Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

BS200U

High-Performance Carbide Drill



Product line	YPP Drill® – solid carbide drills
Series	BS200U (single margin) / BS202U (double margin)
Diameter range	Φ3.00 – Φ16.00 mm
Drilling depth	3×Dc, 5×Dc, 8×Dc, 12×Dc

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Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

Technical Features



- Straight cutting edge
- Generous chip flute space
- Wave-shaped chisel edge design
- Coating suited to high-speed cutting

Applications

High-efficiency hole-making in steel, cast iron and stainless steel

- Diameter range: Φ3.00 – Φ16.00 mm
- Cutting-diameter tolerance: m7
- Point angle: 140°
- Drilling depth: 3×Dc, 5×Dc, 8×Dc, 12×Dc
- Internal (through-coolant) and external coolant versions available; through-coolant is recommended for stainless steel
- Single-margin and double-margin designs available
- Achievable hole tolerance: IT8–9
- Carbide substrate
- Bronze-coloured composite nano-coating

Ordering Code

BS200U	2	03	W	0850	10	A	DH
1	2	3	4	5	6	7	8

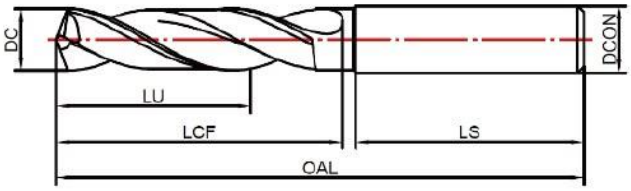
Pos.	Code	Meaning
1	BS200U	Product series: BS200U = single-margin design, BS202U = double-margin design
2	2	Number of cutting edges: 2 = two cutting edges
3	03	Drilling depth: 03 = 3×Dc, 05 = 5×Dc
4	W	Coolant type: W = external coolant, N = internal (through) coolant
5	0850	Cutting diameter: 0850 = Φ8.5
6	10	Shank diameter: 10 = Φ10
7	A	Shank type: A = cylindrical shank
8	DH	Coating: DH = DH coating

Product Range

BS200U.203W – High-Performance Carbide Drill

Key data: HD (high-performance tool) | 3XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



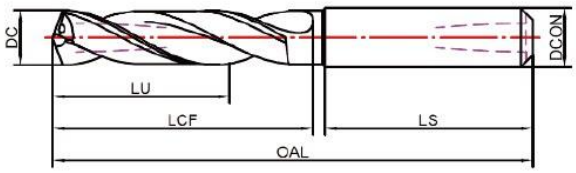
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.203W-0300-04A-DH	3	14	20	62	40	4
BS200U.203W-0310-04A-DH	3.1	14	20	62	40	4
BS200U.203W-0317-04A-DH	3.17	14	20	62	40	4
BS200U.203W-0320-04A-DH	3.2	14	20	62	40	4
BS200U.203W-0330-04A-DH	3.3	14	20	62	40	4
BS200U.203W-0340-04A-DH	3.4	14	20	62	40	4
BS200U.203W-0350-04A-DH	3.5	14	20	62	40	4
BS200U.203W-0355-04A-DH	3.55	14	20	62	40	4
BS200U.203W-0360-04A-DH	3.6	14	20	62	40	4
BS200U.203W-0370-04A-DH	3.7	14	20	62	40	4
BS200U.203W-0380-04A-DH	3.8	17	24	66	40	4
BS200U.203W-0390-04A-DH	3.9	17	24	66	40	4
BS200U.203W-0400-04A-DH	4	17	24	66	40	4
BS200U.203W-0410-06A-DH	4.1	17	24	66	40	6
BS200U.203W-0420-06A-DH	4.2	17	24	66	40	6
BS200U.203W-0430-06A-DH	4.3	17	24	66	40	6
BS200U.203W-0440-06A-DH	4.4	17	24	66	40	6
BS200U.203W-0450-06A-DH	4.5	17	24	66	40	6
BS200U.203W-0460-06A-DH	4.6	17	24	66	40	6
BS200U.203W-0476-06A-DH	4.76	20	28	66	36	6
BS200U.203W-0480-06A-DH	4.8	20	28	66	36	6
BS200U.203W-0490-06A-DH	4.9	20	28	66	36	6
BS200U.203W-0500-06A-DH	5	20	28	66	36	6
BS200U.203W-0510-06A-DH	5.1	20	28	66	36	6
BS200U.203W-0520-06A-DH	5.2	20	28	66	36	6
BS200U.203W-0530-06A-DH	5.3	20	28	66	36	6
BS200U.203W-0540-06A-DH	5.4	20	28	66	36	6
BS200U.203W-0550-06A-DH	5.5	20	28	66	36	6
BS200U.203W-0556-06A-DH	5.56	20	28	66	36	6
BS200U.203W-0560-06A-DH	5.6	20	28	66	36	6
BS200U.203W-0580-06A-DH	5.8	20	28	66	36	6
BS200U.203W-0590-06A-DH	5.9	20	28	66	36	6
BS200U.203W-0595-06A-DH	5.95	20	28	66	36	6
BS200U.203W-0600-06A-DH	6	20	28	66	36	6
BS200U.203W-0610-08A-DH	6.1	24	34	79	40	8
BS200U.203W-0620-08A-DH	6.2	24	34	79	40	8
BS200U.203W-0630-08A-DH	6.3	24	34	79	40	8
BS200U.203W-0635-08A-DH	6.35	24	34	79	40	8
BS200U.203W-0640-08A-DH	6.4	24	34	79	40	8
BS200U.203W-0650-08A-DH	6.5	24	34	79	40	8
BS200U.203W-0660-08A-DH	6.6	24	34	79	40	8
BS200U.203W-0670-08A-DH	6.7	24	34	79	40	8
BS200U.203W-0675-08A-DH	6.75	24	34	79	40	8
BS200U.203W-0680-08A-DH	6.8	24	34	79	40	8
BS200U.203W-0690-08A-DH	6.9	24	34	79	40	8
BS200U.203W-0700-08A-DH	7	24	34	79	40	8
BS200U.203W-0710-08A-DH	7.1	29	41	79	36	8
BS200U.203W-0714-08A-DH	7.14	29	41	79	36	8
BS200U.203W-0720-08A-DH	7.2	29	41	79	36	8
BS200U.203W-0740-08A-DH	7.4	29	41	79	36	8
BS200U.203W-0750-08A-DH	7.5	29	41	79	36	8
BS200U.203W-0760-08A-DH	7.6	29	41	79	36	8
BS200U.203W-0770-08A-DH	7.7	29	41	79	36	8
BS200U.203W-0780-08A-DH	7.8	29	41	79	36	8

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.203W-0790-08A-DH	7.9	29	41	79	36	8
BS200U.203W-0794-08A-DH	7.94	29	41	79	36	8
BS200U.203W-0800-08A-DH	8	29	41	79	36	8
BS200U.203W-0810-10A-DH	8.1	35	47	89	40	10
BS200U.203W-0820-10A-DH	8.2	35	47	89	40	10
BS200U.203W-0830-10A-DH	8.3	35	47	89	40	10
BS200U.203W-0840-10A-DH	8.4	35	47	89	40	10
BS200U.203W-0850-10A-DH	8.5	35	47	89	40	10
BS200U.203W-0860-10A-DH	8.6	35	47	89	40	10
BS200U.203W-0870-10A-DH	8.7	35	47	89	40	10
BS200U.203W-0873-10A-DH	8.73	35	47	89	40	10
BS200U.203W-0880-10A-DH	8.8	35	47	89	40	10
BS200U.203W-0900-10A-DH	9	35	47	89	40	10
BS200U.203W-0910-10A-DH	9.1	35	47	89	40	10
BS200U.203W-0920-10A-DH	9.2	35	47	89	40	10
BS200U.203W-0930-10A-DH	9.3	35	47	89	40	10
BS200U.203W-0940-10A-DH	9.4	35	47	89	40	10
BS200U.203W-0950-10A-DH	9.5	35	47	89	40	10
BS200U.203W-0952-10A-DH	9.52	35	47	89	40	10
BS200U.203W-0960-10A-DH	9.6	35	47	89	40	10
BS200U.203W-0970-10A-DH	9.7	35	47	89	40	10
BS200U.203W-0980-10A-DH	9.8	35	47	89	40	10
BS200U.203W-0990-10A-DH	9.9	35	47	89	40	10
BS200U.203W-1000-10A-DH	10	35	47	89	40	10
BS200U.203W-1010-12A-DH	10.1	40	55	102	45	12
BS200U.203W-1020-12A-DH	10.2	40	55	102	45	12
BS200U.203W-1030-12A-DH	10.3	40	55	102	45	12
BS200U.203W-1032-12A-DH	10.32	40	55	102	45	12
BS200U.203W-1040-12A-DH	10.4	40	55	102	45	12
BS200U.203W-1050-12A-DH	10.5	40	55	102	45	12
BS200U.203W-1070-12A-DH	10.7	40	55	102	45	12
BS200U.203W-1080-12A-DH	10.8	40	55	102	45	12
BS200U.203W-1100-12A-DH	11	40	55	102	45	12
BS200U.203W-1110-12A-DH	11.1	40	55	102	45	12
BS200U.203W-1111-12A-DH	11.11	40	55	102	45	12
BS200U.203W-1120-12A-DH	11.2	40	55	102	45	12
BS200U.203W-1130-12A-DH	11.3	40	55	102	45	12
BS200U.203W-1140-12A-DH	11.4	40	55	102	45	12
BS200U.203W-1150-12A-DH	11.5	40	55	102	45	12
BS200U.203W-1160-12A-DH	11.6	40	55	102	45	12
BS200U.203W-1170-12A-DH	11.7	40	55	102	45	12
BS200U.203W-1190-12A-DH	11.9	40	55	102	45	12
BS200U.203W-1200-12A-DH	12	40	55	102	45	12
BS200U.203W-1210-14A-DH	12.1	43	60	107	45	14
BS200U.203W-1220-14A-DH	12.2	43	60	107	45	14
BS200U.203W-1230-14A-DH	12.3	43	60	107	45	14
BS200U.203W-1250-14A-DH	12.5	43	60	107	45	14
BS200U.203W-1260-14A-DH	12.6	43	60	107	45	14
BS200U.203W-1270-14A-DH	12.7	43	60	107	45	14
BS200U.203W-1280-14A-DH	12.8	43	60	107	45	14
BS200U.203W-1300-14A-DH	13	43	60	107	45	14
BS200U.203W-1310-14A-DH	13.1	43	60	107	45	14
BS200U.203W-1350-14A-DH	13.5	43	60	107	45	14
BS200U.203W-1380-14A-DH	13.8	43	60	107	45	14
BS200U.203W-1400-14A-DH	14	43	60	107	45	14
BS200U.203W-1425-16A-DH	14.25	45	65	115	48	16
BS200U.203W-1429-16A-DH	14.29	45	65	115	48	16
BS200U.203W-1450-16A-DH	14.5	45	65	115	48	16
BS200U.203W-1469-16A-DH	14.69	45	65	115	48	16
BS200U.203W-1500-16A-DH	15	45	65	115	48	16
BS200U.203W-1550-16A-DH	15.5	45	65	115	48	16
BS200U.203W-1580-16A-DH	15.8	45	65	115	48	16
BS200U.203W-1587-16A-DH	15.87	45	65	115	48	16
BS200U.203W-1600-16A-DH	16	45	65	115	48	16

BS200U.203N – High-Performance Carbide Drill

Key data: HD (high-performance tool) | 3XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



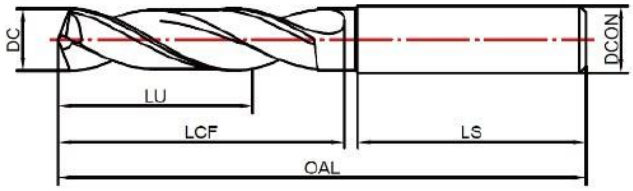
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.203N-0300-04A-DH	3	14	20	62	40	4
BS200U.203N-0310-04A-DH	3.1	14	20	62	40	4
BS200U.203N-0317-04A-DH	3.17	14	20	62	40	4
BS200U.203N-0320-04A-DH	3.2	14	20	62	40	4
BS200U.203N-0330-04A-DH	3.3	14	20	62	40	4
BS200U.203N-0340-04A-DH	3.4	14	20	62	40	4
BS200U.203N-0350-04A-DH	3.5	14	20	62	40	4
BS200U.203N-0355-04A-DH	3.55	14	20	62	40	4
BS200U.203N-0360-04A-DH	3.6	14	20	62	40	4
BS200U.203N-0370-04A-DH	3.7	14	20	62	40	4
BS200U.203N-0380-04A-DH	3.8	17	24	66	40	4
BS200U.203N-0390-04A-DH	3.9	17	24	66	40	4
BS200U.203N-0400-04A-DH	4	17	24	66	40	4
BS200U.203N-0410-06A-DH	4.1	17	24	66	40	6
BS200U.203N-0420-06A-DH	4.2	17	24	66	40	6
BS200U.203N-0430-06A-DH	4.3	17	24	66	40	6
BS200U.203N-0440-06A-DH	4.4	17	24	66	40	6
BS200U.203N-0450-06A-DH	4.5	17	24	66	40	6
BS200U.203N-0460-06A-DH	4.6	17	24	66	40	6
BS200U.203N-0470-06A-DH	4.7	17	24	66	40	6
BS200U.203N-0476-06A-DH	4.76	20	28	66	36	6
BS200U.203N-0480-06A-DH	4.8	20	28	66	36	6
BS200U.203N-0490-06A-DH	4.9	20	28	66	36	6
BS200U.203N-0500-06A-DH	5	20	28	66	36	6
BS200U.203N-0510-06A-DH	5.1	20	28	66	36	6
BS200U.203N-0520-06A-DH	5.2	20	28	66	36	6
BS200U.203N-0530-06A-DH	5.3	20	28	66	36	6
BS200U.203N-0540-06A-DH	5.4	20	28	66	36	6
BS200U.203N-0550-06A-DH	5.5	20	28	66	36	6
BS200U.203N-0556-06A-DH	5.56	20	28	66	36	6
BS200U.203N-0560-06A-DH	5.6	20	28	66	36	6
BS200U.203N-0570-06A-DH	5.7	20	28	66	36	6
BS200U.203N-0580-06A-DH	5.8	20	28	66	36	6
BS200U.203N-0590-06A-DH	5.9	20	28	66	36	6
BS200U.203N-0595-06A-DH	5.95	20	28	66	36	6
BS200U.203N-0600-06A-DH	6	20	28	66	36	6
BS200U.203N-0610-08A-DH	6.1	24	34	79	40	8
BS200U.203N-0620-08A-DH	6.2	24	34	79	40	8
BS200U.203N-0630-08A-DH	6.3	24	34	79	40	8
BS200U.203N-0635-08A-DH	6.35	24	34	79	40	8
BS200U.203N-0640-08A-DH	6.4	24	34	79	40	8
BS200U.203N-0650-08A-DH	6.5	24	34	79	40	8
BS200U.203N-0660-08A-DH	6.6	24	34	79	40	8
BS200U.203N-0670-08A-DH	6.7	24	34	79	40	8
BS200U.203N-0675-08A-DH	6.75	24	34	79	40	8
BS200U.203N-0680-08A-DH	6.8	24	34	79	40	8
BS200U.203N-0690-08A-DH	6.9	24	34	79	40	8
BS200U.203N-0700-08A-DH	7	24	34	79	40	8
BS200U.203N-0710-08A-DH	7.1	29	41	79	36	8
BS200U.203N-0714-08A-DH	7.14	29	41	79	36	8
BS200U.203N-0720-08A-DH	7.2	29	41	79	36	8
BS200U.203N-0730-08A-DH	7.3	29	41	79	36	8
BS200U.203N-0740-08A-DH	7.4	29	41	79	36	8
BS200U.203N-0750-08A-DH	7.5	29	41	79	36	8
BS200U.203N-0760-08A-DH	7.6	29	41	79	36	8
BS200U.203N-0770-08A-DH	7.7	29	41	79	36	8
BS200U.203N-0780-08A-DH	7.8	29	41	79	36	8
BS200U.203N-0790-08A-DH	7.9	29	41	79	36	8

