

brisloy

Solid Carbide Drills

SOLID CARBIDE DRILLS - GENERAL
(with/without COOLANT HOLES)

SOLID CARBIDE DRILLS - INOX
(with COOLANT HOLES)

SOLID CARBIDE DRILLS - ALU
(with COOLANT HOLES)

SOLID CARBIDE DRILLS - CFRP

SOLID CARBIDE DRILLS - MQL(10D ~ 30D)
(with COOLANT HOLES)

SOLID CARBIDE DRILLS
for HIGH HARDENED STEELS(HRc50~70)





SOLID CARBIDE DRILLS GENERAL

with / without Coolant Holes (3XD, 5XD, 8XD)

- Application : Drilling into general steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.
- Advantage : Self centering - Center drilling is not required
 Excellent positioning - Bush is not necessary
 Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

CDG315, CDG515, CDG815 (with coolant holes)

CDG305, CDG307, CDG505 (without coolant holes)



SOLID CARBIDE DRILLS INOX

with Coolant Holes (3XD, 5XD, 8XD)

- The tool has the special flute shape and geometry for suitable machining of stainless steels.
- Excellent chip evacuation due to better surface treatment.
- Point R-thinning makes the superior centering and chip curl.
- Applied TiAlN coating, achieves the better surface finish of material to be cut and longer tool life.

CDS315, CDS515, CDS815



SOLID CARBIDE DRILLS ALU

with Coolant Holes (3XD, 5XD, 8XD)

- Good chip treatment due to flute geometry & chip space.
- Better finish & built-up edge preventive.

CDA315, CDA515, CDA815



SOLID CARBIDE DRILLS CFRP

- Special Point Type improve hole quality for Composite Material.
 -> Minimized Burr and Delamination at Entry / Exit Hole.
- Outstanding Performance.
- Long tool life and increased Productivity by Diamond coating.

CDC305



SOLID CARBIDE DRILLS MQL TYPE

with Coolant Holes (10XD, 15XD, 20XD, 25XD, 30XD)

- Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.
- Advantage : Non step drilling up to 10 times of drill diameter.
 Available for processing MQL (Minimum Quantity Lubrication).
 Excellent positioning - Bush is not necessary.
 Special design - Good chip removal
 Powerful drilling

CDM010, CDM015, CDM020

CDMS10, CDMS15, CDMS20, CDMS25, CDMS30



SOLID CARBIDE DRILLS

for HIGH HARDENED STEELS (HRc50~70)

- Application : Drilling for High Hardened Steels [Quenched Steels, Tempered Steels (Under HRc70)]
- Advantage : Special Design
 Minimum of cutting load through special thinning
 Good chip removal
 Powerful Drilling

CDH909

APPLICATION TABLE

●: Excellent
○: Good

Item	Length	Page	Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRC30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
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Solid Carbide Drills - General (with coolant holes)

CDG315	SHORT (3xD)	P03	○	●	●			○		○			
CDG515	LONG (5xD)	P05	○	●	●			○		○			
CDG815	EXTRA LONG (8xD)	P07	○	●	●			○		○			

Solid Carbide Drills - General (without coolant holes)

CDG305	STUB (3xD)	P09	○	●	●			○		○			
CDG307	SHORT (3xD)	P11	○	●	●			○		○			
CDG505	LONG (5xD)	P13	○	●	●			○		○			

Solid Carbide Drills - INOX (with coolant holes)

CDS315	SHORT (3xD)	P16	●	●	○				○	●	○	○	
CDS515	LONG (5xD)	P18	●	●	○				○	●	○	○	
CDS815	EXTRA LONG (8xD)	P20	●	●	○				○	●	○	○	

Solid Carbide Drills - ALU (with coolant holes)

CDA315	SHORT (3xD)	P23							●				
CDA515	LONG (5xD)	P25							●				
CDA815	EXTRA LONG (8xD)	P27							●				

Solid Carbide Drills - CFRP

CDC305		P30											●
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Solid Carbide Drills - MQL Type (with coolant holes)

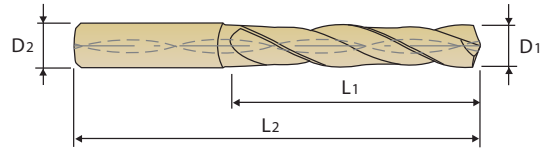
CDM010	EXTRA LONG (10xD)	P31	●	●	○			○				○	
CDMS10		P33											
CDM015	EXTRA LONG (15xD)	P32	●	●	○			○				○	
CDMS15		P33											
CDM020	EXTRA LONG (20xD)	P32	●	●	○			○				○	
CDMS20		P33											
CDMS25	EXTRA LONG (25xD)	P34	●	●	○			○				○	
CDMS30	EXTRA LONG (30xD)	P34	●	●	○			○				○	

Solid Carbide Drills for High Hardened Steels

CDH909		P36				●	●						
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CDG315 Series (Short)

3xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

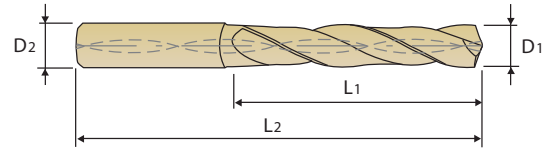
- Advantage :
- Self centering - Center drilling is not required
 - Excellent positioning - Bush is not necessary
 - Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG315030	3.0	6	20	62
CDG315031	3.1	6	20	62
CDG315032	3.2	6	20	62
CDG315033	3.3	6	20	62
CDG315034	3.4	6	20	62
CDG315035	3.5	6	20	62
CDG315036	3.6	6	20	62
CDG315037	3.7	6	20	62
CDG315038	3.8	6	24	66
CDG315039	3.9	6	24	66
CDG315040	4.0	6	24	66
CDG315041	4.1	6	24	66
CDG315042	4.2	6	24	66
CDG315043	4.3	6	24	66
CDG315044	4.4	6	24	66
CDG315045	4.5	6	24	66
CDG315046	4.6	6	24	66
CDG315047	4.7	6	24	66
CDG315048	4.8	6	28	66
CDG315049	4.9	6	28	66
CDG315050	5.0	6	28	66
CDG315051	5.1	6	28	66
CDG315052	5.2	6	28	66
CDG315053	5.3	6	28	66
CDG315054	5.4	6	28	66
CDG315055	5.5	6	28	66
CDG315056	5.6	6	28	66
CDG315057	5.7	6	28	66
CDG315058	5.8	6	28	66
CDG315059	5.9	6	28	66
CDG315060	6.0	6	28	66

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG315061	6.1	8	34	79
CDG315062	6.2	8	34	79
CDG315063	6.3	8	34	79
CDG315064	6.4	8	34	79
CDG315065	6.5	8	34	79
CDG315066	6.6	8	34	79
CDG315067	6.7	8	34	79
CDG315068	6.8	8	34	79
CDG315069	6.9	8	34	79
CDG315070	7.0	8	34	79
CDG315071	7.1	8	41	79
CDG315072	7.2	8	41	79
CDG315073	7.3	8	41	79
CDG315074	7.4	8	41	79
CDG315075	7.5	8	41	79
CDG315076	7.6	8	41	79
CDG315077	7.7	8	41	79
CDG315078	7.8	8	41	79
CDG315079	7.9	8	41	79
CDG315080	8.0	8	41	79
CDG315081	8.1	10	47	89
CDG315082	8.2	10	47	89
CDG315083	8.3	10	47	89
CDG315084	8.4	10	47	89
CDG315085	8.5	10	47	89
CDG315086	8.6	10	47	89
CDG315087	8.7	10	47	89
CDG315088	8.8	10	47	89
CDG315089	8.9	10	47	89
CDG315090	9.0	10	47	89
CDG315091	9.1	10	47	89

CDG315 Series (Short) 3xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

- Advantage :
- Self centering - Center drilling is not required
 - Excellent positioning - Bush is not necessary
 - Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG315092	9.2	10	47	89
CDG315093	9.3	10	47	89
CDG315094	9.4	10	47	89
CDG315095	9.5	10	47	89
CDG315096	9.6	10	47	89
CDG315097	9.7	10	47	89
CDG315098	9.8	10	47	89
CDG315099	9.9	10	47	89
CDG315100	10.0	10	47	89
CDG315101	10.1	12	55	102
CDG315102	10.2	12	55	102
CDG315103	10.3	12	55	102
CDG315104	10.4	12	55	102
CDG315105	10.5	12	55	102
CDG315106	10.6	12	55	102
CDG315107	10.7	12	55	102
CDG315108	10.8	12	55	102
CDG315109	10.9	12	55	102
CDG315110	11.0	12	55	102
CDG315111	11.1	12	55	102
CDG315112	11.2	12	55	102
CDG315113	11.3	12	55	102
CDG315114	11.4	12	55	102

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG315115	11.5	12	55	102
CDG315116	11.6	12	55	102
CDG315117	11.7	12	55	102
CDG315118	11.8	12	55	102
CDG315119	11.9	12	55	102
CDG315120	12.0	12	55	102
CDG315125	12.5	14	60	107
CDG315130	13.0	14	60	107
CDG315135	13.5	14	60	107
CDG315140	14.0	14	60	107
CDG315145	14.5	16	65	115
CDG315150	15.0	16	65	115
CDG315155	15.5	16	65	115
CDG315160	16.0	16	65	115
CDG315165	16.5	18	73	123
CDG315170	17.0	18	73	123
CDG315175	17.5	18	73	123
CDG315180	18.0	18	73	123
CDG315185	18.5	20	79	131
CDG315190	19.0	20	79	131
CDG315195	19.5	20	79	131
CDG315200	20.0	20	79	131

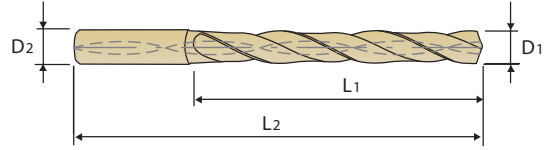
• Other shank types are available on your request.

● : Excellent
○ : Good

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
○	●	●			○		○			

CDG515 Series (Long)

5xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

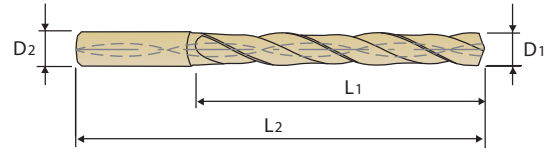
- Advantage :
- Self centering - Center drilling is not required
 - Excellent positioning - Bush is not necessary
 - Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG515010	1.0	3	8	55
CDG515011	1.1	3	12	55
CDG515012	1.2	3	12	55
CDG515013	1.3	3	12	55
CDG515014	1.4	3	12	55
CDG515015	1.5	3	16	55
CDG515016	1.6	3	16	55
CDG515017	1.7	3	16	55
CDG515018	1.8	3	16	55
CDG515019	1.9	3	16	55
CDG515020	2.0	4	21	57
CDG515021	2.1	4	21	57
CDG515022	2.2	4	21	57
CDG515023	2.3	4	21	57
CDG515024	2.4	4	21	57
CDG515025	2.5	4	21	57
CDG515026	2.6	4	21	57
CDG515027	2.7	4	21	57
CDG515028	2.8	4	21	57
CDG515029	2.9	4	21	57
CDG515030	3.0	6	28	66
CDG515031	3.1	6	28	66
CDG515032	3.2	6	28	66
CDG515033	3.3	6	28	66
CDG515034	3.4	6	28	66
CDG515035	3.5	6	28	66
CDG515036	3.6	6	28	66
CDG515037	3.7	6	28	66
CDG515038	3.8	6	36	74
CDG515039	3.9	6	36	74
CDG515040	4.0	6	36	74
CDG515041	4.1	6	36	74
CDG515042	4.2	6	36	74
CDG515043	4.3	6	36	74
CDG515044	4.4	6	36	74
CDG515045	4.5	6	36	74

