



HSD		mm		
Type Specification	D1(Diameter of Cut)	L3(Flute Length)	L1(Overall Length)	D4(Shank Diameter)
HSD0250	2.5	20	55	2.5
HSD0260	2.6	20	55	2.6
HSD0270	2.7	20	55	2.7
HSD0280	2.8	21	60	2.8
HSD0290	2.9	21	60	2.9
HSD0300	3.0	21	60	3.0
HSD0310	3.1	24	60	3.1
HSD0320	3.2	24	60	3.2
HSD0330	3.3	24	60	3.3
HSD0340	3.4	24	60	3.4
HSD0350	3.5	24	60	3.5
HSD0360	3.6	27	60	3.6
HSD0370	3.7	27	60	3.7
HSD0380	3.8	27	60	3.8
HSD0390	3.9	27	60	3.9
HSD0400	4.0	27	60	4.0
HSD0410	4.1	29	63	4.1
HSD0420	4.2	29	63	4.2
HSD0430	4.3	29	63	4.3
HSD0440	4.4	29	63	4.4
HSD0450	4.5	29	63	4.5
HSD0460	4.6	32	68	4.6
HSD0470	4.7	32	68	4.7
HSD0480	4.8	32	68	4.8
HSD0490	4.9	32	68	4.9
HSD0500	5.0	32	68	5.0
HSD0510	5.1	34	72	5.1
HSD0520	5.2	34	72	5.2
HSD0530	5.3	34	72	5.3
HSD0540	5.4	34	72	5.4
HSD0550	5.5	34	72	5.5
HSD0560	5.6	36	74	5.6
HSD0570	5.7	36	74	5.7
HSD0580	5.8	36	74	5.8
HSD0590	5.9	36	74	5.9
HSD0600	6.0	41	81	6.0
HSD0650	6.5	41	81	6.5
HSD0690	6.9	43	83	6.9
HSD0700	7.0	43	83	7.0
HSD0750	7.5	45	87	7.5
HSD0800	8.0	48	90	8.0
HSD0850	8.5	53	96	8.5
HSD0860	8.6	55	98	8.6
HSD0900	9.0	55	98	9.0
HSD0950	9.5	58	102	9.5
HSD1000	10.0	60	105	10.0
HSD1040	10.4	66	112	10.4
HSD1050	10.5	66	112	10.5
HSD1100	11.0	68	114	11.0
HSD1150	11.5	71	118	11.5
HSD1200	12.0	73	121	12.0
HSD1250	12.5	76	135	12.5
HSD1300	13.0	78	137	13.0
HSD1350	13.5	84	144	13.5
HSD1400	14.0	86	147	14.0
HSD1450	14.5	89	151	14.5
HSD1500	15.0	91	153	15.0
HSD1550	15.5	94	157	15.5
HSD1600	16.0	96	160	16.0

RECOMMENDED CUTTING PARAMETERS FOR DRILLING TOOL

Processed Material	Quenched Steel (HRC50-55)		Quenched Steel, Powder High Speed Steel, etc (HRC55-60)	
	Rotational Speed (min-1)	Feed Quantity (Min.-max.) (mm/rev)	Rotational Speed (min-1)	Feed Quantity (Min.-max.) (mm/rev)
2.5	1900	0.06	1300	0.04
3.0	1600	0.06	1100	0.04
4.0	1200	0.06	800	0.04
5.0	1000	0.06	600	0.04
6.0	800	0.06	530	0.04
8.0	600	0.07	400	0.05
10.0	480	0.07	320	0.05
12.0	400	0.07	270	0.05
14.0	340	0.07	230	0.05
16.0	300	0.07	200	0.05