

HSS



Being the best through innovation



MULTI-1 DRILLS

粉末高速钢 MULTI-1 钻头
多用途钻头尤其适用于不锈钢

HSS-PM MULTI-1 DRILLS


Multi Purpose Drilling. Particularly for Stainless Steels

SELECTION GUIDE

粉末高速钢MULTI-1钻头

粉末高速钢钻头进行广泛应用

碳素钢, 合金钢, 不锈钢等

项目	型号	规格	尺寸		页	
			最小	最大		
ITEM	MODEL	DESCRIPTION	SIZE		PAGE	
			MIN	MAX		
CDRA03		粉末高速钢 MULTI-1钻头 PREMIUM HSS-PM MULTI-1 DRILLS	超短 STUB	D1.0	D13.0	116
CDRA04		粉末高速钢 MULTI-1钻头 PREMIUM HSS-PM MULTI-1 DRILLS	细长 JOBBER	D2.0	D13.0	118
推荐的切削条件 RECOMMENDED CUTTING CONDITIONS					120	

HSS-PM MULTI-1 DRILLS

PREMIUM HSS-PM MULTI-1 DRILLS

Premium HSS-PM Drills for wide range of applications

- Carbon Steels, Alloy Steels, Stainless steels, etc

◎ : 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~							
◎	◎	○			○	○	○		◎		
◎	◎	○			○	○	○		◎		



粉末高速钢 MULTI-1钻头
PREMIUM HSS-PM MULTI-1 DRILLS

超硬

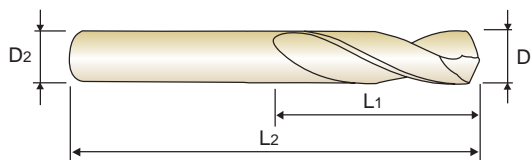
STUB

- ▶ 应用：适用于结构钢，碳素钢，合金钢，预硬化钢，模具钢，不锈钢，淬火钢(H Rc30~45)，铸铁，铝合金，非铁金属合金
- ▶ 优点：钻顶的形状使产品具有极佳的自定心能力。
沟槽的设计使产品的排屑性能更高。
使用粉末高速钢制作使产品具有更优良的韧性。

- ▶ Application : Structural steels, Carbon steels, Alloy steels, Pre-hardened steels, Mold steels, stainless steels, Hardened steels(HRc30~45), Cast iron, Aluminum alloys, Nonferrous alloys.
- ▶ Advantage : Point shape to maximize self-centering.
Flute design for the best chip evacuation.
Premium powder materials with excellent toughness.



up to 1.4mm over 1.4mm



up to 1.9mm over 1.9mm

单位(Unit) : mm

型号	刃径	柄径	刃长	全长	型号	刃径	柄径	刃长	全长
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
CDRA03010	1.0	3	6	38	CDRA03041	4.1	6	22	66
CDRA03011	1.1	3	7	39	CDRA03042	4.2	6	22	66
CDRA03012	1.2	3	8	40	CDRA03043	4.3	6	24	68
CDRA03013	1.3	3	8	40	CDRA03044	4.4	6	24	68
CDRA03014	1.4	3	9	41	CDRA03045	4.5	6	24	68
CDRA03015	1.5	3	9	41	CDRA03046	4.6	6	24	68
CDRA03016	1.6	3	10	42	CDRA03047	4.7	6	24	68
CDRA03017	1.7	3	10	42	CDRA03048	4.8	6	26	70
CDRA03018	1.8	3	11	43	CDRA03049	4.9	6	26	70
CDRA03019	1.9	3	11	43	CDRA03050	5.0	6	26	70
CDRA03020	2.0	3	12	44	CDRA03051	5.1	6	26	70
CDRA03021	2.1	3	12	44	CDRA03052	5.2	6	26	70
CDRA03022	2.2	3	13	45	CDRA03053	5.3	6	26	70
CDRA03023	2.3	3	13	45	CDRA03054	5.4	6	28	72
CDRA03024	2.4	3	14	46	CDRA03055	5.5	6	28	72
CDRA03025	2.5	3	14	46	CDRA03056	5.6	6	28	72
CDRA03026	2.6	3	14	46	CDRA03057	5.7	6	28	72
CDRA03027	2.7	3	16	48	CDRA03058	5.8	6	28	72
CDRA03028	2.8	3	16	48	CDRA03059	5.9	6	28	72
CDRA03029	2.9	3	16	48	CDRA03060	6.0	6	28	72
CDRA03030	3.0	3	16	48	CDRA03061	6.1	8	31	75
CDRA03031	3.1	4	18	50	CDRA03062	6.2	8	31	75
CDRA03032	3.2	4	18	50	CDRA03063	6.3	8	31	75
CDRA03033	3.3	4	18	50	CDRA03064	6.4	8	31	75
CDRA03034	3.4	4	20	52	CDRA03065	6.5	8	31	75
CDRA03035	3.5	4	20	52	CDRA03066	6.6	8	31	75
CDRA03036	3.6	4	20	52	CDRA03067	6.7	8	31	75
CDRA03037	3.7	4	20	52	CDRA03068	6.8	8	34	78
CDRA03038	3.8	4	22	54	CDRA03069	6.9	8	34	78
CDRA03039	3.9	4	22	54	CDRA03070	7.0	8	34	78
CDRA03040	4.0	4	22	54	CDRA03071	7.1	8	34	78

