















DRILL NAVI

DRILL SELECTION CHART

DRILLING DRILL SELECTION CHART - 1ST RECOMMENDATION SUPER ALLOYS

Size Range (mm)	Hole Depth (L/d)	Drill Tolerance	Drill Type/ Series	Shape	Internal Coolant	Coating	Shank Type			Page Number	
							(whistle notch) DIN 6535HE	(cylindrical) DIN 6535HA	(cylindrical) *	Dimensions	Cutting Conditions
φ3.0-φ20.0	2	h8	MWE...SA			VP			●	D038	D056
	3	h8	MWE...MA			VP			●	D038	D056
φ3.0-φ25.0	3	h8	MWS...MB		●	VP			●	D038	D057
	5	h8	MWS...LB		●	VP			●	D038	D057
φ3.0-φ16.0	8	h7	MWS...X8DB		●	VP			●	D038	D057
φ3.0-φ14.0	10	h7	MWS...X10DB		●	VP			●	D049	D057
	15	h7	MWS...X15DB		●	VP			●	D049	D057
	20	h7	MSL...L20C		●	VP		●		D049	D057
φ3.0-φ12.0	25	h7	MSL...L25C		●	VP		●		D049	D057
φ3.0-φ10.0	30	h7	MSL...L30C		●	VP		●		D049	D057
φ20.5-φ25.0	3	h8	MWS...MB		●	VP			●	D047	D057
	5	h8	MWS...LB		●	VP			●	D047	D057

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