



HPD Stub Drills
High Performance



HSS Premium Cobalt Stub Drills

HSS PREMIUM COBALT STUB DRILLS
SUPERIOR TIN COATING D4541 SERIES



DRILLS

Ordering Code	Dia	Overall Length	Flute Length	2007 £
D4541020	2.0	44	12	3.49
D4541021	2.1	44	12	3.49
D4541022	2.2	45	13	3.49
D4541023	2.3	45	13	3.49
D4541024	2.4	46	14	3.49
D4541025	2.5	46	14	3.49
D4541026	2.6	46	14	3.49
D4541027	2.7	48	16	3.49
D4541028	2.8	48	16	3.49
D4541029	2.9	48	16	3.49
D4541030	3.0	48	16	3.49
D4541031	3.1	50	18	3.49
D4541032	3.2	50	18	3.49
D4541033	3.3	50	18	3.49
D4541034	3.4	52	20	3.49
D4541035	3.5	52	20	3.49
D4541036	3.6	52	20	4.33
D4541037	3.7	52	20	4.33
D4541038	3.8	54	22	4.33
D4541039	3.9	54	22	4.33
D4541040	4.0	54	22	4.33
D4541041	4.1	66	22	5.16
D4541042	4.2	66	22	5.16
D4541043	4.3	68	24	5.16
D4541044	4.4	68	24	5.16
D4541045	4.5	68	24	5.16
D4541046	4.6	68	24	6.04
D4541047	4.7	68	24	6.04
D4541048	4.8	70	26	6.04
D4541049	4.9	70	26	6.04
D4541050	5.0	70	26	6.04
D4541051	5.1	70	26	6.04
D4541052	5.2	70	26	6.96
D4541053	5.3	70	26	6.04
D4541054	5.4	72	28	6.04
D4541055	5.5	72	28	6.04
D4541056	5.6	72	28	8.05
D4541057	5.7	72	28	8.05
D4541058	5.8	72	28	8.05
D4541059	5.9	72	28	8.05
D4541060	6.0	72	28	8.05
D4541061	6.1	75	31	8.05
D4541062	6.2	75	31	8.05
D4541063	6.3	75	31	8.05
D4541064	6.4	75	31	8.05
D4541065	6.5	75	31	8.05
D4541066	6.6	75	31	8.05
D4541067	6.7	75	31	8.05
D4541068	6.8	78	34	8.05
D4541069	6.9	78	34	8.05
D4541070	7.0	78	34	8.05
D4541071	7.1	78	34	8.71
D4541072	7.2	78	34	8.71
D4541073	7.3	78	34	8.71
D4541074	7.4	78	34	8.71

Applications

For high performance machining of

- Mild steels
- Hard + tough materials
- Alloy + tool steel
- Inconel
- Nimonic
- Aluminium
- Cast iron

Benefits

- High speeds
- High feeds
- Long tool life
- Good chip removal
- Reinforced web for reduced vibration and deflection
- Up to 300% increased performance, compared to GPD drills

