21/64	.3281	10	61	103
DH408084	8.4		.3307	10	61	103
DH408085	8.5		.3346	10	61	103
DH408086	8.6		.3386	10	61	103
DH408087	8.7		.3425	10	61	103
DH408022F	8.731	11/32	.3438	10	61	103
DH408088	8.8		.3465	10	61	103
DH408089	8.9		.3504	10	61	103
DH408090	9.0		.3543	10	61	103
DH408091	9.1		.3583	10	61	103
DH408023F	9.128	23/64	.3594	10	61	103
DH408092	9.2		.3622	10	61	103
DH408093	9.3		.3661	10	61	103
DH408094	9.4		.3701	10	61	103
DH408095	9.5		.3740	10	61	103
DH408024F	9.525	3/8	.3750	10	61	103
DH408096	9.6		.3780	10	61	103
DH408097	9.7		.3819	10	61	103
DH408098	9.8		.3858	10	61	103
DH408099	9.9		.3898	10	61	103
DH408025F	9.922	25/64	.3906	10	61	103

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

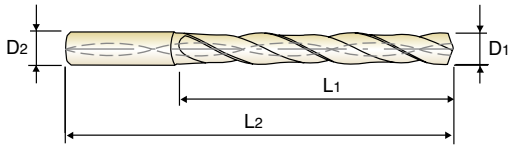
DH408 SERIES

CARBIDE, DREAM DRILLS with COOLANT HOLES

LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.82

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH408100	10.0		.3937	10	61	103
DH408101	10.1		.3976	12	71	118
DH408102	10.2		.4016	12	71	118
DH408103	10.3		.4055	12	71	118
DH408026F	10.319	13/32	.4062	12	71	118
DH408104	10.4		.4094	12	71	118
DH408105	10.5		.4134	12	71	118
DH408106	10.6		.4173	12	71	118
DH408107	10.7		.4212	12	71	118
DH408027F	10.716	27/64	.4219	12	71	118
DH408108	10.8		.4252	12	71	118
DH408109	10.9		.4291	12	71	118
DH408110	11.0		.4330	12	71	118
DH408111	11.1		.4370	12	71	118
DH408028F	11.113	7/16	.4375	12	71	118
DH408112	11.2		.4409	12	71	118
DH408113	11.3		.4448	12	71	118
DH408114	11.4		.4488	12	71	118
DH408115	11.5		.4527	12	71	118
DH408029F	11.509	29/64	.4531	12	71	118
DH408116	11.6		.4566	12	71	118
DH408117	11.7		.4606	12	71	118
DH408118	11.8		.4645	12	71	118
DH408119	11.9		.4685	12	71	118

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH408030F	11.906	15/32	.4688	12	71	118
DH408120	12.0		.4724	12	71	118
DH408031F	12.303	31/64	.4844	14	77	124
DH408125	12.5		.4921	14	77	124
DH408032F	12.7	1/2	.5000	14	77	124
DH408130	13.0		.5118	14	77	124
DH408135	13.5		.5314	14	77	124
DH408140	14.0		.5512	14	77	124
DH408036F	14.288	9/16	.5625	16	83	133
DH408145	14.5		.5708	16	83	133
DH408150	15.0		.5905	16	83	133
DH408155	15.5		.6102	16	83	133
DH408040F	15.875	5/8	.6250	16	83	133
DH408160	16.0		.6299	16	83	133
DH408165	16.5		.6495	18	93	143
DH408170	17.0		.6692	18	93	143
DH408175	17.5		.6889	18	93	143
DH408180	18.0		.7087	18	93	143
DH408185	18.5		.7283	20	101	153
DH408190	19.0		.7480	20	101	153
DH408048F	19.05	3/4	.7500	20	101	153
DH408195	19.5		.7676	20	101	153
DH408200	20.0		.7874	20	101	153

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

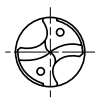
DH421 SERIES

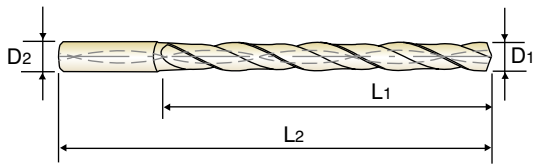
CARBIDE, DREAM DRILLS with COOLANT HOLES

EXTRA LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling





DIN 6537 | MG | h6 | m7 | 140° | 20 bar | P.82

8 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH421030	3.0		.1181	6	34	72
DH421031	3.1		.1220	6	34	72
DH421008F	3.175	1/8	.1250	6	34	72
DH421032	3.2		.1260	6	34	72
DH421033	3.3		.1299	6	34	72
DH421034	3.4		.1339	6	34	72
DH421229G	3.450	#29	.1360	6	34	72
DH421035	3.5		.1378	6	34	72
DH421009F	3.572	9/64	.1406	6	34	72
DH421036	3.6		.1417	6	34	72
DH421037	3.7		.1457	6	34	72
DH421038	3.8		.1496	6	43	81
DH421039	3.9		.1535	6	43	81
DH421010F	3.969	5/32	.1563	6	43	81
DH421040	4.0		.1575	6	43	81
DH421221G	4.040	#21	.1590	6	43	81
DH421041	4.1		.1614	6	43	81
DH421042	4.2		.1654	6	43	81
DH421043	4.3		.1693	6	43	81
DH421011F	4.366	11/64	.1719	6	43	81
DH421044	4.4		.1732	6	43	81
DH421045	4.5		.1772	6	43	81
DH421046	4.6		.1811	6	43	81
DH421047	4.7		.1850	6	43	81
DH421012F	4.763	3/16	.1875	6	57	95
DH421048	4.8		.1890	6	57	95
DH421049	4.9		.1929	6	57	95
DH421050	5.0		.1969	6	57	95

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH421051	5.1		.2008	6	57	95
DH421013F	5.159	13/64	.2031	6	57	95
DH421052	5.2		.2047	6	57	95
DH421053	5.3		.2087	6	57	95
DH421054	5.4		.2126	6	57	95
DH421055	5.5		.2165	6	57	95
DH421014F	5.556	7/32	.2188	6	57	95
DH421056	5.6		.2205	6	57	95
DH421057	5.7		.2244	6	57	95
DH421058	5.8		.2283	6	57	95
DH421059	5.9		.2323	6	57	95
DH421015F	5.953	15/64	.2344	6	57	95
DH421060	6.0		.2362	6	57	95
DH421061	6.1		.2402	8	76	114
DH421062	6.2		.2441	8	76	114
DH421063	6.3		.2480	8	76	114
DH421016F	6.350	1/4	.2500	8	76	114
DH421064	6.4		.2520	8	76	114
DH421065	6.5		.2559	8	76	114
DH421106L	6.53	F	.2570	8	76	114
DH421066	6.6		.2598	8	76	114
DH421067	6.7		.2638	8	76	114
DH421017F	6.747	17/64	.2656	8	76	114
DH421068	6.8		.2677	8	76	114
DH421069	6.9		.2717	8	76	114
DH421070	7.0		.2756	8	76	114
DH421071	7.1		.2795	8	76	114
DH421018F	7.144	9/32	.2813	8	76	114

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium	
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~									
○	◎	◎				○	○						

DREAM DRILLS -GENERAL

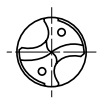
DH421 SERIES

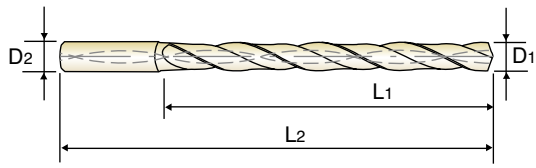
CARBIDE, DREAM DRILLS with COOLANT HOLES

EXTRA LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling





DIN 6537 | MG | h6 | m7 | 140° | 20 bar P.82

8 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH421072	7.2		.2835	8	76	114
DH421073	7.3		.2874	8	76	114
DH421074	7.4		.2913	8	76	114
DH421075	7.5		.2953	8	76	114
DH421019F	7.541	19/64	.2969	8	76	114
DH421076	7.6		.2992	8	76	114
DH421077	7.7		.3031	8	76	114
DH421078	7.8		.3071	8	76	114
DH421079	7.9		.3110	8	76	114
DH421020F	7.938	5/16	.3125	8	76	114
DH421080	8.0		.3150	8	76	114
DH421081	8.1		.3189	10	95	142
DH421082	8.2		.3228	10	95	142
DH421083	8.3		.3268	10	95	142
DH421021F	8.334	21/64	.3281	10	95	142
DH421084	8.4		.3307	10	95	142
DH421117L	8.430	Q	.3320	10	95	142
DH421085	8.5		.3346	10	95	142
DH421086	8.6		.3386	10	95	142
DH421087	8.7		.3425	10	95	142
DH421022F	8.731	11/32	.3438	10	95	142
DH421088	8.8		.3465	10	95	142
DH421089	8.9		.3504	10	95	142
DH421090	9.0		.3543	10	95	142
DH421091	9.1		.3583	10	95	142
DH421023F	9.128	23/64	.3594	10	95	142
DH421092	9.2		.3622	10	95	142
DH421093	9.3		.3661	10	95	142

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH421121L	9.350	U	.3680	10	95	142
DH421094	9.4		.3701	10	95	142
DH421095	9.5		.3740	10	95	142
DH421024F	9.525	3/8	.3750	10	95	142
DH421096	9.6		.3780	10	95	142
DH421097	9.7		.3819	10	95	142
DH421098	9.8		.3858	10	95	142
DH421099	9.9		.3898	10	95	142
DH421025F	9.922	25/64	.3906	10	95	142
DH421100	10.0		.3937	10	95	142
DH421101	10.1		.3976	12	114	162
DH421102	10.2		.4016	12	114	162
DH421103	10.3		.4055	12	114	162
DH421026F	10.319	13/32	.4063	12	114	162
DH421104	10.4		.4094	12	114	162
DH421105	10.5		.4134	12	114	162
DH421106	10.6		.4173	12	114	162
DH421107	10.7		.4212	12	114	162
DH421027F	10.716	27/64	.4219	12	114	162
DH421108	10.8		.4252	12	114	162
DH421109	10.9		.4291	12	114	162
DH421110	11.0		.4330	12	114	162
DH421111	11.1		.4370	12	114	162
DH421028F	11.113	7/16	.4375	12	114	162
DH421112	11.2		.4409	12	114	162
DH421113	11.3		.4448	12	114	162
DH421114	11.4		.4488	12	114	162
DH421115	11.5		.4527	12	114	162

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55		HRc55~							
○	◎	◎				○	○					

DREAM DRILLS -GENERAL

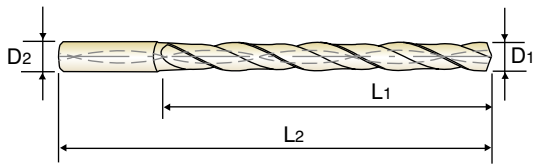
DH421 SERIES

CARBIDE, DREAM DRILLS with COOLANT HOLES

EXTRA LONG

▶ **Application** : Steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metal, non-ferrous light metal, abrasive plastic.

▶ **Advantages** : Self centering - center drilling is not required
Excellent positioning - bushing is not necessary
Special Design - reaming is not required
- good chip removal
- powerful drilling



DIN 6537 | MG | h6 | m7 | 140° | 20 bar P.82

8 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH421116	11.6		.4566	12	114	162
DH421117	11.7		.4606	12	114	162
DH421118	11.8		.4645	12	114	162
DH421119	11.9		.4685	12	114	162
DH421030F	11.906	15/32	.4688	12	114	162
DH421120	12.0		.4724	12	114	162
DH421031F	12.303	31/64	.4844	14	133	178
DH421125	12.5		.4921	14	133	178
DH421032F	12.700	1/2	.5000	14	133	178
DH421130	13.0		.5118	14	133	178
DH421033F	13.097	33/64	.5156	14	133	178
DH421135	13.5		.5314	14	133	178
DH421140	14.0		.5512	14	133	178

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium	
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~									
○	◎	◎				○	○						

DREAM DRILLS -GENERAL

RECOMMENDED CUTTING CONDITIONS

CARBIDE, DREAM DRILLS without COOLANT HOLES, TiAlN COATED

DH414, DH722 SERIES

WORK MATERIAL				K				P			
				CAST IRON		CAST IRON		CARBON STEELS		ALLOY STEELS	
STRENGTH				< HRc24		> HRc24		< HB240, GG25		< HB300, GG40	
DRILLING SPEED(SFM)				400 ~ 650 ft/min		280 ~ 430 ft/min		250 ~ 400 ft/min		210 ~ 350 ft/min	
DIAMETER				N	IPR	N	IPR	N	IPR	N	IPR
Fractional		Metric(mm)									
1/8	3/16	3.175	4.763	13120	.006	8750	.005	7880	.005	7000	.005
3/16	5/16	4.763	7.938	8200	.008	5470	.006	4920	.006	4370	.006
5/16	3/8	7.938	9.525	5970	.011	3980	.009	3560	.009	3190	.009
3/8	1/2	9.525	12.700	4690	.014	3120	.011	2810	.011	2500	.011
1/2	9/16	12.700	14.288	3860	.016	2570	.012	2310	.012	2060	.012
9/16	13/16	14.288	20.638	2980	.018	1990	.014	1790	.014	1590	.014

▸ Recommend to reduce the feed rate as following
DH414(3xD) : Feed 100%
DH722(5xD) : Feed 85%

N = R.P.M
IPR = feed rate(inch/rev.)

CARBIDE, DREAM DRILLS with COOLANT HOLES, TiAlN COATED

DH416, DH418, DH711, DH712 SERIES

WORK MATERIAL				K				P			
				CAST IRON		CAST IRON		CARBON STEELS		ALLOY STEELS	
STRENGTH				< HRc24		> HRc24		< HB240, GG25		< HB300, GG40	
DRILLING SPEED(SFM)				480 ~ 730 ft/min		310 ~ 490 ft/min		280 ~ 430 ft/min		250 ~ 400 ft/min	
DIAMETER				N	IPR	N	IPR	N	IPR	N	IPR
Fractional		Metric(mm)									
1/8	3/16	3.175	4.763	14870	.006	9620	.006	8750	.006	7880	.005
3/16	5/16	4.763	7.938	8200	.008	6010	.008	5470	.008	4920	.006
5/16	3/8	7.938	9.525	6760	.011	4370	.011	3980	.011	3580	.009
3/8	1/2	9.525	12.700	5310	.014	3440	.014	3120	.014	2810	.011
1/2	9/16	12.700	14.288	4370	.016	2830	.016	2570	.016	2310	.012
9/16	13/16	14.288	20.638	3380	.018	2190	.018	1990	.018	1790	.014

▸ Recommend to reduce the feed rate as following
DH416/DH711(3xD) : Feed 100%
DH418/DH712(5xD) : Feed 85%

N = R.P.M
IPR= feed rate (Inch/rev.)

CARBIDE, DREAM DRILLS without COOLANT HOLES, TiAlN COATED

DH404, DH423, DH424 SERIES

WORK MATERIAL		P						K					
		NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON		
STRENGTH		< HRc 20			> HRc 20			< 240 BHN			< 300 BHN		
DRILLING SPEED		130 ~ 400 ft/min			115 ~ 340 ft/min			220 ~ 650 ft/min			150 ~ 430 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal												
1.0	.0394	13000	0.04	.002	11250	0.04	.002	21300	0.04	.002	14200	0.04	.002
2.0	.0787	13000	0.06	.002	11250	0.06	.002	21300	0.06	.002	14200	0.06	.002
3.0	.1181	13000	0.13	.005	11000	0.13	.005	21000	0.13	.005	14000	0.13	.005
4.0	.1575	9500	0.14	.006	8400	0.14	.006	16000	0.14	.006	10500	0.14	.006
5.0	.1969	7600	0.15	.006	6700	0.15	.006	13000	0.15	.006	8300	0.15	.006
6.0	.2362	6400	0.17	.007	5600	0.17	.007	11000	0.17	.007	6900	0.17	.007
7.0	.2756	5500	0.19	.007	4800	0.19	.007	9100	0.19	.007	5900	0.19	.007
8.0	.3150	4800	0.21	.008	4200	0.21	.008	8000	0.21	.008	5200	0.21	.008
9.0	.3543	4200	0.23	.009	3700	0.23	.009	7100	0.23	.009	4600	0.23	.009
10.0	.3937	3800	0.25	.010	3350	0.25	.010	6400	0.25	.010	4150	0.25	.010
12.0	.4724	3200	0.27	.011	2800	0.27	.011	5300	0.27	.011	3450	0.27	.011
14.0	.5512	2750	0.29	.011	2400	0.29	.011	4550	0.29	.011	3000	0.29	.011
16.0	.6299	2400	0.31	.012	2100	0.31	.012	4000	0.31	.012	2600	0.31	.012
18.0	.7087	2100	0.33	.013	1850	0.33	.013	3550	0.33	.013	2300	0.33	.013
20.0	.7874	1900	0.35	.014	1650	0.35	.014	3200	0.35	.014	2100	0.35	.014

▶ Recommend to reduce the feed rate as following
DH404(3xD), DH423(3xD) : Feed 100%
DH424(5xD) : Feed 85%

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

DREAM DRILLS -GENERAL

RECOMMENDED CUTTING CONDITIONS

CARBIDE, DREAM DRILLS with COOLANT HOLES, TiAlN COATED

DH406, DH408, DH421 SERIES

WORK MATERIAL		P						K					
		NON-ALLOY STEELS			ALLOY STEELS			SOFT GREY CAST IRON			HARD GREY CAST IRON		
STRENGTH		< HRc 20			> HRc 20			< 240 BHN			< 300 BHN		
DRILLING SPEED		160 ~ 490 ft/min			150 ~ 440 ft/min			270 ~ 820 ft/min			170 ~ 530 ft/min		
DIAMETER		N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal												
1.0	.0394	16250	0.05	.002	14800	0.05	.002	26600	0.05	.002	17300	0.05	.002
2.0	.0787	16250	0.07	.003	14800	0.07	.003	26600	0.07	.003	17300	0.07	.003
3.0	.1181	16000	0.16	.006	14500	0.16	.006	26000	0.16	.006	17000	0.16	.006
4.0	.1575	12000	0.17	.007	11000	0.17	.007	20000	0.17	.007	13000	0.17	.007
5.0	.1969	9550	0.18	.007	8600	0.18	.007	16000	0.18	.007	10000	0.18	.007
6.0	.2362	8000	0.20	.008	7200	0.20	.008	13000	0.20	.008	8500	0.20	.008
7.0	.2756	6800	0.22	.009	6100	0.22	.009	11500	0.22	.009	7300	0.22	.009
8.0	.3150	6000	0.24	.009	5400	0.24	.009	9900	0.24	.009	6400	0.24	.009
9.0	.3543	5300	0.27	.011	4800	0.27	.011	8800	0.27	.011	5700	0.27	.011
10.0	.3937	4800	0.30	.012	4300	0.30	.012	8000	0.30	.012	5100	0.30	.012
12.0	.4724	4000	0.33	.013	3600	0.33	.013	6600	0.33	.013	4250	0.33	.013
14.0	.5512	3400	0.36	.014	3050	0.36	.014	5700	0.36	.014	3650	0.36	.014
16.0	.6299	3000	0.39	.015	2700	0.39	.015	5000	0.39	.015	3200	0.39	.015
18.0	.7087	2650	0.42	.017	2400	0.42	.017	4400	0.42	.017	2850	0.42	.017
20.0	.7874	2400	0.45	.018	2150	0.45	.018	4000	0.45	.018	2550	0.45	.018

▶ Recommend to reduce the feed rate as following
DH406(3xD) : Feed 100%, DH408(5xD) : Feed 85%
DH421(8xD) : Feed 70%

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

CARBIDE

YG

Being the best through innovation

DREAM DRILLS - HIGH FEED

WITH COOLANT HOLES
- for Carbon Steels, Alloy Steels (up to HRc35) and Cast Iron

SOLID CARBIDE DREAM DRILLS - HIGH FEED (with Coolant Holes)

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○				◎					
◎	◎	○				◎					

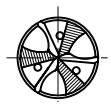
DREAM DRILLS -HIGH FEED

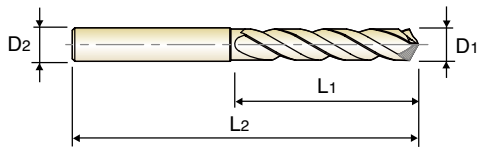
DGR493 SERIES

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

SHORT

▶ Application : Carbon Steels, Alloy Steels (~ HRc35), Cast Iron
▶ Advantage : – Increases productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
– Multi-Layer coating delivers much better productivity and reliability.
– Self-Centering





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.92

3 × D

Unit : mm

EDP No.	Diameter Inch	Diameter Metric	Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter Inch	Diameter Metric	Shank Diameter	Flute Length	Overall Length
H-Coating	D1		D2	L1	L2	H-Coating	D1		D2	L1	L2
DGR493050		.1969	5.00	6	28	66	DGR493069		.2717	6.90	8	34	79
DGR493051		.2008	5.10	6	28	66	DGR496209	I	.2720	6.91	5/16	34	79
DGR496013	13/64	.2031	5.16	1/4	28	66	DGR493070		.2756	7.00	8	34	79
DGR493052		.2047	5.20	6	28	66	DGR493071		.2795	7.10	8	41	79
DGR493053		.2087	5.30	6	28	66	DGR496018	9/32	.2813	7.14	5/16	41	79
DGR493054		.2126	5.40	6	28	66	DGR493072		.2835	7.20	8	41	79
DGR496103	#3	.2130	5.41	1/4	28	66	DGR493073		.2874	7.30	8	41	79
DGR493055		.2165	5.50	6	28	66	DGR493074		.2913	7.40	8	41	79
DGR496014	7/32	.2188	5.56	1/4	28	66	DGR493075		.2953	7.50	8	41	79
DGR493056		.2205	5.60	6	28	66	DGR496019	19/64	.2969	7.54	5/16	41	79
DGR496102	#2	.2210	5.61	1/4	28	66	DGR493076		.2992	7.60	8	41	79
DGR493057		.2244	5.70	6	28	66	DGR493077		.3031	7.70	8	41	79
DGR496101	#1	.2280	5.79	1/4	28	66	DGR493078		.3071	7.80	8	41	79
DGR493058		.2283	5.80	6	28	66	DGR493079		.3110	7.90	8	41	79
DGR493059		.2323	5.90	6	28	66	DGR496020	5/16	.3125	7.94	5/16	41	79
DGR496015	15/64	.2344	5.95	1/4	28	66	DGR493080		.3150	8.00	8	41	79
DGR493060		.2362	6.00	6	28	66	DGR493081		.3189	8.10	10	47	89
DGR493061		.2402	6.10	8	34	79	DGR493082	P	.3228	8.20	10	47	89
DGR493062		.2441	6.20	8	34	79	DGR493083		.3268	8.30	10	47	89
DGR493063		.2480	6.30	8	34	79	DGR496021	21/64	.3281	8.33	3/8	47	89
DGR496016	1/4	.2500	6.35	1/4	34	79	DGR493084		.3307	8.40	10	47	89
DGR493064		.2520	6.40	8	34	79	DGR496217	Q	.3320	8.43	3/8	47	89
DGR493065		.2559	6.50	8	34	79	DGR493085		.3346	8.50	10	47	89
DGR496206	F	.2570	6.53	5/16	34	79	DGR493086		.3386	8.60	10	47	89
DGR493066		.2598	6.60	8	34	79	DGR493087		.3425	8.70	10	47	89
DGR493067		.2638	6.70	8	34	79	DGR496022	11/32	.3437	8.73	3/8	47	89
DGR496017	17/64	.2656	6.75	5/16	34	79	DGR493088		.3465	8.80	10	47	89
DGR493068		.2677	6.80	8	34	79	DGR493089		.3504	8.90	10	47	89

▶ NEXT PAGE

◎ : Excellent ○ : Good

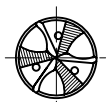
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					◎					

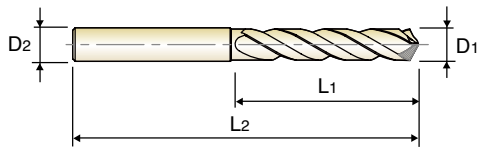
DREAM DRILLS -HIGH FEED

DGR493 SERIES

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES — *SHORT*

▶ Application : Carbon Steels, Alloy Steels (~ HRc35), Cast Iron
▶ Advantage : – Increases productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
– Multi-Layer coating delivers much better productivity and reliability.
– Self-Centering





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.92

3 × D

Unit : mm

EDP No.	Diameter Inch	Diameter Metric	Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter Inch	Diameter Metric	Shank Diameter	Flute Length	Overall Length
H-Coating	D1		D2	L1	L2	H-Coating	D1		D2	L1	L2
DGR493090		.3543	9.00	10	47	89	DGR496028	7/16	.4375	11.11	7/16	55	102
DGR493091		.3583	9.10	10	47	89	DGR493112		.4409	11.20	12	55	102
DGR496023	23/64	.3594	9.13	3/8	47	89	DGR493113		.4449	11.30	12	55	102
DGR493092		.3622	9.20	10	47	89	DGR493114		.4488	11.40	12	55	102
DGR493093		.3661	9.30	10	47	89	DGR493115		.4528	11.50	12	55	102
DGR496221	U	.3680	9.35	3/8	47	89	DGR496029	29/64	.4531	11.51	1/2	55	102
DGR493094		0.3701	9.40	10	47	89	DGR493116		.4567	11.60	12	55	102
DGR493095		.3740	9.50	10	47	89	DGR493117		.4606	11.70	12	55	102
DGR496024	3/8	0.3750	9.53	3/8	47	89	DGR493118		.4646	11.80	12	55	102
DGR493096		.3780	9.60	10	47	89	DGR493119		.4685	11.90	12	55	102
DGR493097		.3819	9.70	10	47	89	DGR496030	15/32	.4688	11.91	1/2	55	102
DGR493098	W	.3858	9.80	10	47	89	DGR493120		.4724	12.00	12	55	102
DGR493099		.3898	9.90	10	47	89	DGR493121		.4764	12.10	14	60	107
DGR496025	25/64	.3906	9.92	7/16	47	89	DGR493122		.4803	12.20	14	60	107
DGR493100		.3937	10.00	10	47	89	DGR493123		.4843	12.30	14	60	107
DGR493101		.3976	10.10	12	55	102	DGR496031	31/64	.4844	12.30	1/2	60	107
DGR493102		.4016	10.20	12	55	102	DGR493124		.4882	12.40	14	60	107
DGR493103		.4055	10.30	12	55	102	DGR493125		.4921	12.50	14	60	107
DGR496026	13/32	.4063	10.32	7/16	55	102	DGR493126		.4961	12.60	14	60	107
DGR493104		.4094	10.40	12	55	102	DGR496032	1/2	.5000	12.70	1/2	60	107
DGR493105		.4134	10.50	12	55	102	DGR493127		.5000	12.70	14	60	107
DGR493106		.4173	10.60	12	55	102	DGR493128		.5039	12.80	14	60	107
DGR493107		.4213	10.70	12	55	102	DGR493129		.5079	12.90	14	60	107
DGR496027	27/64	.4219	10.72	7/16	55	102	DGR493130		.5118	13.00	14	60	107
DGR493108		.4252	10.80	12	55	102	DGR493131	33/64	.5156	13.10	14	60	107
DGR493109		.4291	10.90	12	55	102	DGR493132		.5197	13.20	14	60	107
DGR493110		.4331	11.00	12	55	102	DGR493133		.5236	13.30	14	60	107
DGR493111		.4370	11.10	12	55	102	DGR493134		.5276	13.40	14	60	107

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					◎					

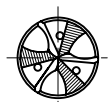
DREAM DRILLS -HIGH FEED

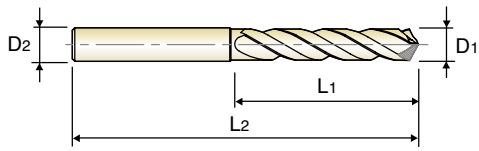
DGR493 SERIES

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

SHORT

▶ Application : Carbon Steels, Alloy Steels (~ HRc35), Cast Iron
▶ Advantage : – Increases productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
– Multi-Layer coating delivers much better productivity and reliability.
– Self-Centering





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.92

3 × D

Unit : mm

EDP No.	Diameter Inch		Diameter Metric		Shank Diameter	Flute Length	Overall Length
H-Coating	D1				D2	L1	L2
DGR496034	17/32	.5312	13.49		9/16	60	107
DGR493135		.5315	13.50		14	60	107
DGR493136		.5354	13.60		14	60	107
DGR493137		.5394	13.70		14	60	107
DGR493138		.5433	13.80		14	60	107
DGR496035	35/64	.5469	13.89		9/16	60	107
DGR493139		.5472	13.90		14	60	107
DGR493140		.5512	14.00		14	60	107
DGR493141		.5551	14.10		16	65	115
DGR493142		.5591	14.20		16	65	115
DGR496036	9/16	.5625	14.29		9/16	65	115
DGR493143		.5630	14.30		16	65	115
DGR493144		.5669	14.40		16	65	115
DGR493145		.5709	14.50		16	65	115
DGR493146		.5748	14.60		16	65	115
DGR496037	37/64	.5781	14.68		5/8	65	115
DGR493147		.5787	14.70		16	65	115
DGR493148		.5827	14.80		16	65	115
DGR493149		.5866	14.90		16	65	115
DGR493150		.5906	15.00		16	65	115
DGR496038	19/32	.5938	15.08		5/8	65	115
DGR493151		.5945	15.10		16	65	115
DGR493152		.5984	15.20		16	65	115
DGR493153		.6024	15.30		16	65	115
DGR493154		.6063	15.40		16	65	115

EDP No.	Diameter Inch		Diameter Metric		Shank Diameter	Flute Length	Overall Length
H-Coating	D1				D2	L1	L2
DGR496039	39/64	.6094	15.48		5/8	65	115
DGR493155		.6102	15.50		16	65	115
DGR493156		.6142	15.60		16	65	115
DGR493157		.6181	15.70		16	65	115
DGR493158		.6220	15.80		16	65	115
DGR496040	5/8	.6250	15.88		5/8	65	115
DGR493159		.6260	15.90		16	65	115
DGR493160		.6299	16.00		16	65	115
DGR493161		.6339	16.10		18	73	123
DGR496041	41/64	.6406	16.27		11/16	73	123
DGR493165		.6496	16.50		18	73	123
DGR496042	21/32	.6563	16.67		11/16	73	123
DGR493170		.6693	17.00		18	73	123
DGR496043	43/64	.6719	17.07		11/16	73	123
DGR496044	11/16	.6875	17.46		11/16	73	123
DGR493175		.6890	17.50		18	73	123
DGR496045	45/64	.7031	17.86		3/4	73	123
DGR493180		.7087	18.00		18	73	123
DGR496046	23/32	.7188	18.26		3/4	79	131
DGR493185		.7283	18.50		20	79	131
DGR496047	47/64	.7344	18.65		3/4	79	131
DGR493190		.7480	19.00		20	79	131
DGR496048	3/4	.7500	19.05		3/4	79	131
DGR493195		.7677	19.50		20	79	131
DGR493200		.7874	20.00		20	79	131

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					◎					

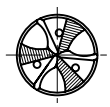
DREAM DRILLS -HIGH FEED

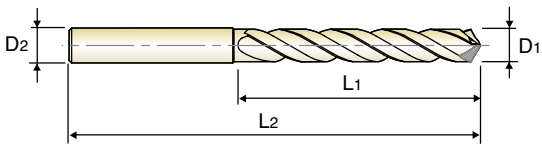
DGR495 SERIES

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

LONG

▶ Application : Carbon Steels, Alloy Steels (~ HRc35), Cast Iron
▶ Advantage : – Increases productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
– Multi-Layer coating delivers much better productivity and reliability.
– Self-Centering





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.92

5 × D

Unit : mm

EDP No.	Diameter Inch	Diameter Metric	Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter Inch	Diameter Metric	Shank Diameter	Flute Length	Overall Length
H-Coating	D1		D2	L1	L2	H-Coating	D1		D2	L1	L2
DGR495050		.1969	5.00	6	44	82	DGR495069		.2717	6.90	8	53	91
DGR495051		.2008	5.10	6	44	82	DGR497209	I	.2720	6.91	5/16	53	91
DGR497013	13/64	.2031	5.16	1/4	44	82	DGR495070		.2756	7.00	8	53	91
DGR495052		.2047	5.20	6	44	82	DGR495071		.2795	7.10	8	53	91
DGR495053		.2087	5.30	6	44	82	DGR497018	9/32	.2813	7.14	5/16	53	91
DGR495054		.2126	5.40	6	44	82	DGR495072		.2835	7.20	8	53	91
DGR497103	#3	.2130	5.41	1/4	44	82	DGR495073		.2874	7.30	8	53	91
DGR495055		.2165	5.50	6	44	82	DGR495074		.2913	7.40	8	53	91
DGR497014	7/32	.2188	5.56	1/4	44	82	DGR495075		.2953	7.50	8	53	91
DGR495056		.2205	5.60	6	44	82	DGR497019	19/64	.2969	7.54	5/16	53	91
DGR497102	#2	.2210	5.61	1/4	44	82	DGR495076		.2992	7.60	8	53	91
DGR495057		.2244	5.70	6	44	82	DGR495077		.3031	7.70	8	53	91
DGR497101	#1	.2280	5.79	1/4	44	82	DGR495078		.3071	7.80	8	53	91
DGR495058		.2283	5.80	6	44	82	DGR495079		.3110	7.90	8	53	91
DGR495059		.2323	5.90	6	44	82	DGR497020	5/16	.3125	7.94	5/16	53	91
DGR497015	15/64	.2344	5.95	1/4	44	82	DGR495080		.3150	8.00	8	53	91
DGR495060		.2362	6.00	6	44	82	DGR495081		.3189	8.10	10	61	103
DGR495061		.2402	6.10	8	53	91	DGR495082	P	.3228	8.20	10	61	103
DGR495062		.2441	6.20	8	53	91	DGR495083		.3268	8.30	10	61	103
DGR495063		.2480	6.30	8	53	91	DGR497021	21/64	.3281	8.33	3/8	61	103
DGR497016	1/4	.2500	6.35	1/4	53	91	DGR495084		.3307	8.40	10	61	103
DGR495064		.2520	6.40	8	53	91	DGR497217	Q	.3320	8.43	3/8	61	103
DGR495065		.2559	6.50	8	53	91	DGR495085		.3346	8.50	10	61	103
DGR497206	F	.2570	6.53	5/16	53	91	DGR495086		.3386	8.60	10	61	103
DGR495066		.2598	6.60	8	53	91	DGR495087		.3425	8.70	10	61	103
DGR495067		.2638	6.70	8	53	91	DGR497022	11/32	.3437	8.73	3/8	61	103
DGR497017	17/64	.2656	6.75	5/16	53	91	DGR495088		.3465	8.80	10	61	103
DGR495068		.2677	6.80	8	53	91	DGR495089		.3504	8.90	10	61	103

▶ NEXT PAGE

◎ : Excellent ○ : Good

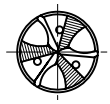
P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○				◎					

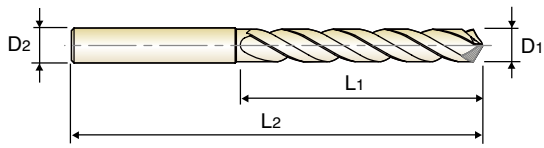
DREAM DRILLS -HIGH FEED

DGR495 SERIES

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES — *LONG*

▶ Application : Carbon Steels, Alloy Steels (~ HRc35), Cast Iron
▶ Advantage : – Increases productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
– Multi-Layer coating delivers much better productivity and reliability.
– Self-Centering





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.92

5 × D

Unit : mm

EDP No.	Diameter Inch		Diameter Metric	Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter Inch		Diameter Metric	Shank Diameter	Flute Length	Overall Length
H-Coating	D1			D2	L1	L2	H-Coating	D1			D2	L1	L2
DGR495090		.3543	9.00	10	61	103	DGR497028	7/16	.4375	11.11	7/16	71	118
DGR495091		.3583	9.10	10	61	103	DGR495112		.4409	11.20	12	71	118
DGR497023	23/64	.3594	9.13	3/8	61	103	DGR495113		.4449	11.30	12	71	118
DGR495092		.3622	9.20	10	61	103	DGR495114		.4488	11.40	12	71	118
DGR495093		.3661	9.30	10	61	103	DGR495115		.4528	11.50	12	71	118
DGR497221	U	.3680	9.35	3/8	61	103	DGR497029	29/64	.4531	11.51	1/2	71	118
DGR495094		.3701	9.40	10	61	103	DGR495116		.4567	11.60	12	71	118
DGR495095		.3740	9.50	10	61	103	DGR495117		.4606	11.70	12	71	118
DGR497024	3/8	.3750	9.53	3/8	61	103	DGR495118		.4646	11.80	12	71	118
DGR495096		.3780	9.60	10	61	103	DGR495119		.4685	11.90	12	71	118
DGR495097		.3819	9.70	10	61	103	DGR497030	15/32	.4688	11.91	1/2	71	118
DGR495098	W	.3858	9.80	10	61	103	DGR495120		.4724	12.00	12	71	118
DGR495099		.3898	9.90	10	61	103	DGR495121		.4764	12.10	14	77	124
DGR497025	25/64	.3906	9.92	7/16	61	103	DGR495122		.4803	12.20	14	77	124
DGR495100		.3937	10.00	10	61	103	DGR495123		.4843	12.30	14	77	124
DGR495101		.3976	10.10	12	71	118	DGR497031	31/64	.4844	12.30	1/2	77	124
DGR495102		.4016	10.20	12	71	118	DGR495124		.4882	12.40	14	77	124
DGR495103		.4055	10.30	12	71	118	DGR495125		.4921	12.50	14	77	124
DGR497026	13/32	.4063	10.32	7/16	71	118	DGR495126		.4961	12.60	14	77	124
DGR495104		.4094	10.40	12	71	118	DGR497032	1/2	.5000	12.70	1/2	77	124
DGR495105		.4134	10.50	12	71	118	DGR495127		.5000	12.70	14	77	124
DGR495106		.4173	10.60	12	71	118	DGR495128		.5039	12.80	14	77	124
DGR495107		.4213	10.70	12	71	118	DGR495129		.5079	12.90	14	77	124
DGR497027	27/64	.4219	10.72	7/16	71	118	DGR495130		.5118	13.00	14	77	124
DGR495108		.4252	10.80	12	71	118	DGR495131	33/64	.5156	13.10	14	77	124
DGR495109		.4291	10.90	12	71	118	DGR495132		.5197	13.20	14	77	124
DGR495110		.4331	11.00	12	71	118	DGR495133		.5236	13.30	14	77	124
DGR495111		.4370	11.10	12	71	118	DGR495134		.5276	13.40	14	77	124

▶ NEXT PAGE

◎ : Excellent ○ : Good

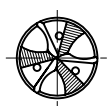
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					◎					

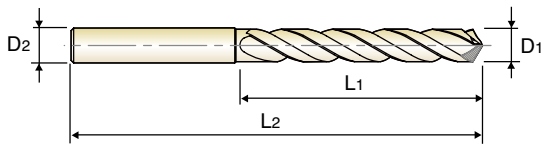
DREAM DRILLS -HIGH FEED

DGR495 SERIES

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES — *LONG*

▶ Application : Carbon Steels, Alloy Steels (~ HRc35), Cast Iron
▶ Advantage : – Increases productivity due to 1.5 to 2 times faster feeding speed than 2-flute drill
– Multi-Layer coating delivers much better productivity and reliability.
– Self-Centering





DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.92

5 × D

Unit : mm

EDP No.	Diameter Inch	Diameter Metric	Shank Diameter	Flute Length	Overall Length	EDP No.	Diameter Inch	Diameter Metric	Shank Diameter	Flute Length	Overall Length
H-Coating	D1		D2	L1	L2	H-Coating	D1		D2	L1	L2
DGR497034	17/32	.5312	13.49	9/16	77	124	DGR497039	39/64	.6094	15.48	5/8	83	133
DGR495135		.5315	13.50	14	77	124	DGR495155		.6102	15.50	16	83	133
DGR495136		.5354	13.60	14	77	124	DGR495156		.6142	15.60	16	83	133
DGR495137		.5394	13.70	14	77	124	DGR495157		.6181	15.70	16	83	133
DGR495138		.5433	13.80	14	77	124	DGR495158		.6220	15.80	16	83	133
DGR497035	35/64	.5469	13.89	9/16	77	124	DGR497040	5/8	.6250	15.88	5/8	83	133
DGR495139		.5472	13.90	14	77	124	DGR495159		.6260	15.90	16	83	133
DGR495140		.5512	14.00	14	77	124	DGR495160		.6299	16.00	16	83	133
DGR495141		.5551	14.10	16	83	133	DGR495161		.6339	16.10	18	93	143
DGR495142		.5591	14.20	16	83	133	DGR497041	41/64	.6406	16.27	11/16	93	143
DGR497036	9/16	.5625	14.29	9/16	83	133	DGR495165		.6496	16.50	18	93	143
DGR495143		.5630	14.30	16	83	133	DGR497042	21/32	.6563	16.67	11/16	93	143
DGR495144		.5669	14.40	16	83	133	DGR495170		.6693	17.00	18	93	143
DGR495145		.5709	14.50	16	83	133	DGR497043	43/64	.6719	17.07	11/16	93	143
DGR495146		.5748	14.60	16	83	133	DGR497044	11/16	.6875	17.46	11/16	93	143
DGR497037	37/64	.5781	14.68	5/8	83	133	DGR495175		.6890	17.50	18	93	143
DGR495147		.5787	14.70	16	83	133	DGR497045	45/64	.7031	17.86	3/4	93	143
DGR495148		.5827	14.80	16	83	133	DGR495180		.7087	18.00	18	93	143
DGR495149		.5866	14.90	16	83	133	DGR497046	23/32	.7188	18.26	3/4	101	153
DGR495150		.5906	15.00	16	83	133	DGR495185		.7283	18.50	20	101	153
DGR497038	19/32	.5938	15.08	5/8	83	133	DGR497047	47/64	.7344	18.65	3/4	101	153
DGR495151		.5945	15.10	16	83	133	DGR495190		.7480	19.00	20	101	153
DGR495152		.5984	15.20	16	83	133	DGR497048	3/4	.7500	19.05	3/4	101	153
DGR495153		.6024	15.30	16	83	133	DGR495195		.7677	19.50	20	101	153
DGR495154		.6063	15.40	16	83	133	DGR495200		.7874	20.00	20	101	153

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					◎					

DREAM DRILLS -HIGH FEED

RECOMMENDED CUTTING CONDITIONS

CARBIDE, DREAM DRILLS - HIGH FEED with COOLANT HOLES

DGR493, DGR495 SERIES

WORK MATERIAL		P						K					
		CARBON STEELS ALLOY STEELS			ALLOY STEELS			CAST IRON			DUCTILE CAST IRON		
HARDNESS		~ HRc20			HRc20 ~ 35								
DRILLING SPEED		329 ft/min			247 ft/min			329 ft/min			264 ft/min		
DRILLING DIAMETER		SFM	IPR		SFM	IPR		SFM	IPR		SFM	IPR	
			Min	Max		Min	Max		Min	Max		Min	Max
5.0	.1969	328	.0079	.0098	246	.0079	.0098	328	.0091	.0118	263	.0079	.0098
6.0	.2362	328	.0094	.0118	246	.0094	.0118	328	.0106	.0142	263	.0094	.0118
7.0	.2756	328	.0110	.0138	247	.0110	.0138	328	.0126	.0165	263	.0110	.0138
8.0	.3150	328	.0126	.0157	247	.0126	.0157	328	.0142	.0189	263	.0126	.0157
9.0	.3543	328	.0142	.0177	247	.0142	.0177	328	.0161	.0213	263	.0142	.0177
10.0	.3937	329	.0157	.0197	246	.0157	.0197	329	.0177	.0236	263	.0157	.0197
11.0	.4331	329	.0173	.0217	247	.0173	.0195	329	.0197	.0260	263	.0173	.0217
12.0	.4724	329	.0189	.0236	247	.0189	.0213	329	.0213	.0283	263	.0189	.0236
13.0	.5118	328	.0205	.0256	247	.0205	.0230	328	.0232	.0307	263	.0205	.0256
14.0	.5512	329	.0220	.0276	247	.0220	.0248	329	.0248	.0331	263	.0220	.0276
16.0	.6299	328	.0220	.0283	247	.0220	.0252	328	.0252	.0315	264	.0220	.0283

SFM = ft/min
IPR = feed rate (Inch/rev.)

CARBIDE

YG

Being the best through innovation

DREAM DRILLS -INOX

- **WITH COOLANT HOLES**
  Stainless Steels, Nickel Alloys and Titanium up to HRc35

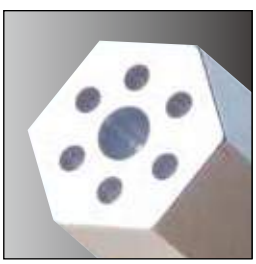
SELECTION GUIDE

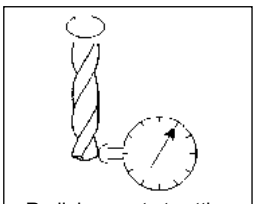
SOLID CARBIDE DREAM DRILLS -INOX (with Coolant Holes)
Stainless Steels, Nickel Alloys and Titanium up to HRc35.

ITEM	MODEL		DESCRIPTION		SIZE MIN	SIZE MAX	PAGE
INCH							
3XD	**DH463 DH714**		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES	*STUB*	D1/8	D5/8	**96**
5XD	**DH464 DH715**		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES	*LONG*	D13/64	D1/2	**98**
METRIC							
3XD	**DH451**		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES	*SHORT*	D3.0	D20.0	**99**
5XD	**DH452**		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES	*LONG*	D3.0	D20.0	**102**
8XD	**DH453**		CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES	*EXTRA LONG*	D3.0	D14.0	**105**
			RECOMMENDED CUTTING CONDITIONS				**108**

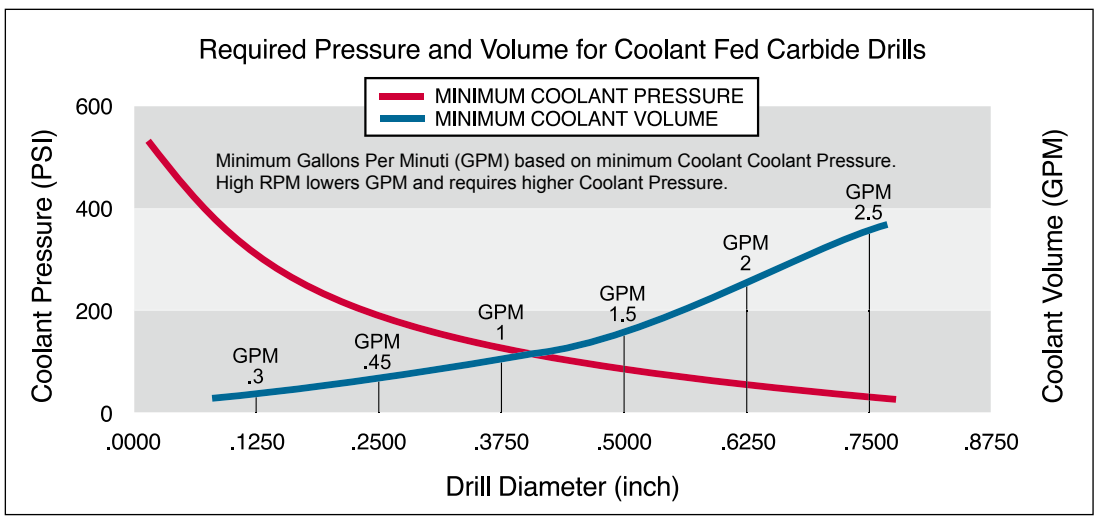
◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			◎		○				○
◎	◎	○			◎		○				○
◎	◎	○			◎		○				○
◎	◎	○			◎		○				○
◎	◎	○			◎		○				○





• Radial run out at cutting lip must not exceed .001



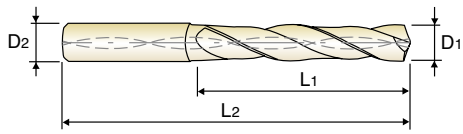
DREAM DRILLS -INOX

DH463, DH714 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

STUB

- ▶Special flute shape and geometry suitable for machining stainless steel.
- ▶Excellent chip evacuation from better surface treatment.
- ▶Point R-thinning achieving superior centering and chip curl.
- ▶TiAlN coating for better surface finishes and longer tool life.
- ▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



MG | 140° | 20 bar | P.108

▶ for stainless steel 3×D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH714008	1/8	.1250	3/16	1.102	2.992
DH463008	1/8	.1250	15/64	1.102	2.992
DH714011	11/64	.1719	3/16	1.417	3.386
DH463011	11/64	.1719	15/64	1.417	3.386
DH714012	3/16	.1875	3/16	1.575	3.543
DH463012	3/16	.1875	15/64	1.575	3.543
DH463013	13/64	.2031	15/64	1.082	3.228
DH714013	13/64	.2031	1/4	1.082	3.228
DH463014	7/32	.2188	15/64	1.181	3.228
DH714014	7/32	.2188	1/4	1.181	3.228
DH463015	15/64	.2344	15/64	1.181	3.228
DH714015	15/64	.2344	1/4	1.181	3.228
DH714016	1/4	.2500	1/4	1.279	3.465
DH463016	1/4	.2500	17/64	1.279	3.465
DH463206	F	.2570	17/64	1.279	3.465
DH714206	F	.2570	5/16	1.279	3.465
DH463017	17/64	.2656	17/64	1.378	3.465
DH714017	17/64	.2656	5/16	1.378	3.465
DH463209	I	.2720	.2720	1.378	3.465
DH714209	I	.2720	5/16	1.378	3.465
DH463018	9/32	.2812	5/16	1.476	3.701
DH463019	19/64	.2969	5/16	1.476	3.701
DH463020	5/16	.3125	5/16	1.575	3.701
DH463021	21/64	.3281	11/32	1.673	3.937

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH714021	21/64	.3281	3/8	1.673	3.937
DH463217	Q	.3320	11/32	1.673	3.937
DH714217	Q	.3320	3/8	1.673	3.937
DH463022	11/32	.3438	11/32	1.772	3.937
DH714022	11/32	.3438	3/8	1.772	3.937
DH714023	23/64	.3594	3/8	1.870	4.174
DH463023	23/64	.3594	25/64	1.870	4.174
DH714221	U	.3680	3/8	1.870	4.174
DH463221	U	.3680	25/64	1.870	4.174
DH714024	3/8	.3750	3/8	1.969	4.174
DH463024	3/8	.3750	25/64	1.969	4.174
DH463025	25/64	.3906	25/64	1.969	4.174
DH714025	25/64	.3906	7/16	1.969	4.174
DH463026	13/32	.4062	27/64	2.067	4.567
DH714026	13/32	.4062	7/16	2.067	4.567
DH463027	27/64	.4219	27/64	2.165	4.567
DH714027	27/64	.4219	7/16	2.165	4.567
DH714028	7/16	.4375	7/16	2.264	4.803
DH463028	7/16	.4375	15/32	2.264	4.803
DH463029	29/64	.4531	15/32	2.264	4.803
DH714029	29/64	.4531	1/2	2.264	4.803
DH463030	15/32	.4688	15/32	2.362	4.803
DH714030	15/32	.4688	1/2	2.362	4.803
DH463031	31/64	.4844	1/2	2.461	5.039

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			◎		○				○

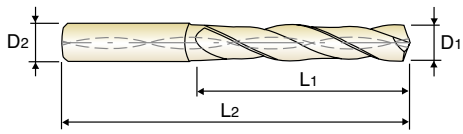
DREAM DRILLS -INOX

DH463, DH714 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

STUB

▶Special flute shape and geometry suitable for machining stainless steel.
▶Excellent chip evacuation from better surface treatment.
▶Point R-thinning achieving superior centering and chip curl.
▶TiAlN coating for better surface finishes and longer tool life.
▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



MG | 140° | 20 bar | P.108

▶ **for stainless steel** 3×D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH463032	**1/2**	**.5000**	1/2	2.559	5.039
DH463033	**33/64**	**.5156**	35/64	2.657	5.276
DH714033	**33/64**	**.5156**	9/16	2.657	5.276
DH463034	**17/32**	**.5312**	35/64	2.756	5.276
DH714034	**17/32**	**.5312**	9/16	2.756	5.276
DH463035	**35/64**	**.5469**	35/64	2.756	5.276
DH714035	**35/64**	**.5469**	9/16	2.756	5.276

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH714036	**9/16**	**.5625**	9/16	2.854	5.512
DH463036	**9/16**	**.5625**	37/64	2.854	5.512
DH463037	**37/64**	**.5781**	37/64	2.953	5.512
DH714037	**37/64**	**.5781**	5/8	2.953	5.512
DH463038	**19/32**	**.5937**	5/8	3.051	5.709
DH463039	**39/64**	**.6094**	5/8	3.051	5.709
DH463040	**5/8**	**.6250**	5/8	3.150	5.709

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

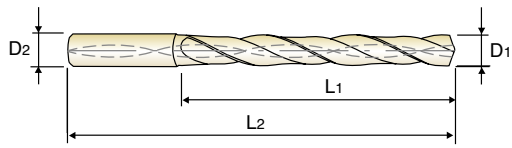
DREAM DRILLS -INOX

DH464, DH715 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

LONG

▶Special flute shape and geometry suitable for machining stainless steel.
▶Excellent chip evacuation from better surface treatment.
▶Point R-thinning achieving superior centering and chip curl.
▶TiAlN coating for better surface finishes and longer tool life.
▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



MG | 140° | 20 bar | P.108

▶ for stainless steel

5 × D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH464013	13/64	.2031	15/64	1-3/4	3-15/16
DH715013	13/64	.2031	1/4	1-3/4	3-15/16
DH464014	7/32	.2188	15/64	1-57/64	3-15/16
DH715014	7/32	.2188	1/4	1-57/64	3-15/16
DH464015	15/64	.2344	15/64	1-57/64	3-15/16
DH715015	15/64	.2344	1/4	1-57/64	3-15/16
DH715016	1/4	.2500	1/4	2-3/64	4-19/64
DH464016	1/4	.2500	17/64	2-3/64	4-19/64
DH464206	F	.2570	17/64	2-13/64	4-19/64
DH715206	F	.2570	5/16	2-13/64	4-19/64
DH464017	17/64	.2656	17/64	2-13/64	4-19/64
DH715017	17/64	.2656	5/16	2-13/64	4-19/64
DH464209	I	.2720	.2720	2-13/64	4-19/64
DH715209	I	.2720	5/16	2-13/64	4-19/64
DH464018	9/32	.2812	5/16	2-23/64	4-41/64
DH464019	19/64	.2969	5/16	2-33/64	4-41/64
DH464020	5/16	.3125	5/16	2-33/64	4-41/64
DH464021	21/64	.3281	11/32	2-43/64	5
DH715021	21/64	.3281	3/8	2-43/64	5
DH464217	Q	.3320	11/32	2-43/64	5
DH715217	Q	.3320	3/8	2-43/64	5
DH464022	11/32	.3438	11/32	2-27/32	5

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH715022	11/32	.3438	3/8	2-27/32	5
DH715023	23/64	.3594	3/8	3	5-23/64
DH464023	23/64	.3594	25/64	3	5-23/64
DH715221	U	.3680	3/8	3	5-23/64
DH464221	U	.3680	25/64	3	5-23/64
DH715024	3/8	.3750	3/8	3-5/32	5-23/64
DH464024	3/8	.3750	25/64	3-5/32	5-23/64
DH464025	25/64	.3906	25/64	3-5/32	5-23/64
DH715025	25/64	.3906	7/16	3-5/32	5-23/64
DH464026	13/32	.4062	27/64	3-5/16	5-7/8
DH715026	13/32	.4062	7/16	3-5/16	5-7/8
DH464027	27/64	.4219	27/64	3-15/32	5-7/8
DH715027	27/64	.4219	7/16	3-15/32	5-7/8
DH715028	7/16	.4375	7/16	3-5/8	6-7/32
DH464028	7/16	.4375	15/32	3-5/8	6-7/32
DH464029	29/64	.4531	15/32	3-25/32	6-7/32
DH715029	29/64	.4531	1/2	3-25/32	6-7/32
DH464030	15/32	.4688	15/32	3-25/32	6-7/32
DH715030	15/32	.4688	1/2	3-25/32	6-7/32
DH464031	31/64	.4844	1/2	3-15/16	6-37/64
DH464032	1/2	.5000	1/2	4-3/32	6-37/64

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

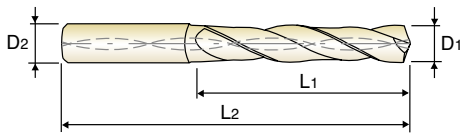
DREAM DRILLS -INOX

DH451 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

SHORT

▶Special flute shape and geometry suitable for machining stainless steel.
▶Excellent chip evacuation from better surface treatment.
▶Point R-thinning achieving superior centering and chip curl.
▶TiAlN coating for better surface finishes and longer tool life.
▶Tolerance : Dia. Tolerance ⌀D1: See page 253, Shank Tolerance ⌀D2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ **for stainless steel**

3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH451030	3.0		.1181	6	20	62
DH451031	3.1		.1220	6	20	62
DH451008F	3.175	1/8	.1250	6	20	62
DH451032	3.2		.1260	6	20	62
DH451033	3.3		.1299	6	20	62
DH451034	3.4		.1339	6	20	62
DH451035	3.5		.1378	6	20	62
DH451009F	3.572	9/64	.1406	6	20	62
DH451036	3.6		.1417	6	20	62
DH451037	3.7		.1457	6	20	62
DH451038	3.8		.1496	6	24	66
DH451039	3.9		.1535	6	24	66
DH451010F	3.969	5/32	.1563	6	24	66
DH451040	4.0		.1575	6	24	66
DH451041	4.1		.1614	6	24	66
DH451042	4.2		.1654	6	24	66
DH451043	4.3		.1693	6	24	66
DH451011F	4.366	11/64	.1719	6	24	66
DH451044	4.4		.1732	6	24	66
DH451045	4.5		.1772	6	24	66
DH451046	4.6		.1811	6	24	66
DH451047	4.7		.1850	6	24	66
DH451012F	4.763	3/16	.1875	6	24	66
DH451048	4.8		.1890	6	28	66
DH451049	4.9		.1929	6	28	66
DH451050	5.0		.1969	6	28	66

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH451051	5.1		.2008	6	28	66
DH451013F	5.159	13/64	.2031	6	28	66
DH451052	5.2		.2047	6	28	66
DH451053	5.3		.2087	6	28	66
DH451054	5.4		.2126	6	28	66
DH451055	5.5		.2165	6	28	66
DH451014F	5.556	7/32	.2188	6	28	66
DH451056	5.6		.2205	6	28	66
DH451057	5.7		.2244	6	28	66
DH451058	5.8		.2283	6	28	66
DH451059	5.9		.2323	6	28	66
DH451015F	5.953	15/64	.2344	6	28	66
DH451060	6.0		.2362	6	28	66
DH451061	6.1		.2402	8	34	79
DH451062	6.2		.2441	8	34	79
DH451063	6.3		.2480	8	34	79
DH451016F	6.35	1/4	.2500	8	34	79
DH451064	6.4		.2520	8	34	79
DH451065	6.5		.2559	8	34	79
DH451066	6.6		.2598	8	34	79
DH451067	6.7		.2638	8	34	79
DH451017F	6.747	17/64	.2656	8	34	79
DH451068	6.8		.2677	8	34	79
DH451069	6.9		.2717	8	34	79
DH451070	7.0		.2756	8	34	79
DH451071	7.1		.2795	8	41	79

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

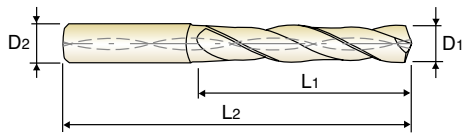
DREAM DRILLS -INOX

DH451 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

SHORT

- ▶Special flute shape and geometry suitable for machining stainless steel.
- ▶Excellent chip evacuation from better surface treatment.
- ▶Point R-thinning achieving superior centering and chip curl.
- ▶TiAlN coating for better surface finishes and longer tool life.
- ▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ **for stainless steel**

3×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH451018F	7.144	9/32	.2812	8	41	79
DH451072	7.2		.2835	8	41	79
DH451073	7.3		.2874	8	41	79
DH451074	7.4		.2913	8	41	79
DH451075	7.5		.2953	8	41	79
DH451019F	7.541	19/64	.2969	8	41	79
DH451076	7.6		.2992	8	41	79
DH451077	7.7		.3031	8	41	79
DH451078	7.8		.3071	8	41	79
DH451079	7.9		.3110	8	41	79
DH451020F	7.938	5/16	.3125	8	41	79
DH451080	8.0		.3150	8	41	79
DH451081	8.1		.3189	10	47	89
DH451082	8.2		.3228	10	47	89
DH451083	8.3		.3268	10	47	89
DH451021F	8.334	21/64	.3281	10	47	89
DH451084	8.4		.3307	10	47	89
DH451085	8.5		.3346	10	47	89
DH451086	8.6		.3386	10	47	89
DH451087	8.7		.3425	10	47	89
DH451022F	8.731	11/32	.3438	10	47	89
DH451088	8.8		.3465	10	47	89
DH451089	8.9		.3504	10	47	89
DH451090	9.0		.3543	10	47	89
DH451091	9.1		.3583	10	47	89
DH451023F	9.128	23/64	.3594	10	47	89

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH451092	9.2		.3622	10	47	89
DH451093	9.3		.3661	10	47	89
DH451094	9.4		.3701	10	47	89
DH451095	9.5		.3740	10	47	89
DH451024F	9.525	3/8	.3750	10	47	89
DH451096	9.6		.3780	10	47	89
DH451097	9.7		.3819	10	47	89
DH451098	9.8		.3858	10	47	89
DH451099	9.9		.3898	10	47	89
DH451025F	9.922	25/64	.3906	10	47	89
DH451100	10.0		.3937	10	47	89
DH451101	10.1		.3976	12	55	102
DH451102	10.2		.4016	12	55	102
DH451103	10.3		.4055	12	55	102
DH451026F	10.319	13/32	.4062	12	55	102
DH451104	10.4		.4094	12	55	102
DH451105	10.5		.4134	12	55	102
DH451106	10.6		.4173	12	55	102
DH451107	10.7		.4212	12	55	102
DH451027F	10.716	27/64	.4219	12	55	102
DH451108	10.8		.4252	12	55	102
DH451109	10.9		.4291	12	55	102
DH451110	11.0		.4330	12	55	102
DH451111	11.1		.4370	12	55	102
DH451028F	11.113	7/16	.4375	12	55	102
DH451112	11.2		.4409	12	55	102

▶ NEXT PAGE

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

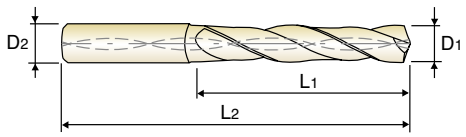
DREAM DRILLS -INOX

DH451 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

SHORT

▶Special flute shape and geometry suitable for machining stainless steel.
▶Excellent chip evacuation from better surface treatment.
▶Point R-thinning achieving superior centering and chip curl.
▶TiAlN coating for better surface finishes and longer tool life.
▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ **for stainless steel**

3 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH451113	11.3		.4448	12	55	102
DH451114	11.4		.4488	12	55	102
DH451115	11.5		.4527	12	55	102
DH451029F	11.509	29/64	.4531	12	55	102
DH451116	11.6		.4566	12	55	102
DH451117	11.7		.4606	12	55	102
DH451118	11.8		.4645	12	55	102
DH451119	11.9		.4685	12	55	102
DH451030F	11.906	15/32	.4688	12	55	102
DH451120	12.0		.4724	12	55	102
DH451031F	12.303	31/64	.4844	14	60	107
DH451125	12.5		.4921	14	60	107
DH451032F	12.7	1/2	.5000	14	60	107
DH451130	13.0		.5118	14	60	107
DH451135	13.5		.5314	14	60	107
DH451140	14.0		.5512	14	60	107

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH451036F	14.288	9/16	.5625	16	65	115
DH451145	14.5		.5708	16	65	115
DH451150	15.0		.5905	16	65	115
DH451155	15.5		.6102	16	65	115
DH451040F	15.875	5/8	.6250	16	65	115
DH451160	16.0		.6299	16	65	115
DH451165	16.5		.6495	18	73	123
DH451170	17.0		.6692	18	73	123
DH451044F	17.463	11/16	.6875	18	73	123
DH451175	17.5		.6889	18	73	123
DH451180	18.0		.7087	18	73	123
DH451185	18.5		.7283	20	79	131
DH451190	19.0		.7480	20	79	131
DH451048F	19.05	3/4	.7500	20	79	131
DH451195	19.5		.7676	20	79	131
DH451200	20.0		.7874	20	79	131

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

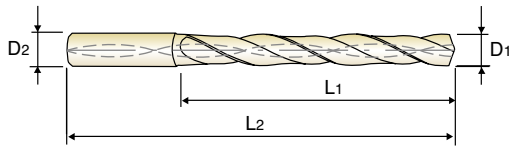
DREAM DRILLS -INOX

DH452 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

LONG

- ▶Special flute shape and geometry suitable for machining stainless steel.
- ▶Excellent chip evacuation from better surface treatment.
- ▶Point R-thinning achieving superior centering and chip curl.
- ▶TiAlN coating for better surface finishes and longer tool life.
- ▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ for stainless steel 5×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH452010	1.0		.0394	3	8	55
DH452011	1.1		.0433	3	12	55
DH452012	1.2		.0472	3	12	55
DH452013	1.3		.0512	3	12	55
DH452014	1.4		.0551	3	12	55
DH452015	1.5		.0591	3	16	55
DH452004F	1.588	1/16	.0625	3	16	55
DH452016	1.6		.0630	3	16	55
DH452017	1.7		.0669	3	16	55
DH452018	1.8		.0709	3	16	55
DH452019	1.9		.0748	3	16	55
DH452005F	1.984	5/64	.0781	3	16	55
DH452020	2.0		.0787	4	21	57
DH452021	2.1		.0827	4	21	57
DH452022	2.2		.0866	4	21	57
DH452023	2.3		.0906	4	21	57
DH452006F	2.381	3/32	.0938	4	21	57
DH452024	2.4		.0945	4	21	57
DH452025	2.5		.0984	4	21	57
DH452026	2.6		.1024	4	21	57
DH452027	2.7		.1063	4	21	57
DH452007F	2.778	7/64	.1094	4	21	57
DH452028	2.8		.1102	4	21	57
DH452029	2.9		.1142	4	21	57
DH452030	3.0		.1181	6	28	66
DH452031	3.1		.1220	6	28	66
DH452008F	3.175	1/8	.1250	6	28	66
DH452032	3.2		.1260	6	28	66

