SOLID ROUND TOOLS

ONE-STOP MACHINING SOLUTION

Solid Round Tools
One-Stop Machining Solution



High-Performance Solid Carbide Drill

One-Stop Service

Customized Solution

Sandvik Coromant Technical Support

Suzhou Yongpu Precision Technology Co., Ltd.

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YONGPUPRECISION

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ABOUT US

SOLID ROUND TOOLS
ONE-STOP MACHINING SOLUTION

One-Stop Service

Customized Solution

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Suzhou Yongpu Precision Technology Co., Ltd. (“Yongpu Precision”) was founded in 2013. Headquartered in Wujiang Economic Development Zone, Suzhou, we operate two major manufacturing bases in Suzhou and Chuzhou, alongside three production and reconditioning centers in Wuhan, Chengdu and Zhuzhou.

Yongpu Precision specializes in the R&D, production and service of solid round tools. Backed by technical support from the Sandvik Group, we deliver full industrial chain customization covering rod stock, cutting tools and coatings.

We always adhere to our mission: “Solve customers’ machining challenges through technological innovation and help customers improve efficiency and reduce costs with high-quality products.”

We embed our core values — Integrity, Collaboration, Professionalism, and Enterprise — across all business operations. Yongpu Precision strives to deliver efficient, reliable one-stop solid round tool solutions for global industries, continuously empowering the metalworking sector with professional expertise.



Versatile Solution

Customized Solution

ISO Workpiece Materials

P K M H



YPP Drill® SFP

INTRODUCTION

High-Performance Solid Carbide Drill

Overview & Applications

- Solutions for general machining, D&M, auto and power generation etc.
- Hole tolerance H8–H9
- Diameter range: 3.0–20.0 mm
- Drill length above 8xDC

Features & Benefits

- Cover both stable and unstable cutting conditions
- Provide both internal & external coolant solutions
- Curve cutting edge generates low cutting force
- Good centering performance thanks to unique design on central cutting edge
- Good chips evacuation thanks to chips flute optimization design
- Extra fine grain size substrate together with multi layers PVD coating generates long tool life

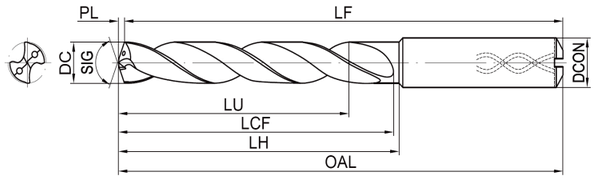
Ordering Code

S	F	P	2	03	N	—	0900	—	10A	—	01DH
↓	↓	↓	↓	↓	↓		↓		↓		↓
S – Product Family	F – Cutting Edge Type	P – P- Material Group	2 – 2 Cutting Edge	03 – 3xDC	N – Internal Coolant		0900 – Drill Diameter 0900–DC9mm		10 – Shank Diameter A – HA Cylindrical Shank		01 – Substrate AK40 DH – Coating

YPP Drill® SFP

High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-0300-04-01RA-H	3	9.5	20	62	61.5	0.5	4	3
SFP205N-0300-04-01RA-H	3	15.5	26	66	65.5	0.5	4	5
SFP208N-0300-04-01RA-H	3	24.5	40	78	77.5	0.5	4	8
SFP203N-0310-04-01RA-H	3.1	9.8	20	62	61.5	0.5	4	3
SFP205N-0310-04-01RA-H	3.1	16	26	66	65.5	0.5	4	5
SFP208N-0310-04-01RA-H	3.1	25.3	40	78	77.5	0.5	4	8
SFP203N-0317-04-01RA-H	3.17	10	20	62	61.5	0.5	4	3
SFP205N-0317-04-01RA-H	3.17	16.4	26	66	65.5	0.5	4	5
SFP208N-0317-04-01RA-H	3.17	25.9	40	78	77.5	0.5	4	8
SFP203N-0320-04-01RA-H	3.2	10.1	20	62	61.5	0.5	4	3
SFP205N-0320-04-01RA-H	3.2	16.5	26	66	65.5	0.5	4	5
SFP208N-0320-04-01RA-H	3.2	26.1	40	78	77.5	0.5	4	8
SFP203N-0330-04-01RA-H	3.3	10.5	20	62	61.4	0.6	4	3
SFP205N-0330-04-01RA-H	3.3	17.1	26	66	65.4	0.6	4	5
SFP208N-0330-04-01RA-H	3.3	27	40	78	77.4	0.6	4	8
SFP203N-0340-04-01RA-H	3.4	10.8	20	62	61.4	0.6	4	3
SFP205N-0340-04-01RA-H	3.4	17.6	26	66	65.4	0.6	4	5
SFP208N-0340-04-01RA-H	3.4	27.5	40	78	77.4	0.6	4	8
SFP208N-0345-04-01RA-H	3.45	27.4	40	78	77.4	0.6	4	8
SFP203N-0350-04-01RA-H	3.5	11.1	20	62	61.4	0.6	4	3
SFP205N-0350-04-01RA-H	3.5	18.1	26	66	65.4	0.6	4	5
SFP208N-0350-04-01RA-H	3.5	27.3	40	78	77.4	0.6	4	8
SFP203N-0355-04-01RA-H	3.55	11.2	20	62	61.4	0.6	4	3
SFP208N-0357-04-01RA-H	3.57	27.1	40	78	77.4	0.6	4	8
SFP203N-0360-04-01RA-H	3.6	11.4	20	62	61.4	0.6	4	3
SFP205N-0360-04-01RA-H	3.6	18.5	26	66	65.4	0.6	4	5
SFP208N-0360-04-01RA-H	3.6	27.1	40	78	77.4	0.6	4	8
SFP203N-0370-04-01RA-H	3.7	11.7	20	62	61.4	0.6	4	3
SFP205N-0370-04-01RA-H	3.7	19.1	26	66	65.4	0.6	4	5
SFP208N-0370-04-01RA-H	3.7	27.9	40	78	77.4	0.6	4	8
SFP203N-0380-04-01RA-H	3.8	12.1	24	66	65.4	0.6	4	3
SFP205N-0380-04-01RA-H	3.8	31.1	34	74	73.4	0.6	4	5
SFP208N-0380-04-01RA-H	3.8	31.1	49	87	86.4	0.6	4	8
SFP203N-0390-04-01RA-H	3.9	12.5	24	66	65.4	0.6	4	3
SFP205N-0390-04-01RA-H	3.9	20.2	34	74	73.4	0.6	4	5
SFP208N-0390-04-01RA-H	3.9	31.9	49	87	86.4	0.6	4	8
SFP208N-0397-04-01RA-H	3.97	32.4	49	87	86.3	0.7	4	8
SFP203N-0400-04-01RA-H	4	12.7	24	66	65.3	0.7	4	3
SFP205N-0400-04-01RA-H	4	20.7	34	74	73.3	0.7	4	5
SFP208N-0400-04-01RA-H	4	32.7	49	87	86.3	0.7	4	8

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-0410-06-01RA-H	4.1	13	24	66	65.3	0.7	6	3
SFP205N-0410-06-01RA-H	4.1	21.2	34	74	73.3	0.7	6	5
SFP208N-0410-06-01RA-H	4.1	33.5	49	87	86.3	0.7	6	8
SFP203N-0420-06-01RA-H	4.2	13.3	24	66	65.3	0.7	6	3
SFP205N-0420-06-01RA-H	4.2	21.7	34	74	73.3	0.7	6	5
SFP208N-0420-06-01RA-H	4.2	34.3	49	87	86.3	0.7	6	8
SFP203N-0430-06-01RA-H	4.3	13.7	24	66	65.3	0.7	6	3
SFP205N-0430-06-01RA-H	4.3	22.3	34	74	73.3	0.7	6	5
SFP208N-0430-06-01RA-H	4.3	35.2	49	87	86.3	0.7	6	8
SFP203N-0440-06-01RA-H	4.4	14.1	24	66	65.3	0.7	6	3
SFP205N-0440-06-01RA-H	4.4	22.8	34	74	73.3	0.7	6	5
SFP208N-0440-06-01RA-H	4.4	36	49	87	86.3	0.7	6	8
SFP203N-0450-06-01RA-H	4.5	14.3	24	66	65.3	0.7	6	3
SFP205N-0450-06-01RA-H	4.5	23.3	34	74	73.3	0.7	6	5
SFP208N-0450-06-01RA-H	4.5	36.8	49	87	86.3	0.7	6	8
SFP203N-0455-06-01RA-H	4.55	23.5	34	74	73.2	0.8	6	3
SFP203N-0460-06-01RA-H	4.6	14.6	24	66	65.2	0.8	6	3
SFP205N-0460-06-01RA-H	4.6	23.8	34	74	73.2	0.8	6	5
SFP208N-0460-06-01RA-H	4.6	36.8	49	87	86.2	0.8	6	8
SFP203N-0470-06-01RA-H	4.7	14.9	24	66	65.2	0.8	6	3
SFP205N-0470-06-01RA-H	4.7	24.2	34	74	73.2	0.8	6	5
SFP208N-0470-06-01RA-H	4.7	36.6	49	87	86.2	0.8	6	8
SFP203N-0476-06-01RA-H	4.76	15	28	66	65.2	0.8	6	3
SFP208N-0476-06-01RA-H	4.76	36.8	56	94	96.2	0.8	6	8
SFP203N-0480-06-01RA-H	4.8	15.2	28	66	65.2	0.8	6	3
SFP205N-0480-06-01RA-H	4.8	24.8	44	82	81.2	0.8	6	5
SFP208N-0480-06-01RA-H	4.8	39.2	56	94	93.2	0.8	6	8
SFP203N-0490-06-01RA-H	4.9	15.5	28	66	65.2	0.8	6	3
SFP205N-0490-06-01RA-H	4.9	25.3	44	82	81.2	0.8	6	5
SFP208N-0490-06-01RA-H	4.9	40	56	94	93.2	0.8	6	8
SFP203N-0500-06-01RA-H	5	15.8	28	66	65.2	0.8	6	3
SFP205N-0500-06-01RA-H	5	25.8	44	82	81.2	0.8	6	5
SFP208N-0500-06-01RA-H	5	40.8	56	94	93.2	0.8	6	8
SFP203N-0510-06-01RA-H	5.1	16.1	28	66	65.2	0.8	6	3
SFP205N-0510-06-01RA-H	5.1	26.3	44	82	81.2	0.8	6	5
SFP208N-0510-06-01RA-H	5.1	41.6	56	94	93.2	0.8	6	8
SFP205N-0516-06-01RA-H	5.16	26.6	44	82	81.2	0.8	6	5
SFP208N-0516-06-01RA-H	5.16	42.1	56	94	93.1	0.9	6	8
SFP203N-0520-06-01RA-H	5.2	16.4	28	66	65.1	0.9	6	3
SFP205N-0520-06-01RA-H	5.2	26.8	44	82	81.1	0.9	6	5
SFP208N-0520-06-01RA-H	5.2	42.4	56	94	93.1	0.9	6	8

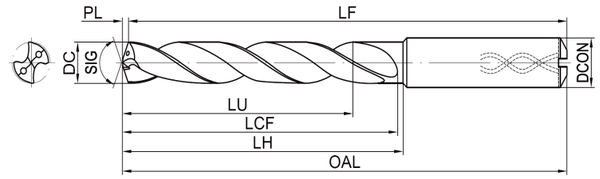
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-0530-06-01RA-H	5.3	16.7	28	66	65.1	0.9	6	3
SFP205N-0530-06-01RA-H	5.3	27.3	44	82	81.1	0.9	6	5
SFP203N-0540-06-01RA-H	5.4	17	28	66	65.1	0.9	6	3
SFP205N-0540-06-01RA-H	5.4	27.8	44	82	81.1	0.9	6	5
SFP208N-0540-06-01RA-H	5.4	44	56	94	93.1	0.9	6	8
SFP203N-0550-06-01RA-H	5.5	17.4	28	66	65.1	0.9	6	3
SFP205N-0550-06-01RA-H	5.5	28.4	44	82	81.1	0.9	6	5
SFP208N-0550-06-01RA-H	5.5	44.9	56	94	93.1	0.9	6	8
SFP205N-0555-06-01RA-H	5.55	28.7	44	82	81.1	0.9	6	5
SFP203N-0556-06-01RA-H	5.56	17.5	28	66	65.1	0.9	6	3
SFP205N-0556-06-01RA-H	5.56	28.7	44	82	81.1	0.9	6	5
SFP208N-0556-06-01RA-H	5.56	45.3	56	94	93.1	0.9	6	8
SFP203N-0560-06-01RA-H	5.6	17.7	28	66	65.1	0.9	6	3
SFP205N-0560-06-01RA-H	5.6	28.9	44	82	81.1	0.9	6	5
SFP208N-0560-06-01RA-H	5.6	45.7	56	94	93.1	0.9	6	8
SFP203N-0570-06-01RA-H	5.7	17.9	28	66	65.1	0.9	6	3
SFP205N-0570-06-01RA-H	5.7	29.4	44	82	81	1	6	5
SFP208N-0570-06-01RA-H	5.7	46.5	56	94	93	1	6	8
SFP203N-0580-06-01RA-H	5.8	18	28	66	65	1	6	3
SFP205N-0580-06-01RA-H	5.8	29.9	44	82	81	1	6	5
SFP208N-0580-06-01RA-H	5.8	47.3	56	94	93	1	6	8
SFP203N-0590-06-01RA-H	5.9	18.2	28	66	65	1	6	3
SFP205N-0590-06-01RA-H	5.9	30.4	44	82	81	1	6	5
SFP208N-0590-06-01RA-H	5.9	47.4	56	94	93	1	6	8
SFP203N-0595-06-01RA-H	5.95	18.2	28	66	65	1	6	3
SFP205N-0595-06-01RA-H	5.95	30.7	44	82	81	1	6	5
SFP203N-0600-06-01RA-H	6	18.9	28	66	65	1	6	3
SFP205N-0600-06-01RA-H	6	30.9	44	82	81	1	6	5
SFP208N-0600-06-01RA-H	6	48	56	94	93	1	6	8
SFP203N-0610-08-01RA-H	6.1	19.3	34	79	77.9	1.1	8	3
SFP205N-0610-08-01RA-H	6.1	31.5	53	91	89.9	1.1	8	5
SFP208N-0610-08-01RA-H	6.1	49.8	67	106	104.9	1.1	8	8
SFP203N-0620-08-01RA-H	6.2	19.6	34	79	77.9	1.1	8	3
SFP205N-0620-08-01RA-H	6.2	32	53	91	89.9	1.1	8	5
SFP208N-0620-08-01RA-H	6.2	50.6	67	106	104.9	1.1	8	8
SFP203N-0630-08-01RA-H	6.3	19.9	34	79	77.9	1.1	8	3
SFP205N-0630-08-01RA-H	6.3	32.5	53	91	89.9	1.1	8	5
SFP208N-0630-08-01RA-H	6.3	51.4	67	106	104.9	1.1	8	8
SFP203N-0635-08-01RA-H	6.35	20.1	34	79	78	1.1	8	3
SFP205N-0635-08-01RA-H	6.35	32.8	53	91	90	1.1	8	5
SFP208N-0635-08-01RA-H	6.35	51.8	67	106	104.9	1.1	8	8

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-0640-08-01RA-H	6.4	20.2	34	79	77.9	1.1	8	3
SFP205N-0640-08-01RA-H	6.4	33	53	91	89.9	1.1	8	5
SFP208N-0640-08-01RA-H	6.4	52.2	67	106	104.9	1.1	8	8
SFP203N-0650-08-01RA-H	6.5	20.6	34	79	77.9	1.1	8	3
SFP205N-0650-08-01RA-H	6.5	33.6	53	91	89.9	1.1	8	5
SFP208N-0650-08-01RA-H	6.5	53.1	67	106	104.9	1.1	8	8
SFP203N-0660-08-01RA-H	6.6	20.9	34	79	77.9	1.1	8	3
SFP205N-0660-08-01RA-H	6.6	34.1	53	91	89.9	1.1	8	5
SFP208N-0660-08-01RA-H	6.6	53.9	67	106	104.9	1.1	8	8
SFP203N-0670-08-01RA-H	6.7	21.2	34	79	77.9	1.1	8	3
SFP205N-0670-08-01RA-H	6.7	34.6	53	91	89.9	1.1	8	5
SFP208N-0670-08-01RA-H	6.7	54.7	67	106	104.9	1.1	8	8
SFP203N-0675-08-01RA-H	6.75	21.3	34	79	77.9	1.1	8	3
SFP205N-0675-08-01RA-H	6.75	34.8	53	91	89.9	1.1	8	5
SFP208N-0675-08-01RA-H	6.75	55.1	67	106	104.9	1.1	8	8
SFP203N-0680-08-01RA-H	6.8	21.5	34	79	77.9	1.1	8	3
SFP205N-0680-08-01RA-H	6.8	35.1	53	91	89.9	1.1	8	5
SFP208N-0680-08-01RA-H	6.8	55.5	67	106	104.9	1.1	8	8
SFP203N-0690-08-01RA-H	6.9	21.8	34	79	77.8	1.2	8	3
SFP205N-0690-08-01RA-H	6.9	35.6	53	91	89.8	1.2	8	5
SFP208N-0690-08-01RA-H	6.9	56.3	67	106	104.8	1.2	8	8
SFP203N-0700-08-01RA-H	7	22.1	34	79	77.8	1.2	8	3
SFP205N-0700-08-01RA-H	7	36.1	53	91	89.8	1.2	8	5
SFP208N-0700-08-01RA-H	7	57.1	67	106	104.8	1.2	8	8
SFP203N-0710-08-01RA-H	7.1	22.4	41	79	77.8	1.2	8	3
SFP205N-0710-08-01RA-H	7.1	36.6	53	91	89.8	1.2	8	5
SFP203N-0714-08-01RA-H	7.14	22.6	41	79	77.8	1.2	8	3
SFP205N-0714-08-01RA-H	7.14	36.9	53	91	89.8	1.2	8	5
SFP208N-0714-08-01RA-H	7.14	58.3	72	110	108.8	1.2	8	8
SFP203N-0720-08-01RA-H	7.2	22.8	41	79	77.8	1.2	8	3
SFP205N-0720-08-01RA-H	7.2	37.2	53	91	89.8	1.2	8	5
SFP203N-0730-08-01RA-H	7.3	23.1	41	79	77.8	1.2	8	3
SFP205N-0730-08-01RA-H	7.3	37.7	53	91	89.8	1.2	8	5
SFP208N-0730-08-01RA-H	7.3	59.6	72	110	108.8	1.2	8	8
SFP203N-0740-08-01RA-H	7.4	23.4	41	79	77.7	1.3	8	3
SFP205N-0740-08-01RA-H	7.4	38.2	53	91	89.7	1.3	8	5
SFP208N-0740-08-01RA-H	7.4	60.4	72	110	108.7	1.3	8	8
SFP203N-0750-08-01RA-H	7.5	23.7	41	79	77.7	1.3	8	3
SFP205N-0750-08-01RA-H	7.5	38.7	53	91	89.7	1.3	8	5
SFP208N-0750-08-01RA-H	7.5	61.2	72	110	108.7	1.3	8	8
SFP205N-0754-08-01RA-H	7.54	38.9	53	91	89.7	1.3	8	5

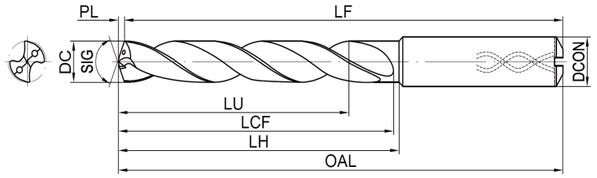
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-0760-08-01RA-H	7.6	24	41	79	77.7	1.3	8	3
SFP205N-0760-08-01RA-H	7.6	39.2	53	91	89.7	1.3	8	5
SFP208N-0760-08-01RA-H	7.6	62	72	110	108.7	1.3	8	8
SFP203N-0770-08-01RA-H	7.7	24.3	41	79	77.7	1.3	8	3
SFP205N-0770-08-01RA-H	7.7	39.7	53	91	89.7	1.3	8	5
SFP208N-0770-08-01RA-H	7.7	62.8	72	110	108.7	1.3	8	8
SFP203N-0780-08-01RA-H	7.8	24.7	41	79	77.7	1.3	8	3
SFP205N-0780-08-01RA-H	7.8	40.3	53	91	89.7	1.3	8	5
SFP208N-0780-08-01RA-H	7.8	63.7	72	110	108.7	1.3	8	8
SFP203N-0790-08-01RA-H	7.9	25	41	79	77.7	1.3	8	3
SFP205N-0790-08-01RA-H	7.9	40.8	53	91	89.7	1.3	8	5
SFP203N-0794-08-01RA-H	7.94	25.1	41	79	77.6	1.4	8	3
SFP205N-0794-08-01RA-H	7.94	41	53	91	89.6	1.4	8	5
SFP208N-0794-08-01RA-H	7.94	64.8	72	110	108.6	1.4	8	8
SFP203N-0800-08-01RA-H	8	25.3	41	79	77.6	1.4	8	3
SFP205N-0800-08-01RA-H	8	41.3	53	91	89.6	1.4	8	5
SFP208N-0800-08-01RA-H	8	56	72	110	108.6	1.4	8	7
SFP203N-0810-10-01RA-H	8.1	25.6	47	89	87.6	1.4	10	3
SFP205N-0810-10-01RA-H	8.1	41.8	61	103	101.6	1.4	10	5
SFP208N-0810-10-01RA-H	8.1	66.1	80	122	120.6	1.4	10	8
SFP205N-0815-10-01RA-H	8.15	42.1	53	91	89.6	1.4	10	5
SFP203N-0820-10-01RA-H	8.2	25.9	47	89	87.6	1.4	10	3
SFP205N-0820-10-01RA-H	8.2	42.3	61	103	101.6	1.4	10	5
SFP208N-0820-10-01RA-H	8.2	66.9	80	122	120.6	1.4	10	8
SFP203N-0830-10-01RA-H	8.3	26.3	47	89	87.6	1.4	10	3
SFP205N-0830-10-01RA-H	8.3	42.9	61	103	101.6	1.4	10	5
SFP208N-0830-10-01RA-H	8.3	67.8	80	122	120.6	1.4	10	8
SFP205N-0833-10-01RA-H	8.33	43	61	103	101.6	1.4	10	5
SFP203N-0840-10-01RA-H	8.4	26.6	47	89	87.6	1.4	10	3
SFP205N-0840-10-01RA-H	8.4	43.4	61	103	101.6	1.4	10	5
SFP208N-0840-10-01RA-H	8.4	68.6	80	122	120.6	1.4	10	8
SFP203N-0850-10-01RA-H	8.5	26.9	47	89	87.6	1.4	10	3
SFP205N-0850-10-01RA-H	8.5	43.9	61	103	101.6	1.4	10	5
SFP208N-0850-10-01RA-H	8.5	69.4	80	122	120.6	1.4	10	8
SFP203N-0860-10-01RA-H	8.6	27.2	47	89	87.5	1.5	10	3
SFP205N-0860-10-01RA-H	8.6	44.4	61	103	101.5	1.5	10	5
SFP208N-0860-10-01RA-H	8.6	70.2	80	122	120.5	1.5	10	8
SFP203N-0870-10-01RA-H	8.7	27.5	47	89	87.5	1.5	10	3
SFP205N-0870-10-01RA-H	8.7	44.9	61	103	101.5	1.5	10	5
SFP208N-0870-10-01RA-H	8.7	71	80	122	120.5	1.5	10	8

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-0873-10-01RA-H	8.73	27.6	47	89	87.5	1.5	10	3
SFP205N-0873-10-01RA-H	8.73	45.1	61	103	101.5	1.5	10	5
SFP208N-0873-10-01RA-H	8.73	71.3	80	122	120.5	1.5	10	8
SFP203N-0880-10-01RA-H	8.8	27.8	47	89	87.5	1.5	10	3
SFP205N-0880-10-01RA-H	8.8	45.4	61	103	101.5	1.5	10	5
SFP208N-0880-10-01RA-H	8.8	71.8	80	122	120.5	1.5	10	8
SFP203N-0890-10-01RA-H	8.9	28	47	89	87.5	1.5	10	3
SFP205N-0890-10-01RA-H	8.9	45.9	61	103	101.5	1.5	10	5
SFP203N-0900-10-01RA-H	9	28.5	47	89	87.5	1.5	10	3
SFP205N-0900-10-01RA-H	9	46.5	61	103	101.5	1.5	10	5
SFP208N-0900-10-01RA-H	9	72	80	122	120.5	1.5	10	8
SFP203N-0910-10-01RA-H	9.1	28.8	47	89	87.5	1.5	10	3
SFP205N-0910-10-01RA-H	9.1	47	61	103	101.5	1.5	10	5
SFP208N-0910-10-01RA-H	9.1	63.7	80	122	120.5	1.5	10	7
SFP203N-0920-10-01RA-H	9.2	29.1	47	89	87.4	1.6	10	3
SFP205N-0920-10-01RA-H	9.2	47.5	61	103	101.4	1.6	10	5
SFP208N-0920-10-01RA-H	9.2	64.4	80	122	120.4	1.6	10	7
SFP203N-0930-10-01RA-H	9.3	29.4	47	89	87.4	1.6	10	3
SFP205N-0930-10-01RA-H	9.3	48	61	103	101.4	1.6	10	5
SFP208N-0930-10-01RA-H	9.3	65.1	80	122	120.4	1.6	10	7
SFP203N-0940-10-01RA-H	9.4	29.7	47	89	87.4	1.6	10	3
SFP205N-0940-10-01RA-H	9.4	48.5	61	103	101.4	1.6	10	5
SFP208N-0940-10-01RA-H	9.4	65.8	80	122	120.4	1.6	10	7
SFP203N-0950-10-01RA-H	9.5	30	47	89	87.4	1.6	10	3
SFP205N-0950-10-01RA-H	9.5	48.7	61	103	101.4	1.6	10	5
SFP208N-0950-10-01RA-H	9.5	66.5	80	122	120.4	1.6	10	7
SFP203N-0952-10-01RA-H	9.52	30.1	47	89	87.4	1.6	10	3
SFP205N-0952-10-01RA-H	9.52	48.6	61	103	101.4	1.6	10	5
SFP208N-0952-10-01RA-H	9.52	66.6	80	122	120.4	1.6	10	7
SFP205N-0955-10-01RA-H	9.55	48.6	61	103	101.4	1.6	10	5
SFP203N-0960-10-01RA-H	9.6	30.3	47	89	87.4	1.6	10	3
SFP205N-0960-10-01RA-H	9.6	48.5	61	103	101.4	1.6	10	5
SFP208N-0960-10-01RA-H	9.6	67.2	80	122	120.4	1.6	10	7
SFP203N-0970-10-01RA-H	9.7	30.7	47	89	87.3	1.7	10	3
SFP205N-0970-10-01RA-H	9.7	48.4	61	103	101.4	1.6	10	5
SFP208N-0970-10-01RA-H	9.7	67.9	80	122	120.3	1.7	10	7
SFP203N-0980-10-01RA-H	9.8	31	47	89	87.3	1.7	10	3
SFP205N-0980-10-01RA-H	9.8	48.3	61	103	101.3	1.7	10	5
SFP208N-0980-10-01RA-H	9.8	68.6	80	122	120.3	1.7	10	7

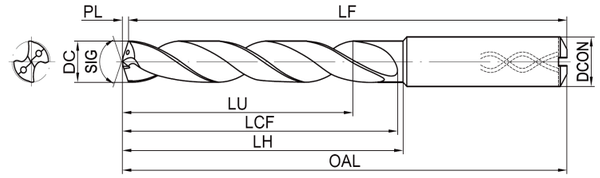
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-0990-10-01RA-H	9.9	31.3	47	89	87.3	1.7	10	3
SFP205N-0990-10-01RA-H	9.9	48.1	61	103	101.3	1.7	10	5
SFP208N-0990-10-01RA-H	9.9	69.3	80	122	120.3	1.7	10	7
SFP208N-0992-10-01RA-H	9.92	69.4	80	122	120.3	1.7	10	7
SFP203N-1000-10-01RA-H	10	31.6	47	89	87.3	1.7	10	3
SFP205N-1000-10-01RA-H	10	50	61	103	101.3	1.7	10	5
SFP208N-1000-10-01RA-H	10	70	80	122	120.3	1.7	10	7
SFP203N-1010-12-01RA-H	10.1	31.9	55	102	100.3	1.7	12	3
SFP205N-1010-12-01RA-H	10.1	52.1	71	118	116.3	1.7	12	5
SFP208N-1010-12-01RA-H	10.1	82.4	96	141	139.3	1.7	12	8
SFP203N-1020-12-01RA-H	10.2	32.3	55	102	100.3	1.7	12	3
SFP205N-1020-12-01RA-H	10.2	52.7	71	118	116.3	1.7	12	5
SFP208N-1020-12-01RA-H	10.2	83.3	96	141	139.3	1.7	12	8
SFP203N-1030-12-01RA-H	10.3	32.6	55	102	100.2	1.8	12	3
SFP205N-1030-12-01RA-H	10.3	53.2	71	118	116.2	1.8	12	5
SFP208N-1030-12-01RA-H	10.3	84.1	96	141	139.2	1.8	12	8
SFP203N-1032-12-01RA-H	10.32	32.6	55	102	100.2	1.8	12	3
SFP205N-1032-12-01RA-H	10.32	53.3	71	118	116.2	1.8	12	5
SFP203N-1040-12-01RA-H	10.4	32.9	55	102	100.2	1.8	12	3
SFP205N-1040-12-01RA-H	10.4	53.7	71	118	116.2	1.8	12	5
SFP208N-1040-12-01RA-H	10.4	84.9	96	141	139.2	1.8	12	8
SFP203N-1050-12-01RA-H	10.5	33.2	55	102	100.2	1.8	12	3
SFP205N-1050-12-01RA-H	10.5	54.2	71	118	116.2	1.8	12	5
SFP208N-1050-12-01RA-H	10.5	84	96	141	139.2	1.8	12	8
SFP203N-1060-12-01RA-H	10.6	33.5	55	102	100.2	1.8	12	3
SFP205N-1060-12-01RA-H	10.6	54.7	71	118	116.2	1.8	12	5
SFP203N-1070-12-01RA-H	10.7	33.8	55	102	100.2	1.8	12	3
SFP205N-1070-12-01RA-H	10.7	55.2	71	118	116.2	1.8	12	5
SFP205N-1071-12-01RA-H	10.71	55.3	71	118	116.2	1.8	12	5
SFP203N-1080-12-01RA-H	10.8	34.2	55	102	100.2	1.8	12	3
SFP205N-1080-12-01RA-H	10.8	55.8	71	118	116.2	1.8	12	5
SFP208N-1080-12-01RA-H	10.8	86.4	96	141	139.2	1.8	12	8
SFP203N-1090-12-01RA-H	10.9	34.6	55	102	100.2	1.8	12	3
SFP205N-1090-12-01RA-H	10.9	56.3	71	118	116.1	1.9	12	5
SFP203N-1100-12-01RA-H	11	34.8	55	102	100.1	1.9	12	3
SFP205N-1100-12-01RA-H	11	56.8	71	118	116.1	1.9	12	5
SFP208N-1100-12-01RA-H	11	77	96	141	139.1	1.9	12	7
SFP203N-1110-12-01RA-H	11.1	35.1	55	102	100.1	1.9	12	3
SFP205N-1110-12-01RA-H	11.1	57.3	71	118	116.1	1.9	12	5
SFP208N-1110-12-01RA-H	11.1	78	96	141	139.1	1.9	12	7

