

DRILLING (BRAZED TYPE)

BRS

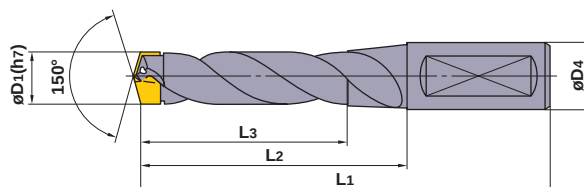
- Excellent cutting sharpness and chip discharge due to high rake type insert.
- High efficiency, high accuracy machining.
- Suitable for stainless steel, mild steel and general steel drilling. (l/d=3)

CARBIDE

Carbon Steel Alloy Steel	Hardened Steel	Stainless Steel	Cast Iron	Light Alloy	Heat Resistant Alloy
◎		◎	○		

14 ≤ D ₁ ≤ 18	18 < D ₁ ≤ 30
$\begin{matrix} 0 \\ -0.018 \end{matrix}$	$\begin{matrix} 0 \\ -0.021 \end{matrix}$

(l/d=3)



Drill Dia. D1 (mm)	Standard Diameter		Intermediate Diameters		Dimensions (mm)			
	Order Number	Stock	Range of Drill Diameters (D1)	Order Number	L3	L2	L1	D4
		UP20M						
14.0	BRS1400S16	●	14.0<D1<14.5	BRS□□□□S16	52	66	114	16
14.5	1450S16	●			52	66	114	16
15.0	1500S20	★	14.5<D1<15.5	BRS□□□□S20	61	76	126	20
15.5	1550S20	●			61	76	126	20
16.0	1600S20	●	15.5<D1<16.5		65	81	131	20
16.5	1650S20	●			65	81	131	20
17.0	1700S20	●	16.5<D1<17.5		69	86	136	20
17.5	1750S20	●			69	86	136	20
18.0	1800S20	●	17.5<D1<18.5		73	91	141	20
18.5	1850S20	●			73	91	141	20
19.0	1900S25	●	18.5<D1<19.5	BRS□□□□S25	77	101	157	25
19.5	1950S25	●			77	101	157	25
20.0	2000S25	●	19.5<D1<20.5		81	101	157	25
20.5	2050S25	●			81	101	157	25
21.0	2100S25	●	20.5<D1<21.5		80	101	157	25
21.5	2150S25	★			80	101	157	25
22.0	2200S25	●	21.5<D1<22.5		84	106	162	25
22.5	2250S25	★			84	106	162	25
23.0	2300S25	●	22.5<D1<23.5		83	106	162	25
23.5	2350S25	★			83	106	162	25
24.0	2400S32	●	23.5<D1<24.5	BRS□□□□S32	87	111	171	32
24.5	2450S32	●			87	111	171	32
25.0	2500S32	●	24.5<D1<25.5		86	111	171	32
25.5	2550S32	★			86	111	171	32
26.0	2600S32	★	25.5<D1<26.5		90	116	176	32
26.5	2650S32	●			90	116	176	32
27.0	2700S32	★	26.5<D1<27.5		89	116	176	32
27.5	2750S32	★			89	116	176	32
28.0	2800S32	●	27.5<D1<28.5		93	121	181	32
28.5	2850S32	★			93	121	181	32
29.0	2900S32	★	28.5<D1<29.5		97	126	186	32
29.5	2950S32	★			97	126	186	32
30.0	3000S32	★	29.5<D1<30.5		96	126	186	32

For ordering an intermediate diameter, please enter the diameter (D₁) into the 4-digit space □□□□ in the nominal designation.
(Ex. UP20M BRS2□5□3□0S32 for a diameter of φ25.30mm)

● : Inventory maintained. ★ : Inventory maintained in Japan.