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH452033	3.3		.1299	6	28	66
DH452034	3.4		.1339	6	28	66
DH452035	3.5		.1378	6	28	66
DH452009F	3.572	9/64	.1406	6	28	66
DH452036	3.6		.1417	6	28	66
DH452037	3.7		.1457	6	28	66
DH452038	3.8		.1496	6	36	74
DH452039	3.9		.1535	6	36	74
DH452010F	3.969	5/32	.1563	6	36	74
DH452040	4.0		.1575	6	36	74
DH452041	4.1		.1614	6	36	74
DH452042	4.2		.1654	6	36	74
DH452043	4.3		.1693	6	36	74
DH452011F	4.366	11/64	.1719	6	36	74
DH452044	4.4		.1732	6	36	74
DH452045	4.5		.1772	6	36	74
DH452046	4.6		.1811	6	36	74
DH452047	4.7		.1850	6	36	74
DH452012F	4.763	3/16	.1875	6	36	74
DH452048	4.8		.1890	6	44	82
DH452049	4.9		.1929	6	44	82
DH452050	5.0		.1969	6	44	82
DH452051	5.1		.2008	6	44	82
DH452013F	5.159	13/64	.2031	6	44	82
DH452052	5.2		.2047	6	44	82
DH452053	5.3		.2087	6	44	82
DH452054	5.4		.2126	6	44	82
DH452055	5.5		.2165	6	44	82

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

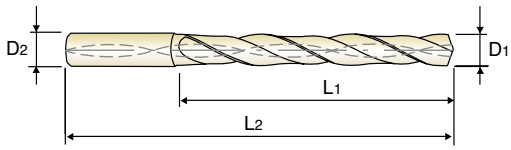
DREAM DRILLS -INOX

DH452 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

LONG

- ▶Special flute shape and geometry suitable for machining stainless steel.
- ▶Excellent chip evacuation from better surface treatment.
- ▶Point R-thinning achieving superior centering and chip curl.
- ▶TiAlN coating for better surface finishes and longer tool life.
- ▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ for stainless steel

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH452014F	5.556	7/32	.2188	6	44	82
DH452056	5.6		.2205	6	44	82
DH452057	5.7		.2244	6	44	82
DH452058	5.8		.2283	6	44	82
DH452059	5.9		.2323	6	44	82
DH452015F	5.953	15/64	.2344	6	44	82
DH452060	6.0		.2362	6	44	82
DH452061	6.1		.2402	8	53	91
DH452062	6.2		.2441	8	53	91
DH452063	6.3		.2480	8	53	91
DH452016F	6.35	1/4	.2500	8	53	91
DH452064	6.4		.2520	8	53	91
DH452065	6.5		.2559	8	53	91
DH452066	6.6		.2598	8	53	91
DH452067	6.7		.2638	8	53	91
DH452017F	6.747	17/64	.2656	8	53	91
DH452068	6.8		.2677	8	53	91
DH452069	6.9		.2717	8	53	91
DH452070	7.0		.2756	8	53	91
DH452071	7.1		.2795	8	53	91
DH452018F	7.144	9/32	.2812	8	53	91
DH452072	7.2		.2835	8	53	91
DH452073	7.3		.2874	8	53	91
DH452074	7.4		.2913	8	53	91
DH452075	7.5		.2953	8	53	91
DH452019F	7.541	19/64	.2969	8	53	91
DH452076	7.6		.2992	8	53	91
DH452077	7.7		.3031	8	53	91

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH452078	7.8		.3071	8	53	91
DH452079	7.9		.3110	8	53	91
DH452020F	7.938	5/16	.3125	8	53	91
DH452080	8.0		.3150	8	53	91
DH452081	8.1		.3189	10	61	103
DH452082	8.2		.3228	10	61	103
DH452083	8.3		.3268	10	61	103
DH452021F	8.334	21/64	.3281	10	61	103
DH452084	8.4		.3307	10	61	103
DH452085	8.5		.3346	10	61	103
DH452086	8.6		.3386	10	61	103
DH452087	8.7		.3425	10	61	103
DH452022F	8.731	11/32	.3438	10	61	103
DH452088	8.8		.3465	10	61	103
DH452089	8.9		.3504	10	61	103
DH452090	9.0		.3543	10	61	103
DH452091	9.1		.3583	10	61	103
DH452023F	9.128	23/64	.3594	10	61	103
DH452092	9.2		.3622	10	61	103
DH452093	9.3		.3661	10	61	103
DH452094	9.4		.3701	10	61	103
DH452095	9.5		.3740	10	61	103
DH452024F	9.525	3/8	.3750	10	61	103
DH452096	9.6		.3780	10	61	103
DH452097	9.7		.3819	10	61	103
DH452098	9.8		.3858	10	61	103
DH452099	9.9		.3898	10	61	103
DH452025F	9.922	25/64	.3906	10	61	103

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

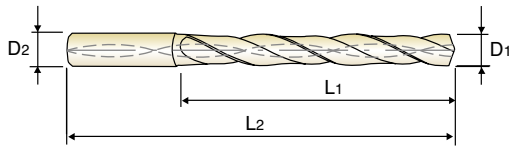
DREAM DRILLS -INOX

DH452 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

LONG

▶Special flute shape and geometry suitable for machining stainless steel.
▶Excellent chip evacuation from better surface treatment.
▶Point R-thinning achieving superior centering and chip curl.
▶TiAlN coating for better surface finishes and longer tool life.
▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ **for stainless steel**

5×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH452100	10.0		.3937	10	61	103
DH452101	10.1		.3976	12	71	118
DH452102	10.2		.4016	12	71	118
DH452103	10.3		.4055	12	71	118
DH452026F	10.319	13/32	.4062	12	71	118
DH452104	10.4		.4094	12	71	118
DH452105	10.5		.4134	12	71	118
DH452106	10.6		.4173	12	71	118
DH452107	10.7		.4212	12	71	118
DH452027F	10.716	27/64	.4219	12	71	118
DH452108	10.8		.4252	12	71	118
DH452109	10.9		.4291	12	71	118
DH452110	11.0		.4330	12	71	118
DH452111	11.1		.4370	12	71	118
DH452028F	11.113	7/16	.4375	12	71	118
DH452112	11.2		.4409	12	71	118
DH452113	11.3		.4448	12	71	118
DH452114	11.4		.4488	12	71	118
DH452115	11.5		.4527	12	71	118
DH452029F	11.509	29/64	.4531	12	71	118
DH452116	11.6		.4566	12	71	118
DH452117	11.7		.4606	12	71	118
DH452118	11.8		.4645	12	71	118
DH452119	11.9		.4685	12	71	118

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH452030F	11.906	15/32	.4688	12	71	118
DH452120	12.0		.4724	12	71	118
DH452031F	12.303	31/64	.4844	14	77	124
DH452125	12.5		.4921	14	77	124
DH452032F	12.7	1/2	.5000	14	77	124
DH452130	13.0		.5118	14	77	124
DH452135	13.5		.5314	14	77	124
DH452140	14.0		.5512	14	77	124
DH452036F	14.288	9/16	.5625	16	83	133
DH452145	14.5		.5708	16	83	133
DH452150	15.0		.5905	16	83	133
DH452155	15.5		.6102	16	83	133
DH452040F	15.875	5/8	.6250	16	83	133
DH452160	16.0		.6299	16	83	133
DH452165	16.5		.6495	18	93	143
DH452170	17.0		.6692	18	93	143
DH452175	17.5		.6889	18	93	143
DH452180	18.0		.7087	18	93	143
DH452185	18.5		.7283	20	101	153
DH452190	19.0		.7480	20	101	153
DH452048F	19.05	3/4	.7500	20	101	153
DH452195	19.5		.7676	20	101	153
DH452200	20.0		.7874	20	101	153

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

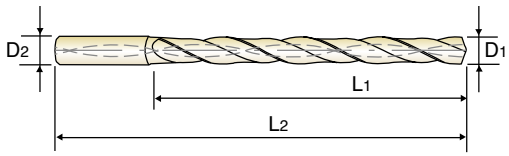
DREAM DRILLS -INOX

DH453 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

EXTRA LONG

▶Special flute shape and geometry suitable for machining stainless steel.
▶Excellent chip evacuation from better surface treatment.
▶Point R-thinning achieving superior centering and chip curl.
▶TiAlN coating for better surface finishes and longer tool life.
▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ **for stainless steel**

8×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH453030	3.0		.1181	6	34	72
DH453031	3.1		.1220	6	34	72
DH453008F	3.175	1/8	.1250	6	34	72
DH453032	3.2		.1260	6	34	72
DH453033	3.3		.1299	6	34	72
DH453034	3.4		.1339	6	34	72
DH453229G	3.454	#29	.1360	6	34	72
DH453035	3.5		.1378	6	34	72
DH453009F	3.572	9/64	.1406	6	34	72
DH453036	3.6		.1417	6	34	72
DH453037	3.7		.1457	6	34	72
DH453038	3.8		.1496	6	43	81
DH453039	3.9		.1535	6	43	81
DH453010F	3.969	5/32	.1563	6	43	81
DH453040	4.0		.1575	6	43	81
DH453221G	4.038	#21	.1590	6	43	81
DH453041	4.1		.1614	6	43	81
DH453042	4.2		.1654	6	43	81
DH453043	4.3		.1693	6	43	81
DH453011F	4.366	11/64	.1719	6	43	81
DH453044	4.4		.1732	6	43	81
DH453045	4.5		.1772	6	43	81
DH453046	4.6		.1811	6	43	81
DH453047	4.7		.1850	6	43	81
DH453012F	4.763	3/16	.1875	6	57	95
DH453048	4.8		.1890	6	57	95
DH453049	4.9		.1929	6	57	95
DH453050	5.0		.1969	6	57	95
DH453051	5.1		.2008	6	57	95
DH453013F	5.159	13/64	.2031	6	57	95
DH453052	5.2		.2047	6	57	95
DH453053	5.3		.2087	6	57	95
DH453054	5.4		.2126	6	57	95
DH453055	5.5		.2165	6	57	95
DH453014F	5.556	7/32	.2188	6	57	95
DH453056	5.6		.2205	6	57	95
DH453057	5.7		.2244	6	57	95
DH453058	5.8		.2283	6	57	95
DH453059	5.9		.2323	6	57	95
DH453015F	5.953	15/64	.2344	6	57	95
DH453060	6.0		.2362	6	57	95
DH453061	6.1		.2402	8	76	114
DH453062	6.2		.2441	8	76	114
DH453063	6.3		.2480	8	76	114
DH453016F	6.35	1/4	.2500	8	76	114
DH453064	6.4		.2520	8	76	114
DH453065	6.5		.2559	8	76	114
DH453106L	6.527	F	.2570	8	76	114
DH453066	6.6		.2598	8	76	114
DH453067	6.7		.2638	8	76	114
DH453017F	6.747	17/64	.2656	8	76	114
DH453068	6.8		.2677	8	76	114
DH453069	6.9		.2717	8	76	114
DH453070	7.0		.2756	8	76	114

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

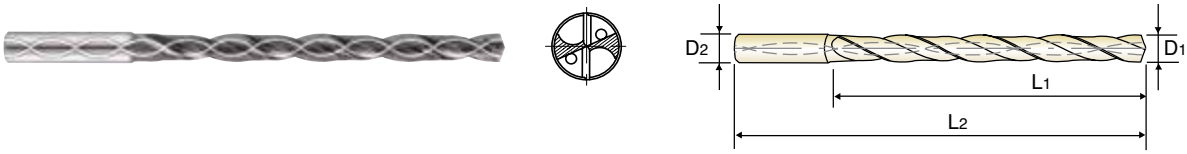
DREAM DRILLS -INOX

DH453 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

EXTRA LONG

▶Special flute shape and geometry suitable for machining stainless steel.
▶Excellent chip evacuation from better surface treatment.
▶Point R-thinning achieving superior centering and chip curl.
▶TiAlN coating for better surface finishes and longer tool life.
▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ **for stainless steel** 8×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH453071	7.1		.2795	8	76	114
DH453018F	7.144	9/32	.2813	8	76	114
DH453072	7.2		.2835	8	76	114
DH453073	7.3		.2874	8	76	114
DH453074	7.4		.2913	8	76	114
DH453075	7.5		.2953	8	76	114
DH453019F	7.541	19/64	.2969	8	76	114
DH453076	7.6		.2992	8	76	114
DH453077	7.7		.3031	8	76	114
DH453078	7.8		.3071	8	76	114
DH453079	7.9		.3110	8	76	114
DH453020F	7.938	5/16	.3125	8	76	114
DH453080	8.0		.3150	8	76	114
DH453081	8.1		.3189	10	95	142
DH453082	8.2		.3228	10	95	142
DH453083	8.3		.3268	10	95	142
DH453021F	8.334	21/64	.3281	10	95	142
DH453084	8.4		.3307	10	95	142
DH453117L	8.432	Q	.3320	10	95	142
DH453085	8.5		.3346	10	95	142
DH453086	8.6		.3386	10	95	142
DH453087	8.7		.3425	10	95	142
DH453022F	8.731	11/32	.3438	10	95	142
DH453088	8.8		.3465	10	95	142
DH453089	8.9		.3504	10	95	142
DH453090	9.0		.3543	10	95	142

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH453091	9.1		.3583	10	95	142
DH453023F	9.128	23/64	.3594	10	95	142
DH453092	9.2		.3622	10	95	142
DH453093	9.3		.3661	10	95	142
DH453121L	9.347	U	.3680	10	95	142
DH453094	9.4		.3701	10	95	142
DH453095	9.5		.3740	10	95	142
DH453024F	9.525	3/8	.3750	10	95	142
DH453096	9.6		.3780	10	95	142
DH453097	9.7		.3819	10	95	142
DH453098	9.8		.3858	10	95	142
DH453099	9.9		.3898	10	95	142
DH453025F	9.922	25/64	.3906	10	95	142
DH453100	10.0		.3937	10	95	142
DH453101	10.1		.3976	12	114	162
DH453102	10.2		.4016	12	114	162
DH453103	10.3		.4055	12	114	162
DH453026F	10.319	13/32	.4063	12	114	162
DH453104	10.4		.4094	12	114	162
DH453105	10.5		.4134	12	114	162
DH453106	10.6		.4173	12	114	162
DH453107	10.7		.4212	12	114	162
DH453027F	10.716	27/64	.4219	12	114	162
DH453108	10.8		.4252	12	114	162
DH453109	10.9		.4291	12	114	162
DH453110	11.0		.4330	12	114	162

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55		HRc55~							
◎	◎	○				◎		○				○

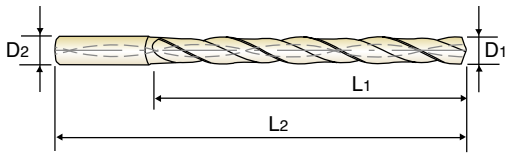
DREAM DRILLS -INOX

DH453 SERIES

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES

EXTRA LONG

▶Special flute shape and geometry suitable for machining stainless steel.
▶Excellent chip evacuation from better surface treatment.
▶Point R-thinning achieving superior centering and chip curl.
▶TiAlN coating for better surface finishes and longer tool life.
▶Tolerance : Dia. Tolerance øD1: See page 253, Shank Tolerance øD2: -.0001 -.0005



DIN 6537 | MG | h6 | m7 | 140° | 20 bar

P.108

▶ **for stainless steel**

8 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH453111	11.1		.4370	12	114	162
DH453028F	11.113	7/16	.4375	12	114	162
DH453112	11.2		.4409	12	114	162
DH453113	11.3		.4448	12	114	162
DH453114	11.4		.4488	12	114	162
DH453115	11.5		.4527	12	114	162
DH453116	11.6		.4566	12	114	162
DH453117	11.7		.4606	12	114	162
DH453118	11.8		.4645	12	114	162
DH453119	11.9		.4685	12	114	162

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH453030F	11.906	15/32	.4688	12	114	162
DH453120	12.0		.4724	12	114	162
DH453031F	12.303	31/64	.4844	14	133	178
DH453125	12.5		.4921	14	133	178
DH453032F	12.7	1/2	.5000	14	133	178
DH453130	13.0		.5118	14	133	178
DH453033F	13.097	33/64	.5156	14	133	178
DH453135	13.5		.5314	14	133	178
DH453140	14.0		.5512	14	133	178

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				◎		○				○

DREAM DRILLS -INOX

RECOMMENDED CUTTING CONDITIONS

CARBIDE, DREAM DRILLS - INOX with COOLANT HOLES, TiAlN COATED

DH451, DH463, DH714, DH452, DH464, DH715, DH453 SERIES

WORK MATERIAL			P			M			M			N		
			CARBON STEELS ALLOY STEELS			STAINLESS STEELS			STAINLESS STEELS			ALUMINUM		
STRENGTH						< 800 N/mm²			> 800 N/mm²			< 10% Si		
DRILLING SPEED(SFM)			260 ~ 410 ft/min			120 ~ 230 ft/min			60 ~ 140 ft/min			490 ~ 720 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal	Fractional												
1.0	.0394		26000	0.02	.001	12000	0.02	.001	6200	0.02	.001	48000	0.04	.002
1.5	.0591		18000	0.03	.001	9000	0.03	.001	5400	0.02	.001	43000	0.05	.002
2.5	.0984		10800	0.05	.002	7000	0.04	.002	4200	0.03	.001	25500	0.08	.003
3.0	.1181	1/8	13000	0.04	.002	7400	0.04	.002	4700	0.02	.001	23000	0.12	.005
4.0	.1575	5/32	10000	0.05	.002	5600	0.05	.002	3600	0.03	.001	17500	0.18	.007
5.0	.1969	13/64	8000	0.05	.002	4400	0.05	.002	2800	0.03	.001	14000	0.20	.008
6.0	.2362	15/64	6600	0.06	.002	3700	0.06	.002	2400	0.04	.002	11700	0.25	.010
8.0	.3150	5/16	5000	0.08	.003	2800	0.08	.003	1800	0.06	.002	8800	0.30	.012
10.0	.3937	25/64	4000	0.10	.004	2200	0.10	.004	1400	0.08	.003	7000	0.40	.016
12.0	.4724	15/32	3300	0.12	.005	1900	0.12	.005	1200	0.10	.004	5800	0.50	.020
14.0	.5512	35/64	2800	0.15	.006	1600	0.15	.006	1000	0.12	.005	5000	0.60	.024
16.0	.6299	5/8	2500	0.20	.008	1400	0.20	.008	900	0.15	.006	4380	0.80	.031
18.0	.7087	45/64	2200	0.22	.009	1250	0.22	.009	800	0.17	.007	3900	1.00	.039
20.0	.7874	25/32	2000	0.24	.009	1120	0.24	.009	720	0.19	.007	3500	1.20	.047

WORK MATERIAL			N			N			S		
			ALUMINUM			NON FRERROUS			TITANIUM TITANIUM ALLOYS		
STRENGTH			< 10% Si								
DRILLING SPEED(SFM)			390 ~ 570 ft/min			390 ~ 490 ft/min			80 ~ 160 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR
Metric(mm)	Decimal	Fractional									
1.0	.0394		38000	0.03	.001	38000	0.02	.001	8100	0.01	.0004
1.5	.0591		32000	0.04	.002	25500	0.03	.001	7500	0.01	.0004
2.5	.0984		19500	0.06	.002	15500	0.05	.002	4500	0.02	.001
3.0	.1181	1/8	18500	0.10	.004	16000	0.08	.003	5300	0.03	.001
4.0	.1575	5/32	13900	0.15	.006	11900	0.10	.004	4000	0.04	.002
5.0	.1969	13/64	11000	0.18	.007	9500	0.12	.005	3200	0.05	.002
6.0	.2362	15/64	9300	0.25	.010	8000	0.15	.006	2650	0.06	.002
8.0	.3150	5/16	7000	0.30	.012	6000	0.18	.007	2000	0.07	.003
10.0	.3937	25/64	5600	0.35	.014	4800	0.22	.009	1600	0.08	.003
12.0	.4724	15/32	4600	0.40	.016	4000	0.26	.010	1300	0.10	.004
14.0	.5512	35/64	4000	0.50	.020	3400	0.30	.012	1100	0.12	.005
16.0	.6299	5/8	3500	0.60	.024	3000	0.40	.016	1000	0.14	.006
18.0	.7087	45/64	3100	0.70	.028	2650	0.45	.018	900	0.16	.006
20.0	.7874	25/32	2800	0.80	.031	2400	0.50	.020	800	0.18	.007

▶ Recommend to reduce the feed rate as following
DH463/DH714/DH451(3xD), DH464/DH714/DH452(5xD) : Feed 100%
DH453(8xD) : Feed 85%

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

CARBIDE

YG

Being the best through innovation

DREAM DRILLS -ALU

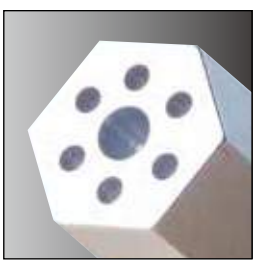
- WITH COOLANT HOLES
  for Aluminum & Aluminum Alloys

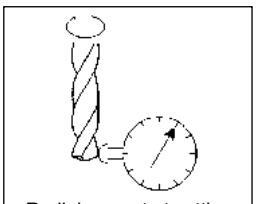
SOLID CARBIDE DREAM DRILLS - ALU (with Coolant Holes)

ITEM	MODEL	DESCRIPTION		SIZE MIN	SIZE MAX	PAGE
INCH						
5XD	DGE466 DGE718 	CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES	*LONG*	D13/64	D1/2	**112**
METRIC						
5XD	DGE433 	CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES	*LONG*	D3.0	D20.0	**113**
		RECOMMENDED CUTTING CONDITIONS				**116**

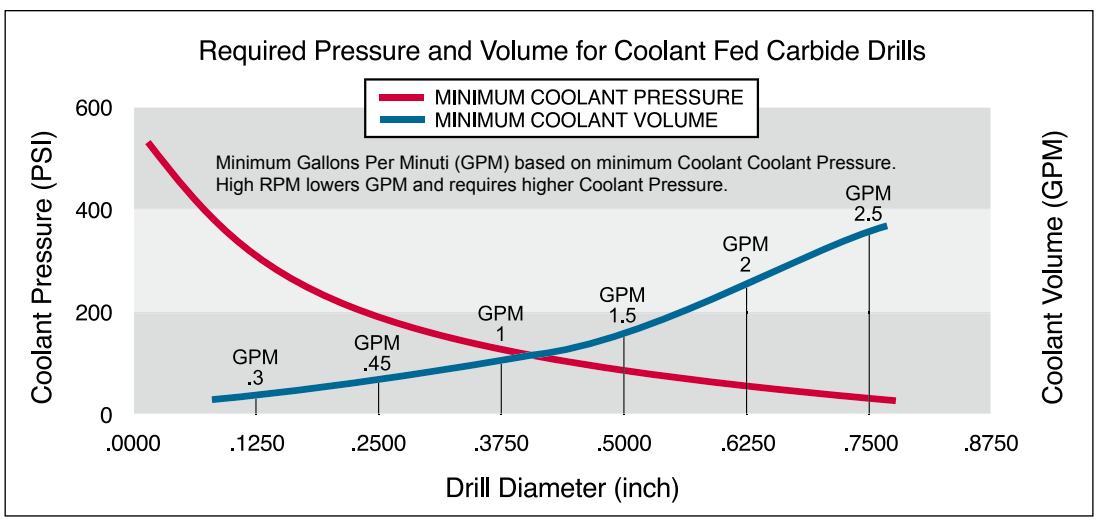
◎ : Excellent ○ : Good

				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
							◎				
							◎				





• Radial run out at cutting lip must not exceed .001



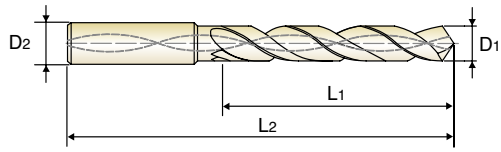
DREAM DRILLS -ALU

DGE466, DGE718 SERIES

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

LONG

▶Wider and deeper flute gullets for maximum chip removal
▶Special geometry and smooth coating reduces built up edge and improves finishes
▶Tolerance : Dia. Tolerance ØD1: See page 57, Shank Tolerance ØD2: -.0001 -.0005



MG | h6 | 118° | 20 bar P.116

▶ for aluminum

5×D

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
DLC	D1		D2	L1	L2
DGE466013	13/64	.2031	15/64	1-3/4	3-15/16
DGE718013	13/64	.2031	1/4	1-3/4	3-15/16
DGE466014	7/32	.2188	15/64	1-57/64	3-15/16
DGE718014	7/32	.2188	1/4	1-57/64	3-15/16
DGE466015	15/64	.2344	15/64	1-57/64	3-15/16
DGE718015	15/64	.2344	1/4	1-57/64	3-15/16
DGE718016	1/4	.2500	1/4	2-3/64	4-19/64
DGE466016	1/4	.2500	17/64	2-3/64	4-19/64
DGE466206	F	.2570	17/64	2-13/64	4-19/64
DGE718206	F	.2570	5/16	2-13/64	4-19/64
DGE466017	17/64	.2656	17/64	2-13/64	4-19/64
DGE718017	17/64	.2656	5/16	2-13/64	4-19/64
DGE466209	I	.2720	.272	2-13/64	4-19/64
DGE718209	I	.2720	5/16	2-13/64	4-19/64
DGE466018	9/32	.2812	5/16	2-23/64	4-41/64
DGE466019	19/64	.2969	5/16	2-33/64	4-41/64
DGE466020	5/16	.3125	5/16	2-33/64	4-41/64
DGE466021	21/64	.3281	11/32	2-43/64	5
DGE718021	21/64	.3281	3/8	2-43/64	5
DGE466217	Q	.3320	11/32	2-43/64	5
DGE718217	Q	.3320	3/8	2-43/64	5
DGE466022	11/32	.3438	11/32	2-27/32	5

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
DLC	D1		D2	L1	L2
DGE718022	11/32	.3438	3/8	2-27/32	5
DGE718023	23/64	.3594	3/8	3	5-23/64
DGE466023	23/64	.3594	25/64	3	5-23/64
DGE718221	U	.3680	3/8	3	5-23/64
DGE466221	U	.3680	25/64	3	5-23/64
DGE718024	3/8	.3750	3/8	3-5/32	5-23/64
DGE466024	3/8	.3750	25/64	3-5/32	5-23/64
DGE466025	25/64	.3906	25/64	3-5/32	5-23/64
DGE718025	25/64	.3906	7/16	3-5/32	5-23/64
DGE466026	13/32	.4062	27/64	3-5/16	5-7/8
DGE718026	13/32	.4062	7/16	3-5/16	5-7/8
DGE466027	27/64	.4219	27/64	3-15/32	5-7/8
DGE718027	27/64	.4219	7/16	3-15/32	5-7/8
DGE718028	7/16	.4375	7/16	3-5/8	6-7/32
DGE466028	7/16	.4375	15/32	3-5/8	6-7/32
DGE466029	29/64	.4531	15/32	3-25/32	6-7/32
DGE718029	29/64	.4531	1/2	3-25/32	6-7/32
DGE466030	15/32	.4688	15/32	3-25/32	6-7/32
DGE718030	15/32	.4688	1/2	3-25/32	6-7/32
DGE466031	31/64	.4844	1/2	3-15/16	6-37/64
DGE466032	1/2	.5000	1/2	4-3/32	6-37/64

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
							◎				

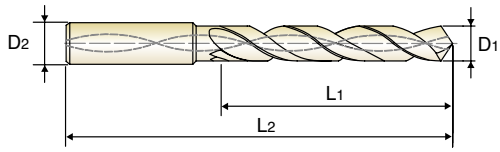
DREAM DRILLS -ALU

DGE433 SERIES

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

LONG

▶Wider and deeper flute gullets for maximum chip removal
▶Special geometry and smooth coating reduces built up edge and improves finishes



DIN 6537 | MG | h6 | m7 | 118° | 20 bar P.116

▶ **for aluminum**

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433030	3.0		.1181	6	28	66
DGE433031	3.1		.1220	6	28	66
DGE433008F	3.175	1/8	.1250	6	28	66
DGE433032	3.2		.1260	6	28	66
DGE433033	3.3		.1299	6	28	66
DGE433034	3.4		.1339	6	28	66
DGE433035	3.5		.1378	6	28	66
DGE433009F	3.572	9/64	.1406	6	28	66
DGE433036	3.6		.1417	6	28	66
DGE433037	3.7		.1457	6	28	66
DGE433038	3.8		.1496	6	36	74
DGE433039	3.9		.1535	6	36	74
DGE433010F	3.969	5/32	.1563	6	36	74
DGE433040	4.0		.1575	6	36	74
DGE433041	4.1		.1614	6	36	74
DGE433042	4.2		.1654	6	36	74
DGE433043	4.3		.1693	6	36	74
DGE433011F	4.366	11/64	.1719	6	36	74
DGE433044	4.4		.1732	6	36	74
DGE433045	4.5		.1772	6	36	74
DGE433046	4.6		.1811	6	36	74
DGE433047	4.7		.1850	6	36	74
DGE433012F	4.763	3/16	.1875	6	36	74
DGE433048	4.8		.1890	6	44	82

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433049	4.9		.1929	6	44	82
DGE433050	5.0		.1969	6	44	82
DGE433051	5.1		.2008	6	44	82
DGE433013F	5.159	13/64	.2031	6	44	82
DGE433052	5.2		.2047	6	44	82
DGE433053	5.3		.2087	6	44	82
DGE433054	5.4		.2126	6	44	82
DGE433055	5.5		.2165	6	44	82
DGE433014F	5.556	7/32	.2188	6	44	82
DGE433056	5.6		.2205	6	44	82
DGE433057	5.7		.2244	6	44	82
DGE433058	5.8		.2283	6	44	82
DGE433059	5.9		.2323	6	44	82
DGE433015F	5.953	15/64	.2344	6	44	82
DGE433060	6.0		.2362	6	44	82
DGE433061	6.1		.2402	8	53	91
DGE433062	6.2		.2441	8	53	91
DGE433063	6.3		.2480	8	53	91
DGE433016F	6.35	1/4	.2500	8	53	91
DGE433064	6.4		.2520	8	53	91
DGE433065	6.5		.2559	8	53	91
DGE433066	6.6		.2598	8	53	91
DGE433067	6.7		.2638	8	53	91
DGE433017F	6.747	17/64	.2656	8	53	91

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
								◎				

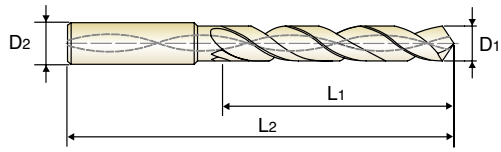
DREAM DRILLS -ALU

DGE433 SERIES

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

LONG

▶Wider and deeper flute gullets for maximum chip removal
▶Special geometry and smooth coating reduces built up edge and improves finishes



DIN 6537 | MG | h6 | m7 | 118° | 20 bar

P.116

▶ **for aluminum**

5×D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433068	6.8		.2677	8	53	91
DGE433069	6.9		.2717	8	53	91
DGE433070	7.0		.2756	8	53	91
DGE433071	7.1		.2795	8	53	91
DGE433018F	7.144	9/32	.2812	8	53	91
DGE433072	7.2		.2835	8	53	91
DGE433073	7.3		.2874	8	53	91
DGE433074	7.4		.2913	8	53	91
DGE433075	7.5		.2953	8	53	91
DGE433019F	7.541	19/64	.2969	8	53	91
DGE433076	7.6		.2992	8	53	91
DGE433077	7.7		.3031	8	53	91
DGE433078	7.8		.3071	8	53	91
DGE433079	7.9		.3110	8	53	91
DGE433020F	7.938	5/16	.3125	8	53	91
DGE433080	8.0		.3150	8	53	91
DGE433081	8.1		.3189	10	61	103
DGE433082	8.2		.3228	10	61	103
DGE433083	8.3		.3268	10	61	103
DGE433021F	8.334	21/64	.3281	10	61	103
DGE433084	8.4		.3307	10	61	103
DGE433085	8.5		.3346	10	61	103
DGE433086	8.6		.3386	10	61	103
DGE433087	8.7		.3425	10	61	103
DGE433022F	8.731	11/32	.3438	10	61	103
DGE433088	8.8		.3465	10	61	103

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433089	8.9		.3504	10	61	103
DGE433090	9.0		.3543	10	61	103
DGE433091	9.1		.3583	10	61	103
DGE433023F	9.128	23/64	.3594	10	61	103
DGE433092	9.2		.3622	10	61	103
DGE433093	9.3		.3661	10	61	103
DGE433094	9.4		.3701	10	61	103
DGE433095	9.5		.3740	10	61	103
DGE433024F	9.525	3/8	.3750	10	61	103
DGE433096	9.6		.3780	10	61	103
DGE433097	9.7		.3819	10	61	103
DGE433098	9.8		.3858	10	61	103
DGE433099	9.9		.3898	10	61	103
DGE433025F	9.922	25/64	.3906	10	61	103
DGE433100	10.0		.3937	10	61	103
DGE433101	10.1		.3976	12	71	118
DGE433102	10.2		.4016	12	71	118
DGE433103	10.3		.4055	12	71	118
DGE433026F	10.319	13/32	.4062	12	71	118
DGE433104	10.4		.4094	12	71	118
DGE433105	10.5		.4134	12	71	118
DGE433106	10.6		.4173	12	71	118
DGE433107	10.7		.4212	12	71	118
DGE433027F	10.716	27/64	.4219	12	71	118
DGE433108	10.8		.4252	12	71	118
DGE433109	10.9		.4291	12	71	118

▶ Other shank types are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55		HRc55~							
								◎				

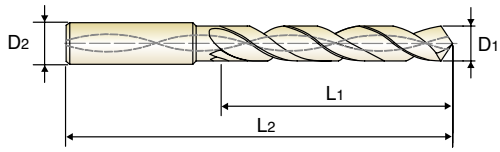
DREAM DRILLS -ALU

DGE433 SERIES

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES

LONG

▶Wider and deeper flute gullets for maximum chip removal
▶Special geometry and smooth coating reduces built up edge and improves finishes



DIN 6537 | MG | h6 | m7 | 118° | 20 bar P.116

▶ **for aluminum**

5 × D

Unit : mm

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433110	11.0		.4330	12	71	118
DGE433111	11.1		.4370	12	71	118
DGE433028F	11.113	7/16	.4375	12	71	118
DGE433112	11.2		.4409	12	71	118
DGE433113	11.3		.4448	12	71	118
DGE433114	11.4		.4488	12	71	118
DGE433115	11.5		.4527	12	71	118
DGE433029F	11.509	29/64	.4531	12	71	118
DGE433116	11.6		.4566	12	71	118
DGE433117	11.7		.4606	12	71	118
DGE433118	11.8		.4645	12	71	118
DGE433119	11.9		.4685	12	71	118
DGE433030F	11.906	15/32	.4688	12	71	118
DGE433120	12.0		.4724	12	71	118
DGE433031F	12.303	31/64	.4844	14	77	124
DGE433125	12.5		.4921	14	77	124
DGE433032F	12.7	1/2	.5000	14	77	124
DGE433130	13.0		.5118	14	77	124

EDP No.	Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
DLC	D1			D2	L1	L2
DGE433135	13.5		.5314	14	77	124
DGE433140	14.0		.5512	14	77	124
DGE433036F	14.288	9/16	.5625	16	83	133
DGE433145	14.5		.5708	16	83	133
DGE433150	15.0		.5905	16	83	133
DGE433155	15.5		.6102	16	83	133
DGE433040F	15.875	5/8	.6250	16	83	133
DGE433160	16.0		.6299	16	83	133
DGE433165	16.5		.6495	18	93	143
DGE433170	17.0		.6692	18	93	143
DGE433175	17.5		.6889	18	93	143
DGE433180	18.0		.7087	18	93	143
DGE433185	18.5		.7283	20	101	153
DGE433190	19.0		.7480	20	101	153
DGE433048F	19.05	3/4	.7500	20	101	153
DGE433195	19.5		.7676	20	101	153
DGE433200	20.0		.7874	20	101	153

▶ Other shank types are available on your request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
								◎				

DREAM DRILLS -ALU

RECOMMENDED CUTTING CONDITIONS

CARBIDE, DREAM DRILLS - ALU with COOLANT HOLES, DLC COATED

DGE466, DGE718, DGE433 SERIES

WORK MATERIAL		N							
		ALUMINUM ALLOY CASTING ALUMINUM DIE CASTING				WROUGHT ALUMINUM ALLOY			
DRILLING SPEED(SFM)		240 ~ 650 ft/min				240 ~ 650 ft/min			
DIAMETER		N	S	IPR		N	S	IPR	
Metric(mm)	Decimal								
3.0~6.0	.1181 ~ .2362	8000 ~ 15000	0.2 ~ 0.5	.008	.020	8000 ~ 15000	0.15 ~ 0.3	.006	.012
~10.0	~.3937	6000 ~ 10500	0.3 ~ 1.0	.012	.039	6000 ~ 10500	0.20 ~ 0.4	.008	.016
~14.0	~.5512	4500 ~ 5800	0.3 ~ 1.0	.012	.039	4500 ~ 5800	0.20 ~ 0.4	.008	.016
~20.0	~.7874	3200 ~ 4600	0.3 ~ 1.0	.012	.039	3200 ~ 4600	0.30 ~ 1.0	.012	.039

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

CARBIDE

Being the best through innovation

DREAM DRILLS -CFRP

- For composite materials including CFRP, GFRP

SOLID CARBIDE DREAM DRILLS - CFRP
For composite materials including CFRP, GFRP

◎ : Excellent ○ : Good

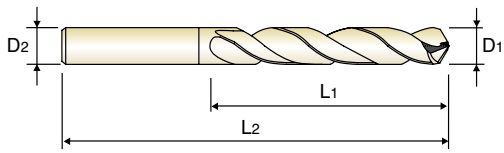
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
										◎	

DREAM DRILLS -CFRP

DI473 SERIES

CARBIDE, DREAM DRILLS-CFRP

- Special Point Type to improve hole quality for Composite Materials
  -> Minimized Burr and Delamination at Entry / Exit Hole.
- Outstanding Performance
- Long Tool Life and Increased product by Diamond Coating.



DIN 6537 | MG | h6 | m7 | 118° P.121

Unit : Inch

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
DIAMOND COATED	D1		D2	L1	L2
DI473040G	#40	.0980	.2362	.9449	2.5984
DI473008F	1/8	.1250	.2362	1.1024	2.5984
DI473030G	#30	.1285	.2362	1.1024	2.5984
DI473010F	5/32	.1562	.2362	1.4173	2.9134
DI473021G	#21	.1590	.2362	1.4173	2.9134
DI473012F	3/16	.1875	.2362	1.4173	2.9134
DI473012G	#12	.1890	.2362	1.7323	3.2283
DI473011G	#11	.1910	.2362	1.7323	3.2283
DI473007G	#7	.2010	.2362	1.7323	3.2283
DI473013F	13/64	.2031	.2362	1.7323	3.2283
DI473014F	7/32	.2188	.2362	1.7323	3.2283
DI473015F	15/64	.2344	.2362	1.7323	3.2283
DI473016F	1/4	.2500	.3150	2.0866	3.5827
DI473020F	5/16	.3125	.3150	2.0866	3.5827
DI473024F	3/8	.3750	.3937	2.4016	4.0551
DI473028F	7/16	.4375	.4724	2.7953	4.6457
DI473032F	1/2	.5000	.5512	3.0315	4.8819
DI473036F	9/16	.5625	.6299	3.2677	5.2362
DI473040F	5/8	.6250	.6299	3.2677	5.2362
DI473044F	11/16	.6875	.7087	3.6614	5.6299
DI473048F	3/4	.7500	.7874	3.9764	6.0236

Unit : mm

Shank Diameter	Flute Length	Overall Length
D2	L1	L2
6	24	66
6	28	66
6	28	66
6	36	74
6	36	74
6	36	74
6	44	82
6	44	82
6	44	82
6	44	82
6	44	82
6	44	82
6	44	82
8	53	91
8	53	91
10	61	103
12	71	118
14	77	124
16	83	133
16	83	133
18	93	143
20	101	153

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
										◎	

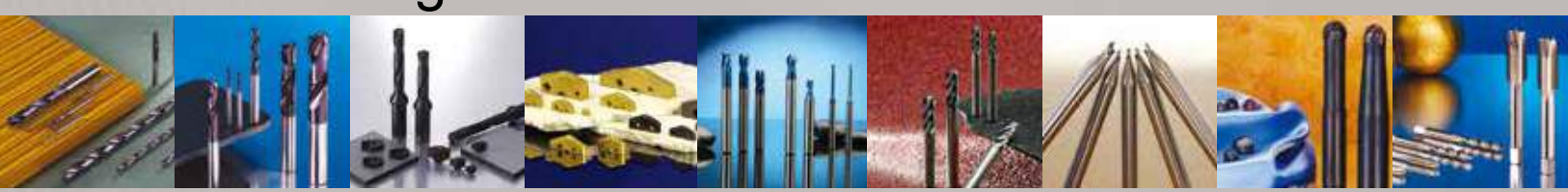
CARBIDE, DREAM DRILLS - CFRP

D1473 SERIES

WORK MATERIAL	N		
	CFRP		
DRILLING SPEED	325 ~ 490 ft/min		
DRILLING DIAMETER	SFM	IPR	
		Min	Max
1/8	328 ~ 492	.0012	.0027
5/32	330 ~ 491		
3/16	328 ~ 490		
1/4	328 ~ 495		
5/16	330 ~ 495		
3/8	325 ~ 492		
1/2	330 ~ 484		
5/8	329 ~ 488		
3/4	334 ~ 482		

SFM = ft/min
IPR = feed rate (Inch/rev.)

Global Cutting Tool Leader **YG-1**



CARBIDE

Being the best through innovation

DREAM DRILLS -MQL TYPE

- **WITH COOLANT HOLES**
  Minimum Quantity Lubrication. Drilling Deep Holes, 10D, 15D, 20D, 25D & 30D

SOLID CARBIDE DREAM DRILLS - MQL TYPE (with Coolant Holes)

Minimum Quantity Lubrication. Drilling Deep Holes, 10D, 15D, 20D, 25D & 30D

ITEM	MODEL	DESCRIPTION	SIZE MIN	SIZE MAX	PAGE
METRIC					
10XD **DH510**		CARBIDE, DREAM DRILLS MQL TYPE with COOLANT HOLES *EXTRA LONG*	D3.0	D14.0	**126**
15XD **DH515**		CARBIDE, DREAM DRILLS MQL TYPE with COOLANT HOLES *EXTRA LONG*	D3.0	D12.0	**127**
20XD **DH520**		CARBIDE, DREAM DRILLS MQL TYPE with COOLANT HOLES ◇ *EXTRA LONG*	D3.0	D12.0	**127**
10XD **DHM10**		CARBIDE, DREAM DRILLS MQL TYPE END MILL SHANK with COOLANT HOLES ◇ *EXTRA LONG*	D3.0	D14.0	**128**
15XD **DHM15**		CARBIDE, DREAM DRILLS MQL TYPE END MILL SHANK with COOLANT HOLES ◇ *EXTRA LONG*	D3.0	D12.0	**128**
20XD **DHM20**		CARBIDE, DREAM DRILLS MQL TYPE END MILL SHANK with COOLANT HOLES ◇ *EXTRA LONG*	D3.0	D12.0	**128**
25XD **DHM25**		CARBIDE, DREAM DRILLS MQL TYPE END MILL SHANK with COOLANT HOLES ◇ *EXTRA LONG*	D3.0	D10.0	**129**
30XD **DHM30**		CARBIDE, DREAM DRILLS MQL TYPE END MILL SHANK with COOLANT HOLES ◇ *EXTRA LONG*	D3.0	D8.0	**129**
		RECOMMENDED CUTTING CONDITIONS			**130**

◇ Call for Availability

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					
◎	◎	○					○					

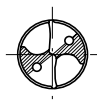
DREAM DRILLS -MQL TYPE

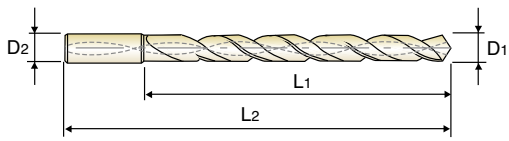
DH510 SERIES

CARBIDE, DREAM DRILLS MQL TYPE with COOLANT HOLES

EXTRA LONG

- ▶Non step drilling up to 10 times of drill diameter
- ▶Available for processing MQL(Minimum Quantity Lubrication)
- ▶Excellent positioning – Bush is not necessary
- ▶Special design – Good chip removal
- ▶Powerful drilling





MG | 30° | h6 | h7 | 140° | 20 bar P.130

10 × D

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DH510030	3.0	.1181	3	39	90
DH510033	3.3	.1299	4	46	97
DH510035	3.5	.1378	4	46	97
DH510040	4.0	.1575	4	52	103
DH510042	4.2	.1654	5	59	112
DH510045	4.5	.1772	5	59	112
DH510050	5.0	.1969	5	65	118
DH510055	5.5	.2165	6	72	127
DH510060	6.0	.2362	6	78	133
DH510065	6.5	.2559	7	85	141
DH510068	6.8	.2677	7	91	147
DH510070	7.0	.2756	7	91	147
DH510075	7.5	.2953	8	98	155

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DH510080	8.0	.3150	8	104	161
DH510085	8.5	.3346	9	111	169
DH510090	9.0	.3543	9	117	175
DH510095	9.5	.3740	10	124	182
DH510100	10.0	.3937	10	130	188
DH510105	10.5	.4134	11	137	201
DH510110	11.0	.4330	11	143	207
DH510115	11.5	.4527	12	150	215
DH510120	12.0	.4724	12	156	221
DH510125	12.5	.4921	13	163	229
DH510130	13.0	.5118	13	169	235
DH510135	13.5	.5314	14	176	243
DH510140	14.0	.5512	14	182	249

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					○					

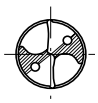
DREAM DRILLS -MQL TYPE

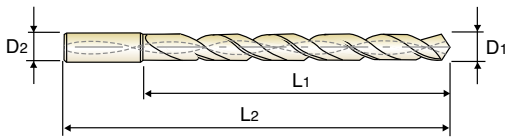
DH515 SERIES
DH520 SERIES

CARBIDE, DREAM DRILLS MQL TYPE with COOLANT HOLES

EXTRA LONG

- ▶Non step drilling up to 15 times (20 times) of drill diameter
- ▶Available for processing MQL(Minimum Quantity Lubrication)
- ▶Excellent positioning – Bush is not necessary
- ▶Special design – Good chip removal
- ▶Powerful drilling





MG | 30° | h6 | h7 | 140° | 45 bar P.130

15 × D (DH515) | 20 × D (DH520)

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DH515030	3.0	.1181	3	54	105
DH515035	3.5	.1378	4	63	114
DH515040	4.0	.1575	4	72	123
DH515045	4.5	.1772	5	81	134
DH515050	5.0	.1969	5	90	143
DH515055	5.5	.2165	6	99	154
DH515060	6.0	.2362	6	108	163
DH515070	7.0	.2756	7	126	182
DH515080	8.0	.3150	8	144	201
DH515090	9.0	.3543	9	162	220
DH515100	10.0	.3937	10	180	238
DH515110	11.0	.4330	11	198	262
DH515120	12.0	.4724	12	216	281

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DH520030	3.0	.1181	3	69	120
DH520035	3.5	.1378	4	81	132
DH520040	4.0	.1575	4	92	143
DH520045	4.5	.1772	5	104	157
DH520050	5.0	.1969	5	115	168
DH520055	5.5	.2165	6	127	182
DH520060	6.0	.2362	6	138	193
DH520070	7.0	.2756	7	161	217
DH520080	8.0	.3150	8	184	241
DH520090	9.0	.3543	9	207	265
DH520100	10.0	.3937	10	230	288
DH520120	12.0	.4724	12	276	341

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					○					

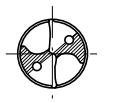
DREAM DRILLS -MQL TYPE

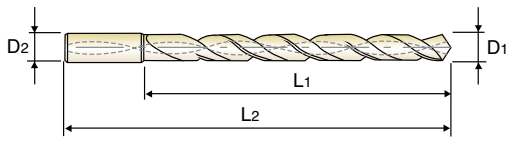
DHM10 SERIES
DHM15 SERIES
DHM20 SERIES

CARBIDE, DREAM DRILLS MQL TYPE END MILL SHANK with COOLANT HOLES

EXTRA LONG

- ▶Non step drilling up to 10 times (15 times & 20 times) of drill diameter
- ▶Available for processing MQL(Minimum Quantity Lubrication)
- ▶Excellent positioning – Bush is not necessary
- ▶Special design – Good chip removal
- ▶Powerful drilling





DHM10 DHM15 DHM20

◇ Call for Availability

MG | 30° | h6 | h7 | 140° | 20 bar | 45 bar | P.130

10 × D (DHM10) | 15 × D (DHM15) | 20 × D (DHM20)

10 × D

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DHM10030	3.0	.1181	6	40	80
DHM10033	3.3	.1299	6	47	87
DHM10035	3.5	.1378	6	47	87
DHM10040	4.0	.1575	6	53	93
DHM10042	4.2	.1654	6	60	100
DHM10045	4.5	.1772	6	60	100
DHM10050	5.0	.1969	6	66	106
DHM10055	5.5	.2165	6	73	113
DHM10060	6.0	.2362	6	79	119
DHM10065	6.5	.2559	8	86	126
DHM10068	6.8	.2677	8	92	132
DHM10070	7.0	.2756	8	92	132
DHM10075	7.5	.2953	8	99	139
DHM10080	8.0	.3150	8	105	145
DHM10085	8.5	.3346	10	112	156
DHM10090	9.0	.3543	10	118	162
DHM10095	9.5	.3740	10	126	170
DHM10100	10.0	.3937	10	132	176
DHM10105	10.5	.4134	12	139	188
DHM10110	11.0	.4330	12	145	194
DHM10115	11.5	.4527	12	152	201
DHM10120	12.0	.4724	12	158	207
DHM10125	12.5	.4921	14	165	214
DHM10130	13.0	.5118	14	171	220
DHM10135	13.5	.5314	14	178	227
DHM10140	14.0	.5512	14	184	233

15 × D

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DHM15030	3.0	.1181	6	55	95
DHM15035	3.5	.1378	6	64	104
DHM15040	4.0	.1575	6	73	113
DHM15045	4.5	.1772	6	82	122
DHM15050	5.0	.1969	6	91	131
DHM15055	5.5	.2165	6	100	140
DHM15060	6.0	.2362	6	109	149
DHM15070	7.0	.2756	8	127	167
DHM15080	8.0	.3150	8	145	185
DHM15090	9.0	.3543	10	163	207
DHM15100	10.0	.3937	10	182	226
DHM15110	11.0	.4330	12	200	249
DHM15120	12.0	.4724	12	218	267

20 × D

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DHM20030	3.0	.1181	6	70	110
DHM20035	3.5	.1378	6	82	122
DHM20040	4.0	.1575	6	93	133
DHM20045	4.5	.1772	6	105	145
DHM20050	5.0	.1969	6	116	156
DHM20055	5.5	.2165	6	128	168
DHM20060	6.0	.2362	6	139	179
DHM20070	7.0	.2756	8	162	202
DHM20080	8.0	.3150	8	185	225
DHM20090	9.0	.3543	10	208	252
DHM20100	10.0	.3937	10	232	276
DHM20110	11.0	.4330	12	255	304
DHM20120	12.0	.4724	12	278	327

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					○					

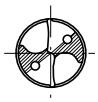
DREAM DRILLS -MQL TYPE

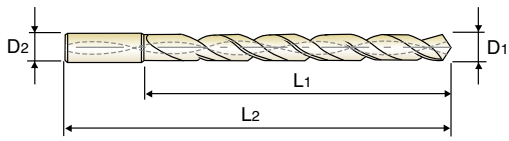
DHM25 SERIES
DHM30 SERIES

CARBIDE, DREAM DRILLS MQL TYPE END MILL SHANK with COOLANT HOLES

EXTRA LONG

- ▶Non step drilling up to 25 times (30 times) of drill diameter
- ▶Available for processing MQL(Minimum Quantity Lubrication)
- ▶Excellent positioning – Bush is not necessary
- ▶Special design – Good chip removal
- ▶Powerful drilling





◇ Call for Availability

MG | 30° | h6 | h7 | 140° | 45 bar P.130

25 × D (DHM25) | 30 × D (DHM30)

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DHM25030	3.0	.1181	6	85	125
DHM25035	3.5	.1378	6	99	139
DHM25040	4.0	.1575	6	113	153
DHM25045	4.5	.1772	6	127	167
DHM25050	5.0	.1969	6	141	181
DHM25055	5.5	.2165	6	155	195
DHM25060	6.0	.2362	6	169	209
DHM25070	7.0	.2756	8	197	237
DHM25080	8.0	.3150	8	225	265
DHM25090	9.0	.3543	10	253	297
DHM25100	10.0	.3937	10	282	326

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Metric	Inch			
TiAlN	D1		D2	L1	L2
DHM30030	3.0	.1181	6	100	140
DHM30035	3.5	.1378	6	117	157
DHM30040	4.0	.1575	6	133	173
DHM30045	4.5	.1772	6	150	190
DHM30050	5.0	.1969	6	166	206
DHM30055	5.5	.2165	6	183	223
DHM30060	6.0	.2362	6	199	239
DHM30070	7.0	.2756	8	232	272
DHM30080	8.0	.3150	8	265	305

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○					○					

DREAM DRILLS -MQL TYPE

RECOMMENDED CUTTING CONDITIONS

CARBIDE, DREAM DRILLS MQL TYPE with COOLANT HOLES, TiAlN COATED

DH510, DH515, DH520, DHM10, DHM15, DHM20 SERIES

WORK MATERIAL		P				K							
		CARBON STEELS				CAST IRON				DUCTILE CAST IRON			
STRENGTH		~ 1060 N/mm²				250 ~ 350 N/mm²				400 ~ 500 N/mm²			
DRILLING SPEED(SFM)		230 ~ 290 ft/min				230 ~ 290 ft/min				220 ~ 240 ft/min			
DIAMETER		N	S	IPR		N	S	IPR		N	S	IPR	
Metric(mm)	Decimal												
3	.1181	7500	0.06~0.12	.0024	.0047	7500	0.06~0.12	.0024	.0047	7500	0.06~0.12	.0024	.0047
4	.1575	6400	0.08~0.16	.0031	.0063	6400	0.08~0.16	.0031	.0063	5600	0.08~0.16	.0031	.0063
5	.1969	5800	0.10~0.20	.0039	.0079	5800	0.10~0.20	.0039	.0079	4500	0.10~0.20	.0039	.0079
6	.2362	4800	0.12~0.24	.0047	.0094	4800	0.12~0.24	.0047	.0094	3800	0.12~0.24	.0047	.0094
8	.3150	3600	0.16~0.28	.0063	.0110	3600	0.16~0.28	.0063	.0110	2800	0.16~0.28	.0063	.0110
10	.3937	2900	0.20~0.35	.0079	.0138	2900	0.20~0.35	.0079	.0138	2300	0.20~0.35	.0079	.0138
12	.4724	2400	0.24~0.42	.0094	.0165	2400	0.24~0.42	.0094	.0165	1900	0.24~0.42	.0094	.0165
14	.5512	2050	0.28~0.46	.0110	.0181	2050	0.28~0.46	.0110	.0181	1600	0.28~0.46	.0110	.0181

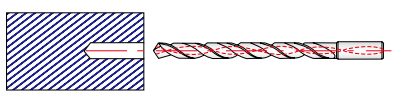
N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

DHM25, DHM30 SERIES

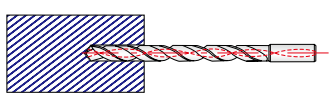
WORK MATERIAL		P				K							
		CARBON STEELS				CAST IRON				DUCTILE CAST IRON			
STRENGTH		~ 1060 N/mm²				250 ~ 350 N/mm²				400 ~ 500 N/mm²			
DRILLING SPEED(SFM)		230 ~ 290 ft/min				230 ~ 290 ft/min				220 ~ 240 ft/min			
DIAMETER		N	S	IPR		N	S	IPR		N	S	IPR	
Metric(mm)	Decimal												
3	.1181	6400	0.06~0.12	.0024	.0047	6400	0.06~0.12	.0024	.0047	6400	0.06~0.12	.0024	.0047
4	.1575	5500	0.08~0.16	.0031	.0063	5500	0.08~0.16	.0031	.0063	4700	0.08~0.16	.0031	.0063
5	.1969	4900	0.10~0.20	.0039	.0079	4900	0.10~0.20	.0039	.0079	3800	0.10~0.20	.0039	.0079
6	.2362	4200	0.12~0.24	.0047	.0094	4200	0.12~0.24	.0047	.0094	3200	0.12~0.24	.0047	.0094
8	.3150	3000	0.16~0.28	.0063	.0110	3000	0.16~0.28	.0063	.0110	2400	0.16~0.28	.0063	.0110
10	.3937	2500	0.20~0.35	.0079	.0138	2500	0.20~0.35	.0079	.0138	1900	0.20~0.35	.0079	.0138

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

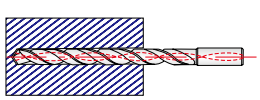
▶ Coolant Pressure : 900 PSI



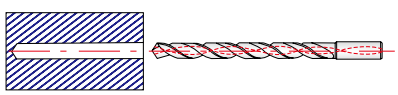
1. Use a YG 3xD Drill to produce a guide hole no larger than .004 over the required drill size. Drill the pilot hole 2xD deep hole.



2. Enter the guide hole at 50 SFM surface and .010 feed rate / per rev.



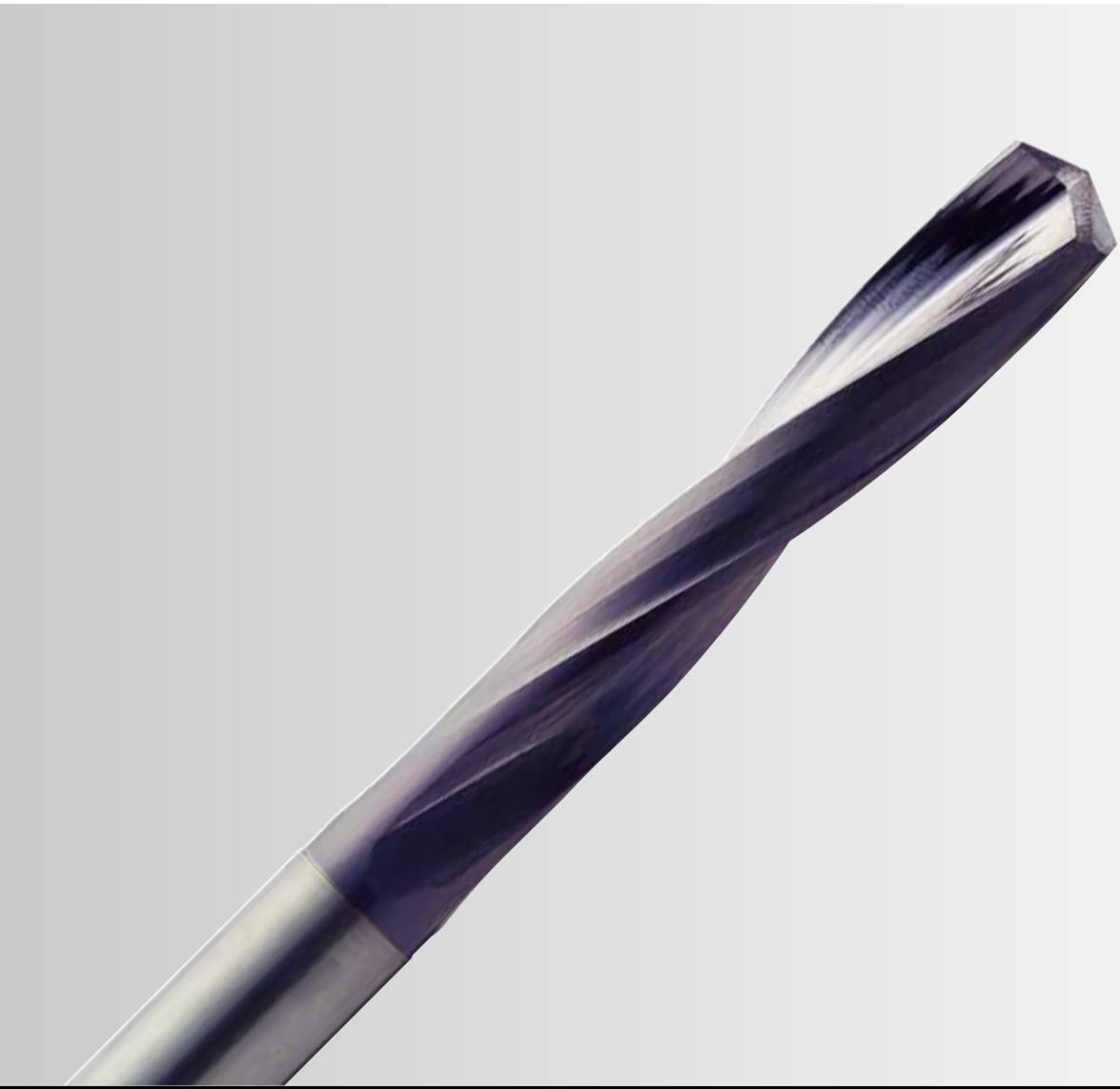
3. Before hitting the bottom of the guide hole, Increase SFM and feed rate for normal drilling.



