

HSS



Being the best through innovation



HPD DRILLS

- 高级的高速钢HPD直柄钻
普通钢和不锈钢

PREMIUM HSS HPD STRAIGHT SHANK DRILLS
General Steels and Stainless Steels

SELECTION GUIDE

HPD-高性能钻头

HPD 钻头可以在普通钢上进行高精度钻孔。

HPD 不锈钢用钻头可以在不锈钢上进行高精度钻孔。

项目	型号	规格	尺寸		页	
			最小	最大		
ITEM	MODEL	DESCRIPTION	SIZE		PAGE	
			MIN	MAX		
D4541		含钴优质高速钢, 钢用HPD麻花钻头 PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS	超短 STUB	D2.0	D13.0	124
D4542		含钴优质高速钢, 钢用HPD麻花钻头 PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS	细长 JOBBER	D2.0	D32.0	128
DJ543		HSS-EX, 不锈钢用HPD-SUS麻花钻头 HSS-EX, HPD-SUS DRILLS for STAINLESS STEELS	超短 STUB	D2.0	D13.0	133
DJ544		HSS-EX, 不锈钢用HPD-SUS麻花钻头 HSS-EX, HPD-SUS DRILLS for STAINLESS STEELS	细长 JOBBER	D2.0	D20.0	135
推荐的切削条件 RECOMMENDED CUTTING CONDITIONS					138	

PREMIUM HSS HPD STRAIGHT SHANK DRILLS

HPD - HIGH PERFORMANCE DRILLS

HPD Drills for High precision drilling in general steels.

HPD-SUS Drills for High precision drilling in Stainless steels

◎ : 优(Excellent)
○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○	○			
◎	◎	○			○	○	○	○			
◎						○	◎	○	○	○	
◎						○	◎	○	○	○	

含钴优质高速钢, 钢用HPD麻花钻头
PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS

超硬

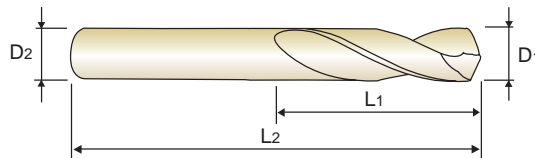
STUB

- ▶ 应用：用于NC/CNC机床上的精密孔加工，可加工高硬度高韧性材料，合金工具钢，镍铬合金，镍钼合金，铸铁，铸铝等。
- ▶ 优点：横刃修磨成P型，提高了排屑性能，具有自定心功能，减少了切削力，提高了加工的精度。
 强化型钻芯和短刃，增强了刚性，减少了加工时的振动和偏心。
 优质含钴高速钢加超级TiN涂层，适用于更高的转速和进给速度，提高了钻头的使用寿命。
 加工表面光洁度好，加工效率高。

- ▶ **Application** : Designed for accurate drilling on NC/CNC machines. Drilling hard and tough materials, alloyed tool steels, inconel, nimonic, cast iron, aluminum die casting, etc.
- ▶ **Advantage** : Helical thinning - good chip removal, self-centering, reducing thrust and improving accuracy. Reinforced web and stub length - increasing rigidity, reducing vibration and deflection. Premium Cobalt HSS with superior TiN coating - higher speed and feed, longer tool life. High quality & good surface finish, high productivity



under 4mm 4mm & over



P.138

D1=D2

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
D4541020	2.0	12	44	D4541032	3.2	18	50
D4541920	2.05	12	44	D4541932	3.25	18	50
D4541021	2.1	12	44	D4541033	3.3	18	50
D4541921	2.15	13	45	D4541933	3.35	18	50
D4541022	2.2	13	45	D4541034	3.4	20	52
D4541922	2.25	13	45	D4541934	3.45	20	52
D4541023	2.3	13	45	D4541035	3.5	20	52
D4541923	2.35	13	45	D4541935	3.55	20	52
D4541024	2.4	14	46	D4541036	3.6	20	52
D4541924	2.45	14	46	D4541936	3.65	20	52
D4541025	2.5	14	46	D4541037	3.7	20	52
D4541925	2.55	14	46	D4541937	3.75	20	52
D4541026	2.6	14	46	D4541038	3.8	22	54
D4541926	2.65	14	46	D4541938	3.85	22	54
D4541027	2.7	16	48	D4541039	3.9	22	54
D4541927	2.75	16	48	D4541939	3.95	22	54
D4541028	2.8	16	48	D4541040	4.0	22	54
D4541928	2.85	16	48	D4541940	4.05	22	66
D4541029	2.9	16	48	D4541041	4.1	22	66
D4541929	2.95	16	48	D4541941	4.15	22	66
D4541030	3.0	16	48	D4541042	4.2	22	66
D4541930	3.05	18	50	D4541942	4.25	22	66
D4541031	3.1	18	50	D4541043	4.3	24	68
D4541931	3.15	18	50	D4541943	4.35	24	68

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Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○	○			

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

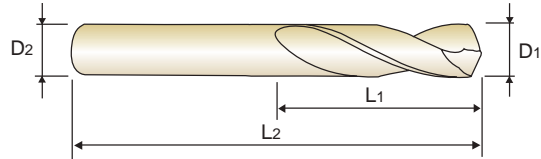
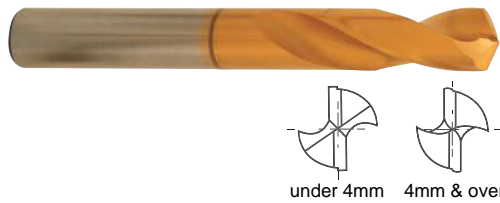