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-1111-12-01RA-H	11.11	35.1	55	102	100.1	1.9	12	3
SFP208N-1111-12-01RA-H	11.11	77.8	96	141	139.1	1.9	12	7
SFP203N-1120-12-01RA-H	11.2	35.4	55	102	100.1	1.9	12	3
SFP205N-1120-12-01RA-H	11.2	57.6	71	118	116.1	1.9	12	5
SFP203N-1130-12-01RA-H	11.3	35.7	55	102	100.1	1.9	12	3
SFP205N-1130-12-01RA-H	11.3	57.4	71	118	116.1	1.9	12	5
SFP208N-1130-12-01RA-H	11.3	79.1	96	141	139.1	1.9	12	7
SFP203N-1140-12-01RA-H	11.4	36.1	55	102	100	2	12	3
SFP205N-1140-12-01RA-H	11.4	57.3	71	118	116.1	1.9	12	5
SFP203N-1150-12-01RA-H	11.5	36.4	55	102	100	2	12	3
SFP205N-1150-12-01RA-H	11.5	57.2	71	118	116	2	12	5
SFP208N-1150-12-01RA-H	11.5	80.5	96	141	139	2	12	7
SFP203N-1160-12-01RA-H	11.6	36.7	55	102	100	2	12	3
SFP205N-1160-12-01RA-H	11.6	57.1	71	118	116	2	12	5
SFP203N-1170-12-01RA-H	11.7	37	55	102	100	2	12	3
SFP205N-1170-12-01RA-H	11.7	57	71	118	116	2	12	5
SFP203N-1180-12-01RA-H	11.8	37.3	55	102	100	2	12	3
SFP205N-1180-12-01RA-H	11.8	56.8	71	118	116	2	12	5
SFP208N-1180-12-01RA-H	11.8	82.6	96	141	139	2	12	7
SFP203N-1190-12-01RA-H	11.9	37.6	55	102	100	2	12	3
SFP205N-1190-12-01RA-H	11.9	58.2	71	118	116	2	12	5
SFP208N-1190-12-01RA-H	11.9	83.3	96	141	139	2	12	7
SFP203N-1200-12-01RA-H	12	38	55	102	99.9	2.1	12	3
SFP205N-1200-12-01RA-H	12	60	71	118	115.9	2.1	12	5
SFP208N-1200-12-01RA-H	12	84	96	141	138.9	2.1	12	7
SFP203N-1210-14-01RA-H	12.1	38.3	60	107	104.9	2.1	14	3
SFP205N-1210-14-01RA-H	12.1	62.5	77	124	121.9	2.1	14	5
SFP208N-1210-14-01RA-H	12.1	96.8	108	155	152.9	2.1	14	8
SFP203N-1220-14-01RA-H	12.2	38.6	60	107	104.9	2.1	14	3
SFP205N-1220-14-01RA-H	12.2	62.4	77	124	121.9	2.1	14	5
SFP208N-1220-14-01RA-H	12.2	97.6	108	155	152.9	2.1	14	8
SFP203N-1230-14-01RA-H	12.3	38.9	60	107	104.9	2.1	14	3
SFP205N-1230-14-01RA-H	12.3	62.2	77	124	121.9	2.1	14	5
SFP208N-1230-14-01RA-H	12.3	98.4	108	155	152.9	2.1	14	8
SFP203N-1240-14-01RA-H	12.4	39.2	60	107	104.9	2.1	14	3
SFP205N-1240-14-01RA-H	12.4	62.6	77	124	121.9	2.1	14	5
SFP203N-1250-14-01RA-H	12.5	39.5	60	107	104.9	2.1	14	3
SFP205N-1250-14-01RA-H	12.5	63	77	124	121.9	2.1	14	5
SFP208N-1250-14-01RA-H	12.5	88	108	155	152.9	2.1	14	7
SFP203N-1260-14-01RA-H	12.6	39.9	60	107	104.8	2.2	14	3
SFP205N-1260-14-01RA-H	12.6	63.5	77	124	121.9	2.1	14	5

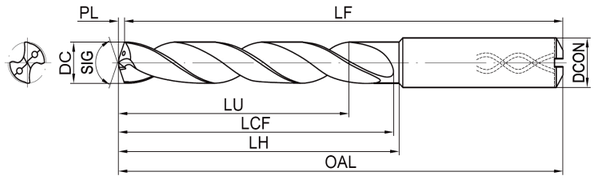
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-1270-14-01RA-H	12.7	40.2	60	107	104.8	2.2	14	3
SFP205N-1270-14-01RA-H	12.7	64	77	124	121.8	2.2	14	5
SFP208N-1270-14-01RA-H	12.7	88.9	108	155	152.8	2.2	14	7
SFP203N-1280-14-01RA-H	12.8	40.5	60	107	104.8	2.2	14	3
SFP205N-1280-14-01RA-H	12.8	64.6	77	124	121.8	2.2	14	5
SFP208N-1280-14-01RA-H	12.8	89.6	108	155	152.8	2.2	14	7
SFP203N-1290-14-01RA-H	12.9	40.8	60	107	104.8	2.2	14	3
SFP205N-1290-14-01RA-H	12.9	65	77	124	121.8	2.2	14	5
SFP203N-1300-14-01RA-H	13	41.1	60	107	104.8	2.2	14	3
SFP205N-1300-14-01RA-H	13	61.4	77	124	121.8	2.2	14	5
SFP208N-1300-14-01RA-H	13	91	108	155	152.8	2.2	14	7
SFP203N-1310-14-01RA-H	13.1	41.4	60	107	104.7	2.3	14	3
SFP205N-1310-14-01RA-H	13.1	61.3	77	124	121.7	2.3	14	5
SFP208N-1310-14-01RA-H	13.1	91.7	108	155	152.7	2.3	14	7
SFP203N-1320-14-01RA-H	13.2	40.2	60	107	104.7	2.3	14	3
SFP205N-1320-14-01RA-H	13.2	57.2	77	124	121.7	2.3	14	5
SFP205N-1325-14-01RA-H	13.25	61.1	77	124	121.7	2.3	14	5
SFP203N-1330-14-01RA-H	13.3	40.1	60	107	104.7	2.3	14	3
SFP205N-1330-14-01RA-H	13.3	57.1	77	124	121.7	2.3	14	5
SFP203N-1340-14-01RA-H	13.4	39.9	60	107	104.7	2.3	14	3
SFP205N-1340-14-01RA-H	13.4	56.9	77	124	121.7	2.3	14	5
SFP203N-1350-14-01RA-H	13.5	42.7	60	107	104.7	2.3	14	3
SFP205N-1350-14-01RA-H	13.5	60.8	77	124	121.7	2.3	14	5
SFP208N-1350-14-01RA-H	13.5	94.5	108	155	152.7	2.3	14	7
SFP203N-1360-14-01RA-H	13.6	39.6	60	107	104.6	2.4	14	3
SFP205N-1360-14-01RA-H	13.6	56.6	77	124	121.6	2.4	14	5
SFP203N-1370-14-01RA-H	13.7	39.5	60	107	104.6	2.4	14	3
SFP205N-1370-14-01RA-H	13.7	56.5	77	124	121.6	2.4	14	5
SFP205N-1375-14-01RA-H	13.75	60.5	77	124	121.6	2.4	14	5
SFP203N-1380-14-01RA-H	13.8	43.4	60	107	104.6	2.4	14	3
SFP205N-1380-14-01RA-H	13.8	60.4	77	124	121.6	2.4	14	5
SFP208N-1380-14-01RA-H	13.8	96.6	108	155	152.6	2.4	14	7
SFP205N-1389-14-01RA-H	13.89	60.3	77	124	121.6	2.4	14	5
SFP203N-1390-14-01RA-H	13.9	39.2	60	107	104.6	2.4	14	3
SFP205N-1390-14-01RA-H	13.9	56.2	77	124	121.6	2.4	14	5
SFP203N-1400-14-01RA-H	14	44.3	60	107	104.6	2.4	14	3
SFP205N-1400-14-01RA-H	14	63	77	124	121.6	2.4	14	5
SFP208N-1400-14-01RA-H	14	98	108	155	152.6	2.4	14	7
SFP203N-1410-16-01RA-H	14.1	43.9	65	115	112.5	2.5	16	3
SFP205N-1410-16-01RA-H	14.1	61.9	83	133	130.5	2.5	16	5

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-1420-16-01RA-H	14.2	43.7	65	115	112.5	2.5	16	3
SFP205N-1420-16-01RA-H	14.2	61.7	83	133	130.5	2.5	16	5
SFP203N-1425-16-01RA-H	14.25	45	65	115	112.5	2.5	16	3
SFP205N-1425-16-01RA-H	14.25	68.8	83	133	130.5	2.5	16	5
SFP203N-1429-16-01RA-H	14.29	45.2	65	115	112.5	2.5	16	3
SFP205N-1429-16-01RA-H	14.29	68.7	83	133	130.5	2.5	16	5
SFP203N-1430-16-01RA-H	14.3	43.6	65	115	112.5	2.5	16	3
SFP205N-1430-16-01RA-H	14.3	61.6	83	133	130.5	2.5	16	5
SFP203N-1440-16-01RA-H	14.4	43.4	65	115	112.5	2.5	16	3
SFP205N-1440-16-01RA-H	14.4	61.4	83	133	130.5	2.5	16	5
SFP203N-1450-16-01RA-H	14.5	45.8	65	115	112.5	2.5	16	3
SFP205N-1450-16-01RA-H	14.5	68.5	83	133	130.5	2.5	16	5
SFP203N-1460-16-01RA-H	14.6	43.1	65	115	112.5	2.5	16	3
SFP205N-1460-16-01RA-H	14.6	61.1	83	133	130.5	2.5	16	5
SFP203N-1469-16-01RA-H	14.69	46.4	65	115	112.5	2.5	16	3
SFP203N-1470-16-01RA-H	14.7	43.0	65	115	112.5	2.5	16	3
SFP205N-1470-16-01RA-H	14.7	61.0	83	133	130.5	2.5	16	5
SFP203N-1480-16-01RA-H	14.8	46.6	65	115	112.5	2.5	16	3
SFP205N-1480-16-01RA-H	14.8	68.2	83	133	131	2.6	16	5
SFP203N-1490-16-01RA-H	14.9	42.7	65	115	112.4	2.6	16	3
SFP205N-1490-16-01RA-H	14.9	60.7	83	133	130.4	2.6	16	5
SFP203N-1500-16-01RA-H	15	47.4	65	115	112.4	2.6	16	3
SFP205N-1500-16-01RA-H	15	68	83	133	130.4	2.6	16	5
SFP203N-1510-16-01RA-H	15.1	42.4	65	115	112.4	2.6	16	3
SFP205N-1510-16-01RA-H	15.1	60.4	83	133	130.4	2.6	16	5
SFP203N-1520-16-01RA-H	15.2	42.2	65	115	112.4	2.6	16	3
SFP205N-1520-16-01RA-H	15.2	60.2	83	133	130.4	2.6	16	5
SFP203N-1530-16-01RA-H	15.3	42.1	65	115	112.4	2.6	16	3
SFP205N-1530-16-01RA-H	15.3	60.1	83	133	130.4	2.6	16	5
SFP203N-1540-16-01RA-H	15.4	41.9	65	115	112.4	2.6	16	3
SFP205N-1540-16-01RA-H	15.4	59.9	83	133	130.4	2.6	16	5
SFP203N-1550-16-01RA-H	15.5	49	65	115	112.3	2.7	16	3
SFP205N-1550-16-01RA-H	15.5	67.5	83	133	130.3	2.7	16	5
SFP203N-1560-16-01RA-H	15.6	41.6	65	115	112.3	2.7	16	3
SFP205N-1560-16-01RA-H	15.6	59.6	83	133	130.3	2.7	16	5
SFP203N-1570-16-01RA-H	15.7	41.5	65	115	112.3	2.7	16	3
SFP205N-1570-16-01RA-H	15.7	59.5	83	133	130.3	2.7	16	5
SFP203N-1580-16-01RA-H	15.8	49.2	65	115	112.2	2.8	16	3
SFP205N-1580-16-01RA-H	15.8	67.2	83	133	130.2	2.8	16	5
SFP203N-1587-16-01RA-H	15.87	49.1	65	115	112.2	2.8	16	3

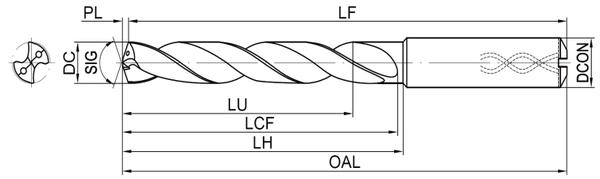
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203N-1590-16-01RA-H	15.9	41.2	65	115	112.2	2.8	16	3
SFP205N-1590-16-01RA-H	15.9	59.2	83	133	130.2	2.8	16	5
SFP203N-1600-16-01RA-H	16	49	65	115	112.2	2.8	16	3
SFP205N-1600-16-01RA-H	16	67	83	133	130.2	2.8	16	5
SFP208N-1600-16-01RA-H	16	111	121	171	168.2	2.8	16	7
SFP203N-1650-18-01RA-H	16.5	52.1	73	123	120.2	2.8	18	3
SFP205N-1650-18-01RA-H	16.5	76.5	93	143	140.2	2.8	18	5
SFP203N-1680-18-01RA-H	16.8	53	73	123	120.2	2.8	18	3
SFP205N-1680-18-01RA-H	16.8	76.2	93	143	140.2	2.8	18	5
SFP203N-1700-18-01RA-H	17	54.1	73	123	120.2	2.8	18	3
SFP205N-1700-18-01RA-H	17	76	93	143	140.2	2.8	18	5
SFP203N-1750-18-01RA-H	17.5	55.2	73	123	120.2	2.8	18	3
SFP205N-1750-18-01RA-H	17.5	75.5	93	143	140.2	2.8	18	5
SFP203N-1780-18-01RA-H	17.8	56.2	73	123	120.2	2.8	18	3
SFP205N-1780-18-01RA-H	17.8	75.2	93	143	140.1	2.9	18	5
SFP203N-1800-18-01RA-H	18	56.8	73	123	120.1	2.9	18	3
SFP205N-1800-18-01RA-H	18	78.6	93	143	140.1	2.9	18	5
SFP203N-1850-20-01RA-H	18.5	58.4	79	131	128.1	2.9	20	3
SFP205N-1850-20-01RA-H	18.5	84	101	153	150.1	2.9	20	5
SFP203N-1880-20-01RA-H	18.8	59.3	79	131	128.1	2.9	20	3
SFP205N-1880-20-01RA-H	18.8	86	101	153	150.1	2.9	20	5
SFP203N-1900-20-01RA-H	19	59.9	79	131	128.1	2.9	20	3
SFP203N-2000-20-01RA-H	20	63	79	131	127.9	3.1	20	3

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	

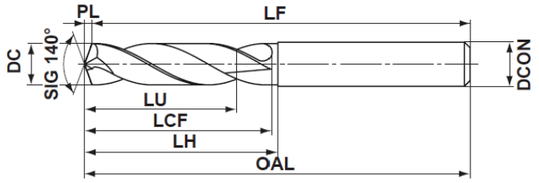
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





External Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203W-0300-04-01RA-H	3	9.5	20	62	61.5	0.5	4	3
SFP205W-0300-04-01RA-H	3	15.5	26	66	65.5	0.5	4	5
SFP203W-0310-04-01RA-H	3.1	9.8	20	62	61.5	0.5	4	3
SFP205W-0310-04-01RA-H	3.1	16	26	66	65.5	0.5	4	5
SFP203W-0317-04-01RA-H	3.17	10	20	62	61.5	0.5	4	3
SFP205W-0317-04-01RA-H	3.17	16.4	26	66	65.5	0.5	4	5
SFP203W-0320-04-01RA-H	3.2	10.1	20	62	61.5	0.5	4	3
SFP205W-0320-04-01RA-H	3.2	16.5	26	66	65.5	0.5	4	5
SFP203W-0330-04-01RA-H	3.3	10.5	20	62	61.4	0.6	4	3
SFP205W-0330-04-01RA-H	3.3	17.1	26	66	65.4	0.6	4	5
SFP203W-0340-04-01RA-H	3.4	10.8	20	62	61.4	0.6	4	3
SFP205W-0340-04-01RA-H	3.4	17.6	26	66	65.4	0.6	4	5
SFP203W-0350-04-01RA-H	3.5	11.1	20	62	61.4	0.6	4	3
SFP205W-0350-04-01RA-H	3.5	18.1	26	66	65.4	0.6	4	5
SFP203W-0355-04-01RA-H	3.55	11.2	20	62	61.4	0.6	4	3
SFP203W-0360-04-01RA-H	3.6	11.4	20	62	61.4	0.6	4	3
SFP205W-0360-04-01RA-H	3.6	18.5	26	66	65.4	0.6	4	5
SFP203W-0370-04-01RA-H	3.7	11.7	20	62	61.4	0.6	4	3
SFP205W-0370-04-01RA-H	3.7	19.1	26	66	65.4	0.6	4	5
SFP203W-0380-04-01RA-H	3.8	12.1	24	66	65.4	0.6	4	3
SFP205W-0380-04-01RA-H	3.8	19.5	34	74	73.4	0.6	4	5
SFP203W-0390-04-01RA-H	3.9	12.5	24	66	65.4	0.6	4	3
SFP205W-0390-04-01RA-H	3.9	20.2	34	74	73.4	0.6	4	5
SFP203W-0400-04-01RA-H	4	12.7	24	66	65.3	0.7	4	3
SFP205W-0400-04-01RA-H	4	20.7	34	74	73.3	0.7	4	5
SFP203W-0410-06-01RA-H	4.1	13	24	66	65.3	0.7	6	3
SFP205W-0410-06-01RA-H	4.1	21.2	34	74	73.3	0.7	6	5
SFP203W-0420-06-01RA-H	4.2	13.3	24	66	65.3	0.7	6	3
SFP205W-0420-06-01RA-H	4.2	21.7	34	74	73.3	0.7	6	5
SFP203W-0430-06-01RA-H	4.3	13.7	24	66	65.2	0.7	6	3
SFP205W-0430-06-01RA-H	4.3	22.3	34	74	73.2	0.7	6	5
SFP203W-0440-06-01RA-H	4.4	14.1	24	66	65.3	0.7	6	3
SFP205W-0440-06-01RA-H	4.4	22.8	34	74	73.3	0.7	6	5
SFP203W-0450-06-01RA-H	4.5	14.3	24	66	65.3	0.7	6	3
SFP205W-0450-06-01RA-H	4.5	23.3	34	74	73.3	0.7	6	5
SFP203W-0455-06-01RA-H	4.55	23.5	36	74	73.2	0.8	6	3
SFP203W-0460-06-01RA-H	4.6	14.6	24	66	65.2	0.8	6	3
SFP205W-0460-06-01RA-H	4.6	23.8	34	74	73.2	0.8	6	5
SFP203W-0470-06-01RA-H	4.7	17.0	24	66	65.2	0.8	6	3
SFP205W-0470-06-01RA-H	4.7	27.0	34	74	73.2	0.8	6	5
SFP203W-0476-06-01RA-H	4.76	15	28	66	65.2	0.8	6	3

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203W-0480-06-01RA-H	4.8	15.2	28	66	65.2	0.8	6	3
SFP205W-0480-06-01RA-H	4.8	24.8	44	82	81.2	0.8	6	5
SFP203W-0490-06-01RA-H	4.9	15.5	28	66	65.2	0.8	6	3
SFP205W-0490-06-01RA-H	4.9	25.3	44	82	81.2	0.8	6	5
SFP203W-0500-06-01RA-H	5	15.8	28	66	65.2	0.8	6	3
SFP205W-0500-06-01RA-H	5	25.8	44	82	81.2	0.8	6	5
SFP203W-0510-06-01RA-H	5.1	16.1	28	66	65.2	0.8	6	3
SFP205W-0510-06-01RA-H	5.1	26.3	44	82	81.2	0.8	6	5
SFP205W-0516-06-01RA-H	5.16	26.6	44	82	81.2	0.8	6	5
SFP203W-0520-06-01RA-H	5.2	16.4	28	66	65.1	0.9	6	3
SFP205W-0520-06-01RA-H	5.2	26.8	44	82	81.1	0.9	6	5
SFP203W-0530-06-01RA-H	5.3	16.7	28	66	65.1	0.9	6	3
SFP205W-0530-06-01RA-H	5.3	27.3	44	82	81.1	0.9	6	5
SFP203W-0540-06-01RA-H	5.4	17	28	66	65.1	0.9	6	3
SFP205W-0540-06-01RA-H	5.4	27.8	44	82	81.1	0.9	6	5
SFP203W-0550-06-01RA-H	5.5	17.4	28	66	65.1	0.9	6	3
SFP205W-0550-06-01RA-H	5.5	28.4	44	82	81.1	0.9	6	5
SFP205W-0555-06-01RA-H	5.55	28.7	44	82	81.1	0.9	6	5
SFP203W-0556-06-01RA-H	5.56	17.5	28	66	65.1	0.9	6	3
SFP205W-0556-06-01RA-H	5.56	28.7	44	82	81.1	0.9	6	5
SFP203W-0560-06-01RA-H	5.6	17.7	28	66	65.1	0.9	6	3
SFP205W-0560-06-01RA-H	5.6	28.9	44	82	81.1	0.9	6	5
SFP203W-0570-06-01RA-H	5.7	17.6	28	66	65.1	0.9	6	3
SFP205W-0570-06-01RA-H	5.7	29.4	44	82	81	1	6	5
SFP203W-0580-06-01RA-H	5.8	17.6	28	66	65	1	6	3
SFP205W-0580-06-01RA-H	5.8	29.9	44	82	81	1	6	5
SFP203W-0590-06-01RA-H	5.9	18.2	28	66	65	1	6	3
SFP205W-0590-06-01RA-H	5.9	30.4	44	82	81	1	6	5
SFP203W-0595-06-01RA-H	5.95	18.2	28	66	65	1	6	3
SFP205W-0595-06-01RA-H	5.95	30.7	44	82	81	1	6	5
SFP203W-0600-06-01RA-H	6	18.9	28	66	65	1	6	3
SFP205W-0600-06-01RA-H	6	30.9	44	82	81	1	6	5
SFP203W-0610-08-01RA-H	6.1	19.3	34	79	77.9	1.1	8	3
SFP205W-0610-08-01RA-H	6.1	31.5	53	91	89.9	1.1	8	5
SFP203W-0620-08-01RA-H	6.2	19.6	34	79	77.9	1.1	8	3
SFP205W-0620-08-01RA-H	6.2	32	53	91	89.9	1.1	8	5
SFP203W-0630-08-01RA-H	6.3	19.9	34	79	77.9	1.1	8	3
SFP205W-0630-08-01RA-H	6.3	32.5	53	91	89.9	1.1	8	5
SFP203W-0635-08-01RA-H	6.35	20.1	34	79	78	1.1	8	3
SFP205W-0635-08-01RA-H	6.35	32.8	53	91	90	1.1	8	5

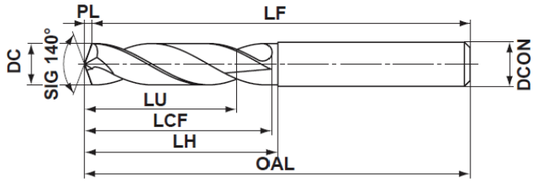
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





External Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203W-0640-08-01RA-H	6.4	20.2	34	79	77.9	1.1	8	3
SFP205W-0640-08-01RA-H	6.4	33	53	91	89.9	1.1	8	5
SFP203W-0650-08-01RA-H	6.5	20.6	34	79	77.9	1.1	8	3
SFP205W-0650-08-01RA-H	6.5	33.6	53	91	89.9	1.1	8	5
SFP203W-0660-08-01RA-H	6.6	20.9	34	79	77.9	1.1	8	3
SFP205W-0660-08-01RA-H	6.6	34.1	53	91	89.9	1.1	8	5
SFP203W-0670-08-01RA-H	6.7	21.2	34	79	77.9	1.1	8	3
SFP205W-0670-08-01RA-H	6.7	34.6	53	91	89.9	1.1	8	5
SFP203W-0675-08-01RA-H	6.75	21.3	34	79	77.9	1.1	8	3
SFP205W-0675-08-01RA-H	6.75	34.8	53	91	89.9	1.1	8	5
SFP203W-0680-08-01RA-H	6.8	21.5	34	79	77.9	1.1	8	3
SFP205W-0680-08-01RA-H	6.8	35.1	53	91	89.9	1.1	8	5
SFP203W-0690-08-01RA-H	6.9	21.8	34	79	77.8	1.2	8	3
SFP205W-0690-08-01RA-H	6.9	35.6	53	91	89.8	1.2	8	5
SFP203W-0700-08-01RA-H	7	22.1	34	79	77.8	1.2	8	3
SFP205W-0700-08-01RA-H	7	36.1	53	91	89.8	1.2	8	5
SFP203W-0710-08-01RA-H	7.1	22.4	41	79	77.8	1.2	8	3
SFP205W-0710-08-01RA-H	7.1	36.6	53	91	89.8	1.2	8	5
SFP203W-0714-08-01RA-H	7.14	22.6	41	79	77.8	1.2	8	3
SFP205W-0714-08-01RA-H	7.14	36.9	53	91	89.8	1.2	8	5
SFP203W-0720-08-01RA-H	7.2	22.8	41	79	77.8	1.2	8	3
SFP205W-0720-08-01RA-H	7.2	37.2	53	91	89.8	1.2	8	5
SFP203W-0730-08-01RA-H	7.3	23.1	41	79	77.8	1.2	8	3
SFP205W-0730-08-01RA-H	7.3	37.7	53	91	89.8	1.2	8	5
SFP203W-0740-08-01RA-H	7.4	23.4	41	79	77.7	1.3	8	3
SFP205W-0740-08-01RA-H	7.4	38.2	53	91	89.7	1.3	8	5
SFP203W-0750-08-01RA-H	7.5	23.7	41	79	77.7	1.3	8	3
SFP205W-0750-08-01RA-H	7.5	38.7	53	91	89.7	1.3	8	5
SFP205W-0754-08-01RA-H	7.54	38.9	53	91	89.7	1.3	8	5
SFP203W-0760-08-01RA-H	7.6	24	41	79	77.7	1.3	8	3
SFP205W-0760-08-01RA-H	7.6	38.2	53	91	89.7	1.3	8	5
SFP203W-0770-08-01RA-H	7.7	24.3	41	79	77.7	1.3	8	3
SFP205W-0770-08-01RA-H	7.7	39.7	53	91	89.7	1.3	8	5
SFP203W-0780-08-01RA-H	7.8	24.7	41	79	77.7	1.3	8	3
SFP205W-0780-08-01RA-H	7.8	40.3	53	91	89.7	1.3	8	5
SFP203W-0790-08-01RA-H	7.9	25	41	79	77.7	1.3	8	3
SFP205W-0790-08-01RA-H	7.9	40.8	53	91	89.7	1.3	8	5
SFP203W-0794-08-01RA-H	7.94	25.1	41	79	77.6	1.4	8	3
SFP205W-0794-08-01RA-H	7.94	41	53	91	89.6	1.4	8	5
SFP203W-0800-08-01RA-H	8	25.3	41	79	77.6	1.4	8	3
SFP205W-0800-08-01RA-H	8	41.3	53	91	89.6	1.4	8	5

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFP203W-0810-10-01RA-H	8.1	25.6	47	89	87.6	1.4	10	3
SFP205W-0810-10-01RA-H	8.1	41.8	61	103	101.6	1.4	10	5
SFP205W-0815-10-01RA-H	8.15	42.1	53	91	89.6	1.4	10	5
SFP203W-0820-10-01RA-H	8.2	25.9	47	89	87.6	1.4	10	3
SFP205W-0820-10-01RA-H	8.2	42.3	61	103	101.6	1.4	10	5
SFP203W-0830-10-01RA-H	8.3	26.3	47	89	87.6	1.4	10	3
SFP205W-0830-10-01RA-H	8.3	42.9	61	103	101.6	1.4	10	5
SFP205W-0833-10-01RA-H	8.33	43	61	103	101.6	1.4	10	5
SFP203W-0840-10-01RA-H	8.4	26.6	47	89	87.6	1.4	10	3
SFP205W-0840-10-01RA-H	8.4	43.4	61	103	101.6	1.4	10	5
SFP203W-0850-10-01RA-H	8.5	26.9	47	89	87.6	1.4	10	3
SFP205W-0850-10-01RA-H	8.5	43.9	61	103	101.6	1.4	10	5
SFP203W-0860-10-01RA-H	8.6	27.2	47	89	87.5	1.5	10	3
SFP205W-0860-10-01RA-H	8.6	44.4	61	103	101.5	1.5	10	5
SFP203W-0870-10-01RA-H	8.7	27.5	47	89	87.5	1.5	10	3
SFP205W-0870-10-01RA-H	8.7	44.9	61	103	101.5	1.5	10	5
SFP203W-0873-10-01RA-H	8.73	27.6	47	89	87.5	1.5	10	3
SFP205W-0873-10-01RA-H	8.73	45.1	61	103	101.5	1.5	10	5
SFP203W-0880-10-01RA-H	8.8	27.8	47	89	87.5	1.5	10	3
SFP205W-0880-10-01RA-H	8.8	45.4	61	103	101.5	1.5	10	5
SFP203W-0890-10-01RA-H	8.9	28.1	47	89	87.5	1.5	10	3
SFP205W-0890-10-01RA-H	8.9	45.9	61	103	101.5	1.5	10	5
SFP203W-0900-10-01RA-H	9	28.5	47	89	87.5	1.5	10	3
SFP205W-0900-10-01RA-H	9	46.5	61	103	101.5	1.5	10	5
SFP203W-0910-10-01RA-H	9.1	28.8	47	89	87.5	1.5	10	3
SFP205W-0910-10-01RA-H	9.1	47	61	103	101.5	1.5	10	5
SFP203W-0920-10-01RA-H	9.2	29.1	47	89	87.4	1.6	10	3
SFP205W-0920-10-01RA-H	9.2	47.5	61	103	101.4	1.6	10	5
SFP203W-0930-10-01RA-H	9.3	29.4	47	89	87.4	1.6	10	3
SFP205W-0930-10-01RA-H	9.3	48	61	103	101.4	1.6	10	5
SFP203W-0940-10-01RA-H	9.4	29.7	47	89	87.4	1.6	10	3
SFP205W-0940-10-01RA-H	9.4	48.5	61	103	101.4	1.6	10	5
SFP203W-0950-10-01RA-H	9.5	30	47	89	87.4	1.6	10	3
SFP205W-0950-10-01RA-H	9.5	48.7	61	103	101.4	1.6	10	5
SFP203W-0952-10-01RA-H	9.52	30.1	47	89	87.4	1.6	10	3
SFP205W-0952-10-01RA-H	9.52	48.6	61	103	101.4	1.6	10	5
SFP205W-0955-10-01RA-H	9.55	48.6	61	103	101.4	1.6	10	5
SFP203W-0960-10-01RA-H	9.6	30.3	47	89	87.4	1.6	10	3
SFP205W-0960-10-01RA-H	9.6	48.5	61	103	101.4	1.6	10	5
SFP203W-0970-10-01RA-H	9.7	30.7	47	89	87.3	1.7	10	3
SFP205W-0970-10-01RA-H	9.7	48.4	61	103	101.4	1.6	10	5

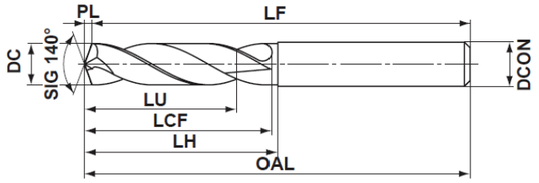
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





External Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
SFP203W-0980-10-01RA-H	9.8	31	47	89	87.3	1.7	10	3
SFP205W-0980-10-01RA-H	9.8	48.3	61	103	101.3	1.7	10	5
SFP203W-0990-10-01RA-H	9.9	31.3	47	89	87.3	1.7	10	3
SFP205W-0990-10-01RA-H	9.9	48.1	61	103	101.3	1.7	10	5
SFP203W-1000-10-01RA-H	10	31.6	47	89	87.3	1.7	10	3
SFP205W-1000-10-01RA-H	10	50	61	103	101.3	1.7	10	5
SFP203W-1010-12-01RA-H	10.1	31.9	55	102	100.3	1.7	12	3
SFP205W-1010-12-01RA-H	10.1	52.1	71	118	116.3	1.7	12	5
SFP203W-1020-12-01RA-H	10.2	32.3	55	102	100.3	1.7	12	3
SFP205W-1020-12-01RA-H	10.2	52.7	71	118	116.3	1.7	12	5
SFP203W-1030-12-01RA-H	10.3	32.6	55	102	100.2	1.8	12	3
SFP205W-1030-12-01RA-H	10.3	53.2	71	118	116.2	1.8	12	5
SFP203W-1032-12-01RA-H	10.32	32.6	55	102	100.2	1.8	12	3
SFP205W-1032-12-01RA-H	10.32	53.3	71	118	116.2	1.8	12	5
SFP203W-1040-12-01RA-H	10.4	32.9	55	102	100.2	1.8	12	3
SFP205W-1040-12-01RA-H	10.4	53.7	71	118	116.2	1.8	12	5
SFP203W-1050-12-01RA-H	10.5	33.2	55	102	100.2	1.8	12	3
SFP205W-1050-12-01RA-H	10.5	54.2	71	118	116.2	1.8	12	5
SFP203W-1060-12-01RA-H	10.6	33.5	55	102	100.2	1.8	12	3
SFP205W-1060-12-01RA-H	10.6	54.7	71	118	116.2	1.8	12	5
SFP203W-1070-12-01RA-H	10.7	33.8	55	102	100.2	1.8	12	3
SFP205W-1070-12-01RA-H	10.7	55.2	71	118	116.2	1.8	12	5
SFP205W-1071-12-01RA-H	10.71	55.3	71	118	116.2	1.8	12	5
SFP203W-1080-12-01RA-H	10.8	34.2	55	102	100.2	1.8	12	3
SFP205W-1080-12-01RA-H	10.8	55.8	71	118	116.2	1.8	12	5
SFP203W-1090-12-01RA-H	10.9	34.5	55	102	100.2	1.8	12	3
SFP205W-1090-12-01RA-H	10.9	56.3	71	118	116.1	1.9	12	5
SFP203W-1100-12-01RA-H	11	34.8	55	102	100.1	1.9	12	3
SFP205W-1100-12-01RA-H	11	56.8	71	118	116.1	1.9	12	5
SFP203W-1110-12-01RA-H	11.1	35.1	55	102	100.1	1.9	12	3
SFP205W-1110-12-01RA-H	11.1	57.3	71	118	116.1	1.9	12	5
SFP203W-1111-12-01RA-H	11.11	35.1	55	102	100.1	1.9	12	3
SFP203W-1120-12-01RA-H	11.2	35.4	55	102	100.1	1.9	12	3
SFP205W-1120-12-01RA-H	11.2	57.6	71	118	116.1	1.9	12	5
SFP203W-1130-12-01RA-H	11.3	35.7	55	102	100.1	1.9	12	3
SFP205W-1130-12-01RA-H	11.3	57.4	71	118	116.1	1.9	12	5
SFP203W-1140-12-01RA-H	11.4	36.1	55	102	100	2	12	3
SFP205W-1140-12-01RA-H	11.4	36.2	71	118	116.1	1.9	12	5
SFP203W-1150-12-01RA-H	11.5	36.4	55	102	100	2	12	3
SFP205W-1150-12-01RA-H	11.5	57.2	71	118	116	2	12	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
SFP203W-1160-12-01RA-H	11.6	36.7	55	102	100	2	12	3
SFP205W-1160-12-01RA-H	11.6	57.1	71	118	116	2	12	5
SFP203W-1170-12-01RA-H	11.7	37	55	102	100	2	12	3
SFP205W-1170-12-01RA-H	11.7	57	71	118	116	2	12	5
SFP203W-1180-12-01RA-H	11.8	37.3	55	102	100	2	12	3
SFP205W-1180-12-01RA-H	11.8	56.8	71	118	116	2	12	5
SFP203W-1190-12-01RA-H	11.9	37.6	55	102	100	2	12	3
SFP205W-1190-12-01RA-H	11.9	58.2	71	118	116	2	12	5
SFP203W-1200-12-01RA-H	12	38	55	102	99.9	2.1	12	3
SFP205W-1200-12-01RA-H	12	60	71	118	115.9	2.1	12	5
SFP203W-1210-14-01RA-H	12.1	38.3	60	107	104.9	2.1	14	3
SFP205W-1210-14-01RA-H	12.1	62.5	77	124	121.9	2.1	14	5
SFP203W-1220-14-01RA-H	12.2	38.6	60	107	104.9	2.1	14	3
SFP205W-1220-14-01RA-H	12.2	62.4	77	124	121.9	2.1	14	5
SFP203W-1230-14-01RA-H	12.3	38.9	60	107	104.9	2.1	14	3
SFP205W-1230-14-01RA-H	12.3	62.2	77	124	121.9	2.1	14	5
SFP203W-1240-14-01RA-H	12.4	41.4	60	107	104.9	2.1	14	3
SFP205W-1240-14-01RA-H	12.4	58.4	77	124	121.9	2.1	14	5
SFP203W-1250-14-01RA-H	12.5	39.5	60	107	104.9	2.1	14	3
SFP205W-1250-14-01RA-H	12.5	63	77	124	121.9	2.1	14	5
SFP203W-1260-14-01RA-H	12.6	39.9	60	107	104.8	2.2	14	3
SFP205W-1260-14-01RA-H	12.6	63.5	77	124	121.9	2.1	14	5
SFP203W-1270-14-01RA-H	12.7	40.2	60	107	104.8	2.2	14	3
SFP205W-1270-14-01RA-H	12.7	64	77	124	121.8	2.2	14	5
SFP203W-1280-14-01RA-H	12.8	40.5	60	107	104.8	2.2	14	3
SFP205W-1280-14-01RA-H	12.8	64.6	77	124	121.8	2.2	14	5
SFP203W-1290-14-01RA-H	12.9	40.7	60	107	104.8	2.2	14	3
SFP205W-1290-14-01RA-H	12.9	57.7	77	124	121.8	2.2	14	5
SFP203W-1300-14-01RA-H	13	41.1	60	107	104.8	2.2	14	3
SFP205W-1300-14-01RA-H	13	61.4	77	124	121.8	2.2	14	5
SFP203W-1310-14-01RA-H	13.1	41.4	60	107	104.7	2.3	14	3
SFP205W-1310-14-01RA-H	13.1	61.3	77	124	121.7	2.3	14	5
SFP203W-1320-14-01RA-H	13.2	40.2	60	107	104.7	2.3	14	3
SFP205W-1320-14-01RA-H	13.2	57.2	77	124	121.7	2.3	14	5
SFP205W-1325-14-01RA-H	13.25	61.1	77	124	121.7	2.3	14	5
SFP203W-1330-14-01RA-H	13.3	40.1	60	107	104.7	2.3	14	3
SFP205W-1330-14-01RA-H	13.3	57.1	77	124	121.7	2.3	14	5
SFP203W-1340-14-01RA-H	13.4	39.9	60	107	104.7	2.3	14	3
SFP205W-1340-14-01RA-H	13.4	56.9	77	124	121.7	2.3	14	5
SFP203W-1350-14-01RA-H	13.5	42.7	60	107	104.7	2.3	14	3
SFP205W-1350-14-01RA-H	13.5	60.8	77	124	121.7	2.3	14	5

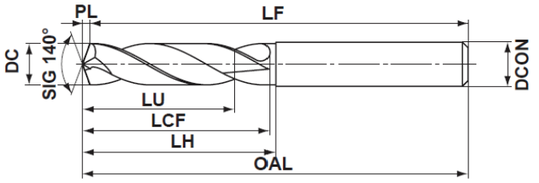
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





External Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
SFP203W-1360-14-01RA-H	13.6	39.6	60	107	104.7	2.3	14	3
SFP205W-1360-14-01RA-H	13.6	56.6	77	124	121.7	2.3	14	5
SFP203W-1370-14-01RA-H	13.7	39.5	60	107	104.7	2.3	14	3
SFP205W-1370-14-01RA-H	13.7	56.5	77	124	121.7	2.3	14	5
SFP205W-1375-14-01RA-H	13.75	60.5	77	124	121.6	2.4	14	5
SFP203W-1380-14-01RA-H	13.8	43.4	60	107	104.6	2.4	14	3
SFP205W-1380-14-01RA-H	13.8	60.4	77	124	121.6	2.4	14	5
SFP205W-1389-14-01RA-H	13.89	60.3	77	124	121.6	2.4	14	5
SFP203W-1390-14-01RA-H	13.9	39.2	60	107	104.6	2.4	14	3
SFP205W-1390-14-01RA-H	13.9	56.2	77	124	121.6	2.4	14	5
SFP203W-1400-14-01RA-H	14	44.3	60	107	104.6	2.4	14	3
SFP205W-1400-14-01RA-H	14	63	77	124	121.6	2.4	14	5
SFP203W-1410-16-01RA-H	14.1	43.9	65	115	112.6	2.4	16	3
SFP205W-1410-16-01RA-H	14.1	61.9	83	133	130.6	2.4	16	5
SFP203W-1420-16-01RA-H	14.2	43.7	65	115	112.5	2.5	16	3
SFP205W-1420-16-01RA-H	14.2	61.7	83	133	130.5	2.5	16	5
SFP203W-1425-16-01RA-H	14.25	45	65	115	112.5	2.5	16	3
SFP205W-1425-16-01RA-H	14.25	68.8	83	133	130.5	2.5	16	5
SFP203W-1429-16-01RA-H	14.29	45.2	65	115	112.5	2.5	16	3
SFP205W-1429-16-01RA-H	14.29	68.7	83	133	130.5	2.5	16	5
SFP203W-1430-16-01RA-H	14.3	43.6	65	115	112.5	2.5	16	3
SFP205W-1430-16-01RA-H	14.3	61.6	83	133	130.5	2.5	16	5
SFP203W-1440-16-01RA-H	14.4	43.4	65	115	112.5	2.5	16	3
SFP205W-1440-16-01RA-H	14.4	61.4	83	133	130.5	2.5	16	5
SFP203W-1450-16-01RA-H	14.5	45.8	65	115	112.5	2.5	16	3
SFP205W-1450-16-01RA-H	14.5	68.5	83	133	130.5	2.5	16	5
SFP203W-1460-16-01RA-H	14.6	43.1	65	115	112.5	2.5	16	3
SFP205W-1460-16-01RA-H	14.6	61.1	83	133	130.5	2.5	16	5
SFP203W-1469-16-01RA-H	14.69	46.4	65	115	112.5	2.5	16	3
SFP203W-1470-16-01RA-H	14.7	43.0	65	115	112.5	2.5	16	3
SFP205W-1470-16-01RA-H	14.7	61.0	83	133	130.5	2.5	16	5
SFP203W-1480-16-01RA-H	14.8	46.9	65	115	112.4	2.6	16	3
SFP205W-1480-16-01RA-H	14.8	68.2	83	133	130.4	2.6	16	5
SFP203W-1490-16-01RA-H	14.9	42.7	65	115	112.4	2.6	16	3
SFP205W-1490-16-01RA-H	14.9	60.7	83	133	130.4	2.6	16	5
SFP203W-1500-16-01RA-H	15	47.4	65	115	112.4	2.6	16	3
SFP205W-1500-16-01RA-H	15	68	83	133	130.4	2.6	16	5
SFP203W-1510-16-01RA-H	15.1	42.4	65	115	112.3	2.7	16	3
SFP205W-1510-16-01RA-H	15.1	60.4	83	133	130.3	2.7	16	5
SFP203W-1520-16-01RA-H	15.2	42.2	65	115	112.3	2.7	16	3
SFP205W-1520-16-01RA-H	15.2	60.2	83	133	130.3	2.7	16	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
SFP203W-1530-16-01RA-H	15.3	42.1	65	115	112.3	2.7	16	3
SFP205W-1530-16-01RA-H	15.3	60.1	83	133	130.3	2.7	16	5
SFP203W-1540-16-01RA-H	15.4	41.9	65	115	112.3	2.7	16	3
SFP205W-1540-16-01RA-H	15.4	59.9	83	133	130.3	2.7	16	5
SFP203W-1550-16-01RA-H	15.5	49	65	115	112.3	2.7	16	3
SFP205W-1550-16-01RA-H	15.5	67.5	83	133	130.3	2.7	16	5
SFP203W-1560-16-01RA-H	15.6	41.6	65	115	112.2	2.8	16	3
SFP205W-1560-16-01RA-H	15.6	59.6	83	133	130.2	2.8	16	5
SFP203W-1570-16-01RA-H	15.7	41.5	65	115	112.2	2.8	16	3
SFP205W-1570-16-01RA-H	15.7	59.5	83	133	130.2	2.8	16	5
SFP203W-1580-16-01RA-H	15.8	49.2	65	115	112.2	2.8	16	3
SFP205W-1580-16-01RA-H	15.8	67.2	83	133	130.2	2.8	16	5
SFP203W-1587-16-01RA-H	15.87	49.1	65	115	112.2	2.8	16	3
SFP203W-1590-16-01RA-H	15.9	41.2	65	115	112.2	2.8	16	3
SFP205W-1590-16-01RA-H	15.9	59.2	83	133	130.2	2.8	16	5
SFP203W-1600-16-01RA-H	16	49	65	115	112.2	2.8	16	3
SFP205W-1600-16-01RA-H	16	67	83	133	130.2	2.8	16	5
SFP203W-1650-18-01RA-H	16.5	52.1	73	123	120.2	2.8	18	3
SFP205W-1650-18-01RA-H	16.5	76.5	93	143	140.2	2.8	18	5
SFP203W-1680-18-01RA-H	16.8	53	73	123	120.2	2.8	18	3
SFP205W-1680-18-01RA-H	16.8	76.2	93	143	140.2	2.8	18	5
SFP203W-1700-18-01RA-H	17	54.1	73	123	120.2	2.8	18	3
SFP205W-1700-18-01RA-H	17	76	93	143	140.2	2.8	18	5
SFP203W-1750-18-01RA-H	17.5	55.2	73	123	120.2	2.8	18	3
SFP205W-1750-18-01RA-H	17.5	75.5	93	143	140.2	2.8	18	5
SFP203W-1780-18-01RA-H	17.8	56.2	73	123	120.2	2.8	18	3
SFP205W-1780-18-01RA-H	17.8	75.2	93	143	140.1	2.9	18	5
SFP203W-1800-18-01RA-H	18	56.8	73	123	120.1	2.9	18	3
SFP205W-1800-18-01RA-H	18	78.6	93	143	140.1	2.9	18	5
SFP203W-1850-20-01RA-H	18.5	58.4	79	131	128.1	2.9	20	3
SFP205W-1850-20-01RA-H	18.5	84	101	153	150.1	2.9	20	5
SFP203W-1880-20-01RA-H	18.8	59.3	79	131	128.1	2.9	20	3
SFP205W-1880-20-01RA-H	18.8	86	101	153	150.1	2.9	20	5
SFP203W-1900-20-01RA-H	19	59.9	79	131	128.1	2.9	20	3
SFP203W-2000-20-01RA-H	20	63	79	131	127.9	3.1	20	3

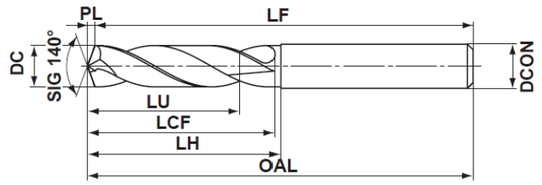
① All intermediate sizes within diameter range & all intermediate lengths within limits, offered via special

② Cutting data, please go to page 18

YPP Drill® SFP

High-Performance Solid Carbide Drill





External Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR

YPP Drill® SFP

High-Performance Solid Carbide Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
M	Austenitic Stainless Steel					
	M1.0.C.UT	Cast+Untreated	165	48	60	72
	M1.0.Z.AQ	Annealed/Quenched	200	48	60	72
	M1.0.Z.PH	PH-Hardened	350	44	55	66
	M1.1.Z.AQ	Machinability Improved	165	48	60	72
	M1.2.Z.AQ	Free Cutting	200	48	60	72
	M1.3.C.AQ	Ti-Stabilized+Cast	200	48	60	72
	M1.3.Z.AQ	Ti-Stabilized	200	48	60	72
	M1.4.Z.AQ	High Strength	250	64	80	96
	Super Austenitic (Ni>20%) Stainless Steel					
	M2.0.C.AQ	Cast+Annealed/Quenched	165	30	40	50
	M2.0.Z.AQ	Annealed/Quenched	200	30	40	50
	Duplex (Austenitic/Ferritic) Stainless Steel					
	M3.1.Z.AQ >60%	Ferrite (N<0.10%) >60%	250	40	50	70
	M3.2.Z.AQ <60%	Ferrite (N≥0.10%) <60%	250	40	50	70

Drill Diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.05	0.07	0.1
4	0.08	0.1	0.12
6	0.09	0.11	0.13
8	0.1	0.12	0.14
10	0.13	0.14	0.17
12	0.13	0.16	0.19
16	0.14	0.2	0.23
20	0.17	0.22	0.25

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

④ Under external coolant condition, please adjust cutting speed to secure good chips formation and evacuation

⑤ Under external coolant condition, please decrease feed per revolution to secure chips evacuation

YPP Drill® SFP

High-Performance Solid Carbide Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
K	Malleable Iron					
	K1.1.C.NS	Ferritic Pearlitic	200	80	100	120
	Gray Cast Iron (GCI)					
	K2.1.C.UT	Low Tensile Strength	180	100	120	140
	K2.2.C.UT	High Tensile Strength	245	80	100	120
	K2.3.C.UT	High Tensile Strength	175	100	120	140
	Nodular Cast Iron (NCI)					
	K3.1.C.UT	Ferritic Pearlitic	155	100	120	140
	K3.2.C.UT	Perlitic	215	80	100	120
	K3.3.C.UT	Perlitic	265	100	120	140
	K3.5.C.UT	Perlitic	190	100	120	140
	K5.1.C.UT	Austempered Ductile Iron (ADI)	300	60	80	100

Drill diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.08	0.1	0.12
4	0.1	0.12	0.14
6	0.12	0.16	0.18
8	0.16	0.2	0.24
10	0.2	0.25	0.3
12	0.22	0.28	0.33
16	0.25	0.32	0.38
20	0.26	0.34	0.4

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

④ Under external coolant condition, please adjust cutting speed to secure good chips formation and evacuation

⑤ Under external coolant condition, please decrease feed per revolution to secure chips evacuation

YPP Drill® SFP

High-Performance Solid Carbide Drill

Internal Coolant

ISO	MC No.	Component material	Hardness Brinell	Cutting Speed VC(m/min)	Drill diameter (mm)			
					3-6	6.01-10	10.01-14	14.01-20
					Feed Fn(mm/r) *			
S	S1.0.U.AN	Hardened HRSA	200	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S1.0.U.AG		280	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.AN	Nickel Base HRSA	250	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.AG		350	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.UT		275	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.NS		320	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.Z.AN	Cobalt Base HRSA	200	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.Z.AG		300	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.C.NS		320	15 - 25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S4.1.Z.UT	Ti Alloy	200	40 - 60	0.06-0.12	0.08-0.20	0.14-0.28	0.10-0.16
	S4.2.Z.AN		320	40 - 60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.3.Z.AN		330	40 - 60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.3.Z.AG		375	40 - 60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.4.Z.AN		330	40 - 60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.4.Z.AG		410	40 - 60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)	Drill diameter (mm)			
					3-6	6.01-10	10.01-14	14.01-20
					Feed Fn(mm/r) *			
H	H1.1.Z.HA	Hardened HRSA	50	16 - 24	0.05-0.12	0.08-0.14	0.10-0.16	0.12-0.2
	H2.0.C.UT.4	Chilled Cast Iron	64	14 - 20	0.05-0.12	0.08-0.14	0.10-0.16	0.12-0.2

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

④ Under external coolant condition, please adjust cutting speed to secure good chips formation and evacuation

⑤ Under external coolant condition, please decrease feed per revolution to secure chips evacuation

YPP Drill® SFP

High-Performance Solid Carbide Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
N	Aluminium					
	N1.2.Z.UT	Commercial Pure	60	110	150	180
	N1.2.Z.AG	AlSi Alloys, Si ≤ 1%	100	110	150	180
	N1.3.C.UT	Cast, Non-Aging	75	110	150	180
	N1.3.C.UT	Cast or Cast and Aged	90	110	130	160
	N1.4.C.NS	AlSi Cast Alloys, Si ≥ 13%	130	80	100	120
	Copper Based Alloys					
	N3.3.U.UT	Free Cutting Alloys (Pb>1%)	110	70	90	110
	N3.1.U.UT	Non-Leaded Copper Alloys (Incl. Electrolytic Copper)	100	70	80	100

Drill Diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.08	0.18	0.28
4	0.1	0.19	0.28
6	0.16	0.28	0.35
8	0.16	0.2	0.24
10	0.2	0.4	0.8
12	0.22	0.5	0.8
16	0.3	0.6	1
20	0.3	0.6	1

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

④ Under external coolant condition, please adjust cutting speed to secure good chips formation and evacuation

⑤ Under external coolant condition, please decrease feed per revolution to secure chips evacuation

Versatile Solution

Customized Solution

ISO Workpiece Materials

M



YPP Drill® SFM

INTRODUCTION

Versatile Solid Carbide Drill for Stainless Steel

Overview & Applications

- General purpose machining for stainless steel
- Including austenitic SS, super austenitic SS, ferritic SS, and duplex stainless steel
- Hole tolerance H8–H9
- Diameter range: 3.0–20.0 mm
- Drill length above 8xDC

Features & Benefits

- Cover both stable and unstable cutting conditions
- Provide internal coolant solutions
- Curve cutting edge generates low cutting force
- Variant clearance angle which provide cutting edge reliability
- Chips evacuation improvement thanks to chips flute new design
- Advanced ER treatment applied on cutting edge, which reduce risk of cutting edge breakage

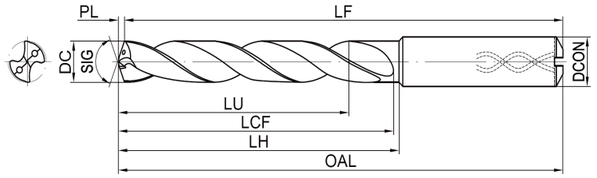
Ordering Code

S	F	M	2	03	N	—	0900	—	10A	—	01DP
↓	↓	↓	↓	↓	↓		↓		↓		↓
s – Product Family	F – Cutting Edge Type	M – Stainless Steel	2 – 2 Cutting Edge	03 – 3xDC	N – Internal Coolant		0900 – Drill Diameter 0900–DC9mm		10 – Shank Diameter A – HA Cylindrical Shank		01 – Substrate AK40 DP – Coating

YPP Drill® SFM

Versatile Solid Carbide Drill for Stainless Steel





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFM203N-0300-04A-01DP	3	9.5	20	62	61.5	0.5	4	3
SFM205N-0300-04A-01DP	3	15.5	26	66	65.5	0.5	4	5
SFM208N-0300-04A-01DP	3	24.5	40	78	77.5	0.5	4	8
SFM203N-0310-04A-01DP	3.1	9.8	20	62	61.5	0.5	4	3
SFM208N-0310-04A-01DP	3.1	25.3	40	78	77.5	0.5	4	8
SFM205N-0318-04A-01DP	3.18	16.4	26	66	65.5	0.5	4	5
SFM205N-0320-04A-01DP	3.2	16.5	26	66	65.5	0.5	4	5
SFM203N-0330-04A-01DP	3.3	10.5	20	62	61.4	0.6	4	3
SFM205N-0330-04A-01DP	3.3	17.1	26	66	65.4	0.6	4	5
SFM208N-0330-04A-01DP	3.3	27	40	78	77.4	0.6	4	8
SFM208N-0340-04A-01DP	3.4	27	40	78	73.4	0.6	4	8
SFM203N-0350-04A-01DP	3.5	11.1	20	62	61.4	0.6	4	3
SFM205N-0350-04A-01DP	3.5	18.1	26	66	65.4	0.6	4	5
SFM208N-0350-04A-01DP	3.5	27.3	40	78	77.4	0.6	4	8
SFM203N-0360-04A-01DP	3.6	11.4	20	62	61.4	0.6	4	3
SFM205N-0370-04A-01DP	3.7	19.1	26	66	65.4	0.6	4	5
SFM208N-0370-04A-01DP	3.7	27.9	40	78	77.4	0.6	4	8
SFM203N-0380-04A-01DP	3.8	12.1	24	66	65.4	0.6	4	3
SFM205N-0380-04A-01DP	3.8	31.1	34	74	73.4	0.6	4	5
SFM208N-0380-04A-01DP	3.8	31.1	49	87	86.4	0.6	4	8
SFM203N-0400-04A-01DP	4	12.7	24	66	65.3	0.7	4	3
SFM205N-0400-04A-01DP	4	20.7	34	74	73.3	0.7	4	5
SFM208N-0400-04A-01DP	4	32.7	49	87	86.3	0.7	4	8
SFM203N-0420-06A-01DP	4.2	13.3	24	66	65.3	0.7	6	3
SFM205N-0420-06A-01DP	4.2	21.7	34	74	73.3	0.7	6	5
SFM208N-0420-06A-01DP	4.2	34.3	49	87	86.3	0.7	6	8
SFM203N-0430-06A-01DP	4.3	13.7	24	66	65.2	0.7	6	3
SFM205N-0430-06A-01DP	4.3	22.3	34	74	73.2	0.7	6	5
SFM208N-0430-06A-01DP	4.3	35.2	49	87	86.3	0.7	6	8
SFM203N-0437-06A-01DP	4.37	13.8	24	66	65.3	0.7	6	3
SFM205N-0437-06A-01DP	4.37	22.5	34	74	73.3	0.7	6	5
SFM203N-0440-06A-01DP	4.4	14.1	24	66	65.3	0.7	6	3
SFM205N-0440-06A-01DP	4.4	22.8	34	74	73.3	0.7	6	5
SFM208N-0440-06A-01DP	4.4	36	49	87	86.3	0.7	6	8
SFM203N-0450-06A-01DP	4.5	14.3	24	66	65.3	0.7	6	3
SFM205N-0450-06A-01DP	4.5	23.3	34	74	73.3	0.7	6	5
SFM208N-0450-06A-01DP	4.5	36.8	49	87	86.3	0.7	6	8
SFM205N-0460-06A-01DP	4.6	23.8	34	74	73.2	0.8	6	5
SFM208N-0460-06A-01DP	4.6	36.8	49	87	86.2	0.8	6	8
SFM205N-0470-06A-01DP	4.7	24.3	34	74	73.2	0.8	6	5
SFM203N-0476-06A-01DP	4.76	15	28	66	65.2	0.8	6	3

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFM203N-0480-06A-01DP	4.8	15.2	28	66	65.2	0.8	6	3
SFM208N-0480-06A-01DP	4.8	39.2	56	94	93.2	0.8	6	8
SFM205N-0490-06A-01DP	4.9	25.3	44	82	81.2	0.8	6	5
SFM203N-0500-06A-01DP	5	15.8	28	66	65.2	0.8	6	3
SFM205N-0500-06A-01DP	5	25.8	44	82	81.2	0.8	6	5
SFM208N-0500-06A-01DP	5	40.8	56	94	93.2	0.8	6	8
SFM203N-0510-06A-01DP	5.1	16.1	28	66	65.2	0.8	6	3
SFM205N-0510-06A-01DP	5.1	26.3	44	82	81.2	0.8	6	5
SFM203N-0516-06A-01DP	5.16	16.3	28	66	65.2	0.8	6	3
SFM203N-0520-06A-01DP	5.2	16.4	28	66	65.1	0.9	6	3
SFM205N-0520-06A-01DP	5.2	26.8	44	82	81.1	0.9	6	5
SFM205N-0530-06A-01DP	5.3	27.3	44	82	81.1	0.9	6	5
SFM203N-0550-06A-01DP	5.5	17.4	28	66	65.1	0.9	6	3
SFM205N-0550-06A-01DP	5.5	28.4	44	82	81.1	0.9	6	5
SFM208N-0550-06A-01DP	5.5	44.9	56	94	93.1	0.9	6	8
SFM203N-0556-06A-01DP	5.56	17.6	28	66	65.1	0.9	6	3
SFM203N-0580-06A-01DP	5.8	17.6	28	66	65	1	6	3
SFM208N-0580-06A-01DP	5.8	47.3	56	94	93	1	6	8
SFM205N-0590-06A-01DP	5.9	30.4	44	82	81	1	6	5
SFM203N-0600-06A-01DP	6	18.9	28	66	65	1	6	3
SFM205N-0600-06A-01DP	6	30.9	44	82	81	1	6	5
SFM208N-0600-06A-01DP	6	48.9	56	94	93	1	6	8
SFM205N-0610-08A-01DP	6.1	31.5	53	91	90	1	8	5
SFM208N-0610-08A-01DP	6.1	49.8	67	106	105	1	8	8
SFM205N-0620-08A-01DP	6.2	32	53	91	89.9	1.1	8	5
SFM208N-0620-08A-01DP	6.2	50.6	67	106	104.9	1.1	8	8
SFM203N-0635-08A-01DP	6.35	20.1	34	79	78	1.1	8	3
SFM205N-0635-08A-01DP	6.35	32.8	53	91	90	1.1	8	5
SFM208N-0635-08A-01DP	6.35	51.8	67	106	104.9	1.1	8	8
SFM203N-0650-08A-01DP	6.5	20.6	34	79	77.9	1.1	8	3
SFM205N-0650-08A-01DP	6.5	33.6	53	91	89.9	1.1	8	5
SFM208N-0650-08A-01DP	6.5	52	67	106	104.9	1.1	8	8
SFM203N-0660-08A-01DP	6.6	20.9	34	79	77.9	1.1	8	3
SFM205N-0660-08A-01DP	6.6	34.1	53	91	89.9	1.1	8	5
SFM203N-0670-08A-01DP	6.7	21.2	34	79	77.9	1.1	8	3
SFM205N-0670-08A-01DP	6.7	34.6	53	91	89.9	1.1	8	5
SFM203N-0675-08A-01DP	6.75	21.3	34	79	77.9	1.1	8	3
SFM203N-0680-08A-01DP	6.8	21.5	34	79	77.9	1.1	8	3
SFM205N-0680-08A-01DP	6.8	35.1	53	91	89.9	1.1	8	5
SFM208N-0680-08A-01DP	6.8	54	67	106	104.9	1.1	8	8
SFM203N-0690-08A-01DP	6.9	21.8	34	79	77.8	1.2	8	3

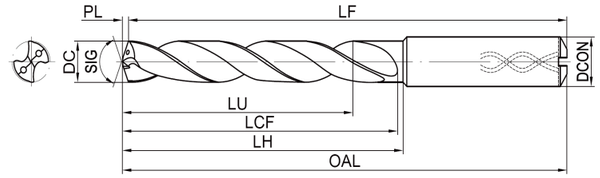
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 28

