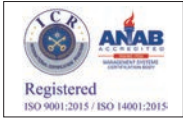


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**SOLID CARBIDE
COMBINATION DRILLS
& COUNTER SINK**

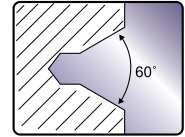
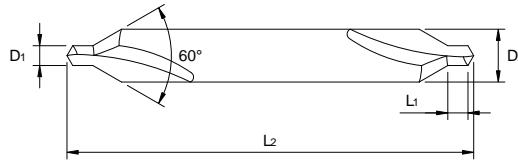


COMBINATION DRILLS & COUNTER SINK

SOLID CARBIDE

Combination Drill & Counter Sink / Center Drill 60°

D5331 SERIES



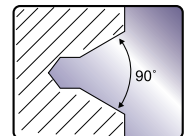
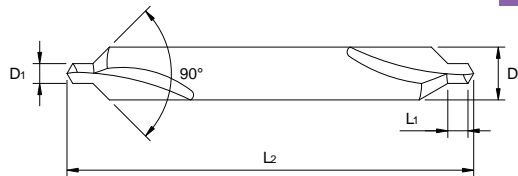
Unit : Inch

EDP No.	SIZE	Diameter		Shank Diameter D ₂	Drill Length L ₁	Overall Length L ₂
		Fractional	Decimal			
		D ₁				
D5331008	#1	3/64	.0468	1/8	3/64	1-1/2
D5331012	#2	5/64	.0781	3/16	5/64	1-7/8
D5331016	#3	7/64	.1094	1/4	7/64	2"
D5331020	#4	1/8	.1250	5/16	1/8	2-1/8
D5331028	#5	3/16	.1875	7/16	3/16	2-3/4
D5331032	#6	7/32	.2188	1/2	7/32	3"
D5331040	#7	1/4	.2500	5/8	1/4	3-3/4
D5331048	#8	5/16	.3125	3/4	5/16	4"

SOLID CARBIDE

Carbide, Combination Drill & Counter Sink / Center Drill 90°

D5332 SERIES



Unit : Inch

EDP No.	SIZE	Diameter		Shank Diameter D ₂	Drill Length L ₁	Overall Length L ₂
		Fractional	Decimal			
		D ₁				
D5332008	#1	3/64	.0468	1/8	3/64	1-1/2
D5332012	#2	5/64	.0781	3/16	5/64	1-7/8
D5332016	#3	7/64	.1094	1/4	7/64	2"
D5332020	#4	1/8	.1250	5/16	1/8	2-1/8
D5332028	#5	3/16	.1875	7/16	3/16	2-3/4
D5332032	#6	7/32	.2188	1/2	7/32	3"
D5332040	#7	1/4	.2500	5/8	1/4	3-3/4
D5332048	#8	5/16	.3125	3/4	5/16	4"

◎ : Excellent ○ : Good

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32		10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎			◎	○					○			◎	○	○		○		
ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34	55	60	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended																					

COMBINATION DRILL & COUNTER SINK

RECOMMENDED CUTTING CONDITIONS

D5331, D5332 SERIES

SOLID CARBIDE, COMBINATION DRILL & COUNTER SINK / CENTER DRILL

SFM = ft/min.
FEED(IPR) = inch/rev.

ISO	VDI 3323	Material Description	SFM	Drill Diameter						
				METRIC	-	-	-	-	-	-
				FRACTIONAL	3/64	5/64	1/8	3/16	1/4	5/16
DECIMAL	.0468	.0781	.1250	.1875	.2500	.3125				
P	1	Non-alloy steel	165	RPM	15920	7960	5310	3200	2650	1990
				FEED	.0008 - .0016	.0012 - .0024	.0016 - .0031	.0024 - .0039	.0028 - .0047	.0035 - .0059
	2		132	RPM	12730	6370	4240	2560	2120	1590
				FEED	.0008 - .0016	.0012 - .0024	.0016 - .0031	.0024 - .0039	.0028 - .0047	.0035 - .0059
	3		99	RPM	9550	4770	3180	1920	1590	1190
FEED		.0004 - .0012		.0004 - .0014	.0004 - .002	.0012 - .0028	.0016 - .0031	.0024 - .0047		
6	132	RPM	12730	6370	4240	2560	2120	1590		
		FEED	.0008 - .0016	.0012 - .0024	.0016 - .0031	.0024 - .0039	.0028 - .0047	.0035 - .0059		
7	99	RPM	9550	4770	3180	1920	1590	1190		
		FEED	.0004 - .0012	.0004 - .0014	.0004 - .002	.0012 - .0028	.0016 - .0031	.0024 - .0047		
M	12	Stainless steel	66	RPM	6370	3180	2120	1280	1060	800
				FEED	.0004 - .0012	.0004 - .0014	.0004 - .002	.0012 - .0028	.0016 - .0031	.0024 - .0047
K	15	Grey cast iron	197	RPM	19100	9550	6370	3820	3180	2390
				FEED	.0008 - .0016	.0012 - .0024	.0016 - .0031	.0024 - .0039	.0028 - .0047	.0035 - .0059
	16		165	RPM	15920	7960	5310	3202	2650	1990
				FEED	.0004 - .0012	.0004 - .0014	.0004 - .002	.0012 - .0028	.0016 - .0031	.0024 - .0047
17	197	RPM	19100	9550	6370	3820	3180	2390		
		FEED	.0008 - .0016	.0012 - .0024	.0016 - .0031	.0024 - .0039	.0028 - .0047	.0035 - .0059		
19	132	RPM	12730	6370	4240	2560	2120	1590		
		FEED	.0008 - .0016	.0012 - .0024	.0016 - .0031	.0024 - .0039	.0028 - .0047	.0035 - .0059		

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