含钴优质高速钢, 钢用HPD麻花钻头

PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS

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TiN	D1	L1	L2	TiN	D1	L1	L2
D4541044	4.4	24	68	D4541056	5.6	28	72
D4541944	4.45	24	68	D4541956	5.65	28	72
D4541045	4.5	24	68	D4541057	5.7	28	72
D4541945	4.55	24	68	D4541957	5.75	28	72
D4541046	4.6	24	68	D4541058	5.8	28	72
D4541946	4.65	24	68	D4541958	5.85	28	72
D4541047	4.7	24	68	D4541059	5.9	28	72
D4541947	4.75	24	68	D4541959	5.95	28	72
D4541048	4.8	26	70	D4541060	6.0	28	72
D4541948	4.85	26	70	D4541061	6.1	31	75
D4541049	4.9	26	70	D4541062	6.2	31	75
D4541949	4.95	26	70	D4541063	6.3	31	75
D4541050	5.0	26	70	D4541064	6.4	31	75
D4541950	5.05	26	70	D4541065	6.5	31	75
D4541051	5.1	26	70	D4541965	6.55	31	75
D4541951	5.15	26	70	D4541066	6.6	31	75
D4541052	5.2	26	70	D4541966	6.65	31	75
D4541952	5.25	26	70	D4541067	6.7	31	75
D4541053	5.3	26	70	D4541068	6.8	34	78
D4541953	5.35	28	72	D4541069	6.9	34	78
D4541054	5.4	28	72	D4541070	7.0	34	78
D4541954	5.45	28	72	D4541071	7.1	34	78
D4541055	5.5	28	72	D4541072	7.2	34	78
D4541955	5.55	28	72	D4541073	7.3	34	78

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-HB225	HB225~325	HRC30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○	○			

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

含钴优质高速钢, 钢用HPD麻花钻头

超硬

PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS

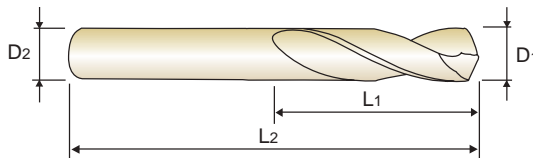
STUB

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under 4mm 4mm & over



P.138

D1=D2

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TiN	D1	L1	L2	TiN	D1	L1	L2
D4541973	7.35	34	78	D4541092	9.2	40	90
D4541074	7.4	34	78	D4541992	9.25	40	90
D4541075	7.5	34	78	D4541093	9.3	40	90
D4541975	7.55	37	81	D4541993	9.35	40	90
D4541076	7.6	37	81	D4541094	9.4	40	90
D4541976	7.65	37	81	D4541994	9.45	40	90
D4541077	7.7	37	81	D4541095	9.5	40	90
D4541078	7.8	37	81	D4541995	9.55	43	93
D4541079	7.9	37	81	D4541096	9.6	43	93
D4541080	8.0	37	81	D4541996	9.65	43	93
D4541081	8.1	37	87	D4541097	9.7	43	93
D4541082	8.2	37	87	D4541098	9.8	43	93
D4541083	8.3	37	87	D4541099	9.9	43	93
D4541983	8.35	37	87	D4541999	9.95	43	93
D4541084	8.4	37	87	D4541100	10.0	43	93
D4541085	8.5	37	87	D4541101	10.1	43	100
D4541985	8.55	40	90	D4541102	10.2	43	100
D4541086	8.6	40	90	D4541802	10.25	43	100
D4541986	8.65	40	90	D4541103	10.3	43	100
D4541087	8.7	40	90	D4541803	10.35	43	100
D4541088	8.8	40	90	D4541104	10.4	43	100
D4541089	8.9	40	90	D4541105	10.5	43	100
D4541090	9.0	40	90	D4541805	10.55	43	100
D4541091	9.1	40	90	D4541106	10.6	43	100

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◎	◎	○			○	○	○	○			

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DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

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CENTER DRILLS

SPADE DRILLS

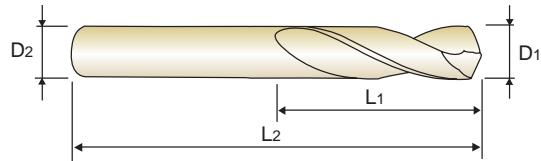
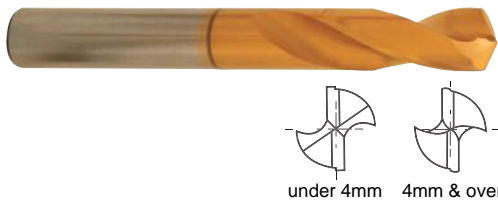
TECHNICAL DATA



含钴优质高速钢, 钢用HPD麻花钻头
PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS 超硬
STUB

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PREMIUM HSS-Co N 25° h7 h8 130° P.138

D1=D2

单位(Unit) : mm

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TiN	D1	L1	L2	TiN	D1	L1	L2
D4541806	10.65	47	104	D4541117	11.7	47	104
D4541107	10.7	47	104	D4541118	11.8	47	104
D4541108	10.8	47	104	D4541119	11.9	51	108
D4541109	10.9	47	104	D4541120	12.0	51	108
D4541809	10.95	47	104	D4541121	12.1	51	108
D4541110	11.0	47	104	D4541122	12.2	51	108
D4541111	11.1	47	104	D4541123	12.3	51	108
D4541112	11.2	47	104	D4541124	12.4	51	108
D4541812	11.25	47	104	D4541125	12.5	51	108
D4541113	11.3	47	104	D4541126	12.6	51	108
D4541813	11.35	47	104	D4541127	12.7	51	108
D4541114	11.4	47	104	D4541128	12.8	51	108
D4541115	11.5	47	104	D4541129	12.9	51	108
D4541815	11.55	47	104	D4541130	13.0	51	108
D4541116	11.6	47	104				