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG515046	4.6	6	36	74
CDG515047	4.7	6	36	74
CDG515048	4.8	6	44	82
CDG515049	4.9	6	44	82
CDG515050	5.0	6	44	82
CDG515051	5.1	6	44	82
CDG515052	5.2	6	44	82
CDG515053	5.3	6	44	82
CDG515054	5.4	6	44	82
CDG515055	5.5	6	44	82
CDG515056	5.6	6	44	82
CDG515057	5.7	6	44	82
CDG515058	5.8	6	44	82
CDG515059	5.9	6	44	82
CDG515060	6.0	6	44	82
CDG515061	6.1	8	53	91
CDG515062	6.2	8	53	91
CDG515063	6.3	8	53	91
CDG515064	6.4	8	53	91
CDG515065	6.5	8	53	91
CDG515066	6.6	8	53	91
CDG515067	6.7	8	53	91
CDG515068	6.8	8	53	91
CDG515069	6.9	8	53	91
CDG515070	7.0	8	53	91
CDG515071	7.1	8	53	91
CDG515072	7.2	8	53	91
CDG515073	7.3	8	53	91
CDG515074	7.4	8	53	91
CDG515075	7.5	8	53	91
CDG515076	7.6	8	53	91
CDG515077	7.7	8	53	91
CDG515078	7.8	8	53	91
CDG515079	7.9	8	53	91
CDG515080	8.0	8	53	91
CDG515081	8.1	10	61	103

CDG515 Series (Long)
5xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

- Advantage :
- Self centering - Center drilling is not required
 - Excellent positioning - Bush is not necessary
 - Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG515082	8.2	10	61	103
CDG515083	8.3	10	61	103
CDG515084	8.4	10	61	103
CDG515085	8.5	10	61	103
CDG515086	8.6	10	61	103
CDG515087	8.7	10	61	103
CDG515088	8.8	10	61	103
CDG515089	8.9	10	61	103
CDG515090	9.0	10	61	103
CDG515091	9.1	10	61	103
CDG515092	9.2	10	61	103
CDG515093	9.3	10	61	103
CDG515094	9.4	10	61	103
CDG515095	9.5	10	61	103
CDG515096	9.6	10	61	103
CDG515097	9.7	10	61	103
CDG515098	9.8	10	61	103
CDG515099	9.9	10	61	103
CDG515100	10.0	10	61	103
CDG515101	10.1	12	71	118
CDG515102	10.2	12	71	118
CDG515103	10.3	12	71	118
CDG515104	10.4	12	71	118
CDG515105	10.5	12	71	118
CDG515106	10.6	12	71	118
CDG515107	10.7	12	71	118
CDG515108	10.8	12	71	118
CDG515109	10.9	12	71	118

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG515110	11.0	12	71	118
CDG515111	11.1	12	71	118
CDG515112	11.2	12	71	118
CDG515113	11.3	12	71	118
CDG515114	11.4	12	71	118
CDG515115	11.5	12	71	118
CDG515116	11.6	12	71	118
CDG515117	11.7	12	71	118
CDG515118	11.8	12	71	118
CDG515119	11.9	12	71	118
CDG515120	12.0	12	71	118
CDG515125	12.5	14	77	124
CDG515130	13.0	14	77	124
CDG515135	13.5	14	77	124
CDG515140	14.0	14	77	124
CDG515145	14.5	16	83	133
CDG515150	15.0	16	83	133
CDG515155	15.5	16	83	133
CDG515160	16.0	16	83	133
CDG515165	16.5	18	93	143
CDG515170	17.0	18	93	143
CDG515175	17.5	18	93	143
CDG515180	18.0	18	93	143
CDG515185	18.5	20	101	153
CDG515190	19.0	20	101	153
CDG515195	19.5	20	101	153
CDG515200	20.0	20	101	153

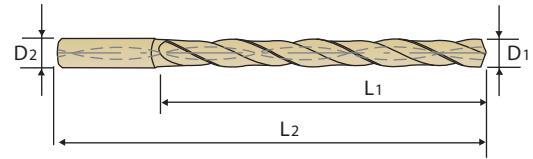
● Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
○	●	●			○		○			

● : Excellent
○ : Good

CDG815 Series (Extra Long)

8xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

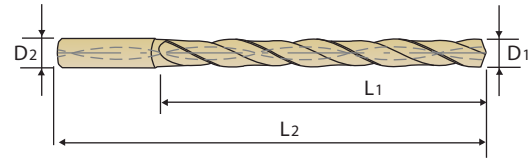
- Advantage :
- Self centering
 - Excellent positioning
 - Special design
 - Center drilling is not required
 - Bush is not necessary
 - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG815030	3.0	6	34	72
CDG815031	3.1	6	34	72
CDG815032	3.2	6	34	72
CDG815033	3.3	6	34	72
CDG815034	3.4	6	34	72
CDG815035	3.5	6	34	72
CDG815036	3.6	6	34	72
CDG815037	3.7	6	34	72
CDG815038	3.8	6	43	81
CDG815039	3.9	6	43	81
CDG815040	4.0	6	43	81
CDG815041	4.1	6	43	81
CDG815042	4.2	6	43	81
CDG815043	4.3	6	43	81
CDG815044	4.4	6	43	81
CDG815045	4.5	6	43	81
CDG815046	4.6	6	43	81
CDG815047	4.7	6	43	81
CDG815048	4.8	6	57	95
CDG815049	4.9	6	57	95
CDG815050	5.0	6	57	95
CDG815051	5.1	6	57	95
CDG815052	5.2	6	57	95
CDG815053	5.3	6	57	95
CDG815054	5.4	6	57	95
CDG815055	5.5	6	57	95
CDG815056	5.6	6	57	95

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG815057	5.7	6	57	95
CDG815058	5.8	6	57	95
CDG815059	5.9	6	57	95
CDG815060	6.0	6	57	95
CDG815061	6.1	8	76	114
CDG815062	6.2	8	76	114
CDG815063	6.3	8	76	114
CDG815064	6.4	8	76	114
CDG815065	6.5	8	76	114
CDG815066	6.6	8	76	114
CDG815067	6.7	8	76	114
CDG815068	6.8	8	76	114
CDG815069	6.9	8	76	114
CDG815070	7.0	8	76	114
CDG815071	7.1	8	76	114
CDG815072	7.2	8	76	114
CDG815073	7.3	8	76	114
CDG815074	7.4	8	76	114
CDG815075	7.5	8	76	114
CDG815076	7.6	8	76	114
CDG815077	7.7	8	76	114
CDG815078	7.8	8	76	114
CDG815079	7.9	8	76	114
CDG815080	8.0	8	76	114
CDG815081	8.1	10	95	142
CDG815082	8.2	10	95	142
CDG815083	8.3	10	95	142

CDG815 Series (Extra Long) 8xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

- Advantage : Self centering
Excellent positioning
Special design
- Center drilling is not required
 - Bush is not necessary
 - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG815084	8.4	10	95	142
CDG815085	8.5	10	95	142
CDG815086	8.6	10	95	142
CDG815087	8.7	10	95	142
CDG815088	8.8	10	95	142
CDG815089	8.9	10	95	142
CDG815090	9.0	10	95	142
CDG815091	9.1	10	95	142
CDG815092	9.2	10	95	142
CDG815093	9.3	10	95	142
CDG815094	9.4	10	95	142
CDG815095	9.5	10	95	142
CDG815096	9.6	10	95	142
CDG815097	9.7	10	95	142
CDG815098	9.8	10	95	142
CDG815099	9.9	10	95	142
CDG815100	10.0	10	95	142
CDG815101	10.1	12	114	162
CDG815102	10.2	12	114	162
CDG815103	10.3	12	114	162
CDG815104	10.4	12	114	162

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG815105	10.5	12	114	162
CDG815106	10.6	12	114	162
CDG815107	10.7	12	114	162
CDG815108	10.8	12	114	162
CDG815109	10.9	12	114	162
CDG815110	11.0	12	114	162
CDG815111	11.1	12	114	162
CDG815112	11.2	12	114	162
CDG815113	11.3	12	114	162
CDG815114	11.4	12	114	162
CDG815115	11.5	12	114	162
CDG815116	11.6	12	114	162
CDG815117	11.7	12	114	162
CDG815118	11.8	12	114	162
CDG815119	11.9	12	114	162
CDG815120	12.0	12	114	162
CDG815125	12.5	14	133	178
CDG815130	13.0	14	133	178
CDG815135	13.5	14	133	178
CDG815140	14.0	14	133	178

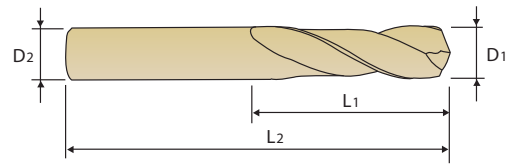
● Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
○	●	●			○		○			

● : Excellent
○ : Good

CDG305 Series (STUB)

3xD



D1=D2

Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

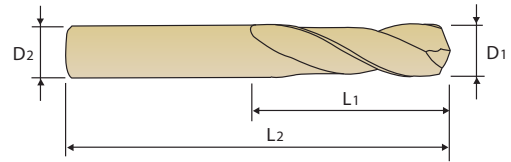
- Advantage : Self centering
 Excellent positioning
 Special design
- Center drilling is not required
 - Bush is not necessary
 - Reaming is not required
 - Good chip removal
 - Powerful drilling

Unit:mm

Part Number TiAlN	Drill Diameter D1	Flute Length L1	Overall Length L2
CDG305030	3.0	16	46
CDG305031	3.1	18	49
CDG305032	3.2	18	49
CDG305033	3.3	18	49
CDG305034	3.4	20	52
CDG305035	3.5	20	52
CDG305036	3.6	20	52
CDG305037	3.7	20	52
CDG305038	3.8	22	55
CDG305039	3.9	22	55
CDG305040	4.0	22	55
CDG305041	4.1	22	55
CDG305042	4.2	22	55
CDG305043	4.3	24	58
CDG305044	4.4	24	58
CDG305045	4.5	24	58
CDG305046	4.6	24	58
CDG305047	4.7	24	58
CDG305048	4.8	26	62
CDG305049	4.9	26	62
CDG305050	5.0	26	62
CDG305051	5.1	26	62
CDG305052	5.2	26	62
CDG305053	5.3	26	62
CDG305054	5.4	28	66
CDG305055	5.5	28	66
CDG305056	5.6	28	66

Part Number TiAlN	Drill Diameter D1	Flute Length L1	Overall Length L2
CDG305057	5.7	28	66
CDG305058	5.8	28	66
CDG305059	5.9	28	66
CDG305060	6.0	28	66
CDG305061	6.1	31	70
CDG305062	6.2	31	70
CDG305063	6.3	31	70
CDG305064	6.4	31	70
CDG305065	6.5	31	70
CDG305066	6.6	31	70
CDG305067	6.7	31	70
CDG305068	6.8	34	74
CDG305069	6.9	34	74
CDG305070	7.0	34	74
CDG305071	7.1	34	74
CDG305072	7.2	34	74
CDG305073	7.3	34	74
CDG305074	7.4	34	74
CDG305075	7.5	34	74
CDG305076	7.6	37	79
CDG305077	7.7	37	79
CDG305078	7.8	37	79
CDG305079	7.9	37	79
CDG305080	8.0	37	79
CDG305081	8.1	37	79
CDG305082	8.2	37	79
CDG305083	8.3	37	79

CDG305 Series (STUB) 3xD



D1=D2

Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

- Advantage : Self centering
Excellent positioning
Special design
- Center drilling is not required
 - Bush is not necessary
 - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Flute Length L1	Overall Length L2
CDG305084	8.4	37	79
CDG305085	8.5	37	79
CDG305086	8.6	40	84
CDG305087	8.7	40	84
CDG305088	8.8	40	84
CDG305089	8.9	40	84
CDG305090	9.0	40	84
CDG305091	9.1	40	84
CDG305092	9.2	40	84
CDG305093	9.3	40	84
CDG305094	9.4	40	84
CDG305095	9.5	40	84
CDG305096	9.6	43	89
CDG305097	9.7	43	89
CDG305098	9.8	43	89
CDG305099	9.9	43	89
CDG305100	10.0	43	89
CDG305102	10.2	43	89
CDG305105	10.5	43	89

Unit:mm

Part Number TiAlN	Drill Diameter D1	Flute Length L1	Overall Length L2
CDG305110	11.0	47	95
CDG305115	11.5	47	95
CDG305120	12.0	51	102
CDG305130	13.0	51	102
CDG305135	13.5	54	107
CDG305140	14.0	54	107
CDG305145	14.5	56	111
CDG305150	15.0	56	111
CDG305155	15.5	58	115
CDG305160	16.0	58	115
CDG305165	16.5	60	119
CDG305170	17.0	60	119
CDG305175	17.5	62	123
CDG305180	18.0	62	123
CDG305185	18.5	64	127
CDG305190	19.0	64	127
CDG305195	19.5	66	131
CDG305200	20.0	66	131