4. After drilling, to withdraw drill, reduce SFM to 50 @ 10 inches per minute.

CARBIDE

Being the best through innovation



DREAM DRILLS
- For HIGH HARDENED STEELS

- HIGH HARDENED STEELS, HRc50~HRc70

SOLID CARBIDE DREAM DRILLS for HIGH HARDENED STEELS

High Hardened Steels, HRc50~HRc70

◎ : Excellent ○ : Good

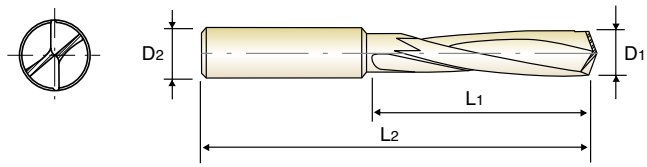
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
			◎	◎							
			◎	◎							

DREAM DRILLS for HIGH HARDENED STEELS

DH501 SERIES

CARBIDE, DREAM DRILLS for HIGH HARDENED STEEL (HRc50~70)

- **Application** : Drilling for High Hardened Steels[Quenched Steels, Tempered Steels (Under HRc 70)]
- **Advantage** : Special Design
  Minimum of cutting load through special thinning
  Good chip removal
  Powerful Drilling
- **Tolerance** : Dia. Tolerance øD1: See page 247, Shank Tolerance øD2: -.0001 -.0005



MG | 15° | h6 | 140° P.138

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH501001	1/8	.1250	1/8	21/32	2
DH501002	#30	.1285	3/16	23/32	2
DH501003	#29	.1360	3/16	13/16	2
DH501004	#28	.1405	3/16	13/16	2
DH501005	9/64	.1406	3/16	13/16	2
DH501006	#27	.1440	3/16	13/16	2
DH501007	#26	.1470	3/16	13/16	2
DH501008	#25	.1495	3/16	7/8	2-1/16
DH501009	#24	.1520	3/16	7/8	2-1/16
DH501010	#23	.1540	3/16	7/8	2-1/16
DH501011	5/32	.1562	3/16	7/8	2-1/16
DH501012	#22	.1570	3/16	7/8	2-1/16
DH501013	#21	.1590	3/16	7/8	2-1/16
DH501014	#20	.1610	3/16	1	2-1/2
DH501015	#19	.1660	3/16	1	2-1/2
DH501016	11/64	.1719	3/16	1-1/8	2-3/4
DH501017	#15	.1800	3/16	1-1/8	2-3/4
DH501018	#14	.1820	3/16	1-1/8	2-3/4
DH501019	3/16	.1875	3/16	1-1/8	2-3/4
DH501020	#10	.1935	1/4	1-9/32	2-7/8
DH501021	#9	.1960	1/4	1-9/32	2-7/8
DH501022	#8	.1990	1/4	1-9/32	2-7/8
DH501023	#7	.2010	1/4	1-9/32	2-7/8
DH501024	13/64	.2031	1/4	1-9/32	2-7/8

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH501025	#6	.2040	1/4	1-9/32	2-7/8
DH501026	#5	.2055	1/4	1-9/32	2-7/8
DH501027	#4	.2090	1/4	1-9/32	2-7/8
DH501028	#3	.2130	1/4	1-13/32	3
DH501029	7/32	.2188	1/4	1-13/32	3
DH501030	#2	.2210	1/4	1-13/32	3
DH501031	#1	.2280	1/4	1-13/32	3
DH501032	15/64	.2344	1/4	1-13/32	3
DH501033	B	.2380	1/4	1-19/32	3-1/8
DH501034	C	.2420	1/4	1-19/32	3-1/8
DH501035	D	.2460	1/4	1-19/32	3-1/8
DH501036	1/4	.2500	1/4	1-19/32	3-1/8
DH501037	F	.2570	3/8	1-19/32	3-1/8
DH501038	G	.2610	3/8	1-19/32	3-1/8
DH501039	17/64	.2656	3/8	1-19/32	3-1/8
DH501040	I	.2720	3/8	1-25/32	3-3/8
DH501041	J	.2770	3/8	1-25/32	3-3/8
DH501042	9/32	.2812	3/8	1-25/32	3-3/8
DH501043	L	.2900	3/8	1-25/32	3-3/8
DH501044	M	.2950	3/8	1-25/32	3-3/8
DH501045	19/64	.2969	3/8	1-25/32	3-3/8
DH501046	N	.3020	3/8	1-31/32	3-7/8
DH501047	5/16	.3125	3/8	1-31/32	3-7/8
DH501048	O	.3160	3/8	1-31/32	3-7/8

▶ NEXT PAGE

◎ : Excellent ○ : Good

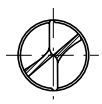
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
			◎	◎								

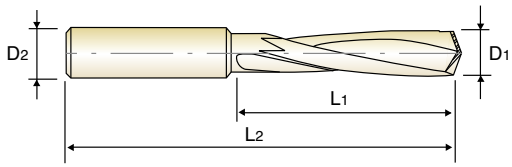
DREAM DRILLS for HIGH HARDENED STEELS

DH501 SERIES

CARBIDE, DREAM DRILLS for HIGH HARDENED STEEL (HRc50~70)

- **Application** : Drilling for High Hardened Steels[Quenched Steels, Tempered Steels (Under HRc 70)]
- **Advantage** : Special Design
  Minimum of cutting load through special thinning
  Good chip removal
  Powerful Drilling
- **Tolerance** : Dia. Tolerance øD1: See page 247, Shank Tolerance øD2: -.0001 -.0005





MG | 15° | h6 | 140° P.138

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH501049	21/64	.3281	3/8	1-31/32	3-7/8
DH501050	Q	.3320	3/8	1-31/32	3-7/8
DH501051	R	.3390	3/8	2-1/4	4-1/8
DH501052	11/32	.3438	3/8	2-1/4	4-1/8
DH501053	23/64	.3594	3/8	2-1/4	4-1/8
DH501054	U	.3680	3/8	2-1/4	4-1/8
DH501055	3/8	.3750	3/8	2-1/4	4-1/8
DH501056	V	.3770	1/2	2-1/2	4-3/8
DH501057	25/64	.3906	1/2	2-1/2	4-3/8
DH501058	X	.3970	1/2	2-1/2	4-3/8
DH501059	Y	.4040	1/2	2-1/2	4-3/8
DH501060	13/32	.4062	1/2	2-1/2	4-3/8
DH501061	Z	.4130	1/2	2-1/2	4-3/8
DH501062	27/64	.4219	1/2	2-13/16	4-5/8
DH501063	7/16	.4375	1/2	2-13/16	4-5/8
DH501064	29/64	.4531	1/2	2-13/16	4-5/8
DH501065	15/32	.4688	1/2	2-13/16	4-5/8
DH501066	31/64	.4844	1/2	2-13/16	4-5/8

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH501067	1/2	.5000	1/2	3-1/16	5
DH501068	33/64	.5156	5/8	3-1/16	5
DH501069	17/32	.5312	5/8	3-1/16	5
DH501070	35/64	.5469	5/8	3-1/16	5
DH501071	9/16	.5625	5/8	3-1/16	5
DH501072	37/64	.5781	5/8	3-9/32	5-1/4
DH501073	19/32	.5937	5/8	3-9/32	5-1/4
DH501074	39/64	.6094	5/8	3-9/32	5-1/4
DH501075	5/8	.6250	5/8	3-9/32	5-1/4
DH501076	41/64	.6406	3/4	3-9/32	5-1/4
DH501077	21/32	.6563	3/4	3-11/16	5-5/8
DH501078	43/64	.6719	3/4	3-11/16	5-5/8
DH501079	11/16	.6875	3/4	3-11/16	5-5/8
DH501080	45/64	.7031	3/4	3-11/16	5-5/8
DH501081	23/32	.7188	3/4	3-3/4	6
DH501082	47/64	.7344	3/4	3-3/4	6
DH501083	3/4	.7500	3/4	3-3/4	6

◎ : Excellent ○ : Good

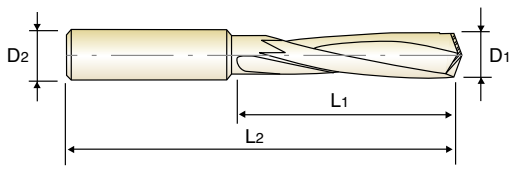
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
			◎	◎								

DREAM DRILLS for HIGH HARDENED STEELS

DH500 SERIES

CARBIDE, DREAM DRILLS for HIGH HARDENED STEEL (HRc50~70)

▶ **Application** : Drilling for High Hardened Steels[Quenched Steels, Tempered Steels (Under HRc 70)]
▶ **Advantage** : Special Design
Minimum of cutting load through special thinning
Good chip removal
Powerful Drilling



MG | 15° | h6 | h7 | 140° P.138

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH500010	1.0	.0394	3	6	40
DH500011	1.1	.0433	3	6	40
DH500012	1.2	.0472	3	6	40
DH500013	1.3	.0512	3	8	40
DH500014	1.4	.0551	3	8	40
DH500015	1.5	.0591	3	8	40
DH500016	1.6	.0630	3	10	40
DH500017	1.7	.0669	3	10	40
DH500018	1.8	.0709	3	10	40
DH500019	1.9	.0748	3	10	40
DH500020	2.0	.0787	3	12	42
DH500025	2.5	.0984	3	14	44
DH500026	2.6	.1024	3	16	44
DH500028	2.8	.1102	3	16	46
DH500030	3.0	.1181	3	18	46
DH500033	3.3	.1299	4	18	48
DH500034	3.4	.1339	4	20	50
DH500035	3.5	.1378	4	20	50
DH500038	3.8	.1496	4	22	52
DH500040	4.0	.1575	4	22	52
DH500041	4.1	.1614	6	25	65
DH500042	4.2	.1654	6	25	65
DH500043	4.3	.1693	6	28	68
DH500044	4.4	.1732	6	28	68

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH500045	4.5	.1772	6	28	68
DH500046	4.6	.1811	6	28	68
DH500048	4.8	.1890	6	32	72
DH500049	4.9	.1929	6	32	72
DH500050	5.0	.1969	6	32	72
DH500051	5.1	.2008	6	32	72
DH500052	5.2	.2047	6	32	72
DH500053	5.3	.2087	6	32	72
DH500055	5.5	.2165	6	35	75
DH500060	6.0	.2362	6	35	75
DH500062	6.2	.2441	8	40	80
DH500065	6.5	.2559	8	40	80
DH500068	6.8	.2677	8	45	85
DH500069	6.9	.2717	8	45	85
DH500070	7.0	.2756	8	45	85
DH500075	7.5	.2953	8	45	85
DH500080	8.0	.3150	8	50	98
DH500085	8.5	.3346	10	50	98
DH500086	8.6	.3386	10	57	105
DH500088	8.8	.3465	10	57	105
DH500090	9.0	.3543	10	57	105
DH500093	9.3	.3661	10	57	105
DH500095	9.5	.3740	10	57	105
DH500100	10.0	.3937	10	63	111

▶ NEXT PAGE

◎ : Excellent ○ : Good

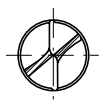
P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
			◎	◎							

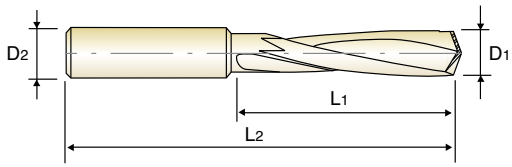
DREAM DRILLS for HIGH HARDENED STEELS

DH500 SERIES

CARBIDE, DREAM DRILLS for HIGH HARDENED STEEL (HRc50~70)

- **Application** : Drilling for High Hardened Steels[Quenched Steels, Tempered Steels (Under HRc 70)]
- **Advantage** : Special Design
  Minimum of cutting load through special thinning
  Good chip removal
  Powerful Drilling
- **Tolerance** : Dia. Tolerance øD1: See page 247, Shank Tolerance øD2: -.0001 -.0005





MG | 15° | h6 | 140° P.138

Unit : mm

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH500102	10.2	.4016	12	63	111
DH500103	10.3	.4055	12	63	111
DH500105	10.5	.4134	12	71	111
DH500108	10.8	.4252	12	71	119
DH500110	11.0	.4331	12	71	119

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
DH500115	11.5	.4528	12	71	119
DH500120	12.0	.4724	12	71	119
DH500121	12.1	.4764	14	77	125
DH500140	14.0	.5512	14	77	125

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
			◎	◎							

DREAM DRILLS for HIGH HARDENED STEELS

RECOMMENDED CUTTING CONDITIONS

CARBIDE, DREAM DRILLS for HIGH HARDENED STEEL (HRc50~70), TiAlN COATED

DH501 SERIES

WORK MATERIAL			P			H					
			HARDENED STEELS								
			HRc 50~55			HRc 55~60			HRc 60~70		
DRILLING SPEED(SFM)			45 ~ 72 ft/min			32 ~ 52 ft/min			26 ~ 42 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR
Fractional	Metric(mm)	Decimal									
5/64	1.984	.0781	2860	0.04	.0015	2000	0.04	.0015	1900	0.04	.0015
1/8	3.175	.1250	1900	0.04	.0015	1330	0.04	.0015	1250	0.04	.0015
5/32	3.969	.1563	1430	0.04	.0015	1000	0.04	.0015	950	0.04	.0015
13/64	5.159	.2031	1150	0.04	.0015	800	0.04	.0015	750	0.04	.0015
15/64	5.953	.2344	960	0.04	.0015	670	0.04	.0015	630	0.04	.0015
5/16	7.938	.3125	720	0.04	.0015	500	0.04	.0015	480	0.04	.0015
25/64	9.922	.3906	570	0.04	.0015	400	0.04	.0015	380	0.04	.0015
15/32	11.906	.4688	480	0.04	.0015	330	0.04	.0015	320	0.04	.0015
9/16	14.288	.5625	435	0.04	.0015	280	0.04	.0015	270	0.04	.0015
41/64	16.272	.6406	380	0.04	.0015	250	0.04	.0015	240	0.04	.0015
11/16	17.463	.6875	325	0.04	.0015	235	0.04	.0015	190	0.04	.0015
47/64	18.653	.7344	310	0.04	.0015	220	0.04	.0015	180	0.04	.0015

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

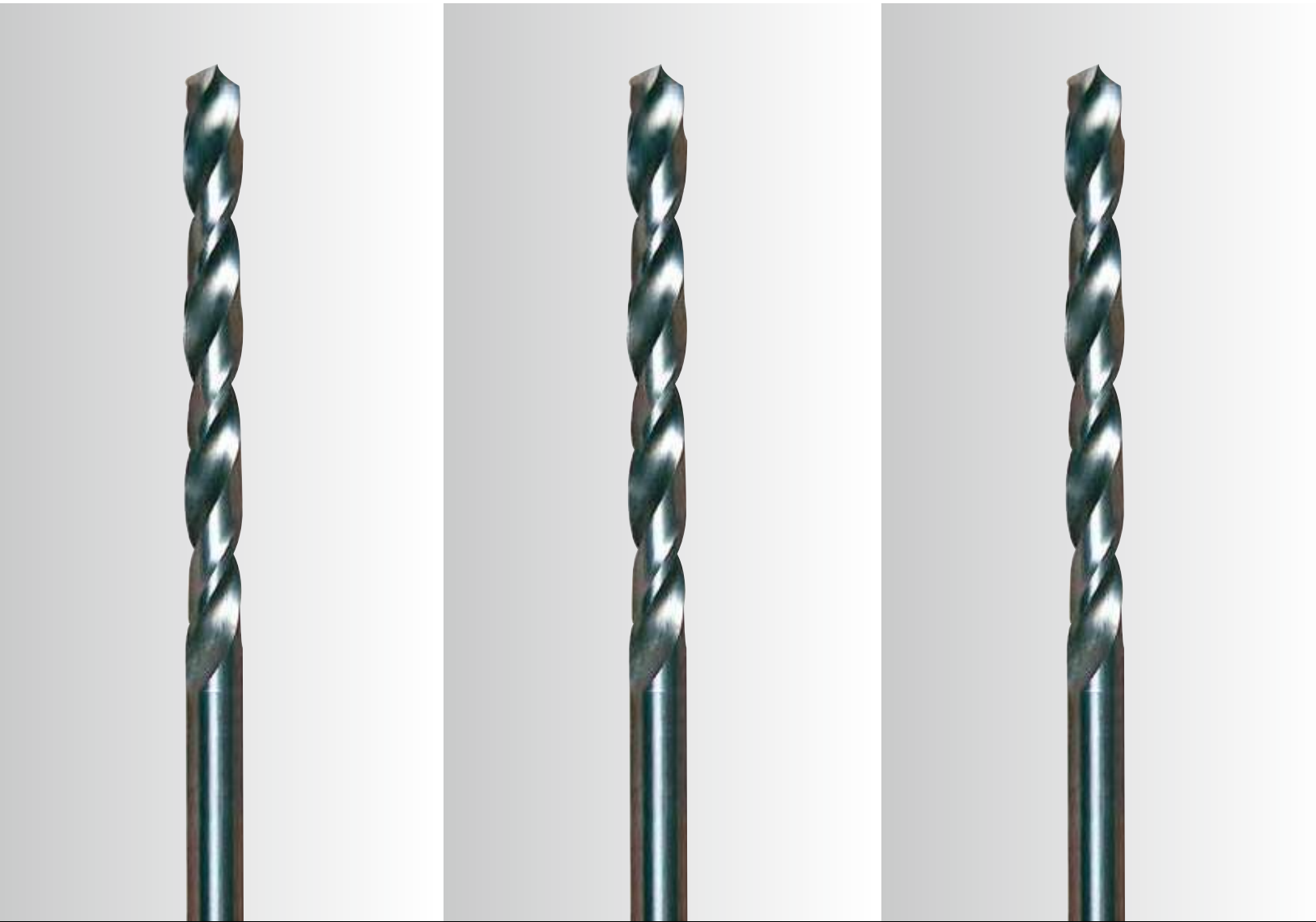
DH500 SERIES

WORK MATERIAL			P			H					
			HARDENED STEELS								
			HRc 50~55			HRc 55~60			HRc 60~70		
DRILLING SPEED(SFM)			45 ~ 72 ft/min			32 ~ 52 ft/min			26 ~ 42 ft/min		
DIAMETER			N	S	IPR	N	S	IPR	N	S	IPR
Fractional	Metric(mm)	Decimal									
1.0		.0394	5600	0.04	.0015	4000	0.04	.0015	3700	0.04	.0015
2.0		.0787	2900	0.04	.0015	2100	0.04	.0015	1900	0.04	.0015
3.0		.1181	1900	0.04	.0015	1330	0.04	.0015	1250	0.04	.0015
4.0		.1575	1430	0.04	.0015	1000	0.04	.0015	950	0.04	.0015
5.0		.1969	1150	0.04	.0015	800	0.04	.0015	750	0.04	.0015
6.0		.2362	960	0.04	.0015	670	0.04	.0015	630	0.04	.0015
8.0		.3150	720	0.04	.0015	500	0.04	.0015	480	0.04	.0015
10.0		.3937	570	0.04	.0015	400	0.04	.0015	380	0.04	.0015
12 .0		.4724	480	0.04	.0015	330	0.04	.0015	320	0.04	.0015
14.0		.5512	438	0.04	.0015	282	0.04	.0015	272	0.04	.0015

N = R.P.M
S= feed rate (mm/rev.)
IPR= feed rate (Inch/rev.)

CARBIDE

Being the best through innovation



STANDARD CARBIDE DRILLS

- General Purpose
  118° Point

SELECTION GUIDE

STANDARD SOLID CARBIDE DRILLS
General Purpose
118° Point

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○				○
◎	◎				○	○	○				○
◎	◎				○	○	○				○

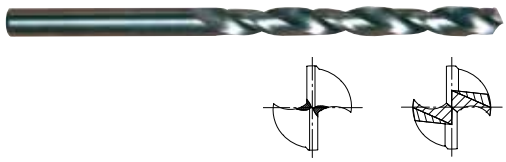
STANDARD CARBIDE DRILLS

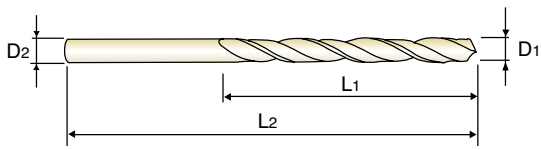
DH412 SERIES
D5412 SERIES

CARBIDE DRILLS

JOBBER

▶ **Application** : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.





MG | N 30° | h6 | h7 | 118° | P.145

$D_1 = D_2$

▶ Wire gauge sizes

Unit : Inch

EDP No.		Diameter		Flute Length	Overall Length	EDP No.		Diameter		Flute Length	Overall Length
		Wire gauge	Decimal					Wire gauge	Decimal		
Bright Finish	TiAlN	$D_1 = D_2$		L_1	L_2	Bright Finish	TiAlN	$D_1 = D_2$		L_1	L_2
D5412101	DH412101	1	.2280	1-3/4	3	D5412129	DH412129	29	.1360	1-3/8	2-1/2
D5412102	DH412102	2	.2210	1-3/4	3	D5412130	DH412130	30	.1285	1-1/4	2-1/4
D5412103	DH412103	3	.2130	1-3/4	3	D5412131	DH412131	31	.1200	1-1/4	2-1/4
D5412104	DH412104	4	.2090	1-3/4	3	D5412132	DH412132	32	.1160	1-1/4	2-1/4
D5412105	DH412105	5	.2055	1-3/4	3	D5412133	DH412133	33	.1130	1-1/4	2-1/4
D5412106	DH412106	6	.2040	1-3/4	3	D5412134	DH412134	34	.1110	1-1/4	2-1/4
D5412107	DH412107	7	.2010	1-3/4	3	D5412135	DH412135	35	.1100	1-1/4	2-1/4
D5412108	DH412108	8	.1990	1-3/4	3	D5412136	DH412136	36	.1065	1-1/4	2-1/4
D5412109	DH412109	9	.1960	1- 3/4	3	D5412137	DH412137	37	.1040	1-1/4	2-1/4
D5412110	DH412110	10	.1935	1-5/8	2-3/4	D5412138	DH412138	38	.1015	1-1/4	2-1/4
D5412111	DH412111	11	.1910	1-5/8	2-3/4	D5412139	DH412139	39	.0995	1-1/4	2-1/4
D5412112	DH412112	12	.1890	1-5/8	2-3/4	D5412140	DH412140	40	.0980	1	2
D5412113	DH412113	13	.1850	1-5/8	2-3/4	D5412141	DH412141	41	.0960	1	2
D5412114	DH412114	14	.1820	1-5/8	2-3/4	D5412142	DH412142	42	.0935	1	2
D5412115	DH412115	15	.1800	1-5/8	2-3/4	D5412143	DH412143	43	.0890	1	2
D5412116	DH412116	16	.1770	1-5/8	2-3/4	D5412144	DH412144	44	.0860	1	2
D5412117	DH412117	17	.1730	1-5/8	2-3/4	D5412145	DH412145	45	.0820	7/8	1-3/4
D5412118	DH412118	18	.1695	1-5/8	2-3/4	D5412146	DH412146	46	.0810	7/8	1-3/4
D5412119	DH412119	19	.1660	1-5/8	2-3/4	D5412147	DH412147	47	.0785	7/8	1-3/4
D5412120	DH412120	20	.1610	1-3/8	2-1/2	D5412148	DH412148	48	.0760	7/8	1-3/4
D5412121	DH412121	21	.1590	1-3/8	2-1/2	D5412149	DH412149	49	.0730	7/8	1-3/4
D5412122	DH412122	22	.1570	1-3/8	2-1/2	D5412150	DH412150	50	.0700	7/8	1-3/4
D5412123	DH412123	23	.1540	1-3/8	2-1/2	D5412151	DH412151	51	.0670	3/4	1-1/2
D5412124	DH412124	24	.1520	1-3/8	2-1/2	D5412152	DH412152	52	.0635	3/4	1-1/2
D5412125	DH412125	25	.1495	1-3/8	2-1/2	D5412153	DH412153	53	.0595	3/4	1-1/2
D5412126	DH412126	26	.1470	1-3/8	2-1/2	D5412154	DH412154	54	.0550	3/4	1-1/2
D5412127	DH412127	27	.1440	1-3/8	2-1/2	D5412155	DH412155	55	.0520	3/4	1-1/2
D5412128	DH412128	28	.1405	1-3/8	2-1/2	D5412156	DH412156	56	.0465	3/4	1-1/2

▶ Other coating is available on you request.

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○				○

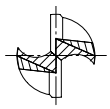
STANDARD CARBIDE DRILLS

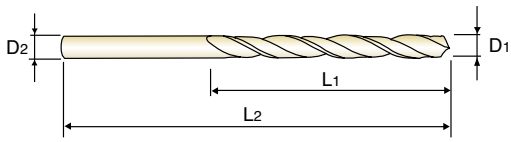
DH413 SERIES
D5413 SERIES

CARBIDE DRILLS

JOBBER

▶ **Application** : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.





MG | N 30° | h6 | h7 | 118° | P.145

$D_1 = D_2$

▶ Letter sizes

Unit : Inch

EDP No.		Diameter		Flute Length	Overall Length	EDP No.		Diameter		Flute Length	Overall Length
		Letter	Decimal					Letter	Decimal		
Bright Finish	TiAlN	$D_1 = D_2$		L_1	L_2	Bright Finish	TiAlN	$D_1 = D_2$		L_1	L_2
D5413201	DH413201	A	.2340	2	3-1/4	D5413214	DH413214	N	.3020	2-3/8	3-3/4
D5413202	DH413202	B	.2380	2	3-1/4	D5413215	DH413215	O	.3160	2-3/8	3-3/4
D5413203	DH413203	C	.2420	2	3-1/4	D5413216	DH413216	P	.3230	2-3/8	3-3/4
D5413204	DH413204	D	.2460	2	3-1/4	D5413217	DH413217	Q	.3320	2-1/2	4
D5413205	DH413205	E	.2500	2	3-1/4	D5413218	DH413218	R	.3390	2-1/2	4
D5413206	DH413206	F	.2570	2	3-1/4	D5413219	DH413219	S	.3480	2-1/2	4
D5413207	DH413207	G	.2610	2-1/8	3-1/2	D5413220	DH413220	T	.3580	2-3/4	4-1/4
D5413208	DH413208	H	.2660	2-1/8	3-1/2	D5413221	DH413221	U	.3680	2-3/4	4-1/4
D5413209	DH413209	I	.2720	2-1/8	3-1/2	D5413222	DH413222	V	.3770	2-3/4	4-1/4
D5413210	DH413210	J	.2770	2-1/8	3-1/2	D5413223	DH413223	W	.3860	2-7/8	4-1/2
D5413211	DH413211	K	.2810	2-1/8	3-1/2	D5413224	DH413224	X	.3970	2-7/8	4-1/2
D5413212	DH413212	L	.2900	2-1/8	3-1/2	D5413225	DH413225	Y	.4040	2-7/8	4-1/2
D5413213	DH413213	M	.2950	2-3/8	3-3/4	D5413226	DH413226	Z	.4130	2-7/8	4-1/2

▶ Other coating is available on you request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○				○

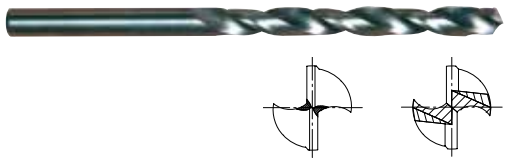
STANDARD CARBIDE DRILLS

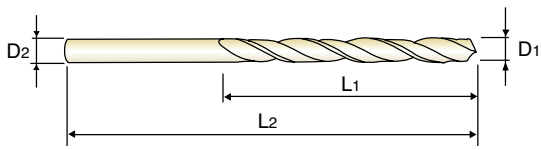
DH417 SERIES
D5417 SERIES

CARBIDE DRILLS

JOBBER

▶ **Application** : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.





MG | N 30° | h6 | h7 | 118° | P.145

$D_1 = D_2$

▶ Fractional sizes

Unit : Inch

EDP No.		Diameter		Flute Length	Overall Length	EDP No.		Diameter		Flute Length	Overall Length
		Fractional	Decimal					Fractional	Decimal		
Bright Finish	TiAlN	$D_1 = D_2$		L_1	L_2	Bright Finish	TiAlN	$D_1 = D_2$		L_1	L_2
D5417003	DH417003	3/64	.0469	3/4	1-1/2	D5417018	DH417018	9/32	.2813	2-1/8	3-1/2
D5417004	DH417004	1/16	.0625	3/4	1-1/2	D5417019	DH417019	19/64	.2969	2-3/8	3-3/4
D5417005	DH417005	5/64	.0781	7/8	1-3/4	D5417020	DH417020	5/16	.3125	2-3/8	3-3/4
D5417006	DH417006	3/32	.0938	1	2	D5417021	DH417021	21/64	.3281	2-1/2	4
D5417007	DH417007	7/64	.1094	1-1/4	2-1/4	D5417022	DH417022	11/32	.3438	2-1/2	4
D5417008	DH417008	1/8	.1250	1-1/4	2-1/4	D5417023	DH417023	23/64	.3594	2-3/4	4-1/4
D5417009	DH417009	9/64	.1406	1-3/8	2-1/2	D5417024	DH417024	3/8	.3750	2-3/4	4-1/4
D5417010	DH417010	5/32	.1563	1-3/8	2-1/2	D5417025	DH417025	25/64	.3906	2-7/8	4-1/2
D5417011	DH417011	11/64	.1719	1-5/8	2-3/4	D5417026	DH417026	13/32	.4063	2-7/8	4-1/2
D5417012	DH417012	3/16	.1875	1-5/8	2-3/4	D5417027	DH417027	27/64	.4219	2-7/8	4-1/2
D5417013	DH417013	13/64	.2031	1-3/4	3	D5417028	DH417028	7/16	.4375	2-7/8	4-1/2
D5417014	DH417014	7/32	.2188	1-3/4	3	D5417029	DH417029	29/64	.4531	3	4-3/4
D5417015	DH417015	15/64	.2344	2	3-1/4	D5417030	DH417030	15/32	.4688	3	4-3/4
D5417016	DH417016	1/4	.2500	2	3-1/4	D5417031	DH417031	31/64	.4844	3	4-3/4
D5417017	DH417017	17/64	.2656	2-1/8	3-1/2	D5417032	DH417032	1/2	.5000	3	4-3/4

▶ Other coating is available on you request.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○				○

CARBIDE DRILLS

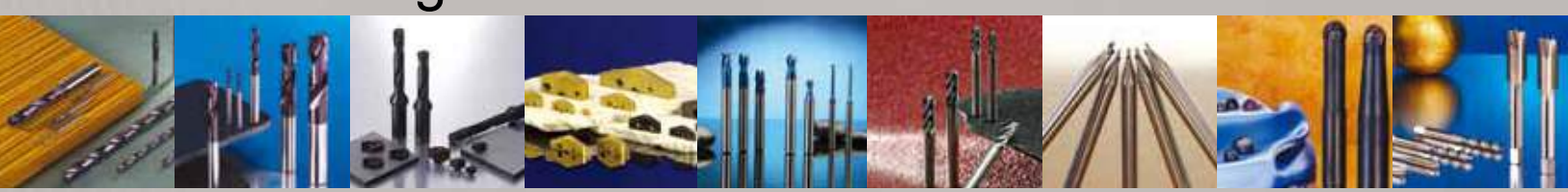
D5412, DH412, D5413, DH413, D5417, DH417 SERIES

WORK MATERIAL	P				K			
	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
DIAMETER	N	S	N	S	N	S	N	
3/64	23000	.0012	17200	.0012	32000	.0016	23000	.0016
5/64	11500	.0016	8600	.0016	16000	.0020	11500	.0020
1/8	7800	.0020	5750	.0020	10500	.0024	7600	.0024
5/32	5800	.0024	4300	.0024	7800	.0028	5700	.0028
13/64	4700	.0028	3450	.0028	6200	.0031	4550	.0031
15/64	3900	.0031	2850	.0031	5200	.0035	3800	.0035
9/32	3350	.0035	2450	.0035	4500	.0039	3250	.0039
5/16	2900	.0039	2150	.0039	3900	.0047	2850	.0047
23/64	2600	.0043	1900	.0043	3450	.0055	2550	.0055
25/64	2350	.0047	1700	.0047	3100	.0063	2300	.0063
7/16	2150	.0051	1600	.0051	2850	.0071	2100	.0071
15/32	1950	.0055	1450	.0055	2600	.0079	1900	.0079
33/64	1800	.0063	1350	.0063	2400	.0079	1750	.0079

WORK MATERIAL	M		N					
	STAINLESS STEELS		Al-Si ALLOY, Si<10%		Al-Si ALLOY, Si>10%		Ti, Ni ALLOY STEELS	
DIAMETER	N	S	N	S	N	S	N	S
3/64	12000	.0016	54000	.0020	42000	.0020	11800	.0008
5/64	6000	.0012	27000	.0024	21000	.0024	5900	.0012
1/8	4000	.0016	18000	.0028	14000	.0028	3900	.0016
5/32	3000	.0020	13000	.0031	10500	.0031	2950	.0020
13/64	2400	.0024	10500	.0035	8500	.0035	2350	.0024
15/64	2000	.0028	8800	.0043	7100	.0043	1950	.0028
9/32	1700	.0031	7600	.0051	6100	.0051	1700	.0031
5/16	1500	.0035	6600	.0059	5350	.0059	1450	.0035
23/64	1350	.0039	5900	.0067	4750	.0067	1300	.0039
25/64	1200	.0043	5300	.0075	4250	.0075	1200	.0043
7/16	1100	.0047	4850	.0083	3900	.0083	1050	.0047
15/32	1000	.0051	4450	.0091	3550	.0091	980	.0051
33/64	950	.0051	4100	.0098	3300	.0098	905	.0051

N = R.P.M
S = Inch per Revolution(inch/rev.)

Global Cutting Tool Leader **YG-1**



HSS

Being the best through innovation

MULTI-1 DRILLS

- **HSS-PM MULTI-1 DRILLS**
  Multi Purpose Drilling. Particularly for Stainless Steels, Titanium

PREMIUM HSS-PM MULTI-1 DRILLS

Premium HSS-PM Drills for wide range of applications
- Carbon Steels, Alloy Steels, Stainless steels, Titanium etc.

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				○	○	○				◎
◎	◎	○				○	○	○				◎
◎	◎	○				○	○	○				◎

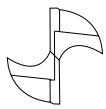
MULTI-1 DRILLS

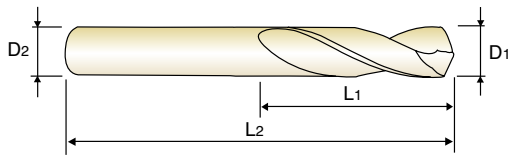
CDRA05 SERIES

PREMIUM HSS-PM, MULTI-1 DRILLS

▶ **Features** : Excellent wear resistance by using Premium powder metallurgy materials.
With special point geometry, no centering required.
Minimal drill wandering and improved hole tolerances.
Better tool life with excellent coating.

▶ **Application** : Applicable to various materials including aluminum and stainless steel, as well carbon steel and structural steel.





PREMIUM HSS-PM | N 30° | h6 | h7 | 135° P.153

▶ M15 / Fractional sizes

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
M15006	3/32	.0938	1/8	1/2	1-3/4
M15007	7/64	.1094	1/8	5/8	1-7/8
M15008	1/8	.1250	1/8	3/4	2
M15009	9/64	.1406	3/16	13/16	2-1/8
M15010	5/32	.1563	3/16	13/16	2-1/8
M15011	11/64	.1719	3/16	1	2-3/8
M15012	3/16	.1875	3/16	1	2-3/8
M15013	13/64	.2031	1/4	1-1/8	2-7/8
M15014	7/32	.2188	1/4	1-1/8	2-7/8
M15015	15/64	.2344	1/4	1-1/4	3
M15016	1/4	.2500	1/4	1-1/4	3
M15017	17/64	.2656	3/8	1-3/8	3-3/16
M15018	9/32	.2813	3/8	1-3/8	3-3/16
M15019	19/64	.2969	3/8	1-3/8	3-3/16

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAlN	D1		D2	L1	L2
M15020	5/16	.3125	3/8	1-1/2	3-3/8
M15021	21/64	.3281	3/8	1-1/2	3-3/8
M15022	11/32	.3438	3/8	1-5/8	3-1/2
M15023	23/64	.3594	3/8	1-5/8	3-1/2
M15024	3/8	.3750	3/8	1-5/8	3-1/2
M15025	25/64	.3906	1/2	1-11/16	3-7/8
M15026	13/32	.4063	1/2	1-11/16	3-7/8
M15027	27/64	.4219	1/2	1-7/8	4-1/8
M15028	7/16	.4375	1/2	1-7/8	4-1/8
M15029	29/64	.4531	1/2	1-7/8	4-1/8
M15030	15/32	.4688	1/2	2	4-1/4
M15031	31/64	.4844	1/2	2	4-1/4
M15032	1/2	.5000	1/2	2	4-1/4

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○				◎

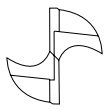
MULTI-1 DRILLS

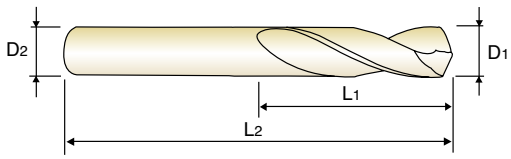
CDRA06 SERIES

PREMIUM HSS-PM, MULTI-1 DRILLS

▶ **Features** : Excellent wear resistance by using Premium powder metallurgy materials.
With special point geometry, no centering required.
Minimal drill wandering and improved hole tolerances.
Better tool life with excellent coating.

▶ **Application** : Applicable to various materials including aluminum and stainless steel, as well carbon steel and structural steel.





PREMIUM HSS-PM | N 30° | h6 | h7 | 135° P.153

▶ M16 / Wire gauge sizes

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Wire gauge	Decimal			
TiAlN	D1		D2	L1	L2
M16045	45	.0820	1/8	3/4	2
M16044	44	.0860	1/8	3/4	2
M16043	43	.0890	1/8	3/4	2
M16042	42	.0935	1/8	3/4	2
M16041	41	.0960	1/8	13/16	2-1/16
M16040	40	.0980	1/8	13/16	2-1/16
M16039	39	.0995	1/8	13/16	2-1/4
M16038	38	.1015	1/8	13/16	2-1/4
M16037	37	.1040	1/8	13/16	2-1/4
M16036	36	.1065	1/8	13/16	2-1/4
M16035	35	.1100	1/8	7/8	2-5/16
M16034	34	.1110	1/8	7/8	2-5/16
M16033	33	.1130	1/8	7/8	2-5/16
M16032	32	.1160	1/8	7/8	2-5/16
M16031	31	.1120	1/8	7/8	2-5/16
M16030	30	.1285	3/16	15/16	2-3/8
M16029	29	.1360	3/16	15/16	2-3/8
M16028	28	.1405	3/16	15/16	2-3/8
M16027	27	.1440	3/16	1	2-7/16
M16026	26	.1470	3/16	1	2-7/16
M16025	25	.1495	3/16	1	2-7/16
M16024	24	.1520	3/16	1	2-7/16
M16023	23	.1540	3/16	1	2-7/16

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Wire gauge	Decimal			
TiAlN	D1		D2	L1	L2
M16022	22	.1570	3/16	1-1/16	2-1/2
M16021	21	.1590	3/16	1-1/16	2-1/2
M16020	20	.1610	3/16	1-1/16	2-1/2
M16019	19	.1660	3/16	1-1/16	2-1/2
M16018	18	.1695	3/16	1-1/16	2-1/2
M16017	17	.1730	3/16	1-1/8	2-9/16
M16016	16	.1770	3/16	1-1/8	2-9/16
M16015	15	.1800	3/16	1-1/8	2-9/16
M16014	14	.1820	3/16	1-1/8	2-9/16
M16013	13	.1850	3/16	1-1/8	2-9/16
M16012	12	.1890	1/4	1-3/16	3
M16011	11	.1910	1/4	1-3/16	3
M16010	10	.1935	1/4	1-3/16	3
M16009	9	.1960	1/4	1-3/16	3
M16008	8	.1990	1/4	1-3/16	3
M16007	7	.2010	1/4	1-3/16	3
M16006	6	.2040	1/4	1-1/4	3-1/16
M16005	5	.2055	1/4	1-1/4	3-1/16
M16004	4	.2090	1/4	1-1/4	3-1/16
M16003	3	.2130	1/4	1-1/4	3-1/16
M16002	2	.2210	1/4	1-5/16	3-1/8
M16001	1	.2280	1/4	1-5/16	3-1/8

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				○	○	○				◎

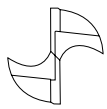
MULTI-1 DRILLS

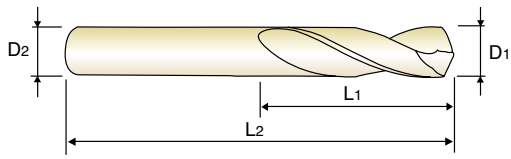
CDRA07 SERIES

PREMIUM HSS-PM, MULTI-1 DRILLS

▶ **Features** : Excellent wear resistance by using Premium powder metallurgy materials.
With special point geometry, no centering required.
Minimal drill wandering and improved hole tolerances.
Better tool life with excellent coating.

▶ **Application** : Applicable to various materials including aluminum and stainless steel, as well carbon steel and structural steel.





PREMIUM HSS-PM | N 30° | h6 | h7 | 135° P.153

▶ M17 / Letter sizes

Unit : Inch

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Letter	Decimal			
TiAlN	D1		D2	L1	L2
M1700B	B	.2380	1/4	1-3/8	3-3/16
M1700C	C	.2420	1/4	1-3/8	3-3/16
M1700D	D	.2460	1/4	1-3/8	3-3/16
M1700F	F	.2570	3/8	1-7/16	3-1/4
M1700G	G	.2610	3/8	1-7/16	3-1/4
M1700I	I	.2720	3/8	1-1/2	3-5/16
M1700J	J	.2770	3/8	1-1/2	3-5/16
M1700L	L	.2900	3/8	1-9/16	3-3/8
M1700M	M	.2950	3/8	1-9/16	3-3/8

EDP No.	Diameter		Shank Diameter	Flute Length	Overall Length
	Letter	Decimal			
TiAlN	D1		D2	L1	L2
M1700N	N	.3020	3/8	1-5/8	3-7/16
M1700O	O	.3160	3/8	1-11/16	3-1/2
M1700Q	Q	.3320	3/8	1-11/16	3-1/2
M1700R	R	.3390	3/8	1-11/16	3-1/2
M1700U	U	.3680	3/8	1-13/16	3-5/8
M1700V	V	.3770	1/2	1-7/8	3-31/32
M1700X	X	.3970	1/2	1-15/16	4-1/32
M1700Y	Y	.4040	1/2	1-15/16	4-1/32
M1700Z	Z	.4130	1/2	2	4-1/32

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				○	○	○				◎

PREMIUM HSS-PM, MULTI-1 DRILLS

CDRA05, CDRA06, CDRA07 SERIES

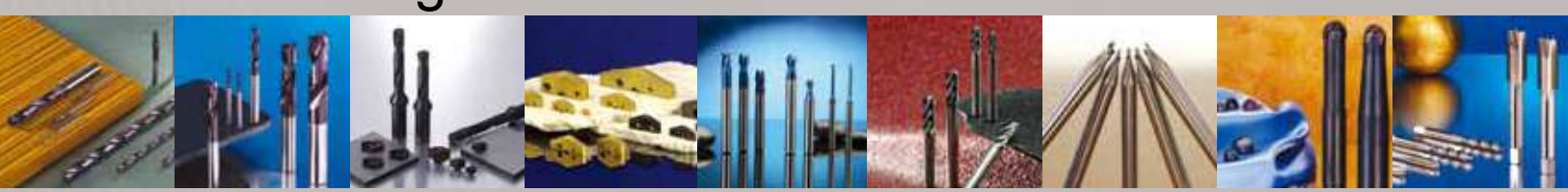
WORK MATERIAL	P								
	STRUCTUAL STEEL CARBON STEEL			ALLOY STEEL			MOLD STEEL		
DIAMETER	RPM	FEED (IPR)	FEED (inch/min)	RPM	FEED (IPR)	FEED (inch/min)	RPM	FEED (IPR)	FEED (inch/min)
3/32	5000	.0030	15.00	4000	.0030	12.00	1800	.0030	5.40
1/8	3800	.0050	19.00	3000	.0040	12.00	1400	.0040	5.60
5/32	3000	.0060	18.00	2400	.0050	12.00	1100	.0040	4.40
3/16	2500	.0070	17.50	2000	.0050	10.00	900	.0040	3.60
1/4	1900	.0080	15.20	1500	.0070	10.50	700	.0050	3.50
5/16	1500	.0090	13.50	1200	.0080	9.60	550	.0070	3.85
3/8	1250	.0100	12.50	1000	.0090	9.00	450	.0080	3.60
1/2	950	.0110	10.45	750	.0100	7.50	350	.0090	3.15

WORK MATERIAL	M			K			N		
	STAINLESS STEEL			CAST IRON			ALUMINIUM ALLOY COPPER ALLOY NONFERROUS ALLOY		
DIAMETER	RPM	FEED (IPR)	FEED (inch/min)	RPM	FEED (IPR)	FEED (inch/min)	RPM	FEED (IPR)	FEED (inch/min)
3/32	1800	.0030	5.40	5700	.0040	22.80	8700	.0040	34.80
1/8	1400	.0040	5.60	4250	.0060	25.50	6500	.0060	39.00
5/32	1100	.0040	4.40	3400	.0070	23.80	5200	.0070	36.40
3/16	900	.0040	3.60	2850	.0080	22.80	4300	.0080	34.40
1/4	700	.0050	3.50	2100	.0100	21.00	3200	.0090	28.80
5/16	550	.0070	3.85	1750	.0120	21.00	2600	.0110	28.60
3/8	450	.0080	3.60	1450	.0120	17.40	2200	.0130	28.60
1/2	350	.0090	3.15	1100	.0150	16.50	1650	.0150	24.75

WORK MATERIAL	S		
	NICKEL ALLOY TITANIUM ALLOY		
DIAMETER	RPM	FEED (IPR)	FEED (inch/min)
3/32	800	.0010	0.80
1/8	600	.0020	1.20
5/32	500	.0020	1.00
3/16	400	.0020	0.80
1/4	300	.0030	0.90
5/16	250	.0030	0.75
3/8	200	.0040	0.80
1/2	150	.0050	0.75

N = R.P.M
S = Inch per Revolution(inch/rev.)

Global Cutting Tool Leader **YG-1**



HSS

Being the best through innovation

HPD DRILLS

- **HSS-EX HPD STRAIGHT SHANK DRILLS for Stainless Steels**

HPD - HIGH PERFORMANCE DRILLS

HPD-SUS Drills for High precision drilling in Stainless steels

ITEM	MODEL	DESCRIPTION		SIZE MIN	SIZE MAX	PAGE
METRIC						
DJ543		HSS-EX, HPD-SUS DRILLS	*STUB*	D2.0	D13.0	**158**
DJ544		HSS-EX, HPD-SUS DRILLS	*JOBBER*	D2.0	D20.0	**160**
		RECOMMENDED CUTTING CONDITIONS				**163**

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎					◎		○	○			○
◎					◎		○	○			○

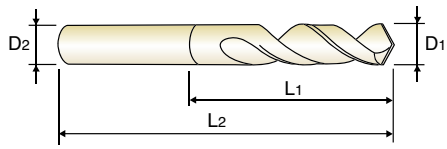
HPD DRILLS

DJ543 SERIES

HSS-EX, HPD-SUS DRILLS

STUB

- **Application** : Designed for drilling in stainless steels, mild steels, aluminum, aluminum alloy, aluminum die cast, copper, copper alloy, etc.
- **Advantage** : Self centering - center drilling is not required
  Excellent positioning - bush is not necessary
  Special Design - reaming is not required
  - good chip removal
  - powerful drilling
- **Plain Shank** : DIN6535-HA



HSS EX | W 38° | h7 | h8 | 130° | 120° | P.163

$D_1=D_2$

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
	$D_1 = D_2$		L_1	L_2
0201JCN	2.0	.0787	12	44
0211JCN	2.1	.0827	12	44
0221JCN	2.2	.0866	13	45
0231JCN	2.3	.0906	13	45
0241JCN	2.4	.0945	14	46
0251JCN	2.5	.0984	14	46
0261JCN	2.6	.1024	14	46
0271JCN	2.7	.1063	16	48
0281JCN	2.8	.1102	16	48
0291JCN	2.9	.1142	16	48
0301JCN	3.0	.1181	16	48
0311JCN	3.1	.1220	18	50
0321JCN	3.2	.1260	18	50
0331JCN	3.3	.1299	18	50
0341JCN	3.4	.1339	20	52
0351JCN	3.5	.1378	20	52
0361JCN	3.6	.1417	20	52
0371JCN	3.7	.1457	20	52
0381JCN	3.8	.1496	22	54
0391JCN	3.9	.1535	22	54
0401JCN	4.0	.1575	22	54
0411JCN	4.1	.1614	22	66
0421JCN	4.2	.1654	22	66
0431JCN	4.3	.1693	24	68
0441JCN	4.4	.1732	24	68
0451JCN	4.5	.1772	24	68
0461JCN	4.6	.1811	24	68
0471JCN	4.7	.1850	24	68

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
0481JCN	4.8	.1890	26	70
0491JCN	4.9	.1929	26	70
0501JCN	5.0	.1969	26	70
0511JCN	5.1	.2008	26	70
0521JCN	5.2	.2047	26	70
0531JCN	5.3	.2087	26	70
0541JCN	5.4	.2126	28	72
0551JCN	5.5	.2165	28	72
0561JCN	5.6	.2205	28	72
0571JCN	5.7	.2244	28	72
0581JCN	5.8	.2283	28	72
0591JCN	5.9	.2323	28	72
0601JCN	6.0	.2362	28	72
0611JCN	6.1	.2402	31	75
0621JCN	6.2	.2441	31	75
0631JCN	6.3	.2480	31	75
0641JCN	6.4	.2520	31	75
0651JCN	6.5	.2559	31	75
0661JCN	6.6	.2598	31	75
0671JCN	6.7	.2638	31	75
0681JCN	6.8	.2677	34	78
0691JCN	6.9	.2717	34	78
0701JCN	7.0	.2756	34	78
0711JCN	7.1	.2795	34	78
0721JCN	7.2	.2835	34	78
0731JCN	7.3	.2874	34	78
0741JCN	7.4	.2913	34	78
0751JCN	7.5	.2953	34	78

* Individually packaged

▶ NEXT PAGE

◎ : Excellent ○ : Good

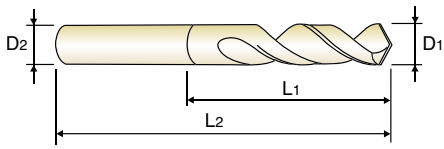
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55		HRc55~							
◎						◎		○	○			○

HSS-EX, HPD-SUS DRILLS

STUB

- **Application** : Designed for drilling in stainless steels, mild steels, aluminum, aluminum alloy, aluminum die cast, copper, copper alloy, etc.
- **Advantage** : Self centering - center drilling is not required
  Excellent positioning - bush is not necessary
  Special Design - reaming is not required
  - good chip removal
  - powerful drilling
- **Plain Shank** : DIN6535-HA

four facet



HSS EX | W 38° | h7 | h8 | 130° | 120°

P.163

$D_1=D_2$

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
0761JCN	7.6	.2992	37	81
0771JCN	7.7	.3031	37	81
0781JCN	7.8	.3071	37	81
0791JCN	7.9	.3110	37	81
0801JCN	8.0	.3150	37	81
0811JCN	8.1	.3189	37	87
0821JCN	8.2	.3228	37	87
0831JCN	8.3	.3268	37	87
0841JCN	8.4	.3307	37	87
0851JCN	8.5	.3346	37	87
0861JCN	8.6	.3386	40	90
0871JCN	8.7	.3425	40	90
0881JCN	8.8	.3465	40	90
0891JCN	8.9	.3504	40	90
0901JCN	9.0	.3543	40	90
0911JCN	9.1	.3583	40	90
0921JCN	9.2	.3622	40	90
0931JCN	9.3	.3661	40	90
0941JCN	9.4	.3701	40	90
0951JCN	9.5	.3740	40	90
0961JCN	9.6	.3780	43	93
0971JCN	9.7	.3819	43	93
0981JCN	9.8	.3858	43	93
0991JCN	9.9	.3898	43	93
1001JCN	10.0	.3937	43	93
1011JCN	10.1	.3976	43	100
1021JCN	10.2	.4016	43	100
1031JCN	10.3	.4055	43	100

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
1041JCN	10.4	.4094	43	100
1051JCN	10.5	.4134	43	100
1061JCN	10.6	.4173	43	100
1071JCN	10.7	.4212	47	104
1081JCN	10.8	.4252	47	104
1091JCN	10.9	.4291	47	104
1101JCN	11.0	.4330	47	104
1111JCN	11.1	.4370	47	104
1121JCN	11.2	.4409	47	104
1131JCN	11.3	.4448	47	104
1141JCN	11.4	.4488	47	104
1151JCN	11.5	.4527	47	104
1161JCN	11.6	.4566	47	104
1171JCN	11.7	.4606	47	104
1181JCN	11.8	.4645	47	104
1191JCN	11.9	.4685	51	108
1201JCN	12.0	.4724	51	108
1211JCN	12.1	.4764	51	108
1221JCN	12.2	.4803	51	108
1231JCN	12.3	.4843	51	108
1241JCN	12.4	.4882	51	108
1251JCN	12.5	.4921	51	108
1261JCN	12.6	.4961	51	108
1271JCN	12.7	.5000	51	108
1281JCN	12.8	.5039	51	108
1291JCN	12.9	.5079	51	108
1301JCN	13.0	.5118	51	108

* Individually packaged

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎						◎		○	○			○

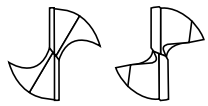
HPD DRILLS

DJ544 SERIES

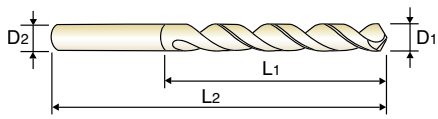
HSS-EX, HPD-SUS DRILLS

JOBBER

▶ **Application** : Designed for drilling in stainless steels, mild steels, aluminum, aluminum alloy, aluminum die cast, copper, copper alloy, etc.
▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Wide flute and stub length-increasing chip removal and reducing vibration and deflection.
High vanadium HSS-EX material with superior TiN coating - higher speed and feed, longer service life
High quality-good surface finishes, high productivity.



up to 13mm over 13mm



HSS EX | W 38° | h7 | h8 | 130° | 120°

up to 4mm over 4mm

P.163

$D_1 = D_2$

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
0201KCN	2.0	.0787	24	56
0211KCN	2.1	.0827	24	56
0221KCN	2.2	.0866	27	59
0231KCN	2.3	.0906	27	59
0241KCN	2.4	.0945	30	62
0251KCN	2.5	.0984	30	62
0261KCN	2.6	.1024	30	62
0271KCN	2.7	.1063	33	65
0281KCN	2.8	.1102	33	65
0291KCN	2.9	.1142	33	65
0301KCN	3.0	.1181	33	65
0311KCN	3.1	.1220	36	68
0321KCN	3.2	.1260	36	68
0331KCN	3.3	.1299	36	68
0341KCN	3.4	.1339	39	71
0351KCN	3.5	.1378	39	71
0361KCN	3.6	.1417	39	71
0371KCN	3.7	.1457	39	71
0381KCN	3.8	.1496	43	75
0391KCN	3.9	.1535	43	75
0401KCN	4.0	.1575	43	75
0411KCN	4.1	.1614	43	87
0421KCN	4.2	.1654	43	87
0431KCN	4.3	.1693	47	91
0441KCN	4.4	.1732	47	91

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
0451KCN	4.5	.1772	47	91
0461KCN	4.6	.1811	47	91
0471KCN	4.7	.1850	47	91
0481KCN	4.8	.1890	52	96
0491KCN	4.9	.1929	52	96
0501KCN	5.0	.1969	52	96
0511KCN	5.1	.2008	52	96
0521KCN	5.2	.2047	52	96
0531KCN	5.3	.2087	52	96
0541KCN	5.4	.2126	57	101
0551KCN	5.5	.2165	57	101
0561KCN	5.6	.2205	57	101
0571KCN	5.7	.2244	57	101
0581KCN	5.8	.2283	57	101
0591KCN	5.9	.2323	57	101
0601KCN	6.0	.2362	57	101
0611KCN	6.1	.2402	63	107
0621KCN	6.2	.2441	63	107
0631KCN	6.3	.2480	63	107
0641KCN	6.4	.2520	63	107
0651KCN	6.5	.2559	63	107
0661KCN	6.6	.2598	63	107
0671KCN	6.7	.2638	63	107
0681KCN	6.8	.2677	69	113
0691KCN	6.9	.2717	69	113

* Individually packaged

▶ NEXT PAGE

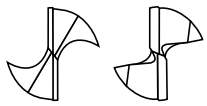
◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎						◎		○	○			○

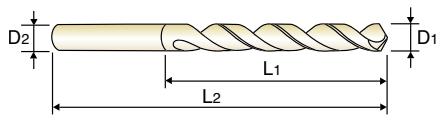
HSS-EX, HPD-SUS DRILLS

JOBBER

▶ **Application** : Designed for drilling in stainless steels, mild steels, aluminum, aluminum alloy, aluminum die cast, copper, copper alloy, etc.
▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Wide flute and stub length-increasing chip removal and reducing vibration and deflection.
High vanadium HSS-EX material with superior TiN coating - higher speed and feed, longer service life
High quality-good surface finishes, high productivity.



up to 13mm over 13mm



HSS EX | W 38° | h7 | h8 | 130° | 120° | up to 4mm

P.163

$D_1 = D_2$

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
0701KCN	7.0	.2756	69	113
0711KCN	7.1	.2795	69	113
0721KCN	7.2	.2835	69	113
0731KCN	7.3	.2874	69	113
0741KCN	7.4	.2913	69	113
0751KCN	7.5	.2953	69	113
0761KCN	7.6	.2992	75	119
0771KCN	7.7	.3031	75	119
0781KCN	7.8	.3071	75	119
0791KCN	7.9	.3110	75	119
0801KCN	8.0	.3150	75	119
0811KCN	8.1	.3189	75	125
0821KCN	8.2	.3228	75	125
0831KCN	8.3	.3268	75	125
0841KCN	8.4	.3307	75	125
0851KCN	8.5	.3346	75	125
0861KCN	8.6	.3386	81	131
0871KCN	8.7	.3425	81	131
0881KCN	8.8	.3465	81	131
0891KCN	8.9	.3504	81	131
0901KCN	9.0	.3543	81	131
0911KCN	9.1	.3583	81	131
0921KCN	9.2	.3622	81	131
0931KCN	9.3	.3661	81	131
0941KCN	9.4	.3701	81	131

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
0951KCN	9.5	.3740	81	131
0961KCN	9.6	.3780	87	137
0971KCN	9.7	.3819	87	137
0981KCN	9.8	.3858	87	137
0991KCN	9.9	.3898	87	137
1001KCN	10.0	.3937	87	137
1011KCN	10.1	.3976	87	144
1021KCN	10.2	.4016	87	144
1031KCN	10.3	.4055	87	144
1041KCN	10.4	.4094	87	144
1051KCN	10.5	.4134	87	144
1061KCN	10.6	.4173	87	144
1071KCN	10.7	.4212	94	151
1081KCN	10.8	.4252	94	151
1091KCN	10.9	.4291	94	151
1101KCN	11.0	.4330	94	151
1111KCN	11.1	.4370	94	151
1121KCN	11.2	.4409	94	151
1131KCN	11.3	.4448	94	151
1141KCN	11.4	.4488	94	151
1151KCN	11.5	.4527	94	151
1161KCN	11.6	.4566	94	151
1171KCN	11.7	.4606	94	151
1181KCN	11.8	.4645	94	151
1191KCN	11.9	.4685	101	158

* Individually packaged

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎						◎		○	○			○

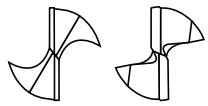
HPD DRILLS

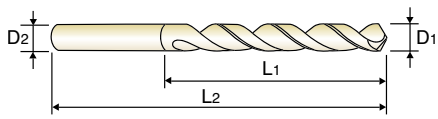
DJ544 SERIES

HSS-EX, HPD-SUS DRILLS

JOBBER

▶ **Application** : Designed for drilling in stainless steels, mild steels, aluminum, aluminum alloy, aluminum die cast, copper, copper alloy, etc.
▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Wide flute and stub length-increasing chip removal and reducing vibration and deflection.
High vanadium HSS-EX material with superior TiN coating - higher speed and feed, longer service life
High quality-good surface finishes, high productivity.





HSS EX | W 38° | h7 | h8 | 130° | 120° | P.163

up to 4mm over 4mm

$D_1 = D_2$

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
1201KCN	12.0	.4724	101	158
1211KCN	12.1	.4764	101	158
1221KCN	12.2	.4803	101	158
1231KCN	12.3	.4843	101	158
1241KCN	12.4	.4882	101	158
1251KCN	12.5	.4921	101	158
1261KCN	12.6	.4961	101	158
1271KCN	12.7	.5000	101	158
1281KCN	12.8	.5039	101	158
1291KCN	12.9	.5079	101	158
1301KCN	13.0	.5118	101	158
1351KCN	13.5	.5314	106	166
1401KCN	14.0	.5512	106	166
1411KCN	14.1	.5551	109	169
1451KCN	14.5	.5708	109	169

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	$D_1 = D_2$		L_1	L_2
1501KCN	15.0	.5905	109	169
1551KCN	15.5	.6102	112	172
1561KCN	15.6	.6141	112	172
1601KCN	16.0	.6299	112	172
1651KCN	16.5	.6495	115	181
1701KCN	17.0	.6692	115	181
1751KCN	17.5	.6889	118	184
1761KCN	17.6	.6929	118	184
1801KCN	18.0	.7087	118	184
1851KCN	18.5	.7283	122	188
1901KCN	19.0	.7480	122	188
1951KCN	19.5	.7676	125	191
1961KCN	19.6	.7716	125	191
2001KCN	20.0	.7874	125	191

* Individually packaged

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55		HRc55~							
◎						◎		○	○			○

HSS-EX, HPD-SUS DRILLS

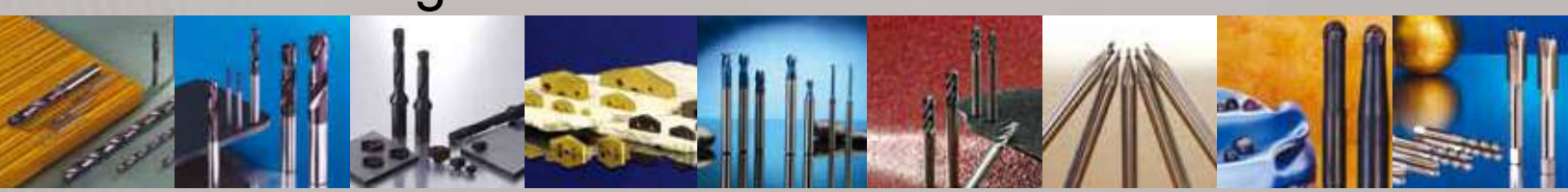
DJ543, DJ544 SERIES

Please decrease the feed rate 15% in JOBBERS SERIES.
Please decrease the feed and speed 20% for cast surface.

WORK MATERIAL	P		M				N			
	MILD STEELS, LOW CARBON STEELS		STAINLESS STEELS (SUS304, 200)		STAINLESS STEELS (SUS420, 440)		ALUMINUM & ALUMINUM ALLOY		PLASTICS, COPPER, COPPER ALLOYS	
DIAMETER	N	S	N	S	N	S	N	S	N	S
2.0	6300	0.003	2600	0.003	3100	0.003	11000	0.004	5600	0.002
3.0	4200	0.005	1800	0.003	2100	0.003	7350	0.005	3750	0.003
4.0	3200	0.006	1300	0.004	1600	0.004	7050	0.007	2800	0.004
5.0	2500	0.006	1050	0.006	1250	0.006	5500	0.009	2250	0.005
6.0	2100	0.007	900	0.007	1050	0.007	4600	0.010	1850	0.006
8.0	1550	0.009	650	0.009	800	0.009	3500	0.013	1350	0.008
10.0	1250	0.010	550	0.010	630	0.012	2800	0.016	1100	0.010
12.0	1050	0.013	450	0.013	530	0.014	2300	0.020	950	0.012
14.0	900	0.014	400	0.014	450	0.017	2050	0.022	800	0.013
16.0	790	0.016	350	0.016	390	0.019	1750	0.024	700	0.014
18.0	700	0.018	300	0.017	350	0.020	1600	0.028	620	0.016
20.0	620	0.019	260	0.018	320	0.021	1450	0.030	560	0.016

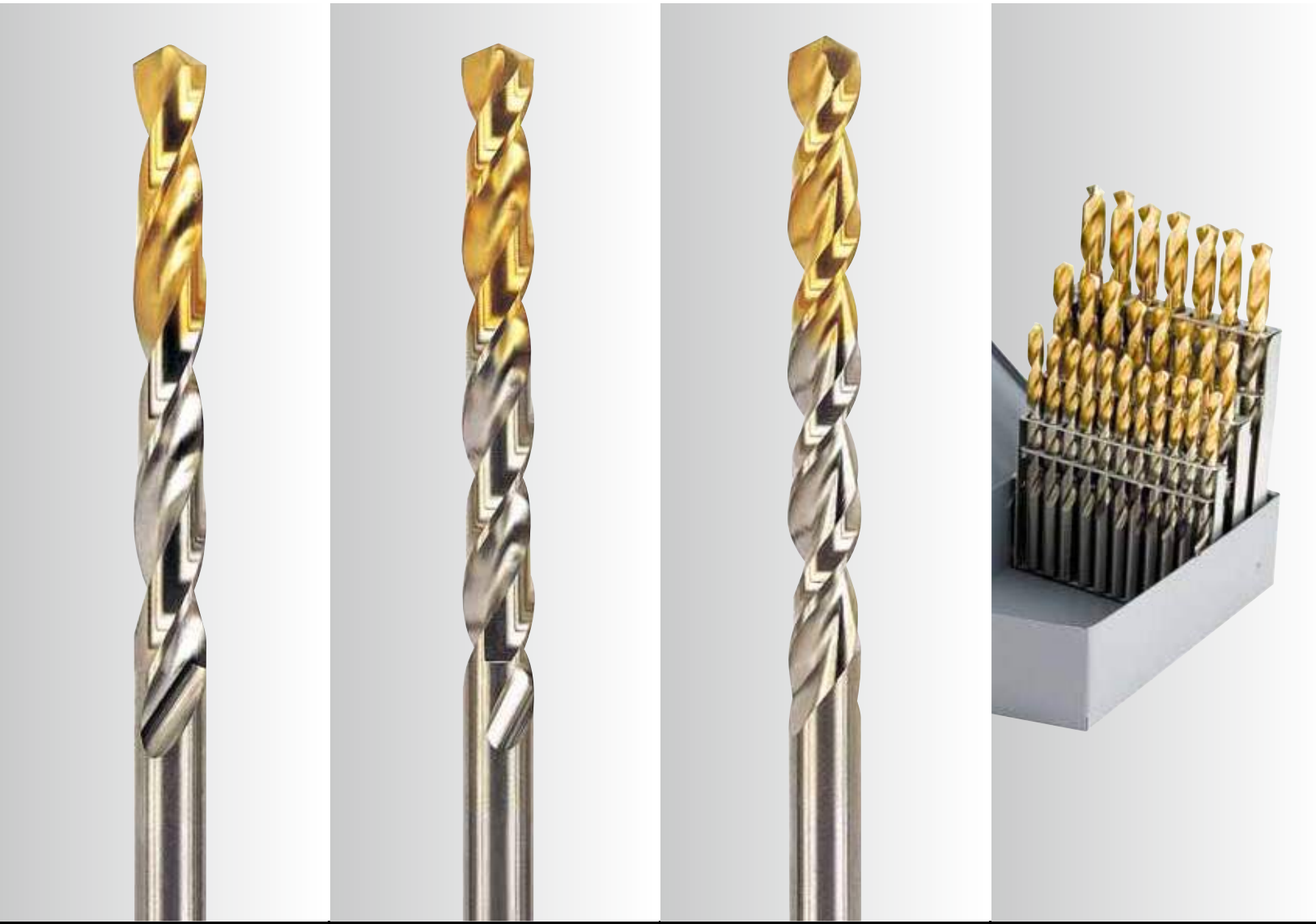
N = R.P.M
S = Inch per Revolution (inch/rev.)