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◎	◎	○			○	○	○	○			

DREAM DRILLS

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DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

含钴优质高速钢, 钢用HPD麻花钻头

细长

PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS

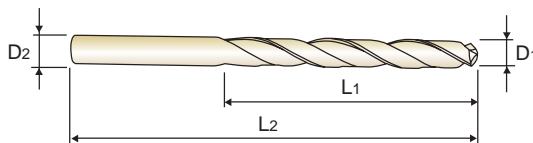
JOBBER

- ▶ 应用：用于4-5倍孔径的高速钻削，适用于低碳钢，铸铁，铝，合金工具钢等材料。
- ▶ 优点：横刃修磨成R型，提高了排屑性能，具有自定心功能，减少了切削力，提高了加工的精度。
强化型钻芯和细长，增强了刚性，适合于4-5倍孔径的钻削。
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- ▶ **Application** : Designed for high speed non-step 4D ~ 5D drilling. Drilling mild steels, cast iron, aluminum, alloyed tool steels, etc.
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under 4mm 4mm & over



PREMIUM HSS-Co N 30° h7 h6 h8 130° P.138

D1=D2

up to 13mm over 13mm

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
D4542020	2.0	124	56	D4542932	3.25	36	68
D4542920	2.05	24	56	D4542033	3.3	36	68
D4542021	2.1	24	56	D4542933	3.35	36	68
D4542921	2.15	27	59	D4542034	3.4	39	71
D4542022	2.2	27	59	D4542934	3.45	39	71
D4542922	2.25	27	59	D4542035	3.5	39	71
D4542023	2.3	27	59	D4542935	3.55	39	71
D4542923	2.35	27	59	D4542036	3.6	39	71
D4542024	2.4	30	62	D4542936	3.65	39	71
D4542924	2.45	30	62	D4542037	3.7	39	71
D4542025	2.5	30	62	D4542937	3.75	39	71
D4542925	2.55	30	62	D4542038	3.8	43	75
D4542026	2.6	30	62	D4542938	3.85	43	75
D4542926	2.65	30	62	D4542039	3.9	43	75
D4542027	2.7	33	65	D4542939	3.95	43	75
D4542927	2.75	33	65	D4542040	4.0	43	75
D4542028	2.8	33	65	D4542940	4.05	43	87
D4542928	2.85	33	65	D4542041	4.1	43	87
D4542029	2.9	33	65	D4542941	4.15	43	87
D4542929	2.95	33	65	D4542042	4.2	43	87
D4542030	3.0	33	65	D4542942	4.25	43	87
D4542930	3.05	36	68	D4542043	4.3	47	91
D4542031	3.1	36	68	D4542943	4.35	47	91
D4542931	3.15	36	68	D4542044	4.4	47	91
D4542032	3.2	36	68	D4542944	4.45	47	91

▶ TiCN (D7542), TiAlN (DQ542) 可根据客户需求进行加工
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◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○	○			

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

含钴优质高速钢, 钢用HPD麻花钻头

细长

PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS

JOBBER

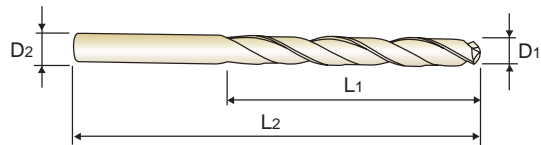
- ▶ 应用：用于4-5倍孔径的高速钻削，适用于低碳钢，铸铁，铝，合金工具钢等材料。
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强化型钻芯和细长，增强了刚性，适合于4-5倍孔径的钻削。
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under 4mm 4mm & over



PREMIUM HSS-Co N 30° h7 h6 h8 130° P.138

D1=D2

up to 13mm over 13mm

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2
D4542045	4.5	47	91
D4542945	4.55	47	91
D4542046	4.6	47	91
D4542946	4.65	47	91
D4542047	4.7	47	91
D4542947	4.75	47	91
D4542048	4.8	52	96
D4542948	4.85	52	96
D4542049	4.9	52	96
D4542949	4.95	52	96
D4542050	5.0	52	96
D4542950	5.05	52	96
D4542051	5.1	52	96
D4542951	5.15	52	96
D4542052	5.2	52	96
D4542952	5.25	52	96
D4542053	5.3	52	96
D4542953	5.35	57	101
D4542054	5.4	57	101
D4542954	5.45	57	101
D4542055	5.5	57	101
D4542955	5.55	57	101
D4542056	5.6	57	101
D4542956	5.65	57	101
D4542057	5.7	57	101

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2
D4542957	5.75	57	101
D4542058	5.8	57	101
D4542958	5.85	57	101
D4542059	5.9	57	101
D4542959	5.95	57	101
D4542060	6.0	57	101
D4542960	6.05	63	107
D4542061	6.1	63	107
D4542961	6.15	63	107
D4542062	6.2	63	107
D4542962	6.25	63	107
D4542063	6.3	63	107
D4542963	6.35	63	107
D4542064	6.4	63	107
D4542964	6.45	63	107
D4542065	6.5	63	107
D4542965	6.55	63	107
D4542066	6.6	63	107
D4542966	6.65	63	107
D4542067	6.7	63	107
D4542967	6.75	69	113
D4542068	6.8	69	113
D4542968	6.85	69	113
D4542069	6.9	69	113
D4542969	6.95	69	113

