









DRILL NAVI









DRILL SELECTION CHART

DRILL SELECTION CHART - 1ST RECOMMENDATION FOR STAINLESS STEEL

● HSS-Co Drills

Size Range (mm)	Hole Depth (L/d)	Drill Tolerance	Drill Type/ Series	Shape	Internal Coolant	Coating	Shank Type		Page Number	
							(whistle notch)	(cylindrical) *	Dimensions	Cutting Conditions
φ0.5-φ20.0	~5	*	VAPDS-SUS					●	D198	D210
φ0.5-φ13.0	~12	*	VAPDM-SUS					●	D204	D210
φ1.0-φ13.0	~10	*	VEUSM					●	D211	D213

● Brazed Drills

Size Range (mm)	Hole Depth (L/d)	Drill Tolerance	Drill Type/ Series	Shape	Internal Coolant	Coating	Shank Type		Page Number	
							(clamping face)	(cylindrical)	Dimensions	Cutting Conditions
φ8.0-φ40.0	3	h7	BRA		●		●		D179	D184
φ14.0-φ30.0	3	h7	BR5		●		●		D181	D184
	5	h8	BRM		●		●		D182	D184
	7	h8	BRK		●		●		D183	D184

*Note: Manufacturers Standard. For more details please refer to the product page.