YPP Drill® SFM

Versatile Solid Carbide Drill for Stainless Steel





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFM205N-0690-08A-01DP	6.9	35.6	53	91	89.8	1.2	8	5
SFM208N-0690-08A-01DP	6.9	55	67	106	104.8	1.2	8	8
SFM203N-0700-08A-01DP	7	22.1	34	79	77.8	1.2	8	3
SFM205N-0700-08A-01DP	7	36.1	53	91	89.8	1.2	8	5
SFM208N-0700-08A-01DP	7	55	67	106	104.8	1.2	8	8
SFM208N-0710-08A-01DP	7.1	57	72	110	108.8	1.2	8	8
SFM203N-0714-08A-01DP	7.14	22.6	41	79	77.8	1.2	8	3
SFM208N-0714-08A-01DP	7.14	58.3	72	110	108.8	1.2	8	8
SFM203N-0740-08A-01DP	7.4	23.4	41	79	77.7	1.3	8	3
SFM203N-0750-08A-01DP	7.5	23.7	41	79	77.7	1.3	8	3
SFM205N-0750-08A-01DP	7.5	38.7	53	91	89.7	1.3	8	5
SFM203N-0780-08A-01DP	7.8	24.7	41	79	77.7	1.3	8	3
SFM205N-0780-08A-01DP	7.8	40.3	53	91	89.7	1.3	8	5
SFM208N-0780-08A-01DP	7.8	63.7	72	110	108.7	1.3	8	8
SFM208N-0794-08A-01DP	7.94	64.8	72	110	108.6	1.4	8	8
SFM203N-0800-08A-01DP	8	25.3	41	79	77.6	1.4	8	3
SFM205N-0800-08A-01DP	8	41.3	53	91	89.6	1.4	8	5
SFM207N-0800-08A-01DP	8	56	72	110	108.6	1.4	8	7
SFM203N-0810-10A-01DP	8.1	25.6	47	89	87.6	1.4	10	3
SFM208N-0810-10A-01DP	8.1	66.1	80	122	120.6	1.4	10	8
SFM203N-0820-10A-01DP	8.2	25.9	47	89	87.6	1.4	10	3
SFM205N-0820-10A-01DP	8.2	42.3	61	103	101.6	1.4	10	5
SFM205N-0840-10A-01DP	8.4	43.4	61	103	101.6	1.4	10	5
SFM203N-0850-10A-01DP	8.5	26.9	47	89	87.6	1.4	10	3
SFM205N-0850-10A-01DP	8.5	43.9	61	103	101.6	1.4	10	5
SFM208N-0850-10A-01DP	8.5	69.4	80	122	120.6	1.4	10	8
SFM203N-0860-10A-01DP	8.6	27.2	47	89	87.5	1.5	10	3
SFM205N-0860-10A-01DP	8.6	44.4	61	103	101.5	1.5	10	5
SFM208N-0860-10A-01DP	8.6	70.2	80	122	120.5	1.5	10	8
SFM203N-0870-10A-01DP	8.7	27.5	47	89	87.5	1.5	10	3
SFM205N-0870-10A-01DP	8.7	44.9	61	103	101.5	1.5	10	5
SFM208N-0870-10A-01DP	8.7	71	80	122	120.5	1.5	10	8
SFM203N-0880-10A-01DP	8.8	27.8	47	89	87.5	1.5	10	3
SFM208N-0880-10A-01DP	8.8	71.8	80	122	120.5	1.5	10	8
SFM203N-0900-10A-01DP	9	28.5	47	89	87.5	1.5	10	3
SFM205N-0900-10A-01DP	9	46.5	61	103	101.5	1.5	10	5
SFM208N-0900-10A-01DP	9	72	80	122	120.5	1.5	10	8
SFM207N-0910-10A-01DP	9.1	63.7	80	122	120.5	1.5	10	7
SFM203N-0930-10A-01DP	9.3	29.4	47	89	87.4	1.6	10	3
SFM205N-0930-10A-01DP	9.3	48	61	103	101.4	1.6	10	5
SFM207N-0940-10A-01DP	9.4	65.8	80	122	120.4	1.6	10	7

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFM203N-0950-10A-01DP	9.5	30	47	89	87.4	1.6	10	3
SFM205N-0950-10A-01DP	9.5	48.7	61	103	101.4	1.6	10	5
SFM207N-0950-10A-01DP	9.5	66.5	80	122	120.4	1.6	10	7
SFM208N-0953-10A-01DP	9.53	66.7	80	122	120.4	1.6	10	7
SFM203N-0960-10A-01DP	9.6	30.3	47	89	87.4	1.6	10	3
SFM207N-0960-10A-01DP	9.6	67.2	80	122	120.4	1.6	10	7
SFM203N-0980-10A-01DP	9.8	31	47	89	87.3	1.7	10	3
SFM205N-0980-10A-01DP	9.8	48.3	61	103	101.3	1.7	10	5
SFM203N-1000-10A-01DP	10	31.6	47	89	87.3	1.7	10	3
SFM205N-1000-10A-01DP	10	50	61	103	101.3	1.7	10	5
SFM207N-1000-10A-01DP	10	70	80	122	120.3	1.7	10	7
SFM205N-1010-12A-01DP	10.1	52.1	71	118	106.3	1.7	12	5
SFM203N-1020-12A-01DP	10.2	32.3	55	102	100.3	1.7	12	3
SFM205N-1020-12A-01DP	10.2	52.7	71	118	116.3	1.7	12	5
SFM203N-1030-12A-01DP	10.3	32.6	55	102	100.2	1.8	12	3
SFM205N-1030-12A-01DP	10.3	53.2	71	118	116.2	1.8	12	5
SFM208N-1030-12A-01DP	10.3	82.4	96	141	139.2	1.8	12	8
SFM203N-1050-12A-01DP	10.5	33.2	55	102	100.2	1.8	12	3
SFM205N-1050-12A-01DP	10.5	54.2	71	118	116.2	1.8	12	5
SFM208N-1050-12A-01DP	10.5	84	96	141	139.2	1.8	12	8
SFM203N-1080-12A-01DP	10.8	34.2	55	102	100.2	1.8	12	3
SFM203N-1100-12A-01DP	11	34.8	55	102	100.1	1.9	12	3
SFM205N-1100-12A-01DP	11	56.8	71	118	116.1	1.9	12	5
SFM207N-1100-12A-01DP	11	77	96	141	139.1	1.9	12	7
SFM203N-1110-12A-01DP	11.1	35.1	55	102	100.1	1.9	12	3
SFM207N-1111-12A-01DP	11.11	77.8	96	141	139.1	1.9	12	7
SFM205N-1120-12A-01DP	11.2	57.6	71	118	116.1	1.9	12	5
SFM203N-1150-12A-01DP	11.5	36.4	55	102	100	2	12	3
SFM205N-1150-12A-01DP	11.5	57.2	71	118	116	2	12	5
SFM203N-1170-12A-01DP	11.7	37	55	102	100	2	12	3
SFM203N-1180-12A-01DP	11.8	37.3	55	102	100	2	12	3
SFM205N-1180-12A-01DP	11.8	56.8	71	118	116	2	12	5
SFM207N-1180-12A-01DP	11.8	82.6	96	141	139	2	12	7
SFM203N-1200-12A-01DP	12	38	55	102	99.9	2.1	12	3
SFM205N-1200-12A-01DP	12	60	71	118	115.9	2.1	12	5
SFM207N-1200-12A-01DP	12	84	96	141	138.9	2.1	12	7
SFM203N-1220-14A-01DP	12.2	38.6	60	107	104.9	2.1	14	3
SFM205N-1250-14A-01DP	12.5	63	77	124	121.9	2.1	14	5
SFM207N-1250-14A-01DP	12.5	88	108	155	152.9	2.1	14	7
SFM203N-1270-14A-01DP	12.7	40.2	60	107	104.8	2.2	14	3
SFM205N-1270-14A-01DP	12.7	64	77	124	121.8	2.2	14	5

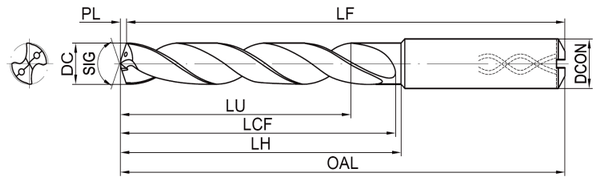
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 28

YPP Drill® SFM

Versatile Solid Carbide Drill for Stainless Steel





Internal Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFM203N-1280-14A-01DP	12.8	40.5	60	107	104.8	2.2	14	3
SFM203N-1300-14A-01DP	13	41.1	60	107	104.8	2.2	14	3
SFM205N-1300-14A-01DP	13	61.4	77	124	121.8	2.2	14	5
SFM207N-1300-14A-01DP	13	91	108	155	152.8	2.2	14	7
SFM205N-1350-14A-01DP	13.5	60.8	77	124	121.7	2.3	14	5
SFM207N-1350-14A-01DP	13.5	95	108	155	152.7	2.3	14	7
SFM203N-1400-14A-01DP	14	44.3	60	107	104.6	2.4	14	3
SFM205N-1400-14A-01DP	14	63	77	124	121.6	2.4	14	5
SFM207N-1400-14A-01DP	14	98	108	155	152.6	2.4	14	7
SFM205N-1425-16A-01DP	14.25	68.7	83	133	130.5	2.5	16	5
SFM208N-1425-16A-01DP	14.25	101	121	171	168.5	2.5	16	7
SFM205N-1450-16A-01DP	14.5	68.5	83	133	130.5	2.5	16	5
SFM203N-1468-16A-01DP	14.68	46.4	65	115	112.5	2.5	16	3
SFM203N-1500-16A-01DP	15	47.4	65	115	112.4	2.6	16	3
SFM205N-1500-16A-01DP	15	68	83	133	130.4	2.6	16	5
SFM208N-1580-16A-01DP	15.8	110.6	121	171	168.2	2.8	16	7
SFM203N-1600-16A-01DP	16	49	65	115	112.2	2.8	16	3
SFM207N-1600-16A-01DP	16	111	121	171	168.2	2.8	16	7
SFM203N-1650-18A-01DP	16.5	52.1	73	123	120.2	2.8	18	3
SFM205N-1650-18A-01DP	16.5	82.5	95	143	140.2	2.8	18	5
SFM203N-1680-18A-01DP	16.8	53	73	123	120.2	2.8	18	3
SFM205N-1700-18A-01DP	17	85	95	143	140.2	2.8	18	5
SFM203N-1750-18A-01DP	17.5	55.2	73	123	120.2	2.8	18	3
SFM204N-1750-18A-01DP	17.5	70	95	143	140.2	2.8	18	4
SFM204N-1780-18A-01DP	17.8	71.2	95	143	140.1	2.9	18	4
SFM203N-1800-18A-01DP	18	56.8	73	123	120.1	2.9	18	3
SFM204N-1800-18A-01DP	18	72	95	143	140.1	2.9	18	4
SFM203N-1850-20A-01DP	18.5	58.4	79	131	128.1	2.9	20	3
SFM203N-1880-20A-01DP	18.8	59.3	79	131	128.1	2.9	20	3
SFM205N-1880-20A-01DP	18.8	93	103	153	150.1	2.9	20	5
SFM203N-1900-20A-01DP	19	59.9	79	131	128.1	2.9	20	3
SFM203N-2000-20A-01DP	20	63	79	131	127.9	3.1	20	3

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	

① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 28

YPP Drill® SFM

Versatile Solid Carbide Drill for Stainless Steel

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
M	Austenitic Stainless Steel					
	M1.0.C.UT	Cast+Untreated	165	48	60	72
	M1.0.Z.AQ	Annealed/Quenched	200	48	60	72
	M1.0.Z.PH	PH-Hardened	350	44	55	66
	M1.1.Z.AQ	Machinability Improved	165	48	60	72
	M1.2.Z.AQ	Free Cutting	200	48	60	72
	M1.3.C.AQ	Ti-Stabilized+Cast	200	48	60	72
	M1.3.Z.AQ	Ti-Stabilized	200	48	60	72
	M1.4.Z.AQ	High Strength	250	48	60	72
	Super Austenitic (Ni>20%) Stainless Steel					
	M2.0.C.AQ	Cast+Annealed/Quenched	165	44	50	68
	M2.0.Z.AQ	Annealed/Quenched	200	44	50	68
	Duplex (Austenitic/Ferritic) Stainless Steel					
	M3.1.Z.AQ >60%	Ferrite (N<0.10%) >60%	250	50	65	80
	M3.2.Z.AQ <60%	Ferrite (N≥0.10%) <60%	250	50	65	80

Drill diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.05	0.07	0.1
4	0.08	0.1	0.12
6	0.09	0.11	0.13
8	0.1	0.12	0.14
10	0.13	0.14	0.17
12	0.13	0.16	0.19
16	0.14	0.2	0.23
20	0.17	0.22	0.25

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase such as PH stainless steel, please decrease cutting speed proportionally

④ Under external coolant condition, please adjust cutting speed to secure good chips formation and evacuation

⑤ Under external coolant condition, please decrease feed per revolution to secure chips evacuation

Dedicated

Customized Solution

ISO Workpiece Materials

P M



YPP Drill® DR200P

INTRODUCTION

Dedicated High-Performance Solid Carbide Drill

Overview & Applications

- Solutions for industry segments such as general machining, D&M, auto and power generation
- Covers ISO-P/M material groups
- Hole tolerance H8–H9
- Diameter range: 3.0–20.0 mm
- Drill length above 8xDC

Features & Benefits

- Cover both stable and unstable cutting conditions
- Provide both internal & external coolant solutions
- Curve cutting edge generates low cutting force
- Good centering performance thanks to unique design on central cutting edge
- Good chips evacuation thanks to chips flute optimization design
- Extra fine grain size substrate together with multi layers PVD coating generates long tool life

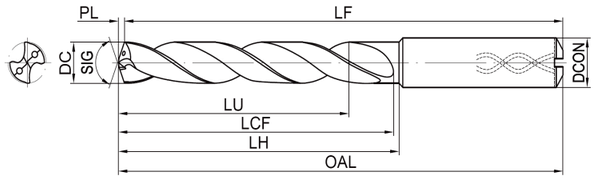
Ordering Code

D	R200	P	2	03	N	—	0900	—	10A	—	01DP
D - Product Family	R - Cutting Edge Type	P - P- Material Group	2 - 2 Cutting Edge	03 - 3xDC	N - Internal Coolant		0900 - Drill Diameter 0900-DC9mm		10 - Shank Diameter A - HA Cylindrical Shank		01 - Substrate AK40 DP - Coating

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203N-0300-04A-01DP	3	9.5	20	62	61.5	0.5	4	3
DR200P205N-0300-04A-01DP	3	15.5	26	66	65.5	0.5	4	5
DR200P208N-0300-04A-01DP	3	24.5	40	78	77.5	0.5	4	8
DR200P203N-0310-04A-01DP	3.1	9.8	20	62	61.5	0.5	4	3
DR200P205N-0310-04A-01DP	3.1	16	26	66	65.5	0.5	4	5
DR200P208N-0310-04A-01DP	3.1	25.3	40	78	77.5	0.5	4	8
DR200P203N-0317-04A-01DP	3.17	10	20	62	61.5	0.5	4	3
DR200P205N-0317-04A-01DP	3.17	16.4	26	66	65.5	0.5	4	5
DR200P208N-0317-04A-01DP	3.17	25.9	40	78	77.5	0.5	4	8
DR200P203N-0320-04A-01DP	3.2	10.1	20	62	61.5	0.5	4	3
DR200P205N-0320-04A-01DP	3.2	16.5	26	66	65.5	0.5	4	5
DR200P208N-0320-04A-01DP	3.2	26.1	40	78	77.5	0.5	4	8
DR200P203N-0330-04A-01DP	3.3	10.5	20	62	61.4	0.6	4	3
DR200P205N-0330-04A-01DP	3.3	17.1	26	66	65.4	0.6	4	5
DR200P208N-0330-04A-01DP	3.3	27	40	78	77.5	0.6	4	8
DR200P203N-0340-04A-01DP	3.4	10.8	20	62	61.4	0.6	4	3
DR200P205N-0340-04A-01DP	3.4	17.6	26	66	65.4	0.6	4	5
DR200P208N-0340-04A-01DP	3.4	27.5	40	78	77.4	0.6	4	8
DR200P208N-0345-04A-01DP	3.45	27.4	40	78	77.4	0.6	4	8
DR200P203N-0350-04A-01DP	3.5	11.1	20	62	61.4	0.6	4	3
DR200P205N-0350-04A-01DP	3.5	18.1	26	66	65.4	0.6	4	5
DR200P208N-0350-04A-01DP	3.5	27.3	40	78	77.4	0.6	4	8
DR200P203N-0355-04A-01DP	3.55	11.2	20	62	61.4	0.6	4	3
DR200P208N-0357-04A-01DP	3.57	27.1	40	78	77.4	0.6	4	8
DR200P203N-0360-04A-01DP	3.6	11.4	20	62	61.4	0.6	4	3
DR200P205N-0360-04A-01DP	3.6	18.5	26	66	65.4	0.6	4	5
DR200P208N-0360-04A-01DP	3.6	27.1	40	78	77.4	0.6	4	8
DR200P203N-0370-04A-01DP	3.7	11.7	20	62	61.4	0.6	4	3
DR200P205N-0370-04A-01DP	3.7	19.1	26	66	65.4	0.6	4	5
DR200P208N-0370-04A-01DP	3.7	27.9	40	78	77.4	0.6	4	8
DR200P203N-0380-04A-01DP	3.8	12.1	24	66	65.4	0.6	4	3
DR200P205N-0380-04A-01DP	3.8	31.1	34	74	73.4	0.6	4	5
DR200P208N-0380-04A-01DP	3.8	31.1	49	87	86.4	0.6	4	8
DR200P203N-0390-04A-01DP	3.9	12.5	24	66	65.4	0.6	4	3
DR200P205N-0390-04A-01DP	3.9	20.2	34	74	73.4	0.6	4	5
DR200P208N-0390-04A-01DP	3.9	31.9	49	87	86.4	0.6	4	8
DR200P208N-0397-04A-01DP	3.97	32.4	49	87	86.3	0.7	4	8
DR200P203N-0400-04A-01DP	4	12.7	24	66	65.3	0.7	4	3
DR200P205N-0400-04A-01DP	4	20.7	34	74	73.3	0.7	4	5
DR200P208N-0400-04A-01DP	4	32.7	49	87	86.3	0.7	4	8

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203N-0410-06A-01DP	4.1	13	24	66	65.3	0.7	6	3
DR200P205N-0410-06A-01DP	4.1	21.2	34	74	73.3	0.7	6	5
DR200P208N-0410-06A-01DP	4.1	33.5	49	87	86.3	0.7	6	8
DR200P203N-0420-06A-01DP	4.2	13.3	24	66	65.3	0.7	6	3
DR200P205N-0420-06A-01DP	4.2	21.7	34	74	73.3	0.7	6	5
DR200P208N-0420-06A-01DP	4.2	34.3	49	87	86.3	0.7	6	8
DR200P203N-0430-06A-01DP	4.3	13.7	24	66	65.2	0.7	6	3
DR200P205N-0430-06A-01DP	4.3	22.3	34	74	73.2	0.7	6	5
DR200P208N-0430-06A-01DP	4.3	35.2	49	87	86.3	0.7	6	8
DR200P203N-0440-06A-01DP	4.4	14.1	24	66	65.3	0.7	6	3
DR200P205N-0440-06A-01DP	4.4	22.8	34	74	73.3	0.7	6	5
DR200P208N-0440-06A-01DP	4.4	36	49	87	86.3	0.7	6	8
DR200P203N-0450-06A-01DP	4.5	14.3	24	66	65.3	0.7	6	3
DR200P205N-0450-06A-01DP	4.5	23.3	34	74	73.3	0.7	6	5
DR200P208N-0450-06A-01DP	4.5	36.8	49	87	86.3	0.7	6	8
DR200P205N-0455-06A-01DP	4.55	23.5	34	74	73.2	0.8	6	5
DR200P203N-0460-06A-01DP	4.6	14.6	24	66	65.2	0.8	6	3
DR200P205N-0460-06A-01DP	4.6	23.8	34	74	73.2	0.8	6	5
DR200P208N-0460-06A-01DP	4.6	36.8	49	87	86.2	0.8	6	8
DR200P208N-0470-06A-01DP	4.7	36.6	49	87	86.2	0.8	6	8
DR200P203N-0476-06A-01DP	4.76	15	28	66	65.2	0.8	6	3
DR200P208N-0476-06A-01DP	4.76	36.8	56	94	93.2	0.8	6	8
DR200P203N-0480-06A-01DP	4.8	15.2	28	66	65.2	0.8	6	3
DR200P205N-0480-06A-01DP	4.8	24.8	44	82	81.2	0.8	6	5
DR200P208N-0480-06A-01DP	4.8	39.2	56	94	93.2	0.8	6	8
DR200P203N-0490-06A-01DP	4.9	15.5	28	66	65.2	0.8	6	3
DR200P205N-0490-06A-01DP	4.9	25.3	44	82	81.2	0.8	6	5
DR200P208N-0490-06A-01DP	4.9	40	56	94	93.2	0.8	6	8
DR200P203N-0500-06A-01DP	5	15.8	28	66	65.2	0.8	6	3
DR200P205N-0500-06A-01DP	5	25.8	44	82	81.2	0.8	6	5
DR200P208N-0500-06A-01DP	5	40.8	56	94	93.2	0.8	6	8
DR200P203N-0510-06A-01DP	5.1	16.1	28	66	65.2	0.8	6	3
DR200P205N-0510-06A-01DP	5.1	26.3	44	82	81.2	0.8	6	5
DR200P208N-0510-06A-01DP	5.1	41.6	56	94	93.2	0.8	6	8
DR200P205N-0516-06A-01DP	5.16	26.6	44	82	81.2	0.8	6	5
DR200P208N-0516-06A-01DP	5.16	42.1	56	94	93.1	0.9	6	8
DR200P203N-0520-06A-01DP	5.2	16.4	28	66	65.1	0.9	6	3
DR200P205N-0520-06A-01DP	5.2	26.8	44	82	81.1	0.9	6	5
DR200P208N-0520-06A-01DP	5.2	42.4	56	94	93.1	0.9	6	8

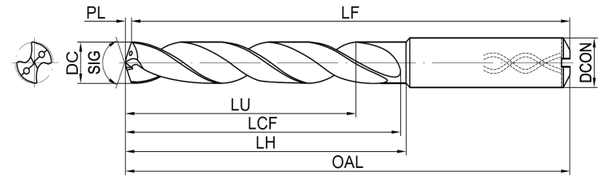
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 39

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203N-0530-06A-01DP	5.3	16.7	28	66	65.1	0.9	6	3
DR200P205N-0530-06A-01DP	5.3	27.3	44	82	81.1	0.9	6	5
DR200P203N-0540-06A-01DP	5.4	17	28	66	65.1	0.9	6	3
DR200P205N-0540-06A-01DP	5.4	27.8	44	82	81.1	0.9	6	5
DR200P208N-0540-06A-01DP	5.4	44	56	94	93.1	0.9	6	8
DR200P203N-0550-06A-01DP	5.5	17.4	28	66	65.1	0.9	6	3
DR200P205N-0550-06A-01DP	5.5	28.4	44	82	81.1	0.9	6	5
DR200P208N-0550-06A-01DP	5.5	44.9	56	94	93.1	0.9	6	8
DR200P205N-0555-06A-01DP	5.55	28.7	44	82	81.1	0.9	6	5
DR200P203N-0556-06A-01DP	5.56	17.5	28	66	65.1	0.9	6	3
DR200P205N-0556-06A-01DP	5.56	28.7	44	82	81.1	0.9	6	5
DR200P208N-0556-06A-01DP	5.56	45.3	56	94	93.1	0.9	6	8
DR200P203N-0560-06A-01DP	5.6	17.7	28	66	65.1	0.9	6	3
DR200P205N-0560-06A-01DP	5.6	28.9	44	82	81.1	0.9	6	5
DR200P208N-0560-06A-01DP	5.6	45.7	56	94	93.1	0.9	6	8
DR200P205N-0570-06A-01DP	5.7	29.4	44	82	81	1	6	5
DR200P208N-0570-06A-01DP	5.7	46.5	56	94	93	1	6	8
DR200P203N-0580-06A-01DP	5.8	17.6	28	66	65	1	6	3
DR200P205N-0580-06A-01DP	5.8	29.9	44	82	81	1	6	5
DR200P208N-0580-06A-01DP	5.8	47.3	56	94	93	1	6	8
DR200P203N-0590-06A-01DP	5.9	18.2	28	66	65	1	6	3
DR200P205N-0590-06A-01DP	5.9	30.4	44	82	81	1	6	5
DR200P208N-0590-06A-01DP	5.9	47.4	56	94	93	1	6	8
DR200P203N-0595-06A-01DP	5.95	18.2	28	66	65	1	6	3
DR200P205N-0595-06A-01DP	5.95	30.7	44	82	81	1	6	5
DR200P203N-0600-06A-01DP	6	18.9	28	66	65	1	6	3
DR200P205N-0600-06A-01DP	6	30.9	44	82	81	1	6	5
DR200P208N-0600-06A-01DP	6	48	56	94	93	1	6	8
DR200P203N-0610-08A-01DP	6.1	19.3	34	79	78	1	8	3
DR200P205N-0610-08A-01DP	6.1	31.5	53	91	90	1	8	5
DR200P208N-0610-08A-01DP	6.1	49.8	67	106	105	1	8	8
DR200P203N-0620-08A-01DP	6.2	19.6	34	79	77.9	1.1	8	3
DR200P205N-0620-08A-01DP	6.2	32	53	91	89.9	1.1	8	5
DR200P208N-0620-08A-01DP	6.2	50.6	67	106	104.9	1.1	8	8
DR200P203N-0630-08A-01DP	6.3	19.9	34	79	77.9	1.1	8	3
DR200P205N-0630-08A-01DP	6.3	32.5	53	91	89.9	1.1	8	5
DR200P208N-0630-08A-01DP	6.3	51.4	67	106	104.9	1.1	8	8
DR200P203N-0635-08A-01DP	6.35	20.1	34	79	78	1.1	8	3
DR200P205N-0635-08A-01DP	6.35	32.8	53	91	90	1.1	8	5
DR200P208N-0635-08A-01DP	6.35	51.8	67	106	104.9	1.1	8	8

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203N-0640-08A-01DP	6.4	20.2	34	79	77.9	1.1	8	3
DR200P205N-0640-08A-01DP	6.4	33	53	91	89.9	1.1	8	5
DR200P208N-0640-08A-01DP	6.4	52.2	67	106	104.9	1.1	8	8
DR200P203N-0650-08A-01DP	6.5	20.6	34	79	77.9	1.1	8	3
DR200P205N-0650-08A-01DP	6.5	33.6	53	91	89.9	1.1	8	5
DR200P208N-0650-08A-01DP	6.5	53.1	67	106	104.9	1.1	8	8
DR200P203N-0660-08A-01DP	6.6	20.9	34	79	77.9	1.1	8	3
DR200P205N-0660-08A-01DP	6.6	34.1	53	91	89.9	1.1	8	5
DR200P208N-0660-08A-01DP	6.6	53.9	67	106	104.9	1.1	8	8
DR200P203N-0670-08A-01DP	6.7	21.2	34	79	77.9	1.1	8	3
DR200P205N-0670-08A-01DP	6.7	34.6	53	91	89.9	1.1	8	5
DR200P208N-0670-08A-01DP	6.7	54.7	67	106	104.9	1.1	8	8
DR200P203N-0675-08A-01DP	6.75	21.3	34	79	77.9	1.1	8	3
DR200P205N-0675-08A-01DP	6.75	34.8	53	91	89.9	1.1	8	5
DR200P208N-0675-08A-01DP	6.75	55.1	67	106	104.9	1.1	8	8
DR200P203N-0680-08A-01DP	6.8	21.5	34	79	77.9	1.1	8	3
DR200P205N-0680-08A-01DP	6.8	35.1	53	91	89.9	1.1	8	5
DR200P208N-0680-08A-01DP	6.8	55.5	67	106	104.9	1.1	8	8
DR200P203N-0690-08A-01DP	6.9	21.8	34	79	77.8	1.2	8	3
DR200P205N-0690-08A-01DP	6.9	35.6	53	91	89.8	1.2	8	5
DR200P208N-0690-08A-01DP	6.9	56.3	67	106	104.8	1.2	8	8
DR200P203N-0700-08A-01DP	7	22.1	34	79	77.8	1.2	8	3
DR200P205N-0700-08A-01DP	7	36.1	53	91	89.8	1.2	8	5
DR200P208N-0700-08A-01DP	7	57.1	67	106	104.8	1.2	8	8
DR200P203N-0710-08A-01DP	7.1	22.4	41	79	77.8	1.2	8	3
DR200P205N-0710-08A-01DP	7.1	36.6	53	91	89.8	1.2	8	5
DR200P203N-0714-08A-01DP	7.14	22.6	41	79	77.8	1.2	8	3
DR200P205N-0714-08A-01DP	7.14	36.9	53	91	89.8	1.2	8	5
DR200P208N-0714-08A-01DP	7.14	58.3	72	110	108.8	1.2	8	8
DR200P203N-0720-08A-01DP	7.2	22.8	41	79	77.8	1.2	8	3
DR200P205N-0720-08A-01DP	7.2	37.2	53	91	89.8	1.2	8	5
DR200P205N-0730-08A-01DP	7.3	37.7	53	91	89.8	1.2	8	5
DR200P208N-0730-08A-01DP	7.3	59.6	72	110	108.8	1.2	8	8
DR200P203N-0740-08A-01DP	7.4	23.4	41	79	77.7	1.3	8	3
DR200P205N-0740-08A-01DP	7.4	38.2	53	91	89.7	1.3	8	5
DR200P208N-0740-08A-01DP	7.4	60.4	72	110	108.7	1.3	8	8
DR200P203N-0750-08A-01DP	7.5	23.7	41	79	77.7	1.3	8	3
DR200P205N-0750-08A-01DP	7.5	38.7	53	91	89.7	1.3	8	5
DR200P208N-0750-08A-01DP	7.5	61.2	72	110	108.7	1.3	8	8
DR200P205N-0754-08A-01DP	7.54	38.9	53	91	89.7	1.3	8	5

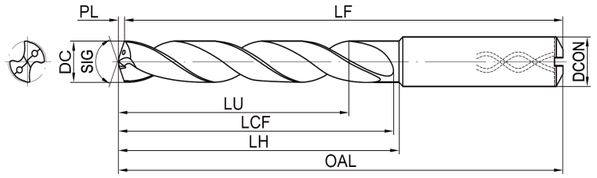
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 39

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203N-0760-08A-01DP	7.6	24	41	79	77.7	1.3	8	3
DR200P208N-0760-08A-01DP	7.6	62	72	110	108.7	1.3	8	8
DR200P203N-0770-08A-01DP	7.7	24.3	41	79	77.7	1.3	8	3
DR200P205N-0770-08A-01DP	7.7	39.7	53	91	89.7	1.3	8	5
DR200P208N-0770-08A-01DP	7.7	61.6	72	110	108.7	1.3	8	8
DR200P203N-0780-08A-01DP	7.8	24.7	41	79	77.7	1.3	8	3
DR200P205N-0780-08A-01DP	7.8	40.3	53	91	89.7	1.3	8	5
DR200P208N-0780-08A-01DP	7.8	63.7	72	110	108.7	1.3	8	8
DR200P203N-0790-08A-01DP	7.9	25	41	79	77.7	1.3	8	3
DR200P205N-0790-08A-01DP	7.9	40.8	53	91	89.7	1.3	8	5
DR200P203N-0794-08A-01DP	7.94	25.1	41	79	77.6	1.4	8	3
DR200P205N-0794-08A-01DP	7.94	41	53	91	89.6	1.4	8	5
DR200P208N-0794-08A-01DP	7.94	63.5	72	110	108.6	1.4	8	8
DR200P203N-0800-08A-01DP	8	25.3	41	79	77.6	1.4	8	3
DR200P205N-0800-08A-01DP	8	41.3	53	91	89.6	1.4	8	5
DR200P207N-0800-08A-01DP	8	56	72	110	108.6	1.4	8	7
DR200P203N-0810-10A-01DP	8.1	25.6	47	89	87.6	1.4	10	3
DR200P205N-0810-10A-01DP	8.1	41.8	61	103	101.6	1.4	10	5
DR200P208N-0810-10A-01DP	8.1	66.1	80	122	120.6	1.4	10	8
DR200P205N-0815-10A-01DP	8.15	42.1	61	103	101.6	1.4	10	5
DR200P203N-0820-10A-01DP	8.2	25.9	47	89	87.6	1.4	10	3
DR200P205N-0820-10A-01DP	8.2	42.3	61	103	101.6	1.4	10	5
DR200P208N-0820-10A-01DP	8.2	66.9	80	122	120.6	1.4	10	8
DR200P203N-0830-10A-01DP	8.3	26.3	47	89	87.6	1.4	10	3
DR200P205N-0830-10A-01DP	8.3	42.9	61	103	101.6	1.4	10	5
DR200P208N-0830-10A-01DP	8.3	67.8	80	122	120.6	1.4	10	8
DR200P205N-0833-10A-01DP	8.33	43	61	103	101.6	1.4	10	5
DR200P203N-0840-10A-01DP	8.4	26.6	47	89	87.6	1.4	10	3
DR200P205N-0840-10A-01DP	8.4	43.4	61	103	101.6	1.4	10	5
DR200P208N-0840-10A-01DP	8.4	68.6	80	122	120.6	1.4	10	8
DR200P203N-0850-10A-01DP	8.5	26.9	47	89	87.6	1.4	10	3
DR200P205N-0850-10A-01DP	8.5	43.9	61	103	101.6	1.4	10	5
DR200P208N-0850-10A-01DP	8.5	69.4	80	122	120.6	1.4	10	8
DR200P203N-0860-10A-01DP	8.6	27.2	47	89	87.5	1.5	10	3
DR200P205N-0860-10A-01DP	8.6	44.4	61	103	101.5	1.5	10	5
DR200P208N-0860-10A-01DP	8.6	70.2	80	122	120.5	1.5	10	8
DR200P203N-0870-10A-01DP	8.7	27.5	47	89	87.5	1.5	10	3
DR200P205N-0870-10A-01DP	8.7	44.9	61	103	101.5	1.5	10	5
DR200P208N-0870-10A-01DP	8.7	71	80	122	120.5	1.5	10	8