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◎	◎	○			○	○	○	○			

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TECHNICAL DATA

含钴优质高速钢, 钢用HPD麻花钻头

细长

PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS

JOBBER

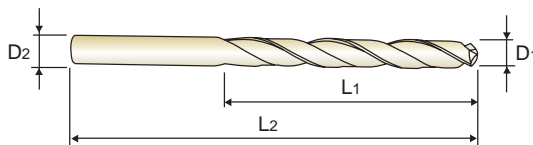
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under 4mm 4mm & over



D1=D2

up to 13mm over 13mm

单位(Unit) : mm

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TiN	D1	L1	L2	TiN	D1	L1	L2
D4542070	7.0	69	113	D4542982	8.25	75	125
D4542970	7.05	69	113	D4542083	8.3	75	125
D4542071	7.1	69	113	D4542983	8.35	75	125
D4542971	7.15	69	113	D4542084	8.4	75	125
D4542072	7.2	69	113	D4542984	8.45	75	125
D4542972	7.25	69	113	D4542085	8.5	75	125
D4542073	7.3	69	113	D4542985	8.55	81	131
D4542973	7.35	69	113	D4542086	8.6	81	131
D4542074	7.4	69	113	D4542986	8.65	81	131
D4542974	7.45	69	113	D4542087	8.7	81	131
D4542075	7.5	69	113	D4542987	8.75	81	131
D4542975	7.55	75	119	D4542088	8.8	81	131
D4542076	7.6	75	119	D4542988	8.85	81	131
D4542976	7.65	75	119	D4542089	8.9	81	131
D4542077	7.7	75	119	D4542989	8.95	81	131
D4542977	7.75	75	119	D4542090	9.0	81	131
D4542078	7.8	75	119	D4542990	9.05	81	131
D4542978	7.85	75	119	D4542091	9.1	81	131
D4542079	7.9	75	119	D4542991	9.15	81	131
D4542979	7.95	75	119	D4542092	9.2	81	131
D4542080	8.0	75	119	D4542992	9.25	81	131
D4542980	8.05	75	125	D4542093	9.3	81	131
D4542081	8.1	75	125	D4542993	9.35	81	131
D4542981	8.15	75	125	D4542094	9.4	81	131
D4542082	8.2	75	125	D4542994	9.45	81	131

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◎	◎	○			○	○	○	○			

含钴优质高速钢, 钢用HPD麻花钻头

细长

PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS

JOBBER

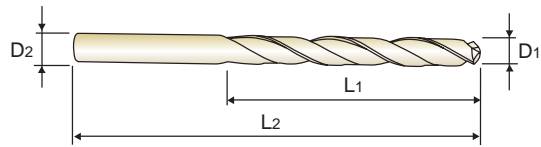
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under 4mm 4mm & over



PREMIUM HSS-Co N 30° h7 h6 h8 130° P.138

D1=D2

up to 13mm over 13mm

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2
D4542095	9.5	81	131
D4542995	9.55	87	137
D4542096	9.6	87	137
D4542996	9.65	87	137
D4542097	9.7	87	137
D4542997	9.75	87	137
D4542098	9.8	87	137
D4542998	9.85	87	137
D4542099	9.9	87	137
D4542999	9.95	87	137
D4542100	10.0	87	137
D4542800	10.05	87	144
D4542101	10.1	87	144
D4542801	10.15	87	144
D4542102	10.2	87	144
D4542802	10.25	87	144
D4542103	10.3	87	144
D4542803	10.35	87	144
D4542104	10.4	87	144
D4542804	10.45	87	144
D4542105	10.5	87	144
D4542805	10.55	87	144
D4542106	10.6	87	144
D4542806	10.65	94	151
D4542107	10.7	94	151

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2
D4542807	10.75	94	151
D4542108	10.8	94	151
D4542808	10.85	94	151
D4542109	10.9	94	151
D4542809	10.95	94	151
D4542110	11.0	94	151
D4542810	11.05	94	151
D4542111	11.1	94	151
D4542811	11.15	94	151
D4542112	11.2	94	151
D4542812	11.25	94	151
D4542113	11.3	94	151
D4542813	11.35	94	151
D4542114	11.4	94	151
D4542814	11.45	94	151
D4542115	11.5	94	151
D4542815	11.55	94	151
D4542116	11.6	94	151
D4542816	11.65	94	151
D4542117	11.7	94	151
D4542817	11.75	94	151
D4542118	11.8	94	151
D4542818	11.85	101	158
D4542119	11.9	101	158
D4542819	11.95	101	158

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◎	◎	○			○	○	○	○			

DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

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HPD DRILLS

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细长

PREMIUM HSS COBALT, HPD TWIST DRILLS for STEELS

JOBBER

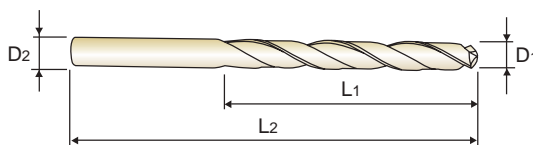
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under 4mm 4mm & over



