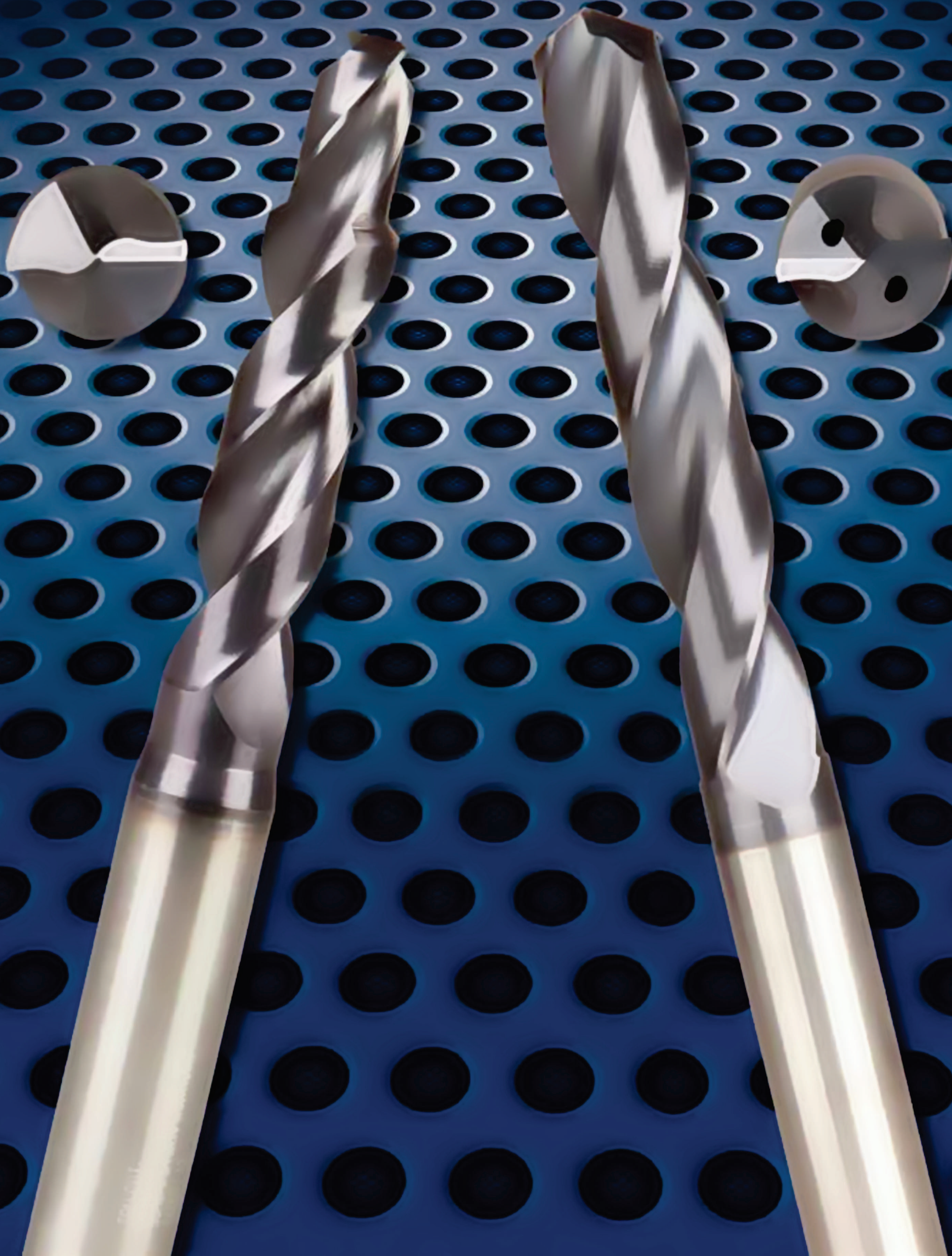


# SOLID CARBIDE DRILL

**TRU CUT**<sup>®</sup>  
QUALITY CUTTING TOOLS

**HYPERLine**<sup>®</sup>  
Hi-Feed Drilling 







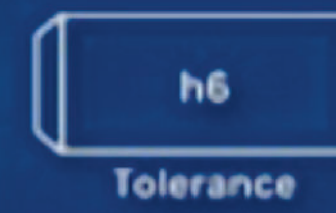
STANDARD

AS PER  
DIN  
6537

TOLERANCE



SHANK



POINT



HELIX



| Item Code<br>3 L/D | Drill Dia | Cutting Length | Overall Length | Shank Dia |
|--------------------|-----------|----------------|----------------|-----------|
| 203-0300           | 3.0       | 20             | 62             | 6         |
| 203-0320           | 3.2       | 20             | 62             | 6         |
| 203-0330           | 3.3       | 20             | 62             | 6         |
| 203-0350           | 3.5       | 20             | 62             | 6         |
| 203-0380           | 3.8       | 24             | 66             | 6         |
| 203-0400           | 4.0       | 24             | 66             | 6         |
| 203-0420           | 4.2       | 24             | 66             | 6         |
| 203-0450           | 4.5       | 24             | 66             | 6         |
| 203-0480           | 4.8       | 28             | 66             | 6         |
| 203-0500           | 5.0       | 28             | 66             | 6         |
| 203-0520           | 5.2       | 28             | 66             | 6         |
| 203-0550           | 5.5       | 28             | 66             | 6         |
| 203-0580           | 5.8       | 28             | 66             | 6         |
| 203-0600           | 6.0       | 28             | 66             | 6         |
| 203-0620           | 6.2       | 34             | 79             | 8         |
| 203-0650           | 6.5       | 34             | 79             | 8         |
| 203-0680           | 6.8       | 34             | 79             | 8         |
| 203-0700           | 7.0       | 34             | 79             | 8         |
| 203-0720           | 7.2       | 41             | 79             | 8         |
| 203-0750           | 7.5       | 41             | 79             | 8         |
| 203-0780           | 7.8       | 41             | 79             | 8         |
| 203-0800           | 8.0       | 41             | 79             | 8         |
| 203-0820           | 8.2       | 47             | 89             | 10        |
| 203-0830           | 8.3       | 47             | 89             | 10        |
| 203-0850           | 8.5       | 47             | 89             | 10        |
| 203-0880           | 8.8       | 47             | 89             | 10        |
| 203-0900           | 9.0       | 47             | 89             | 10        |
| 203-0920           | 9.2       | 47             | 89             | 10        |