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203N-0873-10A-01DP	8.73	27.6	47	89	87.5	1.5	10	3
DR200P205N-0873-10A-01DP	8.73	45.1	61	103	101.5	1.5	10	5
DR200P208N-0873-10A-01DP	8.73	71.3	80	122	120.5	1.5	10	8
DR200P203N-0880-10A-01DP	8.8	27.8	47	89	87.5	1.5	10	3
DR200P205N-0880-10A-01DP	8.8	45.4	61	103	101.5	1.5	10	5
DR200P208N-0880-10A-01DP	8.8	71.8	80	122	120.5	1.5	10	8
DR200P205N-0890-10A-01DP	8.9	45.9	61	103	101.5	1.5	10	5
DR200P203N-0900-10A-01DP	9	28.5	47	89	87.5	1.5	10	3
DR200P205N-0900-10A-01DP	9	46.5	61	103	101.5	1.5	10	5
DR200P208N-0900-10A-01DP	9	72	80	122	120.5	1.5	10	8
DR200P203N-0910-10A-01DP	9.1	28.8	47	89	87.5	1.5	10	3
DR200P205N-0910-10A-01DP	9.1	47	61	103	101.5	1.5	10	5
DR200P207N-0910-10A-01DP	9.1	63.7	80	122	120.5	1.5	10	7
DR200P203N-0920-10A-01DP	9.2	29.1	47	89	87.4	1.6	10	3
DR200P205N-0920-10A-01DP	9.2	47.5	61	103	101.4	1.6	10	5
DR200P207N-0920-10A-01DP	9.2	64.4	80	122	120.4	1.6	10	7
DR200P203N-0930-10A-01DP	9.3	29.4	47	89	87.4	1.6	10	3
DR200P205N-0930-10A-01DP	9.3	48	61	103	101.4	1.6	10	5
DR200P207N-0930-10A-01DP	9.3	65.1	80	122	120.4	1.6	10	7
DR200P203N-0940-10A-01DP	9.4	29.7	47	89	87.4	1.6	10	3
DR200P205N-0940-10A-01DP	9.4	48.5	61	103	101.4	1.6	10	5
DR200P207N-0940-10A-01DP	9.4	65.8	80	122	120.4	1.6	10	7
DR200P203N-0950-10A-01DP	9.5	30	47	89	87.4	1.6	10	3
DR200P205N-0950-10A-01DP	9.5	48.7	61	103	101.4	1.6	10	5
DR200P207N-0950-10A-01DP	9.5	66.5	80	122	120.4	1.6	10	7
DR200P203N-0952-10A-01DP	9.52	30.1	47	89	87.4	1.6	10	3
DR200P205N-0952-10A-01DP	9.52	48.6	61	103	101.4	1.6	10	5
DR200P207N-0952-10A-01DP	9.52	66.6	80	122	120.4	1.6	10	7
DR200P205N-0955-10A-01DP	9.55	48.6	61	103	101.4	1.6	10	5
DR200P203N-0960-10A-01DP	9.6	30.3	47	89	87.4	1.6	10	3
DR200P205N-0960-10A-01DP	9.6	48.5	61	103	101.4	1.6	10	5
DR200P207N-0960-10A-01DP	9.6	67.2	80	122	120.4	1.6	10	7
DR200P203N-0970-10A-01DP	9.7	30.7	47	89	87.3	1.7	10	3
DR200P207N-0970-10A-01DP	9.7	67.9	80	122	120.3	1.7	10	7
DR200P203N-0980-10A-01DP	9.8	31	47	89	87.3	1.7	10	3
DR200P205N-0980-10A-01DP	9.8	48.3	61	103	101.3	1.7	10	5
DR200P207N-0980-10A-01DP	9.8	68.6	80	122	120.3	1.7	10	7
DR200P203N-0990-10A-01DP	9.9	31.3	47	89	87.3	1.7	10	3
DR200P205N-0990-10A-01DP	9.9	48.1	61	103	101.3	1.7	10	5
DR200P207N-0990-10A-01DP	9.9	69.3	80	122	120.3	1.7	10	7

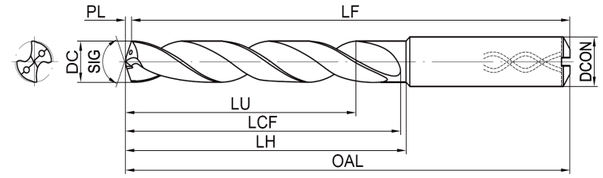
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 39

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P207N-0992-10A-01DP	9.92	69.4	80	122	120	1.7	10	7
DR200P203N-1000-10A-01DP	10	31.6	47	89	87.3	1.7	10	3
DR200P205N-1000-10A-01DP	10	50	61	103	101.3	1.7	10	5
DR200P207N-1000-10A-01DP	10	70	80	122	120.3	1.7	10	7
DR200P203N-1010-12A-01DP	10.1	31.9	55	102	100.3	1.7	12	3
DR200P205N-1010-12A-01DP	10.1	52.1	71	118	116.3	1.7	12	5
DR200P208N-1010-12A-01DP	10.1	82.4	96	141	139.3	1.7	12	8
DR200P203N-1020-12A-01DP	10.2	32.3	55	102	100.3	1.7	12	3
DR200P205N-1020-12A-01DP	10.2	52.7	71	118	116.3	1.7	12	5
DR200P208N-1020-12A-01DP	10.2	83.3	96	141	139.3	1.7	12	8
DR200P203N-1030-12A-01DP	10.3	32.6	55	102	100.2	1.8	12	3
DR200P205N-1030-12A-01DP	10.3	53.2	71	118	116.2	1.8	12	5
DR200P208N-1030-12A-01DP	10.3	82.4	96	141	139.2	1.8	12	8
DR200P203N-1032-12A-01DP	10.32	32.6	55	102	100.2	1.8	12	3
DR200P205N-1032-12A-01DP	10.32	53.3	71	118	116.2	1.8	12	5
DR200P203N-1040-12A-01DP	10.4	32.9	55	102	100.2	1.8	12	3
DR200P205N-1040-12A-01DP	10.4	53.7	71	118	116.2	1.8	12	5
DR200P208N-1040-12A-01DP	10.4	84.9	96	141	139.2	1.8	12	8
DR200P203N-1050-12A-01DP	10.5	33.2	55	102	100.2	1.8	12	3
DR200P205N-1050-12A-01DP	10.5	54.2	71	118	116.2	1.8	12	5
DR200P208N-1050-12A-01DP	10.5	84	96	141	139.2	1.8	12	8
DR200P205N-1060-12A-01DP	10.6	54.7	71	118	116.2	1.8	12	5
DR200P203N-1070-12A-01DP	10.7	33.8	55	102	100.2	1.8	12	3
DR200P205N-1070-12A-01DP	10.7	55.2	71	118	116.2	1.8	12	5
DR200P205N-1071-12A-01DP	10.71	55.3	71	118	116.2	1.8	12	5
DR200P203N-1080-12A-01DP	10.8	34.2	55	102	100.2	1.8	12	3
DR200P205N-1080-12A-01DP	10.8	55.8	71	118	116.2	1.8	12	5
DR200P208N-1080-12A-01DP	10.8	86.4	96	141	139.2	1.8	12	8
DR200P205N-1090-12A-01DP	10.9	56.3	71	118	116.1	1.9	12	5
DR200P203N-1100-12A-01DP	11	34.8	55	102	100.1	1.9	12	3
DR200P205N-1100-12A-01DP	11	56.8	71	118	116.1	1.9	12	5
DR200P207N-1100-12A-01DP	11	77	96	141	139.1	1.9	12	7
DR200P203N-1110-12A-01DP	11.1	35.1	55	102	100	1.9	12	3
DR200P205N-1110-12A-01DP	11.1	57.3	71	118	116.1	1.9	12	5
DR200P207N-1110-12A-01DP	11.1	78	96	141	139.1	1.9	12	7
DR200P203N-1111-12A-01DP	11.11	35.1	55	102	100.1	1.9	12	3
DR200P207N-1111-12A-01DP	11.11	77.8	96	141	139.1	1.9	12	7
DR200P203N-1120-12A-01DP	11.2	35.4	55	102	100.1	1.9	12	3
DR200P205N-1120-12A-01DP	11.2	57.6	71	118	116.1	1.9	12	5
DR200P208N-1120-12A-01DP	11.2	78.4	96	141	139.1	1.9	12	7

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203N-1130-12A-01DP	11.3	35.7	55	102	100	1.9	12	3
DR200P205N-1130-12A-01DP	11.3	57.4	71	118	116.1	1.9	12	5
DR200P207N-1130-12A-01DP	11.3	79.1	96	141	139.1	1.9	12	7
DR200P203N-1140-12A-01DP	11.4	36.1	55	102	100	2	12	3
DR200P203N-1150-12A-01DP	11.5	36.4	55	102	100	2	12	3
DR200P205N-1150-12A-01DP	11.5	57.2	71	118	116	2	12	5
DR200P207N-1150-12A-01DP	11.5	80.5	96	141	139	2	12	7
DR200P203N-1160-12A-01DP	11.6	36.7	55	102	100	2	12	3
DR200P203N-1170-12A-01DP	11.7	37	55	102	100	2	12	3
DR200P205N-1170-12A-01DP	11.7	57	71	118	116	2	12	5
DR200P203N-1180-12A-01DP	11.8	37.3	55	102	100	2	12	3
DR200P205N-1180-12A-01DP	11.8	56.8	71	118	116	2	12	5
DR200P207N-1180-12A-01DP	11.8	82.6	96	141	139	2	12	7
DR200P203N-1190-12A-01DP	11.9	37.6	55	102	100	2	12	3
DR200P207N-1190-12A-01DP	11.9	83.3	96	141	139	2	12	7
DR200P203N-1200-12A-01DP	12	38	55	102	99.9	2.1	12	3
DR200P205N-1200-12A-01DP	12	60	71	118	115.9	2.1	12	5
DR200P207N-1200-12A-01DP	12	84	96	141	138.9	2.1	12	7
DR200P203N-1210-14A-01DP	12.1	38.3	60	107	104.9	2.1	14	3
DR200P205N-1210-14A-01DP	12.1	62.5	77	124	121.9	2.1	14	5
DR200P208N-1210-14A-01DP	12.1	96.8	108	155	152.9	2.1	14	8
DR200P203N-1220-14A-01DP	12.2	38.6	60	107	104.9	2.1	14	3
DR200P205N-1220-14A-01DP	12.2	62.4	77	124	121.9	2.1	14	5
DR200P208N-1220-14A-01DP	12.2	97.6	108	155	152.9	2.1	14	8
DR200P203N-1230-14A-01DP	12.3	38.9	60	107	104.9	2.1	14	3
DR200P205N-1230-14A-01DP	12.3	62.2	77	124	121.9	2.1	14	5
DR200P208N-1230-14A-01DP	12.3	98.4	108	155	152.9	2.1	14	8
DR200P203N-1250-14A-01DP	12.5	39.5	60	107	104.9	2.1	14	3
DR200P205N-1250-14A-01DP	12.5	63	77	124	121.9	2.1	14	5
DR200P207N-1250-14A-01DP	12.5	88	108	155	152.9	2.1	14	7
DR200P203N-1260-14A-01DP	12.6	39.9	60	107	104.8	2.2	14	3
DR200P203N-1270-14A-01DP	12.7	40.2	60	107	105	2.2	14	3
DR200P205N-1270-14A-01DP	12.7	64	77	124	121.8	2.2	14	5
DR200P207N-1270-14A-01DP	12.7	88.9	108	155	152.8	2.2	14	7
DR200P203N-1280-14A-01DP	12.8	40.5	60	107	104.8	2.2	14	3
DR200P205N-1280-14A-01DP	12.8	64.6	77	124	121.8	2.2	14	5
DR200P207N-1280-14A-01DP	12.8	89.6	108	155	152.8	2.2	14	7
DR200P203N-1300-14A-01DP	13	41.1	60	107	104.8	2.2	14	3
DR200P205N-1300-14A-01DP	13	61.4	77	124	121.8	2.2	14	5
DR200P207N-1300-14A-01DP	13	91	108	155	152.8	2.2	14	7

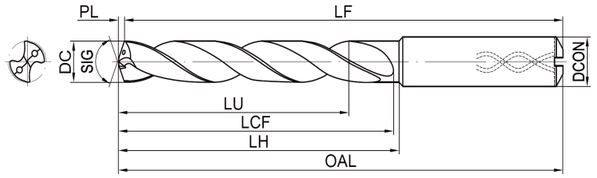
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 39

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203N-1310-14A-01DP	13.1	41.4	60	107	105	2.3	14	3
DR200P205N-1310-14A-01DP	13.1	61.3	77	124	121.7	2.3	14	5
DR200P207N-1310-14A-01DP	13.1	91.7	108	155	152.7	2.3	14	7
DR200P205N-1325-14A-01DP	13.25	61.1	77	124	121.7	2.3	14	5
DR200P203N-1350-14A-01DP	13.5	42.7	60	107	104.7	2.3	14	3
DR200P205N-1350-14A-01DP	13.5	60.8	77	124	121.7	2.3	14	5
DR200P207N-1350-14A-01DP	13.5	94.5	108	155	152.7	2.3	14	7
DR200P205N-1375-14A-01DP	13.75	60.5	77	124	121.6	2.4	14	5
DR200P203N-1380-14A-01DP	13.8	43.4	60	107	104.6	2.4	14	3
DR200P205N-1380-14A-01DP	13.8	60.4	77	124	121.6	2.4	14	5
DR200P207N-1380-14A-01DP	13.8	96.6	108	155	152.6	2.4	14	7
DR200P205N-1389-14A-01DP	13.89	60.3	77	124	121.6	2.4	14	5
DR200P203N-1400-14A-01DP	14	44.3	60	107	104.6	2.4	14	3
DR200P205N-1400-14A-01DP	14	63	77	124	121.6	2.4	14	5
DR200P207N-1400-14A-01DP	14	98	108	155	152.6	2.4	14	7
DR200P203N-1425-16A-01DP	14.25	45	65	115	112.5	2.5	16	3
DR200P205N-1425-16A-01DP	14.25	68.8	83	133	130.5	2.5	16	5
DR200P203N-1429-16A-01DP	14.29	45.2	65	115	112.5	2.5	16	3
DR200P205N-1429-16A-01DP	14.29	68.7	83	133	130.5	2.5	16	5
DR200P203N-1450-16A-01DP	14.5	45.8	65	115	112.5	2.5	16	3
DR200P205N-1450-16A-01DP	14.5	68.5	83	133	130.5	2.5	16	5
DR200P203N-1469-16A-01DP	14.69	46.4	65	115	112.5	2.5	16	3
DR200P205N-1480-16A-01DP	14.8	68.2	83	133	130.4	2.6	16	5
DR200P203N-1500-16A-01DP	15	47.4	65	115	112.4	2.6	16	3
DR200P205N-1500-16A-01DP	15	68	83	133	130.4	2.6	16	5
DR200P203N-1550-16A-01DP	15.5	49	65	115	112.3	2.7	16	3
DR200P205N-1550-16A-01DP	15.5	67.5	83	133	130.3	2.7	16	5
DR200P203N-1580-16A-01DP	15.8	49.2	65	115	112.2	2.8	16	3
DR200P205N-1580-16A-01DP	15.8	67.2	83	133	130.2	2.8	16	5
DR200P203N-1587-16A-01DP	15.87	49.1	65	115	112.2	2.8	16	3
DR200P203N-1600-16A-01DP	16	49	65	115	112.2	2.8	16	3
DR200P205N-1600-16A-01DP	16	67	83	133	130.2	2.8	16	5
DR200P207N-1600-16A-01DP	16	111	121	171	168.2	2.8	16	7

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR

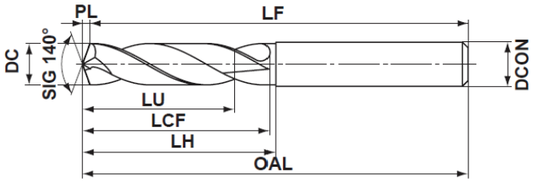
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 39

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

External Coolant Design

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203W-0300-04A-01DP	3	9.5	20	62	61.5	0.5	4	3
DR200P205W-0300-04A-01DP	3	15.5	26	66	65.5	0.5	4	5
DR200P203W-0310-04A-01DP	3.1	9.8	20	62	61.5	0.5	4	3
DR200P205W-0310-04A-01DP	3.1	16	26	66	65.5	0.5	4	5
DR200P203W-0317-04A-01DP	3.17	10	20	62	61.5	0.5	4	3
DR200P205W-0317-04A-01DP	3.17	16.4	26	66	65.5	0.5	4	5
DR200P203W-0320-04A-01DP	3.2	10.1	20	62	61.5	0.5	4	3
DR200P205W-0320-04A-01DP	3.2	16.5	26	66	65.5	0.5	4	5
DR200P203W-0330-04A-01DP	3.3	10.5	20	62	61.4	0.6	4	3
DR200P205W-0330-04A-01DP	3.3	17.1	26	66	65.4	0.6	4	5
DR200P203W-0340-04A-01DP	3.4	10.8	20	62	61.4	0.6	4	3
DR200P205W-0340-04A-01DP	3.4	17.6	26	66	65.4	0.6	4	5
DR200P203W-0350-04A-01DP	3.5	11.1	20	62	61.4	0.6	4	3
DR200P205W-0350-04A-01DP	3.5	18.1	26	66	65.4	0.6	4	5
DR200P203W-0355-04A-01DP	3.55	11.2	20	62	61.4	0.6	4	3
DR200P203W-0360-04A-01DP	3.6	11.4	20	62	61.4	0.6	4	3
DR200P205W-0360-04A-01DP	3.6	18.5	26	66	65.4	0.6	4	5
DR200P203W-0370-04A-01DP	3.7	11.7	20	62	61.4	0.6	4	3
DR200P205W-0370-04A-01DP	3.7	19.1	26	66	65.4	0.6	4	5
DR200P203W-0380-04A-01DP	3.8	12.1	24	66	65.4	0.6	4	3
DR200P203W-0390-04A-01DP	3.9	12.5	24	66	65.4	0.6	4	3
DR200P205W-0390-04A-01DP	3.9	20.2	34	74	73.4	0.6	4	5
DR200P203W-0400-04A-01DP	4	12.7	24	66	65.3	0.7	4	3
DR200P205W-0400-04A-01DP	4	20.7	34	74	73.3	0.7	4	5
DR200P203W-0410-06A-01DP	4.1	13	24	66	65.3	0.7	6	3
DR200P205W-0410-06A-01DP	4.1	21.2	34	74	73.3	0.7	6	5
DR200P203W-0420-06A-01DP	4.2	13.3	24	66	65.3	0.7	6	3
DR200P205W-0420-06A-01DP	4.2	21.7	34	74	73.3	0.7	6	5
DR200P203W-0430-06A-01DP	4.3	13.7	24	66	65.2	0.7	6	3
DR200P205W-0430-06A-01DP	4.3	22.3	34	74	73.2	0.7	6	5
DR200P203W-0440-06A-01DP	4.4	14.1	24	66	65.3	0.7	6	3
DR200P205W-0440-06A-01DP	4.4	22.8	34	74	73.3	0.7	6	5
DR200P203W-0450-06A-01DP	4.5	14.3	24	66	65.3	0.7	6	3
DR200P205W-0450-06A-01DP	4.5	23.3	34	74	73.3	0.7	6	5
DR200P205W-0455-06A-01DP	4.55	23.5	34	74	73.2	0.8	6	5
DR200P203W-0460-06A-01DP	4.6	14.6	24	66	65.2	0.8	6	3
DR200P205W-0460-06A-01DP	4.6	23.8	34	74	73.2	0.8	6	5
DR200P203W-0476-06A-01DP	4.76	15	28	66	65.2	0.8	6	3
DR200P203W-0480-06A-01DP	4.8	15.2	28	66	65.2	0.8	6	3
DR200P205W-0480-06A-01DP	4.8	24.8	44	82	81.2	0.8	6	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203W-0490-06A-01DP	4.9	15.5	28	66	65.2	0.8	6	3
DR200P205W-0490-06A-01DP	4.9	25.3	44	82	81.2	0.8	6	5
DR200P203W-0500-06A-01DP	5	15.8	28	66	65.2	0.8	6	3
DR200P205W-0500-06A-01DP	5	25.8	44	82	81.2	0.8	6	5
DR200P203W-0510-06A-01DP	5.1	16.1	28	66	65.2	0.8	6	3
DR200P205W-0510-06A-01DP	5.1	26.3	44	82	81.2	0.8	6	5
DR200P205W-0516-06A-01DP	5.16	26.6	44	82	81.2	0.8	6	5
DR200P203W-0520-06A-01DP	5.2	16.4	28	66	65.1	0.9	6	3
DR200P205W-0520-06A-01DP	5.2	26.8	44	82	81.1	0.9	6	5
DR200P203W-0530-06A-01DP	5.3	16.7	28	66	65.1	0.9	6	3
DR200P205W-0530-06A-01DP	5.3	27.3	44	82	81.1	0.9	6	5
DR200P203W-0540-06A-01DP	5.4	17	28	66	65.1	0.9	6	3
DR200P205W-0540-06A-01DP	5.4	27.8	44	82	81.1	0.9	6	5
DR200P203W-0550-06A-01DP	5.5	17.4	28	66	65.1	0.9	6	3
DR200P205W-0550-06A-01DP	5.5	28.4	44	82	81.1	0.9	6	5
DR200P205W-0555-06A-01DP	5.55	28.7	44	82	81.1	0.9	6	5
DR200P203W-0556-06A-01DP	5.56	17.5	28	66	65.1	0.9	6	3
DR200P205W-0556-06A-01DP	5.56	28.7	44	82	81.1	0.9	6	5
DR200P203W-0560-06A-01DP	5.6	17.7	28	66	65.1	0.9	6	3
DR200P205W-0560-06A-01DP	5.6	28.9	44	82	81.1	0.9	6	5
DR200P205W-0570-06A-01DP	5.7	29.4	44	82	81	1	6	5
DR200P203W-0580-06A-01DP	5.8	17.6	28	66	65	1	6	3
DR200P205W-0580-06A-01DP	5.8	29.9	44	82	81	1	6	5
DR200P203W-0590-06A-01DP	5.9	18.2	28	66	65	1	6	3
DR200P205W-0590-06A-01DP	5.9	30.4	44	82	81	1	6	5
DR200P203W-0595-06A-01DP	5.95	18.2	28	66	65	1	6	3
DR200P205W-0595-06A-01DP	5.95	30.7	44	82	81	1	6	5
DR200P203W-0600-06A-01DP	6	18.9	28	66	65	1	6	3
DR200P205W-0600-06A-01DP	6	30.9	44	82	81	1	6	5
DR200P203W-0610-08A-01DP	6.1	19.3	34	79	78	1	8	3
DR200P205W-0610-08A-01DP	6.1	31.5	53	91	90	1	8	5
DR200P203W-0620-08A-01DP	6.2	19.6	34	79	77.9	1.1	8	3
DR200P205W-0620-08A-01DP	6.2	32	53	91	89.9	1.1	8	5
DR200P203W-0630-08A-01DP	6.3	19.9	34	79	77.9	1.1	8	3
DR200P205W-0630-08A-01DP	6.3	32.5	53	91	89.9	1.1	8	5
DR200P203W-0635-08A-01DP	6.35	20.1	34	79	78	1.1	8	3
DR200P205W-0635-08A-01DP	6.35	32.8	53	91	90	1.1	8	5
DR200P203W-0640-08A-01DP	6.4	20.2	34	79	77.9	1.1	8	3
DR200P205W-0640-08A-01DP	6.4	33	53	91	89.9	1.1	8	5
DR200P203W-0650-08A-01DP	6.5	20.6	34	79	77.9	1.1	8	3
DR200P205W-0650-08A-01DP	6.5	33.6	53	91	89.9	1.1	8	5

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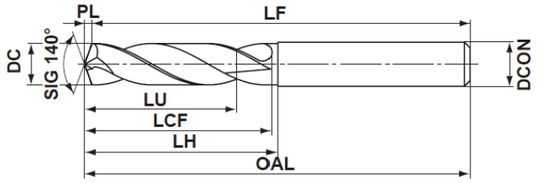
② Cutting data, please go to page 39

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill





External Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203W-0660-08A-01DP	6.6	20.9	34	79	77.9	1.1	8	3
DR200P205W-0660-08A-01DP	6.6	34.1	53	91	89.9	1.1	8	5
DR200P203W-0670-08A-01DP	6.7	21.2	34	79	77.9	1.1	8	3
DR200P205W-0670-08A-01DP	6.7	34.6	53	91	89.9	1.1	8	5
DR200P203W-0675-08A-01DP	6.75	21.3	34	79	77.9	1.1	8	3
DR200P205W-0675-08A-01DP	6.75	34.8	53	91	89.9	1.1	8	5
DR200P203W-0680-08A-01DP	6.8	21.5	34	79	77.9	1.1	8	3
DR200P205W-0680-08A-01DP	6.8	35.1	53	91	89.9	1.1	8	5
DR200P203W-0690-08A-01DP	6.9	21.8	34	79	77.8	1.2	8	3
DR200P205W-0690-08A-01DP	6.9	35.6	53	91	89.8	1.2	8	5
DR200P203W-0700-08A-01DP	7	22.1	34	79	77.8	1.2	8	3
DR200P205W-0700-08A-01DP	7	36.1	53	91	89.8	1.2	8	5
DR200P203W-0710-08A-01DP	7.1	22.4	41	79	77.8	1.2	8	3
DR200P205W-0710-08A-01DP	7.1	36.6	53	91	89.8	1.2	8	5
DR200P203W-0714-08A-01DP	7.14	22.6	41	79	77.8	1.2	8	3
DR200P205W-0714-08A-01DP	7.14	36.9	53	91	89.8	1.2	8	5
DR200P203W-0720-08A-01DP	7.2	22.8	41	79	77.8	1.2	8	3
DR200P205W-0720-08A-01DP	7.2	37.2	53	91	89.8	1.2	8	5
DR200P205W-0730-08A-01DP	7.3	37.7	53	91	89.8	1.2	8	5
DR200P203W-0740-08A-01DP	7.4	23.4	41	79	77.7	1.3	8	3
DR200P205W-0740-08A-01DP	7.4	38.2	53	91	89.7	1.3	8	5
DR200P203W-0750-08A-01DP	7.5	23.7	41	79	77.7	1.3	8	3
DR200P205W-0750-08A-01DP	7.5	38.7	53	91	89.7	1.3	8	5
DR200P205W-0754-08A-01DP	7.54	38.9	53	91	89.7	1.3	8	5
DR200P203W-0760-08A-01DP	7.6	24	41	79	77.7	1.3	8	3
DR200P203W-0770-08A-01DP	7.7	24.3	41	79	77.7	1.3	8	3
DR200P205W-0770-08A-01DP	7.7	39.7	53	91	89.7	1.3	8	5
DR200P203W-0780-08A-01DP	7.8	24.7	41	79	77.7	1.3	8	3
DR200P205W-0780-08A-01DP	7.8	40.3	53	91	89.7	1.3	8	5
DR200P203W-0790-08A-01DP	7.9	25	41	79	77.7	1.3	8	3
DR200P205W-0790-08A-01DP	7.9	40.8	53	91	89.7	1.3	8	5
DR200P203W-0794-08A-01DP	7.94	25.1	41	79	77.6	1.4	8	3
DR200P205W-0794-08A-01DP	7.94	41	53	91	89.6	1.4	8	5
DR200P203W-0800-08A-01DP	8	25.3	41	79	77.6	1.4	8	3
DR200P205W-0800-08A-01DP	8	41.3	53	91	89.6	1.4	8	5
DR200P203W-0810-10A-01DP	8.1	25.6	47	89	87.6	1.4	10	3
DR200P205W-0810-10A-01DP	8.1	41.8	61	103	101.6	1.4	10	5
DR200P205W-0815-10A-01DP	8.15	42.1	61	103	101.6	1.4	10	5
DR200P203W-0820-10A-01DP	8.2	25.9	47	89	87.6	1.4	10	3
DR200P205W-0820-10A-01DP	8.2	42.3	61	103	101.6	1.4	10	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203W-0830-10A-01DP	8.3	26.3	47	89	87.6	1.4	10	3
DR200P205W-0830-10A-01DP	8.3	42.9	61	103	101.6	1.4	10	5
DR200P205W-0833-10A-01DP	8.33	43	61	103	101.6	1.4	10	5
DR200P203W-0840-10A-01DP	8.4	26.6	47	89	87.6	1.4	10	3
DR200P205W-0840-10A-01DP	8.4	43.4	61	103	101.6	1.4	10	5
DR200P203W-0850-10A-01DP	8.5	26.9	47	89	87.6	1.4	10	3
DR200P205W-0850-10A-01DP	8.5	43.9	61	103	101.6	1.4	10	5
DR200P203W-0860-10A-01DP	8.6	27.2	47	89	87.5	1.5	10	3
DR200P205W-0860-10A-01DP	8.6	44.4	61	103	101.5	1.5	10	5
DR200P203W-0870-10A-01DP	8.7	27.5	47	89	87.5	1.5	10	3
DR200P205W-0870-10A-01DP	8.7	44.9	61	103	101.5	1.5	10	5
DR200P203W-0873-10A-01DP	8.73	27.6	47	89	87.5	1.5	10	3
DR200P205W-0873-10A-01DP	8.73	45.1	61	103	101.5	1.5	10	5
DR200P203W-0880-10A-01DP	8.8	27.8	47	89	87.5	1.5	10	3
DR200P205W-0880-10A-01DP	8.8	45.4	61	103	101.5	1.5	10	5
DR200P205W-0890-10A-01DP	8.9	45.9	61	103	101.5	1.5	10	5
DR200P203W-0900-10A-01DP	9	28.5	47	89	87.5	1.5	10	3
DR200P205W-0900-10A-01DP	9	46.5	61	103	101.5	1.5	10	5
DR200P203W-0910-10A-01DP	9.1	28.8	47	89	87.5	1.5	10	3
DR200P205W-0910-10A-01DP	9.1	47	61	103	101.5	1.5	10	5
DR200P203W-0920-10A-01DP	9.2	29.1	47	89	87.4	1.6	10	3
DR200P205W-0920-10A-01DP	9.2	47.5	61	103	101.4	1.6	10	5
DR200P203W-0930-10A-01DP	9.3	29.4	47	89	87.4	1.6	10	3
DR200P205W-0930-10A-01DP	9.3	48	61	103	101.4	1.6	10	5
DR200P203W-0940-10A-01DP	9.4	29.7	47	89	87.4	1.6	10	3
DR200P205W-0940-10A-01DP	9.4	48.5	61	103	101.4	1.6	10	5
DR200P203W-0950-10A-01DP	9.5	30	47	89	87.4	1.6	10	3
DR200P205W-0950-10A-01DP	9.5	48.7	61	103	101.4	1.6	10	5
DR200P203W-0952-10A-01DP	9.52	30.1	47	89	87.4	1.6	10	3
DR200P205W-0952-10A-01DP	9.52	48.6	61	103	101.4	1.6	10	5
DR200P205W-0955-10A-01DP	9.55	48.6	61	103	101.4	1.6	10	5
DR200P203W-0960-10A-01DP	9.6	30.3	47	89	87.4	1.6	10	3
DR200P205W-0960-10A-01DP	9.6	48.5	61	103	101.4	1.6	10	5
DR200P203W-0970-10A-01DP	9.7	30.7	47	89	87.3	1.7	10	3
DR200P203W-0980-10A-01DP	9.8	31	47	89	87.3	1.7	10	3
DR200P205W-0980-10A-01DP	9.8	48.3	61	103	101.3	1.7	10	5
DR200P203W-0990-10A-01DP	9.9	31.3	47	89	87.3	1.7	10	3
DR200P205W-0990-10A-01DP	9.9	48.1	61	103	101.3	1.7	10	5
DR200P203W-1000-10A-01DP	10	31.6	47	89	87.3	1.7	10	3
DR200P205W-1000-10A-01DP	10	50	61	103	101.3	1.7	10	5