D1=D2

up to 13mm over 13mm

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
D4542120	12.0	101	158	D4542190	19.0	118	194
D4542121	12.1	101	158	D4542195	19.5	125	201
D4542122	12.2	101	158	D4542196	19.6	125	201
D4542123	12.3	101	158	D4542200	20.0	125	201
D4542124	12.4	101	158	D4542205	20.5	128	204
D4542125	12.5	101	158	D4542210	21.0	128	204
D4542126	12.6	101	158	D4542211	21.1	128	204
D4542127	12.7	101	158	D4542215	21.5	132	208
D4542128	12.8	101	158	D4542220	22.0	132	208
D4542129	12.9	101	158	D4542225	22.5	136	212
D4542130	13.0	101	158	D4542230	23.0	136	212
D4542135	13.5	90	150	D4542235	23.5	136	212
D4542140	14.0	90	150	D4542240	24.0	140	220
D4542141	14.1	95	155	D4542245	24.5	140	220
D4542145	14.5	95	155	D4542250	25.0	140	220
D4542150	15.0	95	161	D4542255	25.5	145	225
D4542155	15.5	100	166	D4542260	26.0	145	225
D4542156	15.6	100	166	D4542265	26.5	145	225
D4542160	16.0	100	166	D4542270	27.0	150	230
D4542165	16.5	106	172	D4542280	28.0	150	230
D4542170	17.0	106	172	D4542290	29.0	155	235
D4542175	17.5	112	178	D4542300	30.0	155	235
D4542176	17.6	112	178	D4542310	31.0	160	240
D4542180	18.0	112	178	D4542320	32.0	165	245
D4542185	18.5	118	184				

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-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○	○			

HSS-EX, 不锈钢用HPD-SUS麻花钻头

超硬

HSS-EX, HPD-SUS TWIST DRILLS for STAINLESS STEELS

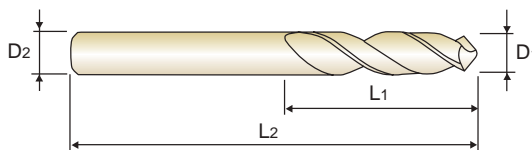
STUB

- ▶ 应用：适用于不锈钢，低碳钢，铝，铝合金，铸铝，铜，铜合金等材料
- ▶ 优点：高螺旋角及锋利的切削力，避免了积屑瘤的产生，适用于高性能钻孔。
宽槽和短刃增强了排屑性能，减少了加工时的振动和摆动。
高钒高速钢材料加超级TiN涂层，适用于更高的转速和进给速度，提高了钻头的使用寿命。
加工表面光洁度好，加工效率高。

- ▶ **Application** : Designed for drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.
- ▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Wide flute and stub length-increasing chip removal and reducing vibration and deflection.
High vanadium HSS-EX material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.



four facet



for STAINLESS STEELS

HSS EX
W 38°
h7
h8
130°
120°
P.138

up to 4mm over 4mm

D1=D2

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
DJ543020	2.0	12	44	DJ543048	4.8	26	70
DJ543021	2.1	12	44	DJ543049	4.9	26	70
DJ543022	2.2	13	45	DJ543050	5.0	26	70
DJ543023	2.3	13	45	DJ543051	5.1	26	70
DJ543024	2.4	14	46	DJ543052	5.2	26	70
DJ543025	2.5	14	46	DJ543053	5.3	26	70
DJ543026	2.6	14	46	DJ543054	5.4	28	72
DJ543027	2.7	16	48	DJ543055	5.5	28	72
DJ543028	2.8	16	48	DJ543056	5.6	28	72
DJ543029	2.9	16	48	DJ543057	5.7	28	72
DJ543030	3.0	16	48	DJ543058	5.8	28	72
DJ543031	3.1	18	50	DJ543059	5.9	28	72
DJ543032	3.2	18	50	DJ543060	6.0	28	72
DJ543033	3.3	18	50	DJ543061	6.1	31	75
DJ543034	3.4	20	52	DJ543062	6.2	31	75
DJ543035	3.5	20	52	DJ543063	6.3	31	75
DJ543036	3.6	20	52	DJ543064	6.4	31	75
DJ543037	3.7	20	52	DJ543065	6.5	31	75
DJ543038	3.8	22	54	DJ543066	6.6	31	75
DJ543039	3.9	22	54	DJ543067	6.7	31	75
DJ543040	4.0	22	54	DJ543068	6.8	34	78
DJ543041	4.1	22	66	DJ543069	6.9	34	78
DJ543042	4.2	22	66	DJ543070	7.0	34	78
DJ543043	4.3	24	68	DJ543071	7.1	34	78
DJ543044	4.4	24	68	DJ543072	7.2	34	78
DJ543045	4.5	24	68	DJ543073	7.3	34	78
DJ543046	4.6	24	68	DJ543074	7.4	34	78
DJ543047	4.7	24	68	DJ543075	7.5	34	78

▶ TiCN (DW543), TiAlN (DY543) 可根据客户需求进行加工
TiCN(DW543), TiAlN(DY543) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRC30~45	HRc45~55	HRc55~							
◎						○	◎	○	○	○	

HSS-EX, 不锈钢用HPD-SUS麻花钻头

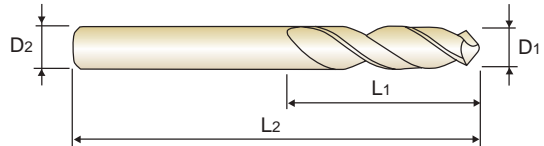
超硬

HSS-EX, HPD-SUS TWIST DRILLS for STAINLESS STEELS

STUB

- ▶ 应用：适用于不锈钢，低碳钢，铝，铝合金，铸铝，铜，铜合金等材料
- ▶ 优点：高螺旋角及锋利的切削力，避免了积屑瘤的产生，适用于高性能钻孔。
宽槽和短刃增强了排屑性能减少了加工时的振动和摆动
高钒高速钢材料加超级TiN涂层，适用于更高的转速和进给速度，提高了钻头的使用寿命。
加工表面光洁度好，加工效率高。