| 203-0950           | 9.5       | 47             | 89             | 10        |
| 203-0980           | 9.8       | 47             | 89             | 10        |
| 203-1000           | 10.0      | 47             | 89             | 10        |
| 203-1020           | 10.2      | 55             | 102            | 12        |
| 203-1030           | 10.3      | 55             | 102            | 12        |
| 203-1050           | 10.5      | 55             | 102            | 12        |
| 203-1080           | 10.8      | 55             | 102            | 12        |
| 203-1100           | 11.0      | 55             | 102            | 12        |
| 203-1120           | 11.2      | 55             | 102            | 12        |
| 203-1130           | 11.3      | 55             | 102            | 12        |
| 203-1150           | 11.5      | 55             | 102            | 12        |
| 203-1180           | 11.8      | 55             | 102            | 12        |
| 203-1200           | 12.0      | 55             | 102            | 12        |
| 203-1250           | 12.5      | 60             | 107            | 14        |
| 203-1270           | 12.7      | 60             | 107            | 14        |
| 203-1280           | 12.8      | 60             | 107            | 14        |
| 203-1300           | 13.0      | 60             | 107            | 14        |
| 203-1320           | 13.2      | 60             | 107            | 14        |
| 203-1350           | 13.5      | 60             | 107            | 14        |
| 203-1380           | 13.8      | 60             | 107            | 14        |
| 203-1400           | 14.0      | 60             | 107            | 14        |
| 203-1450           | 14.5      | 65             | 115            | 16        |
| 203-1500           | 15.0      | 65             | 115            | 16        |
| 203-1550           | 15.5      | 65             | 115            | 16        |
| 203-1600           | 16.0      | 65             | 115            | 16        |
| 203-1650           | 16.5      | 73             | 123            | 18        |
| 203-1700           | 17.0      | 73             | 123            | 18        |
| 203-1750           | 17.5      | 73             | 123            | 18        |
| 203-1800           | 18.0      | 73             | 123            | 18        |
| 203-1850           | 18.5      | 79             | 131            | 20        |
| 203-1900           | 19.0      | 79             | 131            | 20        |
| 203-1950           | 19.5      | 79             | 131            | 20        |
| 203-2000           | 20.0      | 79             | 131            | 20        |

