






# DRILL NAVI





## DRILL SELECTION CHART

DRILLING DRILL SELECTION CHART - 1ST RECOMMENDATION FOR CAST IRON

● HSS-Co 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
φ0.5-φ13.0	~6	*	<b>VAPDS</b>			V		●	D185	D194
φ0.5-φ32.0	~12	*	<b>VAPDM</b>			V		●	D190	D194
φ0.5-φ13.0	~12	*	<b>VSD</b>			V		●	D212	D214

● 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	<b>BRA</b>		●	UP	●		D179	D184
φ14.0-φ30.0	3	h7	<b>BRS</b>		●	UP	●		D181	D184
	5	h8	<b>BRM</b>		●	UP	●		D182	D184
	7	h8	<b>BRK</b>		●	UP	●		D183	D184

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