Global Cutting Tool Leader **YG-1**



HSS

Being the best through innovation



GOLD-P DRILLS

- GOLD-P COATING

GOLD-P DRILLS (GOLD-P COATED)

Competitive price and same performance as full TiN coating

ITEM	MODEL	DESCRIPTION		SIZE MIN	SIZE MAX	PAGE
INCH						
D1GP182 D8182		HSS, STRAIGHT SHANK, GOLD-P COATED / Fractional sizes	*JOBBER*	D3/64	D3/4	**168**
D1GP139		HSS, STRAIGHT SHANK, GOLD-P COATED / Letter sizes	*JOBBER*	A	Z	**169**
D1GP138		HSS, STRAIGHT SHANK, GOLD-P COATED / Wire gauge sizes	*JOBBER*	#56	#1	**170**
D2GP185		HSSCo8, STRAIGHT SHANK, GOLD-P COATED / Fractional sizes	*JOBBER*	D3/64	D1/2	**171**
D2GP186		HSSCo8, STRAIGHT SHANK, GOLD-P COATED / Letter sizes	*JOBBER*	A	Z	**172**
D2GP187		HSSCo8, STRAIGHT SHANK, GOLD-P COATED / Wire gauge sizes	*JOBBER*	#56	#1	**173**
DLGP511		HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE, GOLD-P COATED / Fractional sizes	*JOBBER*	D5/64	D1/2	**174**
DLGP513		HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE, GOLD-P COATED / Letter sizes	*JOBBER*	A	Z	**175**
DLGP512		HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE, GOLD-P COATED / Wire gauge sizes	*JOBBER*	#47	#1	**176**
METRIC						
DLGP195		HSSCo5, STRAIGHT SHANK DRILLS, GOLD-P COATED	*JOBBER*	D1.0	D13.0	**177**
DLGP506		HSSCo5 DH100 STRAIGHT SHANK DRILLS for DEEP HOLES, GOLD-P COATED	*JOBBER*	D2.0	D13.0	**179**
		RECOMMENDED CUTTING CONDITIONS				**182**

◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○		○				○
◎	◎				○		○				○
◎	◎				○		○				○
◎	◎				○		○				○
◎	◎				○		○				○
◎	◎				○		○				○
◎	◎					○	○				
◎	◎					○	○				
◎	◎					○	○				
◎	◎				○		○				○
◎	◎					○	○				

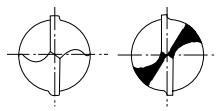
GOLD-P DRILLS

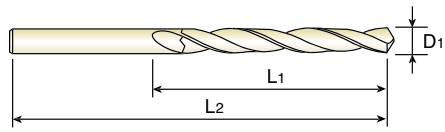
D1GP182 SERIES
D8182 SERIES

HSS, STRAIGHT SHANK, GOLD-P COATED

JOBBER

- **Flute Geometry** : Right hand helix, wider flutes
- **Point Angle** : 135˚
  under 1/16 : Normal point
  1/16 & over : Split point
- **Surface treatment** : Bright body TiN coating on working part
  over TiN coating on flute length
- **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI | HSS | N ≈30° | h8 | 135° P.182

▶ Fractional sizes

Unit : Inch

EDP No.	Diameter Fractional D1	Diameter Decimal D1	Flute Length L1	Overall Length L2
* D1GP113003	3/64	.0469	3/4	1-3/4
* D1GP182004	1/16	.0625	7/8	1-7/8
* D1GP182005	5/64	.0781	1	2
* D1GP182006	3/32	.0938	1-1/4	2-1/4
* D1GP182007	7/64	.1094	1-1/2	2-5/8
* D1GP182008	1/8	.1250	1-5/8	2-3/4
* D1GP182009	9/64	.1406	1-3/4	2-7/8
* D1GP182010	5/32	.1563	2	3-1/8
* D1GP182011	11/64	.1719	2-1/8	3-1/4
* D1GP182012	3/16	.1875	2-5/16	3-1/2
* D1GP182013	13/64	.2031	2-7/16	3-5/8
* D1GP182014	7/32	.2188	2-1/2	3-3/4
* D1GP182015	15/64	.2344	2-5/8	3-7/8
* D1GP182016	1/4	.2500	2-3/4	4
* D1GP182017	17/64	.2656	2-7/8	4-1/8
* D1GP182018	9/32	.2813	2-15/16	4-1/4
* D1GP182019	19/64	.2969	3-1/16	4-3/8
* D1GP182020	5/16	.3125	3-3/16	4-1/2
** D1GP182021	21/64	.3281	3-5/16	4-5/8
** D1GP182022	11/32	.3438	3-7/16	4-3/4
** D1GP182023	23/64	.3594	3-1/2	4-7/8
** D1GP182024	3/8	.3750	3-5/8	5

EDP No.	Diameter Fractional D1	Diameter Decimal D1	Flute Length L1	Overall Length L2
** D1GP182025	25/64	.3906	3-3/4	5-1/8
** D1GP182026	13/32	.4063	3-7/8	5-1/4
** D1GP182027	27/64	.4219	3-15/16	5-3/8
** D1GP182028	7/16	.4375	4-1/16	5-1/2
** D1GP182029	29/64	.4531	4-3/16	5-5/8
** D1GP182030	15/32	.4688	4-5/16	5-3/4
** D1GP182031	31/64	.4844	4-3/8	5-7/8
** D1GP182032	1/2	.5000	4-1/2	6
** D8182033	33/64	.5156	4-13/16	6-5/8
** D8182034	17/32	.5312	4-13/16	6-5/8
** D8182035	35/64	.5469	4-13/16	6-5/8
** D8182036	9/16	.5625	4-13/16	6-5/8
** D8182037	37/64	.5781	4-13/16	6-5/8
⁂ D8182038	19/32	.5937	5-3/16	7-1/8
⁂ D8182039	39/64	.6094	5-3/16	7-1/8
⁂ D8182040	5/8	.6250	5-3/16	7-1/8
⁂ D8182042	21/32	.6563	5-3/16	7-1/8
⁂ D8182044	11/16	.6875	5-5/8	7-5/8
⁂ D8182045	45/64	.7031	5-5/8	9-1/2
⁂ D8182046	23/32	.7188	5-5/8	9-1/2
⁂ D8182047	47/64	.7344	5-5/8	9-3/4
⁂ D8182048	3/4	.7500	5-7/8	9-3/4

* 10per package
** 5per package
⁂ 3per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

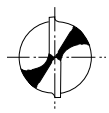
GOLD-P DRILLS

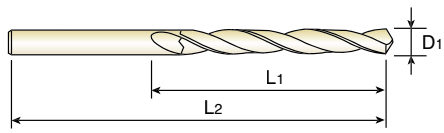
D1GP139 SERIES

HSS, STRAIGHT SHANK, GOLD-P COATED

JOBBER

- ▶ **Flute Geometry** : Right hand helix, wider flutes
- ▶ **Point Angle** : 135°:Split point
- ▶ **Surface treatment** : Bright body TiN coating on working part
- ▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI HSS N ≈ 30° h8 135° P.182

▶ Letter sizes

Unit : Inch

EDP No.	Diameter Letter	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* D1GP139101	A	.2340	2-5/8	3-7/8
* D1GP139102	B	.2380	2-3/4	4
* D1GP139103	C	.2420	2-3/4	4
* D1GP139104	D	.2460	2-3/4	4
* D1GP139105	E	.2500	2-3/4	4
* D1GP139106	F	.2570	2-7/8	4-1/8
* D1GP139107	G	.2610	2-7/8	4-1/8
* D1GP139108	H	.2660	2-7/8	4-1/8
* D1GP139109	I	.2720	2-7/8	4-1/8
* D1GP139110	J	.2770	2-7/8	4-1/8
* D1GP139111	K	.2810	2-15/16	4-1/4
* D1GP139112	L	.2900	2-15/16	4-1/4
* D1GP139113	M	.2950	3-1/16	4-3/8
* D1GP139114	N	.3020	3-1/16	4-3/8
* D1GP139115	O	.3160	3-3/16	4-1/2
* D1GP139116	P	.3230	3-5/16	4-5/8
** D1GP139117	Q	.3320	3-7/16	4-3/4
** D1GP139118	R	.3390	3-7/16	4-3/4
** D1GP139119	S	.3480	3-1/2	4-7/8
** D1GP139120	T	.3580	3-1/2	4-7/8
** D1GP139121	U	.3680	3-5/8	5
** D1GP139122	V	.3770	3-5/8	5
** D1GP139123	W	.3860	3-3/4	5-1/8
** D1GP139124	X	.3970	3-3/4	5-1/8
** D1GP139125	Y	.4040	3-7/8	5-1/4
** D1GP139126	Z	.4130	3-7/8	5-1/4

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

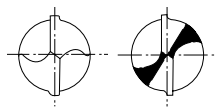
GOLD-P DRILLS

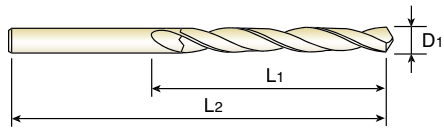
D1GP138 SERIES

HSS, STRAIGHT SHANK, GOLD-P COATED

JOBBER

- **Flute Geometry** : Right hand helix, wider flutes
- **Point Angle** : 135°, Split point
  Wire gauge size #53~#56 : Normal point
  Wire gauge size #1~#52 : Split point
- **Surface treatment** : Bright body TiN coating on working part
- **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI | HSS | N 30° | h8 | 135° | 118°

#53~#56 #1~#52

P.182

▶ Wire gauge sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* D1GP138256	1	.2280	2-5/8	3-7/8
* D1GP138255	2	.2210	2-5/8	3-7/8
* D1GP138254	3	.2130	2-1/2	3-3/4
* D1GP138253	4	.2090	2-1/2	3-3/4
* D1GP138252	5	.2055	2-1/2	3-3/4
* D1GP138251	6	.2040	2-1/2	3-3/4
* D1GP138250	7	.2010	2-7/16	3-5/8
* D1GP138249	8	.1990	2-7/16	3-5/8
* D1GP138248	9	.1960	2-7/16	3-5/8
* D1GP138247	10	.1935	2-7/16	3-5/8
* D1GP138246	11	.1910	2-5/16	3-1/2
* D1GP138245	12	.1890	2-5/16	3-1/2
* D1GP138244	13	.1850	2-5/16	3-1/2
* D1GP138243	14	.1820	2-3/16	3-3/8
* D1GP138242	15	.1800	2-3/16	3-3/8
* D1GP138241	16	.1770	2-3/16	3-3/8
* D1GP138240	17	.1730	2-3/16	3-3/8
* D1GP138239	18	.1695	2-1/8	3-1/4
* D1GP138238	19	.1660	2-1/8	3-1/4
* D1GP138237	20	.1610	2-1/8	3-1/4
* D1GP138236	21	.1590	2-1/8	3-1/4
* D1GP138235	22	.1570	2	3-1/8
* D1GP138234	23	.1540	2	3-1/8
* D1GP138233	24	.1520	2	3-1/8
* D1GP138232	25	.1495	1-7/8	3
* D1GP138231	26	.1470	1-7/8	3
* D1GP138230	27	.1440	1-7/8	3
* D1GP138229	28	.1405	1-3/4	2-7/8

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* D1GP138228	29	.1360	1-3/4	2-7/8
* D1GP138227	30	.1285	1-5/8	2-3/4
* D1GP138226	31	.1200	1-5/8	2-3/4
* D1GP138225	32	.1160	1-5/8	2-3/4
* D1GP138224	33	.1130	1-1/2	2-5/8
* D1GP138223	34	.1110	1-1/2	2-5/8
* D1GP138222	35	.1100	1-1/2	2-5/8
* D1GP138221	36	.1065	1-7/16	2-1/2
* D1GP138220	37	.1040	1-7/16	2-1/2
* D1GP138219	38	.1015	1-7/16	2-1/2
* D1GP138218	39	.0995	1-3/8	2-3/8
* D1GP138217	40	.0980	1-3/8	2-3/8
* D1GP138216	41	.0960	1-3/8	2-3/8
* D1GP138215	42	.0935	1-1/4	2-1/4
* D1GP138214	43	.0890	1-1/4	2-1/4
* D1GP138213	44	.0860	1-1/8	2-1/8
* D1GP138212	45	.0820	1-1/8	2-1/8
* D1GP138211	46	.0810	1-1/8	2-1/8
* D1GP138210	47	.0785	1	2
* D1GP138209	48	.0760	1	2
* D1GP138208	49	.0730	1	2
* D1GP138207	50	.0700	1	2
* D1GP138206	51	.0670	1	2
* D1GP138205	52	.0635	7/8	1-7/8
* D1GP134204	53	.0595	7/8	1-7/8
* D1GP134203	54	.0550	7/8	1-7/8
* D1GP134202	55	.0520	7/8	1-7/8
* D1GP134201	56	.0465	3/4	1-3/4

▶ **Tolerance** : See page 168

* 10per package

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○		○				○

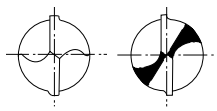
GOLD-P DRILLS

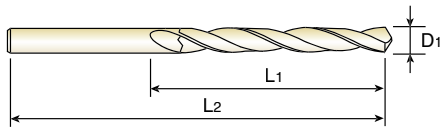
D2GP185 SERIES

HSSCo8, STRAIGHT SHANK, GOLD-P COATED

JOBBER

- ▶ **Flute Geometry** : Right hand helix, wider flutes
- ▶ **Point Angle** : 135˚
  under 1/16 : Normal point
  1/16 & over : Split point
- ▶ **Surface treatment** : Bright body TiN coating on working part
- ▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI | HSS Co8 | N ≈30° | h8 | 135° P.182

▶ Fractional sizes

Unit : Inch

EDP No.	Diameter Fractional D1	Diameter Decimal D1	Flute Length L1	Overall Length L2
* D2GP185003	3/64	.0469	3/4	1-3/4
* D2GP185004	1/16	.0625	7/8	1-7/8
* D2GP185005	5/64	.0781	1	2
* D2GP185006	3/32	.0938	1-1/4	2-1/4
* D2GP185007	7/64	.1094	1-1/2	2-5/8
* D2GP185008	1/8	.1250	1-5/8	2-3/4
* D2GP185009	9/64	.1406	1-3/4	2-7/8
* D2GP185010	5/32	.1563	2	3-1/8
* D2GP185011	11/64	.1719	2-1/8	3-1/4
* D2GP185012	3/16	.1875	2-5/16	3-1/2
* D2GP185013	13/64	.2031	2-7/16	3-5/8
* D2GP185014	7/32	.2188	2-1/2	3-3/4
* D2GP185015	15/64	.2344	2-5/8	3-7/8
* D2GP185016	1/4	.2500	2-3/4	4
* D2GP185017	17/64	.2656	2-7/8	4-1/8

EDP No.	Diameter Fractional D1	Diameter Decimal D1	Flute Length L1	Overall Length L2
* D2GP185018	9/32	.2813	2-15/16	4-1/4
* D2GP185019	19/64	.2969	3-1/16	4-3/8
* D2GP185020	5/16	.3125	3-3/16	4-1/2
** D2GP185021	21/64	.3281	3-5/16	4-5/8
** D2GP185022	11/32	.3438	3-7/16	4-3/4
** D2GP185023	23/64	.3594	3-1/2	4-7/8
** D2GP185024	3/8	.3750	3-5/8	5
** D2GP185025	25/64	.3906	3-3/4	5-1/8
** D2GP185026	13/32	.4063	3-7/8	5-1/4
** D2GP185027	27/64	.4219	3-15/16	5-3/8
** D2GP185028	7/16	.4375	4-1/16	5-1/2
** D2GP185029	29/64	.4531	4-3/16	5-5/8
** D2GP185030	15/32	.4688	4-5/16	5-3/4
** D2GP185031	31/64	.4844	4-3/8	5-7/8
** D2GP185032	1/2	.5000	4-1/2	6

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

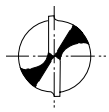
GOLD-P DRILLS

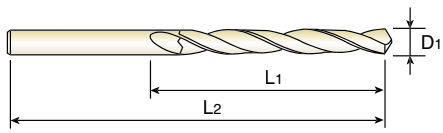
D2GP186 SERIES

HSSCo8, STRAIGHT SHANK, GOLD-P COATED

JOBBER

- **Flute Geometry** : Right hand helix, wider flutes
- **Point Angle** : 135° : Split point
- **Surface treatment** : Bright body TiN coating on working part
- **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI | HSS Co8 | N ≈ 30° | h8 | 135° P.182

▶ Letter sizes

Unit : Inch

EDP No.	Diameter Letter	Diameter Decimal	Flute Length L1	Overall Length L2
	D1			
* D2GP186101	A	.2340	2-5/8	3-7/8
* D2GP186102	B	.2380	2-3/4	4
* D2GP186103	C	.2420	2-3/4	4
* D2GP186104	D	.2460	2-3/4	4
* D2GP185105	E	.2500	2-3/4	4
* D2GP186106	F	.2570	2-7/8	4-1/8
* D2GP186107	G	.2610	2-7/8	4-1/8
* D2GP186108	H	.2660	2-7/8	4-1/8
* D2GP186109	I	.2720	2-7/8	4-1/8
* D2GP186110	J	.2770	2-7/8	4-1/8
* D2GP186111	K	.2810	2-15/16	4-1/4
* D2GP186112	L	.2900	2-15/16	4-1/4
* D2GP186113	M	.2950	3-1/16	4-3/8
* D2GP186114	N	.3020	3-1/16	4-3/8
* D2GP186115	O	.3160	3-3/16	4-1/2
* D2GP186116	P	.3230	3-5/16	4-5/8
** D2GP186117	Q	.3320	3-7/16	4-3/4
** D2GP186118	R	.3390	3-7/16	4-3/4
** D2GP186119	S	.3480	3-1/2	4-7/8
** D2GP186120	T	.3580	3-1/2	4-7/8
** D2GP186121	U	.3680	3-5/8	5
** D2GP186122	V	.3770	3-5/8	5
** D2GP186123	W	.3860	3-3/4	5-1/8
** D2GP186124	X	.3970	3-3/4	5-1/8
** D2GP186125	Y	.4040	3-7/8	5-1/4
** D2GP186126	Z	.4130	3-7/8	5-1/4

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○		○				○

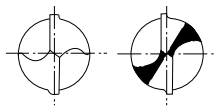
GOLD-P DRILLS

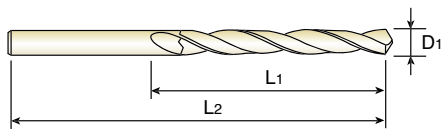
D2GP187 SERIES

HSSCo8, STRAIGHT SHANK, GOLD-P COATED

JOBBER

- ▶ **Flute Geometry** : Right hand helix, wider flutes
- ▶ **Point Angle** : 135° : Split point
  Wire gauge size #53~#56 : Normal point
  Wire gauge size #1~#52 : Split point
- ▶ **Surface treatment** : Bright body TiN coating on working part
- ▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI | HSS Co8 | N ≈30° | h8 | 135° | P.182

▶ Wire gauge sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* D2GP187256	1	.2280	2-5/8	3-7/8
* D2GP187255	2	.2210	2-5/8	3-7/8
* D2GP187254	3	.2130	2-1/2	3-3/4
* D2GP187253	4	.2090	2-1/2	3-3/4
* D2GP187252	5	.2055	2-1/2	3-3/4
* D2GP187251	6	.2040	2-1/2	3-3/4
* D2GP187250	7	.2010	2-7/16	3-5/8
* D2GP187249	8	.1990	2-7/16	3-5/8
* D2GP187248	9	.1960	2-7/16	3-5/8
* D2GP187247	10	.1935	2-7/16	3-5/8
* D2GP187246	11	.1910	2-5/16	3-1/2
* D2GP187245	12	.1890	2-5/16	3-1/2
* D2GP187244	13	.1850	2-5/16	3-1/2
* D2GP187243	14	.1820	2-3/16	3-3/8
* D2GP187242	15	.1800	2-3/16	3-3/8
* D2GP187241	16	.1770	2-3/16	3-3/8
* D2GP187240	17	.1730	2-3/16	3-3/8
* D2GP187239	18	.1695	2-1/8	3-1/4
* D2GP187238	19	.1660	2-1/8	3-1/4
* D2GP187237	20	.1610	2-1/8	3-1/4
* D2GP187236	21	.1590	2-1/8	3-1/4
* D2GP187235	22	.1570	2	3-1/8
* D2GP187234	23	.1540	2	3-1/8
* D2GP187233	24	.1520	2	3-1/8
* D2GP187232	25	.1495	1-7/8	3
* D2GP187231	26	.1470	1-7/8	3
* D2GP187230	27	.1440	1-7/8	3
* D2GP187229	28	.1405	1-3/4	2-7/8

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* D2GP187228	29	.1360	1-3/4	2-7/8
* D2GP187227	30	.1285	1-5/8	2-3/4
* D2GP187226	31	.1200	1-5/8	2-3/4
* D2GP187225	32	.1160	1-5/8	2-3/4
* D2GP187224	33	.1130	1-1/2	2-5/8
* D2GP187223	34	.1110	1-1/2	2-5/8
* D2GP187222	35	.1100	1-1/2	2-5/8
* D2GP187221	36	.1065	1-7/16	2-1/2
* D2GP187220	37	.1040	1-7/16	2-1/2
* D2GP187219	38	.1015	1-7/16	2-1/2
* D2GP187218	39	.0995	1-3/8	2-3/8
* D2GP187217	40	.0980	1-3/8	2-3/8
* D2GP187216	41	.0960	1-3/8	2-3/8
* D2GP187215	42	.0935	1-1/4	2-1/4
* D2GP187214	43	.0890	1-1/4	2-1/4
* D2GP187213	44	.0860	1-1/8	2-1/8
* D2GP187212	45	.0820	1-1/8	2-1/8
* D2GP187211	46	.0810	1-1/8	2-1/8
* D2GP187210	47	.0785	1	2
* D2GP187209	48	.0760	1	2
* D2GP187208	49	.0730	1	2
* D2GP187207	50	.0700	1	2
* D2GP187206	51	.0670	1	2
* D2GP187205	52	.0635	7/8	1-7/8
* D2GP187204	53	.0595	7/8	1-7/8
* D2GP187203	54	.0550	7/8	1-7/8
* D2GP187202	55	.0520	7/8	1-7/8
* D2GP187201	56	.0465	3/4	1-3/4

▶ **Tolerance** : See page 168

* 10per package

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

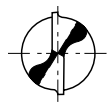
GOLD-P DRILLS

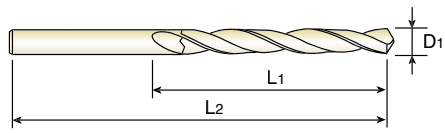
DLGP511 SERIES

HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE, GOLD-P COATED

JOBBER

- **Flute Geometry** : Right hand spiral, 38° helix, parabolic flute.
- **Point Angle** : 130° : Split point
- **Surface treatment** : Bright body TiN coating on working part
- **Application** : Improved chip removal in most materials, especially in deep drilling applications.





ANSI | HSS Co5 | N ≈ 38° | h8 | 130° P.183

▶ Fractional sizes

Unit : Inch

EDP No.	Diameter Fractional D1	Diameter Decimal D1	Flute Length L1	Overall Length L2
* DLGP511005	5/64	.0781	1	2
* DLGP511006	3/32	.0938	1-1/4	2-1/4
* DLGP511007	7/64	.1094	1-1/2	2-5/8
* DLGP511008	1/8	.1250	1-5/8	2-3/4
* DLGP511009	9/64	.1406	1-3/4	2-7/8
* DLGP511010	5/32	.1563	2	3-1/8
* DLGP511011	11/64	.1719	2-1/8	3-1/4
* DLGP511012	3/16	.1875	2-5/16	3-1/2
* DLGP511013	13/64	.2031	2-7/16	3-5/8
* DLGP511014	7/32	.2188	2-1/2	3-3/4
* DLGP511015	15/64	.2344	2-5/8	3-7/8
* DLGP511016	1/4	.2500	2-3/4	4
* DLGP511017	17/64	.2656	2-7/8	4-1/8
* DLGP511018	9/32	.2813	2-15/16	4-1/4

EDP No.	Diameter Fractional D1	Diameter Decimal D1	Flute Length L1	Overall Length L2
* DLGP511019	19/64	.2969	3-1/16	4-3/8
* DLGP511020	5/16	.3125	3-3/16	4-1/2
** DLGP511021	21/64	.3281	3-5/16	4-5/8
** DLGP511022	11/32	.3438	3-7/16	4-3/4
** DLGP511023	23/64	.3594	3-1/2	4-7/8
** DLGP511024	3/8	.3750	3-5/8	5
** DLGP511025	25/64	.3906	3-3/4	5-1/8
** DLGP511026	13/32	.4063	3-7/8	5-1/4
** DLGP511027	27/64	.4219	3-15/16	5-3/8
** DLGP511028	7/16	.4375	4-1/16	5-1/2
** DLGP511029	29/64	.4531	4-3/16	5-5/8
** DLGP511030	15/32	.4688	4-5/16	5-3/4
** DLGP511031	31/64	.4844	4-3/8	5-7/8
** DLGP511032	1/2	.5000	4-1/2	6

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎					○	○				○

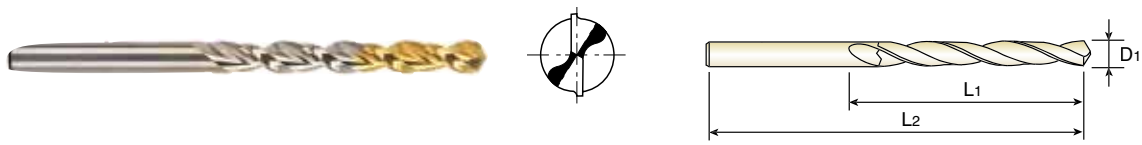
GOLD-P DRILLS

DLGP513 SERIES

HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE, GOLD-P COATED

JOBBER

- ▶ **Flute Geometry** : Right hand spiral, 38° helix, parabolic flute.
- ▶ **Point Angle** : 130° : Split point
- ▶ **Surface treatment** : Bright body TiN coating on working part
- ▶ **Application** : Improved chip removal in most materials, especially in deep drilling applications.



ANSI | HSS Co5 | N ≈ 38° | h8 | 130° P.183

▶ Letter sizes

Unit : Inch

EDP No.	Diameter Letter	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* DLGP513101	A	.2340	2-5/8	3-7/8
* DLGP513102	B	.2380	2-3/4	4
* DLGP513103	C	.2420	2-3/4	4
* DLGP513104	D	.2460	2-3/4	4
* DLGP513105	E	.2500	2-3/4	4
* DLGP513106	F	.2570	2-7/8	4-1/8
* DLGP513107	G	.2610	2-7/8	4-1/8
* DLGP513108	H	.2660	2-7/8	4-1/8
* DLGP513109	I	.2720	2-7/8	4-1/8
* DLGP513110	J	.2770	2-7/8	4-1/8
* DLGP513111	K	.2810	2-15/16	4-1/4
* DLGP513112	L	.2900	2-15/16	4-1/4
* DLGP513113	M	.2950	3-1/16	4-3/8
* DLGP513114	N	.3020	3-1/16	4-3/8
* DLGP513115	O	.3160	3-3/16	4-1/2
* DLGP513116	P	.3230	3-5/16	4-5/8
** DLGP513117	Q	.3320	3-7/16	4-3/4
** DLGP513118	R	.3390	3-7/16	4-3/4
** DLGP513119	S	.3480	3-1/2	4-7/8
** DLGP513120	T	.3580	3-1/2	4-7/8
** DLGP513121	U	.3680	3-5/8	5
** DLGP513122	V	.3770	3-5/8	5
** DLGP513123	W	.3860	3-3/4	5-1/8
** DLGP513124	X	.3970	3-3/4	5-1/8
** DLGP513125	Y	.4040	3-7/8	5-1/4
** DLGP513126	Z	.4130	3-7/8	5-1/4

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎						○	○				

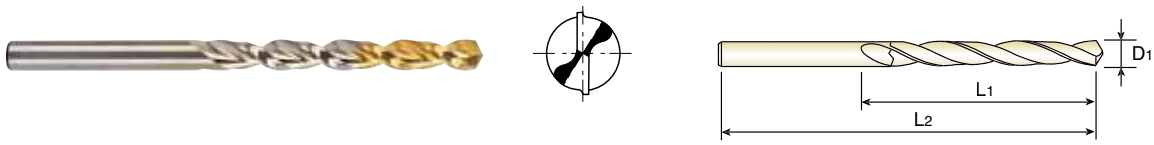
GOLD-P DRILLS

DLGP512 SERIES

HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE, GOLD-P COATED

JOBBER

- **Flute Geometry** : Right hand spiral, 38° helix, parabolic flute.
- **Point Angle** : 130° : Split point
- **Surface treatment** : Bright body TiN coating on working part
- **Application** : Improved chip removal in most materials, especially in deep drilling applications.



ANSI | HSS Co5 | N ≈ 38° | h8 | 130° | P.183

▶ Wire gauge sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* DLGP512247	1	.2280	2-5/8	3-7/8
* DLGP512246	2	.2210	2-5/8	3-7/8
* DLGP512245	3	.2130	2-1/2	3-3/4
* DLGP512244	4	.2090	2-1/2	3-3/4
* DLGP512243	5	.2055	2-1/2	3-3/4
* DLGP512242	6	.2040	2-1/2	3-3/4
* DLGP512241	7	.2010	2-7/16	3-5/8
* DLGP512240	8	.1990	2-7/16	3-5/8
* DLGP512239	9	.1960	2-7/16	3-5/8
* DLGP512238	10	.1935	2-7/16	3-5/8
* DLGP512237	11	.1910	2-5/16	3-1/2
* DLGP512236	12	.1890	2-5/16	3-1/2
* DLGP512235	13	.1850	2-5/16	3-1/2
* DLGP512234	14	.1820	2-3/16	3-3/8
* DLGP512233	15	.1800	2-3/16	3-3/8
* DLGP512232	16	.1770	2-3/16	3-3/8
* DLGP512231	17	.1730	2-3/16	3-3/8
* DLGP512230	18	.1695	2-1/8	3-1/4
* DLGP512229	19	.1660	2-1/8	3-1/4
* DLGP512228	20	.1610	2-1/8	3-1/4
* DLGP512227	21	.1590	2-1/8	3-1/4
* DLGP512226	22	.1570	2	3-1/8
* DLGP512225	23	.1540	2	3-1/8
* DLGP512224	24	.1520	2	3-1/8

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* DLGP512223	25	.1495	1-7/8	3
* DLGP512222	26	.1470	1-7/8	3
* DLGP512221	27	.1440	1-7/8	3
* DLGP512220	28	.1405	1-3/4	2-7/8
* DLGP512219	29	.1360	1-3/4	2-7/8
* DLGP512218	30	.1285	1-5/8	2-3/4
* DLGP512217	31	.1200	1-5/8	2-3/4
* DLGP512216	32	.1160	1-5/8	2-3/4
* DLGP512215	33	.1130	1-1/2	2-5/8
* DLGP512214	34	.1110	1-1/2	2-5/8
* DLGP512213	35	.1100	1-1/2	2-5/8
* DLGP512212	36	.1065	1-7/16	2-1/2
* DLGP512211	37	.1040	1-7/16	2-1/2
* DLGP512210	38	.1015	1-7/16	2-1/2
* DLGP512209	39	.0995	1-3/8	2-3/8
* DLGP512208	40	.0980	1-3/8	2-3/8
* DLGP512207	41	.0960	1-3/8	2-3/8
* DLGP512206	42	.0935	1-1/4	2-1/4
* DLGP512205	43	.0890	1-1/4	2-1/4
* DLGP512204	44	.0860	1-1/8	2-1/8
* DLGP512203	45	.0820	1-1/8	2-1/8
* DLGP512202	46	.0810	1-1/8	2-1/8
* DLGP512201	47	.0785	1	2

▶ **Tolerance** : See page 168

* 10per package

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎						○	○				

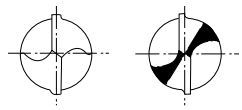
GOLD-P DRILLS

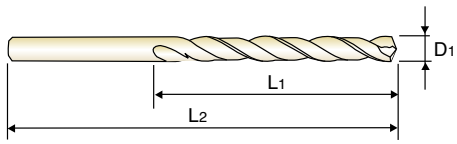
DLGP195 SERIES

HSSCo5, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

- ▶ **Flute Geometry** : Right hand helix
- ▶ **Point Angle** : 135˚
  under 1.6mm : Normal point
  1.6mm & over : Split point
- ▶ **Surface treatment** : Bright body, TiN coating on working area
- ▶ **Application** : Drilling to steels, cast steels alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





DIN 338 | HSS Co5 | N ≈33° | h8 | 135° P.182

Unit : mm

EDP No.	Diameter Metric D1	Diameter Inch D1	Flute Length L1	Overall Length L2
* DLGP195010	1.0	.0394	12	34
* DLGP195011	1.1	.0433	14	36
* DLGP195012	1.2	.0472	16	38
* DLGP195013	1.3	.0512	16	38
* DLGP195014	1.4	.0551	18	40
* DLGP195015	1.5	.0591	18	40
* DLGP195016	1.6	.0630	20	43
* DLGP195017	1.7	.0669	20	43
* DLGP195018	1.8	.0709	22	46
* DLGP195019	1.9	.0748	22	46
* DLGP195020	2.0	.0787	24	49
* DLGP195021	2.1	.0827	24	49
* DLGP195022	2.2	.0866	27	53
* DLGP195023	2.3	.0906	27	53
* DLGP195024	2.4	.0945	30	57
* DLGP195025	2.5	.0984	30	57
* DLGP195026	2.6	.1024	30	57
* DLGP195027	2.7	.1063	33	61
* DLGP195028	2.8	.1102	33	61
* DLGP195029	2.9	.1142	33	61
* DLGP195030	3.0	.1181	33	61
* DLGP195031	3.1	.1220	36	65
* DLGP195032	3.2	.1260	36	65
* DLGP195033	3.3	.1299	36	65
* DLGP195034	3.4	.1339	39	70
* DLGP195035	3.5	.1378	39	70
* DLGP195036	3.6	.1417	39	70
* DLGP195037	3.7	.1457	39	70
* DLGP195038	3.8	.1496	43	75
* DLGP195039	3.9	.1535	43	75
* DLGP195040	4.0	.1575	43	75
* DLGP195041	4.1	.1614	43	75

EDP No.	Diameter Metric D1	Diameter Inch D1	Flute Length L1	Overall Length L2
* DLGP195042	4.2	.1654	43	75
* DLGP195043	4.3	.1693	47	80
* DLGP195044	4.4	.1732	47	80
* DLGP195045	4.5	.1772	47	80
* DLGP195046	4.6	.1811	47	80
* DLGP195047	4.7	.1850	47	80
* DLGP195048	4.8	.1890	52	86
* DLGP195049	4.9	.1929	52	86
* DLGP195050	5.0	.1969	52	86
* DLGP195051	5.1	.2008	52	86
* DLGP195052	5.2	.2047	52	86
* DLGP195053	5.3	.2087	52	86
* DLGP195054	5.4	.2126	57	93
* DLGP195055	5.5	.2165	57	93
* DLGP195056	5.6	.2205	57	93
* DLGP195057	5.7	.2244	57	93
* DLGP195058	5.8	.2283	57	93
* DLGP195059	5.9	.2323	57	93
* DLGP195060	6.0	.2362	57	93
* DLGP195061	6.1	.2402	63	101
* DLGP195062	6.2	.2441	63	101
* DLGP195063	6.3	.2480	63	101
* DLGP195064	6.4	.2520	63	101
* DLGP195065	6.5	.2559	63	101
* DLGP195066	6.6	.2598	63	101
* DLGP195067	6.7	.2638	63	101
* DLGP195068	6.8	.2677	69	109
* DLGP195069	6.9	.2717	69	109
* DLGP195070	7.0	.2756	69	109
* DLGP195071	7.1	.2795	69	109
* DLGP195072	7.2	.2835	69	109
* DLGP195073	7.3	.2874	69	109

* 10per package

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

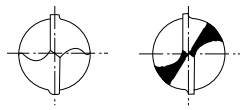
GOLD-P DRILLS

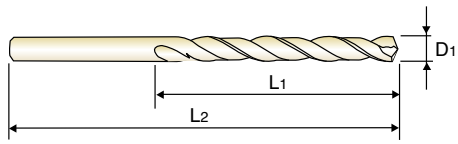
DLGP195 SERIES

HSSCo5, STRAIGHT SHANK DRILLS, GOLD-P COATED

JOBBER

- **Flute Geometry** : Right hand helix
- **Point Angle** : 135°
  under 1.6mm : Normal point
  1.6mm & over : Split point
- **Surface treatment** : Bright body, TiN coating on working area
- **Application** : Drilling to steels, cast steels alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





DIN 338 | HSS Co5 | N ≈33° | h8 | 135° P.182

Unit : mm

EDP No.	Diameter Metric D1	Diameter Inch D1	Flute Length L1	Overall Length L2
* DLGP195074	7.4	.2913	69	109
* DLGP195075	7.5	.2953	69	109
* DLGP195076	7.6	.2992	75	117
* DLGP195077	7.7	.3031	75	117
* DLGP195078	7.8	.3071	75	117
* DLGP195079	7.9	.3110	75	117
* DLGP195080	8.0	.3150	75	117
* DLGP195081	8.1	.3189	75	117
* DLGP195082	8.2	.3228	75	117
* DLGP195083	8.3	.3268	75	117
** DLGP195084	8.4	.3307	75	117
** DLGP195085	8.5	.3346	75	117
** DLGP195086	8.6	.3386	81	125
** DLGP195087	8.7	.3425	81	125
** DLGP195088	8.8	.3465	81	125
** DLGP195089	8.9	.3504	81	125
** DLGP195090	9.0	.3543	81	125
** DLGP195091	9.1	.3583	81	125
** DLGP195092	9.2	.3622	81	125
** DLGP195093	9.3	.3661	81	125
** DLGP195094	9.4	.3701	81	125
** DLGP195095	9.5	.3740	81	125
** DLGP195096	9.6	.3780	87	133
** DLGP195097	9.7	.3819	87	133
** DLGP195098	9.8	.3858	87	133
** DLGP195099	9.9	.3898	87	133
** DLGP195100	10.0	.3937	87	133
** DLGP195101	10.1	.3976	87	133
** DLGP195102	10.2	.4016	87	133

EDP No.	Diameter Metric D1	Diameter Inch D1	Flute Length L1	Overall Length L2
** DLGP195103	10.3	.4055	87	133
** DLGP195104	10.4	.4094	87	133
** DLGP195105	10.5	.4134	87	133
** DLGP195106	10.6	.4173	87	133
** DLGP195107	10.7	.4212	94	142
** DLGP195108	10.8	.4252	94	142
** DLGP195109	10.9	.4291	94	142
** DLGP195110	11.0	.4330	94	142
** DLGP195111	11.1	.4370	94	142
** DLGP195112	11.2	.4409	94	142
** DLGP195113	11.3	.4448	94	142
** DLGP195114	11.4	.4488	94	142
** DLGP195115	11.5	.4527	94	142
** DLGP195116	11.6	.4566	94	142
** DLGP195117	11.7	.4606	94	142
** DLGP195118	11.8	.4645	94	142
** DLGP195119	11.9	.4685	101	151
** DLGP195120	12.0	.4724	101	151
** DLGP195121	12.1	.4764	101	151
** DLGP195122	12.2	.4803	101	151
** DLGP195123	12.3	.4843	101	151
** DLGP195124	12.4	.4882	101	151
** DLGP195125	12.5	.4921	101	151
** DLGP195126	12.6	.4921	101	151
** DLGP195127	12.7	.5000	101	151
** DLGP195128	12.8	.5039	101	151
** DLGP195129	12.9	.5079	101	151
** DLGP195130	13.0	.5118	101	151

* 10per package
** 5per package

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

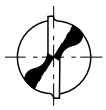
GOLD-P DRILLS

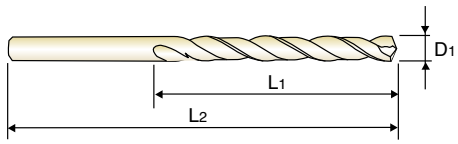
DLGP506 SERIES

HSSCo5, DH100 STRAIGHT SHANK DRILLS for DEEP HOLES, GOLD-P COATED

JOBBER

- ▶ **Flute Geometry** : Right hand, 38° helix, Parabolic flutes
- ▶ **Point Angle** : 130°, Split point giving higher chip removal.
- ▶ **Surface treatment** : Bright body, TiN coating on working area.
- ▶ **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, Special aluminum or magnesium alloys.





DIN 338 | HSS Co5 | N ≈ 38° | h8 | 130° | P.183

Unit : mm

EDP No.	Diameter Metric D1	Diameter Inch D1	Flute Length L1	Overall Length L2
* DLGP506020	2.0	.0787	24	49
* DLGP506021	2.1	.0827	24	49
* DLGP506022	2.2	.0866	27	53
* DLGP506023	2.3	.0906	27	53
* DLGP506024	2.4	.0945	30	57
* DLGP506025	2.5	.0984	30	57
* DLGP506026	2.6	.1024	30	57
* DLGP506027	2.7	.1063	33	61
* DLGP506028	2.8	.1102	33	61
* DLGP506029	2.9	.1142	33	61
* DLGP506030	3.0	.1181	33	61
* DLGP506031	3.1	.1220	36	65
* DLGP506032	3.2	.1260	36	65
* DLGP506033	3.3	.1299	36	65
* DLGP506034	3.4	.1339	39	70
* DLGP506035	3.5	.1378	39	70
* DLGP506036	3.6	.1417	39	70
* DLGP506037	3.7	.1457	39	70
* DLGP506038	3.8	.1496	43	75
* DLGP506039	3.9	.1535	43	75
* DLGP506040	4.0	.1575	43	75
* DLGP506041	4.1	.1614	43	75
* DLGP506042	4.2	.1654	43	75
* DLGP506043	4.3	.1693	47	80
* DLGP506044	4.4	.1732	47	80
* DLGP506045	4.5	.1772	47	80
* DLGP506046	4.6	.1811	47	80
* DLGP506047	4.7	.1850	47	80

EDP No.	Diameter Metric D1	Diameter Inch D1	Flute Length L1	Overall Length L2
* DLGP506048	4.8	.1890	52	86
* DLGP506049	4.9	.1929	52	86
* DLGP506050	5.0	.1969	52	86
* DLGP506051	5.1	.2008	52	86
* DLGP506052	5.2	.2047	52	86
* DLGP506053	5.3	.2087	52	86
* DLGP506054	5.4	.2126	57	93
* DLGP506055	5.5	.2165	57	93
* DLGP506056	5.6	.2205	57	93
* DLGP506057	5.7	.2244	57	93
* DLGP506058	5.8	.2283	57	93
* DLGP506059	5.9	.2323	57	93
* DLGP506060	6.0	.2362	57	93
* DLGP506061	6.1	.2402	63	101
* DLGP506062	6.2	.2441	63	101
* DLGP506063	6.3	.2480	63	101
* DLGP506064	6.4	.2520	63	101
* DLGP506065	6.5	.2559	63	101
* DLGP506066	6.6	.2598	63	101
* DLGP506067	6.7	.2638	63	101
* DLGP506068	6.8	.2677	69	109
* DLGP506069	6.9	.2717	69	109
* DLGP506070	7.0	.2756	69	109
* DLGP506071	7.1	.2795	69	109
* DLGP506072	7.2	.2835	69	109
* DLGP506073	7.3	.2874	69	109
* DLGP506074	7.4	.2913	69	109
* DLGP506075	7.5	.2953	69	109

* 10per package

▶ NEXT PAGE

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎						○	○				

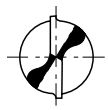
GOLD-P DRILLS

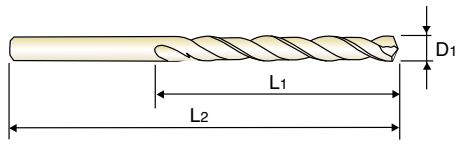
DLGP506 SERIES

HSSCo5, DH100 STRAIGHT SHANK DRILLS for DEEP HOLES, GOLD-P COATED

JOBBER

- ▶ **Flute Geometry** : Right hand, 38° helix, Parabolic flutes
- ▶ **Point Angle** : 130°, Split point giving higher chip removal.
- ▶ **Surface treatment** : Bright body, TiN coating on working area.
- ▶ **Application** : Drilling deep holes in non alloy steels, alloy steels, grey cast iron, malleable cast iron, Special aluminum or magnesium alloys.





DIN 338 | HSS Co5 | N ≈ 38° | h8 | 130° P.183

Unit : mm

EDP No.	Diameter Metric D1	Diameter Inch D1	Flute Length L1	Overall Length L2
* DLGP506076	7.6	.2992	75	117
* DLGP506077	7.7	.3031	75	117
* DLGP506078	7.8	.3071	75	117
* DLGP506079	7.9	.3110	75	117
* DLGP506080	8.0	.3150	75	117
* DLGP506081	8.1	.3189	75	117
* DLGP506082	8.2	.3228	75	117
* DLGP506083	8.3	.3268	75	117
** DLGP506084	8.4	.3307	75	117
** DLGP506085	8.5	.3346	75	117
** DLGP506086	8.6	.3386	81	125
** DLGP506087	8.7	.3425	81	125
** DLGP506088	8.8	.3465	81	125
** DLGP506089	8.9	.3504	81	125
** DLGP506090	9.0	.3543	81	125
** DLGP506091	9.1	.3583	81	125
** DLGP506092	9.2	.3622	81	125
** DLGP506093	9.3	.3661	81	125
** DLGP506094	9.4	.3701	81	125
** DLGP506095	9.5	.3740	81	125
** DLGP506096	9.6	.3780	87	133
** DLGP506097	9.7	.3819	87	133
** DLGP506098	9.8	.3858	87	133
** DLGP506099	9.9	.3898	87	133
** DLGP506100	10.0	.3937	87	133
** DLGP506101	10.1	.3976	87	133
** DLGP506102	10.2	.4016	87	133
** DLGP506103	10.3	.4055	87	133

EDP No.	Diameter Metric D1	Diameter Inch D1	Flute Length L1	Overall Length L2
** DLGP506104	10.4	.4094	87	133
** DLGP506105	10.5	.4134	87	133
** DLGP506106	10.6	.4173	87	133
** DLGP506107	10.7	.4212	94	142
** DLGP506108	10.8	.4252	94	142
** DLGP506109	10.9	.4291	94	142
** DLGP506110	11.0	.4330	94	142
** DLGP506111	11.1	.4370	94	142
** DLGP506112	11.2	.4409	94	142
** DLGP506113	11.3	.4448	94	142
** DLGP506114	11.4	.4488	94	142
** DLGP506115	11.5	.4527	94	142
** DLGP506116	11.6	.4566	94	142
** DLGP506117	11.7	.4606	94	142
** DLGP506118	11.8	.4645	94	142
** DLGP506119	11.9	.4685	101	151
** DLGP506120	12.0	.4724	101	151
** DLGP506121	12.1	.4764	101	151
** DLGP506122	12.2	.4803	101	151
** DLGP506123	12.3	.4843	101	151
** DLGP506124	12.4	.4882	101	151
** DLGP506125	12.5	.4921	101	151
** DLGP506126	12.6	.4921	101	151
** DLGP506127	12.7	.5000	101	151
** DLGP506128	12.8	.5039	101	151
** DLGP506129	12.9	.5079	101	151
** DLGP506130	13.0	.5118	101	151

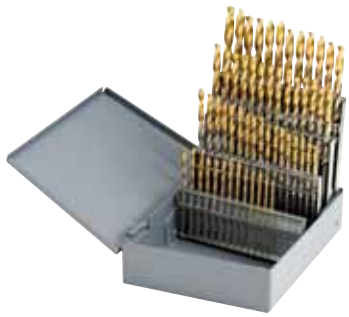
* 10per package
** 5per package

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎						○	○				

GOLD-P DRILLS

GOLD-P COATED DRILL SETS



EDP No.	Series No.	Description	SIZE	Q'TY
D1GP138 SET	D1GP SET924	HSS Straight Shank, Split Point (#53 ~ #56 : NORMAL point)	#1~#56(Wire gauge)	56 pcs
D1GP139 SET	D1GP SET925	HSS Straight Shank, Split Point	A~Z(Letter)	26 pcs
D1GP182 SET	D1GP SET926	HSS Straight Shank, Split Point	Ø1/16~Ø1/2(Fractional)	29 pcs
D2GP185 SET	D2GP SET927	HSSCo8 Straight Shank, Split Point	Ø1/16~Ø1/2(Fractional)	29 pcs
D2GP186 SET	D2GP SET928	HSSCo8 Straight Shank, Split Point	A~Z(Letter)	26 pcs
D2GP187 SET	D2GP SET930	HSSCo8 Straight Shank, Split Point (#53 ~ #56 : NORMAL point)	#1~#56(Wire gauge)	56 pcs
DLGP511 SET	DLGP SET931	HSSCo5 Straight Shank, Split Point	Ø5/64~Ø1/2(Fractional)	28 pcs
DLGP512 SET	DLGP SET932	HSSCo5 Straight Shank, Split Point	#1~#47(Wire gauge)	47 pcs
DLGP513 SET	DLGP SET933	HSSCo5 Straight Shank, Split Point	A~Z(Letter)	26 pcs

HSS & HSSCo5, STRAIGHT SHANK, GOLD-P COATED

D1GP182, D1GP139, D1GP138, D2GP185, D2GP186, D2GP187, DLGP195, SERIES

WORK MATERIAL			P						M	
			CARBON STEELS		CARBON STEELS		ALLOY STEELS		STAINLESS STEELS	
HARDNESS					~ HRc23		HRc23 ~ 34		~ HRc23	
STRENGTH			~ 570N/mm²		~ 830N/mm²		830~1110N/mm²		~ 830N/mm²	
DIAMETER			N	S	N	S	N	S	N	S
Fractional	Decimal	Metric								
3/64	.0469	1.0	14000	.0008	12500	.0008	7700	.0008	7000	.0008
#47	.0785	2.0	7000	.0023	6100	.0024	3850	.0024	3500	.0024
#32	.1160	3.0	4650	.0038	4100	.0031	2550	.0031	2350	.0031
#22	.1570	4.0	3500	.0044	3050	.0043	1950	.0039	1750	.0039
#9	.1960	5.0	2800	.0049	2450	.0043	1550	.0039	1400	.0039
B	.2380	6.0	2350	.0056	2050	.0051	1300	.0047	1150	.0047
J	.2770	7.0	2000	.0064	1750	.0059	1100	.0055	1000	.0055
O	.3160	8.0	1750	.0072	1550	.0071	960	.0059	875	.0059
T	.3580	9.0	1550	.0077	1350	.0087	855	.0071	780	.0071
X	.3970	10.0	1400	.0084	1250	.0087	770	.0071	700	.0071
7/16	.4375	11.0	1250	.0087	1100	.0087	700	.0071	650	.0071
15/32	.4688	12.0	1150	.0090	1000	.0087	650	.0079	585	.0079
1/2	.5000	13.0	1050	.0090	950	.0087	595	.0079	540	.0079

WORK MATERIAL			N				S	
			ALUMINUM ALLOYS, ZINC ALLOYS		MAGNESIUM ALLOYS		TITANIUM ALLOYS	
HARDNESS								
STRENGTH							~410N/mm²	
DIAMETER			N	S	N	S	N	S
Fractional	Decimal	Metric						
3/64	.0469	1.0	30000	.0008	11500	.0012	8050	.0008
#47	.0785	2.0	15000	.0023	5800	.0035	4050	.0024
#32	.1160	3.0	9900	.0038	3850	.0051	2700	.0031
#22	.1570	4.0	7450	.0044	2900	.0059	2000	.0035
#9	.1960	5.0	5950	.0049	2300	.0067	1600	.0039
B	.2380	6.0	14950	.0056	1950	.0075	1350	.0047
J	.2770	7.0	4250	.0064	1650	.0087	1150	.0055
O	.3160	8.0	3700	.0072	1450	.0094	1000	.0059
T	.3580	9.0	3300	.0079	1280	.0106	895	.0067
X	.3970	10.0	3000	.0090	1150	.0114	805	.0071
7/16	.4375	11.0	2700	.0090	1050	.0118	730	.0071
15/32	.4688	12.0	2480	.0090	960	.0122	670	.0079
1/2	.5000	13.0	2300	.0090	890	.0122	620	.0079

N = R.P.M
S = Inch per Revolution (inch/rev.)

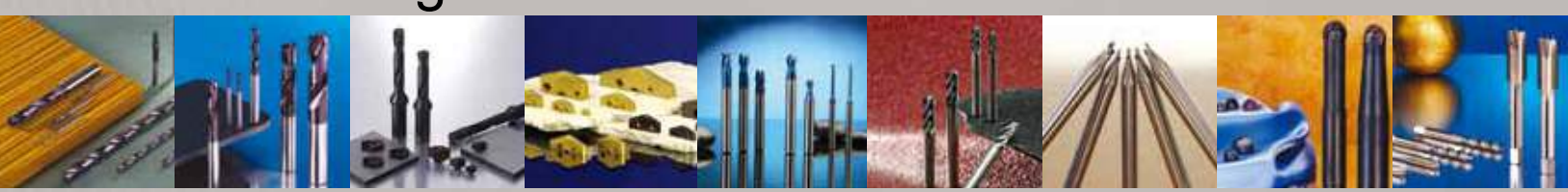
HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE, GOLD-P COATED

DLGP511, DLGP513, DLGP512, DLGP506 SERIES

WORK MATERIAL			P				K			
			CARBON STEELS ALLOY STEELS		TOOL STEELS HARDENED STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
HARDNESS			HRc15 ~ 30		HRc20 ~ 40					
STRENGTH			700 ~ 1000N/mm^2		800~1200N/mm^2					
DIAMETER			N	S	N	S	N	S	N	S
Fractional	Decimal	Metric								
3/64	.0469	1.0	8750	.0008	6300	.0008	16000	.0008	9800	.0008
#47	.0785	2.0	4400	.0022	3150	.0022	7900	.0027	4900	.0027
#32	.1160	3.0	2900	.0032	2100	.0032	5250	.0043	3250	.0043
#22	.1570	4.0	2200	.0036	1600	.0036	3950	.0054	2450	.0054
#9	.1960	5.0	1750	.0041	1250	.0041	3150	.0054	1950	.0054
B	.2380	6.0	1450	.0047	1050	.0047	2650	.0069	1650	.0069
J	.2770	7.0	1250	.0054	900	.0054	2250	.0078	1400	.0078
O	.3160	8.0	1100	.0060	790	.0060	1950	.0087	1250	.0087
T	.3580	9.0	975	.0066	700	.0066	1750	.0095	1100	.0095
X	.3970	10.0	875	.0071	630	.0071	1600	.0108	980	.0108
7/16	.4375	11.0	800	.0077	575	.0077	1450	.0108	890	.0108
15/32	.4688	12.0	730	.0077	525	.0077	1300	.0108	815	.0108
1/2	.5000	13.0	675	.0077	485	.0077	1200	.0108	755	.0108

N = R.P.M
S = Inch per Revolution (inch/rev.)

Global Cutting Tool Leader **YG-1**



HSS

Being the best through innovation

STRAIGHT SHANK DRILLS

- General Purpose

STRAIGHT SHANK TWIST DRILLS

HSS Drills for soft materials & HSS cobalt Drills for tough materials

◎ : Excellent ○ : Good

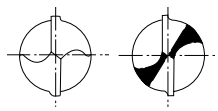
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○				○
◎	◎				○	○	○				○
◎	◎				○	○	○				○
◎	◎				○		○				○
◎	◎				○		○				○
◎	◎				○		○				○
◎	◎					○	○				
◎	◎					○	○				
◎	◎					○	○				
◎	◎					○	○				
◎	◎				○	○	○				○

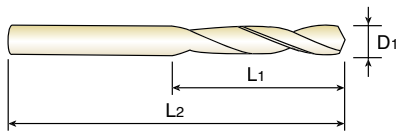
STRAIGHT SHANK DRILLS

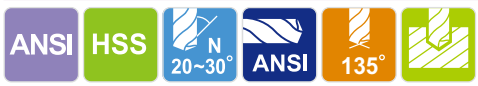
D1118 SERIES

HSS, STRAIGHT SHANK SCREW MACHINE

▶ **Flute Geometry** : Right hand spiral, wider flutes
▶ **Point Angle** : 135˚
under 1/16 : Normal point
1/16 & over : Split point
▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron







P.202

▶ Fractional sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal		
	D1		L1	L2
* D1118003	3/64	.0469	1/2	1-3/8
* D1118004	1/16	.0625	5/8	1-5/8
* D1118005	5/64	.0781	11/16	1-11/16
* D1118006	3/32	.0938	3/4	1-3/4
* D1118007	7/64	.1094	13/16	1-13/16
* D1118008	1/8	.1250	7/8	1-7/8
* D1118009	9/64	.1406	15/16	1-15/16
* D1118010	5/32	.1563	1	2-1/16
* D1118011	11/64	.1719	1-1/16	2-1/8
* D1118012	3/16	.1875	1-1/8	2-3/16
* D1118013	13/64	.2031	1-3/16	2-1/4
* D1118014	7/32	.2188	1-1/4	2-3/8
* D1118015	15/64	.2344	1-5/16	2-7/16
* D1118016	1/4	.2500	1-3/8	2-1/2
* D1118017	17/64	.2656	1-7/16	2-5/8

EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal		
	D1		L1	L2
* D1118018	9/32	.2813	1-1/2	2-11/16
* D1118019	19/64	.2969	1-9/16	2-3/4
* D1118020	5/16	.3125	1-5/8	2-13/16
* D1118021	21/64	.3281	1-11/16	2-15/16
** D1118022	11/32	.3438	1-11/16	3
** D1118023	23/64	.3594	1-3/4	3-1/16
** D1118024	3/8	.3750	1-13/16	3-1/8
** D1118025	25/64	.3906	1-7/8	3-1/4
** D1118026	13/32	.4063	1-15/16	3-5/16
** D1118027	27/64	.4219	2	3-3/8
** D1118028	7/16	.4375	2-1/16	3-7/16
** D1118029	29/64	.4531	2-1/8	3-9/16
** D1118030	15/32	.4688	2-1/8	3-5/8
** D1118031	31/64	.4844	2-3/16	3-11/16
** D1118032	1/2	.5000	2-1/4	3-3/4

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

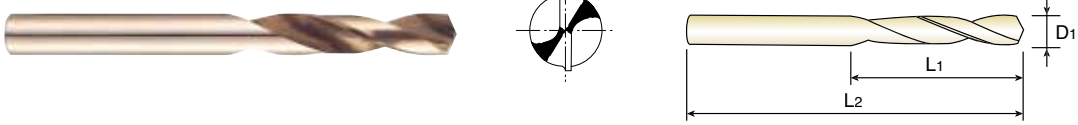
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○				○

STRAIGHT SHANK DRILLS

D1115 SERIES

HSS, STRAIGHT SHANK SCREW MACHINE

▶ **Flute Geometry** : Right hand spiral, wider flutes
▶ **Point Angle** : 135° : Split point
▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron



ANSI | HSS | N 20~30° | ANSI | 135° P.202

▶ Letter sizes

Unit : Inch

EDP No.	Diameter Letter	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* D1115201	A	.2340	1-5/16	2-7/16
* D1115202	B	.2380	1-3/8	2-1/2
* D1115203	C	.2420	1-3/8	2-1/2
* D1115204	D	.2460	1-3/8	2-1/2
* D1115205	E	.2500	1-3/8	2-1/2
* D1115206	F	.2570	1-7/16	2-5/8
* D1115207	G	.2610	1-7/16	2-5/8
* D1115208	H	.2660	1-1/2	2-11/16
* D1115209	I	.2720	1-1/2	2-11/16
* D1115210	J	.2770	1-1/2	2-11/16
* D1115211	K	.2810	1-1/2	2-11/16
* D1115212	L	.2900	1-9/16	2-3/4
* D1115213	M	.2950	1-9/16	2-3/4
* D1115214	N	.3020	1-5/8	2-13/16
* D1115215	O	.3160	1-11/16	2-15/16
* D1115216	P	.3230	1-11/16	2-15/16
** D1115217	Q	.3320	1-11/16	3
** D1115218	R	.3390	1-11/16	3
** D1115219	S	.3480	1-3/4	3-1/16
** D1115220	T	.3580	1-3/4	3-1/16
** D1115221	U	.3680	1-13/16	3-1/8
** D1115222	V	.3770	1-7/8	3-1/4
** D1115223	W	.3860	1-7/8	3-1/4
** D1115224	X	.3970	1-15/16	3-5/16
** D1115225	Y	.4040	1-15/16	3-5/16
** D1115226	Z	.4130	2	3-3/8

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

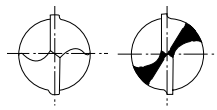
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○				○

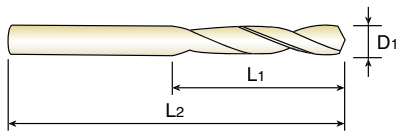
STRAIGHT SHANK DRILLS

D1119 SERIES

HSS, STRAIGHT SHANK SCREW MACHINE

▶ **Flute Geometry** : Right hand spiral, wider flutes
▶ **Point Angle** : 135° : Split point
Wire gauge size #53~#60 : Normal point
Wire gauge size #1~#52 : Split point
▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI HSS N 20~30° ANSI 135° P.202

▶ Wire gauge sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal		
	D1		L1	L2
* D1119201	1	.2280	1-5/16	2-7/16
* D1119202	2	.2210	1-5/16	2-7/16
* D1119203	3	.2130	1-1/4	2-3/8
* D1119204	4	.2090	1-1/4	2-3/8
* D1119205	5	.2055	1-1/4	2-3/8
* D1119206	6	.2040	1-1/4	2-3/8
* D1119207	7	.2010	1-3/16	2-1/4
* D1119208	8	.1990	1-3/16	2-1/4
* D1119209	9	.1960	1-3/16	2-1/4
* D1119210	10	.1935	1-3/16	2-1/4
* D1119211	11	.1910	1-3/16	2-1/4
* D1119212	12	.1890	1-3/16	2-1/4
* D1119213	13	.1850	1-1/8	2-3/16
* D1119214	14	.1820	1-1/8	2-3/16
* D1119215	15	.1800	1-1/8	2-3/16
* D1119216	16	.1770	1-1/8	2-3/16
* D1119217	17	.1730	1-1/8	2-3/16
* D1119218	18	.1695	1-1/16	2-1/8
* D1119219	19	.1660	1-1/16	2-1/8
* D1119220	20	.1610	1-1/16	2-1/8
* D1119221	21	.1590	1-1/16	2-1/8
* D1119222	22	.1570	1-1/16	2-1/8
* D1119223	23	.1540	1	2-1/16
* D1119224	24	.1520	1	2-1/16
* D1119225	25	.1495	1	2-1/16
* D1119226	26	.1470	1	2-1/16
* D1119227	27	.1440	1	2-1/16
* D1119228	28	.1405	15/16	1-15/16
* D1119229	29	.1360	15/16	1-15/16
* D1119230	30	.1285	15/16	1-15/16

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal		
	D1		L1	L2
* D1119231	31	.1200	7/8	1-7/8
* D1119232	32	.1160	7/8	1-7/8
* D1119233	33	.1130	7/8	1-7/8
* D1119234	34	.1110	7/8	1-7/8
* D1119235	35	.1100	7/8	1-7/8
* D1119236	36	.1065	13/16	1-13/16
* D1119237	37	.1040	13/16	1-13/16
* D1119238	38	.1015	13/16	1-13/16
* D1119239	39	.0995	13/16	1-13/16
* D1119240	40	.0980	13/16	1-13/16
* D1119241	41	.0960	13/16	1-13/16
* D1119242	42	.0935	3/4	1-3/4
* D1119243	43	.0890	3/4	1-3/4
* D1119244	44	.0860	3/4	1-3/4
* D1119245	45	.0820	3/4	1-3/4
* D1119246	46	.0810	3/4	1-3/4
* D1119247	47	.0785	11/16	1-11/16
* D1119248	48	.0760	11/16	1-11/16
* D1119249	49	.0730	11/16	1-11/16
* D1119250	50	.0700	11/16	1-11/16
* D1119251	51	.0670	11/16	1-11/16
* D1119252	52	.0635	11/16	1-11/16
* D1119253	53	.0595	5/8	1-5/8
* D1119254	54	.0550	5/8	1-5/8
* D1119255	55	.0520	5/8	1-5/8
* D1119256	56	.0465	1/2	1-3/8
* D1119257	57	.0430	1/2	1-3/8
* D1119258	58	.0420	1/2	1-3/8
* D1119259	59	.0410	1/2	1-3/8
* D1119260	60	.0400	1/2	1-3/8

▶ **Tolerance** : See page 188 / * 10per package

◎ : Excellent ○ : Good

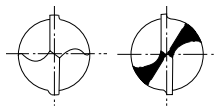
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○				○

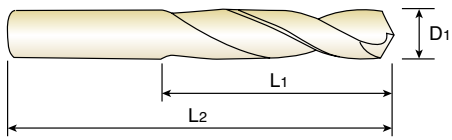
STRAIGHT SHANK DRILLS

D2146 SERIES UN-COATED
D4146 SERIES TiN-COATED

HSSCo8, STRAIGHT SHANK SCREW MACHINE

▶ **Flute Geometry** : Right hand spiral, wider flutes
▶ **Point Angle** : 135°
under 1/16 : Normal point
1/16 & over : Split point
▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI | HSS Co8 | N 20~30° | ANSI | 135° P.202

▶ Fractional sizes

Unit : Inch

EDP No.		Diameter		Flute Length	Overall Length
		Fractional	Decimal		
UN-COATED	TiN-COATED	D1		L1	L2
* D2146003	D4146003	3/64	.0469	1/2	1-3/8
* D2146004	D4146004	1/16	.0625	5/8	1-5/8
* D2146005	D4146005	5/64	.0781	11/16	1-11/16
* D2146006	D4146006	3/32	.0938	3/4	1-3/4
** D2146007	D4146007	7/64	.1094	13/16	1-13/16
** D2146008	D4146008	1/8	.1250	7/8	1-7/8
** D2146009	D4146009	9/64	.1406	15/16	1-15/16
** D2146010	D4146010	5/32	.1563	1	2-1/16
** D2146011	D4146011	11/64	.1719	1-1/16	2-1/8
** D2146012	D4146012	3/16	.1875	1-1/8	2-3/16
** D2146013	D4146013	13/64	.2031	1-3/16	2-1/4
** D2146014	D4146014	7/32	.2188	1-1/4	2-3/8
** D2146015	D4146015	15/64	.2344	1-5/16	2-7/16
** D2146016	D4146016	1/4	.2500	1-3/8	2-1/2
** D2146017	D4146017	17/64	.2656	1-7/16	2-5/8
** D2146018	D4146018	9/32	.2813	1-1/2	2-11/16
** D2146019	D4146019	19/64	.2969	1-9/16	2-3/4
** D2146020	D4146020	5/16	.3125	1-5/8	2-13/16
** D2146021	D4146021	21/64	.3281	1-11/16	2-15/16
** D2146022	D4146022	11/32	.3438	1-11/16	3
** D2146023	D4146023	23/64	.3594	1-3/4	3-1/16
** D2146024	D4146024	3/8	.3750	1-13/16	3-1/8
** D2146025	D4146025	25/64	.3906	1-7/8	3-1/4
** D2146026	D4146026	13/32	.4063	1-15/16	3-5/16
** D2146027	D4146027	27/64	.4219	2	3-3/8
** D2146028	D4146028	7/16	.4375	2-1/16	3-7/16
** D2146029	D4146029	29/64	.4531	2-1/8	3-9/16
** D2146030	D4146030	15/32	.4688	2-1/8	3-5/8
** D2146031	D4146031	31/64	.4844	2-3/16	3-11/16
** D2146032	D4146032	1/2	.5000	2-1/4	3-3/4

▶ **Tolerance** : See page 188 / * 10per package ** 5per package

◎ : Excellent ○ : Good

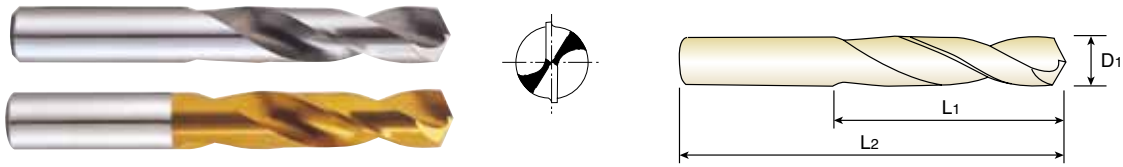
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○				○

STRAIGHT SHANK DRILLS

D2147 SERIES UN-COATED
D4147 SERIES TiN-COATED

HSSCo8, STRAIGHT SHANK SCREW MACHINE

▶ **Flute Geometry** : Right hand spiral, wider flutes
▶ **Point Angle** : 135° : Split point
▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron



ANSI | HSS Co8 | N 20~30° | ANSI | 135° P.202

▶ Letter sizes

Unit : Inch

EDP No.		Diameter		Flute Length	Overall Length
		Letter	Decimal		
UN-COATED	TiN-COATED	D1		L1	L2
** D2147201	D4147201	A	.2340	1-5/16	2-7/16
** D2147202	D4147202	B	.2380	1-3/8	2-1/2
** D2147203	D4147203	C	.2420	1-3/8	2-1/2
** D2147204	D4147204	D	.2460	1-3/8	2-1/2
** D2147205	D4147205	E	.2500	1-3/8	2-1/2
** D2147206	D4147206	F	.2570	1-7/16	2-5/8
** D2147207	D4147207	G	.2610	1-7/16	2-5/8
** D2147208	D4147208	H	.2660	1-1/2	2-11/16
** D2147209	D4147209	I	.2720	1-1/2	2-11/16
** D2147210	D4147210	J	.2770	1-1/2	2-11/16
** D2147211	D4147211	K	.2810	1-1/2	2-11/16
** D2147212	D4147212	L	.2900	1-9/16	2-3/4
** D2147213	D4147213	M	.2950	1-9/16	2-3/4
** D2147214	D4147214	N	.3020	1-5/8	2-13/16
** D2147215	D4147215	O	.3160	1-11/16	2-15/16
** D2147216	D4147216	P	.3230	1-11/16	2-15/16
** D2147217	D4147217	Q	.3320	1-11/16	3
** D2147218	D4147218	R	.3390	1-11/16	3
** D2147219	D4147219	S	.3480	1-3/4	3-1/16
** D2147220	D4147220	T	.3580	1-3/4	3-1/16
** D2147221	D4147221	U	.3680	1-13/16	3-1/8
** D2147222	D4147222	V	.3770	1-7/8	3-1/4
** D2147223	D4147223	W	.3860	1-7/8	3-1/4
** D2147224	D4147224	X	.3970	1-15/16	3-5/16
** D2147225	D4147225	Y	.4040	1-15/16	3-5/16
** D2147226	D4147226	Z	.4130	2	3-3/8

▶ **Tolerance** : See page 188 / ** 5per package

◎ : Excellent ○ : Good

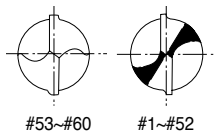
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

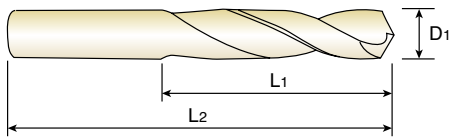
STRAIGHT SHANK DRILLS

D2148 SERIES UN-COATED
D4148 SERIES TiN-COATED

HSSCo8, STRAIGHT SHANK SCREW MACHINE

▶ **Flute Geometry** : Right hand spiral, wider flutes
▶ **Point Angle** : 135° : Split point
Wire gauge size #53~#60 : Normal point
Wire gauge size #1~#52 : Split point
▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI | HSS Co8 | N 20~30° | ANSI | 135° P.202

▶ Wire gauge sizes

Unit : Inch

EDP No.		Diameter		Flute Length	Overall Length
		Wire gauge	Decimal		
UN-COATED	TiN-COATED	D1		L1	L2
** D2148101	D4148101	1	.2280	1-5/16	2-7/16
** D2148102	D4148102	2	.2210	1-5/16	2-7/16
** D2148103	D4148103	3	.2130	1-1/4	2-3/8
** D2148104	D4148104	4	.2090	1-1/4	2-3/8
** D2148105	D4148105	5	.2055	1-1/4	2-3/8
** D2148106	D4148106	6	.2040	1-1/4	2-3/8
** D2148107	D4148107	7	.2010	1-3/16	2-1/4
** D2148108	D4148108	8	.1990	1-3/16	2-1/4
** D2148109	D4148109	9	.1960	1-3/16	2-1/4
** D2148110	D4148110	10	.1935	1-3/16	2-1/4
** D2148111	D4148111	11	.1910	1-3/16	2-1/4
** D2148112	D4148112	12	.1890	1-3/16	2-1/4
** D2148113	D4148113	13	.1850	1-1/8	2-3/16
** D2148114	D4148114	14	.1820	1-1/8	2-3/16
** D2148115	D4148115	15	.1800	1-1/8	2-3/16
** D2148116	D4148116	16	.1770	1-1/8	2-3/16
** D2148117	D4148117	17	.1730	1-1/8	2-3/16
** D2148118	D4148118	18	.1695	1-1/16	2-1/8
** D2148119	D4148119	19	.1660	1-1/16	2-1/8
** D2148120	D4148120	20	.1610	1-1/16	2-1/8
** D2148121	D4148121	21	.1590	1-1/16	2-1/8
** D2148122	D4148122	22	.1570	1-1/16	2-1/8
** D2148123	D4148123	23	.1540	1	2-1/16
** D2148124	D4148124	24	.1520	1	2-1/16
** D2148125	D4148125	25	.1495	1	2-1/16
** D2148126	D4148126	26	.1470	1	2-1/16
** D2148127	D4148127	27	.1440	1	2-1/16
** D2148128	D4148128	28	.1405	15/16	1-15/16
** D2148129	D4148129	29	.1360	15/16	1-15/16
** D2148130	D4148130	30	.1285	15/16	1-15/16

▶ **Tolerance** : See page 188 / ** 5per package

◎ : Excellent ○ : Good

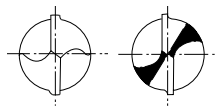
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

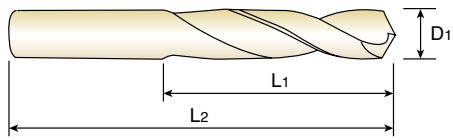
STRAIGHT SHANK DRILLS

D2148 SERIES UN-COATED
D4148 SERIES TiN-COATED

HSSCo8, STRAIGHT SHANK SCREW MACHINE

▶ **Flute Geometry** : Right hand spiral, wider flutes
▶ **Point Angle** : 135° : Split point
Wire gauge size #53~#60 : Normal point
Wire gauge size #1~#52 : Split point
▶ **Application** : Drilling in steel, cast steel alloyed and Non-alloyed, grey cast iron, graphite, malleable cast iron





ANSI | HSS Co8 | N 20~30° | ANSI | 135° | P.202

▶ Wire gauge sizes

Unit : Inch

EDP No.		Diameter		Flute Length	Overall Length
		Wire gauge	Decimal		
UN-COATED	TiN-COATED	D1		L1	L2
** D2148131	D4148131	31	.1200	7/8	1-7/8
** D2148132	D4148132	32	.1160	7/8	1-7/8
** D2148133	D4148133	33	.1130	7/8	1-7/8
** D2148134	D4148134	34	.1110	7/8	1-7/8
** D2148135	D4148135	35	.1100	7/8	1-7/8
** D2148136	D4148136	36	.1065	13/16	1-13/16
* D2148137	D4148137	37	.1040	13/16	1-13/16
* D2148138	D4148138	38	.1015	13/16	1-13/16
* D2148139	D4148139	39	.0995	13/16	1-13/16
* D2148140	D4148140	40	.0980	13/16	1-13/16
* D2148141	D4148141	41	.0960	13/16	1-13/16
* D2148142	D4148142	42	.0935	3/4	1-3/4
* D2148143	D4148143	43	.0890	3/4	1-3/4
* D2148144	D4148144	44	.0860	3/4	1-3/4
* D2148145	D4148145	45	.0820	3/4	1-3/4
* D2148146	D4148146	46	.0810	3/4	1-3/4
* D2148147	D4148147	47	.0785	11/16	1-11/16
* D2148148	D4148148	48	.0760	11/16	1-11/16
* D2148149	D4148149	49	.0730	11/16	1-11/16
* D2148150	D4148150	50	.0700	11/16	1-11/16
* D2148151	D4148151	51	.0670	11/16	1-11/16
* D2148152	D4148152	52	.0635	11/16	1-11/16
* D2148153	D4148153	53	.0595	5/8	1-5/8
* D2148154	D4148154	54	.0550	5/8	1-5/8
* D2148155	D4148155	55	.0520	5/8	1-5/8
* D2148156	D4148156	56	.0465	1/2	1-3/8
* D2148157	D4148157	57	.0430	1/2	1-3/8
* D2148158	D4148158	58	.0420	1/2	1-3/8
* D2148159	D4148159	59	.0410	1/2	1-3/8
* D2148160	D4148160	60	.0400	1/2	1-3/8

▶ **Tolerance** : See page 188 / * 10per package ** 5per package

◎ : Excellent ○ : Good

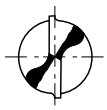
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○		○				○

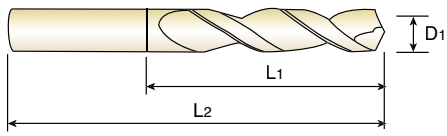
STRAIGHT SHANK DRILLS

DN514 SERIES

HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE SCREW MACHINE, TiN COATED

▶ **Flute Geometry** : Right hand spiral, Parabolic flute
38° helix
▶ **Point Angle** : 130° : Split point
▶ **Application** : Improved chip removal in most materials, especially in deep drilling applications.