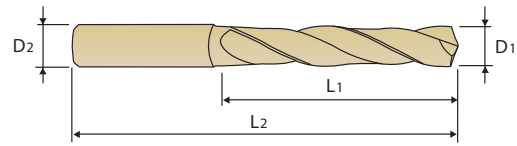
• Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRC30~45	Hardened Steels HRC45~55 HRC55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
○	●	●			○		○			

● : Excellent
○ : Good

CDG307 Series (Short)

3xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

- Advantage :
- Self centering
 - Excellent positioning
 - Special design
 - Center drilling is not required
 - Bush is not necessary
 - Reaming is not required
 - Good chip removal
 - Powerful drilling

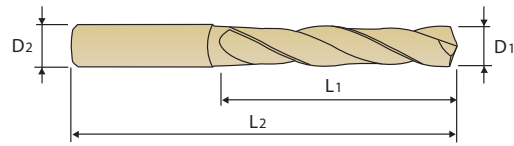
Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG307030	3.0	6	20	62
CDG307031	3.1	6	20	62
CDG307032	3.2	6	20	62
CDG307033	3.3	6	20	62
CDG307034	3.4	6	20	62
CDG307035	3.5	6	20	62
CDG307036	3.6	6	20	62
CDG307037	3.7	6	20	62
CDG307038	3.8	6	24	66
CDG307039	3.9	6	24	66
CDG307040	4.0	6	24	66
CDG307041	4.1	6	24	66
CDG307042	4.2	6	24	66
CDG307043	4.3	6	24	66
CDG307044	4.4	6	24	66
CDG307045	4.5	6	24	66
CDG307046	4.6	6	24	66
CDG307047	4.7	6	24	66
CDG307048	4.8	6	28	66
CDG307049	4.9	6	28	66
CDG307050	5.0	6	28	66
CDG307051	5.1	6	28	66
CDG307052	5.2	6	28	66
CDG307053	5.3	6	28	66
CDG307054	5.4	6	28	66
CDG307055	5.5	6	28	66
CDG307056	5.6	6	28	66
CDG307057	5.7	6	28	66
CDG307058	5.8	6	28	66
CDG307059	5.9	6	28	66
CDG307060	6.0	6	28	66

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG307061	6.1	8	34	79
CDG307062	6.2	8	34	79
CDG307063	6.3	8	34	79
CDG307064	6.4	8	34	79
CDG307065	6.5	8	34	79
CDG307066	6.6	8	34	79
CDG307067	6.7	8	34	79
CDG307068	6.8	8	34	79
CDG307069	6.9	8	34	79
CDG307070	7.0	8	34	79
CDG307071	7.1	8	41	79
CDG307072	7.2	8	41	79
CDG307073	7.3	8	41	79
CDG307074	7.4	8	41	79
CDG307075	7.5	8	41	79
CDG307076	7.6	8	41	79
CDG307077	7.7	8	41	79
CDG307078	7.8	8	41	79
CDG307079	7.9	8	41	79
CDG307080	8.0	8	41	79
CDG307081	8.1	10	47	89
CDG307082	8.2	10	47	89
CDG307083	8.3	10	47	89
CDG307084	8.4	10	47	89
CDG307085	8.5	10	47	89
CDG307086	8.6	10	47	89
CDG307087	8.7	10	47	89
CDG307088	8.8	10	47	89
CDG307089	8.9	10	47	89
CDG307090	9.0	10	47	89
CDG307091	9.1	10	47	89

CDG307 Series (Short)

3xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

- Advantage :
- Self centering - Center drilling is not required
 - Excellent positioning - Bush is not necessary
 - Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG307092	9.2	10	47	89
CDG307093	9.3	10	47	89
CDG307094	9.4	10	47	89
CDG307095	9.5	10	47	89
CDG307096	9.6	10	47	89
CDG307097	9.7	10	47	89
CDG307098	9.8	10	47	89
CDG307099	9.9	10	47	89
CDG307100	10.0	10	47	89
CDG307101	10.1	12	55	102
CDG307102	10.2	12	55	102
CDG307103	10.3	12	55	102
CDG307104	10.4	12	55	102
CDG307105	10.5	12	55	102
CDG307106	10.6	12	55	102
CDG307107	10.7	12	55	102
CDG307108	10.8	12	55	102
CDG307109	10.9	12	55	102
CDG307110	11.0	12	55	102
CDG307111	11.1	12	55	102
CDG307112	11.2	12	55	102
CDG307113	11.3	12	55	102
CDG307114	11.4	12	55	102
CDG307115	11.5	12	55	102
CDG307116	11.6	12	55	102
CDG307117	11.7	12	55	102
CDG307118	11.8	12	55	102

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG307119	11.9	12	55	102
CDG307120	12.0	12	55	102
CDG307123	12.3	14	60	107
CDG307125	12.5	14	60	107
CDG307128	12.8	14	60	107
CDG307130	13.0	14	60	107
CDG307135	13.5	14	60	107
CDG307138	13.8	14	60	107
CDG307140	14.0	14	60	107
CDG307145	14.5	16	65	115
CDG307148	14.8	16	65	115
CDG307150	15.0	16	65	115
CDG307155	15.5	16	65	115
CDG307158	15.8	16	65	115
CDG307160	16.0	16	65	115
CDG307165	16.5	18	73	123
CDG307168	16.8	18	73	123
CDG307170	17.0	18	73	123
CDG307175	17.5	18	73	123
CDG307178	17.8	18	73	123
CDG307180	18.0	18	73	123
CDG307185	18.5	20	79	131
CDG307190	19.0	20	79	131
CDG307195	19.5	20	79	131
CDG307198	19.8	20	79	131
CDG307200	20.0	20	79	131

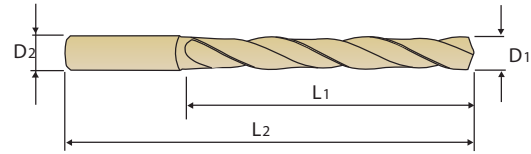
● Other shank types are available on your request.

● : Excellent
○ : Good

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
○	●	●			○		○			

CDG505 Series (Long)

5xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

- Advantage :
- Self centering
 - Excellent positioning
 - Special design
 - Center drilling is not required
 - Bush is not necessary
 - Reaming is not required
 - Good chip removal
 - Powerful drilling

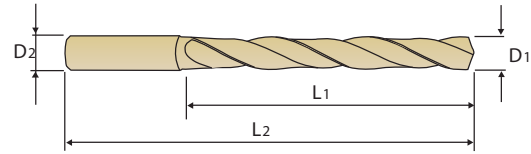
Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG505010	1.0	3	8	55
CDG505011	1.1	3	12	55
CDG505012	1.2	3	12	55
CDG505013	1.3	3	12	55
CDG505014	1.4	3	12	55
CDG505015	1.5	3	16	55
CDG505016	1.6	3	16	55
CDG505017	1.7	3	16	55
CDG505018	1.8	3	16	55
CDG505019	1.9	3	16	55
CDG505020	2.0	4	21	57
CDG505021	2.1	4	21	57
CDG505022	2.2	4	21	57
CDG505023	2.3	4	21	57
CDG505024	2.4	4	21	57
CDG505025	2.5	4	21	57
CDG505026	2.6	4	21	57
CDG505027	2.7	4	21	57
CDG505028	2.8	4	21	57
CDG505029	2.9	4	21	57
CDG505030	3.0	6	28	66
CDG505031	3.1	6	28	66
CDG505032	3.2	6	28	66
CDG505033	3.3	6	28	66
CDG505034	3.4	6	28	66
CDG505035	3.5	6	28	66
CDG505036	3.6	6	28	66
CDG505037	3.7	6	28	66
CDG505038	3.8	6	36	74
CDG505039	3.9	6	36	74
CDG505040	4.0	6	36	74
CDG505041	4.1	6	36	74
CDG505042	4.2	6	36	74
CDG505043	4.3	6	36	74
CDG505044	4.4	6	36	74
CDG505045	4.5	6	36	74

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG505046	4.6	6	36	74
CDG505047	4.7	6	36	74
CDG505048	4.8	6	44	82
CDG505049	4.9	6	44	82
CDG505050	5.0	6	44	82
CDG505051	5.1	6	44	82
CDG505052	5.2	6	44	82
CDG505053	5.3	6	44	82
CDG505054	5.4	6	44	82
CDG505055	5.5	6	44	82
CDG505056	5.6	6	44	82
CDG505057	5.7	6	44	82
CDG505058	5.8	6	44	82
CDG505059	5.9	6	44	82
CDG505060	6.0	6	44	82
CDG505061	6.1	8	53	91
CDG505062	6.2	8	53	91
CDG505063	6.3	8	53	91
CDG505064	6.4	8	53	91
CDG505065	6.5	8	53	91
CDG505066	6.6	8	53	91
CDG505067	6.7	8	53	91
CDG505068	6.8	8	53	91
CDG505069	6.9	8	53	91
CDG505070	7.0	8	53	91
CDG505071	7.1	8	53	91
CDG505072	7.2	8	53	91
CDG505073	7.3	8	53	91
CDG505074	7.4	8	53	91
CDG505075	7.5	8	53	91
CDG505076	7.6	8	53	91
CDG505077	7.7	8	53	91
CDG505078	7.8	8	53	91
CDG505079	7.9	8	53	91
CDG505080	8.0	8	53	91
CDG505081	8.1	10	61	103

CDG505 Series (Long)

5xD



Application : Drilling into general steels, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

- Advantage :
- Self centering - Center drilling is not required
 - Excellent positioning - Bush is not necessary
 - Special design - Reaming is not required
 - Good chip removal
 - Powerful drilling

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG505082	8.2	10	61	103
CDG505083	8.3	10	61	103
CDG505084	8.4	10	61	103
CDG505085	8.5	10	61	103
CDG505086	8.6	10	61	103
CDG505087	8.7	10	61	103
CDG505088	8.8	10	61	103
CDG505089	8.9	10	61	103
CDG505090	9.0	10	61	103
CDG505091	9.1	10	61	103
CDG505092	9.2	10	61	103
CDG505093	9.3	10	61	103
CDG505094	9.4	10	61	103
CDG505095	9.5	10	61	103
CDG505096	9.6	10	61	103
CDG505097	9.7	10	61	103
CDG505098	9.8	10	61	103
CDG505099	9.9	10	61	103
CDG505100	10.0	10	61	103
CDG505101	10.1	12	71	118
CDG505102	10.2	12	71	118
CDG505103	10.3	12	71	118
CDG505104	10.4	12	71	118
CDG505105	10.5	12	71	118
CDG505106	10.6	12	71	118
CDG505107	10.7	12	71	118
CDG505108	10.8	12	71	118
CDG505109	10.9	12	71	118

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDG505110	11.0	12	71	118
CDG505111	11.1	12	71	118
CDG505112	11.2	12	71	118
CDG505113	11.3	12	71	118
CDG505114	11.4	12	71	118
CDG505115	11.5	12	71	118
CDG505116	11.6	12	71	118
CDG505117	11.7	12	71	118
CDG505118	11.8	12	71	118
CDG505119	11.9	12	71	118
CDG505120	12.0	12	71	118
CDG505125	12.5	14	77	124
CDG505130	13.0	14	77	124
CDG505135	13.5	14	77	124
CDG505140	14.0	14	77	124
CDG505145	14.5	16	83	133
CDG505150	15.0	16	83	133
CDG505155	15.5	16	83	133
CDG505160	16.0	16	83	133
CDG505165	16.5	18	93	143
CDG505170	17.0	18	93	143
CDG505175	17.5	18	93	143
CDG505180	18.0	18	93	143
CDG505185	18.5	20	101	153
CDG505190	19.0	20	101	153
CDG505195	19.5	20	101	153
CDG505200	20.0	20	101	153

● Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
○	●	●			○		○			

● : Excellent
○ : Good

CDG315, CDG515, CDG815 Series

Unit:mm

Work Material	Non-Alloy Steels		Alloy Steels		Soft Grey Cast Iron		Hard Grey Cast Iron	
Strength	< 700 N/mm ²		< 1000 N/mm ²		< HB240, GG25		< HB300, GG40	
Drilling Speed	ø1.0~ø2.9 : 50~100 m/min ø3.0~ : 130~150 m/min		ø1.0~ø2.9 : 40~90 m/min ø3.0~ : 115~135 m/min		ø1.0~ø2.9 : 80~160 m/min ø3.0~ : 230~250 m/min		ø1.0~ø2.9 : 50~100 m/min ø3.0~ : 140~160 m/min	
Diameter	N	S	N	S	N	S	N	S
1.0	16250	0.05	14800	0.05	26600	0.05	17300	0.05
2.0	16250	0.07	14800	0.07	26600	0.07	17300	0.07
3.0	16000	0.16	14500	0.16	26000	0.16	17000	0.16
4.0	12000	0.17	11000	0.17	20000	0.17	13000	0.17
5.0	9550	0.18	8600	0.18	16000	0.18	10000	0.18
6.0	8000	0.20	7200	0.20	13000	0.20	8500	0.20
7.0	6800	0.22	6100	0.22	11500	0.22	7300	0.22
8.0	6000	0.24	5400	0.24	9900	0.24	6400	0.24
9.0	5300	0.27	4800	0.27	8800	0.27	5700	0.27
10.0	4800	0.30	4300	0.30	8000	0.30	5100	0.30
12.0	4000	0.33	3600	0.33	6600	0.33	4250	0.33
14.0	3400	0.36	3050	0.36	5700	0.36	3650	0.36
16.0	3000	0.39	2700	0.39	5000	0.39	3200	0.39
18.0	2650	0.42	2400	0.42	4400	0.42	2850	0.42
20.0	2400	0.45	2150	0.45	4000	0.45	2550	0.45

- Recommend to reduce the feed rate as following:
 CDG315(3xD) : Feed 100%
 CDG515(5xD) : Feed 85%
 CDG815(8xD) : Feed 70%

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

Solid Carbide Drills without Coolant Holes, TiAlN Coated

CDG305, CDG307, CDG505 Series

Unit:mm

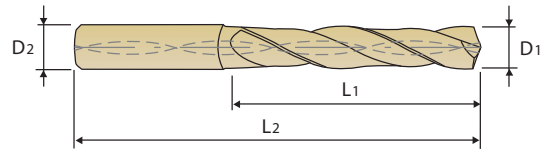
Work Material	Non-Alloy Steels		Alloy Steels		Soft Grey Cast Iron		Hard Grey Cast Iron	
Strength	< 700 N/mm ²		< 1000 N/mm ²		< HB240, GG25		< HB300, GG40	
Drilling Speed	ø1.0~ø2.9 : 50~100 m/min ø3.0~ : 130~150 m/min		ø1.0~ø2.9 : 40~90 m/min ø3.0~ : 115~135 m/min		ø1.0~ø2.9 : 80~160 m/min ø3.0~ : 230~250 m/min		ø1.0~ø2.9 : 50~100 m/min ø3.0~ : 140~160 m/min	
Diameter	N	S	N	S	N	S	N	S
1.0	13000	0.04	11250	0.04	21300	0.04	14200	0.04
2.0	13000	0.06	11250	0.06	21300	0.06	14200	0.06
3.0	13000	0.13	11000	0.13	21000	0.13	14000	0.13
4.0	9500	0.14	8400	0.14	16000	0.14	10500	0.14
5.0	7600	0.15	6700	0.15	13000	0.15	8300	0.15
6.0	6400	0.17	5600	0.17	11000	0.17	6900	0.17
7.0	5500	0.19	4800	0.19	9100	0.19	5900	0.19
8.0	4800	0.21	4200	0.21	8000	0.21	5200	0.21
9.0	4200	0.23	3700	0.23	7100	0.23	4600	0.23
10.0	3800	0.25	3350	0.25	6400	0.25	4150	0.25
12.0	3200	0.27	2800	0.27	5300	0.27	3450	0.27
14.0	2750	0.29	2400	0.29	4550	0.29	3000	0.29
16.0	2400	0.31	2100	0.31	4000	0.31	2600	0.31
18.0	2100	0.33	1850	0.33	3550	0.33	2300	0.33
20.0	1900	0.35	1650	0.35	3200	0.35	2100	0.35

- Recommend to reduce the feed rate as following:
 CDG305(3xD) : Feed 100%
 CDG307(3xD) : Feed 100%
 CDG505(5xD) : Feed 85%

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

CDS315 Series (Short)

3xD



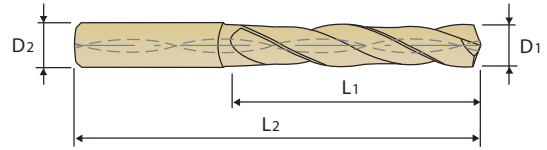
- The tool has the special flute shape and geometry for suitable machining of stainless steels.
- Excellent chip evacuation due to better surface treatment.
- Point R-thinning makes the superior centering and chip curl.
- Applied TiAlN coating, achieves the better surface finish of material to be cut and longer tool life.

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS315030	3.0	6	20	62
CDS315031	3.1	6	20	62
CDS315032	3.2	6	20	62
CDS315033	3.3	6	20	62
CDS315034	3.4	6	20	62
CDS315035	3.5	6	20	62
CDS315036	3.6	6	20	62
CDS315037	3.7	6	20	62
CDS315038	3.8	6	24	66
CDS315039	3.9	6	24	66
CDS315040	4.0	6	24	66
CDS315041	4.1	6	24	66
CDS315042	4.2	6	24	66
CDS315043	4.3	6	24	66
CDS315044	4.4	6	24	66
CDS315045	4.5	6	24	66
CDS315046	4.6	6	24	66
CDS315047	4.7	6	24	66
CDS315048	4.8	6	28	66
CDS315049	4.9	6	28	66
CDS315050	5.0	6	28	66
CDS315051	5.1	6	28	66
CDS315052	5.2	6	28	66
CDS315053	5.3	6	28	66
CDS315054	5.4	6	28	66
CDS315055	5.5	6	28	66
CDS315056	5.6	6	28	66
CDS315057	5.7	6	28	66
CDS315058	5.8	6	28	66
CDS315059	5.9	6	28	66
CDS315060	6.0	6	28	66

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS315061	6.1	8	34	79
CDS315062	6.2	8	34	79
CDS315063	6.3	8	34	79
CDS315064	6.4	8	34	79
CDS315065	6.5	8	34	79
CDS315066	6.6	8	34	79
CDS315067	6.7	8	34	79
CDS315068	6.8	8	34	79
CDS315069	6.9	8	34	79
CDS315070	7.0	8	34	79
CDS315071	7.1	8	41	79
CDS315072	7.2	8	41	79
CDS315073	7.3	8	41	79
CDS315074	7.4	8	41	79
CDS315075	7.5	8	41	79
CDS315076	7.6	8	41	79
CDS315077	7.7	8	41	79
CDS315078	7.8	8	41	79
CDS315079	7.9	8	41	79
CDS315080	8.0	8	41	79
CDS315081	8.1	10	47	89
CDS315082	8.2	10	47	89
CDS315083	8.3	10	47	89
CDS315084	8.4	10	47	89
CDS315085	8.5	10	47	89
CDS315086	8.6	10	47	89
CDS315087	8.7	10	47	89
CDS315088	8.8	10	47	89
CDS315089	8.9	10	47	89
CDS315090	9.0	10	47	89
CDS315091	9.1	10	47	89

CDS315 Series (Short)
3xD



- The tool has the special flute shape and geometry for suitable machining of stainless steels.
- Excellent chip evacuation due to better surface treatment.
- Point R-thinning makes the superior centering and chip curl.
- Applied TiAlN coating, achieves the better surface finish of material to be cut and longer tool life.

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS315092	9.2	10	47	89
CDS315093	9.3	10	47	89
CDS315094	9.4	10	47	89
CDS315095	9.5	10	47	89
CDS315096	9.6	10	47	89
CDS315097	9.7	10	47	89
CDS315098	9.8	10	47	89
CDS315099	9.9	10	47	89
CDS315100	10.0	10	47	89
CDS315101	10.1	12	55	102
CDS315102	10.2	12	55	102
CDS315103	10.3	12	55	102
CDS315104	10.4	12	55	102
CDS315105	10.5	12	55	102
CDS315106	10.6	12	55	102
CDS315107	10.7	12	55	102
CDS315108	10.8	12	55	102
CDS315109	10.9	12	55	102
CDS315110	11.0	12	55	102
CDS315111	11.1	12	55	102
CDS315112	11.2	12	55	102
CDS315113	11.3	12	55	102
CDS315114	11.4	12	55	102

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS315115	11.5	12	55	102
CDS315116	11.6	12	55	102
CDS315117	11.7	12	55	102
CDS315118	11.8	12	55	102
CDS315119	11.9	12	55	102
CDS315120	12.0	12	55	102
CDS315125	12.5	14	60	107
CDS315130	13.0	14	60	107
CDS315135	13.5	14	60	107
CDS315140	14.0	14	60	107
CDS315145	14.5	16	65	115
CDS315150	15.0	16	65	115
CDS315155	15.5	16	65	115
CDS315160	16.0	16	65	115
CDS315165	16.5	18	73	123
CDS315170	17.0	18	73	123
CDS315175	17.5	18	73	123
CDS315180	18.0	18	73	123
CDS315185	18.5	20	79	131
CDS315190	19.0	20	79	131
CDS315195	19.5	20	79	131
CDS315200	20.0	20	79	131

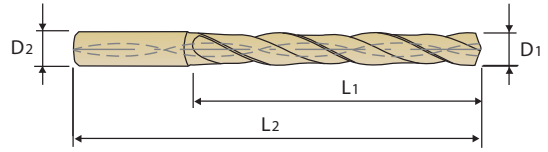
- Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
●	●	○				○	●	○	○	

●: Excellent
○: Good

CDS515 Series (Long)

5xD



- The tool has the special flute shape and geometry for suitable machining of stainless steels.
- Excellent chip evacuation due to better surface treatment.
- Point R-thinning makes the superior centering and chip curl.
- Applied TiAlN coating, achieves the better surface finish of material to be cut and longer tool life.

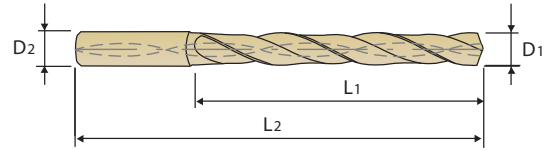
Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS515010	1.0	3	8	55
CDS515011	1.1	3	12	55
CDS515012	1.2	3	12	55
CDS515013	1.3	3	12	55
CDS515014	1.4	3	12	55
CDS515015	1.5	3	16	55
CDS515016	1.6	3	16	55
CDS515017	1.7	3	16	55
CDS515018	1.8	3	16	55
CDS515019	1.9	3	16	55
CDS515020	2.0	4	21	57
CDS515021	2.1	4	21	57
CDS515022	2.2	4	21	57
CDS515023	2.3	4	21	57
CDS515024	2.4	4	21	57
CDS515025	2.5	4	21	57
CDS515026	2.6	4	21	57
CDS515027	2.7	4	21	57
CDS515028	2.8	4	21	57
CDS515029	2.9	4	21	57
CDS515030	3.0	6	28	66
CDS515031	3.1	6	28	66
CDS515032	3.2	6	28	66
CDS515033	3.3	6	28	66
CDS515034	3.4	6	28	66
CDS515035	3.5	6	28	66
CDS515036	3.6	6	28	66
CDS515037	3.7	6	28	66
CDS515038	3.8	6	36	74
CDS515039	3.9	6	36	74
CDS515040	4.0	6	36	74
CDS515041	4.1	6	36	74
CDS515042	4.2	6	36	74
CDS515043	4.3	6	36	74
CDS515044	4.4	6	36	74
CDS515045	4.5	6	36	74

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS515046	4.6	6	36	74
CDS515047	4.7	6	36	74
CDS515048	4.8	6	44	82
CDS515049	4.9	6	44	82
CDS515050	5.0	6	44	82
CDS515051	5.1	6	44	82
CDS515052	5.2	6	44	82
CDS515053	5.3	6	44	82
CDS515054	5.4	6	44	82
CDS515055	5.5	6	44	82
CDS515056	5.6	6	44	82
CDS515057	5.7	6	44	82
CDS515058	5.8	6	44	82
CDS515059	5.9	6	44	82
CDS515060	6.0	6	44	82
CDS515061	6.1	8	53	91
CDS515062	6.2	8	53	91
CDS515063	6.3	8	53	91
CDS515064	6.4	8	53	91
CDS515065	6.5	8	53	91
CDS515066	6.6	8	53	91
CDS515067	6.7	8	53	91
CDS515068	6.8	8	53	91
CDS515069	6.9	8	53	91
CDS515070	7.0	8	53	91
CDS515071	7.1	8	53	91
CDS515072	7.2	8	53	91
CDS515073	7.3	8	53	91
CDS515074	7.4	8	53	91
CDS515075	7.5	8	53	91
CDS515076	7.6	8	53	91
CDS515077	7.7	8	53	91
CDS515078	7.8	8	53	91
CDS515079	7.9	8	53	91
CDS515080	8.0	8	53	91
CDS515081	8.1	10	61	103

CDS515 Series (Long)

5xD



- The tool has the special flute shape and geometry for suitable machining of stainless steels.
- Excellent chip evacuation due to better surface treatment.
- Point R-thinning makes the superior centering and chip curl.
- Applied TiAlN coating, achieves the better surface finish of material to be cut and longer tool life.