High Performance

Good chip removal

Premium HSS-Co

Superior TIN coating



DRILLS HPD High Performance



HPD Stub Drills High Performance



HSS Premium Cobalt Stub Drills

HSS PREMIUM COBALT STUB DRILLS
SUPERIOR TIN COATING D4541 SERIES



Ordering Code	Dia	Overall Length	Flute Length	2007 £
D4541075	7.5	78	34	8.71
D4541076	7.6	81	37	9.58
D4541077	7.7	81	37	9.58
D4541078	7.8	81	37	9.58
D4541079	7.9	81	37	9.58
D4541080	8.0	81	37	9.58
D4541081	8.1	87	37	9.58
D4541082	8.2	87	37	9.58
D4541083	8.3	87	37	9.58
D4541084	8.4	87	37	9.58
D4541085	8.5	87	37	9.58
D4541086	8.6	90	40	9.58
D4541087	8.7	90	40	10.94
D4541088	8.8	90	40	10.94
D4541089	8.9	90	40	10.94
D4541090	9.0	90	40	10.94
D4541091	9.1	90	40	12.21
D4541092	9.2	90	40	12.21
D4541093	9.3	90	40	12.21
D4541094	9.4	90	40	12.21
D4541095	9.5	90	40	12.21
D4541096	9.6	93	43	13.95
D4541097	9.7	93	43	13.95
D4541098	9.8	93	43	13.95
D4541099	9.9	93	43	13.95
D4541100	10.0	93	43	13.95
D4541101	10.1	100	43	14.51
D4541102	10.2	100	43	14.51
D4541103	10.3	100	43	14.51
D4541104	10.4	100	43	14.51
D4541105	10.5	100	43	15.89
D4541106	10.6	100	43	15.89
D4541107	10.7	104	47	15.89
D4541108	10.8	104	47	15.89
D4541109	10.9	104	47	15.89
D4541110	11.0	104	47	17.00
D4541111	11.1	104	47	17.00
D4541112	11.2	104	47	17.00
D4541113	11.3	104	47	17.00
D4541114	11.4	104	47	17.00
D4541115	11.5	104	47	17.00
D4541116	11.6	104	47	17.00
D4541117	11.7	104	47	17.00
D4541118	11.8	104	47	17.00
D4541119	11.9	108	51	17.00
D4541120	12.0	108	51	17.00
D4541121	12.1	108	51	19.00
D4541122	12.2	108	51	19.00
D4541123	12.3	108	51	19.00
D4541124	12.4	108	51	19.00
D4541125	12.5	108	51	19.00
D4541126	12.6	108	51	19.00
D4541127	12.7	108	51	19.00
D4541128	12.8	108	51	19.00
D4541129	12.9	108	51	19.00
D4541130	13.0	108	51	19.00

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Reduced deflection + vibration

Long tool life

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3xD



DRILLS

DRILLS HPD High Performance



HSS Premium Cobalt Jobber Drills

HSS PREMIUM COBALT JOBBER DRILLS
SUPERIOR TIN COATING D4542 SERIES



DRILLS

Ordering Code	Dia	Overall Length	Flute Length	2007 £
D4542020	2.0	56	24	3.99
D4542021	2.1	56	24	3.99
D4542022	2.2	59	27	3.99
D4542023	2.3	59	27	3.99
D4542024	2.4	62	30	3.99
D4542025	2.5	62	30	3.99
D4542026	2.6	62	30	3.99
D4542027	2.7	65	33	3.99
D4542028	2.8	65	33	3.99
D4542029	2.9	65	33	3.99
D4542030	3.0	65	33	3.99
D4542031	3.1	68	36	3.99
D4542032	3.2	68	36	3.99
D4542033	3.3	68	36	3.99
D4542034	3.4	71	39	3.99
D4542035	3.5	71	39	3.99
D4542036	3.6	71	39	4.95
D4542037	3.7	71	39	4.95
D4542038	3.8	75	43	4.95
D4542039	3.9	75	43	4.95
D4542040	4.0	75	43	4.95
D4542041	4.1	87	43	5.90
D4542042	4.2	87	43	5.90
D4542043	4.3	91	47	5.90
D4542044	4.4	91	47	5.90
D4542045	4.5	91	47	5.90
D4542046	4.6	91	47	6.90
D4542047	4.7	91	47	6.90
D4542048	4.8	96	52	6.90
D4542049	4.9	96	52	6.90
D4542050	5.0	96	52	6.90
D4542051	5.1	96	52	6.90
D4542052	5.2	96	52	7.95
D4542053	5.3	96	52	7.95
D4542054	5.4	101	57	7.95
D4542055	5.5	101	57	7.95
D4542056	5.6	101	57	9.20
D4542057	5.7	101	57	9.20
D4542058	5.8	101	57	9.20
D4542059	5.9	101	57	9.20
D4542060	6.0	101	57	9.20
D4542061	6.1	107	63	9.20
D4542062	6.2	107	63	9.20
D4542063	6.3	107	63	9.20
D4542064	6.4	107	63	9.20
D4542065	6.5	107	63	9.20
D4542066	6.6	107	63	9.20
D4542067	6.7	107	63	9.20
D4542068	6.8	113	69	9.20
D4542069	6.9	113	69	9.20
D4542070	7.0	113	69	9.20
D4542071	7.1	113	69	9.95
D4542072	7.2	113	69	9.95
D4542073	7.3	113	69	9.95
D4542074	7.4	113	69	9.95