- ▶ **Application** : Designed for drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.
- ▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Wide flute and stub length-increasing chip removal and reducing vibration and deflection.
High vanadium HSS-EX material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.



four facet

for STAINLESS STEELS

HSS EX
W 38°
h7
h8
130°
120°
P.138

up to 4mm over 4mm

D1=D2

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
DJ543076	7.6	37	81	DJ543104	10.4	43	100
DJ543077	7.7	37	81	DJ543105	10.5	43	100
DJ543078	7.8	37	81	DJ543106	10.6	43	100
DJ543079	7.9	37	81	DJ543107	10.7	47	104
DJ543080	8.0	37	81	DJ543108	10.8	47	104
DJ543081	8.1	37	87	DJ543109	10.9	47	104
DJ543082	8.2	37	87	DJ543110	11.0	47	104
DJ543083	8.3	37	87	DJ543111	11.1	47	104
DJ543084	8.4	37	87	DJ543112	11.2	47	104
DJ543085	8.5	37	87	DJ543113	11.3	47	104
DJ543086	8.6	40	90	DJ543114	11.4	47	104
DJ543087	8.7	40	90	DJ543115	11.5	47	104
DJ543088	8.8	40	90	DJ543116	11.6	47	104
DJ543089	8.9	40	90	DJ543117	11.7	47	104
DJ543090	9.0	40	90	DJ543118	11.8	47	104
DJ543091	9.1	40	90	DJ543119	11.9	51	108
DJ543092	9.2	40	90	DJ543120	12.0	51	108
DJ543093	9.3	40	90	DJ543121	12.1	51	108
DJ543094	9.4	40	90	DJ543122	12.2	51	108
DJ543095	9.5	40	90	DJ543123	12.3	51	108
DJ543096	9.6	43	93	DJ543124	12.4	51	108
DJ543097	9.7	43	93	DJ543125	12.5	51	108
DJ543098	9.8	43	93	DJ543126	12.6	51	108
DJ543099	9.9	43	93	DJ543127	12.7	51	108
DJ543100	10.0	43	93	DJ543128	12.8	51	108
DJ543101	10.1	43	100	DJ543129	12.9	51	108
DJ543102	10.2	43	100	DJ543130	13.0	51	108
DJ543103	10.3	43	100				

▶ TiCN (DW543), TiAlN (DY543) 可根据客户需求进行加工
TiCN(DW543), TiAlN(DY543) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎						○	◎	○	○	○	



HSS-EX, 不锈钢用HPD-SUS麻花钻头

HSS-EX, HPD-SUS TWIST DRILLS for STAINLESS STEELS

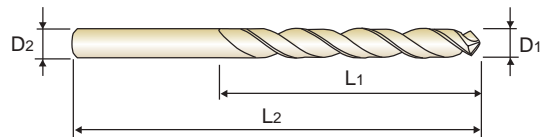
细长 **JOBBER**

- ▶ 应用：用于4-5倍孔径的钻削，适用于不锈钢，铝，铝合金，铸铝，铜，铜合金等材料
- ▶ 优点：高螺旋角及锋利的切削力，避免了积屑瘤的产生，适用于高性能钻孔。
加强的钻腹和合适的长度，增强了钻头的刚性，适合4D-5D深的孔的加工。
高钒高速钢材料加超级TiN涂层，适用于更高的转速和进给速度，提高了钻头的使用寿命。
加工表面光洁度好，加工效率高。

- ▶ **Application** : Designed for 4D ~ 5D drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.
- ▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Reinforced web and jobbers length-increasing rigidity and suitable for 4D ~ 5D drilling.
High vanadium HSS-EX material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.



up to 13mm over 13mm



for STAINLESS STEELS

up to 4mm over 4mm

D1=D2

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
DJ544020	2.0	24	56	DJ544044	4.4	47	91
DJ544021	2.1	24	56	DJ544045	4.5	47	91
DJ544022	2.2	27	59	DJ544046	4.6	47	91
DJ544023	2.3	27	59	DJ544047	4.7	47	91
DJ544024	2.4	30	62	DJ544048	4.8	52	96
DJ544025	2.5	30	62	DJ544049	4.9	52	96
DJ544026	2.6	30	62	DJ544050	5.0	52	96
DJ544027	2.7	33	65	DJ544051	5.1	52	96
DJ544028	2.8	33	65	DJ544052	5.2	52	96
DJ544029	2.9	33	65	DJ544053	5.3	52	96
DJ544030	3.0	33	65	DJ544054	5.4	57	101
DJ544031	3.1	36	68	DJ544055	5.5	57	101
DJ544032	3.2	36	68	DJ544056	5.6	57	101
DJ544033	3.3	36	68	DJ544057	5.7	57	101
DJ544034	3.4	39	71	DJ544058	5.8	57	101
DJ544035	3.5	39	71	DJ544059	5.9	57	101
DJ544036	3.6	39	71	DJ544060	6.0	57	101
DJ544037	3.7	39	71	DJ544061	6.1	63	107
DJ544038	3.8	43	75	DJ544062	6.2	63	107
DJ544039	3.9	43	75	DJ544063	6.3	63	107
DJ544040	4.0	43	75	DJ544064	6.4	63	107
DJ544041	4.1	43	87	DJ544065	6.5	63	107
DJ544042	4.2	43	87	DJ544066	6.6	63	107
DJ544043	4.3	47	91	DJ544067	6.7	63	107

