






DRILL NAVI





DRILL SELECTION CHART

DRILLING | DRILL SELECTION CHART - 1ST RECOMMENDATION FOR 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-φ13.0 | ~6 | * | VAPDS |  | | V | | ● | D187 | D196 |
| φ0.5-φ32.0 | ~12 | * | VAPDM |  | | V | | ● | D192 | D196 |
| φ0.5-φ13.0 | ~12 | * | VSD |  | | V | | ● | D214 | D216 |

● 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 |  | ● | UP | ● | | D179 | D184 |
| φ14.0-φ30.0 | 3 | h7 | BRS |  | ● | UP | ● | | D181 | D184 |
| | 5 | h8 | BRM |  | ● | UP | ● | | D182 | D184 |
| | 7 | h8 | BRK |  | ● | UP | ● | | D183 | D184 |

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