ANSI HSS-E 38° ANSI 130°

P.203

▶ Fractional sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal		
TiN	D1		L1	L2
* DN514006	3/32	.0938	3/4	1-3/4
** DN514007	7/64	.1094	13/16	1-13/16
** DN514008	1/8	.1250	7/8	1-7/8
** DN514009	9/64	.1406	15/16	1-15/16
** DN514010	5/32	.1563	1	2-1/16
** DN514011	11/64	.1719	1-1/16	2-1/8
** DN514012	3/16	.1875	1-1/8	2-3/16
** DN514013	13/64	.2031	1-3/16	2-1/4
** DN514014	7/32	.2188	1-1/4	2-3/8
** DN514015	15/64	.2344	1-5/16	2-7/16
** DN514016	1/4	.2500	1-3/8	2-1/2
** DN514017	17/64	.2656	1-7/16	2-5/8
** DN514018	9/32	.2813	1-1/2	2-11/16
** DN514019	19/64	.2969	1-9/16	2-3/4

EDP No.	Diameter		Flute Length	Overall Length
	Fractional	Decimal		
TiN	D1		L1	L2
** DN514020	5/16	.3125	1-5/8	2-13/16
** DN514021	21/64	.3281	1-11/16	2-15/16
** DN514022	11/32	.3438	1-11/16	3
** DN514023	23/64	.3594	1-3/4	3-1/16
** DN514024	3/8	.3750	1-13/16	3-1/8
** DN514025	25/64	.3906	1-7/8	3-1/4
** DN514026	13/32	.4063	1-15/16	3-5/16
** DN514027	27/64	.4219	2	3-3/8
** DN514028	7/16	.4375	2-1/16	3-7/16
** DN514029	29/64	.4531	2-1/8	3-9/16
** DN514030	15/32	.4688	2-1/8	3-5/8
** DN514031	31/64	.4844	2-3/16	3-11/16
** DN514032	1/2	.5000	2-1/4	3-3/4

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

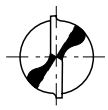
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎						○	○				

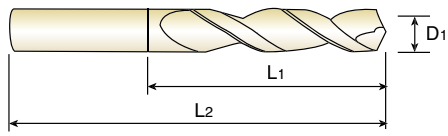
STRAIGHT SHANK DRILLS

DN516 SERIES

HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE SCREW MACHINE, TiN COATED

- **Flute Geometry** : Right hand spiral, Parabolic flute 38° helix
- **Point Angle** : 130° : Split point
- **Application** : Improved chip removal in most materials, especially in deep drilling applications.





ANSI HSS-E 38° ANSI 130°

P.203

Letter sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Letter	Decimal		
TiN	D1		L1	L2
** DN516101	A	.2340	1-5/16	2-7/16
** DN516102	B	.2380	1-3/8	2-1/2
** DN516103	C	.2420	1-3/8	2-1/2
** DN516104	D	.2460	1-3/8	2-1/2
** DN516105	E	.2500	1-3/8	2-1/2
** DN516106	F	.2570	1-7/16	2-5/8
** DN516107	G	.2610	1-7/16	2-5/8
** DN516108	H	.2660	1-1/2	2-11/16
** DN516109	I	.2720	1-1/2	2-11/16
** DN516110	J	.2770	1-1/2	2-11/16
** DN516111	K	.2810	1-1/2	2-11/16
** DN516112	L	.2900	1-9/16	2-3/4
** DN516113	M	.2950	1-9/16	2-3/4

EDP No.	Diameter		Flute Length	Overall Length
	Letter	Decimal		
TiN	D1		L1	L2
** DN516114	N	.3020	1-5/8	2-13/16
** DN516115	O	.3160	1-11/16	2-15/16
** DN516116	P	.3230	1-11/16	2-15/16
** DN516117	Q	.3320	1-11/16	3
** DN516118	R	.3390	1-11/16	3
** DN516119	S	.3480	1-3/4	3-1/16
** DN516120	T	.3580	1-3/4	3-1/16
** DN516121	U	.3680	1-13/16	3-1/8
** DN516122	V	.3770	1-7/8	3-1/4
** DN516123	W	.3860	1-7/8	3-1/4
** DN516124	X	.3970	1-15/16	3-5/16
** DN516125	Y	.4040	1-15/16	3-5/16
** DN516126	Z	.4130	2	3-3/8

** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

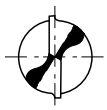
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎					○	○				

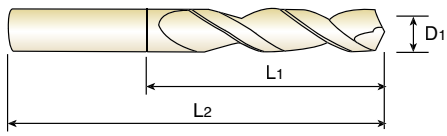
STRAIGHT SHANK DRILLS

DN515 SERIES

HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE SCREW MACHINE, TiN COATED

▶ **Flute Geometry** : Right hand spiral, Parabolic flute
38° helix
▶ **Point Angle** : 130° : Split point
▶ **Application** : Improved chip removal in most materials, especially in deep drilling applications.





ANSI HSS-E 38° ANSI 130°

P.203

▶ Wire gauge sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal		
TiN	D1		L1	L2
** DN515201	1	.2280	1-5/16	2-7/16
** DN515202	2	.2210	1-5/16	2-7/16
** DN515203	3	.2130	1-1/4	2-3/8
** DN515204	4	.2090	1-1/4	2-3/8
** DN515205	5	.2055	1-1/4	2-3/8
** DN515206	6	.2040	1-1/4	2-3/8
** DN515207	7	.2010	1-3/16	2-1/4
** DN515208	8	.1990	1-3/16	2-1/4
** DN515209	9	.1960	1-3/16	2-1/4
** DN515210	10	.1935	1-3/16	2-1/4
** DN515211	11	.1910	1-3/16	2-1/4
** DN515212	12	.1890	1-3/16	2-1/4
** DN515213	13	.1850	1-1/8	2-3/16
** DN515214	14	.1820	1-1/8	2-3/16
** DN515215	15	.1800	1-1/8	2-3/16
** DN515216	16	.1770	1-1/8	2-3/16
** DN515217	17	.1730	1-1/8	2-3/16
** DN515218	18	.1695	1-1/16	2-1/8
** DN515219	19	.1660	1-1/16	2-1/8
** DN515220	20	.1610	1-1/16	2-1/8
** DN515221	21	.1590	1-1/16	2-1/8
** DN515222	22	.1570	1-1/16	2-1/8
** DN515223	23	.1540	1	2-1/16
** DN515224	24	.1520	1	2-1/16

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal		
TiN	D1		L1	L2
** DN515225	25	.1495	1	2-1/16
** DN515226	26	.1470	1	2-1/16
** DN515227	27	.1440	1	2-1/16
** DN515228	28	.1405	15/16	1-15/16
** DN515229	29	.1360	15/16	1-15/16
** DN515230	30	.1285	15/16	1-15/16
** DN515231	31	.1200	7/8	1-7/8
** DN515232	32	.1160	7/8	1-7/8
** DN515233	33	.1130	7/8	1-7/8
** DN515234	34	.1110	7/8	1-7/8
** DN515235	35	.1100	7/8	1-7/8
** DN515236	36	.1065	13/16	1-13/16
* DN515237	37	.1040	13/16	1-13/16
* DN515238	38	.1015	13/16	1-13/16
* DN515239	39	.0995	13/16	1-13/16
* DN515240	40	.0980	13/16	1-13/16
* DN515241	41	.0960	13/16	1-13/16
* DN515242	42	.0935	3/4	1-3/4
* DN515243	43	.0890	3/4	1-3/4
* DN515244	44	.0860	3/4	1-3/4
* DN515245	45	.0820	3/4	1-3/4
* DN515246	46	.0810	3/4	1-3/4
* DN515247	47	.0785	11/16	1-11/16

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

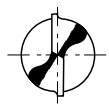
P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎					○	○				

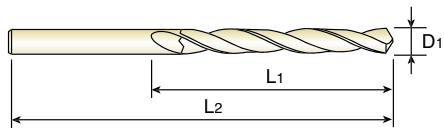
STRAIGHT SHANK DRILLS

DL517 SERIES UN-COATED
DX517 SERIES TiCN-COATED

HSSCo5, TAPER LENGTH STRAIGHT SHANK DRILL

▶ Flute Geometry : Right hand spiral, Parabolic flute
38° helix
▶ Point Angle : 130° : Split point
▶ Application : Improved chip removal in most materials, especially in deep drilling applications.





ANSI HSS-E 38° ANSI 130°

P.204

▶ Fractional sizes

Unit : Inch

EDP No.		Diameter		Flute Length	Overall Length
		Fractional	Decimal		
UN-COATED	TiCN-COATED	D1		L1	L2
* DL517005	DX517005	5/64	.0781	2	3-3/4
* DL517006	DX517006	3/32	.0938	2-1/4	4-1/4
* DL517007	DX517007	7/64	.1094	2-1/2	4-5/8
* DL517008	DX517008	1/8	.1250	2-3/4	5-1/8
* DL517009	DX517009	9/64	.1406	3	5-3/8
* DL517010	DX517010	5/32	.1563	3	5-3/8
* DL517011	DX517011	11/64	.1719	3-3/8	5-3/4
* DL517012	DX517012	3/16	.1875	3-3/8	5-3/4
* DL517013	DX517013	13/64	.2031	3-5/8	6
* DL517014	DX517014	7/32	.2188	3-5/8	6
* DL517015	DX517015	15/64	.2344	3-3/4	6-1/8
** DL517016	DX517016	1/4	.2500	3-3/4	6-1/8
** DL517017	DX517017	17/64	.2656	3-7/8	6-1/4
** DL517018	DX517018	9/32	.2813	3-7/8	6-1/4
** DL517019	DX517019	19/64	.2969	4	6-3/8
** DL517020	DX517020	5/16	.3125	4	6-3/8
** DL517021	DX517021	21/64	.3281	4-1/8	6-1/2
** DL517022	DX517022	11/32	.3438	4-1/8	6-3/4
** DL517023	DX517023	23/64	.3594	4-1/4	6-3/4
** DL517024	DX517024	3/8	.3750	4-1/4	6-3/4
** DL517025	DX517025	25/64	.3906	4-3/8	7
** DL517026	DX517026	13/32	.4063	4-3/8	7
** DL517027	DX517027	27/64	.4219	4-5/8	7-1/4
** DL517028	DX517028	7/16	.4375	4-5/8	7-1/4
** DL517029	DX517029	29/64	.4531	4-3/4	7-1/2
** DL517030	DX517030	15/32	.4688	4-3/4	7-1/2
** DL517031	DX517031	31/64	.4844	4-3/4	7-3/4
** DL517032	DX517032	1/2	.5000	4-3/4	7-3/4

▶ **Tolerance** : See page 197

* 10per package ** 5per package

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎						○	○				

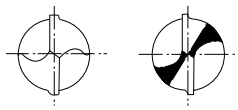
STRAIGHT SHANK DRILLS

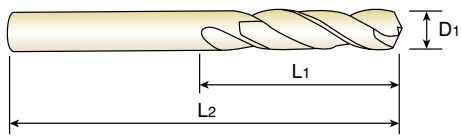
D4107 SERIES

HSSCo8, STRAIGHT SHANK SCREW MACHINE

STUB

- ▶ **Flute Geometry** : Right hand spiral helix
- ▶ **Point Angle** : 135˚
  under 1.6mm : Normal point
  1.6mm & over : Split point
- ▶ **Surface Treatment** : TiN Coating
- ▶ **Application** : Drills suitable for drilling in thin materials with portable drills. Special twist drills for automatic and turret lathes.





DIN 1897 | HSS Co8 | N 33° | h8 | 135° P.205

Unit : mm

EDP No.	Diameter Metric	Diameter Inch	Flute Length	Overall Length
TiN	D1		L1	L2
* D4107010	1.0	.0394	6	26
* D4107011	1.1	.0433	7	28
* D4107012	1.2	.0472	8	30
* D4107912	1.25	.0492	8	30
* D4107013	1.3	.0512	8	30
* D4107014	1.4	.0551	9	32
* D4107015	1.5	.0591	9	32
* D4107016	1.6	.0630	10	34
* D4107017	1.7	.0669	10	34
* D4107917	1.75	.0689	11	36
* D4107018	1.8	.0709	11	36
* D4107019	1.9	.0748	11	36
* D4107020	2.0	.0787	12	38
* D4107021	2.1	.0827	12	38
* D4107022	2.2	.0866	13	40
* D4107925	2.25	0.886	13	40
* D4107023	2.3	.0906	13	40
* D4107024	2.4	.0945	14	43
* D4107025	2.5	.0984	14	43
* D4107026	2.6	.1024	14	43
* D4107027	2.7	.1063	16	46
** D4107927	2.75	.1083	16	46
** D4107028	2.8	.1102	16	46
** D4107029	2.9	.1142	16	46
** D4107030	3.0	.1181	16	46
** D4107031	3.1	.1220	18	49
** D4107032	3.2	.1260	18	49
** D4107932	3.25	.1280	18	49
** D4107033	3.3	.1299	18	49
** D4107034	3.4	.1339	20	52

EDP No.	Diameter Metric	Diameter Inch	Flute Length	Overall Length
TiN			L1	L2
** D4107035	3.5	.1378	20	52
** D4107036	3.6	.1417	20	52
** D4107037	3.7	.1457	20	52
** D4107937	3.75	.1476	20	52
** D4107038	3.8	.1496	22	55
** D4107039	3.9	.1535	22	55
** D4107040	4.0	.1575	22	55
** D4107041	4.1	.1614	22	55
** D4107042	4.2	.1654	22	55
** D4107942	4.25	.1673	22	55
** D4107043	4.3	.1693	24	58
** D4107044	4.4	.1732	24	58
** D4107045	4.5	.1772	24	58
** D4107046	4.6	.1811	24	58
** D4107946	4.65	.1831	24	58
** D4107047	4.7	.1850	24	58
** D4107947	4.75	.1870	24	58
** D4107048	4.8	.1890	26	62
** D4107049	4.9	.1929	26	62
** D4107050	5.0	.1969	26	62
** D4107051	5.1	.2008	26	62
** D4107052	5.2	.2047	26	62
** D4107952	5.25	.2067	26	62
** D4107053	5.3	.2087	26	62
** D4107054	5.4	.2126	28	66
** D4107055	5.5	.2165	28	66
** D4107955	5.55	.2185	28	66
** D4107056	5.6	.2205	28	66
** D4107057	5.7	.2244	28	66
** D4107957	5.75	.2264	28	66

▶ The HSSCo5(DL107) is available when you need.
The TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

* 10per package ** 5per package

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○				○

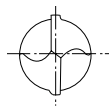
STRAIGHT SHANK DRILLS

D4107 SERIES

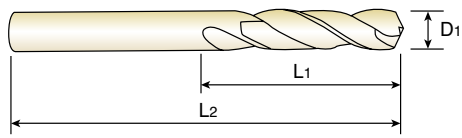
HSSCo8, STRAIGHT SHANK SCREW MACHINE

STUB

▶ **Flute Geometry** : Right hand spiral helix
▶ **Point Angle** : 135°
under 1.6mm : Normal point
1.6mm & over : Split point
▶ **Surface Treatment** : TiN Coating
▶ **Application** : Drills suitable for drilling in thin materials with portable drills. Special twist drills for automatic and turret lathes.



under 1.6mm 1.6mm & over



DIN 1897 | HSS Co8 | N 33° | h8 | 135° P.205

Unit : mm

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	D1		L1	L2
** D4107058	5.8	.2283	28	66
** D4107059	5.9	.2323	28	66
** D4107060	6.0	.2362	28	66
** D4107061	6.1	.2402	31	70
** D4107062	6.2	.2441	31	70
** D4107962	6.25	.2461	31	70
** D4107063	6.3	.2480	31	70
** D4107064	6.4	.2520	31	70
** D4107065	6.5	.2559	31	70
** D4107066	6.6	.2598	31	70
** D4107067	6.7	.2638	31	70
** D4107967	6.75	.2657	34	74
** D4107068	6.8	.2677	34	74
** D4107069	6.9	.2717	34	74
** D4107070	7.0	.2756	34	74
** D4107071	7.1	.2795	34	74
** D4107072	7.2	.2835	34	74
** D4107972	7.25	.2854	34	74
** D4107073	7.3	.2874	34	74
** D4107074	7.4	.2913	34	74
** D4107974	7.45	.2933	34	74
** D4107075	7.5	.2953	34	74
** D4107076	7.6	.2992	37	79
** D4107077	7.7	.3031	37	79
** D4107977	7.75	.3051	37	79
** D4107078	7.8	.3071	37	79
** D4107079	7.9	.3110	37	79
** D4107080	8.0	.3150	37	79
** D4107081	8.1	.3189	37	79
** D4107082	8.2	.3228	37	79

EDP No.	Diameter		Flute Length	Overall Length
	Metric	Inch		
TiN	D1		L1	L2
** D4107982	8.25	.3248	37	79
** D4107083	8.3	.3268	37	79
** D4107084	8.4	.3307	37	79
** D4107085	8.5	.3346	37	79
** D4107086	8.6	.3386	40	84
** D4107087	8.7	.3425	40	84
** D4107987	8.75	.3445	40	84
** D4107088	8.8	.3465	40	84
** D4107089	8.9	.3504	40	84
** D4107090	9.0	.3543	40	84
** D4107091	9.1	.3583	40	84
** D4107092	9.2	.3622	40	84
** D4107992	9.25	.3642	40	84
** D4107093	9.3	.3661	40	84
** D4107993	9.35	.3681	40	84
** D4107094	9.4	.3701	40	84
** D4107095	9.5	.3740	40	84
** D4107096	9.6	.3780	43	89
** D4107097	9.7	.3819	43	89
** D4107997	9.75	.3839	43	89
** D4107098	9.8	.3858	43	89
** D4107099	9.9	.3898	43	89
** D4107100	10.0	.3937	43	89
** D4107102	10.2	.4016	43	89
** D4107802	10.25	.4035	43	89
** D4107105	10.5	.4134	43	89
** D4107807	10.75	.4232	47	95
** D4107110	11.0	.4330	47	95
** D4107812	11.25	.4429	47	95
** D4107115	11.5	.4527	47	95

▶ The HSSCo5(DL107) is available when you need.
The TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

** 5per package

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○				○

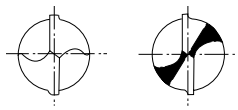
STRAIGHT SHANK DRILLS

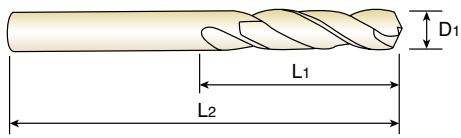
D4107 SERIES

HSSCo8, STRAIGHT SHANK SCREW MACHINE

STUB

- ▶ **Flute Geometry** : Right hand spiral helix
- ▶ **Point Angle** : 135˚
  under 1.6mm : Normal point
  1.6mm & over : Split point
- ▶ **Surface Treatment** : TiN Coating
- ▶ **Application** : Drills suitable for drilling in thin materials with portable drills. Special twist drills for automatic and turret lathes.





DIN 1897 | HSS Co8 | N 33˚ | h8 | 135˚ P.205

Unit : mm

EDP No.	Diameter Metric	Diameter Inch	Flute Length	Overall Length
TiN	D1		L1	L2
** D4107817	11.75	.4626	47	95
** D4107118	11.8	.4645	47	95
** D4107120	12.0	.4724	51	102
** D4107822	12.25	.4823	51	102
** D4107125	12.5	.4921	51	102
** D4107827	12.75	.5020	51	102
** D4107130	13.0	.5118	51	102
- D4107832	13.25	.5217	54	107
- D4107135	13.5	.5314	54	107
- D4107837	13.75	.5413	54	107
- D4107138	13.8	.5433	54	107
- D4107140	14.0	.5512	54	107
- D4107842	14.25	.5610	56	111
- D4107145	14.5	.5708	56	111
- D4107847	14.75	.5807	56	111
- D4107150	15.0	.5905	56	111
- D4107852	15.25	.6004	58	115
- D4107155	15.5	.6102	58	115
- D4107857	15.75	.6201	58	115
- D4107160	16.0	.6299	58	115
- D4107862	16.25	.6398	60	119
- D4107165	16.5	.6495	60	119
- D4107867	16.75	.6594	60	119
- D4107170	17.0	.6692	60	119
- D4107872	17.25	.6791	62	123
- D4107175	17.5	.6889	62	123

EDP No.	Diameter Metric	Diameter Inch	Flute Length	Overall Length
TiN	D1		L1	L2
- D4107877	17.75	.6907	62	123
- D4107180	18.0	.7087	62	123
- D4107882	18.25	.7185	64	127
- D4107185	18.5	.7283	64	127
- D4107887	18.75	.7382	64	127
- D4107190	19.0	.7480	64	127
- D4107892	19.25	.7579	66	131
- D4107195	19.5	.7676	66	131
- D4107897	19.75	.7776	66	131
- D4107200	20.0	.7874	66	131
- D4107205	20.5	.8071	68	136
- D4107210	21.0	.8268	68	136
- D4107215	21.5	.8465	70	141
- D4107220	22.0	.8661	70	141
- D4107225	22.5	.8858	72	146
- D4107230	23.0	.9055	72	146
- D4107235	23.5	.9252	72	146
- D4107240	24.0	.9449	75	151
- D4107245	24.5	.9646	75	151
- D4107250	25.0	.9843	75	151
- D4107260	26.0	1.0236	78	156
- D4107270	27.0	1.0630	81	162
- D4107280	28.0	1.1024	81	162
- D4107290	29.0	1.1417	84	168
- D4107300	30.0	1.1811	84	168
- D4107310	31.0	1.2205	87	174

▶ The HSSCo5(DL107) is available when you need.
The TiN(D4107), TiCN(D7107) and TiAlN(DQ107) are available on your request.

** 5per package
- 1per package

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎					○	○	○				○

STRAIGHT SHANK DRILLS

RECOMMENDED CUTTING CONDITIONS

HSS & HSSCo8, STRAIGHT SHANK SCREW MACHINE DRILLS

D1118, D1115, D1119, D2146, D2147, D2148 SERIES

WORK MATERIAL	P									
	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS	
HARDNESS			~ HRc23		~ HRc23 ~ 28		HRc23 ~ 34		HRc34 ~ 38	
STRENGTH	~ 570 N/mm²		~ 830 N/mm²		830 ~ 950 N/mm²		830 ~ 1110 N/mm²		1110 ~ 1260 N/mm²	
DIAMETER	N	S	N	S	N	S	N	S	N	S
~ 3/32	3380	.0010	2550	.0010	1900	.0006	2380	.0008	1400	.0006
3/32 ~ 5/32	2700	.0020	2000	.0020	1500	.0010	1880	.0020	1100	.0008
11/64 ~ 1/4	1700	.0025	1280	.0025	960	.0015	1190	.0025	700	.0010
17/64 ~ 23/64	1050	.0051	780	.0051	590	.0030	730	.0051	430	.0015
3/8 ~ 37/64	750	.0059	560	.0060	425	.0030	520	.0070	310	.0020
19/32 ~ 1	440	.0090	330	.0090	255	.0051	300	.0090	180	.0020
1 ~	260	.0110	195	.0110	145	.0070	180	.0070	107	.0030

WORK MATERIAL	P		M		K		N		N	
	TOOL STEELS		STAINLESS STEELS		CAST IRON		ALUMINUM ALLOYS		MAGNESIUM ALLOYS	
HARDNESS			HRc23		~ HRc21					
STRENGTH	~ 270 N/mm²		830 N/mm²		~ 800 N/mm²					
DIAMETER	N	S	N	S	N	S	N	S	N	S
~ 3/32	3180	.0016	2550	.0010	2250	.0010	6400	.0015	8600	.0015
3/32 ~ 5/32	2500	.0020	2000	.0020	2000	.0020	5000	.0025	6800	.0025
11/64 ~ 1/4	1590	.0025	1280	.0025	1280	.0025	3200	.0030	4300	.0030
17/64 ~ 23/64	970	.0051	780	.0051	780	.0051	2000	.0070	2600	.0070
3/8 ~ 37/64	700	.0070	560	.0060	560	.0060	1400	.0078	1900	.0078
19/32 ~ 1	440	.0090	330	.0090	330	.0090	820	.0118	1100	.0118
1 ~	240	.1180	195	.0110	195	.0110	490	.0150	660	.0150

WORK MATERIAL	N		N		S	
	ZINC ALLOYS		PLASTIC		TITANIUM ALLOYS	
HARDNESS						
STRENGTH					410 N/mm²	
DIAMETER	N	S	N	S	N	S
~ 3/32	6400	.0015	3380	.0010	1400	.0008
3/32 ~ 5/32	5000	.0025	2700	.0020	1100	.0010
11/64 ~ 1/4	3200	.0030	1700	.0025	700	.0015
17/64 ~ 23/64	2000	.0070	1050	.0051	430	.0030
3/8 ~ 37/64	1400	.0078	750	.0060	430	.0030
19/32 ~ 1	820	.0118	440	.0090	180	.0051
1 ~	490	.0150	260	.0110	107	.0070

N = R.P.M
S =Inch per Revolution (inch/rev.)

HSSCo5, STRAIGHT SHANK PARABOLIC FLUTE SCREW MACHINE, TiN COATED

DN514, DN516, DN515 SERIES

WORK MATERIAL	P				K			
	CARBON STEELS ALLOY STEELS		TOOL STEELS HARDENED STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
HARDNESS	HRc15 ~ 30		HRc20 ~ 40					
STRENGTH	700 ~ 1000 N/mm²		800 ~ 1200 N/mm²					
DIAMETER	N	S	N	S	N	S	N	S
~ 5/64	2630	.0012	2100	.0010	4200	.0023	1680	.0500
3/32 ~ 7/64	2100	.0015	1680	.0012	3300	.0031	1310	.0023
1/8 ~ 5/32	1680	.0020	1310	.0015	2630	.0039	1050	.0031
11/64 ~ 3/16	1310	.0023	1050	.0019	2100	.0051	840	.0039
13/64 ~ 15/64	1050	.0023	840	.0019	1680	.0051	660	.0039
1/4 ~ 9/32	840	.0031	660	.0023	1310	.0063	530	.0051
19/64 ~ 11/32	660	.0039	530	.0031	1050	.0078	420	.0067
23/64 ~ 7/16	530	.0051	420	.0039	840	.0098	330	.0082
29/64 ~ 9/16	420	.0051	330	.0039	660	.0098	260	.0082
37/64 ~ 45/64	330	.0059	260	.0051	530	.0118	210	.0098
23/32 ~ 7/8	260	.0078	210	.0059	420	.0157	170	.0118
57/64 ~ 1-1/8	210	.0098	170	.0078	330	.0196	130	.0196
1-9/64 ~	170	.0098	130	.0078	260	.0196	110	.0196

N = R.P.M
S =Inch per Revolution (inch/rev.)

STRAIGHT SHANK DRILLS

RECOMMENDED CUTTING CONDITIONS

HSSCo5, TAPER LENGTH STRAIGHT SHANK DRILL, TiCN COATED

DX517 SERIES

WORK MATERIAL	P				K			
	CARBON STEELS ALLOY STEELS		TOOL STEELS HARDENED STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
HARDNESS	HRc15 ~ 30		HRc20 ~ 40					
STRENGTH	700 ~ 1000 N/mm^2		800 ~ 1200 N/mm^2					
DIAMETER	N	S	N	S	N	S	N	S
~ 5/64	4900	.0023	3400	.0023	8500	.0027	5400	.0027
3/32 ~ 7/64	3000	.0031	2350	.0031	5700	.0043	3500	.0043
1/8 ~ 5/32	2440	.0035	1800	.0035	4300	.0055	2700	.0055
11/64 ~ 15/64	1950	.0039	1400	.0039	3450	.0055	2150	.0055
1/4 ~ 9/32	1400	.0055	1000	.0055	2450	.0078	1550	.0078
19/64 ~ 5/16	1200	.0059	850	.0059	2100	.0086	1350	.0086
21/64 ~ 23/64	1100	.0066	800	.0066	1950	.0094	1200	.0094
3/8 ~ 25/64	950	.0071	660	.0071	1750	.0110	1050	.0110
13/32 ~ 7/16	900	.0078	630	.0078	1600	.0110	960	.0110
29/64 ~ 15/32	800	.0078	575	.0078	1450	.0110	900	.0110
31/64 ~ 1/2	720	.0078	500	.0078	1300	.0110	830	.0110

N = R.P.M
S =Inch per Revolution (inch/rev.)

HSSCo5, TAPER LENGTH STRAIGHT SHANK DRILL

DL517 SERIES

WORK MATERIAL	P				K			
	CARBON STEELS ALLOY STEELS		TOOL STEELS HARDENED STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON	
HARDNESS	HRc15 ~ 30		HRc20 ~ 40					
STRENGTH	700 ~ 1000 N/mm^2		800 ~ 1200 N/mm^2					
DIAMETER	N	S	N	S	N	S	N	S
~ 5/64	3990	.0023	2770	.0023	6920	.0027	4400	.0027
3/32 ~ 7/64	2440	.0031	1910	.0031	4640	.0043	2850	.0043
1/8 ~ 5/32	1990	.0035	1470	.0035	3500	.0055	2200	.0055
11/64 ~ 15/64	1590	.0039	1140	.0039	2810	.0055	1750	.0055
1/4 ~ 9/32	1140	.0055	810	.0055	1990	.0078	1260	.0078
19/64 ~ 5/16	980	.0059	690	.0059	1710	.0086	1100	.0086
21/64 ~ 23/64	900	.0066	650	.0066	1590	.0094	980	.0094
3/8 ~ 25/64	770	.0071	540	.0071	1420	.0110	850	.0110
13/32 ~ 7/16	730	.0078	510	.0078	1300	.0110	780	.0110
29/64 ~ 15/32	650	.0078	470	.0078	1180	.0110	730	.0110
31/64 ~ 1/2	590	.0078	410	.0078	1060	.0110	680	.0110

N = R.P.M
S =Inch per Revolution (inch/rev.)

HSSCo8, STRAIGHT SHANK SCREW MACHINE

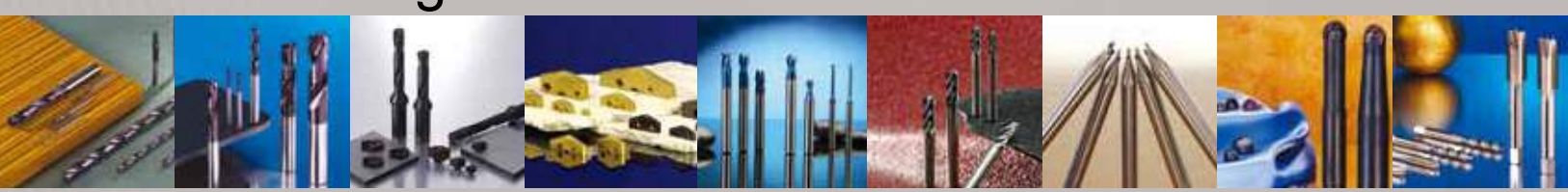
D4107 SERIES

WORK MATERIAL	P												M	
	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS		TOOL STEELS		STAINLESS STEELS	
HARDNESS			~ HRc23		~ HRc23 ~ 28		HRc23 ~ 34		HRc34 ~ 38				HRc23	
STRENGTH	~ 570 N/mm²		~ 830 N/mm²		830 ~ 950 N/mm²		830 ~ 1110 N/mm²		1110 ~ 1260 N/mm²		~ 270 N/mm²		830 N/mm²	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S
2.5	4225	.0010	3200	.0010	2500	.0006	2980	.0008	1750	.0006	3975	.0017	3200	.0010
3.0	3375	.0020	2500	.0020	2000	.0010	2350	.0020	1375	.0008	3125	.0020	2500	.0020
5.0	2125	.0025	1600	.0025	1280	.0015	1500	.0025	875	.0010	2000	.0025	1600	.0025
8.0	1310	.0051	975	.0051	785	.0030	910	.0051	535	.0015	1210	.0051	975	.0051
11.0	935	.0059	700	.0059	565	.0030	650	.0071	385	.0020	875	.0071	700	.0059
19.0	550	.0091	410	.0091	340	.0051	375	.0091	225	.0020	550	.0091	410	.0091
31.0	325	.0110	244	.0110	193	.0071	225	.0071	134	.0030	300	.0118	244	.0110

WORK MATERIAL	K		N								S	
	CAST IRON		ALUMINUM ALLOYS		MAGNESIUM ALLOYS		ZINC ALLOYS		PLASTIC		TITANIUM ALLOYS	
HARDNESS	~ HRc21											
STRENGTH	~ 800 N/mm²										410 N/mm²	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
2.5	2800	.0010	7950	.0015	10700	.0015	7950	.0015	4225	.0010	1750	.0008
3.0	2500	.0020	6200	.0025	8450	.0025	6200	.0025	3350	.0020	1375	.0010
5.0	1600	.0025	3950	.0030	5350	.0030	3950	.0030	2125	.0025	875	.0015
8.0	975	.0051	2490	.0071	3240	.0071	2490	.0071	1310	.0051	535	.0030
11.0	700	.0059	1740	.0079	2365	.0079	1740	.0079	935	.0059	535	.0030
19.0	410	.0091	1020	.0118	1370	.0118	1020	.0118	550	.0091	225	.0051
31.0	244	.0110	610	.0150	820	.0150	610	.0150	325	.0110	134	.0071

N = R.P.M
S =Inch per Revolution (inch/rev.)

Global Cutting Tool Leader **YG-1**



HSS

Being the best through innovation

AIRCRAFT DRILLS

- 6 and 12 inch Length Drills

AIRCRAFT DRILLS

6 and 12 inch Length Drills

◎ : Excellent ○ : Good

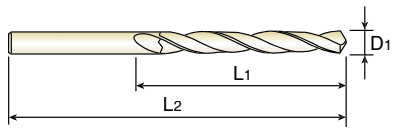
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	○				○	○	○	○	○		
◎	○				○	○	○	○	○		
◎	○				○	○	○	○	○		
◎	◎	○			○	○	○	○	○		○
◎	◎	○			○	○	○	○	○		○
◎	◎	○			○	○	○	○	○		○

AIRCRAFT DRILLS

DL601 SERIES
DL604 SERIES

HSSCo5, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT COLORING

▶ **Flute Geometry** : Right hand spiral, 30° helix
▶ **Point Angle** : 135° : Split point
▶ **Application** : Improved chip removal in most materials, especially in deep drilling applications.



HSS Co5 | NAS 907 | N 30° | 135°

P.216

▶ Fractional sizes

Unit : Inch

EDP No.	Diameter Fractional	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* DL601005	5/64	.0781	1	6
* DL601006	3/32	.0938	1-1/4	6
* DL601007	7/64	.1094	1-1/2	6
* DL601008	1/8	.1250	1-5/8	6
* DL601009	9/64	.1406	1-3/4	6
* DL601010	5/32	.1563	2	6
* DL601011	11/64	.1719	2-1/8	6
* DL601012	3/16	.1875	2-5/16	6
* DL601013	13/64	.2031	2-7/16	6
* DL601014	7/32	.2188	2-1/2	6
* DL601015	15/64	.2344	2-5/8	6
** DL601016	1/4	.2500	2-3/4	6
** DL601017	17/64	.2656	2-7/8	6
** DL601018	9/32	.2813	2-15/16	6
** DL601019	19/64	.2969	3-1/16	6
** DL601020	5/16	.3125	3-3/16	6
** DL601021	21/64	.3281	3-5/16	6
** DL601022	11/32	.3438	3-7/16	6
** DL601023	23/64	.3594	3-1/2	6
** DL601024	3/8	.3750	3-5/8	6
** DL601025	25/64	.3906	3-3/4	6
** DL601026	13/32	.4063	3-7/8	6
** DL601027	27/64	.4219	3-15/16	6
** DL601028	7/16	.4375	4-1/16	6

EDP No.	Diameter Fractional	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
** DL601029	29/64	.4531	4-3/16	6
** DL601030	15/32	.4688	4-5/16	6
** DL601031	31/64	.4844	4-3/8	6
** DL601032	1/2	.5000	4-1/2	6
** DL604014	7/32	.2188	2-1/2	12
** DL604015	15/64	.2344	2-5/8	12
** DL604016	1/4	.2500	2-3/4	12
** DL604017	17/64	.2656	2-7/8	12
** DL604018	9/32	.2813	2-15/16	12
** DL604019	19/64	.2969	3-1/16	12
** DL604020	5/16	.3125	3-3/16	12
** DL604021	21/64	.3281	3-5/16	12
** DL604022	11/32	.3438	3-7/16	12
** DL604023	23/64	.3594	3-1/2	12
** DL604024	3/8	.3750	3-5/8	12
** DL604025	25/64	.3906	3-3/4	12
** DL604026	13/32	.4063	3-7/8	12
** DL604027	27/64	.4219	3-15/16	12
** DL604028	7/16	.4375	4-1/16	12
** DL604029	29/64	.4531	4-3/16	12
** DL604030	15/32	.4688	4-5/16	12
** DL604031	31/64	.4844	4-3/8	12
** DL604032	1/2	.5000	4-1/2	12

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

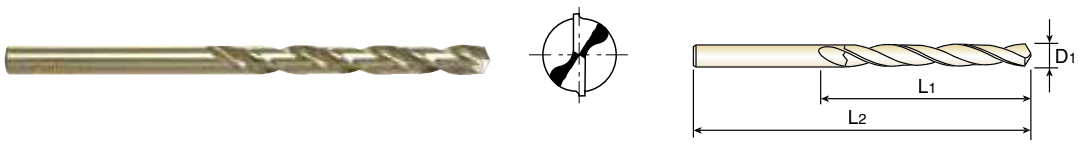
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	○				○	○	○	○	○		

AIRCRAFT DRILLS

DL602 SERIES
DL605 SERIES

HSSCo5, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT COLORING

▶ **Flute Geometry** : Right hand spiral, 30° helix
▶ **Point Angle** : 135° : Split point
▶ **Application** : Improved chip removal in most materials, especially in deep drilling applications.



HSS Co5 | NAS 907 | N 30° | 135° P.216

▶ Letter sizes

Unit : Inch

EDP No.	Diameter Letter	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* DL602101	A	.2340	2-5/8	6
** DL602102	B	,2380	2-3/4	6
** DL602103	C	.2420	2-3/4	6
** DL602104	D	.2460	2-3/4	6
** DL602105	E	.2500	2-3/4	6
** DL602106	F	.2570	2-7/8	6
** DL602107	G	.2610	2-7/8	6
** DL602108	H	.2660	2-7/8	6
** DL602109	I	.2720	2-7/8	6
** DL602110	J	.2770	2-7/8	6
** DL602111	K	.2810	2-15/16	6
** DL602112	L	.2900	2-15/16	6
** DL602113	M	.2950	3-1/16	6
** DL602114	N	.3020	3-1/16	6
** DL602115	O	.3160	3-3/16	6
** DL602116	P	.3230	3-5/16	6
** DL602117	Q	.3320	3-7/16	6
** DL602118	R	.3390	3-7/16	6
** DL602119	S	.3480	3-1/2	6
** DL602120	T	.3580	3-1/2	6
** DL602121	U	.3680	3-5/8	6
** DL602122	V	.3770	3-5/8	6
** DL602123	W	.3860	3-3/4	6
** DL602124	X	.3970	3-3/4	6
** DL602125	Y	.4040	3-7/8	6
** DL602126	Z	.4130	3-7/8	6

EDP No.	Diameter Letter	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* DL605101	A	.2340	2-5/8	12
** DL605102	B	,2380	2-3/4	12
** DL605103	C	.2420	2-3/4	12
** DL605104	D	.2460	2-3/4	12
** DL605105	E	.2500	2-3/4	12
** DL605106	F	.2570	2-7/8	12
** DL605107	G	.2610	2-7/8	12
** DL605108	H	.2660	2-7/8	12
** DL605109	I	.2720	2-7/8	12
** DL605110	J	.2770	2-7/8	12
** DL605111	K	.2810	2-15/16	12
** DL605112	L	.2900	2-15/16	12
** DL605113	M	.2950	3-1/16	12
** DL605114	N	.3020	3-1/16	12
** DL605115	O	.3160	3-3/16	12
** DL605116	P	.3230	3-5/16	12
** DL605117	Q	.3320	3-7/16	12
** DL605118	R	.3390	3-7/16	12
** DL605119	S	.3480	3-1/2	12
** DL605120	T	.3580	3-1/2	12
** DL605121	U	.3680	3-5/8	12
** DL605122	V	.3770	3-5/8	12
** DL605123	W	.3860	3-3/4	12
** DL605124	X	.3970	3-3/4	12
** DL605125	Y	.4040	3-7/8	12
** DL605126	Z	.4130	3-7/8	12

▶ **Tolerance** : See page 210

* 10per package
** 5per package

◎ : Excellent ○ : Good

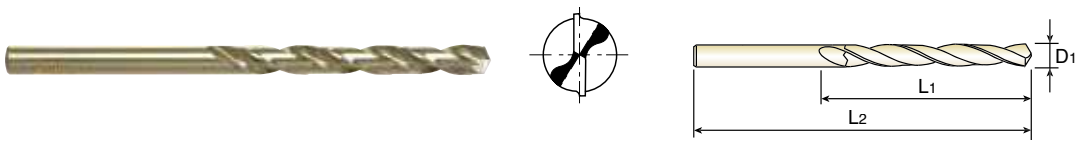
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	○					○	○	○	○	○		

AIRCRAFT DRILLS

DL603 SERIES
DL606 SERIES

HSSCo5, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT COLORING

▶ **Flute Geometry** : Right hand spiral, parabolic fute
30° helix
▶ **Point Angle** : 135° : Split point
▶ **Application** : Improved chip removal in most materials, especially in deep drilling applications.



HSS Co5 | NAS 907 | N 30° | 135° | P.216

▶ Wire gauge sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* DL603256	1	.2280	2-5/8	6
* DL603255	2	.2210	2-5/8	6
* DL603254	3	.2130	2-1/2	6
* DL603253	4	.2090	2-1/2	6
* DL603252	5	.2055	2-1/2	6
* DL603251	6	.2040	2-1/2	6
* DL603250	7	.2010	2-7/16	6
* DL603249	8	.1990	2-7/16	6
* DL603248	9	.1960	2-7/16	6
* DL603247	10	.1935	2-7/16	6
* DL603246	11	.1910	2-5/16	6
* DL603245	12	.1890	2-5/16	6
* DL603244	13	.1850	2-5/16	6
* DL603243	14	.1820	2-3/16	6
* DL603242	15	.1800	2-3/16	6
* DL603241	16	.1770	2-3/16	6
* DL603240	17	.1730	2-3/16	6
* DL603239	18	.1695	2-1/8	6
* DL603238	19	.1660	2-1/8	6
* DL603237	20	.1610	2-1/8	6
* DL603236	21	.1590	2-1/8	6
* DL603235	22	.1570	2	6
* DL603234	23	.1540	2	6

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* DL603233	24	.1520	2	6
* DL603232	25	.1495	1-7/8	6
* DL603231	26	.1470	1-7/8	6
* DL603230	27	.1440	1-7/8	6
* DL603229	28	.1405	1-3/4	6
* DL603228	29	.1360	1-3/4	6
* DL603227	30	.1280	1-5/8	6
* DL603226	31	.1200	1-5/8	6
* DL603225	32	.1160	1-5/8	6
* DL603224	33	.1130	1-1/2	6
* DL603223	34	.1110	1-1/2	6
* DL603222	35	.1100	1-1/2	6
* DL603221	36	.1065	1-7/16	6
* DL603220	37	.1040	1-7/16	6
* DL603219	38	.1015	1-7/16	6
* DL603218	39	.0995	1-3/8	6
* DL603217	40	.0980	1-3/8	6
* DL603216	41	.0960	1-3/8	6
* DL603215	42	.0935	1-1/4	6
* DL603214	43	.0890	1-1/4	6
* DL606256	1	.2280	2-5/8	12
* DL606254	3	.2130	2-1/2	12

* 10per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

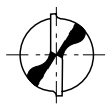
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	○				○	○	○	○	○		

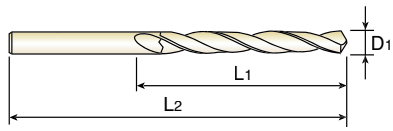
AIRCRAFT DRILLS

D1631 SERIES
D1634 SERIES

HSS, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT STEAM OXIDE

▶ **Flute Geometry** : Right hand spiral, 30° helix
▶ **Point Angle** : 135° : Split point
▶ **Application** : Improved chip removal in most materials, especially in deep drilling applications.





HSS | NAS 907 | N 30° | 135° | P.216

▶ Fractional sizes

Unit : Inch

EDP No.	Diameter Fractional	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* D1631005	5/64	.0781	1	6
* D1631006	3/32	.0938	1-1/4	6
* D1631007	7/64	.1094	1-1/2	6
* D1631008	1/8	.1250	1-5/8	6
* D1631009	9/64	.1406	1-3/4	6
* D1631010	5/32	.1563	2	6
* D1631011	11/64	.1719	2-1/8	6
* D1631012	3/16	.1875	2-5/16	6
* D1631013	13/64	.2031	2-7/16	6
* D1631014	7/32	.2188	2-1/2	6
* D1631015	15/64	.2344	2-5/8	6
** D1631016	1/4	.2500	2-3/4	6
** D1631017	17/64	.2656	2-7/8	6
** D1631018	9/32	.2813	2-15/16	6
** D1631019	19/64	.2969	3-1/16	6
** D1631020	5/16	.3125	3-3/16	6
** D1631021	21/64	.3281	3-5/16	6
** D1631022	11/32	.3438	3-7/16	6
** D1631023	23/64	.3594	3-1/2	6
** D1631024	3/8	.3750	3-5/8	6
** D1631025	25/64	.3906	3-3/4	6
** D1631026	13/32	.4063	3-7/8	6
** D1631027	27/64	.4219	3-15/16	6
** D1631028	7/16	.4375	4-1/16	6
** D1631029	29/64	.4531	4-3/16	6
** D1631030	15/32	.4688	4-5/16	6
** D1631031	31/64	.4844	4-3/8	6
** D1631032	1/2	.5000	4-1/2	6
* D1634014	7/32	.2188	2-1/2	12
* D1634015	15/64	.2344	2-5/8	12
** D1634016	1/4	.2500	2-3/4	12
** D1634017	17/64	.2656	2-7/8	12
** D1634018	9/32	.2813	2-15/16	12
** D1634019	19/64	.2969	3-1/16	12
** D1634020	5/16	.3125	3-3/16	12
** D1634021	21/64	.3281	3-5/16	12
** D1634022	11/32	.3438	3-7/16	12
** D1634023	23/64	.3594	3-1/2	12
** D1634024	3/8	.3750	3-5/8	12
** D1634025	25/64	.3906	3-3/4	12
** D1634026	13/32	.4063	3-7/8	12
** D1634027	27/64	.4219	3-15/16	12
** D1634028	7/16	.4375	4-1/16	12
** D1634029	29/64	.4531	4-3/16	12
** D1634030	15/32	.4688	4-5/16	12
** D1634031	31/64	.4844	4-3/8	12
** D1634032	1/2	.5000	4-1/2	12

* 10per package
** 5per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

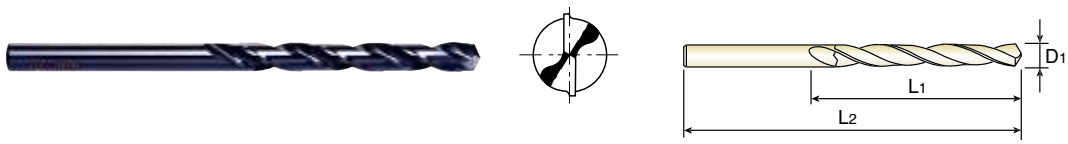
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				○	○	○	○	○		○

AIRCRAFT DRILLS

D1632 SERIES
D1635 SERIES

HSS, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT STEAM OXIDE

- **Flute Geometry** : Right hand spiral, 30° helix
- **Point Angle** : 135° : Split point
- **Application** : Improved chip removal in most materials, especially in deep drilling applications.



HSS | NAS 907 | N 30° | 135° P.216

▶ Letter sizes

Unit : Inch

EDP No.	Diameter Letter	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* D1632101	A	.2340	2-5/8	6
** D1632102	B	,2380	2-3/4	6
** D1632103	C	.2420	2-3/4	6
** D1632104	D	.2460	2-3/4	6
** D1632105	E	.2500	2-3/4	6
** D1632106	F	.2570	2-7/8	6
** D1632107	G	.2610	2-7/8	6
** D1632108	H	.2660	2-7/8	6
** D1632109	I	.2720	2-7/8	6
** D1632110	J	.2770	2-7/8	6
** D1632111	K	.2810	2-15/16	6
** D1632112	L	.2900	2-15/16	6
** D1632113	M	.2950	3-1/16	6
** D1632114	N	.3020	3-1/16	6
** D1632115	O	.3160	3-3/16	6
** D1632116	P	.3230	3-5/16	6
** D1632117	Q	.3320	3-7/16	6
** D1632118	R	.3390	3-7/16	6
** D1632119	S	.3480	3-1/2	6
** D1632120	T	.3580	3-1/2	6
** D1632121	U	.3680	3-5/8	6
** D1632122	V	.3770	3-5/8	6
** D1632123	W	.3860	3-3/4	6
** D1632124	X	.3970	3-3/4	6
** D1632125	Y	.4040	3-7/8	6
** D1632126	Z	.4130	3-7/8	6

EDP No.	Diameter Letter	Diameter Decimal	Flute Length	Overall Length
	D1		L1	L2
* D1635101	A	.2340	2-5/8	12
** D1635102	B	,2380	2-3/4	12
** D1635103	C	.2420	2-3/4	12
** D1635104	D	.2460	2-3/4	12
** D1635105	E	.2500	2-3/4	12
** D1635106	F	.2570	2-7/8	12
** D1635107	G	.2610	2-7/8	12
** D1635108	H	.2660	2-7/8	12
** D1635109	I	.2720	2-7/8	12
** D1635110	J	.2770	2-7/8	12
** D1635111	K	.2810	2-15/16	12
** D1635112	L	.2900	2-15/16	12
** D1635113	M	.2950	3-1/16	12
** D1635114	N	.3020	3-1/16	12
** D1635115	O	.3160	3-3/16	12
** D1635116	P	.3230	3-5/16	12
** D1635117	Q	.3320	3-7/16	12
** D1635118	R	.3390	3-7/16	12
** D1635119	S	.3480	3-1/2	12
** D1635120	T	.3580	3-1/2	12
** D1635121	U	.3680	3-5/8	12
** D1635122	V	.3770	3-5/8	12
** D1635123	W	.3860	3-3/4	12
** D1635124	X	.3970	3-3/4	12
** D1635125	Y	.4040	3-7/8	12
** D1635126	Z	.4130	3-7/8	12

▶ **Tolerance** : See page 210

* 10per package
** 5per package

◎ : Excellent ○ : Good

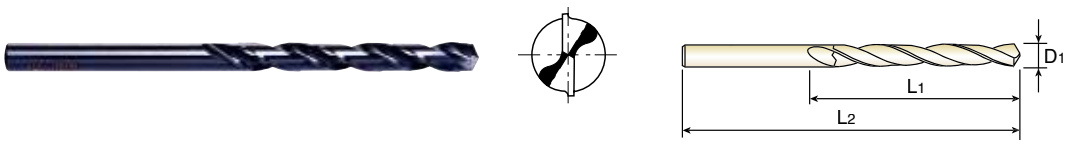
P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				○	○	○	○	○		○

AIRCRAFT DRILLS

D1633 SERIES
D1636 SERIES

HSS, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT STEAM OXIDE

- **Flute Geometry** : Right hand spiral, 30° helix
- **Point Angle** : 135° : Split point
- **Application** : Improved chip removal in most materials, especially in deep drilling applications.



HSS | NAS 907 | N 30° | 135° P.216

▶ Wire gauge sizes

Unit : Inch

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* D1633256	1	.2280	2-5/8	6
* D1633255	2	.2210	2-5/8	6
* D1633254	3	.2130	2-1/2	6
* D1633253	4	.2090	2-1/2	6
* D1633252	5	.2055	2-1/2	6
* D1633251	6	.2040	2-1/2	6
* D1633250	7	.2010	2-7/16	6
* D1633249	8	.1990	2-7/16	6
* D1633248	9	.1960	2-7/16	6
* D1633247	10	.1935	2-7/16	6
* D1633246	11	.1910	2-5/16	6
* D1633245	12	.1890	2-5/16	6
* D1633244	13	.1850	2-5/16	6
* D1633243	14	.1820	2-3/16	6
* D1633242	15	.1800	2-3/16	6
* D1633241	16	.1770	2-3/16	6
* D1633240	17	.1730	2-3/16	6
* D1633239	18	.1695	2-1/8	6
* D1633238	19	.1660	2-1/8	6
* D1633237	20	.1610	2-1/8	6
* D1633236	21	.1590	2-1/8	6
* D1633235	22	.1570	2	6
* D1633234	23	.1540	2	6

EDP No.	Diameter		Flute Length	Overall Length
	Wire gauge	Decimal	D1	
			L1	L2
* D1633233	24	.1520	2	6
* D1633232	25	.1495	1-7/8	6
* D1633231	26	.1470	1-7/8	6
* D1633230	27	.1440	1-7/8	6
* D1633229	28	.1405	1-3/4	6
* D1633228	29	.1360	1-3/4	6
* D1633227	30	.1280	1-5/8	6
* D1633226	31	.1200	1-5/8	6
* D1633225	32	.1160	1-5/8	6
* D1633224	33	.1130	1-1/2	6
* D1633223	34	.1110	1-1/2	6
* D1633222	35	.1100	1-1/2	6
* D1633221	36	.1065	1-7/16	6
* D1633220	37	.1040	1-7/16	6
* D1633219	38	.1015	1-7/16	6
* D1633218	39	.0995	1-3/8	6
* D1633217	40	.0980	1-3/8	6
* D1633216	41	.0960	1-3/8	6
* D1633215	42	.0935	1-1/4	6
* D1633214	43	.0890	1-1/4	6
* D1636256	1	.2280	2-5/8	12
* D1636254	3	.2130	2-1/2	12

* 10per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ −.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ −.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ −.0010

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○	○	○		○

AIRCRAFT DRILLS

RECOMMENDED CUTTING CONDITIONS

HSS & HSSCo5, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT

DL601, DL602, DL603, D1631, D1632, D1633 SERIES

WORK MATERIAL	P									
	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS	
HARDNESS			~ HRc23		~ HRc23 ~ 28		HRc23 ~ 34		HRc34 ~ 38	
STRENGTH	~ 570 N/mm²		~ 830 N/mm²		830 ~ 950 N/mm²		830 ~ 1110 N/mm²		1110 ~ 1260 N/mm²	
DIAMETER	N	S	N	S	N	S	N	S	N	S
~ 3/32	3380	.0010	2550	.0010	1900	.0006	2380	.0008	1400	.0006
3/32 ~ 5/32	2700	.0020	2000	.0020	1500	.0010	1880	.0020	1100	.0008
11/64 ~ 1/4	1700	.0025	1280	.0025	960	.0015	1190	.0025	700	.0010
17/64 ~ 23/64	1050	.0051	780	.0051	590	.0030	730	.0051	430	.0015
3/8 ~ 37/64	750	.0059	560	.0060	425	.0030	520	.0070	310	.0020
19/32 ~ 1	440	.0090	330	.0090	255	.0051	300	.0090	180	.0020
1 ~	260	.0110	195	.0110	145	.0070	180	.0070	107	.0030

WORK MATERIAL	P		M		K		N		N	
	TOOL STEELS		STAINLESS STEELS		CAST IRON		ALUMINUM ALLOYS		MAGNESIUM ALLOYS	
HARDNESS			HRc23		~ HRc21					
STRENGTH	~ 270 N/mm²		830 N/mm²		~ 800 N/mm²					
DIAMETER	N	S	N	S	N	S	N	S	N	S
~ 3/32	3180	.0016	2550	.0010	2250	.0010	6400	.0015	8600	.0015
3/32 ~ 5/32	2500	.0020	2000	.0020	2000	.0020	5000	.0025	6800	.0025
11/64 ~ 1/4	1590	.0025	1280	.0025	1280	.0025	3200	.0030	4300	.0030
17/64 ~ 23/64	970	.0051	780	.0051	780	.0051	2000	.0070	2600	.0070
3/8 ~ 37/64	700	.0070	560	.0060	560	.0060	1400	.0078	1900	.0078
19/32 ~ 1	440	.0090	330	.0090	330	.0090	820	.0118	1100	.0118
1 ~	240	.1180	195	.0110	195	.0110	490	.0150	660	.0150

WORK MATERIAL	N		N		S	
	ZINC ALLOYS		PLASTIC		TITANIUM ALLOYS	
HARDNESS						
STRENGTH					410 N/mm²	
DIAMETER	N	S	N	S	N	S
~ 3/32	6400	.0015	3380	.0010	1400	.0008
3/32 ~ 5/32	5000	.0025	2700	.0020	1100	.0010
11/64 ~ 1/4	3200	.0030	1700	.0025	700	.0015
17/64 ~ 23/64	2000	.0070	1050	.0051	430	.0030
3/8 ~ 37/64	1400	.0078	750	.0060	430	.0030
19/32 ~ 1	820	.0118	440	.0090	180	.0051
1 ~	490	.0150	260	.0110	107	.0070

N = R.P.M
S =Inch per Revolution (inch/rev.)