▶ TiCN (DW544), TiAlN (DY544) 可根据客户需求进行加工
TiCN(DW544), TiAlN(DY544) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRC30~45	HRc45~55	HRc55~							
◎						○	◎	○	○	○	

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

HSS-EX, 不锈钢用HPD-SUS麻花钻头

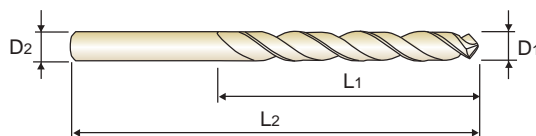
细长

HSS-EX, HPD-SUS TWIST DRILLS for STAINLESS STEELS

JOBBER

- ▶ 应用：用于4-5倍孔径的钻削，适用于不锈钢，铝，铝合金，铸铝，铜，铜合金等材料
- ▶ 优点：高螺旋角及锋利的切削力，避免了积屑瘤的产生，适用于高性能钻孔。
加强的钻腹和合适的长度，增强了钻头的刚性，适合4D-5D深的孔的加工。
高钒高速钢材料加超级TiN涂层，适用于更高的转速和进给速度，提高了钻头的使用寿命。
加工表面光洁度好，加工效率高。

- ▶ **Application** : Designed for 4D ~ 5D drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.
- ▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Reinforced web and jobbers length-increasing rigidity and suitable for 4D ~ 5D drilling.
High vanadium HSS-EX material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.



up to 13mm over 13mm

for STAINLESS STEELS

HSS EX
W 38°
h7
h8
130°
120°
P.138

up to 4mm over 4mm

D1=D2

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiN	D1	L1	L2	TiN	D1	L1	L2
DJ544068	6.8	69	113	DJ544092	9.2	81	131
DJ544069	6.9	69	113	DJ544093	9.3	81	131
DJ544070	7.0	69	113	DJ544094	9.4	81	131
DJ544071	7.1	69	113	DJ544095	9.5	81	131
DJ544072	7.2	69	113	DJ544096	9.6	87	137
DJ544073	7.3	69	113	DJ544097	9.7	87	137
DJ544074	7.4	69	113	DJ544098	9.8	87	137
DJ544075	7.5	69	113	DJ544099	9.9	87	137
DJ544076	7.6	75	119	DJ544100	10.0	87	137
DJ544077	7.7	75	119	DJ544101	10.1	87	144
DJ544078	7.8	75	119	DJ544102	10.2	87	144
DJ544079	7.9	75	119	DJ544103	10.3	87	144
DJ544080	8.0	75	119	DJ544104	10.4	87	144
DJ544081	8.1	75	125	DJ544105	10.5	87	144
DJ544082	8.2	75	125	DJ544106	10.6	87	144
DJ544083	8.3	75	125	DJ544107	10.7	94	151
DJ544084	8.4	75	125	DJ544108	10.8	94	151
DJ544085	8.5	75	125	DJ544109	10.9	94	151
DJ544086	8.6	81	131	DJ544110	11.0	94	151
DJ544087	8.7	81	131	DJ544111	11.1	94	151
DJ544088	8.8	81	131	DJ544112	11.2	94	151
DJ544089	8.9	81	131	DJ544113	11.3	94	151
DJ544090	9.0	81	131	DJ544114	11.4	94	151
DJ544091	9.1	81	131	DJ544115	11.5	94	151

▶ TiCN (DW544), TiAlN (DY544) 可根据客户需求进行加工
TiCN(DW544), TiAlN(DY544) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRC30~45	HRC45~55	HRc55~							
◎						○	◎	○	○	○	



HSS-EX, 不锈钢用HPD-SUS麻花钻头

HSS-EX, HPD-SUS TWIST DRILLS for STAINLESS STEELS

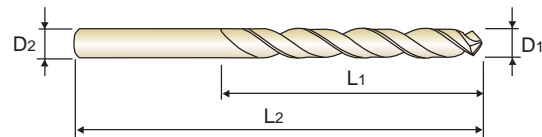
细长 **JOBBER**

- ▶ 应用：用于4-5倍孔径的钻削，适用于不锈钢，铝，铝合金，铸铝，铜，铜合金等材料
- ▶ 优点：高螺旋角及锋利的切削力，避免了积屑瘤的产生，适用于高性能钻孔。
加强的钻腹和合适的长度，增强了钻头的刚性，适合4D-5D深的孔的加工。
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- ▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Reinforced web and jobbers length-increasing rigidity and suitable for 4D ~ 5D drilling.
High vanadium HSS-EX material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.



up to 13mm over 13mm



for STAINLESS STEELS

up to 4mm over 4mm D1=D2

型号	刃径	刃长	全长
EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ544116	11.6	94	151
DJ544117	11.7	94	151
DJ544118	11.8	94	151
DJ544119	11.9	101	158
DJ544120	12.0	101	158
DJ544121	12.1	101	158
DJ544122	12.2	101	158
DJ544123	12.3	101	158
DJ544124	12.4	101	158
DJ544125	12.5	101	158
DJ544126	12.6	101	158
DJ544127	12.7	101	158
DJ544128	12.8	101	158
DJ544129	12.9	101	158
DJ544130	13.0	101	158
DJ544135	13.5	106	166
DJ544140	14.0	106	166