| Item Code<br>5 L/D | Drill Dia | Cutting Length | Overall Length | Shank Dia |
|--------------------|-----------|----------------|----------------|-----------|
| 205-0300           | 3.0       | 28             | 66             | 6         |
| 205-0320           | 3.2       | 28             | 66             | 6         |
| 205-0330           | 3.3       | 28             | 66             | 6         |
| 205-0350           | 3.5       | 28             | 66             | 6         |
| 205-0380           | 3.8       | 36             | 74             | 6         |
| 205-0400           | 4.0       | 36             | 74             | 6         |
| 205-0420           | 4.2       | 36             | 74             | 6         |
| 205-0450           | 4.5       | 36             | 74             | 6         |
| 205-0480           | 4.8       | 44             | 82             | 6         |
| 205-0500           | 5.0       | 44             | 82             | 6         |
| 205-0520           | 5.2       | 44             | 82             | 6         |
| 205-0550           | 5.5       | 44             | 82             | 6         |
| 205-0580           | 5.8       | 44             | 82             | 6         |
| 205-0600           | 6.0       | 44             | 82             | 6         |
| 205-0620           | 6.2       | 53             | 91             | 8         |
| 205-0650           | 6.5       | 53             | 91             | 8         |
| 205-0680           | 6.8       | 53             | 91             | 8         |
| 205-0700           | 7.0       | 53             | 91             | 8         |
| 205-0720           | 7.2       | 53             | 91             | 8         |
| 205-0750           | 7.5       | 53             | 91             | 8         |
| 205-0780           | 7.8       | 53             | 91             | 8         |
| 205-0800           | 8.0       | 53             | 91             | 8         |
| 205-0820           | 8.2       | 61             | 103            | 10        |
| 205-0830           | 8.3       | 61             | 103            | 10        |
| 205-0850           | 8.5       | 61             | 103            | 10        |
| 205-0880           | 8.8       | 61             | 103            | 10        |
| 205-0900           | 9.0       | 61             | 103            | 10        |
| 205-0920           | 9.2       | 61             | 103            | 10        |
| 205-0950           | 9.5       | 61             | 103            | 10        |
| 205-0980           | 9.8       | 61             | 103            | 10        |
| 205-1000           | 10.0      | 61             | 103            | 10        |
| 205-1020           | 10.2      | 71             | 118            | 12        |
| 205-1030           | 10.3      | 71             | 118            | 12        |
| 205-1050           | 10.5      | 71             | 118            | 12        |
| 205-1080           | 10.8      | 71             | 118            | 12        |
| 205-1100           | 11.0      | 71             | 118            | 12        |
| 205-1120           | 11.2      | 71             | 118            | 12        |
| 205-1130           | 11.3      | 71             | 118            | 12        |
| 205-1150           | 11.5      | 71             | 118            | 12        |
| 205-1180           | 11.8      | 71             | 118            | 12        |
| 205-1200           | 12.0      | 71             | 118            | 12        |
| 205-1250           | 12.5      | 77             | 124            | 14        |
| 205-1270           | 12.7      | 77             | 124            | 14        |
| 205-1280           | 12.8      | 77             | 124            | 14        |
| 205-1300           | 13.0      | 77             | 124            | 14        |
| 205-1320           | 13.2      | 77             | 124            | 14        |
| 205-1350           | 13.5      | 77             | 124            | 14        |
| 205-1380           | 13.8      | 77             | 124            | 14        |
| 205-1400           | 14.0      | 77             | 124            | 14        |
| 205-1450           | 14.5      | 83             | 133            | 16        |
| 205-1500           | 15.0      | 83             | 133            | 16        |
| 205-1550           | 15.5      | 83             | 133            | 16        |
| 205-1600           | 16.0      | 83             | 133            | 16        |
| 205-1650           | 16.5      | 93             | 143            | 18        |
| 205-1700           | 17.0      | 93             | 143            | 18        |
| 205-1750           | 17.5      | 93             | 143            | 18        |
| 205-1800           | 18.0      | 93             | 143            | 18        |
| 205-1850           | 18.5      | 101            | 153            | 20        |
| 205-1900           | 19.0      | 101            | 153            | 20        |
| 205-1950           | 19.5      | 101            | 153            | 20        |
| 205-2000           | 20.0      | 101            | 153            | 20        |