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High performance

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Superior TIN coating

Reduced deflection + vibration

Long Tool Life

5xD



DRILLS HPD High Performance

HSS Premium Cobalt Jobber Drills

HSS PREMIUM COBALT JOBBER DRILLS SUPERIOR TIN COATING D4542 SERIES



Ordering Code	Dia	Overall Length	Flute Length	2007 £	Ordering Code	Dia	Overall Length	Flute Length	2007 £
D4542075	7.5	113	69	9.95	D4542112	11.2	151	94	21.00
D4542076	7.6	119	75	10.95	D4542113	11.3	151	94	21.00
D4542077	7.7	119	75	10.95	D4542114	11.4	151	94	21.00
D4542078	7.8	119	75	10.95	D4542115	11.5	151	94	21.00
D4542079	7.9	119	75	10.95	D4542116	11.6	151	94	21.00
D4542080	8.0	119	75	10.95	D4542117	11.7	151	94	21.00
D4542081	8.1	125	75	10.95	D4542118	11.8	151	94	21.00
D4542082	8.2	125	75	10.95	D4542119	11.9	158	101	21.00
D4542083	8.3	125	75	10.95	D4542120	12.0	158	101	21.00
D4542084	8.4	125	75	10.95	D4542121	12.1	158	101	24.75
D4542085	8.5	125	75	10.95	D4542122	12.2	158	101	24.75
D4542086	8.6	131	81	10.95	D4542123	12.3	158	101	24.75
D4542087	8.7	131	81	12.50	D4542124	12.4	158	101	24.75
D4542088	8.8	131	81	12.50	D4542125	12.5	158	101	24.75
D4542089	8.9	131	81	12.50	D4542126	12.6	158	101	24.75
D4542090	9.0	131	81	12.50	D4542127	12.7	158	101	24.75
D4542091	9.1	131	81	13.95	D4542128	12.8	158	101	24.75
D4542092	9.2	131	81	13.95	D4542129	12.9	158	101	24.75
D4542093	9.3	131	81	13.95	D4542130	13.0	158	101	24.75
D4542094	9.4	131	81	13.95	D4542135	13.5	150	90	24.75
D4542095	9.5	131	81	13.95	D4542140	14.0	150	90	24.75
D4542096	9.6	137	87	15.94	D4542141	14.1	155	95	33.00
D4542097	9.7	137	87	15.94	D4542145	14.5	155	95	33.00
D4542098	9.8	137	87	15.94	D4542150	15.0	161	95	33.00
D4542099	9.9	137	87	15.94	D4542155	15.5	166	100	39.00
D4542100	10.0	137	87	15.94	D4542156	15.6	166	100	39.00
D4542101	10.1	144	87	15.94	D4542160	16.0	166	100	39.00
D4542102	10.2	144	87	15.94	D4542165	16.5	172	106	45.00
D4542103	10.3	144	87	15.94	D4542170	17.0	172	106	45.00
D4542104	10.4	144	87	15.94	D4542175	17.5	178	112	57.00
D4542105	10.5	144	87	15.94	D4542176	17.6	178	112	57.00
D4542106	10.6	144	87	15.94	D4542180	18.0	178	112	57.00
D4542107	10.7	151	94	15.94	D4542185	18.5	184	118	57.00
D4542108	10.8	151	94	15.94	D4542190	19.0	194	118	57.00
D4542109	10.9	151	94	15.94	D4542195	19.5	201	125	65.00
D4542110	11.0	151	94	15.94	D4542196	19.6	201	125	65.00
D4542111	11.1	151	94	21.00	D4542200	20.0	201	125	65.00