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.203N-0794-08A-DH	7.94	29	41	79	36	8
BS200U.203N-0800-08A-DH	8	29	41	79	36	8
BS200U.203N-0810-10A-DH	8.1	35	47	89	40	10
BS200U.203N-0820-10A-DH	8.2	35	47	89	40	10
BS200U.203N-0830-10A-DH	8.3	35	47	89	40	10
BS200U.203N-0840-10A-DH	8.4	35	47	89	40	10
BS200U.203N-0850-10A-DH	8.5	35	47	89	40	10
BS200U.203N-0860-10A-DH	8.6	35	47	89	40	10
BS200U.203N-0870-10A-DH	8.7	35	47	89	40	10
BS200U.203N-0873-10A-DH	8.73	35	47	89	40	10
BS200U.203N-0880-10A-DH	8.8	35	47	89	40	10
BS200U.203N-0890-10A-DH	8.9	35	47	89	40	10
BS200U.203N-0900-10A-DH	9	35	47	89	40	10
BS200U.203N-0910-10A-DH	9.1	35	47	89	40	10
BS200U.203N-0920-10A-DH	9.2	35	47	89	40	10
BS200U.203N-0930-10A-DH	9.3	35	47	89	40	10
BS200U.203N-0940-10A-DH	9.4	35	47	89	40	10
BS200U.203N-0950-10A-DH	9.5	35	47	89	40	10
BS200U.203N-0952-10A-DH	9.52	35	47	89	40	10
BS200U.203N-0960-10A-DH	9.6	35	47	89	40	10
BS200U.203N-0970-10A-DH	9.7	35	47	89	40	10
BS200U.203N-0980-10A-DH	9.8	35	47	89	40	10
BS200U.203N-0990-10A-DH	9.9	35	47	89	40	10
BS200U.203N-1000-10A-DH	10	35	47	89	40	10
BS200U.203N-1010-12A-DH	10.1	40	55	102	45	12
BS200U.203N-1020-12A-DH	10.2	40	55	102	45	12
BS200U.203N-1030-12A-DH	10.3	40	55	102	45	12
BS200U.203N-1032-12A-DH	10.32	40	55	102	45	12
BS200U.203N-1040-12A-DH	10.4	40	55	102	45	12
BS200U.203N-1050-12A-DH	10.5	40	55	102	45	12
BS200U.203N-1060-12A-DH	10.6	40	55	102	45	12
BS200U.203N-1070-12A-DH	10.7	40	55	102	45	12
BS200U.203N-1080-12A-DH	10.8	40	55	102	45	12
BS200U.203N-1090-12A-DH	10.9	40	55	102	45	12
BS200U.203N-1100-12A-DH	11	40	55	102	45	12
BS200U.203N-1110-12A-DH	11.1	40	55	102	45	12
BS200U.203N-1111-12A-DH	11.11	40	55	102	45	12
BS200U.203N-1130-12A-DH	11.3	40	55	102	45	12
BS200U.203N-1140-12A-DH	11.4	40	55	102	45	12
BS200U.203N-1150-12A-DH	11.5	40	55	102	45	12
BS200U.203N-1160-12A-DH	11.6	40	55	102	45	12
BS200U.203N-1170-12A-DH	11.7	40	55	102	45	12
BS200U.203N-1180-12A-DH	11.8	40	55	102	45	12
BS200U.203N-1190-12A-DH	11.9	40	55	102	45	12
BS200U.203N-1200-12A-DH	12	40	55	102	45	12
BS200U.203N-1210-14A-DH	12.1	43	60	107	45	14
BS200U.203N-1220-14A-DH	12.2	43	60	107	45	14
BS200U.203N-1230-14A-DH	12.3	43	60	107	45	14
BS200U.203N-1250-14A-DH	12.5	43	60	107	45	14
BS200U.203N-1260-14A-DH	12.6	43	60	107	45	14
BS200U.203N-1270-14A-DH	12.7	43	60	107	45	14
BS200U.203N-1280-14A-DH	12.8	43	60	107	45	14
BS200U.203N-1300-14A-DH	13	43	60	107	45	14
BS200U.203N-1310-14A-DH	13.1	43	60	107	45	14
BS200U.203N-1350-14A-DH	13.5	43	60	107	45	14
BS200U.203N-1380-14A-DH	13.8	43	60	107	45	14
BS200U.203N-1400-14A-DH	14	43	60	107	45	14
BS200U.203N-1425-16A-DH	14.25	45	65	115	48	16
BS200U.203N-1429-16A-DH	14.29	45	65	115	48	16
BS200U.203N-1450-16A-DH	14.5	45	65	115	48	16
BS200U.203N-1469-16A-DH	14.69	45	65	115	48	16
BS200U.203N-1480-16A-DH	14.8	45	65	115	48	16
BS200U.203N-1500-16A-DH	15	45	65	115	48	16
BS200U.203N-1550-16A-DH	15.5	45	65	115	48	16
BS200U.203N-1580-16A-DH	15.8	45	65	115	48	16
BS200U.203N-1587-16A-DH	15.87	45	65	115	48	16
BS200U.203N-1600-16A-DH	16	45	65	115	48	16

BS200U.205W – High-Performance Carbide Drill

Key data: HD (high-performance tool) | 5XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



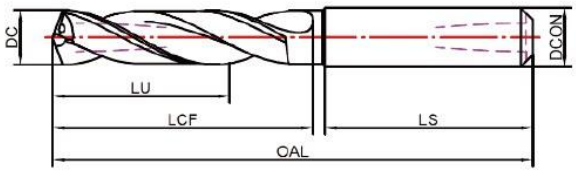
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.205W-0300-04A-DH	3	23	28	66	36	4
BS200U.205W-0310-04A-DH	3.1	23	28	66	36	4
BS200U.205W-0317-04A-DH	3.17	23	28	66	36	4
BS200U.205W-0320-04A-DH	3.2	23	28	66	36	4
BS200U.205W-0330-04A-DH	3.3	23	28	66	36	4
BS200U.205W-0340-04A-DH	3.4	23	28	66	36	4
BS200U.205W-0350-04A-DH	3.5	23	28	66	36	4
BS200U.205W-0360-04A-DH	3.6	23	28	66	36	4
BS200U.205W-0370-04A-DH	3.7	23	28	66	36	4
BS200U.205W-0390-04A-DH	3.9	29	36	74	36	4
BS200U.205W-0400-04A-DH	4	29	36	74	36	4
BS200U.205W-0410-06A-DH	4.1	29	36	74	36	6
BS200U.205W-0420-06A-DH	4.2	29	36	74	36	6
BS200U.205W-0430-06A-DH	4.3	29	36	74	36	6
BS200U.205W-0440-06A-DH	4.4	29	36	74	36	6
BS200U.205W-0450-06A-DH	4.5	29	36	74	36	6
BS200U.203W-0455-06A-DH	4.55	29	36	74	36	6
BS200U.205W-0460-06A-DH	4.6	29	36	74	36	6
BS200U.205W-0480-06A-DH	4.8	35	44	82	36	6
BS200U.205W-0490-06A-DH	4.9	35	44	82	36	6
BS200U.205W-0500-06A-DH	5	35	44	82	36	6
BS200U.205W-0510-06A-DH	5.1	35	44	82	36	6
BS200U.205W-0516-06A-DH	5.16	35	44	82	36	6
BS200U.205W-0520-06A-DH	5.2	35	44	82	36	6
BS200U.205W-0530-06A-DH	5.3	35	44	82	36	6
BS200U.205W-0540-06A-DH	5.4	35	44	82	36	6
BS200U.205W-0550-06A-DH	5.5	35	44	82	36	6
BS200U.205W-0555-06A-DH	5.55	35	44	82	36	6
BS200U.205W-0556-06A-DH	5.56	35	44	82	36	6
BS200U.205W-0560-06A-DH	5.6	35	44	82	36	6
BS200U.205W-0570-06A-DH	5.7	35	44	82	36	6
BS200U.205W-0580-06A-DH	5.8	35	44	82	36	6
BS200U.205W-0590-06A-DH	5.9	35	44	82	36	6
BS200U.205W-0595-06A-DH	5.95	35	44	82	36	6
BS200U.205W-0600-06A-DH	6	35	44	82	36	6
BS200U.205W-0610-08A-DH	6.1	43	53	91	36	8
BS200U.205W-0620-08A-DH	6.2	43	53	91	36	8
BS200U.205W-0630-08A-DH	6.3	43	53	91	36	8
BS200U.205W-0635-08A-DH	6.35	43	53	91	36	8
BS200U.205W-0640-08A-DH	6.4	43	53	91	36	8
BS200U.205W-0650-08A-DH	6.5	43	53	91	36	8
BS200U.205W-0660-08A-DH	6.6	43	53	91	36	8
BS200U.205W-0670-08A-DH	6.7	43	53	91	36	8
BS200U.205W-0675-08A-DH	6.75	43	53	91	36	8
BS200U.205W-0680-08A-DH	6.8	43	53	91	36	8
BS200U.205W-0690-08A-DH	6.9	43	53	91	36	8
BS200U.205W-0700-08A-DH	7	43	53	91	36	8
BS200U.205W-0710-08A-DH	7.1	43	53	91	36	8
BS200U.205W-0714-08A-DH	7.14	43	53	91	36	8
BS200U.205W-0720-08A-DH	7.2	43	53	91	36	8
BS200U.205W-0730-08A-DH	7.3	43	53	91	36	8
BS200U.205W-0740-08A-DH	7.4	43	53	91	36	8
BS200U.205W-0750-08A-DH	7.5	43	53	91	36	8
BS200U.205W-0754-08A-DH	7.54	43	53	91	36	8
BS200U.205W-0770-08A-DH	7.7	43	53	91	36	8
BS200U.205W-0780-08A-DH	7.8	43	53	91	36	8
BS200U.205W-0790-08A-DH	7.9	43	53	91	36	8

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.205W-0794-08A-DH	7.94	43	53	91	36	8
BS200U.205W-0800-08A-DH	8	43	53	91	36	8
BS200U.205W-0810-10A-DH	8.1	49	61	103	40	10
BS200U.205W-0815-10A-DH	8.15	49	61	103	40	10
BS200U.205W-0820-10A-DH	8.2	49	61	103	40	10
BS200U.205W-0830-10A-DH	8.3	49	61	103	40	10
BS200U.205W-0833-10A-DH	8.33	49	61	103	40	10
BS200U.205W-0840-10A-DH	8.4	49	61	103	40	10
BS200U.205W-0850-10A-DH	8.5	49	61	103	40	10
BS200U.205W-0860-10A-DH	8.6	49	61	103	40	10
BS200U.205W-0870-10A-DH	8.7	49	61	103	40	10
BS200U.205W-0873-10A-DH	8.73	49	61	103	40	10
BS200U.205W-0880-10A-DH	8.8	49	61	103	40	10
BS200U.205W-0890-10A-DH	8.9	49	61	103	40	10
BS200U.205W-0900-10A-DH	9	49	61	103	40	10
BS200U.205W-0910-10A-DH	9.1	49	61	103	40	10
BS200U.205W-0920-10A-DH	9.2	49	61	103	40	10
BS200U.205W-0930-10A-DH	9.3	49	61	103	40	10
BS200U.205W-0940-10A-DH	9.4	49	61	103	40	10
BS200U.205W-0950-10A-DH	9.5	49	61	103	40	10
BS200U.205W-0952-10A-DH	9.52	49	61	103	40	10
BS200U.205W-0955-10A-DH	9.55	49	61	103	40	10
BS200U.205W-0960-10A-DH	9.6	49	61	103	40	10
BS200U.205W-0980-10A-DH	9.8	49	61	103	40	10
BS200U.205W-0990-10A-DH	9.9	49	61	103	40	10
BS200U.205W-1000-10A-DH	10	49	61	103	40	10
BS200U.205W-1010-12A-DH	10.1	56	71	118	45	12
BS200U.205W-1020-12A-DH	10.2	56	71	118	45	12
BS200U.205W-1030-12A-DH	10.3	56	71	118	45	12
BS200U.205W-1032-12A-DH	10.32	56	71	118	45	12
BS200U.205W-1040-12A-DH	10.4	56	71	118	45	12
BS200U.205W-1050-12A-DH	10.5	56	71	118	45	12
BS200U.205W-1060-12A-DH	10.6	56	71	118	45	12
BS200U.205W-1070-12A-DH	10.7	56	71	118	45	12
BS200U.205W-1071-12A-DH	10.71	56	71	118	45	12
BS200U.205W-1080-12A-DH	10.8	56	71	118	45	12
BS200U.205W-1090-12A-DH	10.9	56	71	118	45	12
BS200U.205W-1100-12A-DH	11	56	71	118	45	12
BS200U.205W-1110-12A-DH	11.1	56	71	118	45	12
BS200U.205W-1120-12A-DH	11.2	56	71	118	45	12
BS200U.205W-1130-12A-DH	11.3	56	71	118	45	12
BS200U.205W-1150-12A-DH	11.5	56	71	118	45	12
BS200U.205W-1170-12A-DH	11.7	56	71	118	45	12
BS200U.205W-1180-12A-DH	11.8	56	71	118	45	12
BS200U.205W-1200-12A-DH	12	56	71	118	45	12
BS200U.205W-1210-14A-DH	12.1	60	77	124	45	14
BS200U.205W-1220-14A-DH	12.2	60	77	124	45	14
BS200U.205W-1230-14A-DH	12.3	60	77	124	45	14
BS200U.205W-1250-14A-DH	12.5	60	77	124	45	14
BS200U.205W-1270-14A-DH	12.7	60	77	124	45	14
BS200U.205W-1280-14A-DH	12.8	60	77	124	45	14
BS200U.205W-1300-14A-DH	13	60	77	124	45	14
BS200U.205W-1310-14A-DH	13.1	60	77	124	45	14
BS200U.205W-1325-14A-DH	13.25	60	77	124	45	14
BS200U.205W-1350-14A-DH	13.5	60	77	124	45	14
BS200U.205W-1375-14A-DH	13.75	60	77	124	45	14
BS200U.205W-1380-14A-DH	13.8	60	77	124	45	14
BS200U.205W-1389-14A-DH	13.89	60	77	124	45	14
BS200U.205W-1400-14A-DH	14	60	77	124	45	14
BS200U.205W-1425-16A-DH	14.25	63	83	133	48	16
BS200U.205W-1429-16A-DH	14.29	63	83	133	48	16
BS200U.205W-1450-16A-DH	14.5	63	83	133	48	16
BS200U.205W-1480-16A-DH	14.8	63	83	133	48	16
BS200U.205W-1500-16A-DH	15	63	83	133	48	16
BS200U.205W-1550-16A-DH	15.5	63	83	133	48	16
BS200U.205W-1580-16A-DH	15.8	63	83	133	48	16
BS200U.205W-1600-16A-DH	16	63	83	133	48	16

BS200U.205N – High-Performance Carbide Drill

Key data: HD (high-performance tool) | 5XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.205N-0300-04A-DH	3	23	28	66	36	4
BS200U.205N-0310-04A-DH	3.1	23	28	66	36	4
BS200U.205N-0317-04A-DH	3.17	23	28	66	36	4
BS200U.205N-0320-04A-DH	3.2	23	28	66	36	4
BS200U.205N-0330-04A-DH	3.3	23	28	66	36	4
BS200U.205N-0340-04A-DH	3.4	23	28	66	36	4
BS200U.205N-0350-04A-DH	3.5	23	28	66	36	4
BS200U.205N-0360-04A-DH	3.6	23	28	66	36	4
BS200U.205N-0370-04A-DH	3.7	23	28	66	36	4
BS200U.205N-0380-04A-DH	3.8	29	36	74	36	4
BS200U.205N-0390-04A-DH	3.9	29	36	74	36	4
BS200U.205N-0400-04A-DH	4	29	36	74	36	4
BS200U.205N-0410-06A-DH	4.1	29	36	74	36	6
BS200U.205N-0420-06A-DH	4.2	29	36	74	36	6
BS200U.205N-0430-06A-DH	4.3	29	36	74	36	6
BS200U.205N-0440-06A-DH	4.4	29	36	74	36	6
BS200U.205N-0450-06A-DH	4.5	29	36	74	36	6
BS200U.203N-0455-06A-DH	4.55	29	36	74	36	6
BS200U.205N-0460-06A-DH	4.6	29	36	74	36	6
BS200U.205N-0470-06A-DH	4.7	29	36	74	36	6
BS200U.205N-0480-06A-DH	4.8	35	44	82	36	6
BS200U.205N-0490-06A-DH	4.9	35	44	82	36	6
BS200U.205N-0500-06A-DH	5	35	44	82	36	6
BS200U.205N-0510-06A-DH	5.1	35	44	82	36	6
BS200U.205N-0516-06A-DH	5.16	35	44	82	36	6
BS200U.205N-0520-06A-DH	5.2	35	44	82	36	6
BS200U.205N-0530-06A-DH	5.3	35	44	82	36	6
BS200U.205N-0540-06A-DH	5.4	35	44	82	36	6
BS200U.205N-0550-06A-DH	5.5	35	44	82	36	6
BS200U.205N-0555-06A-DH	5.55	35	44	82	36	6
BS200U.205N-0556-06A-DH	5.56	35	44	82	36	6
BS200U.205N-0560-06A-DH	5.6	35	44	82	36	6
BS200U.205N-0570-06A-DH	5.7	35	44	82	36	6
BS200U.205N-0580-06A-DH	5.8	35	44	82	36	6
BS200U.205N-0590-06A-DH	5.9	35	44	82	36	6
BS200U.205N-0595-06A-DH	5.95	35	44	82	36	6
BS200U.205N-0600-06A-DH	6	35	44	82	36	6
BS200U.205N-0610-08A-DH	6.1	43	53	91	36	8
BS200U.205N-0620-08A-DH	6.2	43	53	91	36	8
BS200U.205N-0630-08A-DH	6.3	43	53	91	36	8
BS200U.205N-0635-08A-DH	6.35	43	53	91	36	8
BS200U.205N-0640-08A-DH	6.4	43	53	91	36	8
BS200U.205N-0650-08A-DH	6.5	43	53	91	36	8
BS200U.205N-0660-08A-DH	6.6	43	53	91	36	8
BS200U.205N-0670-08A-DH	6.7	43	53	91	36	8
BS200U.205N-0675-08A-DH	6.75	43	53	91	36	8
BS200U.205N-0680-08A-DH	6.8	43	53	91	36	8
BS200U.205N-0690-08A-DH	6.9	43	53	91	36	8
BS200U.205N-0700-08A-DH	7	43	53	91	36	8
BS200U.205N-0710-08A-DH	7.1	43	53	91	36	8
BS200U.205N-0714-08A-DH	7.14	43	53	91	36	8
BS200U.205N-0720-08A-DH	7.2	43	53	91	36	8