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS515082	8.2	10	61	103
CDS515083	8.3	10	61	103
CDS515084	8.4	10	61	103
CDS515085	8.5	10	61	103
CDS515086	8.6	10	61	103
CDS515087	8.7	10	61	103
CDS515088	8.8	10	61	103
CDS515089	8.9	10	61	103
CDS515090	9.0	10	61	103
CDS515091	9.1	10	61	103
CDS515092	9.2	10	61	103
CDS515093	9.3	10	61	103
CDS515094	9.4	10	61	103
CDS515095	9.5	10	61	103
CDS515096	9.6	10	61	103
CDS515097	9.7	10	61	103
CDS515098	9.8	10	61	103
CDS515099	9.9	10	61	103
CDS515100	10.0	10	61	103
CDS515101	10.1	12	71	118
CDS515102	10.2	12	71	118
CDS515103	10.3	12	71	118
CDS515104	10.4	12	71	118
CDS515105	10.5	12	71	118
CDS515106	10.6	12	71	118
CDS515107	10.7	12	71	118
CDS515108	10.8	12	71	118
CDS515109	10.9	12	71	118

Unit:mm

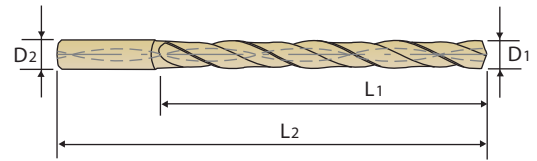
Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS515110	11.0	12	71	118
CDS515111	11.1	12	71	118
CDS515112	11.2	12	71	118
CDS515113	11.3	12	71	118
CDS515114	11.4	12	71	118
CDS515115	11.5	12	71	118
CDS515116	11.6	12	71	118
CDS515117	11.7	12	71	118
CDS515118	11.8	12	71	118
CDS515119	11.9	12	71	118
CDS515120	12.0	12	71	118
CDS515125	12.5	14	77	124
CDS515130	13.0	14	77	124
CDS515135	13.5	14	77	124
CDS515140	14.0	14	77	124
CDS515145	14.5	16	83	133
CDS515150	15.0	16	83	133
CDS515155	15.5	16	83	133
CDS515160	16.0	16	83	133
CDS515165	16.5	18	93	143
CDS515170	17.0	18	93	143
CDS515175	17.5	18	93	143
CDS515180	18.0	18	93	143
CDS515185	18.5	20	101	153
CDS515190	19.0	20	101	153
CDS515195	19.5	20	101	153
CDS515200	20.0	20	101	153

- Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
●	●	○				○	●	○	○	

● : Excellent
○ : Good

CDS815 Series (Extra Long)
8xD



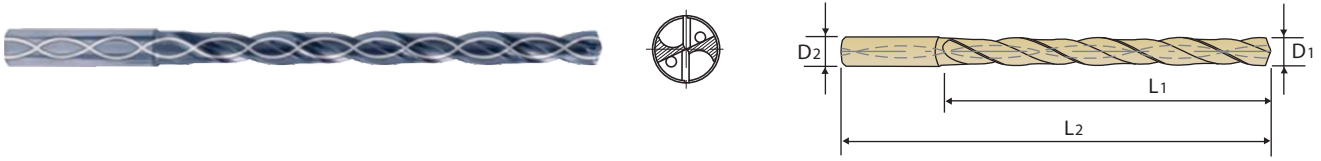
- The tool has the special flute shape and geometry for suitable machining of stainless steels.
- Excellent chip evacuation due to better surface treatment.
- Point R-thinning makes the superior centering and chip curl.
- Applied TiAlN coating, achieves the better surface finish of material to be cut and longer tool life.

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS815030	3.0	6	34	72
CDS815031	3.1	6	34	72
CDS815032	3.2	6	34	72
CDS815033	3.3	6	34	72
CDS815034	3.4	6	34	72
CDS815035	3.5	6	34	72
CDS815036	3.6	6	34	72
CDS815037	3.7	6	34	72
CDS815038	3.8	6	43	81
CDS815039	3.9	6	43	81
CDS815040	4.0	6	43	81
CDS815041	4.1	6	43	81
CDS815042	4.2	6	43	81
CDS815043	4.3	6	43	81
CDS815044	4.4	6	43	81
CDS815045	4.5	6	43	81
CDS815046	4.6	6	43	81
CDS815047	4.7	6	43	81
CDS815048	4.8	6	57	95
CDS815049	4.9	6	57	95
CDS815050	5.0	6	57	95
CDS815051	5.1	6	57	95
CDS815052	5.2	6	57	95
CDS815053	5.3	6	57	95
CDS815054	5.4	6	57	95
CDS815055	5.5	6	57	95
CDS815056	5.6	6	57	95

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS815057	5.7	6	57	95
CDS815058	5.8	6	57	95
CDS815059	5.9	6	57	95
CDS815060	6.0	6	57	95
CDS815061	6.1	8	76	114
CDS815062	6.2	8	76	114
CDS815063	6.3	8	76	114
CDS815064	6.4	8	76	114
CDS815065	6.5	8	76	114
CDS815066	6.6	8	76	114
CDS815067	6.7	8	76	114
CDS815068	6.8	8	76	114
CDS815069	6.9	8	76	114
CDS815070	7.0	8	76	114
CDS815071	7.1	8	76	114
CDS815072	7.2	8	76	114
CDS815073	7.3	8	76	114
CDS815074	7.4	8	76	114
CDS815075	7.5	8	76	114
CDS815076	7.6	8	76	114
CDS815077	7.7	8	76	114
CDS815078	7.8	8	76	114
CDS815079	7.9	8	76	114
CDS815080	8.0	8	76	114
CDS815081	8.1	10	95	142
CDS815082	8.2	10	95	142
CDS815083	8.3	10	95	142

CDS815 Series (Extra Long)
8xD



- The tool has the special flute shape and geometry for suitable machining of stainless steels.
- Excellent chip evacuation due to better surface treatment.
- Point R-thinning makes the superior centering and chip curl.
- Applied TiAlN coating, achieves the better surface finish of material to be cut and longer tool life.

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS815084	8.4	10	95	142
CDS815085	8.5	10	95	142
CDS815086	8.6	10	95	142
CDS815087	8.7	10	95	142
CDS815088	8.8	10	95	142
CDS815089	8.9	10	95	142
CDS815090	9.0	10	95	142
CDS815091	9.1	10	95	142
CDS815092	9.2	10	95	142
CDS815093	9.3	10	95	142
CDS815094	9.4	10	95	142
CDS815095	9.5	10	95	142
CDS815096	9.6	10	95	142
CDS815097	9.7	10	95	142
CDS815098	9.8	10	95	142
CDS815099	9.9	10	95	142
CDS815100	10.0	10	95	142
CDS815101	10.1	12	114	162
CDS815102	10.2	12	114	162
CDS815103	10.3	12	114	162
CDS815104	10.4	12	114	162

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDS815105	10.5	12	114	162
CDS815106	10.6	12	114	162
CDS815107	10.7	12	114	162
CDS815108	10.8	12	114	162
CDS815109	10.9	12	114	162
CDS815110	11.0	12	114	162
CDS815111	11.1	12	114	162
CDS815112	11.2	12	114	162
CDS815113	11.3	12	114	162
CDS815114	11.4	12	114	162
CDS815115	11.5	12	114	162
CDS815116	11.6	12	114	162
CDS815117	11.7	12	114	162
CDS815118	11.8	12	114	162
CDS815119	11.9	12	114	162
CDS815120	12.0	12	114	162
CDS815125	12.5	14	133	178
CDS815130	13.0	14	133	178
CDS815135	13.5	14	133	178
CDS815140	14.0	14	133	178

- Other shank types are available on your request.

●: Excellent
○: Good

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
			HRc45~55	HRc55~						
●	●	○				○	●	○	○	

CDS315, CDS515, CDS815 Series

Unit:mm

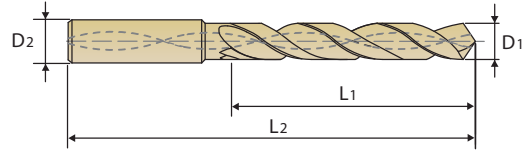
Work Material	Stainless Steels		Stainless Steels		Aluminum		Aluminum		Titanium Ti Alloy		Carbon Steels Alloy Steels		Non Ferrous	
	< 800 N/mm ²		> 800 N/mm ²		< 10 % Si		> 10 % Si							
Drilling Speed	60~70 m/min		35~45 m/min		200~220 m/min		155~175 m/min		40~50 m/min		105~125 m/min		130~150 m/min	
Diameter	N	S	N	S	N	S	N	S	N	S	N	S	N	S
1.0	12000	0.02	6200	0.02	48000	0.04	38000	0.03	8100	0.01	26000	0.02	38000	0.02
1.5	9000	0.03	5400	0.02	43000	0.05	32000	0.04	7500	0.01	18000	0.03	25500	0.03
2.5	7000	0.04	4200	0.03	25500	0.08	19500	0.06	4500	0.02	10800	0.05	15500	0.05
3.0	7400	0.04	4700	0.02	23000	0.12	18500	0.10	5300	0.03	13000	0.04	16000	0.08
4.0	5600	0.05	3600	0.03	17500	0.18	13900	0.15	4000	0.04	10000	0.05	11900	0.10
5.0	4400	0.05	2800	0.03	14000	0.20	11000	0.18	3200	0.05	8000	0.05	9500	0.12
6.0	3700	0.06	2400	0.04	11700	0.25	9300	0.25	2650	0.06	6600	0.06	8000	0.15
8.0	2800	0.08	1800	0.06	8800	0.30	7000	0.30	2000	0.07	5000	0.08	6000	0.18
10.0	2200	0.10	1400	0.08	7000	0.40	5600	0.35	1600	0.08	4000	0.10	4800	0.22
12.0	1900	0.12	1200	0.10	5800	0.50	4600	0.40	1300	0.10	3300	0.12	4000	0.26
14.0	1600	0.15	1000	0.12	5000	0.60	4000	0.50	1100	0.12	2800	0.15	3400	0.30
16.0	1400	0.20	900	0.15	4380	0.80	3500	0.60	1000	0.14	2500	0.20	3000	0.40
18.0	1250	0.22	800	0.17	3900	1.00	3100	0.70	900	0.16	2200	0.22	2650	0.45
20.0	1120	0.24	720	0.19	3500	1.20	2800	0.80	800	0.18	2000	0.24	2400	0.50

- Recommend to reduce the feed rate as following:
 CDS315(3xD) : Feed 100%
 CDS515(5xD) : Feed 100%
 CDS815(8xD) : Feed 85%

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

CDA315 Series (Short)

3xD



- Good chip treatment due to flute geometry & chip space.
- Better finish & built-up edge prevention.