| Item Code<br>7 L/D | Drill Dia | Cutting Length | Overall Length | Shank Dia |
|--------------------|-----------|----------------|----------------|-----------|
| 207-0500           | 5.0       | 50             | 90             | 6         |
| 207-0520           | 5.1       | 50             | 90             | 6         |
| 207-0550           | 5.5       | 57             | 97             | 6         |
| 207-0580           | 5.8       | 57             | 97             | 6         |
| 207-0600           | 6.0       | 57             | 97             | 6         |
| 207-0620           | 6.2       | 66             | 106            | 8         |
| 207-0650           | 6.5       | 66             | 106            | 8         |
| 207-0680           | 6.8       | 66             | 106            | 8         |
| 207-0700           | 7.0       | 76             | 116            | 8         |
| 207-0720           | 7.2       | 76             | 116            | 8         |
| 207-0750           | 7.5       | 76             | 116            | 8         |
| 207-0780           | 7.8       | 76             | 116            | 8         |
| 207-0800           | 8.0       | 76             | 116            | 8         |
| 207-0820           | 8.2       | 87             | 131            | 10        |
| 207-0850           | 8.5       | 87             | 131            | 10        |
| 207-0880           | 8.8       | 87             | 131            | 10        |
| 207-0900           | 9.0       | 87             | 131            | 10        |
| 207-0920           | 9.2       | 95             | 139            | 10        |
| 207-0950           | 9.5       | 95             | 139            | 10        |
| 207-0980           | 9.8       | 95             | 139            | 10        |
| 207-1000           | 10.0      | 95             | 139            | 10        |
| 207-1020           | 10.2      | 106            | 155            | 12        |
| 207-1050           | 10.5      | 106            | 155            | 12        |
| 207-1080           | 10.8      | 106            | 155            | 12        |
| 207-1100           | 11.0      | 106            | 155            | 12        |
| 207-1120           | 11.2      | 114            | 163            | 12        |
| 207-1150           | 11.5      | 114            | 163            | 12        |
| 207-1180           | 11.8      | 114            | 163            | 12        |
| 207-1200           | 12.0      | 114            | 163            | 12        |
| 207-1250           | 12.5      | 133            | 182            | 14        |
| 207-1270           | 12.7      | 133            | 182            | 14        |
| 207-1280           | 12.8      | 133            | 182            | 14        |
| 207-1300           | 13.0      | 133            | 182            | 14        |
| 207-1350           | 13.5      | 133            | 182            | 14        |
| 207-1400           | 14.0      | 133            | 182            | 14        |
| 207-1450           | 14.5      | 152            | 204            | 16        |
| 207-1500           | 15.0      | 152            | 204            | 16        |
| 207-1550           | 15.5      | 152            | 204            | 16        |
| 207-1600           | 16.0      | 152            | 204            | 16        |
| 207-1650           | 16.5      | 171            | 223            | 18        |
| 207-1700           | 17.0      | 171            | 223            | 18        |
| 207-1750           | 17.5      | 171            | 223            | 18        |
| 207-1800           | 18.0      | 171            | 223            | 18        |
| 207-1850           | 18.5      | 190            | 244            | 20        |
| 207-1900           | 19.0      | 190            | 244            | 20        |
| 207-1950           | 19.5      | 190            | 244            | 20        |
| 207-2000           | 20.0      | 190            | 244            | 20        |