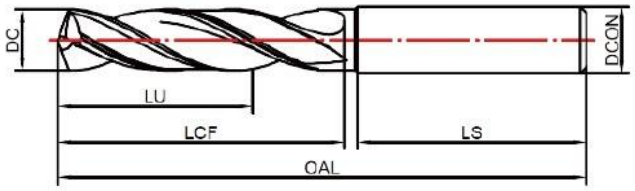
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.205N-0730-08A-DH	7.3	43	53	91	36	8
BS200U.205N-0740-08A-DH	7.4	43	53	91	36	8
BS200U.205N-0750-08A-DH	7.5	43	53	91	36	8
BS200U.205N-0754-08A-DH	7.54	43	53	91	36	8
BS200U.205N-0770-08A-DH	7.7	43	53	91	36	8
BS200U.205N-0780-08A-DH	7.8	43	53	91	36	8
BS200U.205N-0790-08A-DH	7.9	43	53	91	36	8
BS200U.205N-0794-08A-DH	7.94	43	53	91	36	8
BS200U.205N-0800-08A-DH	8	43	53	91	36	8
BS200U.205N-0810-10A-DH	8.1	49	61	103	40	10
BS200U.205N-0815-10A-DH	8.15	49	61	103	40	10
BS200U.205N-0820-10A-DH	8.2	49	61	103	40	10
BS200U.205N-0830-10A-DH	8.3	49	61	103	40	10
BS200U.205N-0833-10A-DH	8.33	49	61	103	40	10
BS200U.205N-0840-10A-DH	8.4	49	61	103	40	10
BS200U.205N-0850-10A-DH	8.5	49	61	103	40	10
BS200U.205N-0860-10A-DH	8.6	49	61	103	40	10
BS200U.205N-0870-10A-DH	8.7	49	61	103	40	10
BS200U.205N-0873-10A-DH	8.73	49	61	103	40	10
BS200U.205N-0880-10A-DH	8.8	49	61	103	40	10
BS200U.205N-0900-10A-DH	9	49	61	103	40	10
BS200U.205N-0910-10A-DH	9.1	49	61	103	40	10
BS200U.205N-0920-10A-DH	9.2	49	61	103	40	10
BS200U.205N-0930-10A-DH	9.3	49	61	103	40	10
BS200U.205N-0940-10A-DH	9.4	49	61	103	40	10
BS200U.205N-0950-10A-DH	9.5	49	61	103	40	10
BS200U.205N-0952-10A-DH	9.52	49	61	103	40	10
BS200U.205N-0955-10A-DH	9.55	49	61	103	40	10
BS200U.205N-0960-10A-DH	9.6	49	61	103	40	10
BS200U.205N-0980-10A-DH	9.8	49	61	103	40	10
BS200U.205N-0990-10A-DH	9.9	49	61	103	40	10
BS200U.205N-1000-10A-DH	10	49	61	103	40	10
BS200U.205N-1010-12A-DH	10.1	56	71	118	45	12
BS200U.205N-1020-12A-DH	10.2	56	71	118	45	12
BS200U.205N-1030-12A-DH	10.3	56	71	118	45	12
BS200U.205N-1032-12A-DH	10.32	56	71	118	45	12
BS200U.205N-1040-12A-DH	10.4	56	71	118	45	12
BS200U.205N-1050-12A-DH	10.5	56	71	118	45	12
BS200U.205N-1060-12A-DH	10.6	56	71	118	45	12
BS200U.205N-1070-12A-DH	10.7	56	71	118	45	12
BS200U.205N-1071-12A-DH	10.71	56	71	118	45	12
BS200U.205N-1080-12A-DH	10.8	56	71	118	45	12
BS200U.205N-1090-12A-DH	10.9	56	71	118	45	12
BS200U.205N-1100-12A-DH	11	56	71	118	45	12
BS200U.205N-1110-12A-DH	11.1	56	71	118	45	12
BS200U.205N-1130-12A-DH	11.3	56	71	118	45	12
BS200U.205N-1140-12A-DH	11.4	56	71	118	45	12
BS200U.205N-1150-12A-DH	11.5	56	71	118	45	12
BS200U.205N-1160-12A-DH	11.6	56	71	118	45	12
BS200U.205N-1170-12A-DH	11.7	56	71	118	45	12
BS200U.205N-1180-12A-DH	11.8	56	71	118	45	12
BS200U.205N-1190-12A-DH	11.9	56	71	118	45	12
BS200U.205N-1200-12A-DH	12	56	71	118	45	12
BS200U.205N-1210-14A-DH	12.1	60	77	124	45	14
BS200U.205N-1220-14A-DH	12.2	60	77	124	45	14
BS200U.205N-1230-14A-DH	12.3	60	77	124	45	14
BS200U.205N-1250-14A-DH	12.5	60	77	124	45	14
BS200U.205N-1260-14A-DH	12.6	60	77	124	45	14
BS200U.205N-1270-14A-DH	12.7	60	77	124	45	14
BS200U.205N-1280-14A-DH	12.8	60	77	124	45	14
BS200U.205N-1300-14A-DH	13	60	77	124	45	14
BS200U.205N-1310-14A-DH	13.1	60	77	124	45	14
BS200U.205N-1325-14A-DH	13.25	60	77	124	45	14
BS200U.205N-1350-14A-DH	13.5	60	77	124	45	14
BS200U.205N-1375-14A-DH	13.75	60	77	124	45	14
BS200U.205N-1380-14A-DH	13.8	60	77	124	45	14
BS200U.205N-1389-14A-DH	13.89	60	77	124	45	14
BS200U.205N-1400-14A-DH	14	60	77	124	45	14
BS200U.205N-1425-16A-DH	14.25	63	83	133	48	16
BS200U.205N-1429-16A-DH	14.29	63	83	133	48	16
BS200U.205N-1450-16A-DH	14.5	63	83	133	48	16
BS200U.205N-1480-16A-DH	14.8	63	83	133	48	16

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS200U.205N-1500-16A-DH	15	63	83	133	48	16
BS200U.205N-1550-16A-DH	15.5	63	83	133	48	16
BS200U.205N-1580-16A-DH	15.8	63	83	133	48	16
BS200U.205N-1600-16A-DH	16	63	83	133	48	16

BS202U.205W – High-Performance Carbide Drill

Key data: HD (high-performance tool) | 5XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.205W-0300-04A-DH	3	23	28	66	36	4
BS202U.205W-0310-04A-DH	3.1	23	28	66	36	4
BS202U.205W-0317-04A-DH	3.17	23	28	66	36	4
BS202U.205W-0320-04A-DH	3.2	23	28	66	36	4
BS202U.205W-0330-04A-DH	3.3	23	28	66	36	4
BS202U.205W-0340-04A-DH	3.4	23	28	66	36	4
BS202U.205W-0350-04A-DH	3.5	23	28	66	36	4
BS202U.205W-0360-04A-DH	3.6	23	28	66	36	4
BS202U.205W-0370-04A-DH	3.7	23	28	66	36	4
BS202U.205W-0390-04A-DH	3.9	29	36	74	36	4
BS202U.205W-0400-04A-DH	4	29	36	74	36	4
BS202U.205W-0410-06A-DH	4.1	29	36	74	36	6
BS202U.205W-0420-06A-DH	4.2	29	36	74	36	6
BS202U.205W-0430-06A-DH	4.3	29	36	74	36	6
BS202U.205W-0440-06A-DH	4.4	29	36	74	36	6
BS202U.205W-0450-06A-DH	4.5	29	36	74	36	6
BS202U.203W-0455-06A-DH	4.55	29	36	74	36	6
BS202U.205W-0460-06A-DH	4.6	29	36	74	36	6
BS202U.205W-0480-06A-DH	4.8	35	44	82	36	6
BS202U.205W-0490-06A-DH	4.9	35	44	82	36	6
BS202U.205W-0500-06A-DH	5	35	44	82	36	6
BS202U.205W-0510-06A-DH	5.1	35	44	82	36	6
BS202U.205W-0516-06A-DH	5.16	35	44	82	36	6
BS202U.205W-0520-06A-DH	5.2	35	44	82	36	6
BS202U.205W-0530-06A-DH	5.3	35	44	82	36	6
BS202U.205W-0540-06A-DH	5.4	35	44	82	36	6
BS202U.205W-0550-06A-DH	5.5	35	44	82	36	6
BS202U.205W-0555-06A-DH	5.55	35	44	82	36	6
BS202U.205W-0556-06A-DH	5.56	35	44	82	36	6
BS202U.205W-0560-06A-DH	5.6	35	44	82	36	6
BS202U.205W-0570-06A-DH	5.7	35	44	82	36	6
BS202U.205W-0580-06A-DH	5.8	35	44	82	36	6
BS202U.205W-0590-06A-DH	5.9	35	44	82	36	6
BS202U.205W-0595-06A-DH	5.95	35	44	82	36	6
BS202U.205W-0600-06A-DH	6	35	44	82	36	6
BS202U.205W-0610-08A-DH	6.1	43	53	91	36	8
BS202U.205W-0620-08A-DH	6.2	43	53	91	36	8
BS202U.205W-0630-08A-DH	6.3	43	53	91	36	8
BS202U.205W-0635-08A-DH	6.35	43	53	91	36	8
BS202U.205W-0640-08A-DH	6.4	43	53	91	36	8
BS202U.205W-0650-08A-DH	6.5	43	53	91	36	8
BS202U.205W-0660-08A-DH	6.6	43	53	91	36	8
BS202U.205W-0670-08A-DH	6.7	43	53	91	36	8
BS202U.205W-0675-08A-DH	6.75	43	53	91	36	8
BS202U.205W-0680-08A-DH	6.8	43	53	91	36	8
BS202U.205W-0690-08A-DH	6.9	43	53	91	36	8
BS202U.205W-0700-08A-DH	7	43	53	91	36	8
BS202U.205W-0710-08A-DH	7.1	43	53	91	36	8
BS202U.205W-0714-08A-DH	7.14	43	53	91	36	8

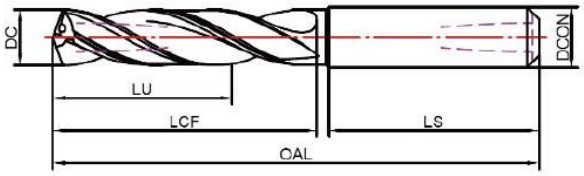
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.205W-0720-08A-DH	7.2	43	53	91	36	8
BS202U.205W-0730-08A-DH	7.3	43	53	91	36	8
BS202U.205W-0740-08A-DH	7.4	43	53	91	36	8
BS202U.205W-0750-08A-DH	7.5	43	53	91	36	8
BS202U.205W-0754-08A-DH	7.54	43	53	91	36	8
BS202U.205W-0770-08A-DH	7.7	43	53	91	36	8
BS202U.205W-0780-08A-DH	7.8	43	53	91	36	8
BS202U.205W-0790-08A-DH	7.9	43	53	91	36	8
BS202U.205W-0794-08A-DH	7.94	43	53	91	36	8
BS202U.205W-0800-08A-DH	8	43	53	91	36	8
BS202U.205W-0810-10A-DH	8.1	49	61	103	40	10
BS202U.205W-0815-10A-DH	8.15	49	61	103	40	10
BS202U.205W-0820-10A-DH	8.2	49	61	103	40	10
BS202U.205W-0830-10A-DH	8.3	49	61	103	40	10
BS202U.205W-0833-10A-DH	8.33	49	61	103	40	10
BS202U.205W-0840-10A-DH	8.4	49	61	103	40	10
BS202U.205W-0850-10A-DH	8.5	49	61	103	40	10
BS202U.205W-0860-10A-DH	8.6	49	61	103	40	10
BS202U.205W-0870-10A-DH	8.7	49	61	103	40	10
BS202U.205W-0873-10A-DH	8.73	49	61	103	40	10
BS202U.205W-0880-10A-DH	8.8	49	61	103	40	10
BS202U.205W-0890-10A-DH	8.9	49	61	103	40	10
BS202U.205W-0900-10A-DH	9	49	61	103	40	10
BS202U.205W-0910-10A-DH	9.1	49	61	103	40	10
BS202U.205W-0920-10A-DH	9.2	49	61	103	40	10
BS202U.205W-0930-10A-DH	9.3	49	61	103	40	10
BS202U.205W-0940-10A-DH	9.4	49	61	103	40	10
BS202U.205W-0950-10A-DH	9.5	49	61	103	40	10
BS202U.205W-0952-10A-DH	9.52	49	61	103	40	10
BS202U.205W-0955-10A-DH	9.55	49	61	103	40	10
BS202U.205W-0960-10A-DH	9.6	49	61	103	40	10
BS202U.205W-0980-10A-DH	9.8	49	61	103	40	10
BS202U.205W-0990-10A-DH	9.9	49	61	103	40	10
BS202U.205W-1000-10A-DH	10	49	61	103	40	10
BS202U.205W-1010-12A-DH	10.1	56	71	118	45	12
BS202U.205W-1020-12A-DH	10.2	56	71	118	45	12
BS202U.205W-1030-12A-DH	10.3	56	71	118	45	12
BS202U.205W-1032-12A-DH	10.32	56	71	118	45	12
BS202U.205W-1040-12A-DH	10.4	56	71	118	45	12
BS202U.205W-1050-12A-DH	10.5	56	71	118	45	12
BS202U.205W-1060-12A-DH	10.6	56	71	118	45	12
BS202U.205W-1070-12A-DH	10.7	56	71	118	45	12
BS202U.205W-1071-12A-DH	10.71	56	71	118	45	12
BS202U.205W-1080-12A-DH	10.8	56	71	118	45	12
BS202U.205W-1090-12A-DH	10.9	56	71	118	45	12
BS202U.205W-1100-12A-DH	11	56	71	118	45	12
BS202U.205W-1110-12A-DH	11.1	56	71	118	45	12
BS202U.205W-1120-12A-DH	11.2	56	71	118	45	12
BS202U.205W-1130-12A-DH	11.3	56	71	118	45	12
BS202U.205W-1150-12A-DH	11.5	56	71	118	45	12
BS202U.205W-1170-12A-DH	11.7	56	71	118	45	12
BS202U.205W-1180-12A-DH	11.8	56	71	118	45	12
BS202U.205W-1200-12A-DH	12	56	71	118	45	12
BS202U.205W-1210-14A-DH	12.1	60	77	124	45	14
BS202U.205W-1220-14A-DH	12.2	60	77	124	45	14
BS202U.205W-1230-14A-DH	12.3	60	77	124	45	14
BS202U.205W-1250-14A-DH	12.5	60	77	124	45	14
BS202U.205W-1270-14A-DH	12.7	60	77	124	45	14
BS202U.205W-1280-14A-DH	12.8	60	77	124	45	14
BS202U.205W-1300-14A-DH	13	60	77	124	45	14
BS202U.205W-1310-14A-DH	13.1	60	77	124	45	14
BS202U.205W-1325-14A-DH	13.25	60	77	124	45	14
BS202U.205W-1350-14A-DH	13.5	60	77	124	45	14
BS202U.205W-1375-14A-DH	13.75	60	77	124	45	14
BS202U.205W-1380-14A-DH	13.8	60	77	124	45	14
BS202U.205W-1389-14A-DH	13.89	60	77	124	45	14
BS202U.205W-1400-14A-DH	14	60	77	124	45	14
BS202U.205W-1425-16A-DH	14.25	63	83	133	48	16
BS202U.205W-1429-16A-DH	14.29	63	83	133	48	16
BS202U.205W-1450-16A-DH	14.5	63	83	133	48	16
BS202U.205W-1480-16A-DH	14.8	63	83	133	48	16
BS202U.205W-1500-16A-DH	15	63	83	133	48	16

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.205W-1550-16A-DH	15.5	63	83	133	48	16
BS202U.205W-1580-16A-DH	15.8	63	83	133	48	16
BS202U.205W-1600-16A-DH	16	63	83	133	48	16