◎ : 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



MULTI-1 DRILLS

CDRA03 SERIES

粉末高速钢 MULTI-1钻头

超硬

PREMIUM HSS-PM MULTI-1 DRILLS

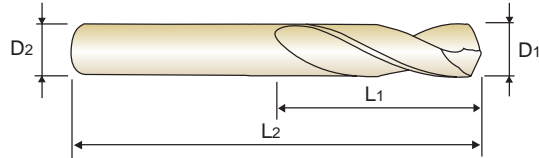
STUB

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P.120

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EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
CDRA03072	7.2	8	34	78	CDRA03102	10.2	12	43	100
CDRA03073	7.3	8	34	78	CDRA03103	10.3	12	43	100
CDRA03074	7.4	8	34	78	CDRA03104	10.4	12	43	100
CDRA03075	7.5	8	34	78	CDRA03105	10.5	12	43	100
CDRA03076	7.6	8	37	81	CDRA03106	10.6	12	43	100
CDRA03077	7.7	8	37	81	CDRA03107	10.7	12	47	104
CDRA03078	7.8	8	37	81	CDRA03108	10.8	12	47	104
CDRA03079	7.9	8	37	81	CDRA03109	10.9	12	47	104
CDRA03080	8.0	8	37	81	CDRA03110	11.0	12	47	104
CDRA03081	8.1	10	37	87	CDRA03111	11.1	12	47	104
CDRA03082	8.2	10	37	87	CDRA03112	11.2	12	47	104
CDRA03083	8.3	10	37	87	CDRA03113	11.3	12	47	104
CDRA03084	8.4	10	37	87	CDRA03114	11.4	12	47	104
CDRA03085	8.5	10	37	87	CDRA03115	11.5	12	47	104
CDRA03086	8.6	10	40	90	CDRA03116	11.6	12	47	104
CDRA03087	8.7	10	40	90	CDRA03117	11.7	12	47	104
CDRA03088	8.8	10	40	90	CDRA03118	11.8	12	47	104
CDRA03089	8.9	10	40	90	CDRA03119	11.9	12	51	108
CDRA03090	9.0	10	40	90	CDRA03120	12.0	12	51	108
CDRA03091	9.1	10	40	90	CDRA03121	12.1	12	51	108
CDRA03092	9.2	10	40	90	CDRA03122	12.2	12	51	108
CDRA03093	9.3	10	40	90	CDRA03123	12.3	12	51	108
CDRA03094	9.4	10	40	90	CDRA03124	12.4	12	51	108
CDRA03095	9.5	10	40	90	CDRA03125	12.5	12	51	108
CDRA03096	9.6	10	43	93	CDRA03126	12.6	12	51	108
CDRA03097	9.7	10	43	93	CDRA03127	12.7	12	51	108
CDRA03098	9.8	10	43	93	CDRA03128	12.8	12	51	108
CDRA03099	9.9	10	43	93	CDRA03129	12.9	12	51	108
CDRA03100	10.0	10	43	93	CDRA03130	13.0	12	51	108
CDRA03101	10.1	12	43	100					

◎ : 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~							
◎	◎	○		○	○	○		◎		

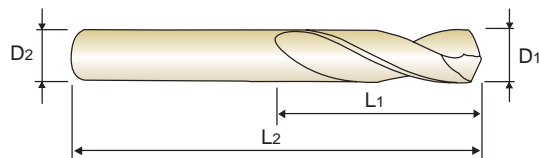
粉末高速钢 MULTI-1钻头
PREMIUM HSS-PM MULTI-1 DRILLS