STANDARD

AS PER  
DIN  
6537

TOLERANCE



SHANK

h6  
Tolerance

POINT



HELIX


**TRU CUT**<sup>®</sup>  
 QUALITY CUTTING TOOLS




| Item Code<br>3 L/D | Drill<br>Dia | Cutting<br>Length | Overall<br>Length | Shank<br>Dia | Item Code<br>5 L/D | Drill<br>Dia | Cutting<br>Length | Overall<br>Length | Shank<br>Dia | Item Code<br>7 L/D | Drill<br>Dia | Cutting<br>Length | Overall<br>Length | Shank<br>Dia |
|--------------------|--------------|-------------------|-------------------|--------------|--------------------|--------------|-------------------|-------------------|--------------|--------------------|--------------|-------------------|-------------------|--------------|
| 203 TC-0300        | 3.0          | 20                | 62                | 6            | 205 TC-0300        | 3.0          | 28                | 66                | 6            | 207 TC-0500        | 5.0          | 50                | 90                | 6            |
| 203 TC-0320        | 3.2          | 20                | 62                | 6            | 205 TC-0320        | 3.2          | 28                | 66                | 6            | 207 TC-0520        | 5.1          | 50                | 90                | 6            |
| 203 TC-0330        | 3.3          | 20                | 62                | 6            | 205 TC-0330        | 3.3          | 28                | 66                | 6            | 207 TC-0550        | 5.5          | 57                | 97                | 6            |
| 203 TC-0350        | 3.5          | 20                | 62                | 6            | 205 TC-0350        | 3.5          | 28                | 66                | 6            | 207 TC-0580        | 5.8          | 57                | 97                | 6            |
| 203 TC-0380        | 3.8          | 24                | 66                | 6            | 205 TC-0380        | 3.8          | 36                | 74                | 6            | 207 TC-0600        | 6.0          | 57                | 97                | 6            |
| 203 TC-0400        | 4.0          | 24                | 66                | 6            | 205 TC-0400        | 4.0          | 36                | 74                | 6            | 207 TC-0620        | 6.2          | 66                | 106               | 8            |
| 203 TC-0420        | 4.2          | 24                | 66                | 6            | 205 TC-0420        | 4.2          | 36                | 74                | 6            | 207 TC-0650        | 6.5          | 66                | 106               | 8            |
| 203 TC-0450        | 4.5          | 24                | 66                | 6            | 205 TC-0450        | 4.5          | 36                | 74                | 6            | 207 TC-0680        | 6.8          | 66                | 106               | 8            |
| 203 TC-0480        | 4.8          | 28                | 66                | 6            | 205 TC-0480        | 4.8          | 44                | 82                | 6            | 207 TC-0700        | 7.0          | 76                | 116               | 8            |
| 203 TC-0500        | 5.0          | 28                | 66                | 6            | 205 TC-0500        | 5.0          | 44                | 82                | 6            | 207 TC-0720        | 7.2          | 76                | 116               | 8            |
| 203 TC-0520        | 5.2          | 28                | 66                | 6            | 205 TC-0520        | 5.2          | 44                | 82                | 6            | 207 TC-0750        | 7.5          | 76                | 116               | 8            |
| 203 TC-0550        | 5.5          | 28                | 66                | 6            | 205 TC-0550        | 5.5          | 44                | 82                | 6            | 207 TC-0780        | 7.8          | 76                | 116               | 8            |
| 203 TC-0580        | 5.8          | 28                | 66                | 6            | 205 TC-0580        | 5.8          | 44                | 82                | 6            | 207 TC-0800        | 8.0          | 76                | 116               | 8            |
| 203 TC-0600        | 6.0          | 28                | 66                | 6            | 205 TC-0600        | 6.0          | 44                | 82                | 6            | 207 TC-0820        | 8.2          | 87                | 131               | 10           |
| 203 TC-0620        | 6.2          | 34                | 79                | 8            | 205 TC-0620        | 6.2          | 53                | 91                | 8            | 207 TC-0850        | 8.5          | 87                | 131               | 10           |
| 203 TC-0650        | 6.5          | 34                | 79                | 8            | 205 TC-0650        | 6.5          | 53                | 91                | 8            | 207 TC-0880        | 8.8          | 87                | 131               | 10           |
| 203 TC-0680        | 6.8          | 34                | 79                | 8            | 205 TC-0680        | 6.8          | 53                | 91                | 8            | 207 TC-0900        | 9.0          | 87                | 131               | 10           |
| 203 TC-0700        | 7.0          | 34                | 79                | 8            | 205 TC-0700        | 7.0          | 53                | 91                | 8            | 207 TC-0920        | 9.2          | 95                | 139               | 10           |
| 203 TC-0720        | 7.2          | 41                | 79                | 8            | 205 TC-0720        | 7.2          | 53                | 91                | 8            | 207 TC-0950        | 9.5          | 95                | 139               | 10           |