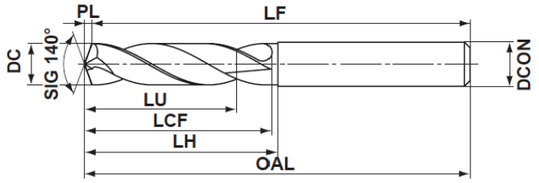
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 39

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill





External Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203W-1010-12A-01DP	10.1	31.9	55	102	100.3	1.7	12	3
DR200P205W-1010-12A-01DP	10.1	52.1	71	118	116.3	1.7	12	5
DR200P203W-1020-12A-01DP	10.2	32.3	55	102	100.3	1.7	12	3
DR200P205W-1020-12A-01DP	10.2	52.7	71	118	116.3	1.7	12	5
DR200P203W-1030-12A-01DP	10.3	32.6	55	102	100.2	1.8	12	3
DR200P205W-1030-12A-01DP	10.3	53.2	71	118	116.2	1.8	12	5
DR200P203W-1032-12A-01DP	10.32	32.6	55	102	100.2	1.8	12	3
DR200P205W-1032-12A-01DP	10.32	53.3	71	118	116.2	1.8	12	5
DR200P203W-1040-12A-01DP	10.4	32.9	55	102	100.2	1.8	12	3
DR200P205W-1040-12A-01DP	10.4	53.7	71	118	116.2	1.8	12	5
DR200P203W-1050-12A-01DP	10.5	33.2	55	102	100.2	1.8	12	3
DR200P205W-1050-12A-01DP	10.5	54.2	71	118	116.2	1.8	12	5
DR200P205W-1060-12A-01DP	10.6	54.7	71	118	116.2	1.8	12	5
DR200P203W-1070-12A-01DP	10.7	33.8	55	102	100.2	1.8	12	3
DR200P205W-1070-12A-01DP	10.7	55.2	71	118	116.2	1.8	12	5
DR200P205W-1071-12A-01DP	10.71	55.3	71	118	116.2	1.8	12	5
DR200P203W-1080-12A-01DP	10.8	34.2	55	102	100.2	1.8	12	3
DR200P205W-1080-12A-01DP	10.8	55.8	71	118	116.2	1.8	12	5
DR200P205W-1090-12A-01DP	10.9	56.3	71	118	116.1	1.9	12	5
DR200P203W-1100-12A-01DP	11	34.8	55	102	100.1	1.9	12	3
DR200P205W-1100-12A-01DP	11	56.8	71	118	116.1	1.9	12	5
DR200P203W-1110-12A-01DP	11.1	35.1	55	102	100.1	1.9	12	3
DR200P205W-1110-12A-01DP	11.1	57.3	71	118	116.1	1.9	12	5
DR200P203W-1111-12A-01DP	11.11	35.1	55	102	100.1	1.9	12	3
DR200P203W-1120-12A-01DP	11.2	35.4	55	102	100.1	1.9	12	3
DR200P205W-1120-12A-01DP	11.2	57.6	71	118	116.1	1.9	12	5
DR200P203W-1130-12A-01DP	11.3	35.7	55	102	100.1	1.9	12	3
DR200P205W-1130-12A-01DP	11.3	57.4	71	118	116.1	1.9	12	5
DR200P203W-1140-12A-01DP	11.4	36.1	55	102	100	2	12	3
DR200P203W-1150-12A-01DP	11.5	36.4	55	102	100	2	12	3
DR200P205W-1150-12A-01DP	11.5	57.2	71	118	116	2	12	5
DR200P203W-1160-12A-01DP	11.6	36.7	55	102	100	2	12	3
DR200P203W-1170-12A-01DP	11.7	37	55	102	100	2	12	3
DR200P205W-1170-12A-01DP	11.7	57	71	118	116	2	12	5
DR200P203W-1180-12A-01DP	11.8	37	55	102	100	2	12	3
DR200P205W-1180-12A-01DP	11.8	56.8	71	118	116	2	12	5
DR200P203W-1190-12A-01DP	11.9	37.6	55	102	100	2	12	3
DR200P203W-1200-12A-01DP	12	38	55	102	99.9	2.1	12	3
DR200P205W-1200-12A-01DP	12	60	71	118	115.9	2.1	12	5
DR200P203W-1210-14A-01DP	12.1	38.3	60	107	104.9	2.1	14	3
DR200P205W-1210-14A-01DP	12.1	62.5	77	124	121.9	2.1	14	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
DR200P203W-1220-14A-01DP	12.2	38.6	60	107	104.9	2.1	14	3
DR200P205W-1220-14A-01DP	12.2	62.4	77	124	121.9	2.1	14	5
DR200P203W-1230-14A-01DP	12.3	38.9	60	107	104.9	2.1	14	3
DR200P205W-1230-14A-01DP	12.3	62.2	77	124	121.9	2.1	14	5
DR200P203W-1250-14A-01DP	12.5	39.5	60	107	104.9	2.1	14	3
DR200P205W-1250-14A-01DP	12.5	63	77	124	121.9	2.1	14	5
DR200P203W-1260-14A-01DP	12.6	39.9	60	107	104.8	2.2	14	3
DR200P203W-1270-14A-01DP	12.7	40.2	60	107	104.8	2.2	14	3
DR200P205W-1270-14A-01DP	12.7	64	77	124	121.8	2.2	14	5
DR200P203W-1280-14A-01DP	12.8	40.5	60	107	104.8	2.2	14	3
DR200P205W-1280-14A-01DP	12.8	64.6	77	124	121.8	2.2	14	5
DR200P203W-1300-14A-01DP	13	41.1	60	107	104.8	2.2	14	3
DR200P205W-1300-14A-01DP	13	61.4	77	124	121.8	2.2	14	5
DR200P203W-1310-14A-01DP	13.1	41.4	60	107	104.7	2.3	14	3
DR200P205W-1310-14A-01DP	13.1	61.3	77	124	121.7	2.3	14	5
DR200P205W-1325-14A-01DP	13.25	61.1	77	124	121.7	2.3	14	5
DR200P203W-1350-14A-01DP	13.5	42.7	60	107	104.7	2.3	14	3
DR200P205W-1350-14A-01DP	13.5	60.8	77	124	121.7	2.3	14	5
DR200P205W-1375-14A-01DP	13.75	60.5	77	124	121.6	2.4	14	5
DR200P203W-1380-14A-01DP	13.8	43.4	60	107	104.6	2.4	14	3
DR200P205W-1380-14A-01DP	13.8	60.4	77	124	121.6	2.4	14	5
DR200P205W-1389-14A-01DP	13.89	60.3	77	124	121.6	2.4	14	5
DR200P203W-1400-14A-01DP	14	44.3	60	107	104.6	2.4	14	3
DR200P205W-1400-14A-01DP	14	63	77	124	121.6	2.4	14	5
DR200P203W-1425-16A-01DP	14.25	45	65	115	112.5	2.5	16	3
DR200P205W-1425-16A-01DP	14.25	68.8	83	133	130.5	2.5	16	5
DR200P203W-1429-16A-01DP	14.29	45.2	65	115	112.5	2.5	16	3
DR200P205W-1429-16A-01DP	14.29	68.7	83	133	130.5	2.5	16	5
DR200P203W-1450-16A-01DP	14.5	45.8	65	115	112.5	2.5	16	3
DR200P205W-1450-16A-01DP	14.5	68.5	83	133	130.5	2.5	16	5
DR200P203W-1469-16A-01DP	14.69	46.4	65	115	112.5	2.5	16	3
DR200P205W-1480-16A-01DP	14.8	68.2	83	133	130.4	2.6	16	5
DR200P203W-1500-16A-01DP	15	47.4	65	115	112.4	2.6	16	3
DR200P205W-1500-16A-01DP	15	68	83	133	130.4	2.6	16	5
DR200P203W-1550-16A-01DP	15.5	49	65	115	112.3	2.7	16	3
DR200P205W-1550-16A-01DP	15.5	67.5	83	133	130.3	2.7	16	5
DR200P203W-1580-16A-01DP	15.8	49.2	65	115	112.2	2.8	16	3
DR200P205W-1580-16A-01DP	15.8	67.2	83	133	130.2	2.8	16	5
DR200P203W-1587-16A-01DP	15.87	49.1	65	115	112.2	2.8	16	3
DR200P203W-1600-16A-01DP	16	49	65	115	112.2	2.8	16	3
DR200P205W-1600-16A-01DP	16	67	83	133	130.2	2.8	16	5

① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 39

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
P	Unalloyed Steel					
	P1.1.Z.AN	C = 0.05–0.1%	125	90	150	170
	P1.1.Z.AN	C = 0.1–0.25%	125	90	150	170
	P1.2.Z.AN	C = 0.25–0.55%	150	90	140	170
	P1.3.Z.AN	C = 0.55–0.80%	170	90	140	170
	High Carbon Steel					
	P1.3.Z.AN	Carbon Tool Steel	210	100	130	150
	Low Alloy Steel					
	P2.1.Z.AN	Non-Hardened	175	80	130	160
	P2.5.Z.HT	Hardeded and Tempered	275	50	80	90
	P2.5.Z.HT	Hardeded And Tempered	350	40	60	70
	High Alloy Steel					
	P3.0.Z.AN	Annealed	200	40	90	90
	P3.0.Z.HT	Hardened Tool Steel	300	40	60	70
	Steel Castings					
	P1.5.C.UT	Unalloyed	150	80	130	140
	P2.6.C.UT	Low-Alloy (Alloying Elements ≤5%)	200	80	130	120

Drill Diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.06	0.1	0.13
4	0.07	0.11	0.14
6	0.11	0.18	0.24
8	0.16	0.21	0.25
10	0.19	0.23	0.27
12	0.22	0.25	0.29
16	0.23	0.28	0.33
20	0.26	0.3	0.34

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

④ Under external coolant condition, please adjust cutting speed to secure good chips formation and evacuation

⑤ Under external coolant condition, please decrease feed per revolution to secure chips evacuation

YPP Drill® DR200P

Dedicated High-Performance Solid Carbide Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
M	Austenitic Stainless Steel					
	M1.0.C.UT	Cast+Untreated	165	48	70	72
	M1.0.Z.AQ	Annealed/Quenched	200	48	70	72
	M1.0.Z.PH	PH-Hardened	350	44	60	66
	M1.1.Z.AQ	Machinability Improved	165	48	70	72
	M1.2.Z.AQ	Free Cutting	200	48	70	72
	M1.3.C.AQ	Ti-Stabilized+Cast	200	48	70	72
	M1.3.Z.AQ	Ti-Stabilized	200	48	70	72
	M1.4.Z.AQ	High Strength	250	64	90	96
	Super Austenitic (Ni>20%) Stainless Steel					
	M2.0.C.AQ	Cast+annealed/Quenched	165	30	40	50
	M2.0.Z.AQ	Annealed/Quenched	200	30	40	50
	Duplex (Austenitic/Ferritic) Stainless Steel					
	M3.1.Z.AQ >60%	Ferrite (N<0.10%) >60%	250	40	60	70
	M3.2.Z.AQ <60%	Ferrite (N≥0.10%) <60%	250	40	60	70

Drill diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.05	0.07	0.1
4	0.08	0.1	0.12
6	0.09	0.11	0.13
8	0.1	0.12	0.14
10	0.13	0.14	0.17
12	0.13	0.16	0.19
16	0.14	0.2	0.23
20	0.17	0.22	0.25

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

④ Under external coolant condition, please adjust cutting speed to secure good chips formation and evacuation

⑤ Under external coolant condition, please decrease feed per revolution to secure chips evacuation



Versatile Solution

Customized Solution

ISO Workpiece Materials

P K M N

YPP Drill® LFRA

INTRODUCTION

Deep Hole Drill

Overview & Applications

- Covers many material groups
- Conventional drilling, cross holes & inclined surface
- Hole tolerance H8–H9
- Diameter range: 3.0–20.0 mm
- Drill length range 12–40xDC

Features & Benefits

- Optimized drill center design helps to reduce axial cutting force
- Provide internal coolant solutions
- Curve cutting edge generates low cutting force
- Secure tool life through high reconditioning quality
- Good chips evacuation thanks to chips flute optimization design
- Advanced ER treatment which reduce the risk of cutting edge breakage

Ordering Code

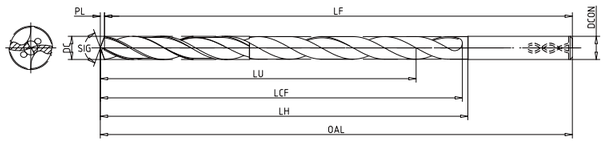
L — F — RA — P — 12 — N — 0900 — 10A — 01DH

- L – Product Family
- F – Cutting Edge Type
- RA – Central Cutting Edge
- P – P- Material Group
- 12 – 12xDC
- N – Internal Coolant
- 0900 – Drill Diameter 0900–DC9mm
- 10 – Shank Diameter
- A – HA Cylindrical Shank
- 01 – Substrate AK40
- DH – Coating

YPP Drill® LFRA

Deep Hole Drill





Shank Diameter Tolerance	h6
SIG	135°
Material Group	ISO-P, ISO-K

ISO Material Group P K

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAP10-0300-06A-01DH	3	31.5	47	89	88.5	0.5	6	10
LFRAP12-0300-06A-01DH	3	36.5	52	94	93.5	0.5	6	12
LFRAP10-0310-06A-01DH	3.1	32.7	47	89	88.5	0.5	6	10
LFRAP12-0310-06A-01DH	3.1	37.7	52	94	93.5	0.5	6	12
LFRAP10-0320-06A-01DH	3.2	33.9	47	89	88.5	0.5	6	10
LFRAP12-0320-06A-01DH	3.2	38.9	52	94	93.5	0.5	6	12
LFRAP10-0330-06A-01DH	3.3	35.1	47	89	88.5	0.5	6	10
LFRAP12-0330-06A-01DH	3.3	40.1	52	94	93.5	0.5	6	12
LFRAP10-0340-06A-01DH	3.4	36.4	47	89	88.4	0.6	6	10
LFRAP12-0340-06A-01DH	3.4	41.4	52	94	93.4	0.6	6	12
LFRAP10-0350-06A-01DH	3.5	37.6	47	89	88.4	0.6	6	10
LFRAP12-0350-06A-01DH	3.5	42.6	52	94	93.4	0.6	6	12
LFRAP15-0350-06A-01DH	3.5	53.1	63	105	104.4	0.6	6	15
LFRAP10-0370-06A-01DH	3.7	38.9	47	89	88.4	0.6	6	10
LFRAP11-0370-06A-01DH	3.7	43.9	52	94	93.4	0.6	6	11
LFRAP10-0380-06A-01DH	3.8	39.2	60	102	101.4	0.6	6	10
LFRAP12-0380-06A-01DH	3.8	46.2	67	109	108.4	0.6	6	12
LFRAP15-0380-06A-01DH	3.8	57.6	68	110	109.4	0.6	6	15
LFRAP10-0400-06A-01DH	4	41.7	60	102	101.3	0.7	6	10
LFRAP12-0400-06A-01DH	4	48.7	67	109	108.3	0.7	6	12
LFRAP15-0400-06A-01DH	4	60.7	72	114	113.3	0.7	6	15
LFRAP20-0400-06A-01DH	4	80.7	92	134	133.3	0.7	6	20
LFRAP30-0400-06A-01DH	4	120.7	132	174	173.3	0.7	6	30
LFRAP10-0410-06A-01DH	4.1	42.9	60	102	101.3	0.7	6	10
LFRAP12-0410-06A-01DH	4.1	49.9	67	109	108.3	0.7	6	12
LFRAP10-0420-06A-01DH	4.2	44.1	60	102	101.3	0.7	6	10
LFRAP12-0420-06A-01DH	4.2	51.1	67	109	108.3	0.7	6	12
LFRAP15-0420-06A-01DH	4.2	63.7	76	118	117.3	0.7	6	15
LFRAP20-0420-06A-01DH	4.2	84.7	97	139	138.3	0.7	6	20
LFRAP10-0430-06A-01DH	4.3	45.3	60	102	101.3	0.7	6	10
LFRAP12-0430-06A-01DH	4.3	52.3	67	109	108.3	0.7	6	12
LFRAP10-0450-06A-01DH	4.5	47.7	60	102	101.3	0.7	6	10
LFRAP12-0450-06A-01DH	4.5	54.7	67	109	108.3	0.7	6	12
LFRAP15-0450-06A-01DH	4.5	68.2	81	123	122.3	0.7	6	15
LFRAP20-0450-06A-01DH	4.5	90.7	104	146	145.3	0.7	6	20
LFRAP30-0450-06A-01DH	4.5	135.7	149	191	190.3	0.7	6	30
LFRAP40-0450-06A-01DH	4.5	153.7	167	209	208.3	0.7	6	40
LFRAP10-0460-06A-01DH	4.6	49	60	102	101.2	0.8	6	10
LFRAP12-0460-06A-01DH	4.6	56	67	109	108.2	0.8	6	12
LFRAP10-0480-06A-01DH	4.8	51.4	60	102	101.2	0.8	6	10
LFRAP12-0480-06A-01DH	4.8	58.4	86	128	127.2	0.8	6	12

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAP15-0480-06A-01DH	4.8	72.8	86	128	127.2	0.8	6	15
LFRAP20-0480-06A-01DH	4.8	96.8	110	152	151.2	0.8	6	20
LFRAP10-0500-06A-01DH	5	50.8	68	110	109.2	0.8	6	10
LFRAP12-0500-06A-01DH	5	60.8	86	128	127.2	0.8	6	12
LFRAP15-0500-06A-01DH	5	75.8	90	132	131.2	0.8	6	15
LFRAP20-0500-06A-01DH	5	100.8	115	157	156.2	0.8	6	20
LFRAP30-0500-06A-01DH	5	150.8	165	207	206.2	0.8	6	30
LFRAP40-0500-06A-01DH	5	200.8	215	257	256.2	0.8	6	40
LFRAP10-0510-06A-01DH	5.1	52	75	117	116.2	0.8	6	10
LFRAP12-0510-06A-01DH	5.1	62	86	128	127.2	0.8	6	12
LFRAP10-0520-06A-01DH	5.2	53.3	75	117	116.1	0.9	6	10
LFRAP12-0520-06A-01DH	5.2	63.3	86	128	127.1	0.9	6	12
LFRAP10-0550-06A-01DH	5.5	56.9	75	117	116.1	0.9	6	10
LFRAP12-0550-06A-01DH	5.5	66.9	86	128	127.1	0.9	6	12
LFRAP15-0550-06A-01DH	5.5	83.4	99	141	140.1	0.9	6	15
LFRAP20-0550-06A-01DH	5.5	110.9	127	169	168.1	0.9	6	20
LFRAP30-0550-06A-01DH	5.5	165.9	182	224	223.1	0.9	6	30
LFRAP40-0550-06A-01DH	5.5	220.9	237	279	278.1	0.9	6	40
LFRAP10-0580-06A-01DH	5.8	59.6	75	117	116	1	6	10
LFRAP12-0580-06A-01DH	5.8	70.6	86	128	127	1	6	12
LFRAP15-0580-06A-01DH	5.8	88	104	146	145	1	6	15
LFRAP20-0580-06A-01DH	5.8	117	133	175	174	1	6	20
LFRAP10-0600-06A-01DH	6	61	75	117	116	1	6	10
LFRAP12-0600-06A-01DH	6	73	86	128	127	1	6	12
LFRAP15-0600-06A-01DH	6	91	108	150	149	1	6	15
LFRAP20-0600-06A-01DH	6	121	138	180	179	1	6	20
LFRAP30-0600-06A-01DH	6	181	198	240	239	1	6	30
LFRAP40-0600-06A-01DH	6	241	258	300	299	1	6	40
LFRAP10-0610-08A-01DH	6.1	62	86	128	127	1	8	10
LFRAP12-0610-08A-01DH	6.1	74.2	116	158	157	1	8	12
LFRAP10-0620-08A-01DH	6.2	63	86	128	127	1	8	10
LFRAP12-0620-08A-01DH	6.2	75.4	116	158	157	1	8	12
LFRAP10-0630-08A-01DH	6.3	64	86	128	127	1	8	10
LFRAP12-0630-08A-01DH	6.3	76.6	116	158	157	1	8	12
LFRAP10-0650-08A-01DH	6.5	66.1	86	128	126.9	1.1	8	10
LFRAP12-0650-08A-01DH	6.5	79.1	116	158	156.9	1.1	8	12
LFRAP15-0650-08A-01DH	6.5	98.6	116	158	156.9	1.1	8	15
LFRAP20-0650-08A-01DH	6.5	131.1	150	192	190.9	1.1	8	20
LFRAP30-0650-08A-01DH	6.5	196.1	215	257	255.9	1.1	8	30
LFRAP40-0650-08A-01DH	6.5	261.1	280	322	320.9	1.1	8	40

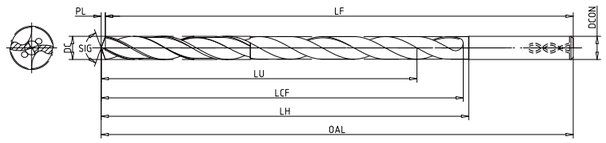
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 49

YPP Drill® LFRA

Deep Hole Drill





Shank Diameter Tolerance	h6
SIG	135°
Material Group	ISO-P, ISO-K

ISO Material Group P K

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAP10-0660-08A-01DH	6.6	67.1	86	128	126.9	1.1	8	10
LFRAP12-0660-08A-01DH	6.6	80.3	116	158	156.9	1.1	8	12
LFRAP10-0670-08A-01DH	6.7	68.1	86	128	126.9	1.1	8	10
LFRAP12-0670-08A-01DH	6.7	81.5	116	158	156.9	1.1	8	12
LFRAP10-0680-08A-01DH	6.8	69.1	86	128	126.9	1.1	8	10
LFRAP12-0680-08A-01DH	6.8	82.7	116	158	156.9	1.1	8	12
LFRAP15-0680-08A-01DH	6.8	103.1	122	164	162.9	1.1	8	15
LFRAP20-0680-08A-01DH	6.8	137.1	156	198	196.9	1.1	8	20
LFRAP10-0690-08A-01DH	6.9	70.1	86	128	126.9	1.1	8	10
LFRAP12-0690-08A-01DH	6.9	83.9	116	158	156.9	1.1	8	12
LFRAP10-0700-08A-01DH	7	71.1	86	128	126.9	1.1	8	10
LFRAP12-0700-08A-01DH	7	85.1	116	158	156.9	1.1	8	12
LFRAP15-0700-08A-01DH	7	106.1	126	168	166.9	1.1	8	15
LFRAP20-0700-08A-01DH	7	141.1	161	203	201.9	1.1	8	20
LFRAP30-0700-08A-01DH	7	211.1	231	273	271.9	1.1	8	30
LFRAP40-0700-08A-01DH	7	281.1	301	343	341.9	1.1	8	40
LFRAP10-0740-08A-01DH	7.4	75.2	101	143	141.8	1.2	8	10
LFRAP12-0740-08A-01DH	7.4	90	116	158	156.8	1.2	8	12
LFRAP10-0750-08A-01DH	7.5	76.2	101	143	141.8	1.2	8	10
LFRAP12-0750-08A-01DH	7.5	91.2	116	158	156.8	1.2	8	12
LFRAP15-0750-08A-01DH	7.5	113.7	135	177	175.8	1.2	8	15
LFRAP20-0750-08A-01DH	7.5	151.2	173	215	213.8	1.2	8	20
LFRAP30-0750-08A-01DH	7.5	226.2	248	290	288.8	1.2	8	30
LFRAP40-0750-08A-01DH	7.5	301.2	323	365	363.8	1.2	8	40
LFRAP10-0760-08A-01DH	7.6	77.2	101	143	141.8	1.2	8	10
LFRAP12-0760-08A-01DH	7.6	92.4	116	158	156.8	1.2	8	12
LFRAP10-0770-08A-01DH	7.7	78.3	101	143	141.7	1.3	8	10
LFRAP12-0770-08A-01DH	7.7	93.7	116	158	156.7	1.3	8	12
LFRAP10-0780-08A-01DH	7.8	79.3	101	143	141.7	1.3	8	10
LFRAP12-0780-08A-01DH	7.8	94.9	116	158	156.7	1.3	8	12
LFRAP10-0800-08A-01DH	8	81.3	101	143	141.7	1.3	8	10
LFRAP12-0800-08A-01DH	8	97.3	116	158	156.7	1.3	8	12
LFRAP15-0800-08A-01DH	8	121.3	144	186	184.7	1.3	8	15
LFRAP20-0800-08A-01DH	8	161.3	184	226	224.7	1.3	8	20
LFRAP30-0800-08A-01DH	8	241.3	264	306	304.7	1.3	8	30
LFRAP40-0800-08A-01DH	8	321.3	344	386	384.7	1.3	8	40
LFRAP10-0810-10A-01DH	8.1	82.3	106	152	150.7	1.3	10	10
LFRAP12-0810-10A-01DH	8.1	98.5	146	192	190.7	1.3	10	12
LFRAP10-0820-10A-01DH	8.2	83.3	106	152	150.7	1.3	10	10
LFRAP12-0820-10A-01DH	8.2	99.7	146	192	190.7	1.3	10	12
LFRAP10-0840-10A-01DH	8.4	85.4	106	152	150.6	1.4	10	10

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAP12-0840-10A-01DH	8.4	102.2	146	192	190.6	1.4	10	12
LFRAP10-0850-10A-01DH	8.5	86.4	106	152	150.6	1.4	10	10
LFRAP12-0850-10A-01DH	8.5	103.4	146	192	190.6	1.4	10	12
LFRAP15-0850-10A-01DH	8.5	128.9	153	199	197.6	1.4	10	15
LFRAP20-0850-10A-01DH	8.5	171.4	196	242	240.6	1.4	10	20
LFRAP30-0850-10A-01DH	8.5	256.4	281	327	325.6	1.4	10	30
LFRAP10-0860-10A-01DH	8.6	87.4	106	152	150.6	1.4	10	10
LFRAP12-0860-10A-01DH	8.6	104.6	146	192	190.6	1.4	10	12
LFRAP10-0870-10A-01DH	8.7	88.4	106	152	150.6	1.4	10	10
LFRAP12-0870-10A-01DH	8.7	105.8	146	192	190.6	1.4	10	12
LFRAP10-0880-10A-01DH	8.8	89.4	106	152	150.6	1.4	10	10
LFRAP12-0880-10A-01DH	8.8	107	146	192	190.6	1.4	10	12
LFRAP10-0900-10A-01DH	9	91.5	128	174	172.5	1.5	10	10
LFRAP12-0900-10A-01DH	9	109.5	146	192	190.5	1.5	10	12
LFRAP15-0900-10A-01DH	9	136.5	162	208	206.5	1.5	10	15
LFRAP20-0900-10A-01DH	9	181.5	207	253	251.5	1.5	10	20
LFRAP30-0900-10A-01DH	9	271.5	297	343	341.5	1.5	10	30
LFRAP10-0930-10A-01DH	9.3	94.5	128	174	172.5	1.5	10	10
LFRAP12-0930-10A-01DH	9.3	113.1	146	192	190.5	1.5	10	12
LFRAP10-0950-10A-01DH	9.5	96.6	128	174	172.4	1.6	10	10
LFRAP12-0950-10A-01DH	9.5	115.6	146	192	190.4	1.6	10	12
LFRAP15-0950-10A-01DH	9.5	144.1	171	217	215.4	1.6	10	15
LFRAP20-0950-10A-01DH	9.5	191.6	219	265	263.4	1.6	10	20
LFRAP30-0950-10A-01DH	9.5	286.6	314	360	358.4	1.6	10	30
LFRAP10-0980-10A-01DH	9.8	99.6	128	174	172.4	1.6	10	10
LFRAP12-0980-10A-01DH	9.8	119.2	146	192	190.4	1.6	10	12
LFRAP10-1000-10A-01DH	10	101.6	128	174	172.4	1.6	10	10
LFRAP12-1000-10A-01DH	10	121.6	146	192	190.4	1.6	10	12
LFRAP15-1000-10A-01DH	10	151.6	180	226	224.4	1.6	10	15
LFRAP20-1000-10A-01DH	10	201.6	230	276	274.4	1.6	10	20
LFRAP30-1000-10A-01DH	10	301.6	330	376	374.4	1.6	10	30
LFRAP10-1020-12A-01DH	10.2	103.7	156	208	206.3	1.7	12	10
LFRAP12-1020-12A-01DH	10.2	124.1	176	228	226.3	1.7	12	12
LFRAP10-1030-12A-01DH	10.3	104.7	156	208	206.3	1.7	12	10
LFRAP12-1030-12A-01DH	10.3	125.3	176	228	226.3	1.7	12	12
LFRAP10-1040-12A-01DH	10.4	105.7	156	208	206.3	1.7	12	10
LFRAP12-1040-12A-01DH	10.4	126.5	176	228	226.3	1.7	12	12
LFRAP10-1050-12A-01DH	10.5	106.7	156	208	206.3	1.7	12	10
LFRAP12-1050-12A-01DH	10.5	127.7	176	228	226.3	1.7	12	12
LFRAP15-1050-12A-01DH	10.5	159.2	188	240	238.3	1.7	12	15
LFRAP20-1050-12A-01DH	10.5	211.7	241	293	291.3	1.7	12	20

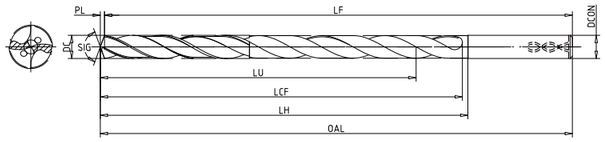
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 49