单位(Unit) : mm

型号	刃径	刃长	全长
EDP No.	Drill Diameter	Flute Length	Overall Length
TiN	D1	L1	L2
DJ544141	14.1	109	169
DJ544145	14.5	109	169
DJ544150	15.0	109	169
DJ544155	15.5	112	172
DJ544156	15.6	112	172
DJ544160	16.0	112	172
DJ544165	16.5	115	181
DJ544170	17.0	115	181
DJ544175	17.5	118	184
DJ544176	17.6	118	184
DJ544180	18.0	118	184
DJ544185	18.5	122	188
DJ544190	19.0	122	188
DJ544195	19.5	125	191
DJ544196	19.6	125	191
DJ544200	20.0	125	191

▶ TiCN (DW544), TiAlN (DY544) 可根据客户需求进行加工
TiCN(DW544), TiAlN(DY544) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRC30~45	HRc45~55	HRc55~							
◎						○	◎	○	○	○	

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA



含钴优质高速钢, 钢用高功率麻花钻头, TiN涂层
PREMIUM HSS COBALT, HPD TWIST DRILLS, TiN COATED

D4541, D4542 SERIES

在使用D4542系列HPD钻头时请减少15~20%的进给率
Please decrease the feed rate (15~20%) in D4542 SERIES HPD drills.

单位(Unit) : mm

被加工材料 WORK MATERIAL	碳钢		合金钢		工具钢, 合金钢		铸铁, 工具钢		铝合金, 镁合金	
	CARBON STEELS		ALLOY STEELS (SCM-SNC-SNCM)		TOOL STEELS ALLOY STEELS (SKD11)		CAST IRON TOOL STEELS		ALUMINUM ALLOYS MAGNESIUM ALLOYS	
DIAMETER	N	S	N	S	N	S	N	S	N	S
2.0	4200	0.08	3600	0.08	1750	0.08	5800	0.11	10500	0.16
3.0	2900	0.13	2500	0.13	1170	0.13	4000	0.14	10500	0.25
4.0	2100	0.14	1900	0.14	880	0.14	3000	0.17	8000	0.30
5.0	1700	0.16	1500	0.16	700	0.16	2400	0.20	6500	0.36
6.0	1300	0.17	1300	0.17	580	0.17	2100	0.23	5200	0.42
8.0	1000	0.21	950	0.21	440	0.21	1500	0.26	4200	0.47
10.0	850	0.25	750	0.25	350	0.25	1100	0.32	3400	0.56
12.0	700	0.30	650	0.30	290	0.30	1000	0.38	2700	0.67
14.0	550	0.35	500	0.35	250	0.35	850	0.40	2400	0.72
16.0	520	0.38	470	0.38	220	0.38	750	0.42	2100	0.77
18.0	450	0.44	420	0.44	195	0.44	700	0.45	1900	0.80
20.0	400	0.45	350	0.45	175	0.45	600	0.51	1600	0.87
22.0	370	0.50	340	0.50	160	0.50	550	0.52	1500	0.95
24.0	350	0.54	300	0.54	145	0.54	500	0.58	1400	1.00
26.0	320	0.58	280	0.58	135	0.58	450	0.60	1300	1.05
28.0	300	0.62	260	0.62	125	0.62	420	0.63	1200	1.10
30.0	280	0.66	240	0.66	115	0.66	400	0.74	1100	1.15
32.0	260	0.70	230	0.70	110	0.70	380	0.74	950	1.20

N = R.P.M
S = Feed per Revolution (mm/rev.)

HSS-EX, 不锈钢用HPD-SUS麻花钻头, TiN涂层
HSS-EX, HPD-SUS TWIST DRILLS, TiN COATED

DJ543, DJ544 SERIES

在使用DJ544系列HPD-SUS钻头时请减少15~20%的进给率
Please decrease the feed rate (15~20%) in DJ544 SERIES HPD-SUS drills.

单位(Unit) : mm

被加工材料 WORK MATERIAL	不锈钢		不锈钢		铝, 铝合金		塑料, 铜, 铜合金		软钢, 低碳钢	
	STAINLESS STEELS (SUS304, 200)		STAINLESS STEELS (SUS420, 440)		ALUMINUM & ALUMINIUM ALLOYS		PLASTICS COPPER COPPER ALLOYS		MILD STEELS LOW CARBON STEELS	
DIAMETER	N	S	N	S	N	S	N	S	N	S
2.0	2600	0.03	3100	0.07	11000	0.09	5600	0.06	6300	0.08
3.0	1800	0.04	2100	0.08	7350	0.13	3750	0.08	4200	0.13
4.0	1300	0.06	1600	0.10	7050	0.18	2800	0.10	3200	0.14
5.0	1050	0.08	1250	0.15	5500	0.22	2250	0.13	2500	0.16
6.0	900	0.09	1050	0.18	4600	0.26	1850	0.15	2100	0.18
8.0	650	0.12	800	0.24	3500	0.34	1350	0.20	1550	0.22
10.0	550	0.15	630	0.30	2800	0.40	1100	0.25	1250	0.26
12.0	450	0.18	530	0.36	2300	0.50	950	0.30	1050	0.32
14.0	400	0.33	450	0.44	2050	0.55	800	0.33	900	0.36
16.0	350	0.36	390	0.48	1750	0.62	700	0.35	790	0.40
18.0	300	0.39	350	0.50	1600	0.70	620	0.40	700	0.45
20.0	260	0.43	320	0.53	1450	0.75	560	0.40	620	0.47

N = R.P.M
S = Feed per Revolution (mm/rev.)