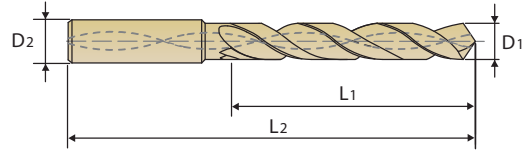
Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA315030	3.0	6	20	62
CDA315031	3.1	6	20	62
CDA315032	3.2	6	20	62
CDA315033	3.3	6	20	62
CDA315034	3.4	6	20	62
CDA315035	3.5	6	20	62
CDA315036	3.6	6	20	62
CDA315037	3.7	6	20	62
CDA315038	3.8	6	24	66
CDA315039	3.9	6	24	66
CDA315040	4.0	6	24	66
CDA315041	4.1	6	24	66
CDA315042	4.2	6	24	66
CDA315043	4.3	6	24	66
CDA315044	4.4	6	24	66
CDA315045	4.5	6	24	66
CDA315046	4.6	6	24	66
CDA315047	4.7	6	24	66
CDA315048	4.8	6	28	66
CDA315049	4.9	6	28	66
CDA315050	5.0	6	28	66
CDA315051	5.1	6	28	66
CDA315052	5.2	6	28	66
CDA315053	5.3	6	28	66
CDA315054	5.4	6	28	66
CDA315055	5.5	6	28	66
CDA315056	5.6	6	28	66
CDA315057	5.7	6	28	66
CDA315058	5.8	6	28	66
CDA315059	5.9	6	28	66
CDA315060	6.0	6	28	66

Unit:mm

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA315061	6.1	8	34	79
CDA315062	6.2	8	34	79
CDA315063	6.3	8	34	79
CDA315064	6.4	8	34	79
CDA315065	6.5	8	34	79
CDA315066	6.6	8	34	79
CDA315067	6.7	8	34	79
CDA315068	6.8	8	34	79
CDA315069	6.9	8	34	79
CDA315070	7.0	8	34	79
CDA315071	7.1	8	41	79
CDA315072	7.2	8	41	79
CDA315073	7.3	8	41	79
CDA315074	7.4	8	41	79
CDA315075	7.5	8	41	79
CDA315076	7.6	8	41	79
CDA315077	7.7	8	41	79
CDA315078	7.8	8	41	79
CDA315079	7.9	8	41	79
CDA315080	8.0	8	41	79
CDA315081	8.1	10	47	89
CDA315082	8.2	10	47	89
CDA315083	8.3	10	47	89
CDA315084	8.4	10	47	89
CDA315085	8.5	10	47	89
CDA315086	8.6	10	47	89
CDA315087	8.7	10	47	89
CDA315088	8.8	10	47	89
CDA315089	8.9	10	47	89
CDA315090	9.0	10	47	89
CDA315091	9.1	10	47	89

- Other shank types are available on your request.

CDA315 Series (Short)
3xD



- Good chip treatment due to flute geometry & chip space.
- Better finish & built-up edge prevention.

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA315092	9.2	10	47	89
CDA315093	9.3	10	47	89
CDA315094	9.4	10	47	89
CDA315095	9.5	10	47	89
CDA315096	9.6	10	47	89
CDA315097	9.7	10	47	89
CDA315098	9.8	10	47	89
CDA315099	9.9	10	47	89
CDA315100	10.0	10	47	89
CDA315101	10.1	12	55	102
CDA315102	10.2	12	55	102
CDA315103	10.3	12	55	102
CDA315104	10.4	12	55	102
CDA315105	10.5	12	55	102
CDA315106	10.6	12	55	102
CDA315107	10.7	12	55	102
CDA315108	10.8	12	55	102
CDA315109	10.9	12	55	102
CDA315110	11.0	12	55	102
CDA315111	11.1	12	55	102
CDA315112	11.2	12	55	102
CDA315113	11.3	12	55	102
CDA315114	11.4	12	55	102

Unit:mm

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA315115	11.5	12	55	102
CDA315116	11.6	12	55	102
CDA315117	11.7	12	55	102
CDA315118	11.8	12	55	102
CDA315119	11.9	12	55	102
CDA315120	12.0	12	55	102
CDA315125	12.5	14	60	107
CDA315130	13.0	14	60	107
CDA315135	13.5	14	60	107
CDA315140	14.0	14	60	107
CDA315145	14.5	16	65	115
CDA315150	15.0	16	65	115
CDA315155	15.5	16	65	115
CDA315160	16.0	16	65	115
CDA315165	16.5	18	73	123
CDA315170	17.0	18	73	123
CDA315175	17.5	18	73	123
CDA315180	18.0	18	73	123
CDA315185	18.5	20	79	131
CDA315190	19.0	20	79	131
CDA315195	19.5	20	79	131
CDA315200	20.0	20	79	131

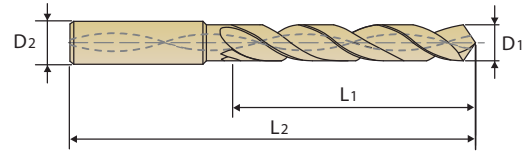
- DLC coating is available on your request.
- Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
						●				

●: Excellent
○: Good

CDA515 Series (Long)

5xD



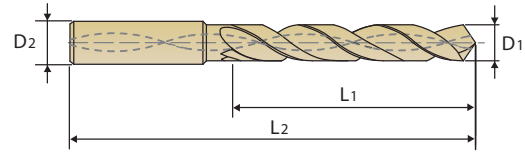
- Good chip treatment due to flute geometry & chip space.
- Better finish & built-up edge prevention.

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA515030	3.0	6	28	66
CDA515031	3.1	6	28	66
CDA515032	3.2	6	28	66
CDA515033	3.3	6	28	66
CDA515034	3.4	6	28	66
CDA515035	3.5	6	28	66
CDA515036	3.6	6	28	66
CDA515037	3.7	6	28	66
CDA515038	3.8	6	36	74
CDA515039	3.9	6	36	74
CDA515040	4.0	6	36	74
CDA515041	4.1	6	36	74
CDA515042	4.2	6	36	74
CDA515043	4.3	6	36	74
CDA515044	4.4	6	36	74
CDA515045	4.5	6	36	74
CDA515046	4.6	6	36	74
CDA515047	4.7	6	36	74
CDA515048	4.8	6	44	82
CDA515049	4.9	6	44	82
CDA515050	5.0	6	44	82
CDA515051	5.1	6	44	82
CDA515052	5.2	6	44	82
CDA515053	5.3	6	44	82
CDA515054	5.4	6	44	82
CDA515055	5.5	6	44	82
CDA515056	5.6	6	44	82
CDA515057	5.7	6	44	82
CDA515058	5.8	6	44	82
CDA515059	5.9	6	44	82
CDA515060	6.0	6	44	82

Unit:mm

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA515061	6.1	8	53	91
CDA515062	6.2	8	53	91
CDA515063	6.3	8	53	91
CDA515064	6.4	8	53	91
CDA515065	6.5	8	53	91
CDA515066	6.6	8	53	91
CDA515067	6.7	8	53	91
CDA515068	6.8	8	53	91
CDA515069	6.9	8	53	91
CDA515070	7.0	8	53	91
CDA515071	7.1	8	53	91
CDA515072	7.2	8	53	91
CDA515073	7.3	8	53	91
CDA515074	7.4	8	53	91
CDA515075	7.5	8	53	91
CDA515076	7.6	8	53	91
CDA515077	7.7	8	53	91
CDA515078	7.8	8	53	91
CDA515079	7.9	8	53	91
CDA515080	8.0	8	53	91
CDA515081	8.1	10	61	103
CDA515082	8.2	10	61	103
CDA515083	8.3	10	61	103
CDA515084	8.4	10	61	103
CDA515085	8.5	10	61	103
CDA515086	8.6	10	61	103
CDA515087	8.7	10	61	103
CDA515088	8.8	10	61	103
CDA515089	8.9	10	61	103
CDA515090	9.0	10	61	103
CDA515091	9.1	10	61	103

CDA515 Series (Long)
5xD



- Good chip treatment due to flute geometry & chip space.
- Better finish & built-up edge prevention.

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA515092	9.2	10	61	103
CDA515093	9.3	10	61	103
CDA515094	9.4	10	61	103
CDA515095	9.5	10	61	103
CDA515096	9.6	10	61	103
CDA515097	9.7	10	61	103
CDA515098	9.8	10	61	103
CDA515099	9.9	10	61	103
CDA515100	10.0	10	61	103
CDA515101	10.1	12	71	118
CDA515102	10.2	12	71	118
CDA515103	10.3	12	71	118
CDA515104	10.4	12	71	118
CDA515105	10.5	12	71	118
CDA515106	10.6	12	71	118
CDA515107	10.7	12	71	118
CDA515108	10.8	12	71	118
CDA515109	10.9	12	71	118
CDA515110	11.0	12	71	118
CDA515111	11.1	12	71	118
CDA515112	11.2	12	71	118
CDA515113	11.3	12	71	118
CDA515114	11.4	12	71	118

Unit:mm

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA515115	11.5	12	71	118
CDA515116	11.6	12	71	118
CDA515117	11.7	12	71	118
CDA515118	11.8	12	71	118
CDA515119	11.9	12	71	118
CDA515120	12.0	12	71	118
CDA515125	12.5	14	77	124
CDA515130	13.0	14	77	124
CDA515135	13.5	14	77	124
CDA515140	14.0	14	77	124
CDA515145	14.5	16	83	133
CDA515150	15.0	16	83	133
CDA515155	15.5	16	83	133
CDA515160	16.0	16	83	133
CDA515165	16.5	18	93	143
CDA515170	17.0	18	93	143
CDA515175	17.5	18	93	143
CDA515180	18.0	18	93	143
CDA515185	18.5	20	101	153
CDA515190	19.0	20	101	153
CDA515195	19.5	20	101	153
CDA515200	20.0	20	101	153

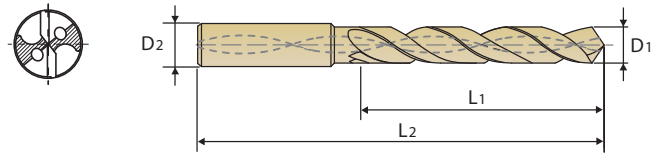
- DLC coating is available on your request.
- Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
						●				

● : Excellent
○ : Good

CDA815 Series (Extra Long)

8xD



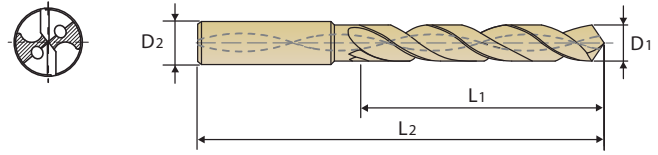
- Good chip treatment due to flute geometry & chip space.
- Better finish & built-up edge prevention.

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA815030	3.0	6	34	72
CDA815031	3.1	6	34	72
CDA815032	3.2	6	34	72
CDA815033	3.3	6	34	72
CDA815034	3.4	6	34	72
CDA815035	3.5	6	34	72
CDA815036	3.6	6	34	72
CDA815037	3.7	6	34	72
CDA815038	3.8	6	43	81
CDA815039	3.9	6	43	81
CDA815040	4.0	6	43	81
CDA815041	4.1	6	43	81
CDA815042	4.2	6	43	81
CDA815043	4.3	6	43	81
CDA815044	4.4	6	43	81
CDA815045	4.5	6	43	81
CDA815046	4.6	6	43	81
CDA815047	4.7	6	43	81
CDA815048	4.8	6	57	95
CDA815049	4.9	6	57	95
CDA815050	5.0	6	57	95
CDA815051	5.1	6	57	95
CDA815052	5.2	6	57	95
CDA815053	5.3	6	57	95
CDA815054	5.4	6	57	95
CDA815055	5.5	6	57	95
CDA815056	5.6	6	57	95
CDA815057	5.7	6	57	95

Unit:mm

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA815058	5.8	6	57	95
CDA815059	5.9	6	57	95
CDA815060	6.0	6	57	95
CDA815061	6.1	8	76	114
CDA815062	6.2	8	76	114
CDA815063	6.3	8	76	114
CDA815064	6.4	8	76	114
CDA815065	6.5	8	76	114
CDA815066	6.6	8	76	114
CDA815067	6.7	8	76	114
CDA815068	6.8	8	76	114
CDA815069	6.9	8	76	114
CDA815070	7.0	8	76	114
CDA815071	7.1	8	76	114
CDA815072	7.2	8	76	114
CDA815073	7.3	8	76	114
CDA815074	7.4	8	76	114
CDA815075	7.5	8	76	114
CDA815076	7.6	8	76	114
CDA815077	7.7	8	76	114
CDA815078	7.8	8	76	114
CDA815079	7.9	8	76	114
CDA815080	8.0	8	76	114
CDA815081	8.1	10	95	142
CDA815082	8.2	10	95	142
CDA815083	8.3	10	95	142
CDA815084	8.4	10	95	142
CDA815085	8.5	10	95	142

CDA815 Series (Extra Long)
8xD



- Good chip treatment due to flute geometry & chip space.
- Better finish & built-up edge prevention.