BS202U.205N – High-Performance Carbide Drill

Key data: HD (high-performance tool) | 5XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.205N-0300-04A-DH	3	23	28	66	36	4
BS202U.205N-0310-04A-DH	3.1	23	28	66	36	4
BS202U.205N-0317-04A-DH	3.17	23	28	66	36	4
BS202U.205N-0320-04A-DH	3.2	23	28	66	36	4
BS202U.205N-0330-04A-DH	3.3	23	28	66	36	4
BS202U.205N-0340-04A-DH	3.4	23	28	66	36	4
BS202U.205N-0350-04A-DH	3.5	23	28	66	36	4
BS202U.205N-0360-04A-DH	3.6	23	28	66	36	4
BS202U.205N-0370-04A-DH	3.7	23	28	66	36	4
BS202U.205N-0380-04A-DH	3.8	29	36	74	36	4
BS202U.205N-0390-04A-DH	3.9	29	36	74	36	4
BS202U.205N-0400-04A-DH	4	29	36	74	36	4
BS202U.205N-0410-06A-DH	4.1	29	36	74	36	6
BS202U.205N-0420-06A-DH	4.2	29	36	74	36	6
BS202U.205N-0430-06A-DH	4.3	29	36	74	36	6
BS202U.205N-0440-06A-DH	4.4	29	36	74	36	6
BS202U.205N-0450-06A-DH	4.5	29	36	74	36	6
BS202U.203N-0455-06A-DH	4.55	29	36	74	36	6
BS202U.205N-0460-06A-DH	4.6	29	36	74	36	6
BS202U.205N-0470-06A-DH	4.7	29	36	74	36	6
BS202U.205N-0480-06A-DH	4.8	35	44	82	36	6
BS202U.205N-0490-06A-DH	4.9	35	44	82	36	6
BS202U.205N-0500-06A-DH	5	35	44	82	36	6
BS202U.205N-0510-06A-DH	5.1	35	44	82	36	6
BS202U.205N-0516-06A-DH	5.16	35	44	82	36	6
BS202U.205N-0520-06A-DH	5.2	35	44	82	36	6
BS202U.205N-0530-06A-DH	5.3	35	44	82	36	6
BS202U.205N-0540-06A-DH	5.4	35	44	82	36	6
BS202U.205N-0550-06A-DH	5.5	35	44	82	36	6
BS202U.205N-0555-06A-DH	5.55	35	44	82	36	6
BS202U.205N-0556-06A-DH	5.56	35	44	82	36	6
BS202U.205N-0560-06A-DH	5.6	35	44	82	36	6
BS202U.205N-0570-06A-DH	5.7	35	44	82	36	6
BS202U.205N-0580-06A-DH	5.8	35	44	82	36	6
BS202U.205N-0590-06A-DH	5.9	35	44	82	36	6
BS202U.205N-0595-06A-DH	5.95	35	44	82	36	6
BS202U.205N-0600-06A-DH	6	35	44	82	36	6
BS202U.205N-0610-08A-DH	6.1	43	53	91	36	8
BS202U.205N-0620-08A-DH	6.2	43	53	91	36	8
BS202U.205N-0630-08A-DH	6.3	43	53	91	36	8
BS202U.205N-0635-08A-DH	6.35	43	53	91	36	8
BS202U.205N-0640-08A-DH	6.4	43	53	91	36	8
BS202U.205N-0650-08A-DH	6.5	43	53	91	36	8
BS202U.205N-0660-08A-DH	6.6	43	53	91	36	8

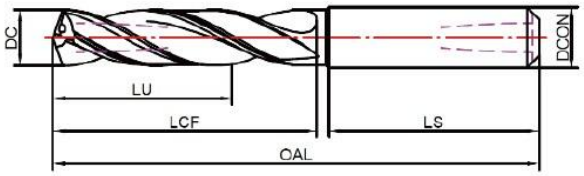
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.205N-0670-08A-DH	6.7	43	53	91	36	8
BS202U.205N-0675-08A-DH	6.75	43	53	91	36	8
BS202U.205N-0680-08A-DH	6.8	43	53	91	36	8
BS202U.205N-0690-08A-DH	6.9	43	53	91	36	8
BS202U.205N-0700-08A-DH	7	43	53	91	36	8
BS202U.205N-0710-08A-DH	7.1	43	53	91	36	8
BS202U.205N-0714-08A-DH	7.14	43	53	91	36	8
BS202U.205N-0720-08A-DH	7.2	43	53	91	36	8
BS202U.205N-0730-08A-DH	7.3	43	53	91	36	8
BS202U.205N-0740-08A-DH	7.4	43	53	91	36	8
BS202U.205N-0750-08A-DH	7.5	43	53	91	36	8
BS202U.205N-0754-08A-DH	7.54	43	53	91	36	8
BS202U.205N-0770-08A-DH	7.7	43	53	91	36	8
BS202U.205N-0780-08A-DH	7.8	43	53	91	36	8
BS202U.205N-0790-08A-DH	7.9	43	53	91	36	8
BS202U.205N-0794-08A-DH	7.94	43	53	91	36	8
BS202U.205N-0800-08A-DH	8	43	53	91	36	8
BS202U.205N-0810-10A-DH	8.1	49	61	103	40	10
BS202U.205N-0815-10A-DH	8.15	49	61	103	40	10
BS202U.205N-0820-10A-DH	8.2	49	61	103	40	10
BS202U.205N-0830-10A-DH	8.3	49	61	103	40	10
BS202U.205N-0833-10A-DH	8.33	49	61	103	40	10
BS202U.205N-0840-10A-DH	8.4	49	61	103	40	10
BS202U.205N-0850-10A-DH	8.5	49	61	103	40	10
BS202U.205N-0860-10A-DH	8.6	49	61	103	40	10
BS202U.205N-0870-10A-DH	8.7	49	61	103	40	10
BS202U.205N-0873-10A-DH	8.73	49	61	103	40	10
BS202U.205N-0880-10A-DH	8.8	49	61	103	40	10
BS202U.205N-0900-10A-DH	9	49	61	103	40	10
BS202U.205N-0910-10A-DH	9.1	49	61	103	40	10
BS202U.205N-0920-10A-DH	9.2	49	61	103	40	10
BS202U.205N-0930-10A-DH	9.3	49	61	103	40	10
BS202U.205N-0940-10A-DH	9.4	49	61	103	40	10
BS202U.205N-0950-10A-DH	9.5	49	61	103	40	10
BS202U.205N-0952-10A-DH	9.52	49	61	103	40	10
BS202U.205N-0955-10A-DH	9.55	49	61	103	40	10
BS202U.205N-0960-10A-DH	9.6	49	61	103	40	10
BS202U.205N-0980-10A-DH	9.8	49	61	103	40	10
BS202U.205N-0990-10A-DH	9.9	49	61	103	40	10
BS202U.205N-1000-10A-DH	10	49	61	103	40	10
BS202U.205N-1010-12A-DH	10.1	56	71	118	45	12
BS202U.205N-1020-12A-DH	10.2	56	71	118	45	12
BS202U.205N-1030-12A-DH	10.3	56	71	118	45	12
BS202U.205N-1032-12A-DH	10.32	56	71	118	45	12
BS202U.205N-1040-12A-DH	10.4	56	71	118	45	12
BS202U.205N-1050-12A-DH	10.5	56	71	118	45	12
BS202U.205N-1060-12A-DH	10.6	56	71	118	45	12
BS202U.205N-1070-12A-DH	10.7	56	71	118	45	12
BS202U.205N-1071-12A-DH	10.71	56	71	118	45	12
BS202U.205N-1080-12A-DH	10.8	56	71	118	45	12
BS202U.205N-1090-12A-DH	10.9	56	71	118	45	12
BS202U.205N-1100-12A-DH	11	56	71	118	45	12
BS202U.205N-1110-12A-DH	11.1	56	71	118	45	12
BS202U.205N-1130-12A-DH	11.3	56	71	118	45	12
BS202U.205N-1140-12A-DH	11.4	56	71	118	45	12
BS202U.205N-1150-12A-DH	11.5	56	71	118	45	12
BS202U.205N-1160-12A-DH	11.6	56	71	118	45	12
BS202U.205N-1170-12A-DH	11.7	56	71	118	45	12
BS202U.205N-1180-12A-DH	11.8	56	71	118	45	12
BS202U.205N-1190-12A-DH	11.9	56	71	118	45	12
BS202U.205N-1200-12A-DH	12	56	71	118	45	12
BS202U.205N-1210-14A-DH	12.1	60	77	124	45	14
BS202U.205N-1220-14A-DH	12.2	60	77	124	45	14
BS202U.205N-1230-14A-DH	12.3	60	77	124	45	14
BS202U.205N-1250-14A-DH	12.5	60	77	124	45	14
BS202U.205N-1260-14A-DH	12.6	60	77	124	45	14
BS202U.205N-1270-14A-DH	12.7	60	77	124	45	14
BS202U.205N-1280-14A-DH	12.8	60	77	124	45	14
BS202U.205N-1300-14A-DH	13	60	77	124	45	14
BS202U.205N-1310-14A-DH	13.1	60	77	124	45	14
BS202U.205N-1325-14A-DH	13.25	60	77	124	45	14
BS202U.205N-1350-14A-DH	13.5	60	77	124	45	14

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.205N-1375-14A-DH	13.75	60	77	124	45	14
BS202U.205N-1380-14A-DH	13.8	60	77	124	45	14
BS202U.205N-1389-14A-DH	13.89	60	77	124	45	14
BS202U.205N-1400-14A-DH	14	60	77	124	45	14
BS202U.205N-1425-16A-DH	14.25	63	83	133	48	16
BS202U.205N-1429-16A-DH	14.29	63	83	133	48	16
BS202U.205N-1450-16A-DH	14.5	63	83	133	48	16
BS202U.205N-1480-16A-DH	14.8	63	83	133	48	16
BS202U.205N-1500-16A-DH	15	63	83	133	48	16
BS202U.205N-1550-16A-DH	15.5	63	83	133	48	16
BS202U.205N-1580-16A-DH	15.8	63	83	133	48	16
BS202U.205N-1600-16A-DH	16	63	83	133	48	16

BS202U.208N – High-Performance Carbide Drill

Key data: HD (high-performance tool) | 8XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



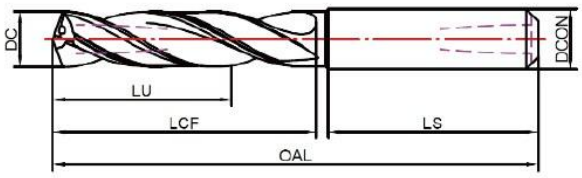
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.208N-0300-04A-DH	3	33	40	78	36	4
BS202U.208N-0310-04A-DH	3.1	33	40	78	36	4
BS202U.208N-0317-04A-DH	3.17	33	40	78	36	4
BS202U.208N-0320-04A-DH	3.2	33	40	78	36	4
BS202U.208N-0330-04A-DH	3.3	33	40	78	36	4
BS202U.208N-0340-04A-DH	3.4	33	40	78	36	4
BS202U.208N-0345-04A-DH	3.45	33	40	78	36	4
BS202U.208N-0350-04A-DH	3.5	33	40	78	36	4
BS202U.208N-0357-04A-DH	3.57	33	40	78	36	4
BS202U.208N-0360-04A-DH	3.6	33	40	78	36	4
BS202U.208N-0370-04A-DH	3.7	33	40	78	36	4
BS202U.208N-0380-04A-DH	3.8	41	49	87	36	4
BS202U.208N-0390-04A-DH	3.9	41	49	87	36	4
BS202U.208N-0397-04A-DH	3.97	41	49	87	36	4
BS202U.208N-0400-04A-DH	4	41	49	87	36	4
BS202U.208N-0410-06A-DH	4.1	41	49	87	36	6
BS202U.208N-0420-06A-DH	4.2	41	49	87	36	6
BS202U.208N-0430-06A-DH	4.3	41	49	87	36	6
BS202U.208N-0440-06A-DH	4.4	41	49	87	36	6
BS202U.208N-0450-06A-DH	4.5	41	49	87	36	6
BS202U.208N-0460-06A-DH	4.6	41	49	87	36	6
BS202U.208N-0470-06A-DH	4.7	41	49	87	36	6
BS202U.208N-0476-06A-DH	4.76	48	56	94	36	6
BS202U.208N-0480-06A-DH	4.8	48	56	94	36	6
BS202U.208N-0490-06A-DH	4.9	48	56	94	36	6
BS202U.208N-0500-06A-DH	5	48	56	94	36	6
BS202U.208N-0510-06A-DH	5.1	48	56	94	36	6
BS202U.208N-0516-06A-DH	5.16	48	56	94	36	6
BS202U.208N-0520-06A-DH	5.2	48	56	94	36	6
BS202U.208N-0540-06A-DH	5.4	48	56	94	36	6
BS202U.208N-0550-06A-DH	5.5	48	56	94	36	6
BS202U.208N-0556-06A-DH	5.56	48	56	94	36	6
BS202U.208N-0560-06A-DH	5.6	48	56	94	36	6
BS202U.208N-0570-06A-DH	5.7	48	56	94	36	6
BS202U.208N-0580-06A-DH	5.8	48	56	94	36	6

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.208N-0590-06A-DH	5.9	48	56	94	36	6
BS202U.208N-0600-06A-DH	6	48	56	94	36	6
BS202U.208N-0610-08A-DH	6.1	57	67	105	36	8
BS202U.208N-0620-08A-DH	6.2	57	67	105	36	8
BS202U.208N-0630-08A-DH	6.3	57	67	105	36	8
BS202U.208N-0635-08A-DH	6.35	57	67	105	36	8
BS202U.208N-0640-08A-DH	6.4	57	67	105	36	8
BS202U.208N-0650-08A-DH	6.5	57	67	105	36	8
BS202U.208N-0660-08A-DH	6.6	57	67	105	36	8
BS202U.208N-0670-08A-DH	6.7	57	67	105	36	8
BS202U.208N-0675-08A-DH	6.75	57	67	105	36	8
BS202U.208N-0680-08A-DH	6.8	57	67	105	36	8
BS202U.208N-0690-08A-DH	6.9	57	67	105	36	8
BS202U.208N-0700-08A-DH	7	57	67	105	36	8
BS202U.208N-0714-08A-DH	7.14	64	74	113	36	8
BS202U.208N-0730-08A-DH	7.3	64	74	113	36	8
BS202U.208N-0740-08A-DH	7.4	64	74	113	36	8
BS202U.208N-0750-08A-DH	7.5	64	74	113	36	8
BS202U.208N-0760-08A-DH	7.6	64	74	113	36	8
BS202U.208N-0770-08A-DH	7.7	64	74	113	36	8
BS202U.208N-0780-08A-DH	7.8	64	74	113	36	8
BS202U.208N-0794-08A-DH	7.94	64	74	113	36	8
BS202U.208N-0800-08A-DH	8	64	74	113	36	8
BS202U.208N-0810-10A-DH	8.1	80	92	135	40	10
BS202U.208N-0820-10A-DH	8.2	80	92	135	40	10
BS202U.208N-0830-10A-DH	8.3	80	92	135	40	10
BS202U.208N-0840-10A-DH	8.4	80	92	135	40	10
BS202U.208N-0850-10A-DH	8.5	80	92	135	40	10
BS202U.208N-0860-10A-DH	8.6	80	92	135	40	10
BS202U.208N-0870-10A-DH	8.7	80	92	135	40	10
BS202U.208N-0873-10A-DH	8.73	80	92	135	40	10
BS202U.208N-0880-10A-DH	8.8	80	92	135	40	10
BS202U.208N-0900-10A-DH	9	80	92	135	40	10
BS202U.208N-0910-10A-DH	9.1	80	92	135	40	10
BS202U.208N-0920-10A-DH	9.2	80	92	135	40	10
BS202U.208N-0930-10A-DH	9.3	80	92	135	40	10
BS202U.208N-0940-10A-DH	9.4	80	92	135	40	10
BS202U.208N-0950-10A-DH	9.5	80	92	135	40	10
BS202U.208N-0952-10A-DH	9.52	80	92	135	40	10
BS202U.208N-0960-10A-DH	9.6	80	92	135	40	10
BS202U.208N-0970-10A-DH	9.7	80	92	135	40	10
BS202U.208N-0980-10A-DH	9.8	80	92	135	40	10
BS202U.208N-0990-10A-DH	9.9	80	92	135	40	10
BS202U.208N-0992-10A-DH	9.92	80	92	135	40	10
BS202U.208N-1000-10A-DH	10	80	92	135	40	10
BS202U.208N-1010-12A-DH	10.1	96	110	158	45	12
BS202U.208N-1020-12A-DH	10.2	96	110	158	45	12
BS202U.208N-1030-12A-DH	10.3	96	110	158	45	12
BS202U.208N-1040-12A-DH	10.4	96	110	158	45	12
BS202U.208N-1050-12A-DH	10.5	96	110	158	45	12
BS202U.208N-1080-12A-DH	10.8	96	110	158	45	12
BS202U.208N-1100-12A-DH	11	96	110	158	45	12
BS202U.208N-1110-12A-DH	11.1	96	110	158	45	12
BS202U.208N-1111-12A-DH	11.11	96	110	158	45	12
BS202U.208N-1130-12A-DH	11.3	96	110	158	45	12
BS202U.208N-1150-12A-DH	11.5	96	110	158	45	12
BS202U.208N-1180-12A-DH	11.8	96	110	158	45	12
BS202U.208N-1190-12A-DH	11.9	96	110	158	45	12
BS202U.208N-1200-12A-DH	12	96	110	158	45	12
BS202U.208N-1210-14A-DH	12.1	112	128	176	45	14
BS202U.208N-1220-14A-DH	12.2	112	128	176	45	14
BS202U.208N-1230-14A-DH	12.3	112	128	176	45	14
BS202U.208N-1250-14A-DH	12.5	112	128	176	45	14
BS202U.208N-1270-14A-DH	12.7	112	128	176	45	14
BS202U.208N-1280-14A-DH	12.8	112	128	176	45	14
BS202U.208N-1300-14A-DH	13	112	128	176	45	14
BS202U.208N-1310-14A-DH	13.1	112	128	176	45	14
BS202U.208N-1350-14A-DH	13.5	112	128	176	45	14
BS202U.208N-1380-14A-DH	13.8	112	128	176	45	14
BS202U.208N-1400-14A-DH	14	112	128	176	45	14
BS202U.208N-1600-16A-DH	16	128	146	197	48	16

BS202U.212N – High-Performance Carbide Drill

Key data: HD (high-performance tool) | 12XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
BS202U.212N-0300-04A-DH	3	44	53	93	36	4
BS202U.212N-0400-04A-DH	4	57	68	107	36	4
BS202U.212N-0500-06A-DH	5	72	86	125	36	6
BS202U.212N-0600-06A-DH	6	72	86	125	36	6
BS202U.212N-0635-08A-DH	6.35	84	100	139	36	8
BS202U.212N-0700-08A-DH	7	84	100	139	36	8
BS202U.212N-0800-08A-DH	8	96	114	153	36	8
BS202U.212N-0900-10A-DH	9	120	142	185	40	10
BS202U.212N-1000-10A-DH	10	120	142	185	40	10
BS202U.212N-1100-12A-DH	11	144	170	218	45	12
BS202U.212N-1200-12A-DH	12	144	170	218	45	12
BS202U.208N-1300-14A-DH	13	168	198	246	45	14
BS202U.212N-1400-14A-DH	14	168	198	246	45	14
BS202U.212N-1600-16A-DH	16	192	226	277	48	16

Notes

Notes: ① For requirements outside the catalogue range (special diameters, length-to-diameter ratios, etc.), non-standard custom tools are available.