- Same day despatch until 6 pm
- Next day delivery
- 10,000 lines ex-stock
- Pre-discounted prices



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HPD Stub Drills
High Performance



HSS-X High Vanadium Stub Drills

HSS-X HIGH VANADIUM STUB DRILLS
SUPERIOR TIN COATING DJ543 SERIES (STAINLESS)



DRILLS

Ordering Code	Dia	Overall Length	Flute Length	2007 £
DJ543020	2.0	44	12	3.49
DJ543021	2.1	44	12	3.49
DJ543022	2.2	45	13	3.49
DJ543023	2.3	45	13	3.49
DJ543024	2.4	46	14	3.49
DJ543025	2.5	46	14	3.49
DJ543026	2.6	46	14	3.49
DJ543027	2.7	48	16	3.49
DJ543028	2.8	48	16	3.49
DJ543029	2.9	48	16	3.49
DJ543030	3.0	48	16	3.49
DJ543031	3.1	50	18	3.49
DJ543032	3.2	50	18	3.49
DJ543033	3.3	50	18	3.49
DJ543034	3.4	52	20	3.49
DJ543035	3.5	52	20	3.49
DJ543036	3.6	52	20	4.33
DJ543037	3.7	52	20	4.33
DJ543038	3.8	54	22	4.33
DJ543039	3.9	54	22	4.33
DJ543040	4.0	54	22	4.33
DJ543041	4.1	66	22	5.16
DJ543042	4.2	66	22	5.16
DJ543043	4.3	68	24	5.16
DJ543044	4.4	68	24	5.16
DJ543045	4.5	68	24	5.16
DJ543046	4.6	68	24	6.04
DJ543047	4.7	68	24	6.04
DJ543048	4.8	70	26	6.04
DJ543049	4.9	70	26	6.04
DJ543050	5.0	70	26	6.04
DJ543051	5.1	70	26	6.04
DJ543052	5.2	70	26	6.96
DJ543053	5.3	70	26	6.96
DJ543054	5.4	72	28	6.96
DJ543055	5.5	72	28	6.96
DJ543056	5.6	72	28	8.05
DJ543057	5.7	72	28	8.05
DJ543058	5.8	72	28	8.05
DJ543059	5.9	72	28	8.05
DJ543060	6.0	72	28	8.05
DJ543061	6.1	75	31	8.05
DJ543062	6.2	75	31	8.05
DJ543063	6.3	75	31	8.05
DJ543064	6.4	75	31	8.05
DJ543065	6.5	75	31	8.05
DJ543066	6.6	75	31	8.05
DJ543067	6.7	75	31	8.05
DJ543068	6.8	78	34	8.05
DJ543069	6.9	78	34	8.05
DJ543070	7.0	78	34	8.05
DJ543071	7.1	78	34	8.71
DJ543072	7.2	78	34	8.71
DJ543073	7.3	78	34	8.71
DJ543074	7.4	78	34	8.71

Applications

For high performance machining of

- Stainless
- Mild steels
- Aluminium
- Copper

Benefits

- High speeds + feeds
- Long tool life
- Good chip removal
- Wide flutes
- Reinforced web for reduced vibration and deflection
- Up to 300% increased performance, compared to GPD drills

