

DRILL NAVI

DRILL SELECTION CHART



● Mini Solid Carbide Drills

Size Range (mm)	Hole Depth (L/d)	Drill Tolerance	Drill Type/ Series	Shape	Internal Coolant	Coating	Shank Type			Page Number	
							(whistle notch) DIN 6535HE	(cilindrico) DIN 6535HA	(cilindrico) *	Dimensions	Cutting Conditions
φ0.10-φ3.0	5-12	0 ~ -0.009	MSE			VP			●	D026	D029
	-	-	MSP	 *Pilot Drill for MSE		VP			●	D028	D029
φ0.70-φ3.0	-100	0 ~ -0.005	MGS		●				*	D090	D091
φ0.5-φ2.95	1	0 ~ -0.014	MWS...SB		●	VP			●	D033	D056
φ0.5-φ2.9	5	*	MWS...LB		●	VP			●	D033	D056
	12	*	MWS...XB		●	VP			●	D033	D056
φ1.0-φ2.95	20	*	MWS...X20DB		●	VP			●	D035	D056
	25	*	MWS...X25DB		●	VP			●	D035	D056
	30	*	MWS...X30DB		●	VP			●	D035	D056

● 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)	(cilindrico) *	Dimensions	Cutting Conditions	
φ0.5-φ13.0	~6	*	VAPDS			V			●	D187	D196
φ0.5-φ32.0	~12	*	VAPDM			V			●	D192	D196

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

DRILLING DRILL SELECTION CHART - 1ST RECOMMENDATION FOR SUPER ALLOYS