② For cutting data, refer to the last page of this section of the catalogue.

③ HD: high-performance tool

Cutting Data

Material group			Material	Strength / hardness [N/mm²] [HRC]	Cutting speed Vc [m/min]				Feed fr [mm/rev] by drill diameter (mm)					
					Internal coolant	External coolant	MQL (oil mist)	Air	3	4.5	6.5	9.5	14	16
P	P1	P1.1	Non-alloy structural steel, free-cutting structural steel, case-hardening steel and quenched & tempered steel	<700	150	135	135		0.10	0.13	0.16	0.21	0.27	0.33
		P1.2	Non-alloy structural steel, free-cutting structural steel, case-hardening steel and quenched & tempered steel	<1200	135	115	115		0.13	0.16	0.21	0.27	0.34	0.41
	P2	P2.1	Alloy case-hardening steel, case-hardening steel and quenched & tempered steel	<900	150	130	130		0.12	0.15	0.19	0.25	0.32	0.39
		P2.2	Alloy case-hardening steel, case-hardening steel and quenched & tempered steel	<1400	105	90	90		0.10	0.13	0.16	0.2	0.26	0.31
	P3	P3.1	Tool steel, bearing steel, spring steel and high-speed steel	<900	115	100	100		0.11	0.14	0.17	0.23	0.29	0.35
		P3.2	Tool steel, bearing steel, spring steel and high-speed steel	<1500	90	85	85		0.09	0.12	0.15	0.19	0.24	0.29
	P4	P4.1	Ferritic and martensitic stainless steel		70	55	60		0.07	0.09	0.12	0.15	0.19	0.23
	P5	P5.1	Cast steel		150	130	130		0.12	0.15	0.19	0.25	0.32	0.39
	P6	P6.1	Ferritic and martensitic stainless cast steel		70	55	60		0.07	0.09	0.12	0.15	0.19	0.23
M	M1	M1.1	Austenitic stainless steel	<700	70	50	50		0.06	0.08	0.10	0.14	0.17	0.21
		M1.2	Ferritic/austenitic (duplex) stainless steel	<1000	75	45	45		0.05	0.07	0.09	0.12	0.15	0.18
	M2	M2.1	Austenitic stainless cast steel	<700	80	50	50		0.06	0.08	0.10	0.14	0.17	0.21
	M3	M3.1	Ferritic/austenitic (duplex) stainless cast steel	<1000	75	45	45		0.05	0.07	0.09	0.12	0.15	0.18
K	K1	K1.1	Lamellar graphite cast iron (grey cast iron), GJL	<300	150	105	105	105	0.12	0.17	0.23	0.31	0.41	0.50
	K2	K2.1	Spheroidal graphite (ductile) cast iron, GJS	<500	200	125	150	150	0.13	0.17	0.22	0.29	0.38	0.46
		K2.2	Spheroidal graphite (ductile) cast iron, GJS	500-800	125	95	95		0.11	0.15	0.19	0.25	0.32	0.40
		K2.3	Spheroidal graphite (ductile) cast iron, GJS	>800										
	K3	K3.1	Vermicular graphite (compacted graphite) cast iron, GJV; malleable cast iron, GJM	<500	115	100	100		0.12	0.16	0.21	0.27	0.35	0.43
		K3.2	Vermicular graphite (compacted graphite) cast iron, GJV; malleable cast iron, GJM	>500	100	90	90		0.11	0.13	0.17	0.22	0.28	0.34

- Recommended minimum through-coolant pressure: 20 bar
- When machining with external coolant, reduce the feed per revolution if necessary to ensure smooth chip evacuation

Various non-standard solutions available

Scope of non-standard customization

- Hole tolerance ≥ IT8
- Customized machining solutions for different workpiece materials
- Custom dimensions within the cutting-diameter range D3–D16
- Optimization of drill-point geometry, e.g. cutting-edge preparation and point chamfering

Contact us for customized tooling (“Custom”).

Contact

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

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- Tel: +86-512-63060818
- E-mail: ypp@yp-tec.com
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Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

DD220KB

CGI (Compacted Graphite Iron) Drill



Product line	YPP Drill® – solid carbide drills
Application	Cast irons, especially compacted graphite iron (CGI)

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Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

Technical Features



- Carbide substrate
- Spherical cutting edge: balanced loading at the cutting corner and uniform wear
- Cutting-diameter tolerance: h7

Applications

Dedicated drill for compacted graphite iron | Suppresses abnormal wear at the cutting corner

- Hole-making in cast iron materials; particularly suitable for compacted graphite iron (CGI)
- Non-standard customization service available; internal (through-coolant) machining solution recommended
- Achievable hole tolerance: IT8–9

Ordering Code

DD220KB	2	20	N	0300	04	A
1	2	3	4	5	6	7

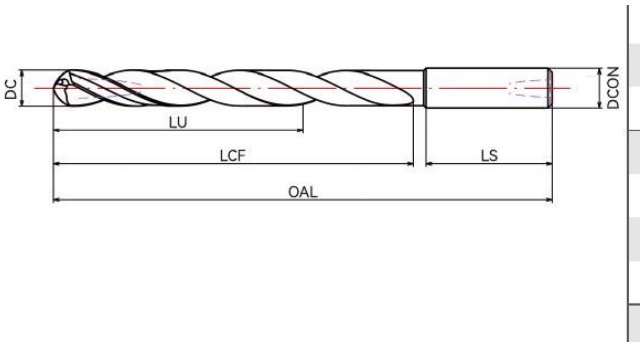
Pos.	Code	Meaning
1	DD220KB	Product series
2	2	Number of cutting edges: 2 = two cutting edges
3	20	Drilling depth: 03 = 3×Dc, 20 = 20×Dc
4	N	Coolant type: W = external coolant, N = internal (through) coolant
5	0300	Cutting diameter: 0300 = D3
6	04	Shank diameter: 04 = D4
7	A	Shank type: A = cylindrical shank

Product Range

DD220KB.216N – CGI (Compacted Graphite Iron) Drill

Key data: SP (special-purpose tool) | 16XD | DIN 6535HA

Material suitability (ISO): P – M – K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)

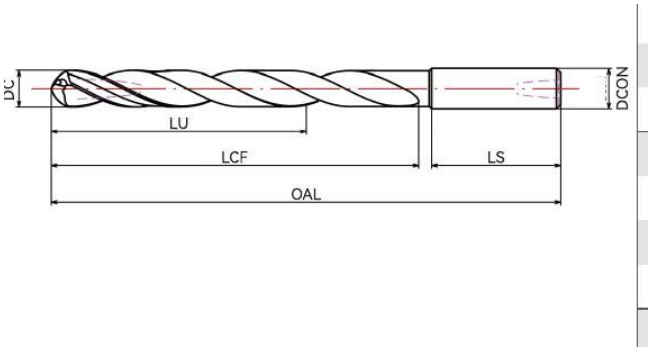


Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DD220KB.216N-0300-04A	3	52	57	89	28	4
DD220KB.216N-0350-04A	3.5	72	78	110	28	4
DD220KB.216N-0400-04A	4	72	78	110	28	4
DD220KB.216N-0450-06A	4.5	92	100	140	36	6
DD220KB.216N-0500-06A	5	92	100	140	36	6
DD220KB.216N-0550-06A	5.5	101	110	150	36	6
DD220KB.216N-0600-06A	6	111	120	160	36	6
DD220KB.216N-0650-08A	6.5	124	135	175	36	8
DD220KB.216N-0700-08A	7	124	135	175	36	8
DD220KB.216N-0750-08A	7.5	140	152	192	36	8
DD220KB.216N-0800-08A	8	140	152	192	36	8
DD220KB.216N-0850-10A	8.5	148	162	206	40	10
DD220KB.216N-0900-10A	9	148	162	206	40	10
DD220KB.216N-0950-10A	9.5	165	180	224	40	10
DD220KB.216N-1000-10A	10	165	180	224	40	10
DD220KB.216N-1050-12A	10.5	181	198	247	45	12
DD220KB.216N-1100-12A	11	181	198	247	45	12
DD220KB.216N-1150-12A	11.5	198	216	265	45	12
DD220KB.216N-1200-12A	12	198	216	265	45	12
DD220KB.216N-1250-14A	12.5	238	252	301	45	14
DD220KB.216N-1300-14A	13	238	252	301	45	14
DD220KB.216N-1350-14A	13.5	238	252	301	45	14
DD220KB.216N-1400-14A	14	238	252	301	45	14
DD220KB.216N-1450-14A	14.5	272	288	340	45	14
DD220KB.216N-1500-16A	15	272	288	340	48	16
DD220KB.216N-1550-16A	15.5	272	288	340	48	16
DD220KB.216N-1600-16A	16	272	288	340	48	16

DD220KB.220N – CGI (Compacted Graphite Iron) Drill

Key data: SP (special-purpose tool) | 16XD | DIN 6535HA

Material suitability (ISO): P – M – K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)

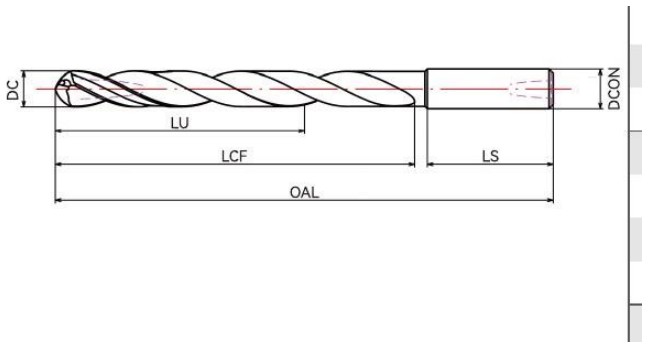


Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DD220KB.220N-0300-04A	3	60	65	97	28	4
DD220KB.220N-0350-04A	3.5	86	92	124	28	4
DD220KB.220N-0400-04A	4	86	92	124	28	4
DD220KB.220N-0450-06A	4.5	110	118	158	36	6
DD220KB.220N-0500-06A	5	110	118	158	36	6
DD220KB.220N-0550-06A	5.5	123	132	170	36	6
DD220KB.220N-0600-06A	6	135	144	182	36	6
DD220KB.220N-0650-08A	6.5	151	162	200	36	8
DD220KB.220N-0700-08A	7	151	162	200	36	8
DD220KB.220N-0750-08A	7.5	172	184	222	36	8
DD220KB.220N-0800-08A	8	172	184	222	36	8
DD220KB.220N-0850-10A	8.5	184	198	240	40	10
DD220KB.220N-0900-10A	9	184	198	240	40	10
DD220KB.220N-0950-10A	9.5	205	220	262	40	10
DD220KB.220N-1000-10A	10	205	220	262	40	10
DD220KB.220N-1050-12A	10.5	225	242	289	45	12
DD220KB.220N-1100-12A	11	225	242	289	45	12
DD220KB.220N-1150-12A	11.5	246	264	311	45	12
DD220KB.220N-1200-12A	12	246	264	311	45	12
DD220KB.220N-1250-14A	12.5	294	308	357	45	14
DD220KB.220N-1300-14A	13	294	308	357	45	14
DD220KB.220N-1350-14A	13.5	294	308	357	45	14
DD220KB.220N-1400-14A	14	294	308	357	45	14
DD220KB.220N-1450-14A	14.5	336	352	404	45	14
DD220KB.220N-1500-16A	15	336	352	404	48	16
DD220KB.220N-1550-16A	15.5	336	352	404	48	16
DD220KB.220N-1600-16A	16	336	352	404	48	16

DD220KB.225N – CGI (Compacted Graphite Iron) Drill

Key data: SP (special-purpose tool) | 16XD | DIN 6535HA

Material suitability (ISO): P – M – K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DD220KB.225N-0300-04A	3	79	84	119	28	4
DD220KB.225N-0350-04A	3.5	108	114	148	28	4
DD220KB.225N-0400-04A	4	108	114	148	28	4
DD220KB.225N-0450-06A	4.5	138	145	185	36	6
DD220KB.225N-0500-06A	5	138	145	185	36	6
DD220KB.225N-0550-06A	5.5	151	160	200	36	6
DD220KB.225N-0600-06A	6	165	174	214	36	6
DD220KB.225N-0650-08A	6.5	183	194	234	36	8
DD220KB.225N-0700-08A	7	183	194	234	36	8
DD220KB.225N-0750-08A	7.5	208	220	260	36	8
DD220KB.225N-0800-08A	8	208	220	260	36	8
DD220KB.225N-0850-10A	8.5	229	243	289	40	10
DD220KB.225N-0900-10A	9	229	243	289	40	10
DD220KB.225N-0950-10A	9.5	257	270	314	40	10
DD220KB.225N-1000-10A	10	257	270	314	40	10
DD220KB.225N-1100-12A	11	280	297	346	45	12
DD220KB.225N-1150-12A	11.5	306	324	373	45	12
DD220KB.225N-1200-12A	12	306	324	373	45	12

Notes

Notes: ① For requirements outside the catalogue range (special diameters, length-to-diameter ratios, etc.), non-standard custom tools are available.

② For cutting data, refer to the last page of this section of the catalogue.

③ SP: special-purpose tool

Cutting Data

- Recommended minimum through-coolant pressure: 20 bar

Material group			Material	Strength / hardness [N/mm²] [HRC]	Cutting speed Vc [m/min]	Feed fr [mm/rev] by drill diameter (mm)					
					Internal coolant	3	4.5	6.5	9.5	14	16
K	K1	K1.1	Grey cast iron, GJL	≤240	210	0.16	0.2	0.28	0.4	0.45	0.5
		K1.2	Grey cast iron, GJL	≤350	160	0.16	0.2	0.28	0.4	0.45	0.5
	K2	K2.1	Spheroidal graphite cast iron, GJS; malleable cast iron, GJMW	≤240	160	0.16	0.2	0.28	0.4	0.45	0.5
		K2.2	Spheroidal graphite cast iron, GJS; malleable cast iron, GJMB	≤350	130	0.12	0.16	0.2	0.3	0.32	0.4
		K2.3	Austempered ductile iron (ADI)		80	0.12	0.16	0.2	0.3	0.32	0.4
		K2.4	Austempered ductile iron (ADI)		60	0.12	0.16	0.2	0.3	0.32	0.4
	K3	K3.1	Vermicular graphite (compacted graphite) cast iron, GJV	≤220	130	0.12	0.16	0.2	0.3	0.32	0.4
		K3.2	Vermicular graphite (compacted graphite) cast iron, GJV	≤300	100	0.12	0.16	0.2	0.3	0.32	0.4

Various non-standard solutions available

Scope of non-standard customization

- All intermediate drill diameters
- All intermediate drilling depths
- Hole tolerance ≥ IT8
- Optimization of cutting-edge preparation, drill point and similar features

Contact us for customized tooling (“Custom”).