| 203 TC-0750        | 7.5          | 41                | 79                | 8            | 205 TC-0750        | 7.5          | 53                | 91                | 8            | 207 TC-0980        | 9.8          | 95                | 139               | 10           |
| 203 TC-0780        | 7.8          | 41                | 79                | 8            | 205 TC-0780        | 7.8          | 53                | 91                | 8            | 207 TC-1000        | 10.0         | 95                | 139               | 10           |
| 203 TC-0800        | 8.0          | 41                | 79                | 8            | 205 TC-0800        | 8.0          | 53                | 91                | 8            | 207 TC-1020        | 10.2         | 106               | 155               | 12           |
| 203 TC-0820        | 8.2          | 47                | 89                | 10           | 205 TC-0820        | 8.2          | 61                | 103               | 10           | 207 TC-1050        | 10.5         | 106               | 155               | 12           |
| 203 TC-0830        | 8.3          | 47                | 89                | 10           | 205 TC-0830        | 8.3          | 61                | 103               | 10           | 207 TC-1080        | 10.8         | 106               | 155               | 12           |
| 203 TC-0850        | 8.5          | 47                | 89                | 10           | 205 TC-0850        | 8.5          | 61                | 103               | 10           | 207 TC-1100        | 11.0         | 106               | 155               | 12           |
| 203 TC-0880        | 8.8          | 47                | 89                | 10           | 205 TC-0880        | 8.8          | 61                | 103               | 10           | 207 TC-1120        | 11.2         | 114               | 163               | 12           |
| 203 TC-0900        | 9.0          | 47                | 89                | 10           | 205 TC-0900        | 9.0          | 61                | 103               | 10           | 207 TC-1150        | 11.5         | 114               | 163               | 12           |
| 203 TC-0920        | 9.2          | 47                | 89                | 10           | 205 TC-0920        | 9.2          | 61                | 103               | 10           | 207 TC-1180        | 11.8         | 114               | 163               | 12           |
| 203 TC-0950        | 9.5          | 47                | 89                | 10           | 205 TC-0950        | 9.5          | 61                | 103               | 10           | 207 TC-1200        | 12.0         | 114               | 163               | 12           |
| 203 TC-0980        | 9.8          | 47                | 89                | 10           | 205 TC-0980        | 9.8          | 61                | 103               | 10           | 207 TC-1250        | 12.5         | 133               | 182               | 14           |
| 203 TC-1000        | 10.0         | 47                | 89                | 10           | 205 TC-1000        | 10.0         | 61                | 103               | 10           | 207 TC-1270        | 12.7         | 133               | 182               | 14           |
| 203 TC-1020        | 10.2         | 55                | 102               | 12           | 205 TC-1020        | 10.2         | 71                | 118               | 12           | 207 TC-1280        | 12.8         | 133               | 182               | 14           |
| 203 TC-1030        | 10.3         | 55                | 102               | 12           | 205 TC-1030        | 10.3         | 71                | 118               | 12           | 207 TC-1300        | 13.0         | 133               | 182               | 14           |
| 203 TC-1050        | 10.5         | 55                | 102               | 12           | 205 TC-1050        | 10.5         | 71                | 118               | 12           | 207 TC-1350        | 13.5         | 133               | 182               | 14           |
| 203 TC-1080        | 10.8         | 55                | 102               | 12           | 205 TC-1080        | 10.8         | 71                | 118               | 12           | 207 TC-1400        | 14.0         | 133               | 182               | 14           |
| 203 TC-1100        | 11.0         | 55                | 102               | 12           | 205 TC-1100        | 11.0         | 71                | 118               | 12           | 207 TC-1450        | 14.5         | 152               | 204               | 16           |
| 203 TC-1120        | 11.2         | 55                | 102               | 12           | 205 TC-1120        | 11.2         | 71                | 118               | 12           | 207 TC-1500        | 15.0         | 152               | 204               | 16           |
| 203 TC-1130        | 11.3         | 55                | 102               | 12           | 205 TC-1130        | 11.3         | 71                | 118               | 12           | 207 TC-1550        | 15.5         | 152               | 204               | 16           |
| 203 TC-1150        | 11.5         | 55                | 102               | 12           | 205 TC-1150        | 11.5         | 71                | 118               | 12           | 207 TC-1600        | 16.0         | 152               | 204               | 16           |
| 203 TC-1180        | 11.8         | 55                | 102               | 12           | 205 TC-1180        | 11.8         | 71                | 118               | 12           | 207 TC-1650        | 16.5         | 171               | 223               | 18           |