YPP Drill® LFRA

Deep Hole Drill





Shank Diameter Tolerance	h6
SIG	135°
Material Group	ISO-P, ISO-K

ISO Material Group P K

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAP10-1100-12A-01DH	11	111.8	156	208	206.2	1.8	12	10
LFRAP12-1100-12A-01DH	11	133.8	176	228	226.2	1.8	12	12
LFRAP15-1100-12A-01DH	11	166.8	197	249	247.2	1.8	12	15
LFRAP20-1100-12A-01DH	11	221.8	252	304	302.2	1.8	12	20
LFRAP10-1120-12A-01DH	11.2	113.8	156	208	206.2	1.8	12	10
LFRAP12-1120-12A-01DH	11.2	136.2	176	228	226.2	1.8	12	12
LFRAP10-1150-12A-01DH	11.5	116.9	156	208	206.1	1.9	12	10
LFRAP12-1150-12A-01DH	11.5	139.9	176	228	226.1	1.9	12	12
LFRAP15-1150-12A-01DH	11.5	174.4	206	258	256.1	1.9	12	15
LFRAP20-1150-12A-01DH	11.5	231.9	264	316	314.1	1.9	12	20
LFRAP10-1180-12A-01DH	11.8	119.9	156	208	206.1	1.9	12	10
LFRAP12-1180-12A-01DH	11.8	143.5	176	228	226.1	1.9	12	12
LFRAP10-1200-12A-01DH	12	122	156	208	206	2	12	10
LFRAP12-1200-12A-01DH	12	146	176	228	226	2	12	12
LFRAP15-1200-12A-01DH	12	182	215	267	265	2	12	15
LFRAP20-1200-12A-01DH	12	242	275	327	325	2	12	20
LFRAP10-1230-14A-01DH	12.3	125.1	182	234	232	2	14	10
LFRAP12-1230-14A-01DH	12.3	149.7	206	258	256	2	14	12
LFRAP10-1250-14A-01DH	12.5	127	182	234	232	2	14	10
LFRAP12-1250-14A-01DH	12.5	152	206	258	256	2	14	12
LFRAP10-1270-14A-01DH	12.7	129.1	182	234	231.9	2.1	14	10
LFRAP12-1270-14A-01DH	12.7	154.5	206	258	255.9	2.1	14	12
LFRAP10-1300-14A-01DH	13	132.1	182	234	231.9	2.1	14	10
LFRAP12-1300-14A-01DH	13	158.1	206	258	255.9	2.1	14	12
LFRAP10-1310-14A-01DH	13.1	133.1	182	234	231.9	2.1	14	10
LFRAP12-1310-14A-01DH	13.1	159.3	206	258	255.9	2.1	14	12
LFRAP10-1350-14A-01DH	13.5	137.2	182	234	231.8	2.2	14	10
LFRAP12-1350-14A-01DH	13.5	164.2	206	258	255.8	2.2	14	12
LFRAP10-1400-14A-01DH	14	142.3	182	234	231.7	2.3	14	10
LFRAP12-1400-14A-01DH	14	170.3	206	258	255.7	2.3	14	12
LFRAP10-1450-16A-01DH	14.5	147.4	207	262	259.6	2.4	16	10
LFRAP12-1450-16A-01DH	14.5	176.4	236	291	288.6	2.4	16	12
LFRAP10-1500-16A-01DH	15	152.5	207	262	259.5	2.5	16	10
LFRAP12-1500-16A-01DH	15	182.5	236	291	288.5	2.5	16	12
LFRAP10-1550-16A-01DH	15.5	157.5	207	262	259.5	2.5	16	10
LFRAP12-1550-16A-01DH	15.5	188.5	236	291	288.5	2.5	16	12
LFRAP10-1600-16A-01DH	16	162.6	207	262	259.4	2.6	16	10
LFRAP12-1600-16A-01DH	16	194.6	236	291	288.4	2.6	16	12

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR

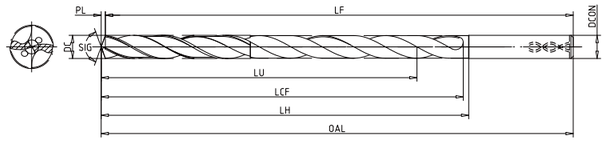
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 49

YPP Drill® LFRA

Deep Hole Drill





Shank Diameter Tolerance	h6
SIG	135°
Material Group	ISO-M

ISO Material Group M

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAM10-0300-04A-01DP	3	31.5	47	89	88.5	0.5	6	10
LFRAM12-0300-06A-01DP	3	36.5	52	94	93.5	0.5	6	12
LFRAM10-0310-06A-01DP	3.1	32.7	47	89	88.5	0.5	6	10
LFRAM12-0310-06A-01DP	3.1	37.7	52	94	93.5	0.5	6	12
LFRAM10-0320-06A-01DP	3.2	33.9	47	89	88.5	0.5	6	10
LFRAM12-0320-06A-01DP	3.2	38.9	52	94	93.5	0.5	6	12
LFRAM10-0330-06A-01DP	3.3	35.1	47	89	88.5	0.5	6	10
LFRAM12-0330-06A-01DP	3.3	40.1	52	94	93.5	0.5	6	12
LFRAM10-0340-06A-01DP	3.4	36.4	47	89	88.4	0.6	6	10
LFRAM12-0340-06A-01DP	3.4	41.4	52	94	93.4	0.6	6	12
LFRAM10-0350-06A-01DP	3.5	37.6	47	89	88.4	0.6	6	10
LFRAM12-0350-06A-01DP	3.5	42.6	52	94	93.4	0.6	6	12
LFRAM15-0350-06A-01DP	3.5	53.1	63	105	104.4	0.6	6	15
LFRAM10-0370-06A-01DP	3.7	38.9	47	89	88.4	0.6	6	10
LFRAM11-0370-06A-01DP	3.7	43.9	52	94	93.4	0.6	6	11
LFRAM10-0380-06A-01DP	3.8	39.2	60	102	101.4	0.6	6	10
LFRAM12-0380-06A-01DP	3.8	46.2	67	109	108.4	0.6	6	12
LFRAM15-0380-06A-01DP	3.8	57.6	68	110	109.4	0.6	6	15
LFRAM10-0400-06A-01DP	4	41.7	60	102	101.3	0.7	6	10
LFRAM12-0400-06A-01DP	4	48.7	67	109	108.3	0.7	6	12
LFRAM15-0400-06A-01DP	4	60.7	72	114	113.3	0.7	6	15
LFRAM20-0400-06A-01DP	4	80.7	92	134	133.3	0.7	6	20
LFRAM30-0400-06A-01DP	4	120.7	132	174	173.3	0.7	6	30
LFRAM10-0410-06A-01DP	4.1	42.9	60	102	101.3	0.7	6	10
LFRAM12-0410-06A-01DP	4.1	49.9	67	109	108.3	0.7	6	12
LFRAM10-0420-06A-01DP	4.2	44.1	60	102	101.3	0.7	6	10
LFRAM12-0420-06A-01DP	4.2	51.1	67	109	108.3	0.7	6	12
LFRAM15-0420-06A-01DP	4.2	63.7	76	118	117.3	0.7	6	15
LFRAM20-0420-06A-01DP	4.2	84.7	97	139	138.3	0.7	6	20
LFRAM10-0430-06A-01DP	4.3	45.3	60	102	101.3	0.7	6	10
LFRAM12-0430-06A-01DP	4.3	52.3	67	109	108.3	0.7	6	12
LFRAM10-0450-06A-01DP	4.5	47.7	60	102	101.3	0.7	6	10
LFRAM12-0450-06A-01DP	4.5	54.7	67	109	108.3	0.7	6	12
LFRAM15-0450-06A-01DP	4.5	68.2	81	123	122.3	0.7	6	15
LFRAM20-0450-06A-01DP	4.5	90.7	104	146	145.3	0.7	6	20
LFRAM30-0450-06A-01DP	4.5	135.7	149	191	190.3	0.7	6	30
LFRAM40-0450-06A-01DP	4.5	153.7	167	209	208.3	0.7	6	40
LFRAM10-0460-06A-01DP	4.6	49	60	102	101.2	0.8	6	10
LFRAM12-0460-06A-01DP	4.6	56	67	109	108.2	0.8	6	12
LFRAM10-0480-06A-01DP	4.8	51.4	60	102	101.2	0.8	6	10
LFRAM12-0480-06A-01DP	4.8	58.4	86	128	127.2	0.8	6	12

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAM15-0480-06A-01DP	4.8	72.8	86	128	127.2	0.8	6	15
LFRAM20-0480-06A-01DP	4.8	96.8	110	152	151.2	0.8	6	20
LFRAM10-0500-06A-01DP	5	50.8	68	110	109.2	0.8	6	10
LFRAM12-0500-06A-01DP	5	60.8	86	128	127.2	0.8	6	12
LFRAM15-0500-06A-01DP	5	75.8	90	132	131.2	0.8	6	15
LFRAM20-0500-06A-01DP	5	100.8	115	157	156.2	0.8	6	20
LFRAM30-0500-06A-01DP	5	150.8	165	207	206.2	0.8	6	30
LFRAM40-0500-06A-01DP	5	200.8	215	257	256.2	0.8	6	40
LFRAM10-0510-06A-01DP	5.1	52	75	117	116.2	0.8	6	10
LFRAM12-0510-06A-01DP	5.1	62	86	128	127.2	0.8	6	12
LFRAM10-0520-06A-01DP	5.2	53.3	75	117	116.1	0.9	6	10
LFRAM12-0520-06A-01DP	5.2	63.3	86	128	127.1	0.9	6	12
LFRAM10-0550-06A-01DP	5.5	56.9	75	117	116.1	0.9	6	10
LFRAM12-0550-06A-01DP	5.5	66.9	86	128	127.1	0.9	6	12
LFRAM15-0550-06A-01DP	5.5	83.4	99	141	140.1	0.9	6	15
LFRAM20-0550-06A-01DP	5.5	110.9	127	169	168.1	0.9	6	20
LFRAM30-0550-06A-01DP	5.5	165.9	182	224	223.1	0.9	6	30
LFRAM40-0550-06A-01DP	5.5	220.9	237	279	278.1	0.9	6	40
LFRAM10-0580-06A-01DP	5.8	59.6	75	117	116	1	6	10
LFRAM12-0580-06A-01DP	5.8	70.6	86	128	127	1	6	12
LFRAM15-0580-06A-01DP	5.8	88	104	146	145	1	6	15
LFRAM20-0580-06A-01DP	5.8	117	133	175	174	1	6	20
LFRAM10-0600-06A-01DP	6	61	75	117	116	1	6	10
LFRAM12-0600-06A-01DP	6	73	86	128	127	1	6	12
LFRAM15-0600-06A-01DP	6	91	108	150	149	1	6	15
LFRAM20-0600-06A-01DP	6	121	138	180	179	1	6	20
LFRAM30-0600-06A-01DP	6	181	198	240	239	1	6	30
LFRAM40-0600-06A-01DP	6	241	258	300	299	1	6	40
LFRAM10-0610-08A-01DP	6.1	62	86	128	127	1	8	10
LFRAM12-0610-08A-01DP	6.1	74.2	116	158	157	1	8	12
LFRAM10-0620-08A-01DP	6.2	63	86	128	127	1	8	10
LFRAM12-0620-08A-01DP	6.2	75.4	116	158	157	1	8	12
LFRAM10-0630-08A-01DP	6.3	64	86	128	127	1	8	10
LFRAM12-0630-08A-01DP	6.3	76.6	116	158	157	1	8	12
LFRAM10-0650-08A-01DP	6.5	66.1	86	128	126.9	1.1	8	10
LFRAM12-0650-08A-01DP	6.5	79.1	116	158	156.9	1.1	8	12
LFRAM15-0650-08A-01DP	6.5	98.6	116	158	156.9	1.1	8	15
LFRAM20-0650-08A-01DP	6.5	131.1	150	192	190.9	1.1	8	20
LFRAM30-0650-08A-01DP	6.5	196.1	215	257	255.9	1.1	8	30
LFRAM40-0650-08A-01DP	6.5	261.1	280	322	320.9	1.1	8	40

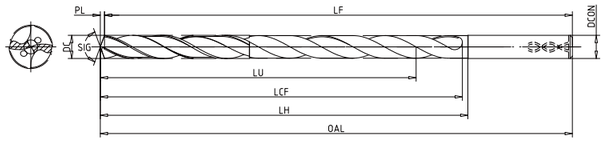
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 49

YPP Drill® LFRA

Deep Hole Drill





Shank Diameter Tolerance	h6
SIG	135°
Material Group	ISO-M

ISO Material Group M

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAM10-0660-08A-01DP	6.6	67.1	86	128	126.9	1.1	8	10
LFRAM12-0660-08A-01DP	6.6	80.3	116	158	156.9	1.1	8	12
LFRAM10-0670-08A-01DP	6.7	68.1	86	128	126.9	1.1	8	10
LFRAM12-0670-08A-01DP	6.7	81.5	116	158	156.9	1.1	8	12
LFRAM10-0680-08A-01DP	6.8	69.1	86	128	126.9	1.1	8	10
LFRAM12-0680-08A-01DP	6.8	82.7	116	158	156.9	1.1	8	12
LFRAM15-0680-08A-01DP	6.8	103.1	122	164	162.9	1.1	8	15
LFRAM20-0680-08A-01DP	6.8	137.1	156	198	196.9	1.1	8	20
LFRAM10-0690-08A-01DP	6.9	70.1	86	128	126.9	1.1	8	10
LFRAM12-0690-08A-01DP	6.9	83.9	116	158	156.9	1.1	8	12
LFRAM10-0700-08A-01DP	7	71.1	86	128	126.9	1.1	8	10
LFRAM12-0700-08A-01DP	7	85.1	116	158	156.9	1.1	8	12
LFRAM15-0700-08A-01DP	7	106.1	126	168	166.9	1.1	8	15
LFRAM20-0700-08A-01DP	7	141.1	161	203	201.9	1.1	8	20
LFRAM30-0700-08A-01DP	7	211.1	231	273	271.9	1.1	8	30
LFRAM40-0700-08A-01DP	7	281.1	301	343	341.9	1.1	8	40
LFRAM10-0740-08A-01DP	7.4	75.2	101	143	141.8	1.2	8	10
LFRAM12-0740-08A-01DP	7.4	90	116	158	156.8	1.2	8	12
LFRAM10-0750-08A-01DP	7.5	76.2	101	143	141.8	1.2	8	10
LFRAM12-0750-08A-01DP	7.5	91.2	116	158	156.8	1.2	8	12
LFRAM15-0750-08A-01DP	7.5	113.7	135	177	175.8	1.2	8	15
LFRAM20-0750-08A-01DP	7.5	151.2	173	215	213.8	1.2	8	20
LFRAM30-0750-08A-01DP	7.5	226.2	248	290	288.8	1.2	8	30
LFRAM40-0750-08A-01DP	7.5	301.2	323	365	363.8	1.2	8	40
LFRAM10-0760-08A-01DP	7.6	77.2	101	143	141.8	1.2	8	10
LFRAM12-0760-08A-01DP	7.6	92.4	116	158	156.8	1.2	8	12
LFRAM10-0770-08A-01DP	7.7	78.3	101	143	141.7	1.3	8	10
LFRAM12-0770-08A-01DP	7.7	93.7	116	158	156.7	1.3	8	12
LFRAM10-0780-08A-01DP	7.8	79.3	101	143	141.7	1.3	8	10
LFRAM12-0780-08A-01DP	7.8	94.9	116	158	156.7	1.3	8	12
LFRAM10-0800-08A-01DP	8	81.3	101	143	141.7	1.3	8	10
LFRAM12-0800-08A-01DP	8	97.3	116	158	156.7	1.3	8	12
LFRAM15-0800-08A-01DP	8	121.3	144	186	184.7	1.3	8	15
LFRAM20-0800-08A-01DP	8	161.3	184	226	224.7	1.3	8	20
LFRAM30-0800-08A-01DP	8	241.3	264	306	304.7	1.3	8	30
LFRAM40-0800-08A-01DP	8	321.3	344	386	384.7	1.3	8	40
LFRAM10-0810-10A-01DP	8.1	82.3	106	152	150.7	1.3	10	10
LFRAM12-0810-10A-01DP	8.1	98.5	146	192	190.7	1.3	10	12
LFRAM10-0820-10A-01DP	8.2	83.3	106	152	150.7	1.3	10	10
LFRAM12-0820-10A-01DP	8.2	99.7	146	192	190.7	1.3	10	12
LFRAM10-0840-10A-01DP	8.4	85.4	106	152	150.6	1.4	10	10

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAM12-0840-10A-01DP	8.4	102.2	146	192	190.6	1.4	10	12
LFRAM10-0850-10A-01DP	8.5	86.4	106	152	150.6	1.4	10	10
LFRAM12-0850-10A-01DP	8.5	103.4	146	192	190.6	1.4	10	12
LFRAM15-0850-10A-01DP	8.5	128.9	153	199	197.6	1.4	10	15
LFRAM20-0850-10A-01DP	8.5	171.4	196	242	240.6	1.4	10	20
LFRAM30-0850-10A-01DP	8.5	256.4	281	327	325.6	1.4	10	30
LFRAM10-0860-10A-01DP	8.6	87.4	106	152	150.6	1.4	10	10
LFRAM12-0860-10A-01DP	8.6	104.6	146	192	190.6	1.4	10	12
LFRAM10-0870-10A-01DP	8.7	88.4	106	152	150.6	1.4	10	10
LFRAM12-0870-10A-01DP	8.7	105.8	146	192	190.6	1.4	10	12
LFRAM10-0880-10A-01DP	8.8	89.4	106	152	150.6	1.4	10	10
LFRAM12-0880-10A-01DP	8.8	107	146	192	190.6	1.4	10	12
LFRAM10-0900-10A-01DP	9	91.5	128	174	172.5	1.5	10	10
LFRAM12-0900-10A-01DP	9	109.5	146	192	190.5	1.5	10	12
LFRAM15-0900-10A-01DP	9	136.5	162	208	206.5	1.5	10	15
LFRAM20-0900-10A-01DP	9	181.5	207	253	251.5	1.5	10	20
LFRAM30-0900-10A-01DP	9	271.5	297	343	341.5	1.5	10	30
LFRAM10-0930-10A-01DP	9.3	94.5	128	174	172.5	1.5	10	10
LFRAM12-0930-10A-01DP	9.3	113.1	146	192	190.5	1.5	10	12
LFRAM10-0950-10A-01DP	9.5	96.6	128	174	172.4	1.6	10	10
LFRAM12-0950-10A-01DP	9.5	115.6	146	192	190.4	1.6	10	12
LFRAM15-0950-10A-01DP	9.5	144.1	171	217	215.4	1.6	10	15
LFRAM20-0950-10A-01DP	9.5	191.6	219	265	263.4	1.6	10	20
LFRAM30-0950-10A-01DP	9.5	286.6	314	360	358.4	1.6	10	30
LFRAM10-0980-10A-01DP	9.8	99.6	128	174	172.4	1.6	10	10
LFRAM12-0980-10A-01DP	9.8	119.2	146	192	190.4	1.6	10	12
LFRAM10-1000-10A-01DP	10	101.6	128	174	172.4	1.6	10	10
LFRAM12-1000-10A-01DP	10	121.6	146	192	190.4	1.6	10	12
LFRAM15-1000-10A-01DP	10	151.6	180	226	224.4	1.6	10	15
LFRAM20-1000-10A-01DP	10	201.6	230	276	274.4	1.6	10	20
LFRAM30-1000-10A-01DP	10	301.6	330	376	374.4	1.6	10	30
LFRAM10-1020-12A-01DP	10.2	103.7	156	208	206.3	1.7	12	10
LFRAM12-1020-12A-01DP	10.2	124.1	176	228	226.3	1.7	12	12
LFRAM10-1030-12A-01DP	10.3	104.7	156	208	206.3	1.7	12	10
LFRAM12-1030-12A-01DP	10.3	125.3	176	228	226.3	1.7	12	12
LFRAM10-1040-12A-01DP	10.4	105.7	156	208	206.3	1.7	12	10
LFRAM12-1040-12A-01DP	10.4	126.5	176	228	226.3	1.7	12	12
LFRAM10-1050-12A-01DP	10.5	106.7	156	208	206.3	1.7	12	10
LFRAM12-1050-12A-01DP	10.5	127.7	176	228	226.3	1.7	12	12
LFRAM15-1050-12A-01DP	10.5	159.2	188	240	238.3	1.7	12	15
LFRAM20-1050-12A-01DP	10.5	211.7	241	293	291.3	1.7	12	20

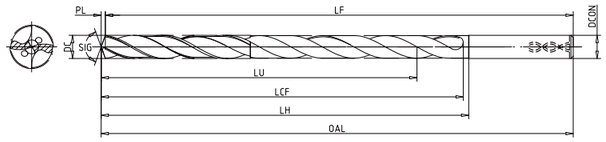
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 49

YPP Drill® LFRA

Deep Hole Drill





Shank Diameter Tolerance	h6
SIG	135°
Material Group	ISO-M

ISO Material Group M

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
LFRAM10-1100-12A-01DP	11	111.8	156	208	206.2	1.8	12	10
LFRAM12-1100-12A-01DP	11	133.8	176	228	226.2	1.8	12	12
LFRAM15-1100-12A-01DP	11	166.8	197	249	247.2	1.8	12	15
LFRAM20-1100-12A-01DP	11	221.8	252	304	302.2	1.8	12	20
LFRAM10-1120-12A-01DP	11.2	113.8	156	208	206.2	1.8	12	10
LFRAM12-1120-12A-01DP	11.2	136.2	176	228	226.2	1.8	12	12
LFRAM10-1150-12A-01DP	11.5	116.9	156	208	206.1	1.9	12	10
LFRAM12-1150-12A-01DP	11.5	139.9	176	228	226.1	1.9	12	12
LFRAM15-1150-12A-01DP	11.5	174.4	206	258	256.1	1.9	12	15
LFRAM20-1150-12A-01DP	11.5	231.9	264	316	314.1	1.9	12	20
LFRAM10-1180-12A-01DP	11.8	119.9	156	208	206.1	1.9	12	10
LFRAM12-1180-12A-01DP	11.8	143.5	176	228	226.1	1.9	12	12
LFRAM10-1200-12A-01DP	12	122	156	208	206	2	12	10
LFRAM12-1200-12A-01DP	12	146	176	228	226	2	12	12
LFRAM15-1200-12A-01DP	12	182	215	267	265	2	12	15
LFRAM20-1200-12A-01DP	12	242	275	327	325	2	12	20
LFRAM10-1230-14A-01DP	12.3	125.1	182	234	232	2	14	10
LFRAM12-1230-14A-01DP	12.3	149.7	206	258	256	2	14	12
LFRAM10-1250-14A-01DP	12.5	127	182	234	232	2	14	10
LFRAM12-1250-14A-01DP	12.5	152	206	258	256	2	14	12
LFRAM10-1270-14A-01DP	12.7	129.1	182	234	231.9	2.1	14	10
LFRAM12-1270-14A-01DP	12.7	154.5	206	258	255.9	2.1	14	12
LFRAM10-1300-14A-01DP	13	132.1	182	234	231.9	2.1	14	10
LFRAM12-1300-14A-01DP	13	158.1	206	258	255.9	2.1	14	12
LFRAM10-1310-14A-01DP	13.1	133.1	182	234	231.9	2.1	14	10
LFRAM12-1310-14A-01DP	13.1	159.3	206	258	255.9	2.1	14	12
LFRAM10-1350-14A-01DP	13.5	137.2	182	234	231.8	2.2	14	10
LFRAM12-1350-14A-01DP	13.5	164.2	206	258	255.8	2.2	14	12
LFRAM10-1400-14A-01DP	14	142.3	182	234	231.7	2.3	14	10
LFRAM12-1400-14A-01DP	14	170.3	206	258	255.7	2.3	14	12
LFRAM10-1450-16A-01DP	14.5	147.4	207	262	259.6	2.4	16	10
LFRAM12-1450-16A-01DP	14.5	176.4	236	291	288.6	2.4	16	12
LFRAM10-1500-16A-01DP	15	152.5	207	262	259.5	2.5	16	10
LFRAM12-1500-16A-01DP	15	182.5	236	291	288.5	2.5	16	12
LFRAM10-1550-16A-01DP	15.5	157.5	207	262	259.5	2.5	16	10
LFRAM12-1550-16A-01DP	15.5	188.5	236	291	288.5	2.5	16	12
LFRAM10-1600-16A-01DP	16	162.6	207	262	259.4	2.6	16	10
LFRAM12-1600-16A-01DP	16	194.6	236	291	288.4	2.6	16	12

① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 49

YPP Drill® LFRA

Deep Hole Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
P	Unalloyed Steel					
	P1.1.Z.AN	C = 0.05–0.1%	125	60	90	120
	P1.1.Z.AN	C = 0.1–0.25%	125	60	90	120
	P1.2.Z.AN	C = 0.25–0.55%	150	60	90	120
	P1.3.Z.AN	C = 0.55–0.80%	170	60	90	120
	High Carbon Steel					
	P1.3.Z.AN	Carbon Tool Steel	210	60	80	100
	Low Alloy Steel					
	P2.1.Z.AN	Non-Hardened	175	60	80	120
	P2.5.Z.HT	Hardeded and Tempered	275	50	80	100
	P2.5.Z.HT	Hardeded and Tempered	350	40	50	70
	High Alloy Steel					
	P3.0.Z.AN	Annealed	200	40	80	90
	P3.0.Z.HT	Hardened Tool Steel	300	40	50	70
	Steel Castings					
	P1.5.C.UT	Unalloyed	150	80	110	140
	P2.6.C.UT	Low-Alloy (Alloying Elements ≤5%)	200	80	110	120

Drill Diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.06	0.1	0.13
4	0.06	0.1	0.13
6	0.11	0.18	0.24
8	0.16	0.21	0.25
10	0.19	0.23	0.27
12	0.2	0.25	0.3
16	0.2	0.25	0.3
20	0.2	0.25	0.3

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

YPP Drill® LFRA

Deep Hole Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
M	Austenitic Stainless Steel					
	M1.0.C.UT	Cast+Untreated	165	30	40	60
	M1.0.Z.AQ	Annealed/Quenched	200	30	40	60
	M1.0.Z.PH	PH-Hardened	350	30	40	60
	M1.1.Z.AQ	Machinability Improved	165	30	40	60
	M1.2.Z.AQ	Free Cutting	200	30	40	60
	M1.3.C.AQ	Ti-Stabilized+Cast	200	30	40	60
	M1.3.Z.AQ	Ti-Stabilized	200	30	40	60
	M1.4.Z.AQ	High Strength	250	30	40	60
	Super Austenitic (Ni>20%) Stainless Steel					
	M2.0.C.AQ	Cast+Annealed/Quenched	165	20	30	40
	M2.0.Z.AQ	Annealed/Quenched	200	20	30	40
	Duplex (Austenitic/Ferritic) Stainless Steel					
	M3.1.Z.AQ >60%	Ferrite (N<0.10%) >60%	250	30	40	60
	M3.2.Z.AQ <60%	Ferrite (N≥0.10%) <60%	250	30	40	60

Drill diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.05	0.1	0.15
4	0.05	0.1	0.15
6	0.06	0.11	0.16
8	0.06	0.11	0.16
10	0.07	0.12	0.17
12	0.08	0.13	0.18
16	0.09	0.14	0.19
20	0.1	0.15	0.2

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase such as PH stainless steel, please decrease cutting speed proportionally

YPP Drill® LFRA

Deep Hole Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
K	Malleable Iron					
	K1.1.C.NS	Ferritic Pearlitic	200	60	80	120
	Gray Cast Iron (GCI)					
	K2.1.C.UT	Low Tensile Strength	180	60	80	120
	K2.2.C.UT	High Tensile Strength	245	60	80	120
	K2.3.C.UT	High Tensile Strength	175	60	80	120
	Nodular Cast Iron (NCI)					
	K3.1.C.UT	Ferritic Pearlitic	155	60	70	80
	K3.2.C.UT	Perlitic	215	60	70	80
	K3.3.C.UT	Perlitic	265	60	70	80
	K3.5.C.UT	Perlitic	190	60	70	80
	K5.1.C.UT	Austempered Ductile Iron (ADI)	300	60	70	80

Drill Diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.06	0.09	0.12
4	0.07	0.1	0.13
6	0.08	0.12	0.16
8	0.16	0.2	0.24
10	0.16	0.2	0.28
12	0.16	0.2	0.28
16	0.2	0.25	0.3
20	0.2	0.25	0.3

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

YPP Drill® LFRA

Deep Hole Drill

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
N	Aluminium					
	N1.2.Z.UT	Commercial Pure	60	80	120	150
	N1.2.Z.AG	AlSi Alloys, Si ≤ 1%	100	80	120	150
	N1.3.C.UT	Cast, Non-Aging	75	80	120	150
	N1.3.C.UT	Cast or Cast and Aged	90	80	120	150
	N1.4.C.NS	AlSi Cast Alloys, Si ≥ 13%	130	60	100	120
	Copper Based Alloys					
	N3.3.U.UT	Free Cutting Alloys (Pb>1%)	110	70	90	110
	N3.1.U.UT	Non-Leaded Copper Alloys (incl. electrolytic copper)	100	70	80	100

Drill diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.08	0.15	0.2
4	0.1	0.15	0.2
6	0.16	0.28	0.35
8	0.16	0.28	0.35
10	0.2	0.25	0.35
12	0.2	0.25	0.35
16	0.2	0.28	0.35
20	0.2	0.3	0.35

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

Versatile Solution

Customized Solution

ISO Workpiece Materials

K



YPP Drill® SFK

INTRODUCTION

Versatile Solid Carbide Drill for ISO-K

Overview & Applications

- General machining for ISO-K material
- Including GCI, NCI, CGI and ADI
- Hole tolerance H8–H9
- Diameter range: 3.0–20.0 mm
- Drill length above 8xDC

Features & Benefits

- Cover both stable and unstable cutting conditions
- Provide internal coolant solutions
- Curve cutting edge generates good chips deformation
- Conical flank surface generates cutting edge high toughness
- Good chips evacuation thanks to chips flute optimization design
- Chamfer design on peripheral corner which reduce risk of breakage

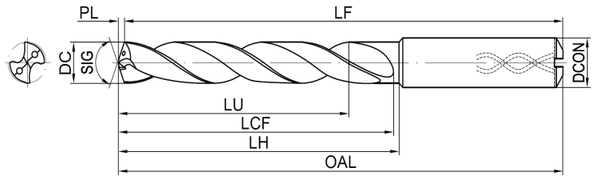
Ordering Code

S	F	K	2	03	N	—	0900	—	10A	—	01KX
↓	↓	↓	↓	↓	↓		↓		↓		↓
S - Product Family	F - Cutting Edge type	K - K- Material Group	2 - 2 Cutting Edge	03 - 3xDC	N/W - Internal Coolant / External Coolant		0900 - Drill Diameter 0900–DC9mm		10 - Shank Diameter A - HA Cylindrical Shank		01 - Substrate AK40 KX - Coating