Contact

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

- Address: No. 8 Maoyuan Road, Wujiang Economic Development Zone, Suzhou, China
- Tel: +86-512-63060818
- E-mail: ypp@yp-tec.com
- Website: www.yp-tec.com

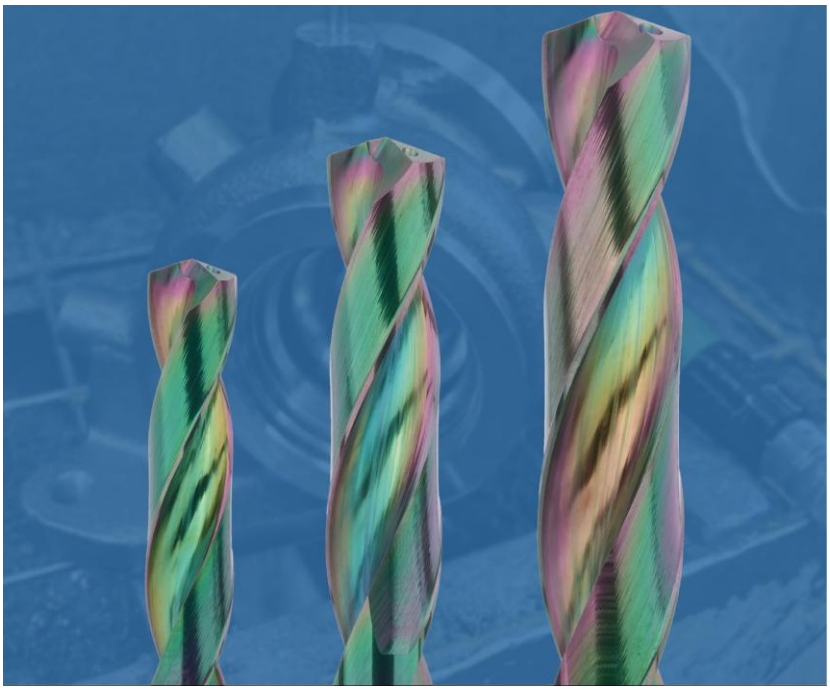
Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

DR212M

Special Drill for Turbine Housings



Product line	YPP Drill® – solid carbide drills
Application	Duplex stainless steel, turbocharger turbine housings

English translation of the Chinese-language brochure published by Suzhou Yongpu Precision Technology Co., Ltd. Product names, model codes, trademarks, numbers and units are reproduced exactly as printed in the original.

Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

Technical Features



- Carbide substrate
- Aurora-coloured composite nano-coating
- Cutting-diameter tolerance: m7

Applications

Dedicated drill for turbocharger housings | Withstands high-temperature machining | Stable and wear-resistant

- Hole-making in duplex stainless steel; particularly suitable for turbocharger housings
- Non-standard customization service available; through-coolant solution recommended
- Achievable hole tolerance: IT8–9

Ordering Code

DR212M	2	03	W	1050	12	A
1	2	3	4	5	6	7

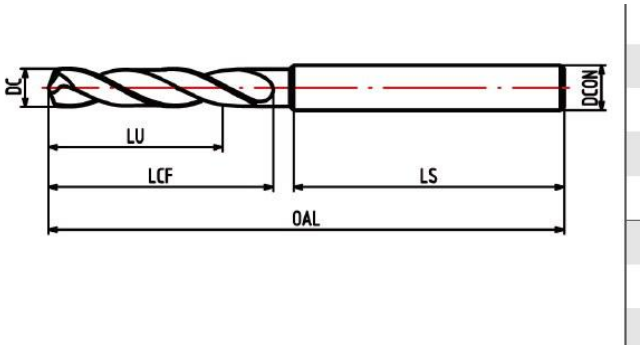
Pos.	Code	Meaning
1	DR212M	Product series
2	2	Number of cutting edges: 2 = two cutting edges
3	03	Drilling depth: 03 = 3×Dc, 05 = 5×Dc
4	W	Coolant type: W = external coolant, N = internal (through) coolant
5	1050	Cutting diameter: 1050 = D10.5
6	12	Shank diameter: 12 = D12
7	A	Shank type: A = cylindrical shank

Product Range

DR212M.203W – Special Drill for Turbine Housings

Key data: SP (special-purpose tool) | m7 | 3XD | DIN 6535HA

Material suitability (ISO): P – M ● K – N – S ● H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)

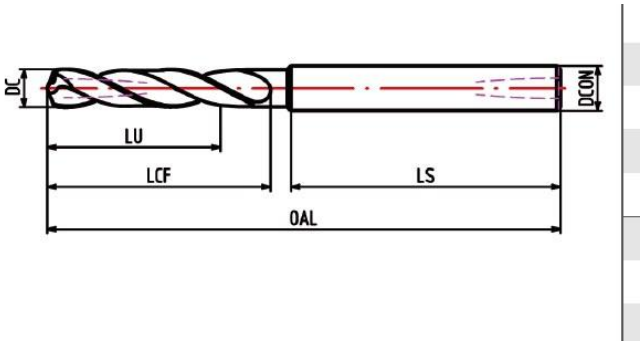


Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DR212M.203W-0300-04A	3	14	20	62	36	4
DR212M.203W-0330-04A	3.3	14	20	62	36	4
DR212M.203W-0350-04A	3.5	14	20	62	36	4
DR212M.203W-0375-04A	3.75	14	20	62	36	4
DR212M.203W-0400-04A	4	17	24	66	36	4
DR212M.203W-0420-06A	4.2	17	24	66	36	6
DR212M.203W-0450-06A	4.5	17	24	66	36	6
DR212M.203W-0500-06A	5	20	28	66	36	6
DR212M.203W-0510-06A	5.1	20	28	66	36	6
DR212M.203W-0550-06A	5.5	20	28	66	36	6
DR212M.203W-0554-06A	5.54	20	28	66	36	6
DR212M.203W-0580-06A	5.8	20	28	66	36	6
DR212M.203W-0600-06A	6	20	28	66	36	6
DR212M.203W-0650-08A	6.5	24	34	79	36	8
DR212M.203W-0675-08A	6.75	24	34	79	36	8
DR212M.203W-0685-08A	6.85	24	34	79	36	8
DR212M.203W-0700-08A	7	24	34	79	36	8
DR212M.203W-0750-08A	7.5	29	41	79	36	8
DR212M.203W-0775-08A	7.75	29	41	79	36	8
DR212M.203W-0780-08A	7.8	29	41	79	36	8
DR212M.203W-0800-08A	8	29	41	79	36	8
DR212M.203W-0820-10A	8.2	35	47	89	40	10
DR212M.203W-0830-10A	8.3	35	47	89	40	10
DR212M.203W-0840-10A	8.4	35	47	89	40	10
DR212M.203W-0850-10A	8.5	35	47	89	40	10
DR212M.203W-0865-10A	8.65	35	47	89	40	10
DR212M.203W-0873-10A	8.73	35	47	89	40	10
DR212M.203W-0880-10A	8.8	35	47	89	40	10
DR212M.203W-0885-10A	8.85	35	47	89	40	10
DR212M.203W-0900-10A	9	35	47	89	40	10
DR212M.203W-0910-10A	9.1	35	47	89	40	10
DR212M.203W-0950-10A	9.5	35	47	89	40	10
DR212M.203W-0980-10A	9.8	35	47	89	40	10
DR212M.203W-1000-10A	10	35	47	89	40	10
DR212M.203W-1025-12A	10.25	40	55	102	45	12
DR212M.203W-1050-12A	10.5	40	55	102	45	12
DR212M.203W-1100-12A	11	40	55	102	45	12
DR212M.203W-1110-12A	11.1	40	55	102	45	12
DR212M.203W-1150-12A	11.5	40	55	102	45	12
DR212M.203W-1200-12A	12	40	55	102	45	12
DR212M.203W-1250-14A	12.5	43	60	107	45	14
DR212M.203W-1300-14A	13	43	60	107	45	14
DR212M.203W-1350-14A	13.5	43	60	107	45	14
DR212M.203W-1400-14A	14	43	60	107	45	14
DR212M.203W-1450-16A	14.5	45	65	115	48	16
DR212M.203W-1500-16A	15	45	65	115	48	16
DR212M.203W-1550-16A	15.5	45	65	115	48	16
DR212M.203W-1600-16A	16	45	65	115	48	16

DR212M.203N – Special Drill for Turbine Housings

Key data: SP (special-purpose tool) | m7 | 3XD | DIN 6535HA

Material suitability (ISO): P – M ● K – N – S ● H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)

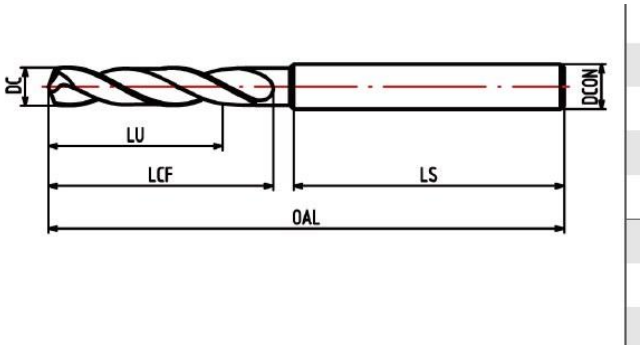


Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DR212M.203N-0300-04A	3	14	20	62	36	4
DR212M.203N-0330-04A	3.3	17	24	66	36	4
DR212M.203N-0350-04A	3.5	17	24	66	36	4
DR212M.203N-0375-04A	3.75	17	24	66	36	4
DR212M.203N-0400-04A	4	17	24	66	36	4
DR212M.203N-0420-06A	4.2	17	24	66	36	6
DR212M.203N-0450-06A	4.5	17	24	66	36	6
DR212M.203N-0500-06A	5	20	28	66	36	6
DR212M.203N-0510-06A	5.1	20	28	66	36	6
DR212M.203N-0550-06A	5.5	20	28	66	36	6
DR212M.203N-0554-06A	5.54	20	28	66	36	6
DR212M.203N-0580-06A	5.8	20	28	66	36	6
DR212M.203N-0600-06A	6	20	28	66	36	6
DR212M.203N-0650-08A	6.5	24	34	79	36	8
DR212M.203N-0675-08A	6.75	24	34	79	36	8
DR212M.203N-0685-08A	6.85	24	34	79	36	8
DR212M.203N-0700-08A	7	24	34	79	36	8
DR212M.203N-0750-08A	7.5	29	41	79	36	8
DR212M.203N-0775-08A	7.75	29	41	79	36	8
DR212M.203N-0780-08A	7.8	29	41	79	36	8
DR212M.203N-0800-08A	8	29	41	79	36	8
DR212M.203N-0820-10A	8.2	35	47	89	40	10
DR212M.203N-0830-10A	8.3	35	47	89	40	10
DR212M.203N-0840-10A	8.4	35	47	89	40	10
DR212M.203N-0850-10A	8.5	35	47	89	40	10
DR212M.203N-0865-10A	8.65	35	47	89	40	10
DR212M.203N-0873-10A	8.73	35	47	89	40	10
DR212M.203N-0880-10A	8.8	35	47	89	40	10
DR212M.203N-0885-10A	8.85	35	47	89	40	10
DR212M.203N-0900-10A	9	35	47	89	40	10
DR212M.203N-0910-10A	9.1	35	47	89	40	10
DR212M.203N-0950-10A	9.5	35	47	89	40	10
DR212M.203N-0980-10A	9.8	35	47	89	40	10
DR212M.203N-1000-10A	10	35	47	89	40	10
DR212M.203N-1025-12A	10.25	40	55	102	45	12
DR212M.203N-1050-12A	10.5	40	55	102	45	12
DR212M.203N-1100-12A	11	40	55	102	45	12
DR212M.203N-1110-12A	11.1	40	55	102	45	12
DR212M.203N-1150-12A	11.5	40	55	102	45	12
DR212M.203N-1200-12A	12	40	55	102	45	12
DR212M.203N-1250-14A	12.5	43	60	107	45	14
DR212M.203N-1300-14A	13	43	60	107	45	14
DR212M.203N-1350-14A	13.5	43	60	107	45	14
DR212M.203N-1400-14A	14	43	60	107	45	14
DR212M.203N-1450-16A	14.5	45	65	115	48	16
DR212M.203N-1500-16A	15	45	65	115	48	16
DR212M.203N-1550-16A	15.5	45	65	115	48	16
DR212M.203N-1600-16A	16	45	65	115	48	16

DR212M.205W – Special Drill for Turbine Housings

Key data: SP (special-purpose tool) | m7 | 5XD | DIN 6535HA

Material suitability (ISO): P – M ● K – N – S ● H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)

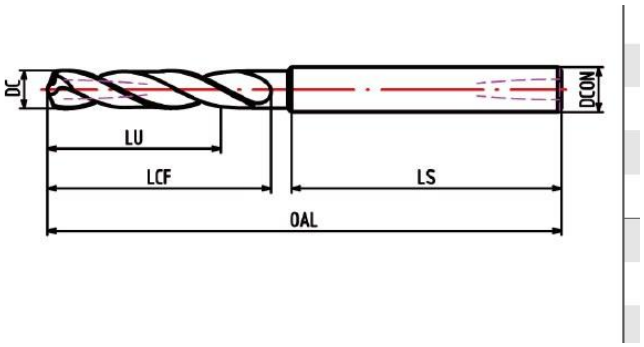


Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DR212M.205W-0300-04A	3	23	28	66	36	4
DR212M.205W-0330-04A	3.3	23	28	66	36	4
DR212M.205W-0350-04A	3.5	23	28	66	36	4
DR212M.205W-0375-04A	3.75	23	28	66	36	4
DR212M.205W-0400-04A	4	29	36	74	36	4
DR212M.205W-0420-06A	4.2	29	36	74	36	6
DR212M.205W-0450-06A	4.5	29	36	74	36	6
DR212M.205W-0500-06A	5	35	44	82	36	6
DR212M.205W-0510-06A	5.1	35	44	82	36	6
DR212M.205W-0550-06A	5.5	35	44	82	36	6
DR212M.205W-0554-06A	5.54	35	44	82	36	6
DR212M.205W-0580-06A	5.8	35	44	82	36	6
DR212M.205W-0600-06A	6	35	44	82	36	6
DR212M.205W-0650-08A	6.5	43	43	91	36	8
DR212M.205W-0675-08A	6.75	43	43	91	36	8
DR212M.205W-0685-08A	6.85	43	43	91	36	8
DR212M.205W-0700-08A	7	43	43	91	36	8
DR212M.205W-0750-08A	7.5	43	43	91	36	8
DR212M.205W-0775-08A	7.75	43	43	91	36	8
DR212M.205W-0780-08A	7.8	43	43	91	36	8
DR212M.205W-0800-08A	8	43	43	91	36	8
DR212M.205W-0820-10A	8.2	49	61	103	40	10
DR212M.205W-0830-10A	8.3	49	61	103	40	10
DR212M.205W-0840-10A	8.4	49	61	103	40	10
DR212M.205W-0850-10A	8.5	49	61	103	40	10
DR212M.205W-0865-10A	8.65	49	61	103	40	10
DR212M.205W-0880-10A	8.8	49	61	103	40	10
DR212M.205W-0885-10A	8.85	49	61	103	40	10
DR212M.205W-0900-10A	9	49	61	103	40	10
DR212M.205W-0910-10A	9.1	49	61	103	40	10
DR212M.205W-0950-10A	9.5	49	61	103	40	10
DR212M.205W-0980-10A	9.8	49	61	103	40	10
DR212M.205W-1000-10A	10	49	61	103	40	10
DR212M.205W-1025-12A	10.25	56	71	118	45	12
DR212M.205W-1050-12A	10.5	56	71	118	45	12
DR212M.205W-1100-12A	11	56	71	118	45	12
DR212M.205W-1110-12A	11.1	56	71	118	45	12
DR212M.205W-1150-12A	11.5	56	71	118	45	12
DR212M.205W-1200-12A	12	56	71	118	45	12
DR212M.205W-1250-14A	12.5	60	77	124	45	14
DR212M.205W-1300-14A	13	60	77	124	45	14
DR212M.205W-1350-14A	13.5	60	77	124	45	14
DR212M.205W-1400-14A	14	60	77	124	45	14
DR212M.205W-1450-16A	14.5	63	83	133	48	16
DR212M.205W-1500-16A	15	63	83	133	48	16
DR212M.205W-1550-16A	15.5	63	83	133	48	16
DR212M.205W-1600-16A	16	63	83	133	48	16

DR212M.205N – Special Drill for Turbine Housings

Key data: SP (special-purpose tool) | m7 | 5XD | DIN 6535HA

Material suitability (ISO): P – M ● K – N – S ● H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DR212M.205N-0300-04A	3	23	28	66	36	4
DR212M.205N-0330-04A	3.3	23	28	66	36	4
DR212M.205N-0350-04A	3.5	23	28	66	36	4
DR212M.205N-0375-04A	3.75	23	28	66	36	4
DR212M.205N-0400-04A	4	29	36	74	36	4
DR212M.205N-0420-06A	4.2	29	36	74	36	6
DR212M.205N-0450-06A	4.5	29	36	74	36	6
DR212M.205N-0500-06A	5	35	44	82	36	6
DR212M.205N-0510-06A	5.1	35	44	82	36	6
DR212M.205N-0550-06A	5.5	35	44	82	36	6
DR212M.205N-0554-06A	5.54	35	44	82	36	6
DR212M.205N-0580-06A	5.8	35	44	82	36	6
DR212M.205N-0600-06A	6	35	44	82	36	6
DR212M.205N-0650-08A	6.5	43	53	91	36	8
DR212M.205N-0675-08A	6.75	43	53	91	36	8
DR212M.205N-0685-08A	6.85	43	53	91	36	8
DR212M.205N-0700-08A	7	43	53	91	36	8
DR212M.205N-0750-08A	7.5	43	53	91	36	8
DR212M.205N-0775-08A	7.75	43	53	91	36	8
DR212M.205N-0780-08A	7.8	43	53	91	36	8
DR212M.205N-0800-08A	8	43	53	91	36	8
DR212M.205N-0820-10A	8.2	49	61	103	40	10
DR212M.205N-0830-10A	8.3	49	61	103	40	10
DR212M.205N-0840-10A	8.4	49	61	103	40	10
DR212M.205N-0850-10A	8.5	49	61	103	40	10
DR212M.205N-0865-10A	8.65	49	61	103	40	10
DR212M.205N-0880-10A	8.8	49	61	103	40	10
DR212M.205N-0885-10A	8.85	49	61	103	40	10
DR212M.205N-0900-10A	9	49	61	103	40	10
DR212M.205N-0910-10A	9.1	49	61	103	40	10
DR212M.205N-0950-10A	9.5	49	61	103	40	10
DR212M.205N-0980-10A	9.8	49	61	103	40	10
DR212M.205N-1000-10A	10	49	61	103	40	10
DR212M.205N-1025-12A	10.25	56	71	118	45	12
DR212M.205N-1050-12A	10.5	56	71	118	45	12
DR212M.205N-1100-12A	11	56	71	118	45	12
DR212M.205N-1110-12A	11.1	56	71	118	45	12
DR212M.205N-1150-12A	11.5	56	71	118	45	12
DR212M.205N-1200-12A	12	56	71	118	45	12
DR212M.205N-1250-14A	12.5	60	77	124	45	14
DR212M.205N-1300-14A	13	60	77	124	45	14
DR212M.205N-1350-14A	13.5	60	77	124	45	14
DR212M.205N-1400-14A	14	60	77	124	45	14
DR212M.205N-1450-16A	14.5	63	83	133	48	16
DR212M.205N-1500-16A	15	63	83	133	48	16
DR212M.205N-1550-16A	15.5	63	83	133	48	16
DR212M.205N-1600-16A	16	63	83	133	48	16

Notes

Notes: ① For requirements outside the catalogue range (special diameters, length-to-diameter ratios, etc.), non-standard custom tools are available.