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA815086	8.6	10	95	142
CDA815087	8.7	10	95	142
CDA815088	8.8	10	95	142
CDA815089	8.9	10	95	142
CDA815090	9.0	10	95	142
CDA815091	9.1	10	95	142
CDA815092	9.2	10	95	142
CDA815093	9.3	10	95	142
CDA815094	9.4	10	95	142
CDA815095	9.5	10	95	142
CDA815096	9.6	10	95	142
CDA815097	9.7	10	95	142
CDA815098	9.8	10	95	142
CDA815099	9.9	10	95	142
CDA815100	10.0	10	95	142
CDA815101	10.1	12	114	162
CDA815102	10.2	12	114	162
CDA815103	10.3	12	114	162
CDA815104	10.4	12	114	162
CDA815105	10.5	12	114	162

Unit:mm

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDA815106	10.6	12	114	162
CDA815107	10.7	12	114	162
CDA815108	10.8	12	114	162
CDA815109	10.9	12	114	162
CDA815110	11.0	12	114	162
CDA815111	11.1	12	114	162
CDA815112	11.2	12	114	162
CDA815113	11.3	12	114	162
CDA815114	11.4	12	114	162
CDA815115	11.5	12	114	162
CDA815116	11.6	12	114	162
CDA815117	11.7	12	114	162
CDA815118	11.8	12	114	162
CDA815119	11.9	12	114	162
CDA815120	12.0	12	114	162
CDA815125	12.5	14	133	178
CDA815130	13.0	14	133	178
CDA815135	13.5	14	133	178
CDA815140	14.0	14	133	178

- DLC coating is available on your request.
- Other shank types are available on your request.

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
						●				

● : Excellent
○ : Good

CDA315, CDA515, CDA815 Series

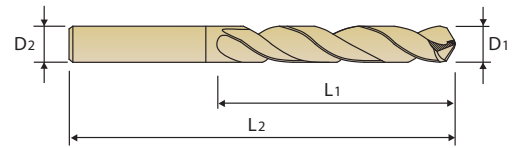
Unit:mm

Work Material	Aluminum Alloy Casting Aluminum Die Casting		Wrought Aluminum Alloy	
	N	S	N	S
ø3.0 ~ø 6.0	8,000~15,000	0.2~0.5	8,000~15,000	0.15~0.3
~ ø10.0	6,000~10,500	0.3~1.0	6,000~10,500	0.2~0.4
~ ø14.0	4,500~5,800	0.3~1.0	4,500~5,800	0.2~0.4
~ ø20.0	3,200~4,600	0.3~1.0	3,200~4,600	0.2~0.4

N = R.P.M

S = Feed per Revolution (mm/rev.)

CDC305 Series



- Special Point Type improve hole quality for Composite Material
-> Minimized Burr and Delamination at Entry / Exit Hole.
- Outstanding Performance.
- Long tool life and increased Productivity by Diamond coating.

Unit:mm

Part Number Diamond Coated	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDC305025	2.5	6	24	66
CDC305030	3.0	6	28	66
CDC305040	4.0	6	36	74
CDC305050	5.0	6	44	82
CDC305060	6.0	6	44	82
CDC305080	8.0	8	53	91
CDC305090	9.0	10	61	103
CDC305100	10.0	10	61	103
CDC305110	11.0	12	71	118
DI473120	12.0	12	71	118

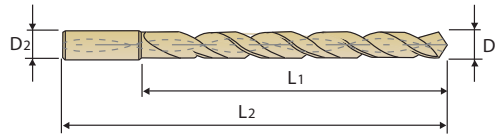
Cutting Condition

Work Material Diameter	Speed (m/min)	CFRP RPM	Feed (mm/rev)
2.5	100 ~ 150	12,700 ~ 19,000	0.03 ~ 0.07
3.0	100 ~ 150	10,600 ~ 15,900	0.03 ~ 0.07
4.0	100 ~ 150	8,000 ~ 11,900	0.03 ~ 0.07
5.0	100 ~ 150	6,370 ~ 9,500	0.03 ~ 0.07
6.0	100 ~ 150	5,300 ~ 8,000	0.03 ~ 0.07
8.0	100 ~ 150	4,000 ~ 6,000	0.03 ~ 0.07
9.0	100 ~ 150	3,500 ~ 5,300	0.03 ~ 0.07
10.0	100 ~ 150	3,200 ~ 4,700	0.03 ~ 0.07
11.0	100 ~ 150	2,900 ~ 4,300	0.03 ~ 0.07
12.0	100 ~ 150	2,700 ~ 3,900	0.03 ~ 0.07

●: Excellent
○: Good

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
										●

CDM010 Series
10xD



Application : Drilling steels in general, cast steels, cast iron, non-ferrous heavy metals, non-ferrous light metals.
 Advantage : Non step drilling up to 10 times of drill diameter. Available for processing MQL (Minimum Quantity Lubrication)
 Excellent positioning - Bush is not necessary
 Special design - Good chip removal
 - Powerful drilling

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDM010030	3.0	3	39	90
CDM010033	3.3	4	46	97
CDM010035	3.5	4	46	97
CDM010040	4.0	4	52	103
CDM010042	4.2	5	59	112
CDM010045	4.5	5	59	112
CDM010050	5.0	5	65	118
CDM010055	5.5	6	72	127
CDM010060	6.0	6	78	133
CDM010065	6.5	7	85	141
CDM010068	6.8	7	91	147
CDM010070	7.0	7	91	147
CDM010075	7.5	8	98	155

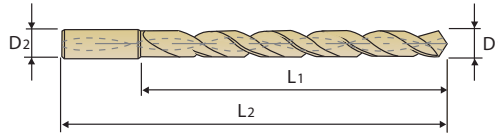
Unit:mm

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDM010080	8.0	8	104	161
CDM010085	8.5	9	111	169
CDM010090	9.0	9	117	175
CDM010095	9.5	10	124	182
CDM010100	10.0	10	130	188
CDM010105	10.5	11	137	201
CDM010110	11.0	11	143	207
CDM010115	11.5	12	150	215
CDM010120	12.0	12	156	221
CDM010125	12.5	13	163	229
CDM010130	13.0	13	169	235
CDM010135	13.5	14	176	243
CDM010140	14.0	14	182	249

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRC30~45	Hardened Steels HRC45~55 HRC55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
●	●	○			○				○	

● : Excellent
○ : Good

CDM015, CDM020 Series 15xD, 20xD



Application : Drilling steels in general, cast steels, cast iron, non-ferrous heavy metals, non-ferrous light metals.
 Advantage : Non step drilling up to 10 times of drill diameter. Available for processing MQL (Minimum Quantity Lubrication)
 Excellent positioning - Bush is not necessary
 Special design - Good chip removal
 - Powerful drilling

15xD

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDM015030	3.0	3	54	105
CDM015035	3.5	4	63	114
CDM015040	4.0	4	72	123
CDM015045	4.5	5	81	134
CDM015050	5.0	5	90	143
CDM015055	5.5	6	99	154
CDM015060	6.0	6	108	163
CDM015070	7.0	7	126	182
CDM015080	8.0	8	144	201
CDM015090	9.0	9	162	220
CDM015100	10.0	10	180	238
CDM015110	11.0	11	198	262
CDM015120	12.0	12	216	281

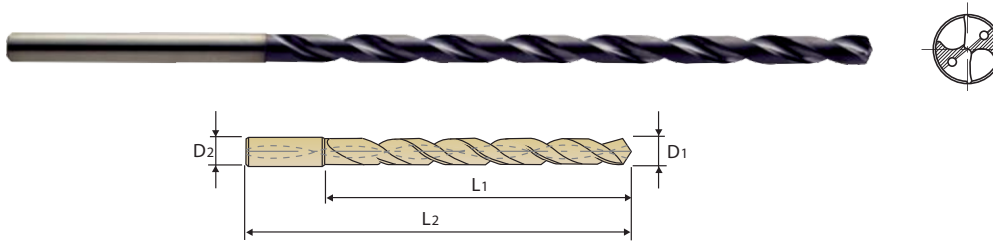
20xD

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDM020030	3.0	3	69	120
CDM020035	3.5	4	81	132
CDM020040	4.0	4	92	143
CDM020045	4.5	5	104	157
CDM020050	5.0	5	115	168
CDM020055	5.5	6	127	182
CDM020060	6.0	6	138	193
CDM020070	7.0	7	161	217
CDM020080	8.0	8	184	241
CDM020090	9.0	9	207	265
CDM020100	10.0	10	230	288
CDM020120	12.0	12	276	341

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
			HRc45~55	HRc55~						
●	●	○			○				○	

● : Excellent
○ : Good

CDMS10, CDMS15, CDMS20 Series
10xD, 15xD, 20xD



Application : Drilling steels in general, cast steels, cast iron, non-ferrous heavy metals, non-ferrous light metals.
 Advantage : Non step drilling up to 10 times of drill diameter. Available for processing MQL (Minimum Quantity Lubrication)
 Excellent positioning - Bush is not necessary
 Special design - Good chip removal
 - Powerful drilling

10xD

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDMS10030	3.0	6	40	80
CDMS10033	3.3	6	47	87
CDMS10035	3.5	6	47	87
CDMS10040	4.0	6	53	93
CDMS10042	4.2	6	60	100
CDMS10045	4.5	6	60	100
CDMS10050	5.0	6	66	106
CDMS10055	5.5	6	73	113
CDMS10060	6.0	6	79	119
CDMS10065	6.5	8	86	126
CDMS10068	6.8	8	92	132
CDMS10075	7.5	8	99	139
CDMS10080	8.0	8	105	145
CDMS10085	8.5	10	112	156
CDMS10090	9.0	10	118	162
CDMS10095	9.5	10	126	170
CDMS10100	10.0	10	132	176
CDMS10105	10.5	12	139	188
CDMS10110	11.0	12	145	195
CDMS10115	11.5	12	152	201
CDMS10120	12.0	12	158	207
CDMS10125	12.5	14	165	214
CDMS10130	13.0	14	171	220
CDMS10135	13.5	14	178	227
CDMS10140	14.0	14	184	233

15xD

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDMS15030	3.0	6	55	95
CDMS15035	3.5	6	64	104
CDMS15040	4.0	6	73	113
CDMS15045	4.5	6	82	122
CDMS15050	5.0	6	91	131
CDMS15055	5.5	6	100	140
CDMS15060	6.0	6	109	149
CDMS15070	7.0	8	127	167
CDMS15080	8.0	8	145	185
CDMS15090	9.0	10	163	207
CDMS15100	10.0	10	182	226
CDMS15110	11.0	12	200	249
CDMS15120	12.0	12	218	267

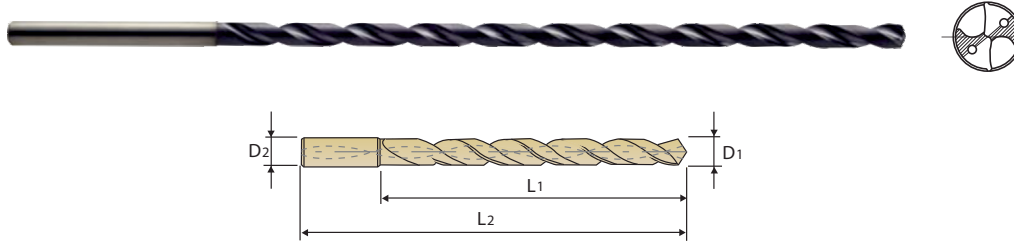
20xD

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDMS20030	3.0	6	70	110
CDMS20035	3.5	6	82	122
CDMS20040	4.0	6	93	133
CDMS20045	4.5	6	105	145
CDMS20050	5.0	6	116	156
CDMS20055	5.5	6	128	168
CDMS20060	6.0	6	139	179
CDMS20070	7.0	8	162	202
CDMS20080	8.0	8	185	225
CDMS20090	9.0	10	208	252
CDMS20100	10.0	10	232	276
CDMS20110	11.0	12	255	304
CDMS20120	12.0	12	278	327

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels HRc45~55 HRc55~		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
●	●	○			○				○	