HSS

Being the best through innovation

SILVER & DEMING DRILLS

- 118° Split Point
  3 Flats Black and Gold

HSS SILVER & DEMING DRILLS

118° Split Point

3 Flat Black and Gold

ITEM	MODEL	DESCRIPTION	SIZE MIN	SIZE MAX	PAGE
INCH					
D1191		HSS(M2), 118° SPLIT POINT 3FLAT BLACK&GOLD SILVER & DEMING DRILLS	D1/2	D1-1/2	**220**
		RECOMMENDED CUTTING CONDITIONS			**221**

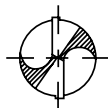
◎ : Excellent ○ : Good

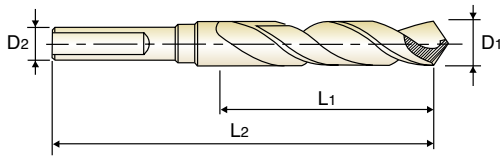
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○				

SILVER & DEMING DRILLS

D1191 SERIES

HSS(M2), 118° SPLIT POINT 3FLAT BLACK&GOLD SILVER & DEMING DRILLS





ANSI HSS 30~35° h8 118° P.221

Unit : Inch

EDP No.	Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D1191032	1/2	1/2	3	6
D1191033	33/64	1/2	3	6
D1191034	17/32	1/2	3	6
D1191035	35/64	1/2	3	6
D1191036	9/16	1/2	3	6
D1191037	37/64	1/2	3	6
D1191038	19/32	1/2	3	6
D1191039	39/64	1/2	3	6
D1191040	5/8	1/2	3	6
D1191041	41/64	1/2	3	6
D1191042	21/32	1/2	3	6
D1191043	43/64	1/2	3	6
D1191044	11/16	1/2	3	6
D1191045	45/64	1/2	3	6
D1191046	23/32	1/2	3	6
D1191047	47/64	1/2	3	6
D1191048	3/4	1/2	3	6
D1191049	49/64	1/2	3	6
D1191050	25/32	1/2	3	6
D1191051	51/64	1/2	3	6
D1191052	13/16	1/2	3	6
D1191053	53/64	1/2	3	6
D1191054	27/32	1/2	3	6
D1191055	55/64	1/2	3	6
D1191056	7/8	1/2	3	6
D1191057	57/64	1/2	3	6
D1191058	29/32	1/2	3	6
D1191059	59/64	1/2	3	6
D1191060	15/16	1/2	3	6

EDP No.	Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
D1191061	61/64	1/2	3	6
D1191062	31/32	1/2	3	6
D1191063	63/64	1/2	3	6
D1191064	1	1/2	3	6
D1191101	1-1/64	1/2	3	6
D1191102	1-1/32	1/2	3	6
D1191103	1-3/64	1/2	3	6
D1191104	1-1/16	1/2	3	6
D1191105	1-5/64	1/2	3	6
D1191106	1-3/32	1/2	3	6
D1191107	1-7/64	1/2	3	6
D1191108	1-1/8	1/2	3	6
D1191109	1-9/64	1/2	3	6
D1191110	1-5/32	1/2	3	6
D1191111	1-11/64	1/2	3	6
D1191112	1-3/16	1/2	3	6
D1191113	1-13/64	1/2	3	6
D1191114	1-7/32	1/2	3	6
D1191115	1-15/64	1/2	3	6
D1191116	1-1/4	1/2	3	6
D1191118	1-9/32	1/2	3	6
D1191120	1-5/16	1/2	3	6
D1191122	1-11/32	1/2	3	6
D1191124	1-3/8	1/2	3	6
D1191126	1-13/32	1/2	3	6
D1191128	1-7/16	1/2	3	6
D1191130	1-15/32	1/2	3	6
D1191132	1-1/2	1/2	3	6

* Individually packaged

◎ : Excellent ○ : Good

P					H	M	K	N					S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP		Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~									
◎	◎					○	○	○					

HSS(M2), 118° SPLIT POINT 3FLAT BLACK&GOLD SILVER & DEMING DRILLS

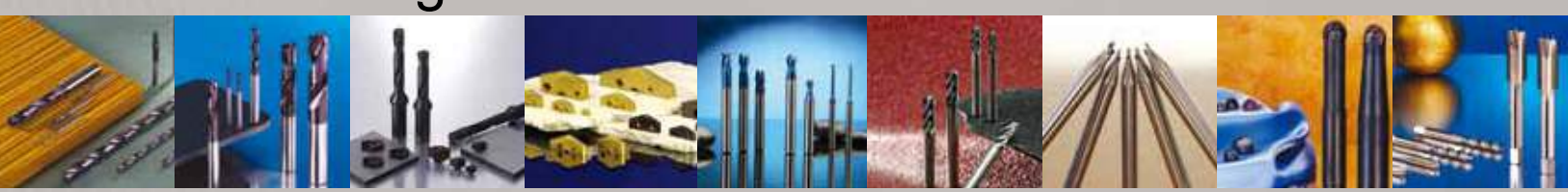
D1191 SERIES

WORK MATERIAL	P											
	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS		TOOL STEELS	
HARDNESS			~ HRc23		~ HRc23 ~ 28		HRc23 ~ 34		HRc34 ~ 38			
STRENGTH	~ 570 N/mm²		~ 830 N/mm²		830 ~ 950 N/mm²		830 ~ 1110 N/mm²		1110 ~ 1260 N/mm²		~ 270 N/mm²	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
1/2	645	.0067	480	.0067	370	.0035	440	.0067	265	.0020	645	.0067
3/4	440	.0091	330	.0091	255	.0051	300	.0091	180	.0020	440	.0091
1	325	.0110	245	.0110	185	.0063	220	.0110	133	.0030	325	.0110
1-9/32	260	.0110	195	.0110	145	.0071	180	.0110	107	.0030	240	.0118
1-1/2	220	.0130	165	.0130	120	.0076	150	.0130	90	.0030	198	.0121

WORK MATERIAL	M		N									
	STAINLESS STEELS		CAST IRON		ALUMINUM ALLOYS		MAGNESIUM ALLOYS		ZINC ALLOYS		PLASTIC	
HARDNESS	HRc23		~ HRc21									
STRENGTH	830 N/mm²		~ 800 N/mm²									
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
1/2	480	.0067	480	.0067	1200	.0100	1600	.0100	1200	.0100	645	.0067
3/4	330	.0091	330	.0091	820	.0118	1100	.0118	820	.0118	440	.0091
1	245	.0110	245	.0110	605	.0146	810	.0150	605	.0146	325	.0110
1-9/32	195	.0110	195	.0110	490	.0150	660	.0150	490	.0150	260	.0110
1-1/2	165	.0130	165	.0130	410	.0172	550	.0180	410	.0172	220	.0130

N = R.P.M
S = Inch per Revolution(inch/rev.)

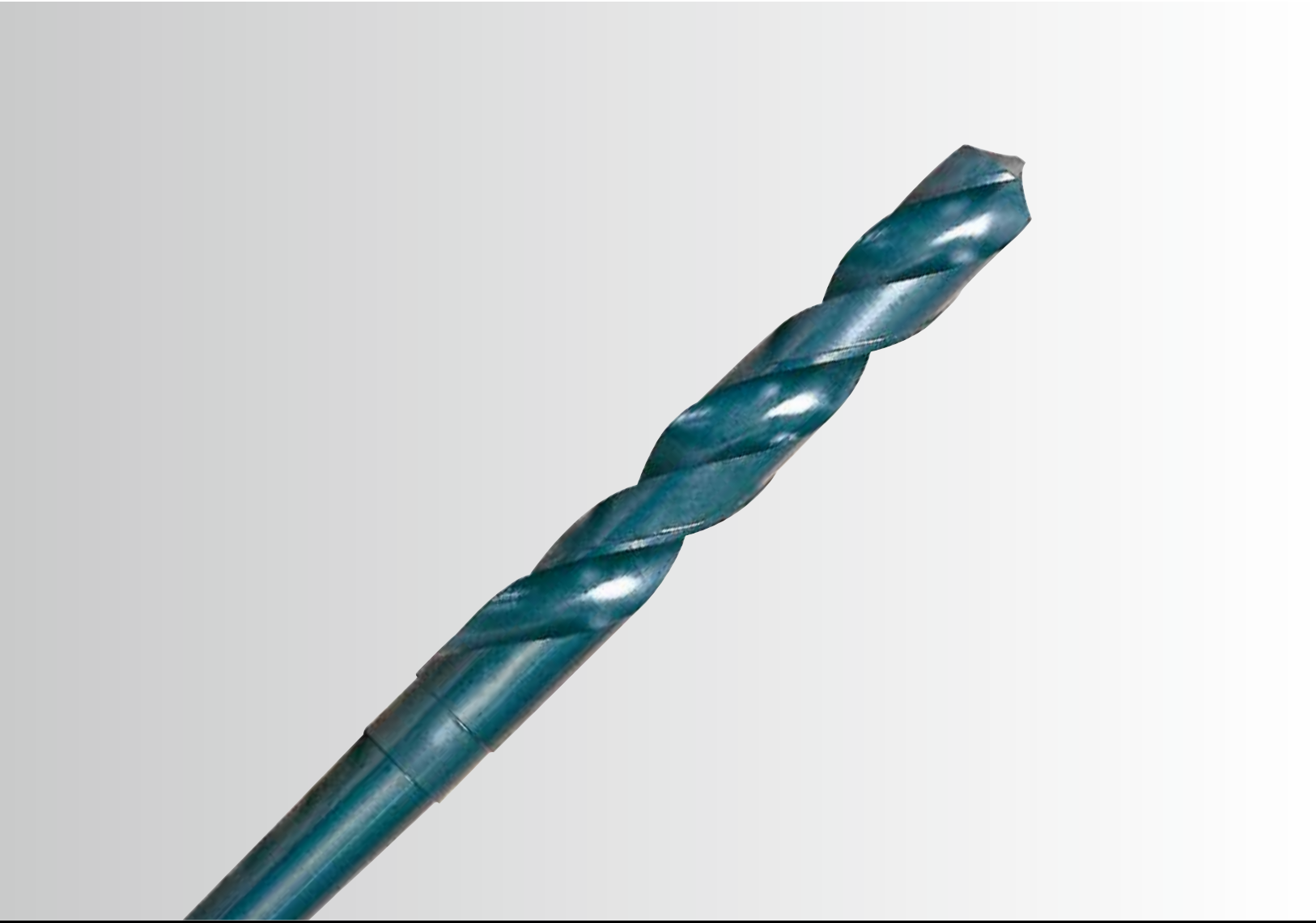
Global Cutting Tool Leader **YG-1**



HSS

YG

Being the best through innovation



MORSE TAPER SHANK DRILLS

- General Purpose
  Standard Length

HSS MORSE TAPER SHANK DRILLS

General Purpose

Standard Length

◎ : Excellent ○ : Good

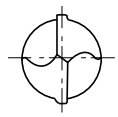
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○				

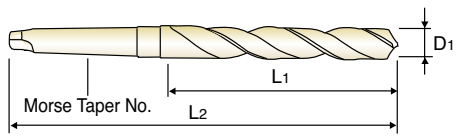
MORSE TAPER SHANK DRILLS

D1211 SERIES

HSS(M2) MORSE TAPER SHANK TWIST DRILL

▶ **Surface treatment** :Steam Tempered(Black Oxide Finish)
▶ **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron, graphite.





ANSI HSS 30~35° 2~5 h8 118° P.228

Unit : Inch

EDP No.	Diameter D1	Flute Length L1	Overall Length L2	Morse Taper No.
D1211032	1/2	4-3/8	8-1/4	2
D1211033	33/64	4-5/8	8-1/2	2
D1211034	17/32	4-5/8	8-1/2	2
D1211035	35/64	4-7/8	8-3/4	2
D1211036	9/16	4-7/8	8-3/4	2
D1211037	37/64	4-7/8	8-3/4	2
D1211038	19/32	4-7/8	8-3/4	2
D1211039	39/64	4-7/8	8-3/4	2
D1211040	5/8	4-7/8	8-3/4	2
D1211041	41/64	5-1/8	9	2
D1211042	21/32	5-1/8	9	2
D1211043	43/64	5-3/8	9-1/4	2
D1211044	11/16	5-3/8	9-1/4	2
D1211045	45/64	5-5/8	9-1/2	2
D1211046	23/32	5-5/8	9-1/2	2
D1211047	47/64	5-7/8	9-3/4	2
D1211048	3/4	5-7/8	9-3/4	2
D1211049	49/64	6	9-7/8	2
D1211050	25/32	6	9-7/8	2
D1211051	51/64	6-1/8	10-3/4	3
D1211052	13/16	6-1/8	10-3/4	3
D1211053	53/64	6-1/8	10-3/4	3
D1211054	27/32	6-1/8	10-3/4	3
D1211055	55/64	6-1/8	10-3/4	3
D1211056	7/8	6-1/8	10-3/4	3
D1211057	57/64	6-1/8	10-3/4	3
D1211058	29/32	6-1/8	10-3/4	3
D1211059	59/64	6-1/8	10-3/4	3
D1211060	15/16	6-1/8	10-3/4	3

EDP No.	Diameter D1	Flute Length L1	Overall Length L2	Morse Taper No.
D1211061	61/64	6-3/8	11	3
D1211062	31/32	6-3/8	11	3
D1211063	63/64	6-3/8	11	3
D1211100	1	6-3/8	11	3
D1211101	1-1/64	6-1/2	11-1/8	3
D1211102	1-1/32	6-1/2	11-1/8	3
D1211103	1-3/64	6-5/8	11-1/4	3
D1211104	1-1/16	6-5/8	11-1/4	3
D1211105	1-5/64	6-7/8	12-1/2	4
D1211106	1-3/32	6-7/8	12-1/2	4
D1211107	1-7/64	7-1/8	12-3/4	4
D1211108	1-1/8	7-1/8	12-3/4	4
D1211109	1-9/64	7-1/4	12-7/8	4
D1211110	1-5/32	7-1/4	12-7/8	4
D1211111	1-11/64	7-3/8	13	4
D1211112	1-3/16	7-3/8	13	4
D1211113	1-13/64	7-1/2	13-1/8	4
D1211114	1-7/32	7-1/2	13-1/8	4
D1211115	1-15/64	7-7/8	13-1/2	4
D1211116	1-1/4	7-7/8	13-1/2	4
D1211117	1-17/64	8-1/2	14-1/8	4
D1211118	1-9/32	8-1/2	14-1/8	4
D1211119	1-19/64	8-5/8	14-1/4	4
D1211120	1-5/16	8-5/8	14-1/4	4
D1211121	1-21/64	8-3/4	14-3/8	4
D1211122	1-11/32	8-3/4	14-3/8	4
D1211123	1-23/64	8-7/8	14-1/2	4
D1211124	1-3/8	8-7/8	14-1/2	4
D1211126	1-13/32	9	14-5/8	4

◎ : Excellent ○ : Good

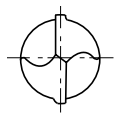
P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○				

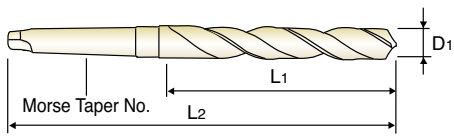
MORSE TAPER SHANK DRILLS

D1211 SERIES

HSS(M2) MORSE TAPER SHANK TWIST DRILL

▶ **Surface treatment** :Steam Tempered(Black Oxide Finish)
▶ **Application** : Drilling steels, cast steels alloyed and non-alloyed, grey cast iron, malleable cast iron, graphite.





ANSI HSS 30~35° 2~5 h8 118° P.228

Unit : Inch

EDP No.	Diameter D1	Flute Length L1	Overall Length L2	Morse Taper No.
D1211128	1-7/16	9-1/8	14-3/4	4
D1211130	1-15/32	9-1/4	14-7/8	4
D1211132	1-1/2	9-3/8	15	4
D1211133	1-33/64	9-3/8	16-3/8	4
D1211134	1-17/32	9-3/8	16-3/8	5
D1211136	1-9/16	9-5/8	16-5/8	5
D1211138	1-19/32	9-7/8	16-7/8	5
D1211140	1-5/8	10	17	5
D1211142	1-21/32	10-1/8	17-1/8	5
D1211144	1-11/16	10-1/8	17-1/8	5
D1211146	1-23/32	10-1/8	17-1/8	5
D1211148	1-3/4	10-1/8	17-1/8	5
D1211152	1-13/16	10-1/8	17-1/8	5
D1211154	1-27/32	10-1/8	17-1/8	5
D1211156	1-7/8	10-3/8	17-3/8	5

EDP No.	Diameter D1	Flute Length L1	Overall Length L2	Morse Taper No.
D1211160	1-15/16	10-3/8	17-3/8	5
D1211162	1-31/32	10-3/8	17-3/8	5
D1211200	2	10-3/8	17-3/8	5
D1211202	2-1/32	10-3/8	17-3/8	5
D1211204	2-1/16	10-1/4	17-3/8	5
D1211206	2-3/32	10-1/4	17-3/8	5
D1211208	2-1/8	10-1/4	17-3/8	5
D1211210	2-5/32	10-1/4	17-3/8	5
D1211212	2-3/16	10-1/4	17-3/8	5
D1211214	2-7/32	10-1/8	17-3/8	5
D1211216	2-1/4	10-1/8	17-3/8	5
D1211220	2-5/16	10-1/8	17-3/8	5
D1211224	2-3/8	10-1/8	17-3/8	5
D1211228	2-7/16	11-1/4	18-3/4	5
D1211232	2-1/2	11-1/4	18-3/4	5

◎ : Excellent ○ : Good

P					H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels			Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~								
◎	◎	○				○	○	○				

MORSE TAPER SHANK DRILLS

RECOMMENDED CUTTING CONDITIONS

HSS(M2) MORSE TAPER SHANK TWIST DRILL

D1211 SERIES

WORK MATERIAL	P											
	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS		TOOL STEELS	
HARDNESS			~ HRc23		~ HRc23 ~ 28		HRc23 ~ 34		HRc34 ~ 38			
STRENGTH	~ 570 N/mm²		~ 830 N/mm²		830 ~ 950 N/mm²		830 ~ 1110 N/mm²		1110 ~ 1260 N/mm²		~ 270 N/mm²	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
1/2	645	.0067	480	.0067	370	.0035	440	.0067	265	.0020	645	.0067
3/4	440	.0091	330	.0091	255	.0051	300	.0091	180	.0020	440	.0091
1	325	.0110	245	.0110	185	.0063	220	.0110	133	.0030	325	.0110
1-17/64	260	.0110	195	.0110	145	.0071	180	.0110	107	.0030	240	.0118
1-1/2	220	.0130	165	.0130	120	.0076	150	.0130	90	.0030	198	.0121
1-31/32	165	.0130	125	.0130	93	.0079	115	.0130	68	.0030	150	.0169
2-3/8	140	.0157	105	.0157	78	.0091	95	.0157	57	.0039	125	.0188

WORK MATERIAL	M		K		N							
	STAINLESS STEELS		CAST IRON		ALUMINUM ALLOYS		MAGNESIUM ALLOYS		ZINC ALLOYS		PLASTIC	
HARDNESS	HRc23		~ HRc21									
STRENGTH	830 N/mm²		~ 800 N/mm²									
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
1/2	480	.0067	480	.0067	1200	.0100	1600	.0100	1200	.0100	645	.0067
3/4	330	.0091	330	.0091	820	.0118	1100	.0118	820	.0118	440	.0091
1	245	.0110	245	.0110	605	.0146	810	.0150	605	.0146	325	.0110
1-17/64	195	.0110	195	.0110	490	.0150	660	.0150	490	.0150	260	.0110
1-1/2	165	.0130	165	.0130	410	.0172	550	.0180	410	.0172	220	.0130
1-31/32	125	.0130	125	.0130	310	.0181	415	.0181	310	.0181	165	.0130
2-3/8	105	.0157	105	.0157	260	.0196	345	.0196	260	.0196	140	.0157

N = R.P.M
S = Inch per Revolution (inch/rev.)

HSS

Being the best through innovation

NC SPOTTING DRILLS

- HSS(8% COBALT)
  Centering and Chamfering of Holes

HSS(8% Cobalt) NC SPOTTING DRILLS
Centering and Chamfering of Holes

ITEM	MODEL	DESCRIPTION	SIZE MIN	SIZE MAX	PAGE
INCH					
D2N90		HSSCo8, NC SPOTTING DRILLS 90°	D1/8	D1	**232**
		HSSCo8, NC SPOTTING DRILLS 120°	D1/8	D1	**232**
		RECOMMENDED CUTTING CONDITIONS			**233**

◎ : Excellent ○ : Good

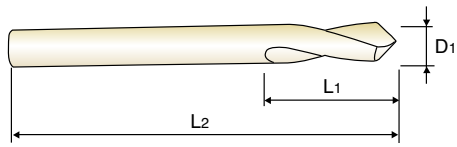
P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○		○		○		
◎	◎				○		○		○		

NC SPOTTING DRILLS

D2N90 SERIES

HSSCo8, NC SPOTTING DRILLS

▶ **Application** : For more precise centering work on NC/CNC machine. A larger diameter in respect to the subsequent drilling tool permit to obtain the centering and chamfering simultaneously.



NC | HSS Co8 | h6 | h6 | 90° | 120° P.233

NC Spotting drills 90°

Unit : Inch

EDP No.	Diameter	Flute Length	Overall Length
	D1	L1	L2
0081L	1/8	.472	1.93
0121L	3/16	.590	2.44
0161L	1/4	.669	2.76
0201L	5/16	.984	3.11
0241L	3/8	.827	3.50
0321L	1/2	.984	4.02
0401L	5/8	1.575	4.53
0481L	3/4	1.968	5.16
0641L	1	1.968	6.14

NC Spotting drills 120°

EDP No.	Diameter	Flute Length	Overall Length
	D1	L1	L2
2081L	1/8	.472	1.93
2121L	3/16	.590	2.44
2161L	1/4	.669	2.76
2201L	5/16	.984	3.11
2241L	3/8	.827	3.50
2321L	1/2	.984	4.02
2401L	5/8	1.575	4.53
2481L	3/4	1.968	5.16
2641L	1	1.968	6.14

* Individually packaged

◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○		○		○		

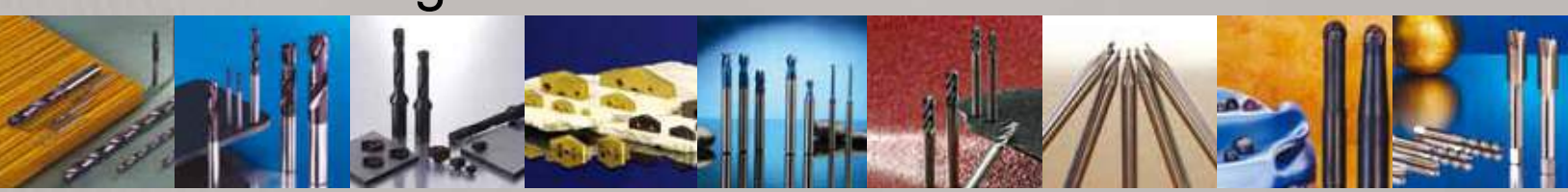
HSSCo8, NC SPOTTING DRILLS

D2N90 SERIES

WORK MATERIAL	P						M		N	
	CARBON STEELS		ALLOY STEELS		ALLOY STEELS, TOOL STEELS, HARDENED STEELS		STAINLESS STEELS		ALUMINUM, ALUMINUM ALLOYS	
DIAMETER	N	S	N	S	N	S	N	S	N	S
1/8 ~ 5/32	2460	.002	2110	.002	1080	.002	940	.002	7040	.005
11/64 ~ 3/16	1850	.002	1580	.002	800	.002	700	.002	5280	.006
13/64 ~ 15/64	1510	.003	1300	.003	670	.003	580	.003	4400	.006
1/4 ~ 5/16	1170	.003	1030	.003	540	.003	460	.003	3520	.007
21/64 ~ 25/64	880	.004	790	.004	400	.004	350	.004	2640	.008
13/32 ~ 15/32	700	.004	630	.004	320	.004	290	.004	2110	.009
31/64 ~ 5/8	590	.005	530	.005	260	.005	240	.005	1760	.011
41/64 ~ 47/64	460	.007	400	.007	200	.007	180	.007	1320	.012
3/4 ~ 1	350	.009	320	.009	150	.009	140	.009	1060	.017

N = R.P.M
S = Inch per Revolution (inch/rev.)

Global Cutting Tool Leader **YG-1**



HSS

Being the best through innovation

COMBINATION DRILL & COUNTER SINK / CENTER DRILL

- Regular and Long Length

HSS COMBINATION DRILL & COUNTER SINK / CENTER DRILL
Regular and Long Length

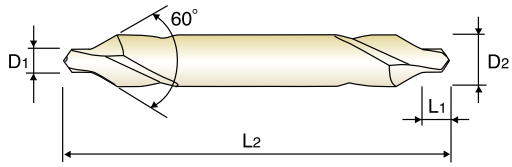
◎ : Excellent ○ : Good

P				H	M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○	○	○		○

COMBINATION DRILL & COUNTER SINK

D1C90 SERIES

HSS(M2), COMBINATION DRILL & COUNTER SINK / CENTER DRILL



HSS | h8 | k12 | 120°

P.238

60°

EDP No.	Size	Diameter	Shank Diameter	Drill Length	Overall Length
		D1	D2	L1	L2
* D1C90079	1	3/64	1/8	1/16	1-1/2
* D1C90080	2	1/16	3/16	5/64	1-3/4
* D1C90081	3	3/32	1/4	1/8	2
* D1C90082	4	1/8	5/16	5/32	2-1/4
* D1C90083	5	3/16	7/16	1/4	2-1/2
★ D1C90084	6	7/32	1/2	7/32	3

* 10per package
★ Individually package

60°

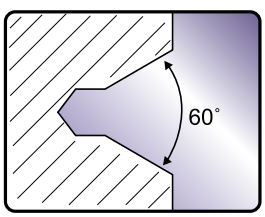
EDP No.	Size	Diameter	Shank Diameter	Drill Length	Overall Length
		D1	D2	L1	L2
* D1C90141	1	3/64	1/8	3/64	1-1/4
* D1C90142	2	5/64	3/16	5/64	1-7/8
* D1C90143	3	7/64	1/4	7/64	2
* D1C90144	4	1/8	5/16	1/8	2-1/8
* D1C90145	5	3/16	7/16	3/16	2-3/4

* 10per package

LONG LENGTH (60°)

Unit : Inch

EDP No.	Size	Diameter	Shank Diameter	Drill Length	Overall Length
		D1	D2	L1	L2
D1C90085	1	3/64	1/8	3/64	3
D1C90086	1	3/64	1/8	3/64	4
D1C90087	1	3/64	1/8	3/64	5
D1C90088	1	3/64	1/8	3/64	6
D1C90089	2	5/64	3/16	5/64	3
D1C90090	2	5/64	3/16	5/64	4
D1C90091	2	5/64	3/16	5/64	5
D1C90092	2	5/64	3/16	5/64	6
D1C90093	3	7/64	1/4	7/64	4
D1C90094	3	7/64	1/4	7/64	5
D1C90095	3	7/64	1/4	7/64	6
D1C90096	4	1/8	5/16	1/8	4
D1C90097	4	1/8	5/16	1/8	5
D1C90098	4	1/8	5/16	1/8	6
D1C90099	5	3/16	7/16	3/16	4
D1C90100	5	3/16	7/16	3/16	5
D1C90101	5	3/16	7/16	3/16	6
D1C90102	6	7/32	1/2	7/32	4
D1C90103	6	7/32	1/2	7/32	5
D1C90104	6	7/32	1/2	7/32	6

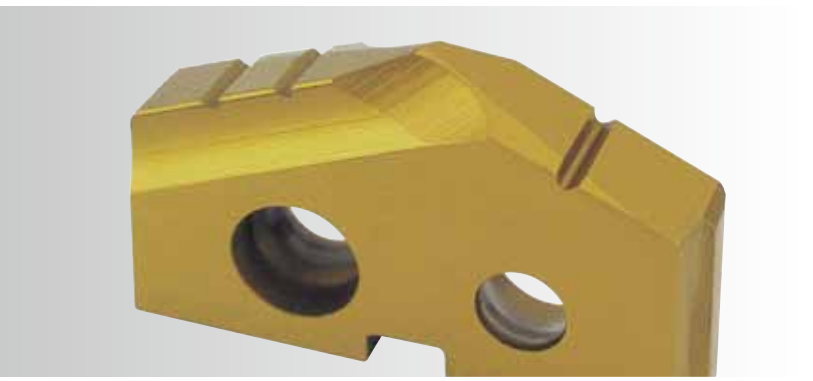


◎ : Excellent ○ : Good

P			H		M	K	N				S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Stainless Steels	Cast Iron	Aluminum	Copper	Bronze	CFRP	Titanium
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○	○	○		○

INSERTS & HOLDERS

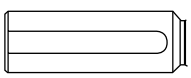
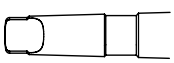
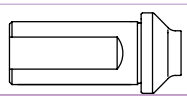
Being the best through innovation



SPADE DRILLS

- **Carbide for Long Tool Life, and HSS-PM for General Machines and Large Diameters Higher Productivity than Other Drilling Tools**

SPADE DRILL INSERTS & HOLDER

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
SERIES 1~8		SPADE DRILL INSERTS - HSS M4	.7031 (#1)	4.5000 (#8)	242
SERIES Y,Z,0,1~8		SPADE DRILL INSERTS - SUPER HSS T15	.3740 (#Y)	4.5000 (#8)	246
SERIES Y,Z,0,1,2		SPADE DRILL INSERTS - PREMIUM HSS M48	.3740 (#Y)	1.3780 (#2)	253
SERIES Y,Z,0,1~3		CARBIDE BLADE INSERTS-C2(K20)	.3740 (#Y)	1.8750 (#3)	256
SERIES Y,Z,0,1~3		CARBIDE BLADE INSERTS-C5(P40)	.3740 (#Y)	1.8750 (#3)	256
SERIES Y,Z,0,1~2		CARBIDE BLADE INSERTS-C3(K10)	.3740 (#Y)	1.3780 (#2)	256
SERIES Y,Z,0,1~8		SM-POINT SPADE DRILL INSERTS - SUPER COBALT(T15)	.3740 (#Y)	4.5000 (#8)	262
SERIES Y,Z,0,1~3		SM-POINT SPADE DRILL INSERTS - CARBIDE(C5)	.3740 (#Y)	1.8750 (#3)	266
SERIES Y,Z,0,1,2		SPADE DRILL FLAT BOTTOM INSERTS - SUPER COBALT T15	.3750 (#Y)	1.3750 (#2)	268
STRAIGHT SHANK		SPADE DRILL HOLDER - STRAIGHT SHANK			269
TAPER SHANK		SPADE DRILL HOLDER - TAPER SHANK			273
FLANGED SHANK		SPADE DRILL HOLDER - FLANGED SHANK			275
		HOLDER ACCESSORIES			277
		RECOMMENDED CUTTING CONDITIONS			278

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
○	○	○	○		○		○	○			◎	◎	○	◎	◎
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	○	○
○	○	○	○	○	◎	◎	○	○	○	○	◎	○	○	◎	◎
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○
												◎	◎		
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 1,2

SPADE DRILL INSERTS - HSS M4

- General purpose insert for most materials
- Not recommended for tool steels and high temp alloys
- High toughness for loose or manual machines

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	HSS (M4) TiN	HSS (M4) TiAlN	HSS (M4) Hardslick
1 .690 (17.53) to .960 (24.38)	45/64	17.86	.7031	5/32 (4.0)	SO1101	SO3101	SO4101
		18.00	.7087		SO1102	SO3102	SO4102
	23/32	18.26	.7188		SO1103	SO3103	SO4103
		18.50	.7283		SO1104	SO3104	SO4104
	47/64	18.65	.7344		SO1105	SO3105	SO4105
		19.00	.7480		SO1106	SO3106	SO4106
	3/4	19.05	.7500		SO1107	SO3107	SO4107
	49/64	19.45	.7656		SO1108	SO3108	SO4108
		19.50	.7677		SO1109	SO3109	SO4109
	25/32	19.84	.7813		SO1110	SO3110	SO4110
		20.00	.7874		SO1111	SO3111	SO4111
	51/64	20.24	.7969		SO1160	SO3160	SO4160
		20.50	.8071		SO1112	SO3112	SO4112
	13/16	20.64	.8125		SO1113	SO3113	SO4113
		21.00	.8268		SO1114	SO3114	SO4114
	27/32	21.43	.8438		SO1115	SO3115	SO4115
	55/64	21.83	.8594		SO1161	SO3161	SO4161
		22.00	.8661		SO1116	SO3116	SO4116
	7/8	22.23	.8750		SO1117	SO3117	SO4117
	57/64	22.62	.8906		SO1162	SO3162	SO4162
		23.00	.9055		SO1118	SO3118	SO4118
	29/32	23.02	.9063		SO1119	SO3119	SO4119
	59/64	23.42	.9219		SO1120	SO3120	SO4120
	15/16	23.81	.9375		SO1121	SO3121	SO4121
		24.00	.9449		SO1122	SO3122	SO4122
2 .961 (24.41) to 1.380 (35.05)	31/32	24.61	.9688	3/16 (4.8)	SO1201	SO3201	SO4201
	63/64	25.00	.9843		SO1202	SO3202	SO4202
	1	25.40	1.0000		SO1203	SO3203	SO4203
	1-1/64	25.80	1.0156		SO1204	SO3204	SO4204
		26.00	1.0236		SO1205	SO3205	SO4205
	1-1/32	26.19	1.0313		SO1206	SO3206	SO4206
	1-3/64	26.59	1.0469		SO1260	SO3260	SO4260
	1-1/16	26.99	1.0625		SO1207	SO3207	SO4207
		27.00	1.0630		SO1208	SO3208	SO4208

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
○	○	○	○		○		○	○			◎	◎	○	◎	◎

SPADE DRILLS

SERIES 2,3

SPADE DRILL INSERTS - HSS M4

- General purpose insert for most materials
- Not recommended for tool steels and high temp alloys
- High toughness for loose or manual machines

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
					HSS (M4)		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAlN	Hardslick
2 .961 (24.41) to 1.380 (35.05)	1-3/32	27.78	1.0938	3/16 (4.8)	SO1209	SO3209	SO4209
		28.00	1.1024		SO1210	SO3210	SO4210
	1-7/64	28.18	1.1094		SO1261	SO3261	SO4261
	1-1/8	28.58	1.1250		SO1211	SO3211	SO4211
		29.00	1.1417		SO1212	SO3212	SO4212
	1-5/32	29.37	1.1563		SO1213	SO3213	SO4213
		30.00	1.1811		SO1214	SO3214	SO4214
	1-3/16	30.16	1.1875		SO1215	SO3215	SO4215
	1-7/32	30.96	1.2188		SO1216	SO3216	SO4216
		31.00	1.2205		SO1217	SO3217	SO4217
	1-1/4	31.75	1.2500		SO1218	SO3218	SO4218
		32.00	1.2598		SO1219	SO3219	SO4219
	1-9/32	32.54	1.2813		SO1220	SO3220	SO4220
		33.00	1.2992		SO1221	SO3221	SO4221
	1-5/16	33.34	1.3125		SO1222	SO3222	SO4222
		34.00	1.3386		SO1223	SO3223	SO4223
	1-11/32	34.13	1.3438		SO1224	SO3224	SO4224
	1-3/8	34.93	1.3750		SO1225	SO3225	SO4225
		35.00	1.3780		SO1226	SO3226	SO4226
3 1.353 (34.37) to 1.882 (47.80)	1-13/32	35.72	1.4063	1/4 (6.4)	SO1301	SO3301	SO4301
		36.00	1.4173		SO1302	SO3302	SO4302
	1-7/16	36.51	1.4375		SO1303	SO3303	SO4303
		37.00	1.4567		SO1304	SO3304	SO4304
	1-15/32	37.31	1.4688		SO1305	SO3305	SO4305
		38.00	1.4961		SO1306	SO3306	SO4306
	1-1/2	38.10	1.5000		SO1307	SO3307	SO4307
	1-17/32	38.89	1.5313		SO1308	SO3308	SO4308
		39.00	1.5354		SO1309	SO3309	SO4309
	1-9/16	39.69	1.5625		SO1310	SO3310	SO4310
		40.00	1.5748		SO1311	SO3311	SO4311
	1-19/32	40.48	1.5938		SO1312	SO3312	SO4312
		41.00	1.6142		SO1313	SO3313	SO4313
	1-5/8	41.28	1.6250		SO1314	SO3314	SO4314
		42.00	1.6535		SO1315	SO3315	SO4315

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
○	○	○	○		○		○	○			◎	◎	○	◎	◎

SPADE DRILLS

SERIES 3,4

SPADE DRILL INSERTS - HSS M4

- General purpose insert for most materials
- Not recommended for tool steels and high temp alloys
- High toughness for loose or manual machines

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	HSS (M4) TiN	HSS (M4) TiAlN	HSS (M4) Hardslick
3 1.353 (34.37) to 1.882 (47.80)	1-21/32	42.07	1.6563	1/4 (6.4)	SO1316	SO3316	SO4316
	1-11/16	42.86	1.6875		SO1317	SO3317	SO4317
		43.00	1.6929		SO1318	SO3318	SO4318
	1-23/32	43.66	1.7188		SO1319	SO3319	SO4319
		44.00	1.7323		SO1320	SO3320	SO4320
	1-3/4	44.45	1.7500		SO1321	SO3321	SO4321
		45.00	1.7717		SO1322	SO3322	SO4322
	1-25/32	45.24	1.7813		SO1323	SO3323	SO4323
		46.00	1.8110		SO1324	SO3324	SO4324
	1-13/16	46.04	1.8125		SO1325	SO3325	SO4325
	1-27/32	46.83	1.8438		SO1326	SO3326	SO4326
		47.00	1.8504		SO1327	SO3327	SO4327
	1-7/8	47.63	1.8750		SO1328	SO3328	SO4328
4 1.850 (46.99) to 2.570 (65.28)	1-29/32	48.42	1.9063	5/16 (7.9)	SO1402	SO3402	SO4402
	1-15/16	49.21	1.9375		SO1404	SO3404	SO4404
	1-31/32	50.01	1.9688		SO1406	SO3406	SO4406
	2	50.80	2.0000		SO1407	SO3407	SO4407
	2-1/32	51.59	2.0313		SO1409	SO3409	SO4409
	2-3/64	52.00	2.0472		SO1410	SO3410	SO4410
	2-1/16	52.39	2.0625		SO1411	SO3411	SO4411
	2-3/32	53.18	2.0938		SO1413	SO3413	SO4413
	2-1/8	53.98	2.1250		SO1414	SO3414	SO4414
	2-5/32	54.77	2.1563		SO1416	SO3416	SO4416
	2-3/16	55.56	2.1875		SO1418	SO3418	SO4418
	2-7/32	56.36	2.2188		SO1420	SO3420	SO4420
	2-1/4	57.15	2.2500		SO1422	SO3422	SO4422
	2-9/32	57.94	2.2813		SO1423	SO3423	SO4423
	2-5/16	58.74	2.3125		SO1425	SO3425	SO4425
	2-11/32	59.53	2.3438		SO1427	SO3427	SO4427
	2-3/8	60.33	2.3750		SO1429	SO3429	SO4429
	2-13/32	61.12	2.4063		SO1431	SO3431	SO4431
	2-7/16	61.91	2.4375		SO1432	SO3432	SO4432
	2-15/32	62.71	2.4688		SO1434	SO3434	SO4434
	2-1/2	63.50	2.5000		SO1436	SO3436	SO4436

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
○	○	○	○		○		○	○			◎	◎	○	◎	◎

SPADE DRILLS

SERIES 4,5,6,7,8

SPADE DRILL INSERTS - HSS M4

- General purpose insert for most materials
- Not recommended for tool steels and high temp alloys
- High toughness for loose or manual machines

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	HSS (M4) TiN	HSS (M4) TiAlN	HSS (M4) Hardslick
4	2-17/32	64.29	2.5313	5/16 (7.9)	SO1438	SO3438	SO4438
	2-9/16	65.09	2.5625		SO1440	SO3440	SO4440
5 2.456 (62.38) to 3.000 (76.20)	2-1/2	63.50	2.5000	7/16 (11.1)	SO1501	SO3501	SO4501
	2-5/8	66.68	2.6250		SO1507	SO3507	SO4507
	2-3/4	69.85	2.7500		SO1512	SO3512	SO4512
	2-25/32	70.64	2.7813		SO1514	SO3514	SO4514
	2-13/16	71.44	2.8125		SO1515	SO3515	SO4515
	2-27/32	72.23	2.8438		SO1517	SO3517	SO4517
	2-7/8	73.03	2.8750		SO1518	SO3518	SO4518
	2-29/32	73.82	2.9063		SO1519	SO3519	SO4519
	2-15/16	74.61	2.9375		SO1521	SO3521	SO4521
	2-31/32	75.41	2.9688		SO1522	SO3522	SO4522
	3	76.20	3.0000		SO1524	SO3524	SO4524
6 3.001(76.23) to 3.507(89.08)	3-1/16	77.79	3.0625	7/16 (11.1)	SO1602	SO3602	SO4602
	3-1/8	79.38	3.1250		SO1605	SO3605	SO4605
	3-1/4	82.55	3.2500		SO1611	SO3611	SO4611
	3-3/8	85.73	3.3750		SO1616	SO3616	SO4616
	3-7/16	87.31	3.4375		SO1619	SO3619	SO4619
	3-1/2	88.90	3.5000		SO1622	SO3622	SO4622
7 3.455 (87.76) to 4.000 (101.60)	3-9/16	90.49	3.5625	7/16 (11.1)	SO1703	SO3703	SO4703
	3-5/8	92.08	3.6250		SO1706	SO3706	SO4706
	3-3/4	95.25	3.7500		SO1711	SO3711	SO4711
	3-7/8	98.43	3.8750		SO1717	SO3717	SO4717
	4	101.60	4.0000		SO1722	SO3722	SO4722
8 4.001 (101.63) to 4.507 (114.48)	4-1/8	104.78	4.1250	7/16 (11.1)	SO1804	SO3804	SO4804
	4-1/4	107.95	4.2500		SO1807	SO3807	SO4807
	4-3/8	111.13	4.3750		SO1811	SO3811	SO4811
	4-1/2	114.30	4.5000		SO1815	SO3815	SO4815

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
○	○	○	○		○		○	○			◎	◎	○	◎	◎

SPADE DRILLS

SERIES Y,Z,0

SPADE DRILL INSERTS - SUPER COBALT(T15)

- Increase wear resistance over M4
- For use in medium carbon steel to high temperature alloys over 280 Brinell
- Performs best in rigid setups

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	SUPER COBALT(T15) TiN	SUPER COBALT(T15) TiAlN	SUPER COBALT(T15) Hardslick
Y .374 (9.50) to .436 (11.07)		9.50	.3740	3/32 (2.4)	* S06Y01	* S08Y01	* S09Y01
	3/8	9.53	.3750		* S06Y02	* S08Y02	* S09Y02
		9.80	.3860		* S06Y03	* S08Y03	* S09Y03
	25/64	9.92	.3906		* S06Y04	* S08Y04	* S09Y04
		10.00	.3937		* S06Y05	* S08Y05	* S09Y05
		10.20	.4016		* S06Y06	* S08Y06	* S09Y06
	13/32	10.32	.4063		* S06Y07	* S08Y07	* S09Y07
		10.50	.4134		* S06Y08	* S08Y08	* S09Y08
	27/64	10.72	.4219		* S06Y09	* S08Y09	* S09Y09
		10.80	.4252		* S06Y10	* S08Y10	* S09Y10
		11.00	.4331		* S06Y11	* S08Y11	* S09Y11
Z .437 (11.11) to .510 (12.95)	7/16	11.11	.4375	3/32 (2.4)	* S06Z01	* S08Z01	* S09Z01
		11.50	.4528		* S06Z02	* S08Z02	* S09Z02
	29/64	11.51	.4531		* S06Z03	* S08Z03	* S09Z03
	15/32	11.91	.4688		* S06Z04	* S08Z04	* S09Z04
		12.00	.4724		* S06Z05	* S08Z05	* S09Z05
	31/64	12.30	.4844		* S06Z06	* S08Z06	* S09Z06
		12.50	.4921		* S06Z07	* S08Z07	* S09Z07
	1/2	12.70	.5000		* S06Z08	* S08Z08	* S09Z08
0 .511 (12.98) to .695 (17.65)		13.00	.5118	1/8 (3.2)	* S06001	* S08001	* S09001
	33/64	13.10	.5156		* S06002	* S08002	* S09002
	17/32	13.49	.5313		* S06003	* S08003	* S09003
		13.50	.5315		* S06004	* S08004	* S09004
	35/64	13.89	.5469		* S06060	* S08060	* S09060
		14.00	.5512		* S06005	* S08005	* S09005
	9/16	14.29	.5625		* S06006	* S08006	* S09006
		14.50	.5709		* S06007	* S08007	* S09007
	37/64	14.68	.5781		* S06008	* S08008	* S09008
		15.00	.5906		* S06009	* S08009	* S09009
	19/32	15.08	.5938		* S06010	* S08010	* S09010
	39/64	15.48	.6094		* S06061	* S08061	* S09061
		15.50	.6102		* S06011	* S08011	* S09011
	5/8	15.88	.6250		* S06012	* S08012	* S09012

* 2pcs per package

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 0,1

SPADE DRILL INSERTS - SUPER COBALT(T15)

- Increase wear resistance over M4
- For use in medium carbon steel to high temperature alloys over 280 Brinell
- Performs best in rigid setups

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
					SUPER COBALT(T15)		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAlN	Hardslick
0 .511 (12.98) to .695 (17.65)		16.00	.6299	1/8 (3.2)	* SO6013	* SO8013	* SO9013
	41/64	16.27	.6406		* SO6062	* SO8062	* SO9062
		16.50	.6496		* SO6014	* SO8014	* SO9014
	21/32	16.67	.6563		* SO6015	* SO8015	* SO9015
		17.00	.6693		* SO6016	* SO8016	* SO9016
	43/64	17.07	.6719		* SO6063	* SO8063	* SO9063
	11/16	17.46	.6875		* SO6017	* SO8017	* SO9017
		17.50	.6890		* SO6018	* SO8018	* SO9018
1 .690 (17.53) to .960 (24.38)	45/64	17.86	.7031	5/32 (4.0)	SO6101	SO8101	SO9101
		18.00	.7087		SO6102	SO8102	SO9102
	23/32	18.26	.7188		SO6103	SO8103	SO9103
		18.50	.7283		SO6104	SO8104	SO9104
	47/64	18.65	.7344		SO6105	SO8105	SO9105
		19.00	.7480		SO6106	SO8106	SO9106
	3/4	19.05	.7500		SO6107	SO8107	SO9107
	49/64	19.45	.7656		SO6108	SO8108	SO9108
		19.50	.7677		SO6109	SO8109	SO9109
	25/32	19.84	.7813		SO6110	SO8110	SO9110
		20.00	.7874		SO6111	SO8111	SO9111
	51/64	20.24	.7969		SO6160	SO8160	SO9160
		20.50	.8071		SO6112	SO8112	SO9112
	13/16	20.64	.8125		SO6113	SO8113	SO9113
		21.00	.8268		SO6114	SO8114	SO9114
	27/32	21.43	.8438		SO6115	SO8115	SO9115
	55/64	21.83	.8594		SO6161	SO8161	SO9161
		22.00	.8661		SO6116	SO8116	SO9116
	7/8	22.23	.8750		SO6117	SO8117	SO9117
	57/64	22.62	.8906		SO6162	SO8162	SO9162
		23.00	.9055		SO6118	SO8118	SO9118
	29/32	23.02	.9063		SO6119	SO8119	SO9119
	59/64	23.42	.9219		SO6120	SO8120	SO9120
	15/16	23.81	.9375		SO6121	SO8121	SO9121
		24.00	.9449		SO6122	SO8122	SO9122

* 2pcs per package

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 2,3

SPADE DRILL INSERTS - SUPER COBALT(T15)

- Increase wear resistance over M4
- For use in medium carbon steel to high temperature alloys over 280 Brinell
- Performs best in rigid setups

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	SUPER COBALT(T15) TiN	SUPER COBALT(T15) TiAlN	SUPER COBALT(T15) Hardslick
2 .961 (24.41) to 1.380 (35.05)	31/32	24.61	.9688	3/16 (4.8)	S06201	S08201	S09201
	63/64	25.00	.9843		S06202	S08202	S09202
	1	25.40	1.0000		S06203	S08203	S09203
	1-1/64	25.80	1.0156		S06204	S08204	S09204
		26.00	1.0236		S06205	S08205	S09205
	1-1/32	26.19	1.0313		S06206	S08206	S09206
	1-3/64	26.59	1.0469		S06260	S08260	S09260
	1-1/16	26.99	1.0625		S06207	S08207	S09207
		27.00	1.0630		S06208	S08208	S09208
	1-3/32	27.78	1.0938		S06209	S08209	S09209
		28.00	1.1024		S06210	S08210	S09210
	1-7/64	28.18	1.1094		S06261	S08261	S09261
	1-1/8	28.58	1.1250		S06211	S08211	S09211
		29.00	1.1417		S06212	S08212	S09212
	1-5/32	29.37	1.1563		S06213	S08213	S09213
		30.00	1.1811		S06214	S08214	S09214
	1-3/16	30.16	1.1875		S06215	S08215	S09215
	1-7/32	30.96	1.2188		S06216	S08216	S09216
		31.00	1.2205		S06217	S08217	S09217
	1-1/4	31.75	1.2500		S06218	S08218	S09218
		32.00	1.2598		S06219	S08219	S09219
	1-9/32	32.54	1.2813		S06220	S08220	S09220
		33.00	1.2992		S06221	S08221	S09221
	1-5/16	33.34	1.3125		S06222	S08222	S09222
		34.00	1.3386		S06223	S08223	S09223
	1-11/32	34.13	1.3438		S06224	S08224	S09224
	1-3/8	34.93	1.3750		S06225	S08225	S09225
		35.00	1.3780		S06226	S08226	S09226
3	1-13/32	35.72	1.4063	1/4 (6.4)	S06301	S08301	S09301
		36.00	1.4173		S06302	S08302	S09302
	1-7/16	36.51	1.4375		S06303	S08303	S09303
		37.00	1.4567		S06304	S08304	S09304
	1-15/32	37.31	1.4688		S06305	S08305	S09305

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 3,4

SPADE DRILL INSERTS - SUPER COBALT(T15)

- Increase wear resistance over M4
- For use in medium carbon steel to high temperature alloys over 280 Brinell
- Performs best in rigid setups

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
					SUPER COBALT(T15)		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAlN	Hardslick
3 **1.353 (34.37) to 1.882 (47.80)**		38.00	1.4961	1/4 (6.4)	S06306	S08306	S09306
	1-1/2	38.10	1.5000		S06307	S08307	S09307
	1-17/32	38.89	1.5313		S06308	S08308	S09308
		39.00	1.5354		S06309	S08309	S09309
	1-9/16	39.69	1.5625		S06310	S08310	S09310
		40.00	1.5748		S06311	S08311	S09311
	1-19/32	40.48	1.5938		S06312	S08312	S09312
		41.00	1.6142		S06313	S08313	S09313
	1-5/8	41.28	1.6250		S06314	S08314	S09314
		42.00	1.6535		S06315	S08315	S09315
	1-21/32	42.07	1.6563		S06316	S08316	S09316
	1-11/16	42.86	1.6875		S06317	S08317	S09317
		43.00	1.6929		S06318	S08318	S09318
	1-23/32	43.66	1.7188		S06319	S08319	S09319
		44.00	1.7323		S06320	S08320	S09320
	1-3/4	44.45	1.7500		S06321	S08321	S09321
		45.00	1.7717		S06322	S08322	S09322
	1-25/32	45.24	1.7813		S06323	S08323	S09323
		46.00	1.8110		S06324	S08324	S09324
	1-13/16	46.04	1.8125		S06325	S08325	S09325
	1-27/32	46.83	1.8438		S06326	S08326	S09326
		47.00	1.8504		S06327	S08327	S09327
	1-7/8	47.63	1.8750		S06328	S08328	S09328
4 **1.850 (46.99) to 2.570 (65.28)**	1-29/32	48.42	1.9062	5/16 (7.9)	S06402	S08402	S09402
	1-15/16	49.21	1.9375		S06404	S08404	S09404
	1-31/32	50.01	1.9688		S06406	S08406	S09406
	2	50.80	2.0000		S06407	S08407	S09407
	2-1/32	51.59	2.0312		S06409	S08409	S09409
	2-3/64	52.00	2.0472		S06410	S08410	S09410
	2-1/16	52.39	2.0625		S06411	S08411	S09411
	2-3/32	53.18	2.0938		S06413	S08413	S09413
	2-1/8	53.98	2.1250		S06414	S08414	S09414
	2-5/32	54.77	2.1562		S06416	S08416	S09416

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 4,5

SPADE DRILL INSERTS - SUPER COBALT(T15)

- Increase wear resistance over M4
- For use in medium carbon steel to high temperature alloys over 280 Brinell
- Performs best in rigid setups

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	SUPER COBALT(T15) TiN	SUPER COBALT(T15) TiAlN	SUPER COBALT(T15) Hardslick
4 1.850 (46.99) to 2.570 (65.28)	2-3/16	55.56	2.1875	5/16 (7.9)	S06418	S08418	S09418
	2-7/32	56.36	2.2188		S06420	S08420	S09420
	2-1/4	57.15	2.2500		S06422	S08422	S09422
	2-9/32	57.94	2.2812		S06423	S08423	S09423
	2-5/16	58.74	2.3125		S06425	S08425	S09425
	2-11/32	59.53	2.3438		S06427	S08427	S09427
	2-3/8	60.33	2.3750		S06429	S08429	S09429
	2-13/32	61.12	2.4062		S06431	S08431	S09431
	2-7/16	61.91	2.4375		S06432	S08432	S09432
	2-15/32	62.71	2.4688		S06434	S08434	S09434
	2-1/2	63.50	2.5000		S06436	S08436	S09436
	2-17/32	64.29	2.5312		S06438	S08438	S09438
	2-9/16	65.09	2.5625		S06440	S08440	S09440
5 2.456 (62.38) to 3.000 (76.20)	2-1/2	63.50	2.5000	7/16 (11.1)	—	—	S09501
		64.00	2.5197		—	—	S09502
	2-17/32	64.29	2.5312		—	—	S09503
	2-9/16	65.09	2.5625		—	—	S09504
	2-19/32	65.88	2.5938		—	—	S09505
		66.00	2.5984		—	—	S09506
	2-5/8	66.68	2.6250		—	—	S09507
	2-21/32	67.47	2.6562		—	—	S09508
		68.00	2.6772		—	—	S09509
	2-11/16	68.26	2.6875		—	—	S09510
	2-23/32	69.09	2.7188		—	—	S09511
	2-3/4	69.85	2.7500		—	—	S09512
		70.00	2.7559		—	—	S09513
	2-25/32	70.64	2.7812		—	—	S09514
	2-13/16	71.44	2.8125		—	—	S09515
		72.00	2.8346		—	—	S09516
	2-27/32	72.23	2.8438		—	—	S09517
	2-7/8	73.03	2.8750		—	—	S09518
	2-29/32	73.82	2.9062		—	—	S09519
		74.00	2.9134		—	—	S09520

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 5,6,7

SPADE DRILL INSERTS - SUPER COBALT(T15)

- Increase wear resistance over M4
- For use in medium carbon steel to high temperature alloys over 280 Brinell
- Performs best in rigid setups

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
					SUPER COBALT(T15)		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAlN	Hardslick
5	2-15/16	74.61	2.9375	7/16 (11.1)	—	—	S09521
	2-31/32	75.41	2.8688		—	—	S09522
		76.00	2.9921		—	—	S09523
	3	76.20	3.0000		—	—	S09524
6 3.001 (76.23) to 3.507 (89.08)	3-1/32	76.99	3.0312	7/16 (11.1)	—	—	S09601
	3-1/16	77.79	3.0625		—	—	S09602
		78.00	3.0709		—	—	S09603
	3-3/32	78.58	3.0938		—	—	S09604
	3-1/8	79.38	3.1250		—	—	S09605
		80.00	3.1496		—	—	S09606
	3-5/32	80.17	3.1562		—	—	S09607
	3-3/16	80.96	3.1875		—	—	S09608
	3-7/32	81.76	3.2188		—	—	S09609
		82.00	3.2283		—	—	S09610
	3-1/4	82.55	3.2500		—	—	S09611
	3-9/32	83.34	3.2812		—	—	S09612
		84.00	3.3071		—	—	S09613
	3-5/16	84.14	3.3125		—	—	S09614
	3-11/32	84.93	3.3438		—	—	S09615
	3-3/8	85.73	3.3750		—	—	S09616
		86.00	3.3858		—	—	S09617
	3-13/32	86.52	3.3062		—	—	S09618
	3-7/16	87.31	3.4375		—	—	S09619
		88.00	3.4646		—	—	S09620
	3-15/32	88.11	3.4688		—	—	S09621
	3-1/2	88.90	3.5000		—	—	S09622
7 3.455(87.76) to 4.000(101.60)	3-17/32	89.69	3.5312	7/16 (11.1)	—	—	S09701
		90.00	3.5433		—	—	S09702
	3-9/16	90.49	3.5625		—	—	S09703
	3-19/32	91.28	3.5938		—	—	S09704
		92.00	3.6221		—	—	S09705
	3-5/8	92.08	3.6250		—	—	S09706
	3-21/32	92.87	3.6563		—	—	S09707

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 7,8

SPADE DRILL INSERTS - SUPER COBALT(T15)

- Increase wear resistance over M4
- For use in medium carbon steel to high temperature alloys over 280 Brinell
- Performs best in rigid setups

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	SUPER COBALT(T15) TiN	SUPER COBALT(T15) TiAlN	SUPER COBALT(T15) Hardslick
7 3.455 (87.76) to 4.000 (101.60)	3-11/16	93.66	3.6875	7/16 (11.1)	—	—	S09708
		94.00	3.7008		—	—	S09709
	3-23/32	94.46	3.7188		—	—	S09710
	3-3/4	95.25	3.7500		—	—	S09711
		96.00	3.7795		—	—	S09712
	3-25/32	96.04	3.7812		—	—	S09713
	3-13/16	96.84	3.8125		—	—	S09714
	3-27/32	97.63	3.8438		—	—	S09715
		98.00	3.8583		—	—	S09716
	3-7/8	98.43	3.8750		—	—	S09717
	3-29/32	99.22	3.9062		—	—	S09718
		100.00	3.9370		—	—	S09719
	3-15/16	100.01	3.9375		—	—	S09720
	3-31/32	100.81	3.9688		—	—	S09721
	4	101.60	4.0000		—	—	S09722
8 4.001 (101.63) to 4.507 (114.48)	4-1/64	102.00	4.0156	7/16 (11.1)	—	—	S09801
	4-1/16	103.19	4.0625		—	—	S09802
	4-3/32	104.00	4.0945		—	—	S09803
	4-1/8	104.78	4.1250		—	—	S09804
		106.00	4.1732		—	—	S09805
	4-3/16	106.36	4.1875		—	—	S09806
	4-1/4	107.95	4.2500		—	—	S09807
		108.00	4.2520		—	—	S09808
	4-5/16	109.54	4.3125		—	—	S09809
		110.00	4.3307		—	—	S09810
	4-3/8	111.13	4.3750		—	—	S09811
		112.00	4.4094		—	—	S09812
	4-7/16	112.71	4.4375		—	—	S09813
		114.00	4.4882		—	—	S09814
	4-1/2	114.30	4.5000		—	—	S09815

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES Y,Z,0

SPADE DRILL INSERTS - PREMIUM COBALT(M48)

- Increased tool life over T15
- For use in high temperature alloys and materials including medium carbon, Alloy and tool steels with 350~500 Brinell
- Rigid set up needed

POINT ANGLE : 132 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	PREMIUM COBALT(M48) TiN	TiAlN	Hardslick
Y .374 (9.50) to .436 (11.07)		9.50	.3740	3/32 (2.4)	* S11Y01	* S13Y01	* S14Y01
	3/8	9.53	.3750		* S11Y02	* S13Y02	* S14Y02
		9.80	.3860		* S11Y03	* S13Y03	* S14Y03
	25/64	9.92	.3906		* S11Y04	* S13Y04	* S14Y04
		10.00	.3937		* S11Y05	* S13Y05	* S14Y05
		10.20	.4016		* S11Y06	* S13Y06	* S14Y06
	13/32	10.32	.4063		* S11Y07	* S13Y07	* S14Y07
		10.50	.4134		* S11Y08	* S13Y08	* S14Y08
	27/64	10.72	.4219		* S11Y09	* S13Y09	* S14Y09
		10.80	.4252		* S11Y10	* S13Y10	* S14Y10
		11.00	.4331		* S11Y11	* S13Y11	* S14Y11
Z .437 (11.11) to .510 (12.95)	7/16	11.11	.4375	3/32 (2.4)	* S11Z01	* S13Z01	* S14Z01
		11.50	.4528		* S11Z02	* S13Z02	* S14Z02
	29/64	11.51	.4531		* S11Z03	* S13Z03	* S14Z03
	15/32	11.91	.4688		* S11Z04	* S13Z04	* S14Z04
		12.00	.4724		* S11Z05	* S13Z05	* S14Z05
	31/64	12.30	.4844		* S11Z06	* S13Z06	* S14Z06
		12.50	.4921		* S11Z07	* S13Z07	* S14Z07
	1/2	12.70	.5000		* S11Z08	* S13Z08	* S14Z08
0 .511 (12.98) to .695 (17.65)		13.00	.5118	1/8 (3.2)	* S11001	* S13001	* S14001
	33/64		.5156		* S11002	* S13002	* S14002
	17/32		.5313		* S11003	* S13003	* S14003
		13.50	.5315		* S11004	* S13004	* S14004
	35/64		.5469		* S11060	* S13060	* S14060
		14.00	.5512		* S11005	* S13005	* S14005
	9/16		.5625		* S11006	* S13006	* S14006
		14.50	.5709		* S11007	* S13007	* S14007
	37/64		.5781		* S11008	* S13008	* S14008
		15.00	.5906		* S11009	* S13009	* S14009
	19/32		.5938		* S11010	* S13010	* S14010
	39/64		.6094		* S11061	* S13061	* S14061
		15.50	.6102		* S11011	* S13011	* S14011
	5/8		.6250		* S11012	* S13012	* S14012

* 2pcs per package

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	○	○

SPADE DRILLS

SERIES 0,1

SPADE DRILL INSERTS - PREMIUM COBALT(M48)

- Increased tool life over T15
- For use in high temperature alloys and materials including medium carbon, Alloy and tool steels with 350~500 Brinell
- Rigid set up needed

POINT ANGLE : 132 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	PREMIUM COBALT(M48) TiN	TiAlN	Hardslick
0 .511 (12.98) to .695 (17.65)		16.00	.6299	1/8 (3.2)	* S11013	* S13013	* S14013
	41/64		.6406		* S11062	* S13062	* S14062
		16.50	.6496		* S11014	* S13014	* S14014
	21/32		.6563		* S11015	* S13015	* S14015
		17.00	.6693		* S11016	* S13016	* S14016
	43/64		.6719		* S11063	* S13063	* S14063
	11/16		.6875		* S11017	* S13017	* S14017
		17.50	.6890		* S11018	* S13018	* S14018
1 .690 (17.53) to .960 (24.38)	45/64	17.86	.7031	5/32 (4.0)	S11101	S13101	S14101
		18.00	.7087		S11102	S13102	S14102
	23/32	18.26	.7188		S11103	S13103	S14103
		18.50	.7283		S11104	S13104	S14104
	47/64	18.65	.7344		S11105	S13105	S14105
		19.00	.7480		S11106	S13106	S14106
	3/4	19.05	.7500		S11107	S13107	S14107
	49/64	19.45	.7656		S11108	S13108	S14108
		19.50	.7677		S11109	S13109	S14109
	25/32	19.84	.7812		S11110	S13110	S14110
		20.00	.7874		S11111	S13111	S14111
	51/64	20.24	.7969		S11160	S13160	S14160
		20.50	.8071		S11112	S13112	S14112
	13/16	20.64	.8125		S11113	S13113	S14113
		21.00	.8268		S11114	S13114	S14114
	27/32	21.43	.8438		S11115	S13115	S14115
	55/64	21.83	.8594		S11161	S13161	S14161
		22.00	.8661		S11116	S13116	S14116
	7/8	22.23	.8750		S11117	S13117	S14117
	57/64	22.62	.8906		S11162	S13162	S14162
		23.00	.9055		S11118	S13118	S14118
	29/32	23.02	.9062		S11119	S13119	S14119
	59/64	23.42	.9219		S11120	S13120	S14120
	15/16	23.81	.9375		S11121	S13121	S14121
		24.00	.9449		S11122	S13122	S14122

* 2pcs per package

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	○	○

SPADE DRILLS

SERIES 2

SPADE DRILL INSERTS - PREMIUM COBALT(M48)

- Increased tool life over T15
- For use in high temperature alloys and materials including medium carbon, Alloy and tool steels with 350~500 Brinell
- Rigid set up needed