细长

JOBBER

- ▶ 应用：适用于结构钢，碳素钢，合金钢，预硬化钢，模具钢，不锈钢，淬火钢(H Rc30~45)，铸铁，铝合金，非铁金属合金
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EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
CDRA04020	2.0	3	24	56	CDRA04048	4.8	6	52	94
CDRA04021	2.1	3	24	56	CDRA04049	4.9	6	52	94
CDRA04022	2.2	3	25	56	CDRA04050	5.0	6	52	94
CDRA04023	2.3	3	25	56	CDRA04051	5.1	6	52	94
CDRA04024	2.4	3	30	61	CDRA04052	5.2	6	52	94
CDRA04025	2.5	3	30	61	CDRA04053	5.3	6	52	94
CDRA04026	2.6	3	30	61	CDRA04054	5.4	6	57	99
CDRA04027	2.7	3	33	64	CDRA04055	5.5	6	57	99
CDRA04028	2.8	3	33	64	CDRA04056	5.6	6	57	99
CDRA04029	2.9	3	33	64	CDRA04057	5.7	6	57	99
CDRA04030	3.0	3	33	64	CDRA04058	5.8	6	57	99
CDRA04031	3.1	4	36	68	CDRA04059	5.9	6	57	99
CDRA04032	3.2	4	36	68	CDRA04060	6.0	6	57	99
CDRA04033	3.3	4	36	68	CDRA04061	6.1	8	63	107
CDRA04034	3.4	4	39	71	CDRA04062	6.2	8	63	107
CDRA04035	3.5	4	39	71	CDRA04063	6.3	8	63	107
CDRA04036	3.6	4	39	71	CDRA04064	6.4	8	63	107
CDRA04037	3.7	4	39	71	CDRA04065	6.5	8	63	107
CDRA04038	3.8	4	43	75	CDRA04066	6.6	8	63	107
CDRA04039	3.9	4	43	75	CDRA04067	6.7	8	63	107
CDRA04040	4.0	4	43	75	CDRA04068	6.8	8	69	113
CDRA04041	4.1	6	43	85	CDRA04069	6.9	8	69	113
CDRA04042	4.2	6	43	85	CDRA04070	7.0	8	69	113
CDRA04043	4.3	6	47	89	CDRA04071	7.1	8	69	113
CDRA04044	4.4	6	47	89	CDRA04072	7.2	8	69	113
CDRA04045	4.5	6	47	89	CDRA04073	7.3	8	69	113
CDRA04046	4.6	6	47	89	CDRA04074	7.4	8	69	113
CDRA04047	4.7	6	47	89	CDRA04075	7.5	8	69	113

◎ : 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~							
◎	◎	○			○	○	○		◎		



MULTI-1 DRILLS

CDRA04 SERIES

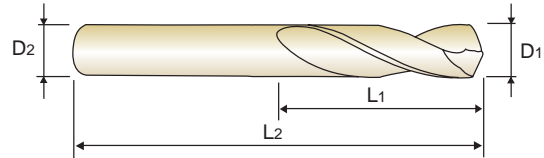
粉末高速钢 MULTI-1钻头 PREMIUM HSS-PM MULTI-1 DRILLS

细长

JOBBER

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P.120

单位(Unit) : mm

型号	刃径	柄径	刃长	全长	型号	刃径	柄径	刃长	全长
EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
CDRA04076	7.6	8	75	119	CDRA04104	10.4	12	87	144
CDRA04077	7.7	8	75	119	CDRA04105	10.5	12	87	144
CDRA04078	7.8	8	75	119	CDRA04106	10.6	12	87	144
CDRA04079	7.9	8	75	119	CDRA04107	10.7	12	94	151
CDRA04080	8.0	8	75	119	CDRA04108	10.8	12	94	151
CDRA04081	8.1	10	75	125	CDRA04109	10.9	12	94	151
CDRA04082	8.2	10	75	125	CDRA04110	11.0	12	94	151
CDRA04083	8.3	10	75	125	CDRA04111	11.1	12	94	151
CDRA04084	8.4	10	75	125	CDRA04112	11.2	12	94	151
CDRA04085	8.5	10	75	125	CDRA04113	11.3	12	94	151
CDRA04086	8.6	10	81	131	CDRA04114	11.4	12	94	151
CDRA04087	8.7	10	81	131	CDRA04115	11.5	12	94	151
CDRA04088	8.8	10	81	131	CDRA04116	11.6	12	94	151
CDRA04089	8.9	10	81	131	CDRA04117	11.7	12	94	151
CDRA04090	9.0	10	81	131	CDRA04118	11.8	12	94	151
CDRA04091	9.1	10	81	131	CDRA04119	11.9	12	101	158
CDRA04092	9.2	10	81	131	CDRA04120	12.0	12	101	158
CDRA04093	9.3	10	81	131	CDRA04121	12.1	12	101	158
CDRA04094	9.4	10	81	131	CDRA04122	12.2	12	101	158
CDRA04095	9.5	10	81	131	CDRA04123	12.3	12	101	158
CDRA04096	9.6	10	87	137	CDRA04124	12.4	12	101	158
CDRA04097	9.7	10	87	137	CDRA04125	12.5	12	101	158
CDRA04098	9.8	10	87	137	CDRA04126	12.6	12	101	158
CDRA04099	9.9	10	87	137	CDRA04127	12.7	12	101	158
CDRA04100	10.0	10	87	137	CDRA04128	12.8	12	101	158
CDRA04101	10.1	12	87	144	CDRA04129	12.9	12	101	158
CDRA04102	10.2	12	87	144	CDRA04130	13.0	12	101	158
CDRA04103	10.3	12	87	144					