● : Excellent
 ○ : Good

CDMS25, CDMS30 Series
25xD, 30xD



Application : Drilling steels in general, cast steels, cast iron, non-ferrous heavy metals, non-ferrous light metals.
 Advantage : Non step drilling up to 10 times of drill diameter. Available for processing MQL (Minimum Quantity Lubrication)
 Excellent positioning - Bush is not necessary
 Special design - Good chip removal
 - Powerful drilling

25xD

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDMS25030	3.0	6.0	85	125
CDMS25035	3.5	6.0	99	139
CDMS25040	4.0	6.0	113	153
CDMS25045	4.5	6.0	127	167
CDMS25050	5.0	6.0	141	181
CDMS25055	5.5	6.0	155	195
CDMS25060	6.0	6.0	169	209
CDMS25070	7.0	8.0	197	237
CDMS25080	8.0	8.0	225	265
CDMS25090	9.0	10.0	253	297
CDMS25100	10.0	10.0	282	326

30xD

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDMS30030	3.0	6.0	100	140
CDMS30035	3.5	6.0	117	157
CDMS30040	4.0	6.0	133	173
CDMS30045	4.5	6.0	150	190
CDMS30050	5.0	6.0	166	206
CDMS30055	5.5	6.0	183	223
CDMS30060	6.0	6.0	199	239
CDMS30070	7.0	8.0	232	272
CDMS30080	8.0	8.0	265	305

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
			HRc45~55	HRc55~						
●	●	○			○				○	

● : Excellent
○ : Good

CDM010, CDM015, CDM020, CDMS10, CDMS15, CDMS20 Series

Work Material	Carbon Steels Alloy Steels		Cast Iron		Ductile Cast Iron	
Strength	~ 1060 N/mm ²		250 ~ 350 N/mm ²		400 ~ 500 N/mm ²	
Drilling Speed	63~125 m/min		63~125 m/min		60~80 m/min	
Diameter	N	S	N	S	N	S
3.0	7500	0.06 ~ 0.12	7500	0.06 ~ 0.12	7500	0.06 ~ 0.12
4.0	6400	0.08 ~ 0.16	6400	0.08 ~ 0.16	5600	0.08 ~ 0.16
5.0	5800	0.10 ~ 0.20	5800	0.10 ~ 0.20	4500	0.10 ~ 0.20
6.0	4800	0.12 ~ 0.24	4800	0.12 ~ 0.24	3800	0.12 ~ 0.24
8.0	3600	0.16 ~ 0.28	3600	0.16 ~ 0.28	2800	0.16 ~ 0.28
10.0	2900	0.20 ~ 0.35	2900	0.20 ~ 0.35	2300	0.20 ~ 0.35
12.0	2400	0.24 ~ 0.42	2400	0.24 ~ 0.42	1900	0.24 ~ 0.42
14.0	2050	0.28 ~ 0.46	2050	0.28 ~ 0.46	1600	0.28 ~ 0.46

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

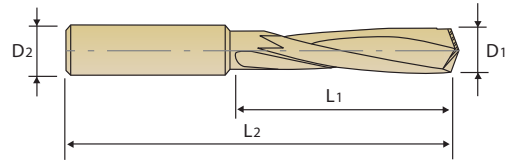
CDMS25, CDMS30 Series

Work Material	Carbon Steels Alloy Steels		Cast Iron		Ductile Cast Iron	
Strength	~ 1060 N/mm ²		250 ~ 350 N/mm ²		400 ~ 500 N/mm ²	
Drilling Speed	50~110 m/min		50~110 m/min		40~70 m/min	
Diameter	N	S	N	S	N	S
3.0	6400	0.06~0.12	6400	0.06~0.12	6400	0.06~0.12
4.0	5500	0.08~0.16	5500	0.08~0.16	4700	0.08~0.16
5.0	4900	0.10~0.20	4900	0.10~0.20	3800	0.10~0.20
6.0	4200	0.12~0.24	4200	0.12~0.24	3200	0.12~0.24
8.0	3000	0.16~0.28	3000	0.16~0.28	2400	0.16~0.28
10.0	2500	0.20~0.35	2500	0.20~0.35	1900	0.20~0.35

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

1. Guide Drilling should be done as Diameter +0.1mm between 3xD and 5xD depth.
2. For main Drilling, proceed with low RPM at Guide Drilling segment. (RPM 300, Feed 400mm/min)
3. Just before the end of Guide Drilling segment, reduce feed to zero and increase the RPM according to Recommended Cutting Condition chart.
4. After then, proceed main drilling by increasing feed without step drilling.
5. When coming out from Guide Drilling start point after drilling, RPM should be reduced as 300 and feed should be 1000 mm/min.
6. When coming out from Guide Drilling segment to the outside, the feed should be decreased as 50%.

CDH909 Series



Application : Drilling for high hardened steels (Quenched steels, Tempered steels (Under HRC70).

Advantage : Special design

Minimum of cutting load through special thinning.

Good chip removal.

Powerful Drilling.

Unit:mm

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDH909026	2.6	3	14	44
CDH909030	3.0	3	16	46
CDH909033	3.3	4	18	48
CDH909034	3.4	4	20	50
CDH909035	3.5	4	20	50
CDH909040	4.0	4	22	52
CDH909042	4.2	6	25	65
CDH909043	4.3	6	28	68
CDH909044	4.4	6	28	68
CDH909045	4.5	6	28	68
CDH909050	5.0	6	32	72
CDH909051	5.1	6	32	72
CDH909052	5.2	6	32	72
CDH909055	5.5	6	35	75
CDH909060	6.0	6	35	75
CDH909065	6.5	8	40	80
CDH909068	6.8	8	45	85
CDH909069	6.9	8	45	85

Part Number TiAlN	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
CDH909070	7.0	8	45	85
CDH909075	7.5	8	45	85
CDH909080	8.0	8	50	98
CDH909085	8.5	10	50	98
CDH909086	8.6	10	57	105
CDH909088	8.8	10	57	105
CDH909090	9.0	10	57	105
CDH909095	9.5	10	57	105
CDH909100	10.0	10	63	111
CDH909102	10.2	12	63	111
CDH909103	10.3	12	63	111
CDH909105	10.5	12	63	111
CDH909108	10.8	12	71	119
CDH909110	11.0	12	71	119
CDH909115	11.5	12	71	119
CDH909120	12.0	12	71	119
CDH909140	14.0	14	77	125

● : Excellent
○ : Good

Carbon Steels ~HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~45	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	CFRP
			HRc45~55	HRc55~						
			●	●						

Solid Carbide Drills for High Hardened Steels HRc50 ~ HRc70, TiAlN Coated

CDH909 Series

Work Material	Hardened Steels					
	HRc50 ~ 55		HRc55 ~ 60		HRc60 ~ 70	
Drilling Speed	14~22 m/min		10~16 m/min		8~13 m/min	
Diameter	N	S	N	S	N	S
3.0	1900	~ 0.04	1330	~ 0.04	1250	~ 0.04
4.0	1430	~ 0.04	1000	~ 0.04	950	~ 0.04
5.0	1150	~ 0.04	800	~ 0.04	750	~ 0.04
6.0	960	~ 0.04	670	~ 0.04	630	~ 0.04
8.0	720	~ 0.04	500	~ 0.04	480	~ 0.04
10.0	570	~ 0.04	400	~ 0.04	380	~ 0.04
12.0	480	~ 0.04	330	~ 0.04	320	~ 0.04
14.0	438	~ 0.04	282	~ 0.04	272	~ 0.04

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



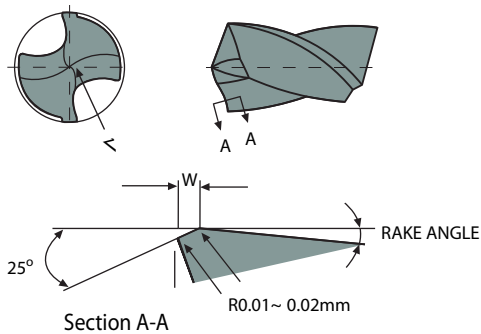
Characteristic of Solid Carbide DRILL

- Brisloy's Drill Series are suitable for high speed and accurate drilling operations by special design and high quality.
- Good performance for Steels, Cast Irons, Tool steels, Alloy steels and Stainless steels.
- Rapid chip evacuation and excellent chip breaking can be achieved by special designed cutting edges on point and chip breakers on leading edges.
- High accuracy and stability.
- Longer tool life due to TiAlN coating.
- Self-centering

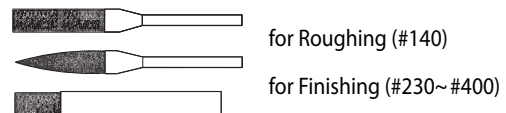


Honing Guide of Solid Carbide DRILL

Dimension of Honing



Scraper

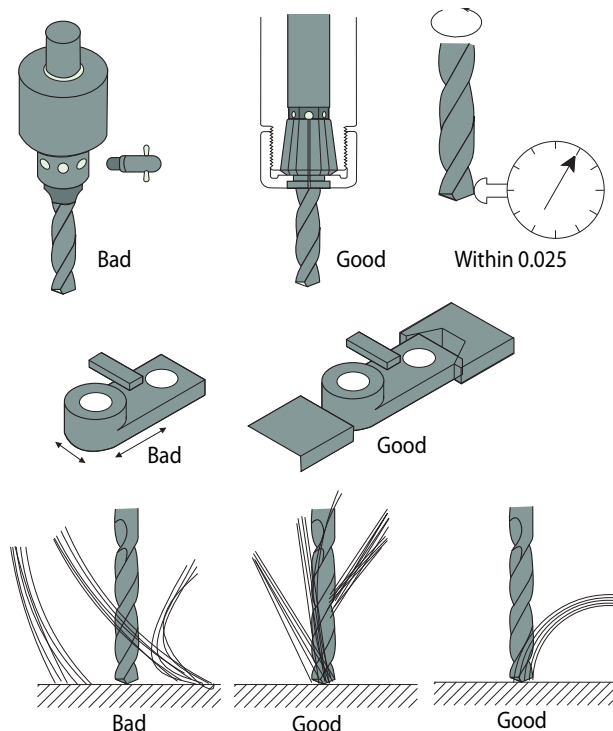


Work Material	Alloy Steels	Mild Steels	Cast Iron
W(mm)	0.15~0.2	0.1~0.15	0.03

- The dimension W of stocked products is 0.1~0.15.



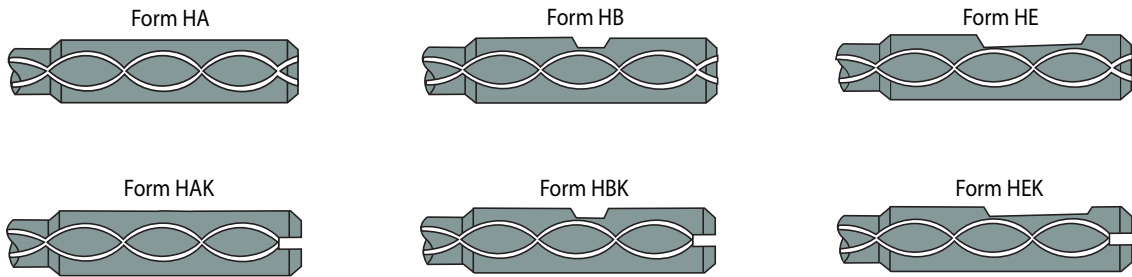
Use of Solid Carbide DRILL



- Chucking with spring collet correctly.
- Radial run out at cutting lip must not exceed 0.025 mm.
- Tighten clamp of work piece.
- Supply coolant enough to the entrance of holes.
- In using Solid Carbide Drill with Coolant holes, high pressure coolant is needed.

4

Shank Type Solid Carbide DRILL with Coolant Holes



- Shank Type of stocked products is Form HA.
- If you need other Shank Type, we can supply them.

5

ISO Tolerance

$\mu\text{m}=1/1000\text{mm}$

Diameter (mm)	1 - 3 from to	3 - 6 over to	6 - 10 over to	10 - 18 over to	18 - 30 over to	30 - 50 over to
Tolerance range in μm						
h6	0 - 6	0 - 8	0 - 9	0 - 11	0 - 13	0 - 16
h7	0 - 10	0 - 12	0 - 15	0 - 18	0 - 21	0 - 25
h8	0 - 14	0 - 18	0 - 22	0 - 27	0 - 33	0 - 39
m7	+ 12 + 2	+ 16 + 4	+ 21 + 6	+ 25 + 7	+ 29 + 8	+ 34 + 9

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