POINT ANGLE : 132 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.		
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	PREMIUM COBALT(M48) TiN	PREMIUM COBALT(M48) TiAlN	PREMIUM COBALT(M48) Hardslick
2 .961 (24.41) to 1.380 (35.05)	31/32	24.61	.9688	3/16 (4.8)	S11201	S13201	S14201
	63/64	25.00	.9843		S11202	S13202	S14202
	1	25.40	1.0000		S11203	S13203	S14203
	1-1/64	25.80	1.0156		S11204	S13204	S14204
		26.00	1.0236		S11205	S13205	S14205
	1-1/32	26.19	1.0312		S11206	S13206	S14206
	1-3/64	26.59	1.0469		S11260	S13260	S14260
	1-1/16	26.99	1.0625		S11207	S13207	S14207
		27.00	1.0630		S11208	S13208	S14208
	1-3/32	27.78	1.0938		S11209	S13209	S14209
		28.00	1.1024		S11210	S13210	S14210
	1-7/64	28.18	1.1094		S11261	S13261	S14261
	1-1/8	28.58	1.1250		S11211	S13211	S14211
		29.00	1.1417		S11212	S13212	S14212
	1-5/32	29.37	1.1562		S11213	S13213	S14213
		30.00	1.1811		S11214	S13214	S14214
	1-3/16	30.16	1.1875		S11215	S13215	S14215
	1-7/32	30.96	1.2188		S11216	S13216	S14216
		31.00	1.2205		S11217	S13217	S14217
	1-1/4	31.75	1.2500		S11218	S13218	S14218
		32.00	1.2598		S11219	S13219	S14219
	1-9/32	32.54	1.2812		S11220	S13220	S14220
		33.00	1.2992		S11221	S13221	S14221
	1-5/16	33.34	1.3125		S11222	S13222	S14222
		34.00	1.3386		S11223	S13223	S14223
	1-11/32	34.13	1.3438		S11224	S13224	S14224
	1-3/8	34.93	1.3750		S11225	S13225	S14225
		35.00	1.3780		S11226	S13226	S14226

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	○	○

SPADE DRILLS

SERIES Y,Z

CARBIDE BLADE INSERTS(C2,C5,C3)

- High performance on Gray cast iron over 220 Brinell, malleable cast iron with short chips, silicon aluminum and copper alloys. (C3)
- For general use in carbon steels and alloys steels. (C5)
- For use in Gray cast iron up to 220 Brinell, nonferrous metals,copper, brass and aluminum. (C2)

POINT ANGLE : 132 degree

cutting conditions : p.279

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.					
					Multi purpose Geometry				Cast Iron Geometry	
					C2(K20)		C5(P40)		C3(K10)	
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAIN	TiN	TiAIN	TiN	TiAIN
Y .374 (9.50) to .436 (11.07)		9.50	.3740	3/32 (2.4)	* S21Y01	* S23Y01	* S26Y01	* S28Y01	* S16Y01	* S18Y01
	3/8	9.53	.3750		* S21Y02	* S23Y02	* S26Y02	* S28Y02	* S16Y02	* S18Y02
		9.80	.3860		* S21Y03	* S23Y03	* S26Y03	* S28Y03	* S16Y03	* S18Y03
	25/64	9.92	.3906		* S21Y04	* S23Y04	* S26Y04	* S28Y04	* S16Y04	* S18Y04
		10.00	.3937		* S21Y05	* S23Y05	* S26Y05	* S28Y05	* S16Y05	* S18Y05
		10.20	.4016		* S21Y06	* S23Y06	* S26Y06	* S28Y06	* S16Y06	* S18Y06
	13/32	10.32	.4063		* S21Y07	* S23Y07	* S26Y07	* S28Y07	* S16Y07	* S18Y07
		10.50	.4134		* S21Y08	* S23Y08	* S26Y08	* S28Y08	* S16Y08	* S18Y08
	27/64	10.72	.4219		* S21Y09	* S23Y09	* S26Y09	* S28Y09	* S16Y09	* S18Y09
		10.80	.4252		* S21Y10	* S23Y10	* S26Y10	* S28Y10	* S16Y10	* S18Y10
		11.00	.4331		* S21Y11	* S23Y11	* S26Y11	* S28Y11	* S16Y11	* S18Y11
Z .437 (11.11) to .510 (12.95)	7/16	11.11	.4375	3/32 (2.4)	* S21Z01	* S23Z01	* S26Z01	* S28Z01	* S16Z01	* S18Z01
		11.50	.4528		* S21Z02	* S23Z02	* S26Z02	* S28Z02	* S16Z02	* S18Z02
	29/64	11.51	.4531		* S21Z03	* S23Z03	* S26Z03	* S28Z03	* S16Z03	* S18Z03
	15/32	11.91	.4688		* S21Z04	* S23Z04	* S26Z04	* S28Z04	* S16Z04	* S18Z04
		12.00	.4724		* S21Z05	* S23Z05	* S26Z05	* S28Z05	* S16Z05	* S18Z05
	31/64	12.30	.4844		* S21Z06	* S23Z06	* S26Z06	* S28Z06	* S16Z06	* S18Z06
		12.50	.4921		* S21Z07	* S23Z07	* S26Z07	* S28Z07	* S16Z07	* S18Z07
	1/2	12.70	.5000		* S21Z08	* S23Z08	* S26Z08	* S28Z08	* S16Z08	* S18Z08

* 2pcs per package

◎ : Excellent ○ : Good

	P											M	K		N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
C2	○	○	○	○	○	◎	◎	○	○	○	○	◎	○	○	◎	◎
C5	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○
C3													◎	◎		

SPADE DRILLS

SERIES 0

CARBIDE BLADE INSERTS(C2,C5,C3)

- High performance on Gray cast iron over 220 Brinell, malleable cast iron with short chips, silicon aluminum and copper alloys. (C3)
- For general use in carbon steels and alloys steels. (C5)
- For use in Gray cast iron up to 220 Brinell, nonferrous metals,copper, brass and aluminum. (C2)

POINT ANGLE : 132 degree

cutting conditions : p.279

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.					
					Multi purpose Geometry				Cast Iron Geometry	
					C2(K20)		C5(P40)		C3(K10)	
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAlN	TiN	TiAlN	TiN	TiAlN
0 .511 (12.98) to .695 (17.65)		13.00	.5118	1/8 (3.2)	* S21001	* S23001	* S26001	* S28001	* S16001	* S18001
	33/64	13.10	.5156		* S21002	* S23002	* S26002	* S28002	* S16002	* S18002
	17/32	13.49	.5313		* S21003	* S23003	* S26003	* S28003	* S16003	* S18003
		13.50	.5315		* S21004	* S23004	* S26004	* S28004	* S16004	* S18004
	35/64	13.89	.5469		* S21060	* S23060	* S26060	* S28060	* S16060	* S18060
		14.00	.5512		* S21005	* S23005	* S26005	* S28005	* S16005	* S18005
	9/16	14.29	.5625		* S21006	* S23006	* S26006	* S28006	* S16006	* S18006
		14.50	.5709		* S21007	* S23007	* S26007	* S28007	* S16007	* S18007
	37/64	14.68	.5781		* S21008	* S23008	* S26008	* S28008	* S16008	* S18008
		15.00	.5906		* S21009	* S23009	* S26009	* S28009	* S16009	* S18009
	19/32	15.08	.5938		* S21010	* S23010	* S26010	* S28010	* S16010	* S18010
	39/64	15.48	.6094		* S21061	* S23061	* S26061	* S28061	* S16061	* S18061
		15.50	.6102		* S21011	* S23011	* S26011	* S28011	* S16011	* S18011
		15.70	.6181		* S21064	* S23064	* S26064	* S28064	* S16064	* S18064
	5/8	15.88	.6250		* S21012	* S23012	* S26012	* S28012	* S16012	* S18012
		16.00	.6299		* S21013	* S23013	* S26013	* S28013	* S16013	* S18013
	41/64	16.27	.6406		* S21062	* S23062	* S26062	* S28062	* S16062	* S18062
		16.50	.6496		* S21014	* S23014	* S26014	* S28014	* S16014	* S18014
	21/32	16.67	.6563		* S21015	* S23015	* S26015	* S28015	* S16015	* S18015
		17.00	.6693		* S21016	* S23016	* S26016	* S28016	* S16016	* S18016
	43/64	17.07	.6719		* S21063	* S23063	* S26063	* S28063	* S16063	* S18063
	11/16	17.46	.6875		* S21017	* S23017	* S26017	* S28017	* S16017	* S18017
		17.50	.6890		* S21018	* S23018	* S26018	* S28018	* S16018	* S18018

* 2pcs per package

◎ : Excellent ○ : Good

	P											M	K			N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron			Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)		~HRc8 (~HB180)	~HB110
C2	○	○	○	○	○	◎	◎	○	○	○	○	◎	○	○		◎	◎
C5	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○		○	○
C3													◎	◎			

SPADE DRILLS

SERIES 1

CARBIDE BLADE INSERTS(C2,C5,C3)

- High performance on Gray cast iron over 220 Brinell, malleable cast iron with short chips, silicon aluminum and copper alloys. (C3)
- For general use in carbon steels and alloys steels. (C5)
- For use in Gray cast iron up to 220 Brinell, nonferrous metals,copper, brass and aluminum. (C2)

POINT ANGLE : 132 degree

cutting conditions : p.279

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.					
					Multi purpose Geometry				Cast Iron Geometry	
					C2(K20)		C5(P40)		C3(K10)	
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAlN	TiN	TiAlN	TiN	TiAlN
1 .690 (17.53) to .960 (24.38)	45/64	17.86	.7031	5/32 (4.0)	S21101	S23101	S26101	S28101	S16101	S18101
		18.00	.7087		S21102	S23102	S26102	S28102	S16102	S18102
	23/32	18.26	.7188		S21103	S23103	S26103	S28103	S16103	S18103
		18.50	.7283		S21104	S23104	S26104	S28104	S16104	S18104
	47/64	18.65	.7344		S21105	S23105	S26105	S28105	S16105	S18105
		19.00	.7480		S21106	S23106	S26106	S28106	S16106	S18106
	3/4	19.05	.7500		S21107	S23107	S26107	S28107	S16107	S18107
	49/64	19.45	.7656		S21108	S23108	S26108	S28108	S16108	S18108
		19.50	.7677		S21109	S23109	S26109	S28109	S16109	S18109
	25/32	19.84	.7813		S21110	S23110	S26110	S28110	S16110	S18110
		20.00	.7874		S21111	S23111	S26111	S28111	S16111	S18111
	51/64	20.24	.7969		S21160	S23160	S26160	S28160	S16160	S18160
		20.50	.8071		S21112	S23112	S26112	S28112	S16112	S18112
	13/16	20.64	.8125		S21113	S23113	S26113	S28113	S16113	S18113
		21.00	.8268		S21114	S23114	S26114	S28114	S16114	S18114
	27/32	21.43	.8438		S21115	S23115	S26115	S28115	S16115	S18115
	55/64	21.83	.8594		S21161	S23161	S26161	S28161	S16161	S18161
		22.00	.8661		S21116	S23116	S26116	S28116	S16116	S18116
	7/8	22.23	.8750		S21117	S23117	S26117	S28117	S16117	S18117
	57/64	22.62	.8906		S21162	S23162	S26162	S28162	S16162	S18162
		23.00	.9055		S21118	S23118	S26118	S28118	S16118	S18118
	29/32	23.02	.9063		S21119	S23119	S26119	S28119	S16119	S18119
	59/64	23.42	.9219		S21120	S23120	S26120	S28120	S16120	S18120
	15/16	23.81	.9375		S21121	S23121	S26121	S28121	S16121	S18121
		24.00	.9449		S21122	S23122	S26122	S28122	S16122	S18122

◎ : Excellent ○ : Good

	P											M	K		N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
C2	○	○	○	○	○	◎	◎	○	○	○	○	◎	○	○	◎	◎
C5	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○
C3													◎	◎		

SPADE DRILLS

SERIES 2

CARBIDE BLADE INSERTS(C2,C5,C3)

- High performance on Gray cast iron over 220 Brinell, malleable cast iron with short chips, silicon aluminum and copper alloys. (C3)
- For general use in carbon steels and alloys steels. (C5)
- For use in Gray cast iron up to 220 Brinell, nonferrous metals,copper, brass and aluminum. (C2)

POINT ANGLE : 132 degree

cutting conditions : p.279

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.					
					Multi purpose Geometry				Cast Iron Geometry	
					C2(K20)		C5(P40)		C3(K10)	
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAlN	TiN	TiAlN	TiN	TiAlN
2 .961 (24.41) to 1.380 (35.05)	31/32	24.61	.9688	3/16 (4.8)	S21201	S23201	S26201	S28201	S16201	S18201
	63/64	25.00	.9843		S21202	S23202	S26202	S28202	S16202	S18202
	1	25.40	1.0000		S21203	S23203	S26203	S28203	S16203	S18203
	1-1/64	25.80	1.0156		S21204	S23204	S26204	S28204	S16204	S18204
		26.00	1.0236		S21205	S23205	S26205	S28205	S16205	S18205
	1-1/32	26.19	1.0313		S21206	S23206	S26206	S28206	S16206	S18206
	1-3/64	26.59	1.0469		S21260	S23260	S26260	S28260	S16260	S18260
	1-1/16	26.99	1.0625		S21207	S23207	S26207	S28207	S16207	S18207
		27.00	1.0630		S21208	S23208	S26208	S28208	S16208	S18208
	1-3/32	27.78	1.0938		S21209	S23209	S26209	S28209	S16209	S18209
		28.00	1.1024		S21210	S23210	S26210	S28210	S16210	S18210
	1-7/64	28.18	1.1094		S21261	S23261	S26261	S28261	S16261	S18261
	1-1/8	28.58	1.1250		S21211	S23211	S26211	S28211	S16211	S18211
		29.00	1.1417		S21212	S23212	S26212	S28212	S16212	S18212
	1-5/32	29.37	1.1563		S21213	S23213	S26213	S28213	S16213	S18213
		30.00	1.1811		S21214	S23214	S26214	S28214	S16214	S18214
	1-3/16	30.16	1.1875		S21215	S23215	S26215	S28215	S16215	S18215
	1-7/32	30.96	1.2188		S21216	S23216	S26216	S28216	S16216	S18216
		31.00	1.2205		S21217	S23217	S26217	S28217	S16217	S18217
	1-1/4	31.75	1.2500		S21218	S23218	S26218	S28218	S16218	S18218
		32.00	1.2598		S21219	S23219	S26219	S28219	S16219	S18219
	1-9/32	32.54	1.2813		S21220	S23220	S26220	S28220	S16220	S18220
		33.00	1.2992		S21221	S23221	S26221	S28221	S16221	S18221
	1-5/16	33.34	1.3125		S21222	S23222	S26222	S28222	S16222	S18222
		34.00	1.3386		S21223	S23223	S26223	S28223	S16223	S18223
	1-11/32	34.13	1.3438		S21224	S23224	S26224	S28224	S16224	S18224
	1-3/8	34.93	1.3750		S21225	S23225	S26225	S28225	S16225	S18225
		35.00	1.3780		S21226	S23226	S26226	S28226	S16226	S18226

◎ : Excellent ○ : Good

	P											M	K			N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron			Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)		~HRc8 (~HB180)	~HB110
C2	○	○	○	○	○	◎	◎	○	○	○	○	◎	○	○		◎	◎
C5	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○		○	○
C3													◎	◎			

SPADE DRILLS

SERIES 3

CARBIDE BLADE INSERTS(C2,C5,C3)

- High performance on Gray cast iron over 220 Brinell, malleable cast iron with short chips, silicon aluminum and copper alloys. (C3)
- For general use in carbon steels and alloys steels. (C5)
- For use in Gray cast iron up to 220 Brinell, nonferrous metals,copper, brass and aluminum. (C2)

POINT ANGLE : 132 degree

cutting conditions : p.279

Series Min. to Max. (inch/mm)	Diameter			Thick	EDP No.					
					Multi purpose Geometry				Cast Iron Geometry	
					C2(K20)		C5(P40)		C3(K10)	
	Fractional (inch)	Metric (mm)	Decimal (inch)	Metric (inch/mm)	TiN	TiAlN	TiN	TiAlN	TiN	TiAlN
3 1.353 (34.37) to 1.882 (47.80)	1-13/32	35.72	1.4063	1/4 (6.4)	S21301	S23301	S26301	S28301	Special or non-standard inserts available on request	
		36.00	1.4173		S21302	S23302	S26302	S28302		
	1-7/16	36.51	1.4375		S21303	S23303	S26303	S28303		
		37.00	1.4567		S21304	S23304	S26304	S28304		
	1-15/32	37.31	1.4688		S21305	S23305	S26305	S28305		
		38.00	1.4961		S21306	S23306	S26306	S28306		
	1-1/2	38.10	1.5000		S21307	S23307	S26307	S28307		
	1-17/32	38.89	1.5313		S21308	S23308	S26308	S28308		
		39.00	1.5354		S21309	S23309	S26309	S28309		
	1-9/16	39.69	1.5625		S21310	S23310	S26310	S28310		
		40.00	1.5748		S21311	S23311	S26311	S28311		
	1-19/32	40.48	1.5938		S21312	S23312	S26312	S28312		
		41.00	1.6142		S21313	S23313	S26313	S28313		
	1-5/8	41.28	1.6250		S21314	S23314	S26314	S28314		
		42.00	1.6535		S21315	S23315	S26315	S28315		
	1-21/32	42.07	1.6563		S21316	S23316	S26316	S28316		
	1-11/16	42.86	1.6875		S21317	S23317	S26317	S28317		
		43.00	1.6929		S21318	S23318	S26318	S28318		
	1-23/32	43.66	1.7188		S21319	S23319	S26319	S28319		
		44.00	1.7323		S21320	S23320	S26320	S28320		
	1-3/4	44.45	1.7500		S21321	S23321	S26321	S28321		
		45.00	1.7717		S21322	S23322	S26322	S28322		
	1-25/32	45.24	1.7813		S21323	S23323	S26323	S28323		
		46.00	1.8110		S21324	S23324	S26324	S28324		
	1-13/16	46.04	1.8125		S21325	S23325	S26325	S28325		
	1-27/32	46.83	1.8438		S21326	S23326	S26326	S28326		
		47.00	1.8504		S21327	S23327	S26327	S28327		
	1-7/8	47.63	1.8750		S21328	S23328	S26328	S28328		

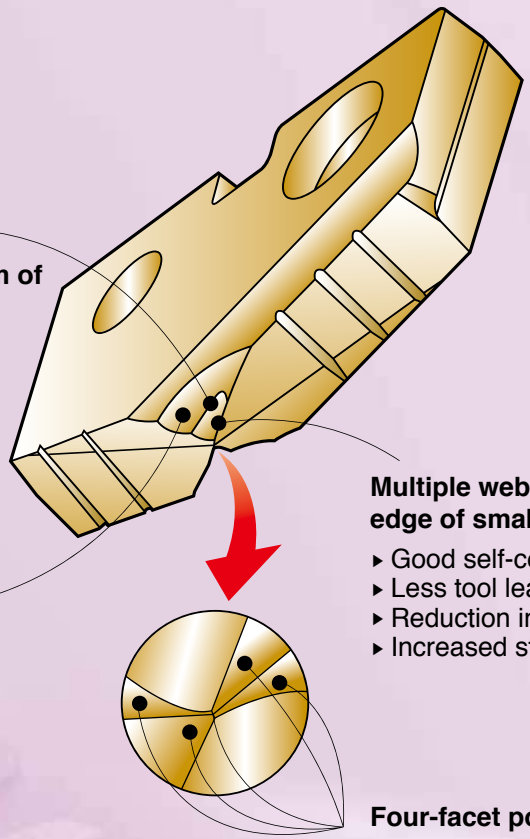
◎ : Excellent ○ : Good

	P											M	K		N	
	Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
	~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
C2	○	○	○	○	○	◎	◎	○	○	○	○	◎	○	○	◎	◎
C5	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○
C3													◎	◎		

Special features of SM-Point Spade Drill

This new “Hybrid Point” combines the strength of the standard point with additional “Web Thinning”.

This new point increases stability, reduces thrust, improves centering and allows increased speeds and feeds.



Multiple thinning form at the bottom of the large thinning.

- The optimum thinning for the difference from the cutting speed, the cutting quantity and the cutting load according to the distance from the drill point to the cutting edge.

Multiple web thinning with the cutting edge of small web thinning.

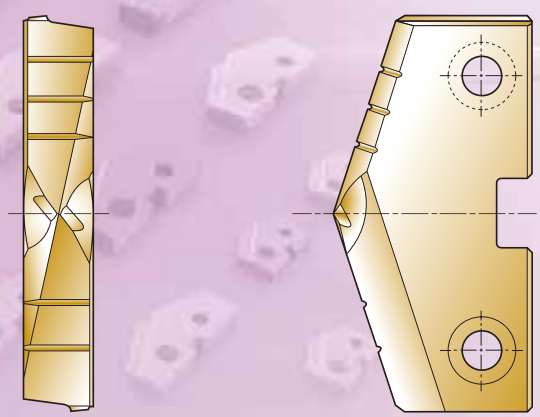
- Good self-centering
- Less tool lead off
- Reduction in bell mouthing, thrust
- Increased stability

Radius back face

- Wide chip space

Four-facet point

- Self-centering
- Less thrust force



SPADE DRILLS

SERIES Y,Z,0,1

SM-POINT SPADE DRILL INSERTS - SUPER COBALT(T15)

- Improved stability and hole straightness by newly developed thinning design.
- Less thrust force and excellent self-centering.
- Any non-standard size available.

POINT ANGLE : 132 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter Fractional (inch)	Diameter Metric (mm)	Diameter Decimal (inch)	EDP No. TiAlN
Y .374 (9.50) to .436 (11.07) Thick 3/32 (2.4)		9.50	.3740	* SM08Y01
	3/8	9.53	.3750	* SM08Y02
		9.80	.3858	* SM08Y03
	25/64	9.92	.3906	* SM08Y04
		10.00	.3937	* SM08Y05
		10.20	.4016	* SM08Y06
	13/32	10.32	.4062	* SM08Y07
		10.50	.4134	* SM08Y08
	27/64	10.72	.4219	* SM08Y09
		10.80	.4252	* SM08Y10
		11.00	.4331	* SM08Y11
Z .437 (11.11) to .510 (12.95) 3/32(2.4)	7/16	11.11	.4375	* SM08Z01
		11.50	.4528	* SM08Z02
	29/64	11.51	.4531	* SM08Z03
	15/32	11.91	.4688	* SM08Z04
		12.00	.4724	* SM08Z05
	31/64	12.30	.4844	* SM08Z06
		12.50	.4921	* SM08Z07
	1/2	12.70	.5000	* SM08Z08
0 .511 (12.98) to .695 (17.65) Thick 1/8 (3.2)		13.00	.5118	* SM08001
	33/64	13.10	.5156	* SM08002
	17/32	13.49	.5312	* SM08003
		13.50	.5315	* SM08004
	35/64	13.89	.5469	* SM08060
		14.00	.5512	* SM08005
	9/16	14.29	.5625	* SM08006
		14.50	.5709	* SM08007
	37/64	14.68	.5781	* SM08008
		15.00	.5906	* SM08009
	19/32	15.08	.5938	* SM08010
	39/64	15.48	.6094	* SM08061
		15.50	.6102	* SM08011
	5/8	15.88	.6250	* SM08012

Series Min. to Max. (inch/mm)	Diameter Fractional (inch)	Diameter Metric (mm)	Diameter Decimal (inch)	EDP No. TiAlN
0 .511 (12.98) to .695 (17.65)		16.00	.6299	* SM08013
	41/64	16.27	.6406	* SM08062
		16.50	.6496	* SM08014
	21/32	16.67	.6562	* SM08015
		17.00	.6693	* SM08016
	43/64	17.07	.6719	* SM08063
	11/16	17.46	.6875	* SM08017
		17.50	.6890	* SM08018
1 .690 (17.53) to .960 (24.38) Thick 5/32 (4.0)	45/64	17.86	.7031	SM08101
		18.00	.7087	SM08102
	23/32	18.26	.7188	SM08103
		18.50	.7283	SM08104
	47/64	18.65	.7344	SM08105
		19.00	.7480	SM08106
	3/4	19.05	.7500	SM08107
	49/64	19.45	.7656	SM08108
		19.50	.7677	SM08109
	25/32	19.84	.7812	SM08110
		20.00	.7874	SM08111
	51/64	20.24	.7969	SM08160
		20.50	.8071	SM08112
	13/16	20.64	.8125	SM08113
		21.00	.8268	SM08114
	27/32	21.43	.8438	SM08115
	55/64	21.83	.8594	SM08161
		22.00	.8661	SM08116
	7/8	22.23	.8750	SM08117
	57/64	22.62	.8906	SM08162
		23.00	.9055	SM08118
	29/32	23.02	.9062	SM08119
	59/64	23.42	.9219	SM08120
	15/16	23.81	.9375	SM08121
		24.00	.9449	SM08122

* 2pcs per package

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 2,3

SM-POINT SPADE DRILL INSERTS - SUPER COBALT(T15)

- Improved stability and hole straightness by newly developed thinning design.
- Less thrust force and excellent self-centering.
- Any non-standard size available.

POINT ANGLE : 132 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			EDP No.
	Fractional (inch)	Metric (mm)	Decimal (inch)	TiAlN
2 .961 (24.41) to 1.380 (35.05) Thick 3/16 (4.8)	31/32	24.61	.9688	SM08201
	63/64	25.00	.9843	SM08202
	1	25.40	1.0000	SM08203
	1-1/64	25.80	1.0156	SM08204
		26.00	1.0236	SM08205
	1-1/32	26.19	1.0312	SM08206
	1-3/64	26.59	1.0469	SM08260
	1-1/16	26.99	1.0625	SM08207
		27.00	1.0630	SM08208
	1-3/32	27.78	1.0938	SM08209
		28.00	1.1024	SM08210
	1-7/64	28.18	1.1094	SM08261
	1-1/8	28.58	1.1250	SM08211
		29.00	1.1417	SM08212
	1-5/32	29.37	1.1562	SM08213
		30.00	1.1811	SM08214
	1-3/16	30.16	1.1875	SM08215
	1-7/32	30.96	1.2188	SM08216
		31.00	1.2205	SM08217
	1-1/4	31.75	1.2500	SM08218
		32.00	1.2598	SM08219
	1-9/32	32.54	1.2812	SM08220
		33.00	1.2992	SM08221
	1-5/16	33.34	1.3125	SM08222
		34.00	1.3386	SM08223
	1-11/32	34.13	1.3438	SM08224
	1-3/8	34.93	1.3750	SM08225
		35.00	1.3780	SM08226

Series Min. to Max. (inch/mm)	Diameter			EDP No.
	Fractional (inch)	Metric (mm)	Decimal (inch)	TiAlN
3 1.353 (34.37) to 1.882 (47.80) Thick 1/4 (6.4)	1-13/32	35.72	1.4062	SM08301
		36.00	1.4173	SM08302
	1-7/16	36.51	1.4375	SM08303
		37.00	1.4567	SM08304
	1-15/32	37.31	1.4688	SM08305
		38.00	1.4961	SM08306
	1-1/2	38.10	1.5000	SM08307
	1-17/32	38.89	1.5312	SM08308
		39.00	1.5354	SM08309
	1-9/16	39.69	1.5625	SM08310
		40.00	1.5748	SM08311
	1-19/32	40.48	1.5938	SM08312
		41.00	1.6142	SM08313
	1-5/8	41.28	1.6250	SM08314
		42.00	1.6535	SM08315
	1-21/32	42.07	1.6562	SM08316
	1-11/16	42.86	1.6875	SM08317
		43.00	1.6929	SM08318
	1-23/32	43.66	1.7188	SM08319
		44.00	1.7323	SM08320
	1-3/4	44.45	1.7500	SM08321
		45.00	1.7717	SM08322
	1-25/32	45.24	1.7812	SM08323
		46.00	1.8110	SM08324
	1-13/16	46.04	1.8125	SM08325
	1-27/32	46.83	1.8438	SM08326
		47.00	1.8504	SM08327
	1-7/8	47.63	1.8750	SM08328

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 4,5

SM-POINT SPADE DRILL INSERTS - SUPER COBALT(T15)

- Improved stability and hole straightness by newly developed thinning design.
- Less thrust force and excellent self-centering.
- Any non-standard size available.

POINT ANGLE **- under 2-1/2 : 132 degree**
- over 2-1/2 : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter			EDP No.
	Fractional (inch)	Metric (mm)	Decimal (inch)	TiAlN
4 **1.850 (46.99) to 2.570 (65.28)** **Thick** 5/16 (7.9)		48.00	1.8898	SM08401
	1-29/32	48.42	1.9062	SM08402
		49.00	1.9291	SM08403
	1-15/16	49.21	1.9375	SM08404
		50.00	1.9685	SM08405
	1-31/32	50.01	1.9688	SM08406
	2	50.80	2.0000	SM08407
		51.00	2.0079	SM08408
	2-1/32	51.59	2.0312	SM08409
	2-3/64	52.00	2.0472	SM08410
	2-1/16	52.39	2.0625	SM08411
		53.00	2.0866	SM08412
	2-3/32	53.18	2.0938	SM08413
	2-1/8	53.98	2.1250	SM08414
		54.00	2.1260	SM08415
	2-5/32	54.77	2.1562	SM08416
		55.00	2.1654	SM08417
	2-3/16	55.56	2.1875	SM08418
		56.00	2.2047	SM08419
	2-7/32	56.36	2.2188	SM08420
		57.00	2.2441	SM08421
	2-1/4	57.15	2.2500	SM08422
	2-9/32	57.94	2.2812	SM08423
		58.00	2.2835	SM08424
	2-5/16	58.74	2.3125	SM08425
		59.00	2.3228	SM08426
	2-11/32	59.53	2.3438	SM08427
		60.00	2.3622	SM08428
	2-3/8	60.33	2.3750	SM08429
		61.00	2.4016	SM08430
	2-13/32	61.12	2.4062	SM08431
	2-7/16	61.91	2.4375	SM08432

Series Min. to Max. (inch/mm)	Diameter			EDP No.
	Fractional (inch)	Metric (mm)	Decimal (inch)	TiAlN
4 **1.850 (46.99) to 2.570 (65.28)**		62.00	2.4409	SM08433
	2-15/32	62.71	2.4688	SM08434
		63.00	2.4803	SM08435
	2-1/2	63.50	2.5000	SM08436
		64.00	2.5197	SM08437
	2-17/32	64.29	2.5312	SM08438
		65.00	2.5591	SM08439
	2-9/16	65.09	2.5625	SM08440
5 **2.456 (62.38) to 3.000 (76.20)** **Thick** 7/16 (11.1)	2-1/2	63.50	2.5000	SM08501
		64.00	2.5197	SM08502
	2-17/32	64.29	2.5312	SM08503
	2-9/16	65.09	2.5625	SM08504
	2-19/32	65.88	2.5938	SM08505
		66.00	2.5984	SM08506
	2-5/8	66.68	2.6250	SM08507
	2-21/32	67.47	2.6562	SM08508
		68.00	2.6772	SM08509
	2-11/16	68.26	2.6875	SM08510
	2-23/32	69.05	2.7188	SM08511
	2-3/4	69.85	2.7500	SM08512
		70.00	2.7559	SM08513
	2-25/32	70.64	2.7812	SM08514
	2-13/16	71.44	2.8125	SM08515
		72.00	2.8346	SM08516
	2-27/32	72.23	2.8438	SM08517
	2-7/8	73.03	2.8750	SM08518
	2-29/32	73.82	2.9062	SM08519
		74.00	2.9134	SM08520
	2-15/16	74.61	2.9375	SM08521
	2-31/32	75.41	2.9688	SM08522
		76.00	2.9921	SM08523
	3	76.20	3.0000	SM08524

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES 6,7,8

SM-POINT SPADE DRILL INSERTS - SUPER COBALT(T15)

- Improved stability and hole straightness by newly developed thinning design.
- Less thrust force and excellent self-centering.
- Any non-standard size available.

POINT ANGLE : 144 degree

cutting conditions : p.278

Series Min. to Max. (inch/mm)	Diameter Fractional (inch)	Diameter Metric (mm)	Diameter Decimal (inch)	EDP No. TiAlN
6 3.001 (76.23) to 3.507 (89.08) Thick 7/16 (11.1)	3-1/32	76.99	3.0312	SM08601
	3-1/16	77.79	3.0625	SM08602
		78.00	3.0709	SM08603
	3-3/32	78.58	3.0938	SM08604
	3-1/8	79.38	3.1250	SM08605
		80.00	3.1496	SM08606
	3-5/32	80.17	3.1562	SM08607
	3-3/16	80.96	3.1875	SM08608
	3-7/32	81.76	3.2188	SM08609
		82.00	3.2283	SM08610
	3-1/4	82.55	3.2500	SM08611
	3-9/32	83.34	3.2812	SM08612
		84.00	3.3071	SM08613
	3-5/16	84.14	3.3125	SM08614
	3-11/32	84.93	3.3438	SM08615
	3-3/8	85.73	3.3750	SM08616
		86.00	3.3858	SM08617
	3-13/32	86.52	3.4063	SM08618
	3-7/16	87.31	3.4375	SM08619
		88.00	3.4646	SM08620
	3-15/32	88.11	3.4688	SM08621
	3-1/2	88.90	3.5000	SM08622
7 3.455 (87.76) to 4.000 (101.60)	3-17/32	89.69	3.5312	SM08701
		90.00	3.5433	SM08702
	3-9/16	90.49	3.5625	SM08703
	3-19/32	91.28	3.5938	SM08704
		92.00	3.6221	SM08705
	3-5/8	92.08	3.6250	SM08706
	3-21/32	92.87	3.6562	SM08707
	3-11/16	93.66	3.6875	SM08708

Series Min. to Max. (inch/mm)	Diameter Fractional (inch)	Diameter Metric (mm)	Diameter Decimal (inch)	EDP No. TiAlN
7 3.455 (87.76) to 4.000 (101.60) Thick 7/16 (11.1)		94.00	3.7008	SM08709
	3-23/32	94.46	3.7188	SM08710
	3-3/4	95.25	3.7500	SM08711
		96.00	3.7795	SM08712
	3-25/32	96.04	3.7812	SM08713
	3-13/16	96.84	3.8125	SM08714
	3-27/32	97.63	3.8438	SM08715
		98.00	3.8583	SM08716
	3-7/8	98.43	3.8750	SM08717
	3-29/32	99.22	3.9062	SM08718
		100.00	3.9370	SM08719
	3-15/16	100.01	3.9375	SM08720
	3-31/32	100.81	3.9688	SM08721
	4	101.60	4.0000	SM08722
8 4.001 (101.63) to 4.507 (114.48) Thick 7/16 (11.1)	4-1/64	102.00	4.0156	SM08801
	4-1/16	103.19	4.0625	SM08802
	4-3/32	104.00	4.0945	SM08803
	4-1/8	104.78	4.1250	SM08804
		106.00	4.1732	SM08805
	4-3/16	106.36	4.1875	SM08806
	4-1/4	107.95	4.2500	SM08807
		108.00	4.2520	SM08808
	4-5/16	109.54	4.3125	SM08809
		110.00	4.3307	SM08810
	4-3/8	111.13	4.3750	SM08811
		112.00	4.4094	SM08812
	4-7/16	112.71	4.4375	SM08813
		114.00	4.4882	SM08814
	4-1/2	114.30	4.5000	SM08815

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

SERIES Y,Z,0,1

SM-POINT SPADE DRILL INSERTS - CARBIDE(C5)

- Improved stability and hole straightness by newly developed chip thinning design.
- Less thrust force and excellent self-centering.
- Any non-standard size available.
- Increased speeds & feeds

POINT ANGLE : 132 degree

cutting conditions : p.279

Series Min. to Max. (inch/mm)	Diameter Fractional (inch)	Diameter Metric (mm)	Diameter Decimal (inch)	EDP No. TiAlN
Y .374 (9.50) to .436 (11.07) Thick 3/32 (2.4)		9.50	.3740	* SM28Y01
	3/8	9.53	.3750	* SM28Y02
		9.80	.3858	* SM28Y03
	25/64	9.92	.3906	* SM28Y04
		10.00	.3937	* SM28Y05
		10.20	.4016	* SM28Y06
	13/32	10.32	.4062	* SM28Y07
		10.50	.4134	* SM28Y08
	27/64	10.72	.4219	* SM28Y09
		10.80	.4252	* SM28Y10
		11.00	.4331	* SM28Y11
Z .437 (11.11) to .510 (12.95) 3/32(2.4)	7/16	11.11	.4375	* SM28Z01
		11.50	.4528	* SM28Z02
	29/64	11.51	.4531	* SM28Z03
	15/32	11.91	.4688	* SM28Z04
		12.00	.4724	* SM28Z05
	31/64	12.30	.4844	* SM28Z06
		12.50	.4921	* SM28Z07
	1/2	12.70	.5000	* SM28Z08
0 .511 (12.98) to .695 (17.65) Thick 1/8 (3.2)		13.00	.5118	* SM28001
	33/64	13.10	.5156	* SM28002
	17/32	13.49	.5312	* SM28003
		13.50	.5315	* SM28004
	35/64	13.89	.5469	* SM28060
		14.00	.5512	* SM28005
	9/16	14.29	.5625	* SM28006
		14.50	.5709	* SM28007
	37/64	14.68	.5781	* SM28008
		15.00	.5906	* SM28009
	19/32	15.08	.5938	* SM28010
	39/64	15.48	.6094	* SM28061
		15.50	.6102	* SM28011
	5/8	15.88	.6250	* SM28012

Series Min. to Max. (inch/mm)	Diameter Fractional (inch)	Diameter Metric (mm)	Diameter Decimal (inch)	EDP No. TiAlN
0 .511 (12.98) to .695 (17.65)		16.00	.6299	* SM28013
	41/64	16.27	.6406	* SM28062
		16.50	.6496	* SM28014
	21/32	16.67	.6562	* SM28015
		17.00	.6693	* SM28016
	43/64	17.07	.6719	* SM28063
	11/16	17.46	.6875	* SM28017
		17.50	.6890	* SM28018
1 .690 (17.53) to .960 (24.38) Thick 5/32 (4.0)	45/64	17.86	.7031	SM28101
		18.00	.7087	SM28102
	23/32	18.26	.7188	SM28103
		18.50	.7283	SM28104
	47/64	18.65	.7344	SM28105
		19.00	.7480	SM28106
	3/4	19.05	.7500	SM28107
	49/64	19.45	.7656	SM28108
		19.50	.7677	SM28109
	25/32	19.84	.7812	SM28110
		20.00	.7874	SM28111
	51/64	20.24	.7969	SM28160
		20.50	.8071	SM28112
	13/16	20.64	.8125	SM28113
		21.00	.8268	SM28114
	27/32	21.43	.8438	SM28115
	55/64	21.83	.8594	SM28161
		22.00	.8661	SM28116
	7/8	22.23	.8750	SM28117
	57/64	22.62	.8906	SM28162
		23.00	.9055	SM28118
	29/32	23.02	.9062	SM28119
	59/64	23.42	.9219	SM28120
	15/16	23.81	.9375	SM28121
		24.00	.9449	SM28122

* 2pcs per package

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○

SPADE DRILLS

SERIES 2,3

SM-POINT SPADE DRILL INSERTS - CARBIDE(C5)

- Improved stability and hole straightness by newly developed chip thinning design.
- Less thrust force and excellent self-centering.
- Any non-standard size available.
- Increased speeds & feeds

POINT ANGLE : 132 degree

cutting conditions : p.279

Series Min. to Max. (inch/mm)	Diameter			EDP No.
	Fractional (inch)	Metric (mm)	Decimal (inch)	TiAlN
2 **.961 (24.41) to 1.380 (35.05)** **Thick** 3/16 (4.8)	31/32	24.61	.9688	SM28201
	63/64	25.00	.9843	SM28202
	1	25.40	1.0000	SM28203
	1-1/64	25.80	1.0156	SM28204
		26.00	1.0236	SM28205
	1-1/32	26.19	1.0312	SM28206
	1-3/64	26.59	1.0469	SM28260
	1-1/16	26.99	1.0625	SM28207
		27.00	1.0630	SM28208
	1-3/32	27.78	1.0938	SM28209
		28.00	1.1024	SM28210
	1-7/64	28.18	1.1094	SM28261
	1-1/8	28.58	1.1250	SM28211
		29.00	1.1417	SM28212
	1-5/32	29.37	1.1562	SM28213
		30.00	1.1811	SM28214
	1-3/16	30.16	1.1875	SM28215
	1-7/32	30.96	1.2188	SM28216
		31.00	1.2205	SM28217
	1-1/4	31.75	1.2500	SM28218
		32.00	1.2598	SM28219
	1-9/32	32.54	1.2812	SM28220
		33.00	1.2992	SM28221
	1-5/16	33.34	1.3125	SM28222
		34.00	1.3386	SM28223
	1-11/32	34.13	1.3438	SM28224
	1-3/8	34.93	1.3750	SM28225
		35.00	1.3780	SM28226

Series Min. to Max. (inch/mm)	Diameter			EDP No.
	Fractional (inch)	Metric (mm)	Decimal (inch)	TiAlN
3 **1.353 (34.37) to 1.882 (47.80)** **Thick** 1/4 (6.4)	1-13/32	35.72	1.4062	SM28301
		36.00	1.4173	SM28302
	1-7/16	36.51	1.4375	SM28303
		37.00	1.4567	SM28304
	1-15/32	37.31	1.4688	SM28305
		38.00	1.4961	SM28306
	1-1/2	38.10	1.5000	SM28307
	1-17/32	38.89	1.5312	SM28308
		39.00	1.5354	SM28309
	1-9/16	39.69	1.5625	SM28310
		40.00	1.5748	SM28311
	1-19/32	40.48	1.5938	SM28312
		41.00	1.6142	SM28313
	1-5/8	41.28	1.6250	SM28314
		42.00	1.6535	SM28315
	1-21/32	42.07	1.6562	SM28316
	1-11/16	42.86	1.6875	SM28317
		43.00	1.6929	SM28318
	1-23/32	43.66	1.7188	SM28319
		44.00	1.7323	SM28320
	1-3/4	44.45	1.7500	SM28321
		45.00	1.7717	SM28322
	1-25/32	45.24	1.7812	SM28323
		46.00	1.8110	SM28324
	1-13/16	46.04	1.8125	SM28325
	1-27/32	46.83	1.8438	SM28326
		47.00	1.8504	SM28327
	1-7/8	47.63	1.8750	SM28328

◎ : Excellent ○ : Good

P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○

SPADE DRILLS

SERIES Y,Z,0,1,2

SPADE DRILL FLAT BOTTOM INSERTS - SUPER COBALT T15

POINT ANGLE : 180 degree

cutting conditions : p.280

Series	Diameter		EDP No.	
	Fractional (inch)	Decimal (inch)	TiN	TiAlN
Y	3/8	.3750	* SF05024	* SF15024
	13/32	.4063	* SF05026	* SF15026
Z	7/16	.4375	* SF05028	* SF15028
	15/32	.4688	* SF05030	* SF15030
	1/2	.5000	* SF05032	* SF15032
0	17/32	.5313	* SF05034	* SF15034
	9/16	.5625	* SF05036	* SF15036
	19/32	.5938	* SF05038	* SF15038
	5/8	.6250	* SF05040	* SF15040
	21/32	.6563	* SF05042	* SF15042
	11/16	.6875	* SF05044	* SF15044
1	23/32	.7188	SF05046	SF15046
	3/4	.7500	SF05048	SF15048
	25/32	.7813	SF05050	SF15050
	13/16	.8125	SF05052	SF15052
	27/32	.8438	SF05054	SF15054
	7/8	.8750	SF05056	SF15056
	29/32	.9063	SF05058	SF15058
	15/16	.9375	SF05060	SF15060

Series	Diameter		EDP No.	
	Fractional (inch)	Decimal (inch)	TiN	TiAlN
2	31/32	.9688	SF05062	SF15062
	1	1.0000	SF05100	SF15100
	1-1/32	1.0313	SF05102	SF15102
	1-1/16	1.0625	SF05104	SF15104
	1-3/32	1.0938	SF05106	SF15106
	1-1/8	1.1250	SF05108	SF15108
	1-5/32	1.1563	SF05110	SF15110
	1-3/16	1.1875	SF05112	SF15112
	1-7/32	1.2188	SF05114	SF15114
	1-1/4	1.2500	SF05116	SF15116
	1-9/32	1.2813	SF05118	SF15118
	1-5/16	1.3125	SF05120	SF15120
	1-11/32	1.3438	SF05122	SF15122
	1-3/8	1.3750	SF05124	SF15124

* 2pcs per package

◎ : Excellent ○ : Good

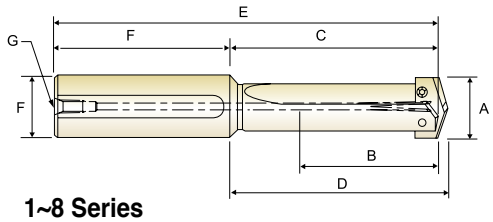
P											M	K		N	
Non-alloyed Steels, Free Machining Steels	Carbon Steels		Alloy Steels		High Alloyed steels		Structural Steels		Tool Steels		Stainless Steels	Cast Iron		Aluminum	Copper Alloys
~HRc24 (~HB250)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc28 (~HB275)	HRc28~ (HB275~)	~HRc37 (~HB350)	HRc37~ (HB350~)	~HRc24 (~HB250)	HRc24~ (HB250~)	~HRc13 (~HB200)	HRc13~ (HB200~)	~HRc28 (~HB275)	~HRc19 (~HB220)	HRc19~ (HB220~)	~HRc8 (~HB180)	~HB110
◎	◎	◎	◎	○	○	○	◎	◎	○	○	○	○	◎	○	○

SPADE DRILLS

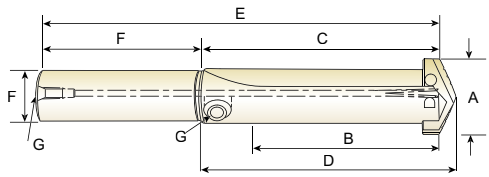
P13 SERIES
P14 SERIES

STRAIGHT SHANK HOLDER, STRAIGHT FLUTE

Y~0.5 Series



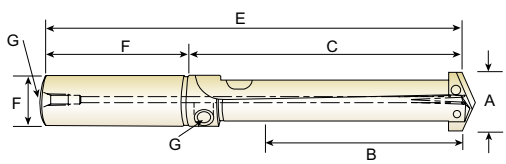
1~8 Series



SHORT LENGTH

Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
Y	P13Y01	3/8 – 27/64	1-1/4	2-1/32	2-1/8	4-13/32	3/4	2-3/8	1/8
Z	P13Z01	7/16 – 1/2	1-1/4	2-1/32	2-1/8	4-13/32	3/4	2-3/8	1/8
0	P13001	33/64 – 11/16	1-3/8	2-3/16	2-19/64	4-9/16	3/4	2-3/8	1/8
0.5	P13051	39/64 – 11/16	1-3/8	2-3/16	2-19/64	4-9/16	3/4	2-3/8	1/8
1	P13101	45/64 – 15/16	2-5/8	3-7/8	4-1/64	6-7/8	3/4	3	1/8
	P13102	45/64 – 15/16	2-5/8	3-7/8	4-1/64	6-7/8	1	3	1/8
1.5	P13151	55/64 – 15/16	2-5/8	3-7/8	4-1/64	6-7/8	3/4	3	1/8
	P13152	55/64 – 15/16	2-5/8	3-7/8	4-1/64	6-7/8	1	3	1/8
2	P13202	31/32 – 1-3/8	3-3/8	4-1/2	4-41/64	8	1	3-1/2	1/8
	P13203	31/32 – 1-3/8	3-3/8	4-1/2	4-41/64	8	1-1/4	3-1/2	1/8
2.5	P13252	1-3/16 – 1-3/8	3-3/8	4-1/2	4-41/64	8	1	3-1/2	1/8
	P13253	1-3/16 – 1-3/8	3-3/8	4-1/2	4-41/64	8	1-1/4	3-1/2	1/8
3	P13303	1-13/32 – 1-7/8	4-3/4	6	6-3/16	10	1-1/4	4	1/4
	P13304	1-13/32 – 1-7/8	4-3/4	6	6-3/16	10	1-1/2	4	1/4
4	P13404	1-29/32 – 2-9/16	5-1/8	6-1/2	6-11/16	10-1/2	1-1/2	4	1/4
	P13405	1-29/32 – 2-9/16	5-1/8	6-1/2	6-11/16	10-1/2	1-3/4	4	1/4
5-6	P13506	2-1/2 – 3-1/2	6-3/4	8-1/2	8-3/4	12-1/2	2	4	1/2
7-8	P13708	3-17/32 – 4-1/2	6-3/4	8-7/8	9-1/8	13-7/8	3	5	1/2



INTERMEDIATE LENGTH

Unit : Inch

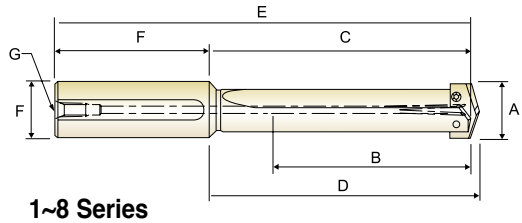
Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
1	P14102	45/64 – 15/16	4-5/8	5-7/8	6-1/64	8-7/8	1	3	1/8
1.5	P14152	55/64 – 15/16	4-5/8	5-7/8	6-1/64	8-7/8	1	3	1/8
2	P14203	31/32 – 1-3/8	5-3/8	6-1/2	6-41/64	10	1-1/4	3-1/2	1/8
2.5	P14253	1-3/16 – 1-3/8	5-3/8	6-1/2	6-41/64	10	1-1/4	3-1/2	1/8
3	P14304	1-13/32 – 1-7/8	6-1/2	7-3/4	7-15/16	11-3/4	1-1/2	4	1/4

SPADE DRILLS

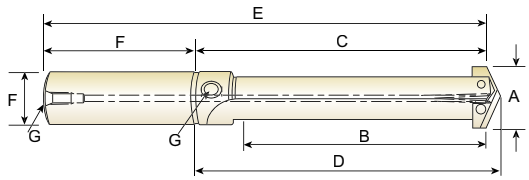
P15 SERIES

STRAIGHT SHANK HOLDER, STRAIGHT FLUTE

Y~0.5 Series



1~8 Series



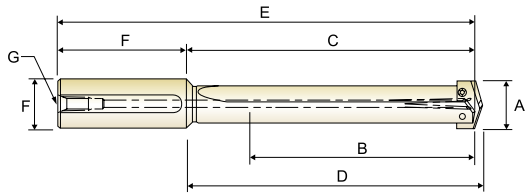
STANDARD LENGTH

Unit : Inch

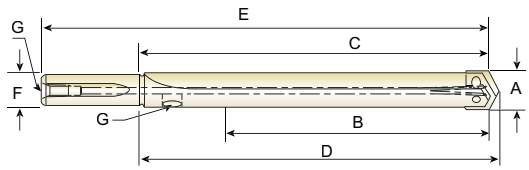
Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
Y	P15Y01	3/8 – 27/64	2-3/8	3-5/32	3-1/4	5-17/32	3/4	2-3/8	1/8
Z	P15Z01	7/16 – 1/2	2-3/8	3-5/32	3-1/4	5-17/32	3/4	2-3/8	1/8
0	P15001	33/64 – 11/16	2-1/2	3-5/16	3-27/64	5-11/16	3/4	2-3/8	1/8
0.5	P15051	39/64 – 11/16	2-1/2	3-5/16	3-27/64	5-11/16	3/4	2-3/8	1/8
1	P15101	45/64 – 15/16	6-5/8	7-7/8	8-1/64	10-7/8	3/4	3	1/8
	P15102	45/64 – 15/16	6-5/8	7-7/8	8-1/64	10-7/8	1	3	1/8
1.5	P15151	55/64 – 15/16	6-5/8	7-7/8	8-1/64	10-7/8	3/4	3	1/8
	P15152	55/64 – 15/16	6-5/8	7-7/8	8-1/64	10-7/8	1	3	1/8
2	P15202	31/32 – 1-3/8	7-3/8	8-1/2	8-41/64	12	1	3-1/2	1/8
	P15203	31/32 – 1-3/8	7-3/8	8-1/2	8-41/64	12	1-1/4	3-1/2	1/8
2.5	P15252	1-3/16 – 1-3/8	7-3/8	8-1/2	8-41/64	12	1	3-1/2	1/8
	P15253	1-3/16 – 1-3/8	7-3/8	8-1/2	8-41/64	12	1-1/4	3-1/2	1/8
3	P15303	1-13/32 – 1-7/8	8-1/4	9-1/2	9-11/16	13-1/2	1-1/4	4	1/4
	P15304	1-13/32 – 1-7/8	8-1/4	9-1/2	9-11/16	13-1/2	1-1/2	4	1/4
4	P15404	1-29/32 – 2-9/16	9-1/8	10-1/2	10-11/16	14-1/2	1-1/2	4	1/4
	P15405	1-29/32 – 2-9/16	9-1/8	10-1/2	10-11/16	14-1/2	1-3/4	4	1/4
5-6	P15506	2-1/2 – 3-1/2	10-3/4	12-1/2	12-3/4	16-1/2	2	4	1/2
7-8	P15708	3-17/32 – 4-1/2	10-3/4	12-7/8	13-1/8	17-7/8	3	5	1/2

STRAIGHT SHANK HOLDER, STRAIGHT FLUTE

Y~0.5 Series



1~8 Series



EXTENDED LENGTH

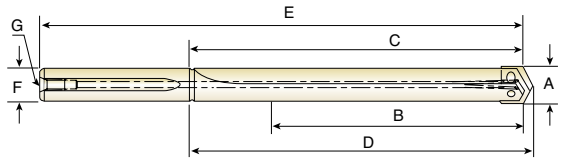
Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
Y	P16Y01	3/8 – 27/64	4-3/8	5-5/32	5-1/4	7-17/32	3/4	2-3/8	1/8
Z	P16Z01	7/16 – 1/2	4-3/8	5-5/32	5-1/4	7-17/32	3/4	2-3/8	1/8
0	P16001	33/64 – 11/16	4-1/2	5-5/16	5-27/64	7-11/16	3/4	2-3/8	1/8
0.5	P16051	39/64 – 11/16	4-1/2	5-5/16	5-27/64	7-11/16	3/4	2-3/8	1/8
1	P16102	45/64 – 15/16	10-5/8	11-7/8	12-1/64	14-7/8	1	3	1/8
1.5	P16152	55/64 – 15/16	10-5/8	11-7/8	12-1/64	14-7/8	1	3	1/8
2	P16203	31/32 – 1-3/8	11-3/8	12-1/2	12-41/64	16	1-1/4	3-1/2	1/8
2.5	P16253	1-3/16 – 1-3/8	11-3/8	12-1/2	12-41/64	16	1-1/4	3-1/2	1/8
3	P16303	1-13/32 – 1-7/8	13-3/4	15	15-3/16	19	1-1/4	4	1/4
4	P16404	1-29/32 – 2-9/16	16-5/8	18	18-3/16	22	1-1/2	4	1/4
5-6	P16506	2-1/2 – 3-1/2	18-1/4	20	20-1/4	24	2	4	1/2
7-8	P16708	3-17/32 – 4-1/2	21-7/8	24	24-1/4	29	3	5	1/2

SPADE DRILLS

P17 SERIES

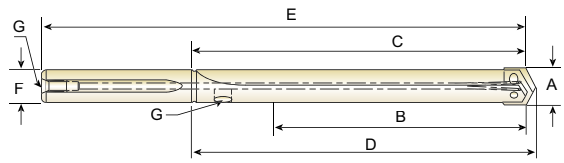
STRAIGHT SHANK HOLDER, STRAIGHT FLUTE



LONG LENGTH

Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
0	P17001	33/64 – 11/16	7	7-13/16	7-59/64	10-3/16	3/4	2-3/8	1/8
0.5	P17051	39/64 – 11/16	7	7-13/16	7-59/64	10-3/16	3/4	2-3/8	1/8



EXTRA LONG LENGTH

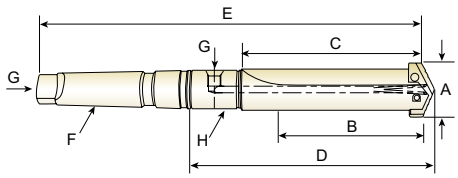
Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
1	P17101	45/64 – 15/16	18	19-1/4	19-25/64	22-1/4	1	3	1/8
2	P17202	31/32 – 1-3/8	20-1/8	21-1/4	21-25/64	24-3/4	1-1/4	3-1/2	1/8
3	P17303	1-13/32 – 1-7/8	22	23-1/4	23-7/16	27-1/4	1-1/2	4	1/4
4	P17404	1-29/32 – 2-9/16	24-5/8	26	26-3/16	30	1-1/2	4	1/4
5	P17506	2-1/2 – 3-1/2	26	27-3/4	28	31-3/4	2	4	1/2
7	P17708	3-17/32 – 4-1/2	27	29-1/8	29-3/8	34-1/8	3	5	1/2

SPADE DRILLS

P01 SERIES
P08 SERIES

TAPER SHANK HOLDER, STRAIGHT FLUTE / HELICAL FLUTE

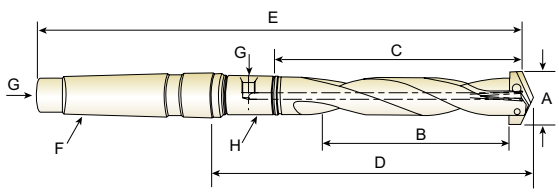


SHORT LENGTH

Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	MT	Pipe Tap	RCI
		A	B	C	D	E	F	G	H
Y	P01Y02	3/8 – 27/64	1-1/4	2-1/32	3-15/32	6-5/16	#2	1/16	PR1030
Z	P01Z02	7/16 – 1/2	1-1/4	2-1/32	3-15/32	6-5/16	#2	1/16	PR1030
0	P01002	33/64 – 11/16	1-3/8	2-3/16	3-41/64	6-15/32	#2	1/16	PR1030
0.5	P01052	39/64 – 11/16	1-3/8	2-3/16	3-41/64	6-15/32	#2	1/16	PR1030
1	P01103	45/64 – 15/16	2-3/4	3-7/8	5-39/64	9-5/32	#3	1/8	PR1031
	P01104	45/64 – 15/16	2-3/4	3-7/8	5-43/64	10-5/32	#4	1/8	PR1031
1.5	P01153	55/64 – 15/16	2-3/4	3-7/8	5-39/64	9-5/32	#3	1/8	PR1031
	P01154	55/64 – 15/16	2-3/4	3-7/8	5-43/64	10-5/32	#4	1/8	PR1031
2	P01203	31/32 – 1-3/8	3-3/8	4-1/2	6-15/64	9-25/32	#3	1/8	PR1031
	P01204	31/32 – 1-3/8	3-3/8	4-1/2	6-19/64	10-25/32	#4	1/8	PR1031
2.5	P01253	1-3/16 – 1-3/8	3-3/8	4-1/2	6-15/64	9-25/32	#3	1/8	PR1031
	P01254	1-3/16 – 1-3/8	3-3/8	4-1/2	6-37/64	11-1/16	#4	1/4	PR1042
3	P01304	1-13/32 – 1-7/8	4-3/4	6	8-1/8	12-9/16	#4	1/4	PR1042
	P01305	1-13/32 – 1-7/8	4-3/4	6	8-1/8	13-13/16	#5	1/4	PR1043
4	P01404	1-29/32 – 2-9/16	5-1/8	6-1/2	8-5/8	13-1/16	#4	1/4	PR1042
	P01405	1-29/32 – 2-9/16	5-1/8	6-1/2	8-5/8	14-5/16	#5	1/4	PR1043
5-6	P01505	2-1/2 – 3-1/2	6-3/4	8-1/2	11-5/16	16-15/16	#5	1/2	PR1054
7-8	P01705	3-17/32 – 4-1/2	6-3/4	8-7/8	11-11/16	17-5/16	#5	1/2	PR1054

▶ You can also apply **RCI**(**R**otary **C**oolant **I**nducer) for internal cooling. (See page 277)



INTERMEDIATE LENGTH

Unit : Inch

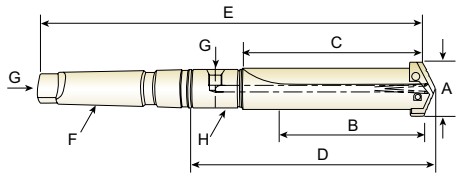
Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	MT	Pipe Tap	RCI
		A	B	C	D	E	F	G	H
1	P08103	45/64 – 15/16	4-3/4	5-7/8	7-39/64	11-5/32	#3	1/8	PR1031
1.5	P08153	55/64 – 15/16	4-3/4	5-7/8	7-39/64	11-5/32	#3	1/8	PR1031
2	P08204	31/32 – 1-3/8	5-3/8	6-1/2	8-19/64	12-25/32	#4	1/8	PR1031
2.5	P08254	1-3/16 – 1-3/8	5-3/8	6-1/2	8-37/64	13–1/16	#4	1/4	PR1042

▶ You can also apply **RCI**(**R**otary **C**oolant **I**nducer) for internal cooling. (See page 277)

SPADE DRILLS

P03 SERIES

TAPER SHANK HOLDER, STRAIGHT FLUTE



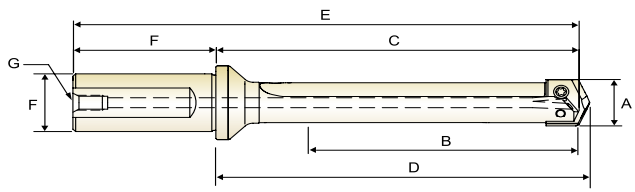
STANDARD LENGTH

Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	MT	Pipe Tap	RCI
		A	B	C	D	E	F	G	H
Y	P03Y02	3/8 – 27/64	2-3/8	3-5/32	4-19/32	7-7/16	#2	1/16	PR1030
Z	P03Z02	7/16 – 1/2	2-3/8	3-5/32	4-19/32	7-7/16	#2	1/16	PR1030
0	P03002	33/64 – 11/16	2-1/2	3-5/16	4-49/64	7-19/32	#2	1/16	PR1030
0.5	P03052	39/64 – 11/16	2-1/2	3-5/16	4-49/64	7-19/32	#2	1/16	PR1030
1	P03103	45/64 – 15/16	6-3/4	7-7/8	9-39/64	13-5/32	#3	1/8	PR1031
	P03104	45/64 – 15/16	6-3/4	7-7/8	9-43/64	14-5/32	#4	1/8	PR1031
1.5	P03153	55/64 – 15/16	6-3/4	7-7/8	9-39/64	13-5/32	#3	1/8	PR1031
	P03154	55/64 – 15/16	6-3/4	7-7/8	9-43/64	14-5/32	#4	1/8	PR1031
2	P03203	31/32 – 1-3/8	7-3/8	8-1/2	10-15/64	13-25/32	#3	1/8	PR1031
	P03204	31/32 – 1-3/8	7-3/8	8-1/2	10-19/64	14-25/32	#4	1/8	PR1031
2.5	P03253	1-3/16 – 1-3/8	7-3/8	8-1/2	10-15/64	13-25/32	#3	1/8	PR1031
	P03254	1-3/16 – 1-3/8	7-3/8	8-1/2	10-37/64	15-1/16	#4	1/4	PR1042
3	P03304	1-13/32 – 1-7/8	8-1/4	9-1/2	11-5/8	16-1/16	#4	1/4	PR1042
	P03305	1-13/32 – 1-7/8	8-1/4	9-1/2	11-5/8	17-5/16	#5	1/4	PR1043
4	P03404	1-29/32 – 2-9/16	9-1/8	10-1/2	12-5/8	17-1/16	#4	1/4	PR1042
	P03405	1-29/32 – 2-9/16	9-1/8	10-1/2	12-5/8	18-5/16	#5	1/4	PR1043
5-6	P03505	2-1/2 – 3-1/2	10-3/4	12-1/2	15-5/16	20-15/16	#5	1/2	PR1054
7-8	P03705	3-17/32 – 4-1/2	10-3/4	12-7/8	15-11/16	21-5/16	#5	1/2	PR1054

▶ You can also apply **RCI**(**R**otary **C**oolant **I**nducer) for internal cooling. (See page 277)

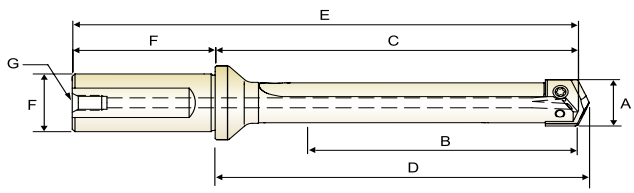
FLANGED STRAIGHT SHANK HOLDER, STRAIGHT FLUGTE



SHORT LENGTH SPADE DRILL HOLDER

Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
Y	P25Y01	3/8 – 27/64	1-1/4	2-13/32	2-1/2	4-7/16	3/4	2-1/32	1/8
Z	P25Y01	7/16 – 1/2	1-1/4	2-13/32	2-1/2	4-7/16	3/4	2-1/32	1/8
0	P25001	33/64 – 11/16	1-3/8	2-1/2	2-39/64	4-17/32	3/4	2-1/32	1/8
0.5	P25051	39/64 – 11/16	1-3/8	2-1/2	2-39/64	4-17/32	3/4	2-1/32	1/8
1	P25102	45/64 – 15/16	2-5/8	4-7/32	4-23/64	6-1/2	1	2-9/32	1/8
1.5	P25152	55/64 – 15/16	2-5/8	4-7/32	4-23/64	6-1/2	1	2-9/32	1/8
2	P25203	31/32 – 1-3/8	3-3/8	5-1/16	5-13/64	7-11/32	1-1/4	2-9/32	1/4
2.5	P25253	1-3/16 – 1-3/8	3-3/8	5-1/16	5-13/64	7-11/32	1-1/4	2-9/32	1/4
3	P25303	1-13/32 – 1-7/8	4-3/4	6-13/16	7	9-1/2	1-1/2	2-11/16	1/4
4	P25404	1-29/32 – 2-9/16	5-1/8	7-1/16	7-1/4	9-3/4	1-1/2	2-11/16	1/4



INTERMEDIATED LENGTH

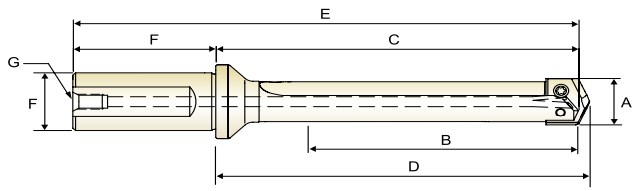
Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
1	P26102	45/64 ~ 15/16	4-5/8	6-3/32	6-15/64	8-3/8	1	2-9/32	1/8
1.5	P26152	55/64 ~ 15/16	4-5/8	6-3/32	6-15/64	8-3/8	1	2-9/32	1/8
2	P26203	31/32 ~ 1-3/8	5-3/8	7-1/16	7-13/64	9-11/32	1-1/4	2-9/32	1/4
2.5	P26253	1-3/16 ~ 1-3/8	5-3/8	7-1/16	7-13/64	9-11/32	1-1/4	2-9/32	1/4
3	P26304	1-13/32 ~ 1-7/8	6-1/2	8-9/16	8-3/4	11-1/4	1-1/2	2-11/32	1/4

SPADE DRILLS

P27 SERIES
P28 SERIES

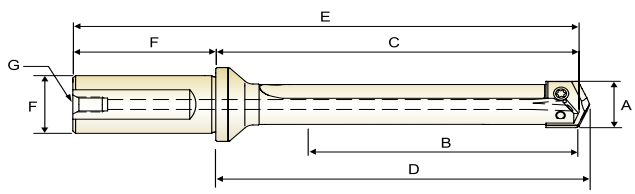
FLANGED STRAIGHT SHANK HOLDER, STRAIGHT FLUGTE



STANDARD LENGTH

Unit : Inch

Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
Y	P27Y01	3/8 ~ 27/64	2-3/8	3-17/32	3-5/8	5-9/16	3/4	2-1/32	1/8
Z	P27Z01	7/16 ~ 1/2	2-3/8	3-17/32	3-5/8	5-9/16	3/4	2-1/32	1/8
0	P27001	33/64 ~ 11/16	2-1/2	3-5/8	3-47/64	5-21/32	3/4	2-1/32	1/8
0.5	P27051	39/64 ~ 11/16	2-1/2	3-5/8	3-47/64	5-21/32	3/4	2-1/32	1/8
1	P27102	45/64 ~ 15/16	6-5/8	8-3/32	8-15/64	10-3/8	1	2-9/32	1/8
1.5	P27152	55/64 ~ 15/16	6-5/8	8-3/32	8-15/64	10-3/8	1	2-9/32	1/8
2	P27203	31/32 ~ 1-3/8	7-3/8	9-1/16	9-13/64	11-11/32	1-1/4	2-9/32	1/4
2.5	P27253	1-3/16 ~ 1-3/8	7-3/8	9-1/16	9-13/64	11-11/32	1-1/4	2-9/32	1/4
3	P27303	1-13/32 ~ 1-7/8	8-1/4	10-5/16	10-1/2	13	1-1/2	2-11/16	1/4
4	P27404	1-29/32 ~ 2-9/16	9-1/8	11-1/16	11-1/4	13-3/4	1-1/2	2-11/16	1/4



EXTENDED LENGTGH

Unit : Inch

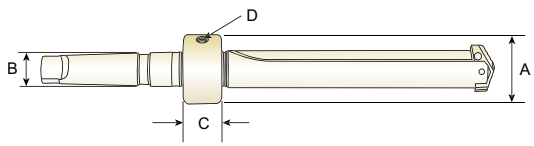
Series	EDP No.	Drill Insert Range	Max. Drill Depth	Flute Length	Ref. Length	Overall Length	Shank		Pipe Tap
							Dia.	Length	
		A	B	C	D	E	F		G
Y	P28Y01	3/8 ~ 27/64	4-3/8	5-17/32	5-5/8	7-9/16	3/4	2-1/32	1/8
Z	P28Y01	7/16 ~ 1/2	4-3/8	5-17/32	5-5/8	7-9/16	3/4	2-1/32	1/8
0	P28001	33/64 ~ 11/16	4-1/2	5-5/8	5-47/64	7-21/32	3/4	2-1/32	1/8
0.5	P28051	39/64 ~ 11/16	4-1/2	5-5/8	5-47/64	7-21/32	3/4	2-1/32	1/8
1	P28102	45/64 ~ 15/16	10-5/8	12-3/32	12-15/64	14-3/8	1	2-9/32	1/8
1.5	P28152	55/64 ~ 15/16	10-5/8	12-3/32	12-15/64	14-3/8	1	2-9/32	1/8
2	P28203	31/32 ~ 1-3/8	11-3/8	13-1/16	13-13/64	15-11/32	1-1/4	2-9/32	1/4
2.5	P28253	1-3/32 ~ 1-3/8	11-3/8	13-1/16	13-13/64	15-11/32	1-1/4	2-9/32	1/4

HOLDER ACCESSORIES

TORX SCREWS AND PREMIUM TORX HAND DRIVERS

Series	Torx Screws		Torx Screws (Nylon Locking)		Premium Torx Drivers	Drill Range		Torque in Lbs. 5.5
	Item	PKG EDP No. (10 Screws)	Item	PKG EDP No. (10 Screws)	EDP No.	Fractional inch	Metric mm	
Y	2XT7	J7Y001	2XT7N	J7Y006	J5Y007	3/8 – 27/64	9.5 – 11.0	5.5
Z	2LXT7	J7Z011	2LXT7N	J7Z016	J5Y007	7/16 – 1/2	11.5 – 12.5	5.5
0	2.5XT8	J80021	2.5XT8N	J80026	J50008	33/64 – 11/16	13.0 – 17.5	11.0
0.5	2.5LXT8	J80531	2.5LXT8N	J80536	J50008	39/64 – 11/16	15.5 – 17.5	11.0
1	3XT9	J91041	3XT9N	J91046	J51009	45/64 – 15/16	18.0 – 24.0	20.0
1.5	3LXT9	J91551	3LXT9N	J91556	J51009	55/64 – 15/16	22.0 – 24.0	20.0
2	4XT15	JB2061	4XT15N	JB2066	J52015	31/32 – 1-3/8	25.0 – 35.0	45.0
2.5	4XT15	JB2061	4XT15N	JB2066	J52015	31/32 – 1-3/8	30.0 – 35.0	45.0
3-4	5XT20	JC3081	5XT20N	JC3086	J53020	1-13/32 – 2-9/16	36.0 – 65.0	90.0
5-8	6XT25	JD5091	6XT25N	JD5096	J55025	2-1/2 – 4-1/2	64.0 – 114.0	155.0

NOTE : Replacement screws sold in packages (10 screws per package)



ROTARY COOLANT INDUCER (RCI) AND ACCESSORIES

Complete with O-Rings, Flat Washers and Locking Clips.