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



粉末高速钢 MULTI-1钻头, TiAlN涂层

PREMIUM HSS-PM MULTI-1 DRILLS, TiAlN COATED

CDRA03 SERIES

单位(Unit) : mm

被加工材料 WORK MATERIAL	碳钢 CARBON STEELS		合金钢 预硬钢 ALLOY STEELS PRE-HARDENED STEELS		铸铁 CAST IRON		铝合金 有色金属合金 ALUMINUM ALLOYS NONFERROUS ALLOYS		型模钢, 硬化钢 (HRc30~45) 不锈钢 (SUS304, 200) MOLD STEELS, HARDENED STEELS (HRc30~45) STAINLESS STEELS (SUS304, 200)		不锈钢 (SUS420, 440) STAINLESS STEELS (SUS420, 440)		
	N	S	N	S	N	S	N	S	N	S	N	S	
DIAMETER													
2.0	5800	0.06	4700	0.05	6500	0.08	10500	0.17	2600	0.04	3100	0.08	
3.0	4300	0.12	3500	0.09	4900	0.14	10500	0.27	1800	0.05	2100	0.09	
4.0	3200	0.15	2600	0.13	3600	0.18	8000	0.33	1300	0.07	1600	0.11	
5.0	2600	0.18	2100	0.16	2900	0.21	6500	0.39	1050	0.09	1250	0.17	
6.0	2100	0.20	1700	0.18	2400	0.25	5200	0.46	900	0.10	1050	0.19	
8.0	1600	0.24	1300	0.20	1800	0.29	4200	0.51	650	0.14	800	0.26	
10.0	1300	0.27	1000	0.24	1500	0.32	3400	0.61	550	0.17	630	0.33	
12.0	1100	0.29	850	0.26	1200	0.36	2700	0.73	450	0.20	530	0.39	

N = R.P.M

S = Feed per Revolution (mm/rev.)

粉末高速钢 MULTI-1钻头, TiAlN涂层

PREMIUM HSS-PM MULTI-1 DRILLS, TiAlN COATED

CDRA04 SERIES

单位(Unit) : mm

被加工材料 WORK MATERIAL	碳钢 CARBON STEELS		合金钢 预硬钢 ALLOY STEELS PRE-HARDENED STEELS		铸铁 CAST IRON		铝合金 有色金属合金 ALUMINUM ALLOYS NONFERROUS ALLOYS		型模钢, 硬化钢 (HRc30~45) 不锈钢 (SUS304, 200) MOLD STEELS, HARDENED STEELS (HRc30~45) STAINLESS STEELS (SUS304, 200)		不锈钢 (SUS420, 440) STAINLESS STEELS (SUS420, 440)	
	N	S	N	S	N	S	N	S	N	S	N	S
DIAMETER												
2.0	5800	0.05	4700	0.04	6500	0.07	10500	0.14	2600	0.03	3100	0.07
3.0	4300	0.10	3500	0.08	4900	0.12	10500	0.23	1800	0.04	2100	0.08
4.0	3200	0.13	2600	0.11	3600	0.15	8000	0.28	1300	0.06	1600	0.09
5.0	2600	0.15	2100	0.14	2900	0.18	6500	0.33	1050	0.08	1250	0.14
6.0	2100	0.17	1700	0.15	2400	0.21	5200	0.39	900	0.09	1050	0.16
8.0	1600	0.20	1300	0.17	1800	0.25	4200	0.43	650	0.12	800	0.22
10.0	1300	0.23	1000	0.20	1500	0.27	3400	0.52	550	0.14	630	0.28
12.0	1100	0.25	850	0.22	1200	0.31	2700	0.62	450	0.17	530	0.33

N = R.P.M

S = Feed per Revolution (mm/rev.)