YPP Drill® SFK

Versatile Solid Carbide Drill for ISO-K





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
SFK203N-0300-04A-01KX	3	9.5	20	62	61.5	0.5	4	3
SFK205N-0300-04A-01KX	3	15.5	26	66	65.5	0.5	4	5
SFK208N-0300-04A-01KX	3	24.5	40	78	77.5	0.5	4	8
SFK203N-0310-04A-01KX	3.1	9.8	20	62	61.5	0.5	4	3
SFK205N-0310-04A-01KX	3.1	16	26	66	65.5	0.5	4	5
SFK208N-0310-04A-01KX	3.1	25.3	40	78	77.5	0.5	4	8
SFK203N-0320-04A-01KX	3.2	10.1	20	62	61.5	0.5	4	3
SFK205N-0320-04A-01KX	3.2	16.5	26	66	65.5	0.5	4	5
SFK208N-0320-04A-01KX	3.2	26.1	40	78	77.5	0.5	4	8
SFK203N-0330-04A-01KX	3.3	10.5	20	62	61.4	0.6	4	3
SFK205N-0330-04A-01KX	3.3	17.1	26	66	65.4	0.6	4	5
SFK208N-0330-04A-01KX	3.3	27	40	78	77.5	0.6	4	8
SFK203N-0340-04A-01KX	3.4	10.8	20	62	61.4	0.6	4	3
SFK205N-0340-04A-01KX	3.4	17.6	26	66	65.4	0.6	4	5
SFK208N-0340-04A-01KX	3.4	27.5	40	78	77.4	0.6	4	8
SFK203N-0350-04A-01KX	3.5	11.1	20	62	61.4	0.6	4	3
SFK205N-0350-04A-01KX	3.5	18.1	26	66	65.4	0.6	4	5
SFK208N-0350-04A-01KX	3.5	27.3	40	78	77.4	0.6	4	8
SFK203N-0360-04A-01KX	3.6	11.4	20	62	61.4	0.6	4	3
SFK205N-0360-04A-01KX	3.6	18.5	26	66	65.4	0.6	4	5
SFK208N-0360-04A-01KX	3.6	27.3	40	78	77.4	0.6	4	8
SFK203N-0370-04A-01KX	3.7	11.7	20	62	61.4	0.6	4	3
SFK205N-0370-04A-01KX	3.7	19.1	26	66	65.4	0.6	4	5
SFK208N-0370-04A-01KX	3.7	27.9	40	78	77.4	0.6	4	8
SFK203N-0380-04A-01KX	3.8	12.1	24	66	65.4	0.6	4	3
SFK205N-0380-04A-01KX	3.8	20.2	34	74	73.4	0.6	4	5
SFK208N-0380-04A-01KX	3.8	31.1	49	87	86.4	0.6	4	8
SFK203N-0390-04A-01KX	3.9	12.5	24	66	65.4	0.6	4	3
SFK205N-0390-04A-01KX	3.9	20.2	34	74	73.4	0.6	4	5
SFK208N-0390-04A-01KX	3.9	31.9	49	87	86.4	0.6	4	8
SFK203N-0400-04A-01KX	4	12.7	24	66	65.3	0.7	4	3
SFK205N-0400-04A-01KX	4	20.7	34	74	73.3	0.7	4	5
SFK208N-0400-04A-01KX	4	32.7	49	87	86.3	0.7	4	8
SFK203N-0410-06A-01KX	4.1	13	24	66	65.3	0.7	6	3
SFK205N-0410-06A-01KX	4.1	21.2	34	74	73.3	0.7	6	5
SFK208N-0410-06A-01KX	4.1	33.5	49	87	86.3	0.7	6	8
SFK203N-0420-06A-01KX	4.2	13.3	24	66	65.3	0.7	6	3
SFK205N-0420-06A-01KX	4.2	21.7	34	74	73.3	0.7	6	5
SFK208N-0420-06A-01KX	4.2	34.3	49	87	86.3	0.7	6	8
SFK203N-0430-06A-01KX	4.3	13.7	24	66	65.2	0.7	6	3
SFK205N-0430-06A-01KX	4.3	22.3	34	74	73.2	0.7	6	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
SFK208N-0430-06A-01KX	4.3	35.2	49	87	86.3	0.7	6	8
SFK203N-0440-06A-01KX	4.4	14.1	24	66	65.3	0.7	6	3
SFK205N-0440-06A-01KX	4.4	22.8	34	74	73.3	0.7	6	5
SFK208N-0440-06A-01KX	4.4	36	49	87	86.3	0.7	6	8
SFK203N-0450-06A-01KX	4.5	14.3	24	66	65.3	0.7	6	3
SFK205N-0450-06A-01KX	4.5	23.3	34	74	73.3	0.7	6	5
SFK208N-0450-06A-01KX	4.5	36.8	49	87	86.3	0.7	6	8
SFK203N-0460-06A-01KX	4.6	14.6	24	66	65.2	0.8	6	3
SFK205N-0460-06A-01KX	4.6	23.8	34	74	73.2	0.8	6	5
SFK208N-0460-06A-01KX	4.6	39.2	56	94	93.2	0.8	6	8
SFK208N-0470-06A-01KX	4.7	39.2	56	94	93.2	0.8	6	8
SFK203N-0480-06A-01KX	4.8	15.2	28	66	65.2	0.8	6	3
SFK205N-0480-06A-01KX	4.8	24.8	44	82	81.2	0.8	6	5
SFK208N-0480-06A-01KX	4.8	39.2	56	94	93.2	0.8	6	8
SFK203N-0490-06A-01KX	4.9	15.5	28	66	65.2	0.8	6	3
SFK205N-0490-06A-01KX	4.9	25.3	44	82	81.2	0.8	6	5
SFK208N-0490-06A-01KX	4.9	40	56	94	93.2	0.8	6	8
SFK203N-0500-06A-01KX	5	15.8	28	66	65.2	0.8	6	3
SFK205N-0500-06A-01KX	5	25.8	44	82	81.2	0.8	6	5
SFK208N-0500-06A-01KX	5	40.8	56	94	93.2	0.8	6	8
SFK203N-0510-06A-01KX	5.1	16.1	28	66	65.2	0.8	6	3
SFK205N-0510-06A-01KX	5.1	26.3	44	82	81.2	0.8	6	5
SFK208N-0510-06A-01KX	5.1	41.6	56	94	93.2	0.8	6	8
SFK203N-0520-06A-01KX	5.2	16.4	28	66	65.1	0.9	6	3
SFK205N-0520-06A-01KX	5.2	26.8	44	82	81.1	0.9	6	5
SFK208N-0520-06A-01KX	5.2	42.4	56	94	93.1	0.9	6	8
SFK203N-0530-06A-01KX	5.3	16.7	28	66	65.1	0.9	6	3
SFK205N-0530-06A-01KX	5.3	27.3	44	82	81.1	0.9	6	5
SFK203N-0540-06A-01KX	5.4	17	28	66	65.1	0.9	6	3
SFK205N-0540-06A-01KX	5.4	27.8	44	82	81.1	0.9	6	5
SFK208N-0540-06A-01KX	5.4	44	56	94	93.1	0.9	6	8
SFK203N-0550-06A-01KX	5.5	17.4	28	66	65.1	0.9	6	3
SFK205N-0550-06A-01KX	5.5	28.4	44	82	81.1	0.9	6	5
SFK208N-0550-06A-01KX	5.5	44.9	56	94	93.1	0.9	6	8
SFK203N-0560-06A-01KX	5.6	17.7	28	66	65.1	0.9	6	3
SFK205N-0560-06A-01KX	5.6	28.9	44	82	81.1	0.9	6	5
SFK208N-0560-06A-01KX	5.6	45.7	56	94	93.1	0.9	6	8
SFK205N-0570-06A-01KX	5.7	29.4	44	82	81	1	6	5
SFK208N-0570-06A-01KX	5.7	46.5	56	94	93	1	6	8
SFK203N-0580-06A-01KX	5.8	17.6	28	66	65	1	6	3
SFK205N-0580-06A-01KX	5.8	29.9	44	82	81	1	6	5

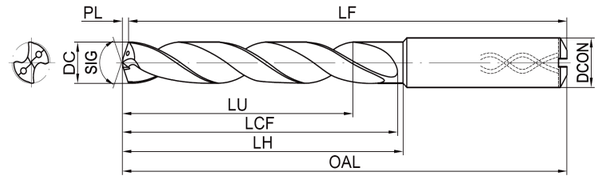
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 59

YPP Drill® SFK

Versatile Solid Carbide Drill for ISO-K





Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Internal Coolant Design

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
SFK208N-0580-06A-01KX	5.8	47.3	56	94	93	1	6	8
SFK203N-0590-06A-01KX	5.9	18.2	28	66	65	1	6	3
SFK205N-0590-06A-01KX	5.9	30.4	44	82	81	1	6	5
SFK208N-0590-06A-01KX	5.9	47.4	56	94	93	1	6	8
SFK203N-0600-06A-01KX	6	18.9	28	66	65	1	6	3
SFK205N-0600-06A-01KX	6	30.9	44	82	81	1	6	5
SFK208N-0600-06A-01KX	6	48.9	56	94	93	1	6	8
SFK203N-0610-08A-01KX	6.1	19.6	34	79	77.9	1	8	3
SFK205N-0610-08A-01KX	6.1	32	53	91	89.9	1	8	5
SFK208N-0610-08A-01KX	6.1	50.6	67	106	104.9	1	8	8
SFK203N-0620-08A-01KX	6.2	19.6	34	79	77.9	1.1	8	3
SFK205N-0620-08A-01KX	6.2	32	53	91	89.9	1.1	8	5
SFK208N-0620-08A-01KX	6.2	50.6	67	106	104.9	1.1	8	8
SFK203N-0630-08A-01KX	6.3	19.9	34	79	77.9	1.1	8	3
SFK205N-0630-08A-01KX	6.3	32.5	53	91	89.9	1.1	8	5
SFK208N-0630-08A-01KX	6.3	51.4	67	106	104.9	1.1	8	8
SFK203N-0640-08A-01KX	6.4	20.2	34	79	77.9	1.1	8	3
SFK205N-0640-08A-01KX	6.4	33	53	91	89.9	1.1	8	5
SFK208N-0640-08A-01KX	6.4	52.2	67	106	104.9	1.1	8	8
SFK203N-0650-08A-01KX	6.5	20.6	34	79	77.9	1.1	8	3
SFK205N-0650-08A-01KX	6.5	33.6	53	91	89.9	1.1	8	5
SFK208N-0650-08A-01KX	6.5	53.1	67	106	104.9	1.1	8	8
SFK203N-0660-08A-01KX	6.6	20.9	34	79	77.9	1.1	8	3
SFK205N-0660-08A-01KX	6.6	34.1	53	91	89.9	1.1	8	5
SFK208N-0660-08A-01KX	6.6	53.9	67	106	104.9	1.1	8	8
SFK203N-0670-08A-01KX	6.7	21.2	34	79	77.9	1.1	8	3
SFK205N-0670-08A-01KX	6.7	34.6	53	91	89.9	1.1	8	5
SFK208N-0670-08A-01KX	6.7	54.7	67	106	104.9	1.1	8	8
SFK203N-0680-08A-01KX	6.8	21.5	34	79	77.9	1.1	8	3
SFK205N-0680-08A-01KX	6.8	35.1	53	91	89.9	1.1	8	5
SFK208N-0680-08A-01KX	6.8	55.5	67	106	104.9	1.1	8	8
SFK203N-0690-08A-01KX	6.9	21.8	34	79	77.8	1.2	8	3
SFK205N-0690-08A-01KX	6.9	35.6	53	91	89.8	1.2	8	5
SFK208N-0690-08A-01KX	6.9	56.3	67	106	104.8	1.2	8	8
SFK203N-0700-08A-01KX	7	22.1	34	79	77.8	1.2	8	3
SFK205N-0700-08A-01KX	7	36.1	53	91	89.8	1.2	8	5
SFK208N-0700-08A-01KX	7	57.1	67	106	104.8	1.2	8	8
SFK203N-0710-08A-01KX	7.1	22.4	41	79	77.8	1.2	8	3
SFK205N-0710-08A-01KX	7.1	36.6	53	91	89.8	1.2	8	5
SFK203N-0720-08A-01KX	7.2	22.8	41	79	77.8	1.2	8	3
SFK205N-0720-08A-01KX	7.2	37.2	53	91	89.8	1.2	8	5

Ordering Code	Dimension (mm)							
	DC	LU	LCF	OAL	LF	PL	DCON	ULDR
SFK205N-0730-08A-01KX	7.3	37.7	53	91	89.8	1.2	8	5
SFK208N-0730-08A-01KX	7.3	59.6	72	110	108.8	1.2	8	8
SFK203N-0740-08A-01KX	7.4	23.4	41	79	77.7	1.3	8	3
SFK205N-0740-08A-01KX	7.4	38.2	53	91	89.7	1.3	8	5
SFK208N-0740-08A-01KX	7.4	60.4	72	110	108.7	1.3	8	8
SFK203N-0750-08A-01KX	7.5	23.7	41	79	77.7	1.3	8	3
SFK205N-0750-08A-01KX	7.5	38.7	53	91	89.7	1.3	8	5
SFK208N-0750-08A-01KX	7.5	61.2	72	110	108.7	1.3	8	8
SFK203N-0760-08A-01KX	7.6	24	41	79	77.7	1.3	8	3
SFK208N-0760-08A-01KX	7.6	62	72	110	108.7	1.3	8	8
SFK203N-0770-08A-01KX	7.7	24.3	41	79	77.7	1.3	8	3
SFK205N-0770-08A-01KX	7.7	39.7	53	91	89.7	1.3	8	5
SFK208N-0770-08A-01KX	7.7	62.8	72	110	108.7	1.3	8	8
SFK203N-0780-08A-01KX	7.8	24.7	41	79	77.7	1.3	8	3
SFK205N-0780-08A-01KX	7.8	40.3	53	91	89.7	1.3	8	5
SFK208N-0780-08A-01KX	7.8	63.7	72	110	108.7	1.3	8	8
SFK203N-0790-08A-01KX	7.9	25	41	79	77.7	1.3	8	3
SFK205N-0790-08A-01KX	7.9	40.8	53	91	89.7	1.3	8	5
SFK203N-0800-08A-01KX	8	25.3	41	79	77.6	1.4	8	3
SFK205N-0800-08A-01KX	8	41.3	53	91	89.6	1.4	8	5
SFK207N-0800-08A-01KX	8	56	72	110	108.6	1.4	8	7
SFK203N-0810-10A-01KX	8.1	25.6	41	79	77.6	1.4	10	3
SFK205N-0810-10A-01KX	8.1	41.8	53	91	89.6	1.4	10	5
SFK208N-0810-10A-01KX	8.1	66.1	80	122	120.6	1.4	10	8
SFK203N-0820-10A-01KX	8.2	25.9	47	89	87.6	1.4	10	3
SFK205N-0820-10A-01KX	8.2	42.3	61	103	101.6	1.4	10	5
SFK208N-0820-10A-01KX	8.2	66.9	80	122	120.6	1.4	10	8
SFK203N-0830-10A-01KX	8.3	26.3	47	89	87.6	1.4	10	3
SFK205N-0830-10A-01KX	8.3	42.9	61	103	101.6	1.4	10	5
SFK208N-0830-10A-01KX	8.3	67.8	80	122	120.6	1.4	10	8
SFK203N-0840-10A-01KX	8.4	26.6	47	89	87.6	1.4	10	3
SFK205N-0840-10A-01KX	8.4	43.4	61	103	101.6	1.4	10	5
SFK208N-0840-10A-01KX	8.4	68.6	80	122	120.6	1.4	10	8
SFK203N-0850-10A-01KX	8.5	26.9	47	89	87.6	1.4	10	3
SFK205N-0850-10A-01KX	8.5	43.9	61	103	101.6	1.4	10	5
SFK208N-0850-10A-01KX	8.5	69.4	80	122	120.6	1.4	10	8
SFK203N-0860-10A-01KX	8.6	27.2	47	89	87.5	1.5	10	3
SFK205N-0860-10A-01KX	8.6	44.4	61	103	101.5	1.5	10	5
SFK208N-0860-10A-01KX	8.6	70.2	80	122	120.5	1.5	10	8
SFK203N-0870-10A-01KX	8.7	27.5	47	89	87.5	1.5	10	3
SFK205N-0870-10A-01KX	8.7	44.9	61	103	101.5	1.5	10	5

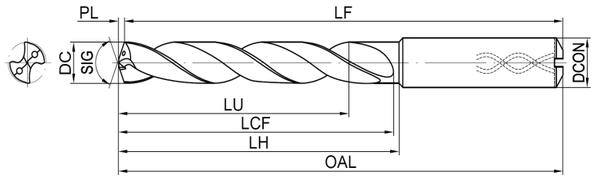
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 59

YPP Drill® SFK

Versatile Solid Carbide Drill for ISO-K





Internal Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFK208N-0870-10A-01KX	8.7	71	80	122	120.5	1.5	10	8
SFK203N-0880-10A-01KX	8.8	27.8	47	89	87.5	1.5	10	3
SFK205N-0880-10A-01KX	8.8	45.4	61	103	101.5	1.5	10	5
SFK208N-0880-10A-01KX	8.8	71.8	80	122	120.5	1.5	10	8
SFK205N-0890-10A-01KX	8.9	45.9	61	103	101.5	1.5	10	5
SFK203N-0900-10A-01KX	9	28.5	47	89	87.5	1.5	10	3
SFK205N-0900-10A-01KX	9	46.5	61	103	101.5	1.5	10	5
SFK208N-0900-10A-01KX	9	73.5	80	122	120.5	1.5	10	8
SFK203N-0910-10A-01KX	9.1	28.8	47	89	87.5	1.5	10	3
SFK205N-0910-10A-01KX	9.1	47	61	103	101.5	1.5	10	5
SFK207N-0910-10A-01KX	9.1	63.7	80	122	120.5	1.5	10	7
SFK203N-0920-10A-01KX	9.2	29.1	47	89	87.4	1.6	10	3
SFK205N-0920-10A-01KX	9.2	47.5	61	103	101.4	1.6	10	5
SFK207N-0920-10A-01KX	9.2	64.4	80	122	120.4	1.6	10	7
SFK203N-0930-10A-01KX	9.3	29.4	47	89	87.4	1.6	10	3
SFK205N-0930-10A-01KX	9.3	48	61	103	101.4	1.6	10	5
SFK207N-0930-10A-01KX	9.3	65.1	80	122	120.4	1.6	10	7
SFK203N-0940-10A-01KX	9.4	29.7	47	89	87.4	1.6	10	3
SFK205N-0940-10A-01KX	9.4	48.5	61	103	101.4	1.6	10	5
SFK207N-0940-10A-01KX	9.4	65.8	80	122	120.4	1.6	10	7
SFK203N-0950-10A-01KX	9.5	30	47	89	87.4	1.6	10	3
SFK205N-0950-10A-01KX	9.5	48.7	61	103	101.4	1.6	10	5
SFK207N-0950-10A-01KX	9.5	66.5	80	122	120.4	1.6	10	7
SFK203N-0960-10A-01KX	9.6	30.3	47	89	87.4	1.6	10	3
SFK205N-0960-10A-01KX	9.6	48.5	61	103	101.4	1.6	10	5
SFK207N-0960-10A-01KX	9.6	67.2	80	122	120.4	1.6	10	7
SFK203N-0970-10A-01KX	9.7	30.7	47	89	87.3	1.7	10	3
SFK207N-0970-10A-01KX	9.7	67.9	80	122	120.3	1.7	10	7
SFK203N-0980-10A-01KX	9.8	31	47	89	87.3	1.7	10	3
SFK205N-0980-10A-01KX	9.8	48.3	61	103	101.3	1.7	10	5
SFK207N-0980-10A-01KX	9.8	68.6	80	122	120.3	1.7	10	7
SFK203N-0990-10A-01KX	9.9	31.3	47	89	87.3	1.7	10	3
SFK205N-0990-10A-01KX	9.9	48.1	61	103	101.3	1.7	10	5
SFK207N-0990-10A-01KX	9.9	69.3	80	122	120.3	1.7	10	7
SFK203N-1000-10A-01KX	10	31.6	47	89	87.3	1.7	10	3
SFK205N-1000-10A-01KX	10	50	61	103	101.3	1.7	10	5
SFK207N-1000-10A-01KX	10	70	80	122	120.3	1.7	10	7
SFK203N-1010-12A-01KX	10.1	31.9	47	89	87.3	1.7	12	3
SFK205N-1010-12A-01KX	10.1	52.1	61	103	101.3	1.7	12	5
SFK208N-1010-12A-01KX	10.1	82.4	96	141	139.3	1.7	12	8
SFK203N-1020-12A-01KX	10.2	32.3	55	102	100.3	1.7	12	3

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFK205N-1020-12A-01KX	10.2	52.7	71	118	116.3	1.7	12	5
SFK208N-1020-12A-01KX	10.2	83.3	96	141	139.3	1.7	12	8
SFK203N-1030-12A-01KX	10.3	32.6	55	102	100.2	1.8	12	3
SFK205N-1030-12A-01KX	10.3	53.2	71	118	116.2	1.8	12	5
SFK208N-1030-12A-01KX	10.3	84.1	96	141	139.2	1.8	12	8
SFK203N-1040-12A-01KX	10.4	32.9	55	102	100.2	1.8	12	3
SFK205N-1040-12A-01KX	10.4	53.7	71	118	116.2	1.8	12	5
SFK208N-1040-12A-01KX	10.4	84.9	96	141	139.2	1.8	12	8
SFK203N-1050-12A-01KX	10.5	33.2	55	102	100.2	1.8	12	3
SFK205N-1050-12A-01KX	10.5	54.2	71	118	116.2	1.8	12	5
SFK208N-1050-12A-01KX	10.5	85.7	96	141	139.2	1.8	12	8
SFK205N-1060-12A-01KX	10.6	54.7	71	118	116.2	1.8	12	5
SFK203N-1070-12A-01KX	10.7	33.8	55	102	100.2	1.8	12	3
SFK205N-1070-12A-01KX	10.7	55.2	71	118	116.2	1.8	12	5
SFK203N-1080-12A-01KX	10.8	34.2	55	102	100.2	1.8	12	3
SFK205N-1080-12A-01KX	10.8	55.8	71	118	116.2	1.8	12	5
SFK208N-1080-12A-01KX	10.8	88.2	96	141	139.2	1.8	12	8
SFK205N-1090-12A-01KX	10.9	56.3	71	118	116.1	1.9	12	5
SFK203N-1100-12A-01KX	11	34.8	55	102	100.1	1.9	12	3
SFK205N-1100-12A-01KX	11	56.8	71	118	116.1	1.9	12	5
SFK207N-1100-12A-01KX	11	77	96	141	139.1	1.9	12	7
SFK203N-1110-12A-01KX	11.1	35.1	55	102	100.1	1.9	12	3
SFK205N-1110-12A-01KX	11.1	57.3	71	118	116.1	1.9	12	5
SFK207N-1110-12A-01KX	11.1	77.8	96	141	139.1	1.9	12	7
SFK203N-1120-12A-01KX	11.2	35.4	55	102	100.1	1.9	12	3
SFK205N-1120-12A-01KX	11.2	57.6	71	118	116.1	1.9	12	5
SFK208N-1120-12A-01KX	11.2	78.4	96	141	139.1	1.9	12	7
SFK203N-1130-12A-01KX	11.3	35.7	55	102	100.1	1.9	12	3
SFK205N-1130-12A-01KX	11.3	57.4	71	118	116.1	1.9	12	5
SFK207N-1130-12A-01KX	11.3	79.1	96	141	139.1	1.9	12	7
SFK203N-1140-12A-01KX	11.4	36.1	55	102	100	2	12	3
SFK203N-1150-12A-01KX	11.5	36.4	55	102	100	2	12	3
SFK205N-1150-12A-01KX	11.5	57.2	71	118	116	2	12	5
SFK207N-1150-12A-01KX	11.5	80.5	96	141	139	2	12	7
SFK203N-1160-12A-01KX	11.6	36.7	55	102	100	2	12	3
SFK203N-1170-12A-01KX	11.7	37	55	102	100	2	12	3
SFK205N-1170-12A-01KX	11.7	57	71	118	116	2	12	5
SFK203N-1180-12A-01KX	11.8	37.3	55	102	100	2	12	3
SFK205N-1180-12A-01KX	11.8	56.8	71	118	116	2	12	5
SFK207N-1180-12A-01KX	11.8	82.6	96	141	139	2	12	7
SFK203N-1190-12A-01KX	11.9	37.6	55	102	100	2	12	3

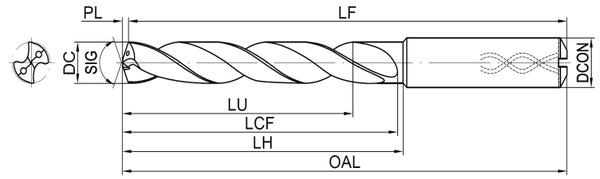
① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 59

YPP Drill® SFK

Versatile Solid Carbide Drill for ISO-K





Internal Coolant Design

Shank Diameter Tolerance	h6
SIG	140°
Max. Reconditioning Times	5

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFK207N-1190-12A-01KX	11.9	97.1	96	141	139	2	12	7
SFK203N-1200-12A-01KX	12	38	55	102	99.9	2.1	12	3
SFK205N-1200-12A-01KX	12	60	71	118	115.9	2.1	12	5
SFK207N-1200-12A-01KX	12	84	96	141	138.9	2.1	12	7
SFK203N-1210-14A-01KX	12.1	38.3	55	107	99.9	2.1	14	3
SFK205N-1210-14A-01KX	12.1	62.5	71	118	115.9	2.1	14	5
SFK208N-1210-14A-01KX	12.1	96.8	108	155	152.9	2.1	14	8
SFK203N-1220-14A-01KX	12.2	38.6	60	107	104.9	2.1	14	3
SFK205N-1220-14A-01KX	12.2	62.4	77	124	121.9	2.1	14	5
SFK208N-1220-14A-01KX	12.2	97.6	108	155	152.9	2.1	14	8
SFK203N-1230-14A-01KX	12.3	38.9	60	107	104.9	2.1	14	3
SFK205N-1230-14A-01KX	12.3	62.2	77	124	121.9	2.1	14	5
SFK208N-1230-14A-01KX	12.3	98.4	108	155	152.9	2.1	14	8
SFK203N-1250-14A-01KX	12.5	39.5	60	107	104.9	2.1	14	3
SFK205N-1250-14A-01KX	12.5	63	77	124	121.9	2.1	14	5
SFK207N-1250-14A-01KX	12.5	88	108	155	152.9	2.1	14	7
SFK203N-1260-14A-01KX	12.6	39.9	60	107	104.8	2.2	14	3
SFK203N-1270-14A-01KX	12.7	40.2	60	107	104.8	2.2	14	3
SFK205N-1270-14A-01KX	12.7	64	77	124	121.8	2.2	14	5
SFK207N-1270-14A-01KX	12.7	88.9	108	155	152.8	2.2	14	7
SFK203N-1280-14A-01KX	12.8	40.5	60	107	104.8	2.2	14	3
SFK205N-1280-14A-01KX	12.8	64.6	77	124	121.8	2.2	14	5
SFK207N-1280-14A-01KX	12.8	89.6	108	155	152.8	2.2	14	7
SFK203N-1300-14A-01KX	13	41.1	60	107	104.8	2.2	14	3
SFK205N-1300-14A-01KX	13	61.4	77	124	121.8	2.2	14	5
SFK207N-1300-14A-01KX	13	91	108	155	152.8	2.2	14	7
SFK203N-1310-14A-01KX	13.1	41.4	60	107	104.7	2.3	14	3
SFK205N-1310-14A-01KX	13.1	61.3	77	124	121.7	2.3	14	5
SFK207N-1310-14A-01KX	13.1	91.7	108	155	152.7	2.3	14	7
SFK203N-1350-14A-01KX	13.5	42.7	60	107	104.7	2.3	14	3
SFK205N-1350-14A-01KX	13.5	60.8	77	124	121.7	2.3	14	5
SFK207N-1350-14A-01KX	13.5	94.5	108	155	152.7	2.3	14	7
SFK203N-1380-14A-01KX	13.8	43.4	60	107	104.6	2.4	14	3
SFK205N-1380-14A-01KX	13.8	60.4	77	124	121.6	2.4	14	5
SFK207N-1380-14A-01KX	13.8	96.6	108	155	152.6	2.4	14	7
SFK203N-1400-14A-01KX	14	44.3	60	107	104.6	2.4	14	3
SFK205N-1400-14A-01KX	14	63	77	124	121.6	2.4	14	5
SFK207N-1400-14A-01KX	14	98	108	155	152.6	2.4	14	7
SFK203N-1450-16A-01KX	14.5	45.8	65	115	112.5	2.5	16	3
SFK205N-1450-16A-01KX	14.5	68.5	83	133	130.5	2.5	16	5
SFK205N-1480-16A-01KX	14.8	68.2	83	133	130.4	2.6	16	5

Ordering Code	Dimension (mm)							ULDR
	DC	LU	LCF	OAL	LF	PL	DCON	
SFK203N-1500-16A-01KX	15	47.4	65	115	112.4	2.6	16	3
SFK205N-1500-16A-01KX	15	68	83	133	130.4	2.6	16	5
SFK203N-1550-16A-01KX	15.5	49	65	115	112.3	2.7	16	3
SFK205N-1550-16A-01KX	15.5	67.5	83	133	130.3	2.7	16	5
SFK203N-1580-16A-01KX	15.8	49.2	65	115	112.2	2.8	16	3
SFK205N-1580-16A-01KX	15.8	67.2	83	133	130.2	2.8	16	5
SFK203N-1600-16A-01KX	16	49	65	115	112.2	2.8	16	3
SFK205N-1600-16A-01KX	16	67	83	133	130.2	2.8	16	5
SFK207N-1600-16A-01KX	16	111	121	171	168.2	2.8	16	7
SFK203N-1650-18A-01KX	16.5	52.1	73	123	120.2	2.8	18	3
SFK205N-1650-18A-01KX	16.5	76.5	93	143	140.2	2.8	18	5
SFK203N-1680-18A-01KX	16.8	53	73	123	120.2	2.8	18	3
SFK205N-1700-18A-01KX	17	76	93	143	140.2	2.8	18	5
SFK203N-1750-18A-01KX	17.5	55.2	73	123	120.2	2.8	18	3
SFK204N-1750-18A-01KX	17.5	70	95	143	140.2	2.8	18	4
SFK204N-1780-18A-01KX	17.8	71.2	95	143	140.1	2.9	18	4
SFK203N-1800-18A-01KX	18	56.8	73	123	120.1	2.9	18	3
SFK204N-1800-18A-01KX	18	72	93	143	140.1	2.9	18	4
SFK203N-1850-20A-01KX	18.5	58.4	79	131	128.1	2.9	20	3
SFK203N-1880-20A-01KX	18.8	59.3	79	131	128.1	2.9	20	3
SFK205N-1880-20A-01KX	18.8	86	101	153	150.1	2.9	20	5
SFK203N-1900-20A-01KX	19	59.9	79	131	128.1	2.9	20	3
SFK203N-2000-20A-01KX	20	63	79	131	127.9	3.1	20	3

① All proudcts on this page are made-to-order, please contact Yongpu sales representative for quotation and ordering

② Cutting data, please go to page 59

YPP Drill® SFK

Versatile Solid Carbide Drill for ISO-K

Internal Coolant

ISO	MC No.	Component Material	Hardness Brinell	Cutting Speed VC(m/min)		
				Min.	Start	Max.
K	Malleable Iron					
	K1.1.C.NS	Ferritic Pearlitic	200	80	100	120
	Gray Cast Iron (GCI)					
	K2.1.C.UT	Low Tensile Strength	180	100	120	140
	K2.2.C.UT	High tensile strength	245	80	100	120
	K2.3.C.UT	High tensile strength	175	100	120	140
	Nodular Cast Iron (NCI)					
	K3.1.C.UT	Ferritic Pearlitic	155	100	120	140
	K3.2.C.UT	Perlitic	215	80	100	120
	K3.3.C.UT	Perlitic	265	100	120	140
	K3.5.C.UT	Perlitic	190	100	120	140
	K5.1.C.UT	Austempered Ductile Iron (ADI)	300	60	80	100

Drill Diameter (mm)	Feed Fn(mm/r) *		
	Min.	Start	Max.
3	0.08	0.1	0.12
4	0.1	0.12	0.14
6	0.12	0.16	0.18
8	0.16	0.2	0.24
10	0.2	0.25	0.3
12	0.22	0.28	0.33
16	0.25	0.32	0.38
20	0.26	0.34	0.4

① Cutting data is suitable for internal coolant

② Coolant pressure recommendation min. 20bar

③ In case component material hardness increase, please decrease cutting speed proportionally

④ Under external coolant condition, please adjust cutting speed to secure good chips formation and evacuation

⑤ Under external coolant condition, please decrease feed per revolution to secure chips evacuation

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SOLID ROUND TOOLS
ONE-STOP MACHINING SOLUTION

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