| 203 TC-1200        | 12.0         | 55                | 102               | 12           | 205 TC-1200        | 12.0         | 71                | 118               | 12           | 207 TC-1700        | 17.0         | 171               | 223               | 18           |
| 203 TC-1250        | 12.5         | 60                | 107               | 14           | 205 TC-1250        | 12.5         | 77                | 124               | 14           | 207 TC-1750        | 17.5         | 171               | 223               | 18           |
| 203 TC-1270        | 12.7         | 60                | 107               | 14           | 205 TC-1270        | 12.7         | 77                | 124               | 14           | 207 TC-1800        | 18.0         | 171               | 223               | 18           |
| 203 TC-1280        | 12.8         | 60                | 107               | 14           | 205 TC-1280        | 12.8         | 77                | 124               | 14           | 207 TC-1850        | 18.5         | 190               | 244               | 20           |
| 203 TC-1300        | 13.0         | 60                | 107               | 14           | 205 TC-1300        | 13.0         | 77                | 124               | 14           | 207 TC-1900        | 19.0         | 190               | 244               | 20           |
| 203 TC-1320        | 13.2         | 60                | 107               | 14           | 205 TC-1320        | 13.2         | 77                | 124               | 14           | 207 TC-1950        | 19.5         | 190               | 244               | 20           |
| 203 TC-1350        | 13.5         | 60                | 107               | 14           | 205 TC-1350        | 13.5         | 77                | 124               | 14           | 207 TC-2000        | 20.0         | 190               | 244               | 20           |
| 203 TC-1380        | 13.8         | 60                | 107               | 14           | 205 TC-1380        | 13.8         | 77                | 124               | 14           |                    |              |                   |                   |              |
| 203 TC-1400        | 14.0         | 60                | 107               | 14           | 205 TC-1400        | 14.0         | 77                | 124               | 14           |                    |              |                   |                   |              |
| 203 TC-1450        | 14.5         | 65                | 115               | 16           | 205 TC-1450        | 14.5         | 83                | 133               | 16           |                    |              |                   |                   |              |
| 203 TC-1500        | 15.0         | 65                | 115               | 16           | 205 TC-1500        | 15.0         | 83                | 133               | 16           |                    |              |                   |                   |              |
| 203 TC-1550        | 15.5         | 65                | 115               | 16           | 205 TC-1550        | 15.5         | 83                | 133               | 16           |                    |              |                   |                   |              |
| 203 TC-1600        | 16.0         | 65                | 115               | 16           | 205 TC-1600        | 16.0         | 83                | 133               | 16           |                    |              |                   |                   |              |
| 203 TC-1650        | 16.5         | 73                | 123               | 18           | 205 TC-1650        | 16.5         | 93                | 143               | 18           |                    |              |                   |                   |              |
| 203 TC-1700        | 17.0         | 73                | 123               | 18           | 205 TC-1700        | 17.0         | 93                | 143               | 18           |                    |              |                   |                   |              |
| 203 TC-1750        | 17.5         | 73                | 123               | 18           | 205 TC-1750        | 17.5         | 93                | 143               | 18           |                    |              |                   |                   |              |
| 203 TC-1800        | 18.0         | 73                | 123               | 18           | 205 TC-1800        | 18.0         | 93                | 143               | 18           |                    |              |                   |                   |              |
| 203 TC-1850        | 18.5         | 79                | 131               | 20           | 205 TC-1850        | 18.5         | 101               | 153               | 20           |                    |              |                   |                   |              |
| 203 TC-1900        | 19.0         | 79                | 131               | 20           | 205 TC-1900        | 19.0         | 101               | 153               | 20           |                    |              |                   |                   |              |
| 203 TC-1950        | 19.5         | 79                | 131               | 20           | 205 TC-1950        | 19.5         | 101               | 153               | 20           |                    |              |                   |                   |              |
| 203 TC-2000        | 20.0         | 79                | 131               | 20           | 205 TC-2000        | 20.0         | 101               | 153               | 20           |                    |              |                   |                   |              |