First for stainless

High performance

Reduced deflection + vibration

HSS Vanadium

3xD



DRILLS HPD High Performance



HPD Stub Drills

High Performance



HSS-X High Vanadium Stub Drills

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DJ543075	7.5	78	34	8.71
DJ543076	7.6	81	37	9.58
DJ543077	7.7	81	37	9.58
DJ543078	7.8	81	37	9.58
DJ543079	7.9	81	37	9.58
DJ543080	8.0	81	37	9.58
DJ543081	8.1	87	37	9.58
DJ543082	8.2	87	37	9.58
DJ543083	8.3	87	37	9.58
DJ543084	8.4	87	37	9.58
DJ543085	8.5	87	37	9.58
DJ543086	8.6	90	40	9.58
DJ543087	8.7	90	40	10.94
DJ543088	8.8	90	40	10.94
DJ543089	8.9	90	40	10.94
DJ543090	9.0	90	40	10.94
DJ543091	9.1	90	40	12.21
DJ543092	9.2	90	40	12.21
DJ543093	9.3	90	40	12.21
DJ543094	9.4	90	40	12.21
DJ543095	9.5	90	40	12.21
DJ543096	9.6	93	43	13.95
DJ543097	9.7	93	43	13.95
DJ543098	9.8	93	43	13.95
DJ543099	9.9	93	43	13.95
DJ543100	10.0	93	43	13.95
DJ543101	10.1	100	43	14.51
DJ543102	10.2	100	43	14.51
DJ543103	10.3	100	43	14.51
DJ543104	10.4	100	43	14.51
DJ543105	10.5	100	43	15.89
DJ543106	10.6	100	43	15.89
DJ543107	10.7	104	47	15.89
DJ543108	10.8	104	47	15.89
DJ543109	10.9	104	47	15.89
DJ543110	11.0	104	47	17.00
DJ543111	11.1	104	47	17.00
DJ543112	11.2	104	47	17.00
DJ543113	11.3	104	47	17.00
DJ543114	11.4	104	47	17.00
DJ543115	11.5	104	47	17.00
DJ543116	11.6	104	47	17.00
DJ543117	11.7	104	47	17.00
DJ543118	11.8	104	47	17.00
DJ543119	11.9	108	51	17.00
DJ543120	12.0	108	51	17.00
DJ543121	12.1	108	51	19.00
DJ543122	12.2	108	51	19.00
DJ543123	12.3	108	51	19.00
DJ543124	12.4	108	51	19.00
DJ543125	12.5	108	51	19.00
DJ543126	12.6	108	51	19.00
DJ543127	12.7	108	51	19.00
DJ543128	12.8	108	51	19.00
DJ543129	12.9	108	51	19.00
DJ543130	13.0	108	51	19.00

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DRILLS

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DJ544020	2.0	56	24	3.99
DJ544021	2.1	56	24	3.99
DJ544022	2.2	59	27	3.99
DJ544023	2.3	59	27	3.99
DJ544024	2.4	62	30	3.99
DJ544025	2.5	62	30	3.99
DJ544026	2.6	62	30	3.99
DJ544027	2.7	65	33	3.99
DJ544028	2.8	65	33	3.99
DJ544029	2.9	65	33	3.99
DJ544030	3.0	65	33	3.99
DJ544031	3.1	68	36	3.99
DJ544032	3.2	68	36	3.99
DJ544033	3.3	68	36	3.99
DJ544034	3.4	71	39	3.99
DJ544035	3.5	71	39	3.99
DJ544036	3.6	71	39	4.95
DJ544037	3.7	71	39	4.95
DJ544038	3.8	75	43	4.95
DJ544039	3.9	75	43	4.95
DJ544040	4.0	75	43	4.95
DJ544041	4.1	87	43	5.90
DJ544042	4.2	87	43	5.90
DJ544043	4.3	91	47	5.90
DJ544044	4.4	91	47	5.90
DJ544045	4.5	91	47	5.90
DJ544046	4.6	91	47	6.90
DJ544047	4.7	91	47	6.90
DJ544048	4.8	96	52	6.90
DJ544049	4.9	96	52	6.90
DJ544050	5.0	96	52	6.90
DJ544051	5.1	96	52	6.90
DJ544052	5.2	96	52	7.95
DJ544053	5.3	96	52	7.95
DJ544054	5.4	101	57	7.95
DJ544055	5.5	101	57	7.95
DJ544056	5.6	101	57	9.20
DJ544057	5.7	101	57	9.20
DJ544058	5.8	101	57	9.20
DJ544059	5.9	101	57	9.20
DJ544060	6.0	101	57	9.20
DJ544061	6.1	107	63	9.20
DJ544062	6.2	107	63	9.20
DJ544063	6.3	107	63	9.20
DJ544064	6.4	107	63	9.20
DJ544065	6.5	107	63	9.20
DJ544066	6.6	107	63	9.20
DJ544067	6.7	107	63	9.20
DJ544068	6.8	113	69	9.20
DJ544069	6.9	113	69	9.20
DJ544070	7.0	113	69	9.20