② For cutting data, refer to the last page of this section of the catalogue.

③ SP: special-purpose tool

Cutting Data

Material group			Material	Strength / hardness [N/mm²] [HRC]	Cutting speed Vc [m/min]				Feed fr [mm/rev] by drill diameter (mm)					
					Internal coolant	External coolant	MQL (oil mist)	Air	3	4.5	6.5	9.5	14	16
M	M1	M1.1	Austenitic stainless steel	<700	60	50	50		0.06	0.08	0.10	0.14	0.17	0.21
		M1.2	Ferritic/austenitic (duplex) stainless steel	<1000	75	45	45		0.05	0.07	0.09	0.12	0.15	0.18
	M2	M2.1	Austenitic stainless cast steel	<700	80	50	50		0.06	0.08	0.10	0.14	0.17	0.21
	M3	M3.1	Ferritic/austenitic (duplex) stainless cast steel	<1000	75	45	45		0.05	0.07	0.09	0.12	0.15	0.18
S	S1	S1.1	Titanium, titanium alloys	<400	40	25			0.06	0.08	0.1	0.14	0.17	0.21
	S2	S2.1	Titanium, titanium alloys	<1200	30	20			0.05	0.07	0.09	0.12	0.15	0.18
		S2.2	Titanium, titanium alloys	>1200	25	15			0.05	0.06	0.07	0.1	0.12	0.15
	S3	S3.1	Non-alloy and alloy nickel	<900	20	15			0.04	0.05	0.06	0.08	0.1	0.12
		S3.2	Non-alloy and alloy nickel	>900	15	10			0.05	0.06	0.07	0.1	0.12	0.15
	S4	S4.1	Nickel-, cobalt*- and iron-based heat-resistant superalloys		15	10			0.04	0.05	0.06	0.08	0.1	0.12
		S4.2	Tungsten alloys and aluminium alloys		15	10			0.04	0.05	0.06	0.08	0.1	0.12

- Recommended minimum through-coolant pressure: 20 bar
- When machining with external coolant, reduce the feed per revolution if necessary to ensure smooth chip evacuation

Various non-standard solutions available

Scope of non-standard customization

- All intermediate drill diameters
- All intermediate drilling depths
- Point angle 120°–150°
- Hole tolerance ≥ IT8
- Optimization of drill-point geometry, e.g. cutting-edge preparation and point chamfering

Contact us for customized tooling (“Custom”).

Contact

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

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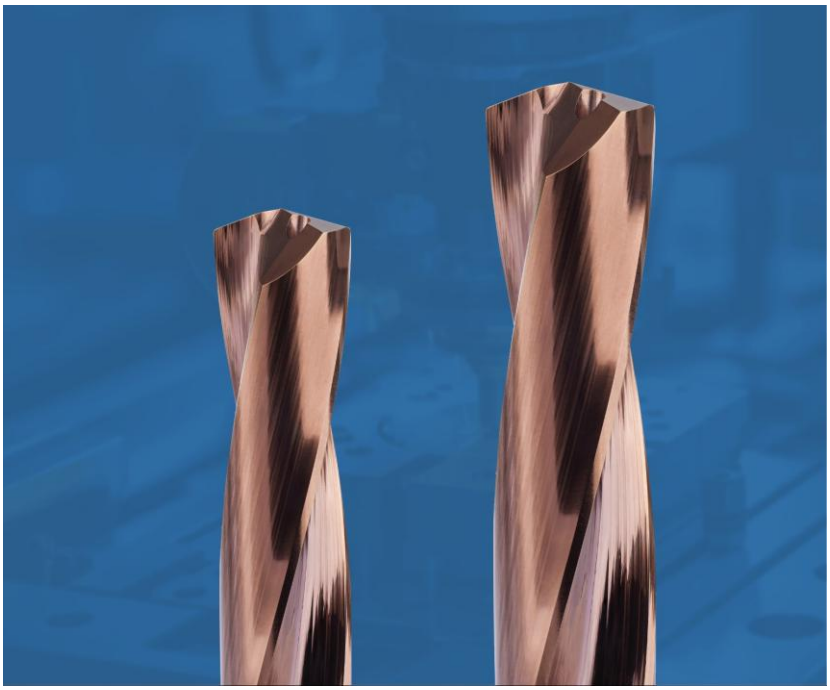
Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

DS50H

HRC50 High-Hardness Carbide Drill



Product line	YPP Drill® – solid carbide drills
Application	Hardened materials HRC35–50
Drilling depth	3×Dc, 5×Dc

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Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

Technical Features



- Low helix angle design
- Cross-shaped drill point
- Crescent-shaped cutting edge
- Protective corner radius at the cutting corner
- Substrate microstructure shown schematically

Applications

High-efficiency hole-making in hardened materials (HRC35–50)

- Cutting-diameter tolerance: m7
- Helix angle: 12–16°
- Drilling depth: 3×Dc, 5×Dc
- Achievable hole tolerance: IT8–9
- Carbide substrate
- Bronze-coloured composite nano-coating

Ordering Code

DS50H	2	03	W	0800	08	A	DH
1	2	3	4	5	6	7	8

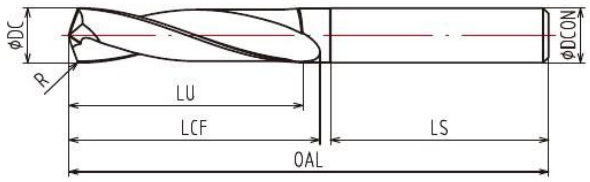
Pos.	Code	Meaning
1	DS50H	Product series
2	2	Number of cutting edges: 2 = two cutting edges
3	03	Drilling depth: 03 = 3×Dc, 05 = 5×Dc
4	W	Coolant type: W = external coolant, N = internal (through) coolant
5	0800	Cutting diameter: 0800 = Φ8.00
6	08	Shank diameter: 08 = Φ8
7	A	Shank type: A = cylindrical shank
8	DH	Coating: DH = DH coating

Product Range

DS50H.203W – HRC50 High-Hardness Carbide Drill

Key data: SP (special-purpose tool) | m7 | 3XD | DIN 6535HA

Material suitability (ISO): P – M – K – N – S – H ● C – (● first choice ○ suitable □ limited suitability; – = not recommended)



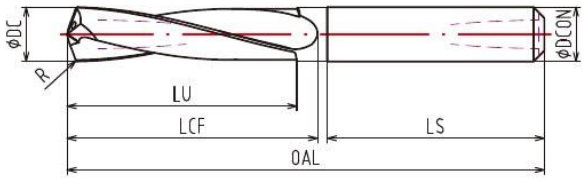
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DS50H.203W-0300-04A-DH	3	14	20	62	40	4
DS50H.203W-0310-04A-DH	3.1	14	20	62	40	4
DS50H.203W-0320-04A-DH	3.2	14	20	62	40	4
DS50H.203W-0330-04A-DH	3.3	14	20	62	40	4
DS50H.203W-0340-04A-DH	3.4	14	20	62	40	4
DS50H.203W-0350-04A-DH	3.5	14	20	62	40	4
DS50H.203W-0360-04A-DH	3.6	14	20	62	40	4
DS50H.203W-0370-04A-DH	3.7	14	20	62	40	4
DS50H.203W-0380-04A-DH	3.8	17	24	66	40	4
DS50H.203W-0390-04A-DH	3.9	17	24	66	40	4
DS50H.203W-0400-04A-DH	4	17	24	66	40	4
DS50H.203W-0410-06A-DH	4.1	17	24	66	40	6
DS50H.203W-0420-06A-DH	4.2	17	24	66	40	6
DS50H.203W-0430-06A-DH	4.3	17	24	66	40	6
DS50H.203W-0440-06A-DH	4.4	17	24	66	40	6
DS50H.203W-0450-06A-DH	4.5	17	24	66	40	6
DS50H.203W-0460-06A-DH	4.6	17	24	66	40	6
DS50H.203W-0470-06A-DH	4.7	20	28	66	36	6
DS50H.203W-0480-06A-DH	4.8	20	28	66	36	6
DS50H.203W-0490-06A-DH	4.9	20	28	66	36	6
DS50H.203W-0500-06A-DH	5	20	28	66	36	6
DS50H.203W-0510-06A-DH	5.1	20	28	66	36	6
DS50H.203W-0520-06A-DH	5.2	20	28	66	36	6
DS50H.203W-0530-06A-DH	5.3	20	28	66	36	6
DS50H.203W-0540-06A-DH	5.4	20	28	66	36	6
DS50H.203W-0550-06A-DH	5.5	20	28	66	36	6
DS50H.203W-0560-06A-DH	5.6	20	28	66	36	6
DS50H.203W-0570-06A-DH	5.7	20	28	66	36	6
DS50H.203W-0580-06A-DH	5.8	20	28	66	36	6
DS50H.203W-0590-06A-DH	5.9	20	28	66	36	6
DS50H.203W-0600-06A-DH	6	20	28	66	36	6
DS50H.203W-0610-08A-DH	6.1	24	34	79	40	8
DS50H.203W-0620-08A-DH	6.2	24	34	79	40	8
DS50H.203W-0630-08A-DH	6.3	24	34	79	40	8
DS50H.203W-0640-08A-DH	6.4	24	34	79	40	8
DS50H.203W-0650-08A-DH	6.5	24	34	79	40	8
DS50H.203W-0660-08A-DH	6.6	24	34	79	40	8
DS50H.203W-0670-08A-DH	6.7	24	34	79	40	8
DS50H.203W-0680-08A-DH	6.8	24	34	79	40	8
DS50H.203W-0690-08A-DH	6.9	24	34	79	40	8
DS50H.203W-0700-08A-DH	7	24	34	79	40	8
DS50H.203W-0710-08A-DH	7.1	29	41	79	36	8
DS50H.203W-0720-08A-DH	7.2	29	41	79	36	8
DS50H.203W-0730-08A-DH	7.3	29	41	79	36	8
DS50H.203W-0740-08A-DH	7.4	29	41	79	36	8
DS50H.203W-0750-08A-DH	7.5	29	41	79	36	8
DS50H.203W-0760-08A-DH	7.6	29	41	79	36	8
DS50H.203W-0770-08A-DH	7.7	29	41	79	36	8
DS50H.203W-0780-08A-DH	7.8	29	41	79	36	8

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DS50H.203W-0790-08A-DH	7.9	29	41	79	36	8
DS50H.203W-0800-08A-DH	8	29	41	79	36	8
DS50H.203W-0810-10A-DH	8.1	35	47	89	40	10
DS50H.203W-0820-10A-DH	8.2	35	47	89	40	10
DS50H.203W-0830-10A-DH	8.3	35	47	89	40	10
DS50H.203W-0840-10A-DH	8.4	35	47	89	40	10
DS50H.203W-0850-10A-DH	8.5	35	47	89	40	10
DS50H.203W-0860-10A-DH	8.6	35	47	89	40	10
DS50H.203W-0870-10A-DH	8.7	35	47	89	40	10
DS50H.203W-0880-10A-DH	8.8	35	47	89	40	10
DS50H.203W-0890-10A-DH	8.9	35	47	89	40	10
DS50H.203W-0900-10A-DH	9	35	47	89	40	10
DS50H.203W-0910-10A-DH	9.1	35	47	89	40	10
DS50H.203W-0920-10A-DH	9.2	35	47	89	40	10
DS50H.203W-0930-10A-DH	9.3	35	47	89	40	10
DS50H.203W-0940-10A-DH	9.4	35	47	89	40	10
DS50H.203W-0950-10A-DH	9.5	35	47	89	40	10
DS50H.203W-0960-10A-DH	9.6	35	47	89	40	10
DS50H.203W-0970-10A-DH	9.7	35	47	89	40	10
DS50H.203W-0980-10A-DH	9.8	35	47	89	40	10
DS50H.203W-0990-10A-DH	9.9	35	47	89	40	10
DS50H.203W-1000-10A-DH	10	35	47	89	40	10
DS50H.203W-1010-12A-DH	10.1	40	55	102	45	12
DS50H.203W-1020-12A-DH	10.2	40	55	102	45	12
DS50H.203W-1030-12A-DH	10.3	40	55	102	45	12
DS50H.203W-1040-12A-DH	10.4	40	55	102	45	12
DS50H.203W-1050-12A-DH	10.5	40	55	102	45	12
DS50H.203W-1060-12A-DH	10.6	40	55	102	45	12
DS50H.203W-1070-12A-DH	10.7	40	55	102	45	12
DS50H.203W-1080-12A-DH	10.8	40	55	102	45	12
DS50H.203W-1090-12A-DH	10.9	40	55	102	45	12
DS50H.203W-1100-12A-DH	11	40	55	102	45	12
DS50H.203W-1110-12A-DH	11.1	40	55	102	45	12
DS50H.203W-1120-12A-DH	11.2	40	55	102	45	12
DS50H.203W-1130-12A-DH	11.3	40	55	102	45	12
DS50H.203W-1140-12A-DH	11.4	40	55	102	45	12
DS50H.203W-1150-12A-DH	11.5	40	55	102	45	12
DS50H.203W-1160-12A-DH	11.6	40	55	102	45	12
DS50H.203W-1170-12A-DH	11.7	40	55	102	45	12
DS50H.203W-1180-12A-DH	11.8	40	55	102	45	12
DS50H.203W-1190-12A-DH	11.9	40	55	102	45	12
DS50H.203W-1200-12A-DH	12	40	55	102	45	12
DS50H.203W-1250-14A-DH	12.5	43	60	107	45	14
DS50H.203W-1300-14A-DH	13	43	60	107	45	14
DS50H.203W-1350-14A-DH	13.5	43	60	107	45	14
DS50H.203W-1400-14A-DH	14	43	60	107	45	14
DS50H.203W-1450-16A-DH	14.5	45	65	115	48	16
DS50H.203W-1500-16A-DH	15	45	65	115	48	16
DS50H.203W-1600-16A-DH	16	45	65	115	48	16

DS50H.203N – HRC50 High-Hardness Carbide Drill

Key data: SP (special-purpose tool) | m7 | 3XD | DIN 6535HA

Material suitability (ISO): P – M – K – N – S – H ● C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)