## Recommended Cutting Condition for Series - 203, 205, 207, 203-TC, 205-TC, 207-TC

| Material                            | Cutting Speed Vc (m / min)               |   | Feed Rate f (mm / rev) with Drill Ø |             |             |             |
|-------------------------------------|--|---|-------------------------------------|-------------|-------------|-------------|
|                                     | Without coolant<br>Hole 203,<br>205, 207 | With Coolant<br>Hole 203Tc,<br>205Tc, 207Tc | Ø 3 - 5                             | Ø 6 - 8     | Ø 10 - 12   | Ø 16 - 20   |
| Carbon & Alloy Steel < Upto 30 HRC  | 110 - 140                                | 140 - 180                                   | 0.100-0.160                         | 0.200-0.240 | 0.260-0.300 | 0.440-0.500 |
| Carbon & Alloy Steel < 38 - 40 HRC  | 70 - 110                                 | 90 - 140                                    | 0.100-0.160                         | 0.200-0.240 | 0.220-0.240 | 0.440-0.500 |
| Alloyed Steel < 48 < 55 HRC         | 20 - 30                                  | 40 - 50                                     | 0.060-0.070                         | 0.080-0.120 | 0.070-0.090 | 0.090-0.100 |
| Stainless Steels - 300 & 400 Series | 60 - 80                                  | 70 - 100                                    | 0.060-0.010                         | 0.080-0.150 | 0.070-0.150 | 0.090-0.150 |
| Cast Iron and Malleable Cast Iron   | 100 - 180                                | 140 - 220                                   | 0.200-0.240                         | 0.260-0.300 | 0.300-0.320 | 0.500-0.600 |
| Titanium Alloys                     | 70 - 90                                  | 90 - 110                                    | 0.080-0.120                         | 0.160-0.200 | 0.240-0.260 | 0.400-0.500 |
| Copper / Brass                      | 140 - 220                                | 180 - 270                                   | 0.160-0.200                         | 0.300-0.400 | 0.560-0.600 | 0.500-0.600 |

 These data are recommended considering Cutting Speed and Feed of 3 L/D  
 Considering Rigid Component Clamping and Drill Holding with Hydrogrip or Power Chuck.  
 Please Multiply with specific correction factor as below.

### Non Through Coolant

| Drilling Depth:   | 1 X D    | 3 X D    | 5 X D    | 7 X D    |
|-------------------|----------|----------|----------|----------|
| Vc & Feed Factor: | 1.2 Time | 1.0 Time | 0.8 Time | 0.6 Time |

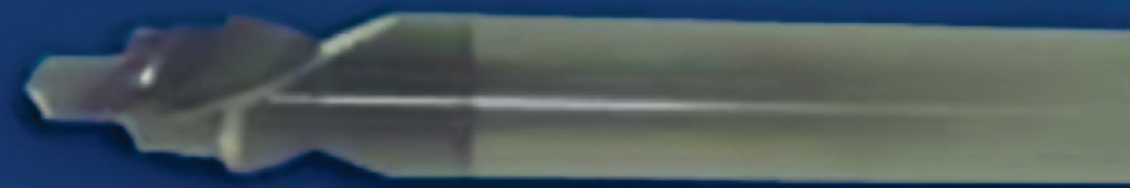
### Internal Coolant

| Drilling Depth:   | 3 X D    | 5 X D  | 7 X D    |
|-------------------|----------|--------|----------|
| Vc & Feed Factor: | 1.2 Time | 1 Time | 0.8 Time |

**SINGLE  
STEP DRILL**  
on Request



**MULTI  
STEP DRILL**  
on Request



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