Applications

For high performance machining of

- Stainless
- Mild steels
- Aluminium
- Copper

Benefits

- High speeds + feeds
- Long tool life
- Good chip removal
- Wide flutes
- Reinforced web for reduced vibration and deflection
- Up to 300% increased performance, compared to GPD drills

First for stainless

High performance

Reduced deflection + vibration

HSS Vanadium

5xD



UP TO 4mm

OVER 4mm

DRILLS HPD High Performance



HPD Jobber Drills High Performance



HSS-X High Vanadium Jobber Drills

HSS-X HIGH VANADIUM JOBBER DRILLS
SUPERIOR TIN COATING DJ544 SERIES (STAINLESS)



Ordering Code	Dia	Overall Length	Flute Length	2007 £
DJ544071	7.1	113	69	9.95
DJ544072	7.2	113	69	9.95
DJ544073	7.3	113	69	9.95
DJ544074	7.4	113	69	9.95
DJ544075	7.5	113	69	9.95
DJ544076	7.6	119	75	10.95
DJ544077	7.7	119	75	10.95
DJ544078	7.8	119	75	10.95
DJ544079	7.9	119	75	10.95
DJ544080	8.0	119	75	10.95
DJ544081	8.1	125	75	10.95
DJ544082	8.2	125	75	10.95
DJ544083	8.3	125	75	10.95
DJ544084	8.4	125	75	10.95
DJ544085	8.5	125	75	10.95
DJ544086	8.6	131	81	10.95
DJ544087	8.7	131	81	12.50
DJ544088	8.8	131	81	12.50
DJ544089	8.9	131	81	12.50
DJ544090	9.0	131	81	12.50
DJ544091	9.1	131	81	13.95
DJ544092	9.2	131	81	13.95
DJ544093	9.3	131	81	13.95
DJ544094	9.4	131	81	13.95
DJ544095	9.5	131	81	13.95
DJ544096	9.6	137	87	15.94
DJ544097	9.7	137	87	15.94
DJ544098	9.8	137	87	15.94
DJ544099	9.9	137	87	15.94
DJ544100	10.0	137	87	15.94
DJ544101	10.1	144	87	15.94
DJ544102	10.2	144	87	15.94
DJ544103	10.3	144	87	15.94
DJ544104	10.4	144	87	15.94
DJ544105	10.5	144	87	15.94
DJ544106	10.6	144	87	15.94
DJ544107	10.7	151	94	15.94
DJ544108	10.8	151	94	15.94
DJ544109	10.9	151	94	15.94
DJ544110	11.0	151	94	15.94
DJ544115	11.5	151	94	17.50
DJ544120	12.0	158	101	17.50
DJ544125	12.5	158	101	19.50
DJ544130	13.0	158	101	22.00
DJ544135	13.5	166	106	23.00
DJ544140	14.0	166	106	25.00

Applications

For high performance machining of

- Stainless
- Mild steels
- Aluminium
- Copper

Benefits

- High speeds + feeds
- Long tool life
- Good chip removal
- Wide flutes
- Reinforced web for reduced vibration and deflection
- Up to 300% increased performance, compared to GPD drills