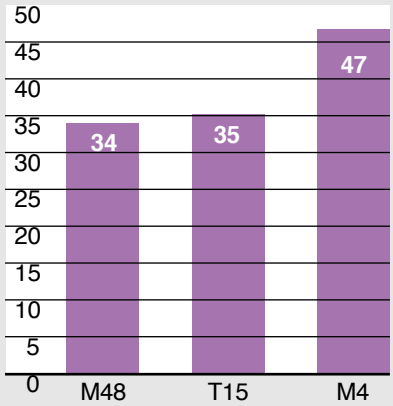
EDP No.	I.D. A	Pipe O.D. B	Length C	Tap D	Thread for Driving Rod
PR1030	1-3/4	3/4	7/8	1/8	5/16 – NC
PR1031	2-1/8	1	1-1/8	1/8	5/16 – NC
PR1042	2-1/2	1-1/4	1-3/8	1/4	3/8 – NC
PR1043	3	1-3/4	1-3/8	1/4	3/8 – NC
PR1054	3-3/4	2-1/4	1-3/4	1/2	1/2 – NC

SPADE DRILLS

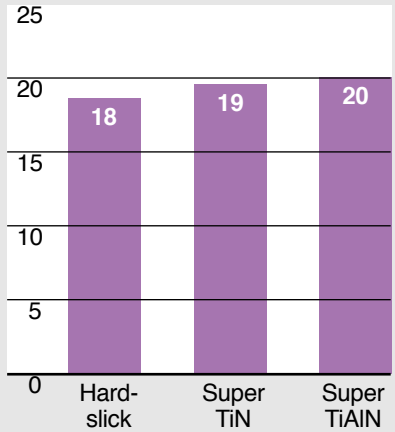
RECOMMENDED CUTTING CONDITIONS

SPADE BLADE INSERTS SELECTION & APPLICATIONS HSS

Toughness Values



Wear Values



- **WHEN TO USE M4**
  - Loose or Manual Machines
  - If T15 Breaks
- **WHEN TO USE T15**
  - When M4 Life needs to be Extended
  - If M48 Breaks
- **WHEN TO USE M48**
  - Extend Life T15
- **WHEN TO USE SM POINT**
  - Reduce Thrust
  - Smoother Entry
  - Improve Hole Quality
  - Higher Speeds and Feeds

SPEEDS – FEED RECOMMENDATIONS (STD POINT-SM POINT)

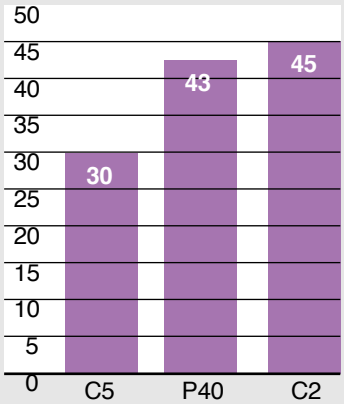
STANDARD GEOMETRY
SM POINT

Material	Material Hardness (BHN)	SFM Surface Footage		Feed (IPR) 3/8 ~ 1/2		33/64 ~ 11/16		45/64 ~ 15/16		31/32~ 1-3/8		1-13/32 ~ 1-7/8		1-29/32 ~ 2-9/16		2-19/32 ~ 4-1/2	
Free Machining Steel 1118, 1215, 12L14	100 - 150	280	330	.007	.008	.010	.012	.013	.016	.016	.019	.020	.020	.023	.023	.028	.028
	150 - 200	260	305	.007	.007	.010	.011	.013	.015	.016	.017	.020	.020	.023	.023	.028	.028
	200 - 250	240	285	.007	.006	.010	.010	.013	.014	.016	.016	.020	.020	.023	.023	.028	.028
Low & Medium Carbon Steel 1018, 1040, 1140		240	280	.006	.007	.009	.010	.012	.014	.015	.017	.019	.019	.023	.023	.027	.027
		225	265	.005	.006	.008	.009	.010	.013	.014	.016	.018	.018	.021	.021	.024	.024
		210	245	.005	.006	.008	.009	.010	.013	.014	.016	.018	.018	.021	.021	.024	.024
		195	230	.004	.005	.007	.008	.009	.012	.012	.015	.016	.016	.019	.019	.022	.022
Alloy Steel 4140, 5140, 8640	125 - 175	210	245	.006	.007	.008	.010	.010	.014	.014	.017	.017	.017	.019	.019	.022	.022
	175 - 225	195	230	.005	.006	.008	.009	.010	.013	.014	.016	.017	.017	.019	.019	.022	.022
	225 - 275	180	215	.005	.006	.007	.009	.010	.013	.014	.016	.017	.017	.019	.019	.022	.022
	275 - 325	170	200	.004	.005	.006	.008	.009	.012	.012	.015	.015	.015	.017	.017	.020	.020
	325 - 375	155	185	.003	.004	.006	.007	.009	.011	.012	.014	.015	.015	.017	.017	.020	.020
High Strength Alloy Stee 4340, 4330V, 300M		110	130	.005	.006	.007	.009	.009	.011	.010	.013	.014	.014	.017	.017	.020	.020
		85	105	.004	.005	.007	.008	.009	.010	.010	.012	.014	.014	.017	.017	.020	.020
		70	85	.003	.004	.006	.007	.008	.009	.009	.011	.012	.012	.015	.015	.018	.018
Structural Steel A36, A285, A516	100 - 150	200	240	.006	.008	.010	.011	.012	.015	.014	.017	.018	.018	.021	.021	.026	.026
	150 - 250	170	195	.005	.006	.009	.010	.010	.013	.012	.015	.016	.016	.019	.019	.024	.024
	250 - 350	140	165	.004	.005	.008	.009	.009	.012	.010	.013	.014	.014	.017	.017	.020	.020
High Temp, Alloy Hastelloy B, Inconel 600		40	50	.003	.004	.006	.007	.007	.009	.008	.011	.010	.012	.012	.015	.015	.017
		35	45	.003	.004	.006	.006	.007	.008	.008	.010	.010	.010	.012	.012	.015	.014
Stainless Steel 303, 416, 420, 17-4 PH	135 - 185	105	125	.006	.007	.008	.009	.009	.012	.011	.014	.014	.014	.016	.016	.020	.020
	185 - 275	90	110	.005	.006	.007	.008	.008	.011	.010	.012	.012	.012	.014	.014	.018	.018
Tool Steel H-13, H021, A04, O-2, S-3		110	130	.004	.004	.006	.007	.008	.010	.010	.012	.012	.012	.015	.015	.017	.017
		90	110	.004	.004	.006	.007	.008	.010	.010	.012	.012	.012	.015	.015	.017	.017
Aluminum	30	850	-	.008	-	.013	-	.016	-	.020	-	.022	.022	.025	.025	.025	.025
	180	450	-	.008	-	.013	-	.016	-	.018	-	.022	.022	.025	.025	.025	.025
Cast Iron Gray, Ductile, Nodular		250	295	.007	.008	.012	.012	.016	.016	.020	.020	.024	.024	.027	.027	.030	.030
		225	265	.006	.007	.011	.011	.014	.015	.018	.019	.022	.022	.025	.025	.028	.028
		195	230	.006	.006	.009	.009	.012	.013	.016	.017	.018	.018	.021	.021	.024	.024
		165	195	.005	.005	.007	.008	.009	.011	.012	.014	.014	.014	.017	.017	.020	.020
		135	160	.004	.005	.006	.007	.007	.010	.009	.011	.012	.012	.014	.014	.016	.016

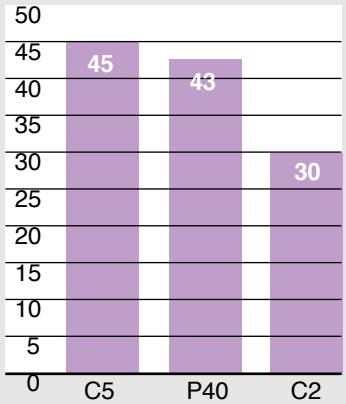
The recommendations for speed, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points. Speed and feed reduction (20% reduction in speed and 10% reduction in feed) are recommended.

SPADE BLADE INSERTS SELECTION & APPLICATIONS CARBIDE

Toughness Values



Wear Values



If C5 chips try C2 at 10% – 20% lower S.F.M. than C5 rating

Grade	Geometry and Application	Stocked Coatings
P40 & C5	Steel Cutting	Super TiN TiAlN
C3	Cast Iron	Super TiN TiAlN
P40 & C2	Ductile Iron Stainless Steel Aluminum Exotic Alloys	Super TiN TiAlNE

Note : Carbide has a lower transverse rupture strength than HSS and is prone to chipping and breakage.

Recutting of chips or lack of rigidity can cause breakage.

Check Coolant Recommendations Chart on Page 461 for flow rates.

SPEEDS – FEED RECOMMENDATIONS (STD POINT-SM POINT)

STANDARD GEOMETRY

SM POINT

Material	Material Hardness (BHN)	SFM Surface Footage		Feed (IPR) 3/8 ~ 1/2		33/64 ~ 11/16		45/64 ~ 15/16		31/32 ~ 1-3/8		1-13/32 ~ 1-7/8	
Free Machining Steel 1118, 1215, 12L14	100 - 150	420	485	.006	.008	.009	.012	.012	.016	.015	.019	.019	-
	150 - 200	360	420	.006	.007	.008	.011	.011	.015	.013	.017	.017	-
	200 - 250	340	395	.005	.006	.008	.010	.010	.014	.012	.016	.015	-
Low & Medium Carbon Steel 1018, 1040, 1140	125 - 175	340	395	.005	.007	.008	.010	.010	.014	.014	.017	.017	-
	175 - 225	310	360	.005	.006	.007	.009	.008	.013	.012	.016	.016	-
	225 - 275	270	315	.004	.006	.007	.009	.008	.013	.012	.016	.015	-
	275 - 325	230	270	.004	.005	.006	.008	.006	.012	.010	.015	.014	-
Alloy Steel 4140, 5140, 8640	125 - 175	325	380	.005	.007	.008	.010	.010	.014	.013	.017	.016	-
	175 - 225	300	350	.005	.006	.007	.009	.009	.013	.012	.016	.015	-
	225 - 275	270	315	.004	.006	.007	.009	.009	.013	.012	.016	.015	-
	275 - 325	250	290	.004	.005	.006	.008	.008	.012	.011	.015	.014	-
	325 - 375	220	260	.003	.004	.005	.007	.008	.011	.010	.014	.013	-
High Strength Alloy Stee 4340, 4330V, 300M	225 - 300	200	235	.005	.006	.007	.009	.008	.011	.010	.013	.014	-
	300 - 350	180	210	.004	.005	.006	.008	.007	.010	.009	.012	.012	-
	350 - 400	160	190	.003	.004	.005	.007	.006	.009	.008	.011	.010	-
Structural Steel A36, A285, A516	100 - 150	310	360	.006	.008	.010	.011	.011	.015	.012	.017	.016	-
	150 - 250	250	290	.005	.006	.008	.010	.009	.013	.011	.015	.015	-
	250 - 350	230	270	.004	.005	.007	.009	.008	.012	.009	.013	.013	-
High Temp, Alloy Hastelloy B, Inconel 600	140 - 220	80	125	.003	.004	.006	.007	.007	.009	.009	.011	.011	-
	220 - 310	60	100	.003	.004	.005	.006	.006	.008	.008	.010	.010	-
Stainless Steel 303, 416, 420, 17-4 PH	135 - 185	210	245	.006	.007	.008	.009	.009	.012	.011	.014	.013	-
	185 - 275	160	190	.005	.006	.007	.008	.008	.011	.010	.012	.011	-
Tool Steel H-13, H021, A04, O-2, S-3	150 - 200	220	260	.003	.004	.005	.007	.007	.010	.009	.012	.011	-
	200 - 250	170	200	.003	.004	.005	.007	.007	.010	.009	.012	.011	-
Aluminum	30	1500	-	.008	-	.013	-	.016	-	.020	-	.022	-
	180	1000	-	.007	-	.011	-	.014	-	.018	-	.020	-
Cast Iron Gray, Ductile, Nodular	120 - 150	460	505	.006	.008	.009	.012	.011	.015	.015	.019	.020	-
	150 - 200	400	485	.005	.007	.008	.011	.010	.013	.014	.017	.018	-
	200 - 220	360	435	.005	.006	.007	.009	.008	.012	.012	.015	.015	-
	220 - 260	310	375	.004	.005	.006	.008	.007	.011	.010	.013	.013	-
	260 - 320	270	340	.004	.005	.005	.007	.006	.010	.008	.011	.011	-

The recommendations for speed, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points. Speed and feed reduction (20% reduction in speed and 10% reduction in feed) are recommended.

SPADE DRILLS

RECOMMENDED CUTTING CONDITIONS

SUPER COBALT T15 FLAT BOTTOM

Material	Material Hardness (BHN)	Speed (SFM)		Feed			
		TiN	TiAlN	3/8 ~ 1/2	33/64 ~ 11/16	45/64 ~ 15/16	31/32 ~ 1-3/8
Free machining Steel **1213, 12L13, 1215** **12L14, 1118**	100 - 150 150 - 200 200 - 250	165 150 135	220 215 190	0.005 0.005 0.004	0.007 0.007 0.007	0.010 0.010 0.010	0.013 0.013 0.012
Low Carbon Steel **1015, 1020, 1140,** **1025**	85 - 125 125 - 175 175 - 225 225 - 275	140 135 125 115	195 190 180 175	0.005 0.005 0.004 0.004	0.007 0.007 0.006 0.006	0.009 0.009 0.008 0.008	0.012 0.012 0.011 0.011
Medium Carbon Steel **1035, 1050, 1045** **1055, 1140**	125 - 175 175 - 225 225 - 275 275 - 325	135 125 115 105	195 180 165 150	0.004 0.004 0.004 0.003	0.007 0.006 0.006 0.005	0.009 0.007 0.007 0.007	0.011 0.011 0.011 0.009
Structural Steel **A36, A516, A182**	100 - 150 150 - 250 250 - 350	115 100 80	165 140 115	0.004 0.004 0.003	0.007 0.007 0.006	0.009 0.008 0.007	0.011 0.009 0.008
Cast Iron / S,G Iron **A48-76 GR30/GR45** **A536-72 60-40-18** **A220-76 GR40010**	120 - 150 150 - 200 200 - 220 220 - 260 260 - 320	145 130 110 95 80	215 190 165 150 120	0.005 0.005 0.005 0.004 0.004	0.010 0.008 0.008 0.006 0.005	0.014 0.011 0.010 0.008 0.006	0.016 0.016 0.014 0.010 0.008
Alloy Steel **8620, 4130, 4137** **4140, 6150**	125 - 175 175 - 225 225 - 275 275 - 325 325 - 375	125 115 105 100 90	165 150 145 140 120	0.005 0.004 0.004 0.003 0.003	0.006 0.006 0.005 0.005 0.005	0.008 0.008 0.007 0.007 0.007	0.011 0.011 0.011 0.009 0.009
Tool Steel **H13, H21, A2, S1**	150 - 200 200 - 250	65 45	90 75	0.003 0.003	0.005 0.005	0.006 0.006	0.008 0.008
High Temp. Alloy **Hastelloy B,Inconel**	140 - 220 220 - 310 225 - 300	20 15 65	30 25 90	0.003 0.003 0.004	0.005 0.004 0.006	0.006 0.006 0.007	0.008 0.006 0.008
High Strength Alloy **9840, 4340, 4330V**	300 - 350 350 - 400	45 40	70 60	0.003 0.003	0.006 0.005	0.007 0.006	0.008 0.007
Aluminium **2014, 6061, 7075**	30 180	520 255	700 390	0.007 0.007	0.011 0.011	0.014 0.014	0.017 0.016
Stainless Steel **310, 316, 410, 330**	135 - 185 185 - 275	60 50	90 80	0.005 0.004	0.007 0.006	0.008 0.007	0.009 0.009

RPM = revolution per minute (rev/min)
SFM = surface feet per minute (ft/min)
DIA = diameter of drill (inch)
IPR = feed rate (in/rev)
IPM = inch per minute penetration rate

*** Formulas :**

$SFM = (RPM) \cdot (.262) \cdot (DIA.)$

$IPM = (RPM) \cdot (IPR)$

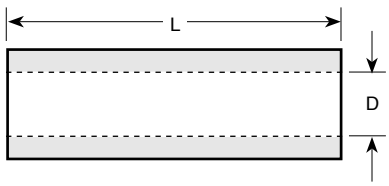
$$RPM = \frac{(SFM) \cdot (3.82)}{(DIA.)}$$

The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points. Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.

SPADE BLADE INSERTS HORSEPOWER CONSUMPTION RATE

Metal Removal Rates (MRR)
Example : 1.50 Dia. Drill @ 6.412 I.P.M.

Volume of Cylinder Method : D^2x.785xL
D = Hole Diameter
L = Length in I.P.M.
.785 is Constant



Material Drilled 4140 250 BHN :
Cutting Data : 180 S.F.M. (458 R.P.M.) x .014 Feed per Rev.

458 R.P.M. x .014 = 6.412 I.P.M. (L)

D^2 $(1.5)^2$ x .785 x L (6.412) = 11.3 C.U.In./ Min (MRR)

MRR of 11.3 x 1.4 Energy Value = 15.8HP.

metal removal rates (mrR)

- Cubic inches of metal removal per unit of horsepower.
- Unit horsepower (HP_u) is the amount of power to remove a volume of metal in a period of time.
  - HP_u = power to cut 1 cubic inch per minute – found in tables

Average Unit Horsepower Values of Energy Per Unit Volume

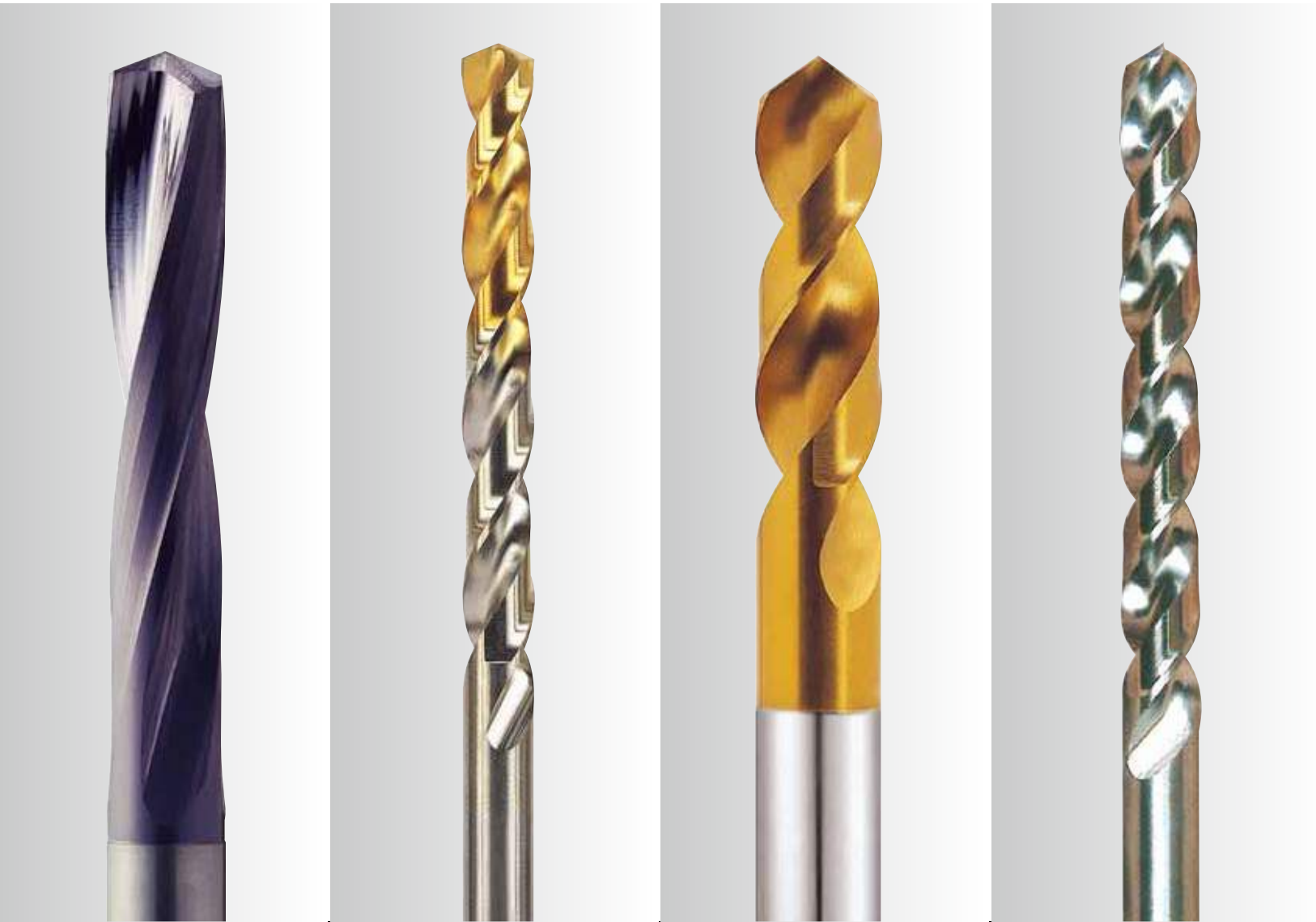
Material	BHN	HP_u (HP/(in^3/min.))
Carbon Steels	150-200 200-250 250-350	1.0 1.4 1.6
Leaded Steels	150-175	0.7
Cast Irons	125-190 190-250	0.5 1.6
Stainless Steels	135-275	1.5
Aluminum Alloys	50-100	0.3
Magnesium Alloys	40-90	0.2
Copper	125-140	0.7
Copper Alloys	100-150	0.7

COOLANT RECOMMENDATIONS (SPADE BLADE)

Material	Material Hardness (BHN)	Coolant Pressure (PSi) / Coolant Volumetric Flowrate (GPM)						
		3/8 ~ 1/2	33/64 ~ 11/16	23/32 ~ 1	1 ~ 1-1/4	1-1/4 ~ 2	2 ~ 3	3 ~ 4
Free Machining Steel **1118, 1215, 12L14, etc.**	100 – 250	175-185 2.5-2.6	100-120 2.8-3.0	105-140 4.4-5.2	80-115 7-8	75-100 12-14	40-50 30-33	65-90 38-44
Low Carbon Steel **1010, 1020, 1025, 1522, etc.**	85 – 275	165-170 2.4-2.5	75-90 2.4-2.6	75-95 3.7-4.2	60-80 6-7	55-75 11-12	30-40 26-30	50-65 33-38
Medium Carbon Steel **1030,1040,1050,1527,1140,1151,etc.**	125 – 325	160-165 2.3-2.4	70-85 2.3-2.6	70-90 3.6-4.1	55-75 5-6	50-70 10-12	30-40 26-30	50-65 33-38
Alloy Steel **4140, 5140, 8640, etc.**	125 – 375	160-165 2.3-2.4	66-75 2.2-2.4	65-80 3.5-3.9	50-70 5-6	45-60 10-11	30-35 26-28	40-50 30-33
High Strength Alloy **4340, 4330V, 300M, etc.**	225 – 400	150-155 2.3-2.4	55-60 2.1-2.2	45-50 2.9-3.1	25-30 4-5	25-30 7-8	20-25 21-23	25-30 23-26
Structural Steel **A36, A285, A516, etc.**	100 – 350	160-165 2.3-2.4	75-85 2.4-2.6	65-80 3.5-3.9	40-55 5-6	40-50 9-10	25-30 23-26	40-50 30-33
High Temp. Alloy **Hastelloy B, Inconel 600, etc.**	140 – 310	150-155 2.3-2.4	60-65 2.2-2.3	50-55 3.1-3.2	30-35 4-5	25-30 7-8	25-30 23-26	- -
Stainless Steel **301, 316, 330, 17-4PH, etc.**	135 – 275	165-170 2.4-2.5	70-85 2.3-2.6	65-75 3.5-3.7	40-55 5-6	40-50 9-10	25-30 23-26	35-45 28-31
Tool Steel **H-13, H-21, A-4, O-2, S-3, etc.**	150 – 250	150-155 2.3-2.4	55-60 2.1-2.2	45-50 2.9-3.1	25-30 4-5	25-30 7-8	20-25 21-23	25-30 23-26
Aluminum	30 – 180	190-210 2.6-2.7	140-180 3.3-3.7	150-200 5.3-6.1	115-160 8-9	90-125 14-16	40-50 30-33	60-80 36-42
Cast Iron	120 – 320	155-160 2.3-2.4	60-65 2.2-2.3	50-60 3.1-3.3	30-40 4-5	30-35 8-9	25-30 23-26	30-35 26-28

DRILLS

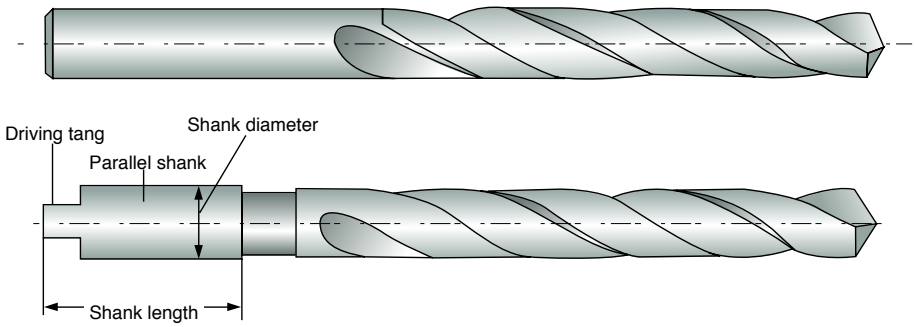
Being the best through innovation



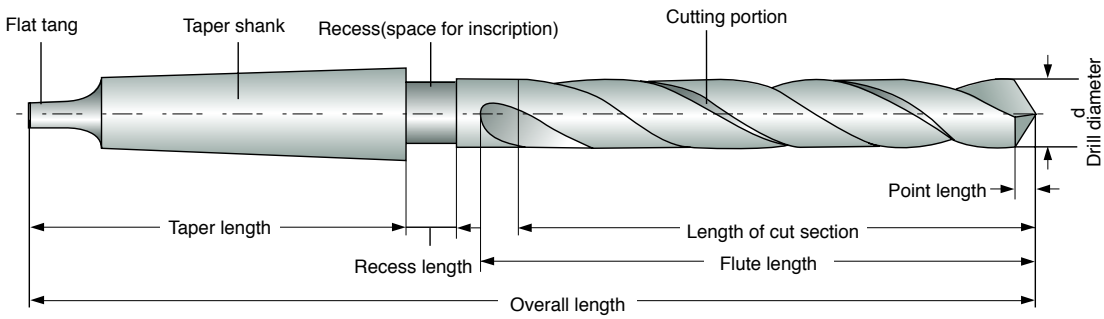
TECHNICAL DATA

TECHNICAL DATA

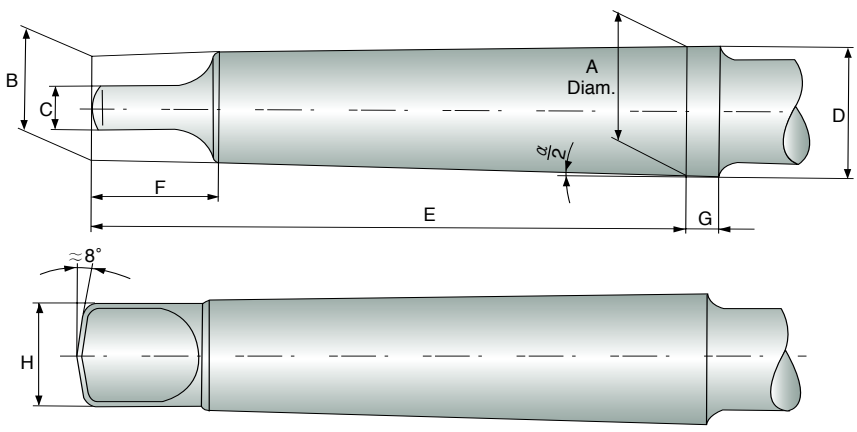
1 Twist Drill with parallel shank



2 Twist Drill with taper shank

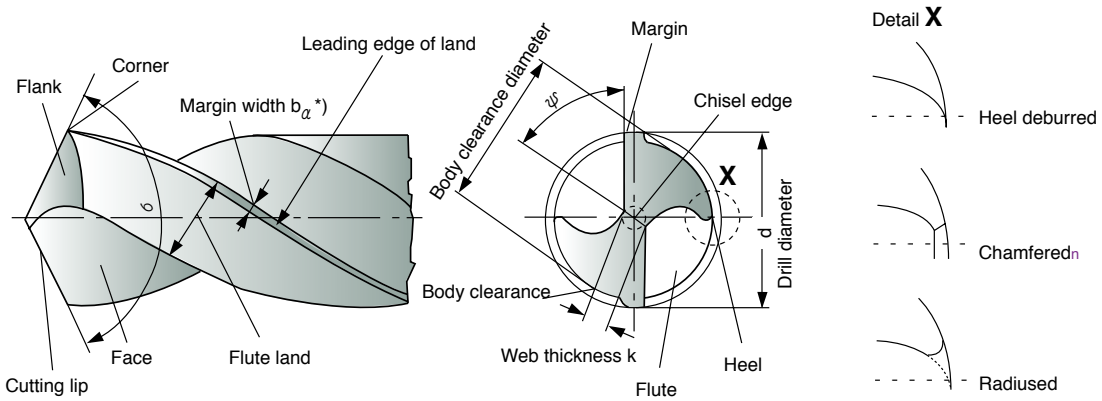


3 General dimensions of morse taper shanks



Morse Taper Shank	A mm	B mm	C(h13) mm	D mm	E mm	F(max.) mm	G mm	H(max.) mm	α/2
No.1	12.065	9	5.2	12.2	62	13.5	3.5	8.7	1° 25′ 43″
No.2	17.780	14	6.3	18.0	75	16	5	13.5	1° 25′ 50″
No.3	23.825	19.1	7.9	24.1	94	20	5	18.5	1° 26′ 16″
No.4	31.267	25.2	11.9	31.6	117.5	24	6.5	24.5	1° 29′ 15″
No.5	44.399	36.5	15.9	44.7	149.5	29	6.5	35.7	1° 30′ 26″
No.6	63.348	52.4	19	63.8	210	40	8	51	1° 29′ 36″

4 Cutting portion



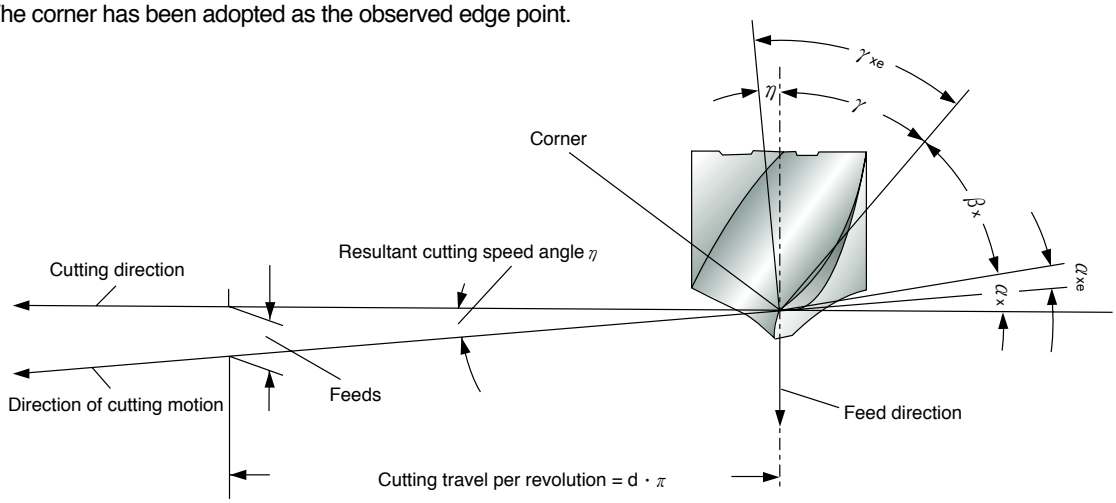
σ = Point angle (sigma)

ψ = Chisel edge angle (psi)

* In the context of cutting technology, land width b_α is the body clearance land width which is to be by $b_{f\alpha n}$, see DIN 6581.

5 Angle at the cutting edges

The corner has been adopted as the observed edge point.



α_x = Side clearance angle (alpha)

α_{xe} = Effective side clearance angle

β_x = Side wedge angle (beta)

γ_x = Front rake angle (gamma)

γ_{xe} = Working front rake angle

η = Resultant cutting speed angle (eta)

Clearance angle α, wedge angle β and rake angle γ are measured in the tool orthogonal plane. For details, see DIN 6581, definitions of metal-cutting technology; geometry at the tool edge.

TECHNICAL DATA

6 Web thickness k

Test values : The web thickness according to Fig. 1 shall not be less than the minimum value k_{min} indicated in Fig. 2.
Test point : At the point of the drill.
Testing equipment : Slide gauge with measuring points.

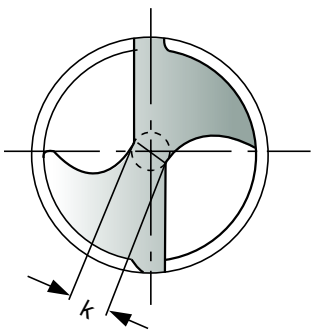


Figure 1. Web thickness k

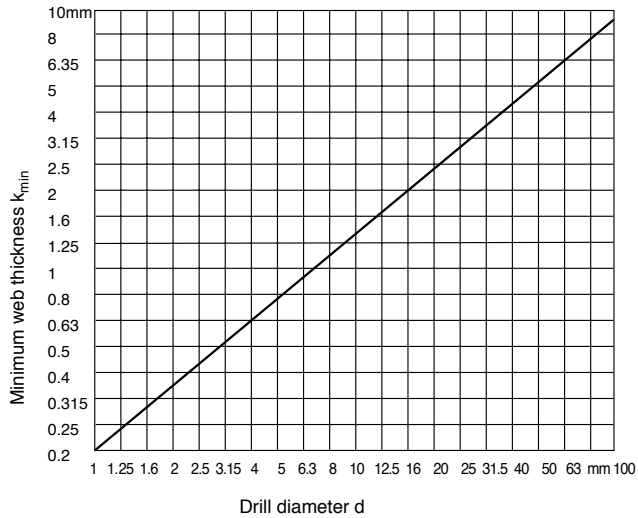


Figure 2. Web thickness k_{min}

7 Margin width b_α

Test values : The land width as in Fig. 3 shall lie within the limited values indicated in Fig. 4.
Test point : 5mm behind the corner
Testing equipment : Slide gauge

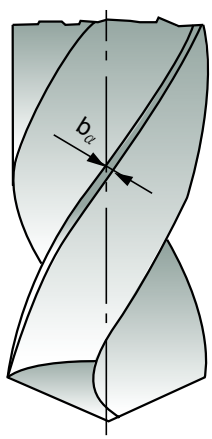


Figure 3. Margin width b_α

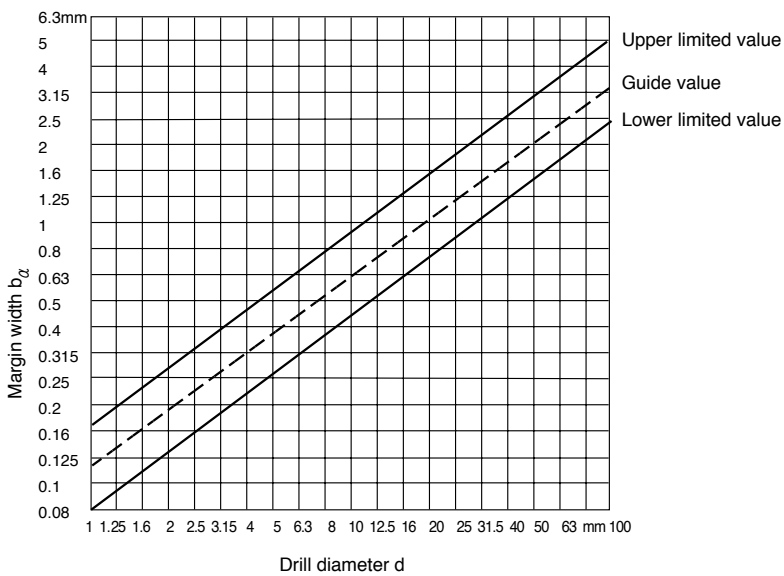


Figure 4. Margin width b_α

Angle on Twist Drills

(1) Side rake angle γ_f (Helix angle)

Recommended test value : Recommended ranges depending on the tool types N,H and W according to DIN 1836 and the diameter of the drill included in Fig. 5.

Test point : At the corner, see Fig. 6.

Testing equipment : According to VDI Guideline 3331 Part 1, Section Margin width b_α

Note : The side rake angle γ_f is measured in place of the orthogonal rake angle γ_O found in the wedge measuring plane (see DIN 6581), as this changes along the cutting edge (becoming smaller towards the point of the drill).

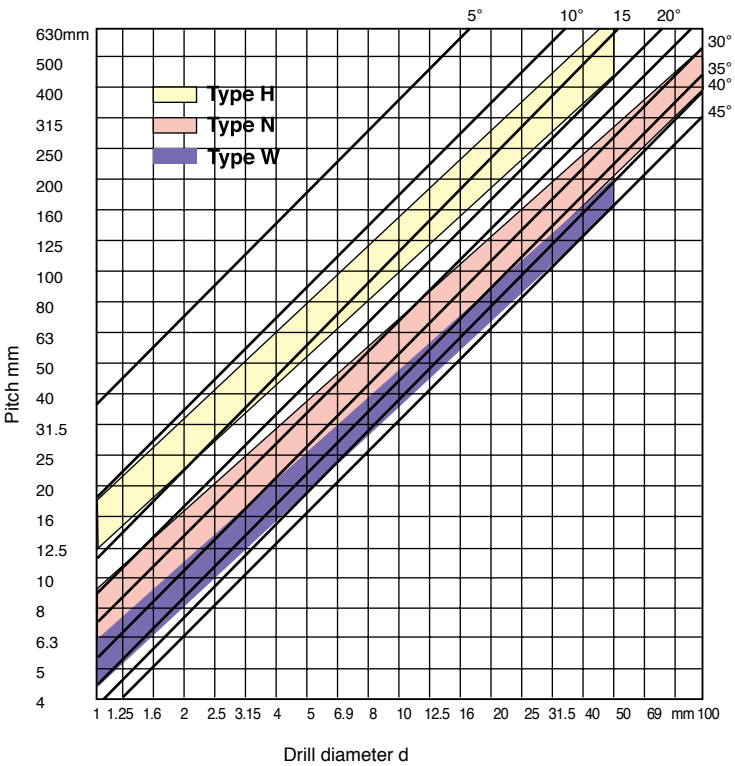


Figure 6. Side rake angle γ_f

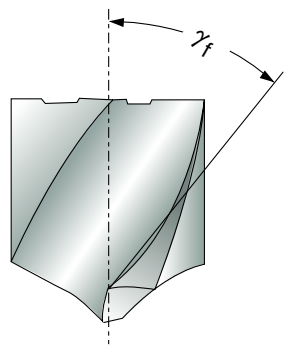


Figure 5. Side rake angle γ_f

(2) Point angle σ

Test value : Usual executin for tool types N and H : σ=118°, for tool type W : σ=130°

Test point : At the cutting, see Fig. 7.

Testing equipment : According to VDI Guideline 3331 Part 1, Section Margin width b_α

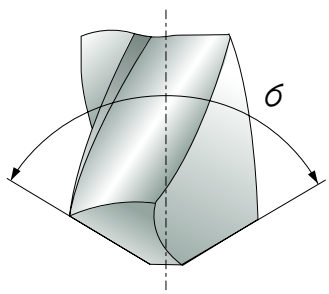


Figure 7. Point angle σ

9 Resharpening Twist Drills

(1) Drills are worn off irregularly. It should be sharpened prior to developing into excessive wear.

(2) Resharpening

① Grind the correct point angle to suit your application. (figure 8)
② Check that both cutting lips have the same angle. On a 130° point, each lip should be 65° toward the axis. The point must be on center, i.e., the chisel edge must produce cutting lips of equal length. (figure 8)
③ Grind Primary relief and Secondary clearance. (figure 9)
④ Grind web thinning. (figure 10)

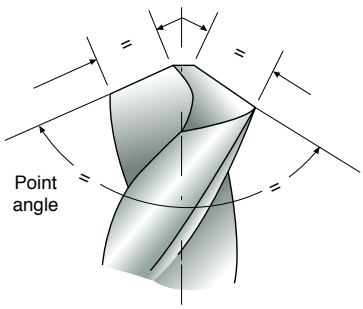


Figure 8

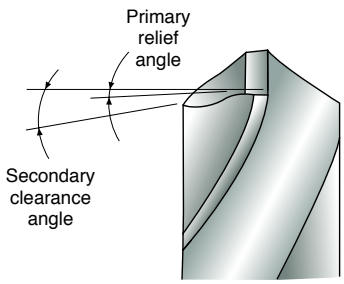


Figure 9

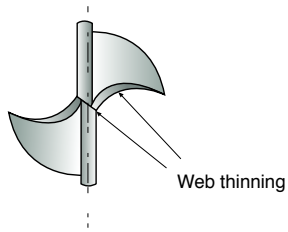
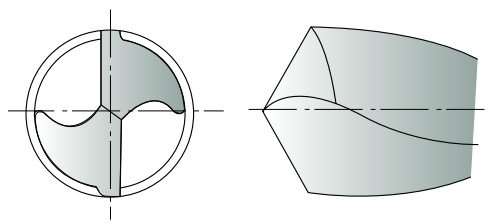


Figure 10

10 Web thinning

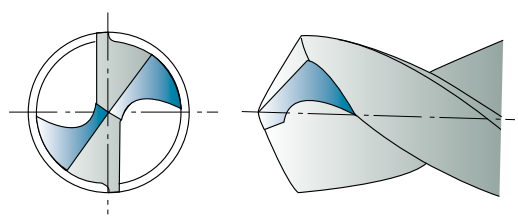
(1) Without thinning

Suitable for drill of general purpose.
Thanks to thin web thickness, web thinning is not needed.
This without web thinning type is applied to design of drills for mild steels, alloy steels, cast iron, stainless steels, titanium, inconel, etc. and conventional cutting conditons.



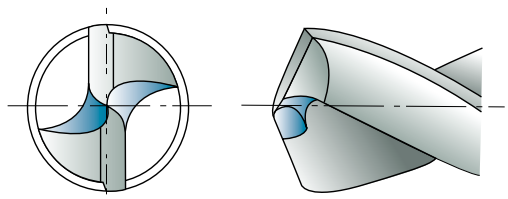
(2) Type C thinning (DIN1412 FORM C, SPLIT POINT)

Because Split point enables good centering when drilling and breaks the chips, chip removals are easy.
Suitable for drill design in high hardened tough materials, i.e, heat treated steels, titanium alloys, stainless steels, incoroy inconel, nimonic, etc.



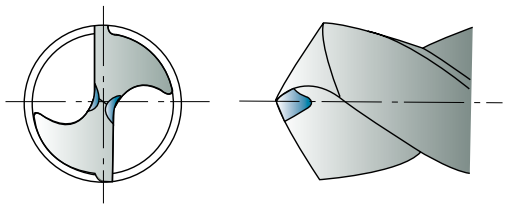
(3) Type R thinning (HELICAL THINNING)

Helical thinning ensures to frequent chip breaking and removal. The different direction force of cutting edges and helical thinning parts enable that chips curl, break and remove through the flutes. In addition, helical thinning makes the chip room up to center, remove the chisel and enables good centering



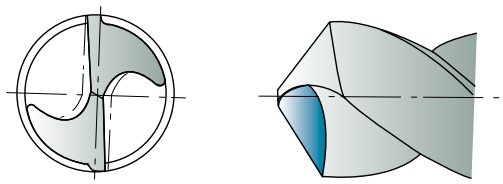
(4) Type A thinning (DIN1412 FORM A)

A type thinnings makes thin chisel, good chip removal and favorable centering.
This type is the easiest type to grind the thinning. In narrow web and wide fluted drills, keeping of the rigidity and smooth chip removal are possible.



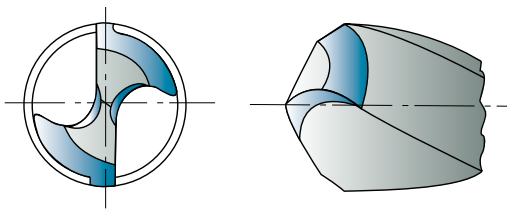
(5) Type B thinning (DIN1412 FORM B)

In case of work materials with low cutting resistance and good chip removal, i.e., cast iron, aluminum, plastic etc., B type thinning is suitable.
Especially when drills for high hardened steels are designed, this type is applied to decrease rake angle and avoid chipping of cutting lips.



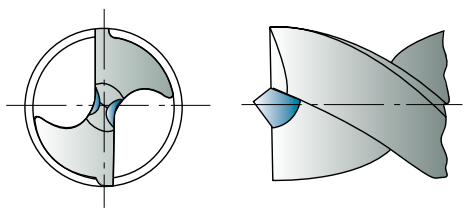
(6) Type D thinning (DIN1412 FORM D)

Grey cast iron thinning; bevelling of external edges strengthens the cutting edge.
Used for medium to high grey cast iron hardness and for abrasives.



(7) Type E thinning (DIN1412 FORM E)

Center drill bit thinning; ensures optimal center drilling and does not leave burs in through holes.
As the bit and cutting edges are delicate, this bit should be used for drilling thin sheet metal.



Surface Finishes for high speed steels Twist Drills

(1) Bright Finish

Drills with a bright finish are without surface treatment and ground condition.
Especially bright finished drills are used in machining of non ferrous materials.

(2) Coloring (Gold color)

The coloring is a thin oxide layer formed on the tool surfaces.
This is often applied to cobalt high speed steels twist drills.

(3) Steam Tempered (black oxide finish)

This is a black oxide layer 1-2㎛ formed on the tool surfaces.
Steam Tempered treated drill is the result of a steam tempering operation. Because the oxide layer retains some coolant on the tool surface, and aids chip flow, helps to dissipate heat, steam homo treated drills are recommended for ferrous applications.

12 Coating

The use of coated cutting tools reduce production costs.
For example

- Avoidance of machine downtime due to premature tool wear.
- Higher cutting capabilities to reduce actual machining times.
- Reproducible tool life.
- Improvement of component surface quality.

(1) TiN (Titanium Nitride) coating

Titanium Nitride gives the tool a higher performance in comparison to traditional non-coated drills.
TiN coating, with good all-around properties, is recommended for the general application, i.e., attack by abrasive, adhesive and chemical wear in equal proportions.

(2) TiCN (Titanium Carbon Nitride) coating

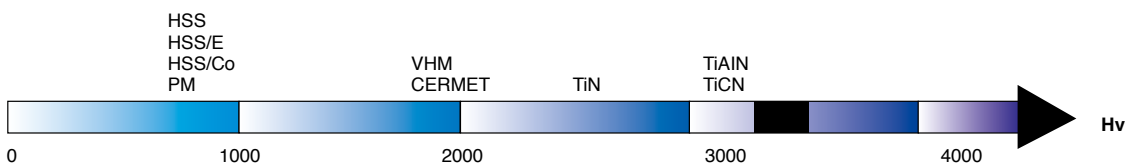
TiCN coating should be employed when severe thermodynamic stress is expected, for example when drilling in high hardened steels or in mild steels with high speed and feed.

(3) TiAlN (Titanium Alumium Nitride) coating

The addition of Aluminum to the Titanium Nitride produces an increase in hardness and an exceptional increase in resistance to oxidation at high temperature.
TiAlN coating is applied to drilling with severe thermal stress on cutting edges when continuous non-step feed, dry cutting or high speed cutting.

(4) Properties of coating

Properties	TiN	TiCN	TiAlN
Coating color	gold - yellow	blue - grey	violet - grey
Hardness (Hv 0.05)	2300	3000	3000
Coating thickness(㎛)	1~4	1~4	1~5
Max. working temperature (°C)	600	400	800
Coefficient of friction against steels(dry)	0.4	0.4	0.4



(5) Selection of coating

Work-material	HSS TWIST DRILLS	CARBIDE DRILLS
Unalloyed steels	TiCN, TiAlN	TiCN, TiAlN
Steels < 1000 N/mm²	TiCN, TiAlN	TiCN, TiAlN
Steels > 1000 N/mm²	TiCN, TiAlN	TiCN, TiAlN
Stainless steels	TiCN, TiAlN	TiCN, TiAlN
Cast iron	TiCN, TiAlN	TiAlN
Al-wrought alloys	TiN	TiN
Al-cast alloys	TiCN	TiCN
Copper (pure)	CrN	CrN
Brass	TiCN	TiCN
Bronze	TiCN	TiCN

Drill sizes before Tapping

(1) Metric - ISO threads coarse pitch

Nominal diameter	Drill diameter	Nominal diameter	Drill diameter	Nominal diameter	Drill diameter	Nominal diameter	Drill diameter
		M3	2.5	M11	9.5	M30	26.5
M1	0.75	M3.5	2.9	M12	10.2	M33	29.5
M1.2	0.95	M4	3.3	M14	12.0	M36	32.0
M1.4	1.1	M5	4.2	M16	14.0	M39	35.0
M1.6	1.25	M6	5.0	M18	15.5	M42	37.5
M1.8	1.45	M7	6.0	M20	17.5	M45	40.5
M2	1.6	M8	6.8	M22	19.5	M48	43.0
M2.2	1.75	M9	7.8	M24	21.0	M52	47.0
M2.5	2.05	M10	8.5	M27	24.0	M56	50.5

(2) Metric ISO threads fine pitch

Nominal diameter	Tap Pitch	Drill diameter	Nominal diameter	Tap Pitch	Drill diameter	Nominal diameter	Tap Pitch	
2.5	0.35	2.15	17	1.5	15.5	33	1.5	31.5
3	0.35	2.65	18	1	17	33	2	31
3.5	0.35	3.15	18	1.5	16.5	33	3	30
4	0.5	3.5	18	2	16	35	1.5	33.5
4.5	0.5	4	20	1	19	36	1.5	34.5
5	0.5	4.5	20	1.5	18.5	36	2	34
5.5	0.5	5	20	2	18	36	3	33
6	0.75	5.2	22	1	21	38	1.5	36.5
7	0.75	6.2	22	1.5	20.5	39	1.5	37.5
8	0.75	7.2	22	2	20	39	2	37
8	1	7	24	1	23	39	3	36
9	0.75	8.2	24	1.5	22.5	40	1.5	38.5
9	1	8	24	2	22	40	2	38
10	0.75	9.2	25	1	24	40	3	37
10	1	9	25	1.5	23.5	42	1.5	40.5
10	1.25	8.8	25	2	23	42	2	40
11	0.75	10.2	26	1.5	24.5	42	3	39
11	1	10	27	1	26	45	1.5	43.5
12	1	11	27	1.5	25.5	45	2	43
12	1.25	10.8	27	2	25	45	3	42
12	1.5	10.5	28	1	27	48	1.5	46.5
14	1	13	28	1.5	26.5	48	2	46
14	1.25	12.8	28	2	26	48	3	45
14	1.5	12.5	30	1	29	50	1.5	48.5
15	1	14	30	1.5	28.5	50	2	48
15	1.5	13.5	30	2	28	50	3	47
16	1	15	30	3	27	52	1.5	50.5
16	1.5	14.5	32	1.5	30.5	52	2	50
17	1	16	32	2	30	52	3	49

(3) WITHWORTH pipe threads (BSP)

Nominal size	Drill diameter	Nominal size	Drill diameter
inches	mm	inches	mm
G1/8	8.8	G1∗1/4	39.5
G1/4	11.8	G1∗3/8	42.0
G3/8	15.25	G1∗1/2	45.0
G1/2	19.0	G1∗3/4	51.0
G5/8	21.0	G2	57.0
G3/4	24.5	G2∗1/4	63.0
G7/8	28.25	G2∗1/2	73.0
G1	30.75	G2∗3/4	79.0
G11/8	35.5	G3	85.0

(4) American unified coarse threads

UNC	Drill diameter		UNC	Drill diameter	
	inches	mm		inches	mm
No. 1	53	1.51	**7/16**	U	9.35
No. 2	50	1.78	**1/2**	27/64	10.71
No. 3	47	1.99	**9/16**	31/64	12.30
No. 4	43	2.26	**5/8**	17/32	13.49
No. 5	38	2.58	**3/4**	21/32	16.67
No. 6	36	2.71	**7/8**	49/64	19.44
No. 8	29	3.45	**1**	7/8	22.22
No. 10	25	3.8	**1∗1/8**	63/64	25.00
No. 12	16	4.5	**1∗1/4**	1∗7/64	28.18
1/4	7	5.11	**1∗3/8**	1∗7/32	30.95
5/16	F	6.53	**1∗1/2**	1∗11/32	34.13
3/8	5/16	7.94			

(5) American unified fine threads

NF	Drill diameter		NF	Drill diameter	
	inches	mm		inches	mm
No. 0	3/64	1.19	**3/8**	Q	8.43
No. 1	53	1.51	**7/16**	25/64	9.92
No. 2	50	1.78	**1/2**	29/64	11.51
No. 3	45	2.08	**9/16**	33/64	13.10
No. 4	42	2.37	**5/8**	37/64	14.86
No. 5	37	2.64	**3/4**	11/16	17.46
No. 6	33	2.87	**7/8**	13/16	20.64
No. 8	29	3.45	**1**	59/64	23.42
No. 10	21	4.04	**1∗1/8**	1∗ 3/64	26.59
No. 12	14	4.62	**1∗1/4**	1∗11/32	29.76
1/4	3	5.41	**1∗3/8**	1∗19/32	32.94
5/16	1	6.91	**1∗1/2**	1∗27/64	36.11

ISO Tolerance

Drill Diameter Tolerance Inch

up to .118	over .118 up to .236	over .236 up to .394	over .394 up to .709
+0 -.00055	+0 -.00071	+0 -.00087	+0 -.00106

Drill Diameter Tolerance Metric

Diameter (mm)	1 - 3 from to	3 - 6 over to	6 - 10 over to	10 - 18 over to	18 - 30 over to
h6	0 –.00024	0 –.00032	0 –.00036	0 –.00044	0 –.00052
h7	0 –.0004	0 –.00048	0 –.00059	0 –.00071	0 –.00083
h8	0 –.00056	0 –.00071	0 –.00087	0 –.00107	0 –.00130
m7	+.00048 +.00007	+.00063 +.00015	+.00083 +.00023	+.00099 +.00027	+.00114 +.00031

Trouble Shooting in Drilling

Occurrence of trouble	Cause of trouble	Countermeasures
Drill will not enter work	1. Drill is dull. 2. Lip relief too small. 3. Too thick a web.	1. Grind lip relief sufficiently. 2. Grind web thinning. 3. Choose a drill with narrow web.
Margin chipping	1.Oversized jig bushing.	1. Choose the suitable jig bushing for drill diameter
Cutting lip breaks	1. Lip relief too much. 2. Feed too heavy.	1. Grind lip relief sufficiently. 2. Decrease feed rate.
Tang breaks Bruch der	1. Imperfect fit between taper shank and socket. 2. Burred or Badly worn sockets.	1. Clean the dirt or chips in sockets. 2. Change the worn sockets to new ones.
Drill breaks in brass	1. Unsuitable drill 2. Flutes clogged with chips	1. Choose the suitable drill for work material.
Chipping of drill center	1. Lip relief too much. 2. Feed too heavy.	1. Grind lip relief sufficiently. 2. Decrease feed rate.
Hole oversize	1. Unequal angle or length of cutting edges. 2. Loosen spindle.	1. Resharpening point, choose correct drills. 2. Tighten spindle sufficiently.
Outer corners broken down	1. Cutting speed too high. 2. Hard spots in work material. 3. Flutes clogged with chips. 4. Too wear of drills.	1. Grind point to suit work material. 2. Decrease the feed rates. 3. Resharpening early beforce too wear.
Large chip of one flute and small chip of other flute	1. Improperly ground point. 2. Only one lip doing all the cutting	1. Properly grind point. 2. Grind point with same point angle and length of lip 3. Grind with small lip height.
Hole rough	1. Improperly ground point. 2. Unenough coolant supply 3. Too much feed. 4. Fixture not rigid.	1. Properly grind point. 2. Supply coolant enough. 3. Decrease the feed rate. 4. Tighten the fixture or replace.

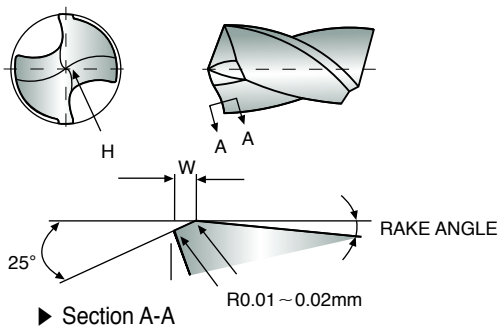
Characteristic of DREAM DRILLS

- YG-1□ Dream Drill Series are suitable for high speed and accurate drilling operations by special design and high quality.
- Good performance for Steels, Cast Irons, Tool steels, Alloy steels and Stainless steels.
- Rapid chip evacuation and excellent chip breaking can be achieved by special designed cutting edges on point and chip breakers on leading edges.
- High accuracy and stability.
- Longer tool life with TiAlN coating.
- Self-centering

TECHNICAL DATA

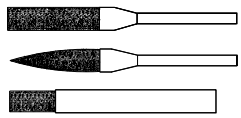
17 Honing Guide of DREAM DRILLS

■ **Dimension of Honing**



▶ Section A-A

■ **Scraper**



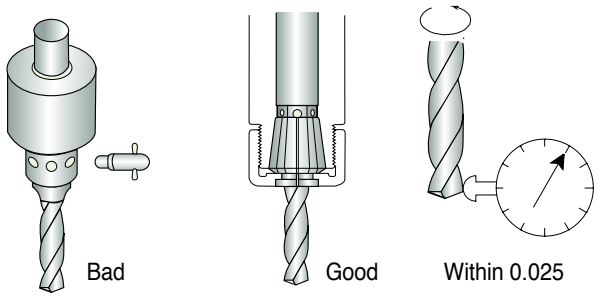
for Roughing (#140)

for Finishing (#230～#400)

Work Material	Alloy Steels	Mild Steels	Cast Iron
W(mm)	0.15～0.2	0.1～0.15	0.03

▶ The dimension W of stocked products is 0.1～0.15.

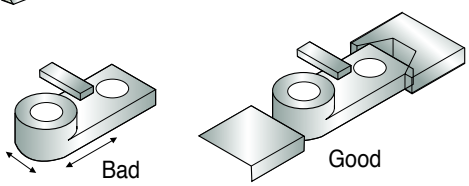
18 Use of DREAM DRILLS

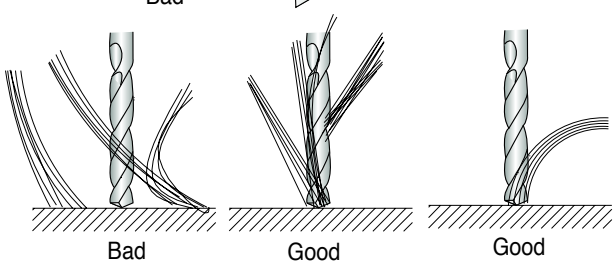


▶ Chucking with spring collet correctly.

▶ Radial run out at cutting lip must not exceed 0.025 mm.

▶ Tighten clamp of work piece.

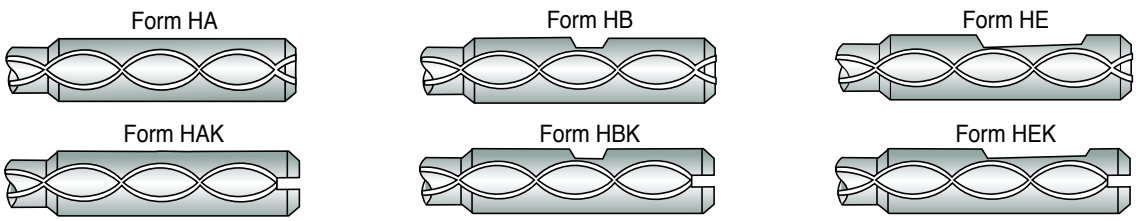




▶ Supply coolant enough to the entrance of hole.

▶ When using Dream Drills with Coolant holes, Supply high pressure coolant.

19 Shank Type DREAM DRILLS with Coolant Holes



▶ Shank Type of stocked products is Form HA.

▶ If you need other Shank Type, we can supply them.