First for stainless

Good chip removal

Reinforced web

Wide flutes

Superior TIN coating



5xD

HSS-EX



UP TO 4mm OVER 4mm



DRILLS

DRILLS HPD High Performance



Premium Cobalt HSS, HPD Twist Drills, TiN Coated, D4541/D4542 Series

Please decrease the feed rate in D4542 series HPD drills

DRILLS

Work Material	Carbon Steels (S45C-S50C)		Alloy Steels (SCM-SNC-SNCM)		Tool Steels Alloy Steels (SKD11)		Cast Iron Tool Steel		Aluminium Alloy Magnesium Alloy	
	~ 700 N/mm ²		700 ~ 900 N/mm ²		900 ~ 1100 N/mm ²					
Strength										
Diameter (mm)	N	S	N	S	N	S	N	S	N	S
	2	4200	0.08	3600	0.08	1750	0.08	5800	0.11	10500
3	2900	0.13	2500	0.13	1170	0.13	4000	0.14	10500	0.25
4	2100	0.14	1900	0.14	880	0.14	3000	0.17	8000	0.30
5	1700	0.16	1500	0.16	700	0.16	2400	0.20	6500	0.36
6	1300	0.17	1300	0.17	580	0.17	2100	0.23	5200	0.42
8	1000	0.21	950	0.21	440	0.21	1500	0.26	4200	0.47
10	850	0.25	750	0.25	350	0.25	1100	0.32	3400	0.56
12	700	0.30	650	0.30	290	0.30	1000	0.38	2700	0.67
14	550	0.35	500	0.35	250	0.35	850	0.40	2400	0.72
16	520	0.38	470	0.38	220	0.38	750	0.42	2100	0.77
18	450	0.44	420	0.44	195	0.44	700	0.45	1900	0.80
20	400	0.45	350	0.45	175	0.45	600	0.51	1600	0.87
22	370	0.50	340	0.50	160	0.50	550	0.52	1500	0.95
24	350	0.54	300	0.54	145	0.54	500	0.58	1400	1.00
26	320	0.58	280	0.58	135	0.58	450	0.60	1300	1.05
28	300	0.62	260	0.62	125	0.62	420	0.63	1200	1.10
30	280	0.66	240	0.66	115	0.66	400	0.74	1100	1.15
32	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)

DRILLS HPD High Performance

- Same day despatch until 6 pm
- Next day delivery
- 10,000 lines ex-stock
- Pre-discounted prices



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HPD Drills

Recommended Cutting Conditions



HSS-EX, HPD-SUS Twist Drills, TiN Coated, DJ543/DJ544 Series

Please decrease the feed rate in DJ544 series HPD-SUS drills

Work Material	Stainless Steels (SUS304, 200)		Stainless Steels (SUS420, 440)		Aluminium + Aluminium Alloy		Plastics, Copper + Copper Alloys		Mild Steels + Low Carbon Steels	
	N	S	N	S	N	S	N	S	N	S
2	2600	0.07	3100	0.07	11000	0.09	5600	0.06	6300	0.08
3	1800	0.08	2100	0.08	7350	0.13	3750	0.08	4200	0.13
4	1300	0.10	1600	0.10	7050	0.18	2800	0.10	3200	0.14
5	1050	0.14	1250	0.15	5500	0.22	2250	0.13	2500	0.16
6	900	0.17	1050	0.18	4600	0.26	1850	0.15	2100	0.18
8	650	0.22	800	0.24	3500	0.34	1350	0.20	1550	0.22
10	550	0.26	630	0.30	2800	0.40	1100	0.25	1250	0.26
12	450	0.33	530	0.36	2300	0.50	950	0.30	1050	0.32
14	400	0.36	450	0.44	2050	0.55	800	0.33	900	0.36
16	350	0.40	390	0.48	1750	0.62	700	0.35	790	0.40
18	300	0.43	350	0.50	1600	0.70	620	0.40	700	0.45
20	260	0.46	320	0.53	1450	0.75	560	0.40	620	0.47

N = R.P.M.

S = Feed per revolution (mm/rev)

DRILLS

DRILLS HPD High Performance

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our website?
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