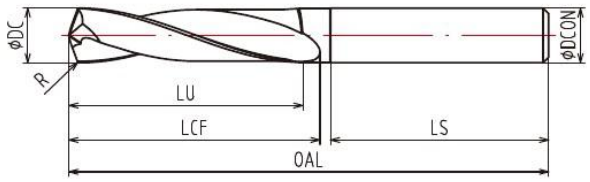
	DC	LU	LCF	OAL	LS	DCON
DS50H.203N-0300-04A-DH	3	14	20	62	40	4
DS50H.203N-0310-04A-DH	3.1	14	20	62	40	4
DS50H.203N-0320-04A-DH	3.2	14	20	62	40	4
DS50H.203N-0330-04A-DH	3.3	14	20	62	40	4
DS50H.203N-0340-04A-DH	3.4	14	20	62	40	4
DS50H.203N-0350-04A-DH	3.5	14	20	62	40	4
DS50H.203N-0360-04A-DH	3.6	14	20	62	40	4
DS50H.203N-0370-04A-DH	3.7	14	20	62	40	4
DS50H.203N-0380-04A-DH	3.8	17	24	66	40	4
DS50H.203N-0390-04A-DH	3.9	17	24	66	40	4
DS50H.203N-0400-04A-DH	4	17	24	66	40	4
DS50H.203N-0410-06A-DH	4.1	17	24	66	40	6
DS50H.203N-0420-06A-DH	4.2	17	24	66	40	6
DS50H.203N-0430-06A-DH	4.3	17	24	66	40	6
DS50H.203N-0440-06A-DH	4.4	17	24	66	40	6
DS50H.203N-0450-06A-DH	4.5	17	24	66	40	6
DS50H.203N-0460-06A-DH	4.6	17	24	66	40	6
DS50H.203N-0470-06A-DH	4.7	20	28	66	36	6
DS50H.203N-0480-06A-DH	4.8	20	28	66	36	6
DS50H.203N-0490-06A-DH	4.9	20	28	66	36	6
DS50H.203N-0500-06A-DH	5	20	28	66	36	6
DS50H.203N-0510-06A-DH	5.1	20	28	66	36	6
DS50H.203N-0520-06A-DH	5.2	20	28	66	36	6
DS50H.203N-0530-06A-DH	5.3	20	28	66	36	6
DS50H.203N-0540-06A-DH	5.4	20	28	66	36	6
DS50H.203N-0550-06A-DH	5.5	20	28	66	36	6
DS50H.203N-0560-06A-DH	5.6	20	28	66	36	6
DS50H.203N-0570-06A-DH	5.7	20	28	66	36	6
DS50H.203N-0580-06A-DH	5.8	20	28	66	36	6
DS50H.203N-0590-06A-DH	5.9	20	28	66	36	6
DS50H.203N-0600-06A-DH	6	20	28	66	36	6
DS50H.203N-0610-08A-DH	6.1	24	34	79	40	8
DS50H.203N-0620-08A-DH	6.2	24	34	79	40	8
DS50H.203N-0630-08A-DH	6.3	24	34	79	40	8
DS50H.203N-0640-08A-DH	6.4	24	34	79	40	8
DS50H.203N-0650-08A-DH	6.5	24	34	79	40	8
DS50H.203N-0660-08A-DH	6.6	24	34	79	40	8
DS50H.203N-0670-08A-DH	6.7	24	34	79	40	8
DS50H.203N-0680-08A-DH	6.8	24	34	79	40	8
DS50H.203N-0690-08A-DH	6.9	24	34	79	40	8
DS50H.203N-0700-08A-DH	7	24	34	79	40	8
DS50H.203N-0710-08A-DH	7.1	29	41	79	36	8
DS50H.203N-0720-08A-DH	7.2	29	41	79	36	8
DS50H.203N-0730-08A-DH	7.3	29	41	79	36	8
DS50H.203N-0740-08A-DH	7.4	29	41	79	36	8
DS50H.203N-0750-08A-DH	7.5	29	41	79	36	8
DS50H.203N-0760-08A-DH	7.6	29	41	79	36	8
DS50H.203N-0770-08A-DH	7.7	29	41	79	36	8
DS50H.203N-0780-08A-DH	7.8	29	41	79	36	8
DS50H.203N-0790-08A-DH	7.9	29	41	79	36	8
DS50H.203N-0800-08A-DH	8	29	41	79	36	8
DS50H.203N-0810-10A-DH	8.1	35	47	89	40	10
DS50H.203N-0820-10A-DH	8.2	35	47	89	40	10
DS50H.203N-0830-10A-DH	8.3	35	47	89	40	10
DS50H.203N-0840-10A-DH	8.4	35	47	89	40	10
DS50H.203N-0850-10A-DH	8.5	35	47	89	40	10
DS50H.203N-0860-10A-DH	8.6	35	47	89	40	10
DS50H.203N-0870-10A-DH	8.7	35	47	89	40	10
DS50H.203N-0880-10A-DH	8.8	35	47	89	40	10
DS50H.203N-0890-10A-DH	8.9	35	47	89	40	10
DS50H.203N-0900-10A-DH	9	35	47	89	40	10
DS50H.203N-0910-10A-DH	9.1	35	47	89	40	10
DS50H.203N-0920-10A-DH	9.2	35	47	89	40	10
DS50H.203N-0930-10A-DH	9.3	35	47	89	40	10
DS50H.203N-0940-10A-DH	9.4	35	47	89	40	10
DS50H.203N-0950-10A-DH	9.5	35	47	89	40	10
DS50H.203N-0960-10A-DH	9.6	35	47	89	40	10
DS50H.203N-0970-10A-DH	9.7	35	47	89	40	10
DS50H.203N-0980-10A-DH	9.8	35	47	89	40	10
DS50H.203N-0990-10A-DH	9.9	35	47	89	40	10
DS50H.203N-1000-10A-DH	10	35	47	89	40	10
DS50H.203N-1010-12A-DH	10.1	40	55	102	45	12
DS50H.203N-1020-12A-DH	10.2	40	55	102	45	12

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DS50H.203N-1030-12A-DH	10.3	40	55	102	45	12
DS50H.203N-1040-12A-DH	10.4	40	55	102	45	12
DS50H.203N-1050-12A-DH	10.5	40	55	102	45	12
DS50H.203N-1060-12A-DH	10.6	40	55	102	45	12
DS50H.203N-1070-12A-DH	10.7	40	55	102	45	12
DS50H.203N-1080-12A-DH	10.8	40	55	102	45	12
DS50H.203N-1090-12A-DH	10.9	40	55	102	45	12
DS50H.203N-1100-12A-DH	11	40	55	102	45	12
DS50H.203N-1110-12A-DH	11.1	40	55	102	45	12
DS50H.203N-1120-12A-DH	11.2	40	55	102	45	12
DS50H.203N-1130-12A-DH	11.3	40	55	102	45	12
DS50H.203N-1140-12A-DH	11.4	40	55	102	45	12
DS50H.203N-1150-12A-DH	11.5	40	55	102	45	12
DS50H.203N-1160-12A-DH	11.6	40	55	102	45	12
DS50H.203N-1170-12A-DH	11.7	40	55	102	45	12
DS50H.203N-1180-12A-DH	11.8	40	55	102	45	12
DS50H.203N-1190-12A-DH	11.9	40	55	102	45	12
DS50H.203N-1200-12A-DH	12	40	55	102	45	12
DS50H.203N-1250-14A-DH	12.5	43	60	107	45	14
DS50H.203N-1300-14A-DH	13	43	60	107	45	14
DS50H.203N-1350-14A-DH	13.5	43	60	107	45	14
DS50H.203N-1400-14A-DH	14	43	60	107	45	14
DS50H.203N-1450-16A-DH	14.5	45	65	115	48	16
DS50H.203N-1500-16A-DH	15	45	65	115	48	16
DS50H.203N-1600-16A-DH	16	45	65	115	48	16

DS50H.205W – HRC50 High-Hardness Carbide Drill

Key data: SP (special-purpose tool) | m7 | 5XD | DIN 6535HA

Material suitability (ISO): P – M – K – N – S – H ● C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DS50H.205W-0300-04A-DH	3	23	28	66	36	4
DS50H.205W-0310-04A-DH	3.1	23	28	66	36	4
DS50H.205W-0320-04A-DH	3.2	23	28	66	36	4
DS50H.205W-0330-04A-DH	3.3	23	28	66	36	4
DS50H.205W-0340-04A-DH	3.4	23	28	66	36	4
DS50H.205W-0350-04A-DH	3.5	23	28	66	36	4
DS50H.205W-0360-04A-DH	3.6	23	28	66	36	4
DS50H.205W-0370-04A-DH	3.7	23	28	66	36	4
DS50H.205W-0380-04A-DH	3.8	23	28	66	36	4
DS50H.205W-0390-04A-DH	3.9	29	36	74	36	4
DS50H.205W-0400-04A-DH	4	29	36	74	36	4
DS50H.205W-0410-06A-DH	4.1	29	36	74	36	6
DS50H.205W-0420-06A-DH	4.2	29	36	74	36	6
DS50H.205W-0430-06A-DH	4.3	29	36	74	36	6
DS50H.205W-0440-06A-DH	4.4	29	36	74	36	6
DS50H.205W-0450-06A-DH	4.5	29	36	74	36	6
DS50H.205W-0460-06A-DH	4.6	29	36	74	36	6
DS50H.205W-0470-06A-DH	4.7	29	36	74	36	6
DS50H.205W-0480-06A-DH	4.8	35	44	82	36	6
DS50H.205W-0490-06A-DH	4.9	35	44	82	36	6
DS50H.205W-0500-06A-DH	5	35	44	82	36	6
DS50H.205W-0510-06A-DH	5.1	35	44	82	36	6
DS50H.205W-0520-06A-DH	5.2	35	44	82	36	6

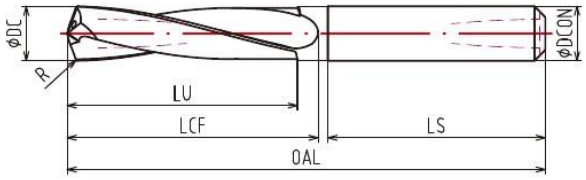
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DS50H.205W-0530-06A-DH	5.3	35	44	82	36	6
DS50H.205W-0540-06A-DH	5.4	35	44	82	36	6
DS50H.205W-0550-06A-DH	5.5	35	44	82	36	6
DS50H.205W-0560-06A-DH	5.6	35	44	82	36	6
DS50H.205W-0570-06A-DH	5.7	35	44	82	36	6
DS50H.205W-0580-06A-DH	5.8	35	44	82	36	6
DS50H.205W-0590-06A-DH	5.9	35	44	82	36	6
DS50H.205W-0600-06A-DH	6	35	44	82	36	6
DS50H.205W-0610-08A-DH	6.1	43	53	91	36	8
DS50H.205W-0620-08A-DH	6.2	43	53	91	36	8
DS50H.205W-0630-08A-DH	6.3	43	53	91	36	8
DS50H.205W-0640-08A-DH	6.4	43	53	91	36	8
DS50H.205W-0650-08A-DH	6.5	43	53	91	36	8
DS50H.205W-0660-08A-DH	6.6	43	53	91	36	8
DS50H.205W-0670-08A-DH	6.7	43	53	91	36	8
DS50H.205W-0680-08A-DH	6.8	43	53	91	36	8
DS50H.205W-0690-08A-DH	6.9	43	53	91	36	8
DS50H.205W-0700-08A-DH	7	43	53	91	36	8
DS50H.205W-0710-08A-DH	7.1	43	53	91	36	8
DS50H.205W-0720-08A-DH	7.2	43	53	91	36	8
DS50H.205W-0730-08A-DH	7.3	43	53	91	36	8
DS50H.205W-0740-08A-DH	7.4	43	53	91	36	8
DS50H.205W-0750-08A-DH	7.5	43	53	91	36	8
DS50H.205W-0760-08A-DH	7.6	43	53	91	36	8
DS50H.205W-0770-08A-DH	7.7	43	53	91	36	8
DS50H.205W-0780-08A-DH	7.8	43	53	91	36	8
DS50H.205W-0790-08A-DH	7.9	43	53	91	36	8
DS50H.205W-0800-08A-DH	8	43	53	91	36	8
DS50H.205W-0810-10A-DH	8.1	49	61	103	40	10
DS50H.205W-0820-10A-DH	8.2	49	61	103	40	10
DS50H.205W-0830-10A-DH	8.3	49	61	103	40	10
DS50H.205W-0840-10A-DH	8.4	49	61	103	40	10
DS50H.205W-0850-10A-DH	8.5	49	61	103	40	10
DS50H.205W-0860-10A-DH	8.6	49	61	103	40	10
DS50H.205W-0870-10A-DH	8.7	49	61	103	40	10
DS50H.205W-0880-10A-DH	8.8	49	61	103	40	10
DS50H.205W-0890-10A-DH	8.9	49	61	103	40	10
DS50H.205W-0900-10A-DH	9	49	61	103	40	10
DS50H.205W-0910-10A-DH	9.1	49	61	103	40	10
DS50H.205W-0920-10A-DH	9.2	49	61	103	40	10
DS50H.205W-0930-10A-DH	9.3	49	61	103	40	10
DS50H.205W-0940-10A-DH	9.4	49	61	103	40	10
DS50H.205W-0950-10A-DH	9.5	49	61	103	40	10
DS50H.205W-0960-10A-DH	9.6	49	61	103	40	10
DS50H.205W-0970-10A-DH	9.7	49	61	103	40	10
DS50H.205W-0980-10A-DH	9.8	49	61	103	40	10
DS50H.205W-0990-10A-DH	9.9	49	61	103	40	10
DS50H.205W-1000-10A-DH	10	49	61	103	40	10
DS50H.205W-1010-12A-DH	10.1	56	71	118	45	12
DS50H.205W-1020-12A-DH	10.2	56	71	118	45	12
DS50H.205W-1030-12A-DH	10.3	56	71	118	45	12
DS50H.205W-1040-12A-DH	10.4	56	71	118	45	12
DS50H.205W-1050-12A-DH	10.5	56	71	118	45	12
DS50H.205W-1060-12A-DH	10.6	56	71	118	45	12
DS50H.205W-1070-12A-DH	10.7	56	71	118	45	12
DS50H.205W-1080-12A-DH	10.8	56	71	118	45	12
DS50H.205W-1090-12A-DH	10.9	56	71	118	45	12
DS50H.205W-1100-12A-DH	11	56	71	118	45	12
DS50H.205W-1110-12A-DH	11.1	56	71	118	45	12
DS50H.205W-1120-12A-DH	11.2	56	71	118	45	12
DS50H.205W-1130-12A-DH	11.3	56	71	118	45	12
DS50H.205W-1140-12A-DH	11.4	56	71	118	45	12
DS50H.205W-1150-12A-DH	11.5	56	71	118	45	12
DS50H.205W-1160-12A-DH	11.6	56	71	118	45	12
DS50H.205W-1170-12A-DH	11.7	56	71	118	45	12
DS50H.205W-1180-12A-DH	11.8	56	71	118	45	12
DS50H.205W-1190-12A-DH	11.9	56	71	118	45	12
DS50H.205W-1200-12A-DH	12	56	71	118	45	12
DS50H.205W-1250-14A-DH	12.5	60	77	124	45	14
DS50H.205W-1300-14A-DH	13	60	77	124	45	14
DS50H.205W-1350-14A-DH	13.5	60	77	124	45	14
DS50H.205W-1400-14A-DH	14	60	77	124	45	14

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DS50H.205W-1450-16A-DH	14.5	63	83	133	48	16
DS50H.205W-1500-16A-DH	15	63	83	133	48	16
DS50H.205W-1600-16A-DH	16	63	83	133	48	16

DS50H.205N – HRC50 High-Hardness Carbide Drill

Key data: SP (special-purpose tool) | m7 | 5XD | DIN 6535HA

Material suitability (ISO): P – M – K – N – S – H ● C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DS50H.205N-0300-04A-DH	3	23	28	66	36	4
DS50H.205N-0310-04A-DH	3.1	23	28	66	36	4
DS50H.205N-0320-04A-DH	3.2	23	28	66	36	4
DS50H.205N-0330-04A-DH	3.3	23	28	66	36	4
DS50H.205N-0340-04A-DH	3.4	23	28	66	36	4
DS50H.205N-0350-04A-DH	3.5	23	28	66	36	4
DS50H.205N-0360-04A-DH	3.6	23	28	66	36	4
DS50H.205N-0370-04A-DH	3.7	23	28	66	36	4
DS50H.205N-0380-04A-DH	3.8	23	28	66	36	4
DS50H.205N-0390-04A-DH	3.9	29	36	74	36	4
DS50H.205N-0400-04A-DH	4	29	36	74	36	4
DS50H.205N-0410-06A-DH	4.1	29	36	74	36	6
DS50H.205N-0420-06A-DH	4.2	29	36	74	36	6
DS50H.205N-0430-06A-DH	4.3	29	36	74	36	6
DS50H.205N-0440-06A-DH	4.4	29	36	74	36	6
DS50H.205N-0450-06A-DH	4.5	29	36	74	36	6
DS50H.205N-0460-06A-DH	4.6	29	36	74	36	6
DS50H.205N-0470-06A-DH	4.7	29	36	74	36	6
DS50H.205N-0480-06A-DH	4.8	35	44	82	36	6
DS50H.205N-0490-06A-DH	4.9	35	44	82	36	6
DS50H.205N-0500-06A-DH	5	35	44	82	36	6
DS50H.205N-0510-06A-DH	5.1	35	44	82	36	6
DS50H.205N-0520-06A-DH	5.2	35	44	82	36	6
DS50H.205N-0530-06A-DH	5.3	35	44	82	36	6
DS50H.205N-0540-06A-DH	5.4	35	44	82	36	6
DS50H.205N-0550-06A-DH	5.5	35	44	82	36	6
DS50H.205N-0560-06A-DH	5.6	35	44	82	36	6
DS50H.205N-0570-06A-DH	5.7	35	44	82	36	6
DS50H.205N-0580-06A-DH	5.8	35	44	82	36	6
DS50H.205N-0590-06A-DH	5.9	35	44	82	36	6
DS50H.205N-0600-06A-DH	6	35	44	82	36	6
DS50H.205N-0610-08A-DH	6.1	43	53	91	36	8
DS50H.205N-0620-08A-DH	6.2	43	53	91	36	8
DS50H.205N-0630-08A-DH	6.3	43	53	91	36	8
DS50H.205N-0640-08A-DH	6.4	43	53	91	36	8
DS50H.205N-0650-08A-DH	6.5	43	53	91	36	8
DS50H.205N-0660-08A-DH	6.6	43	53	91	36	8
DS50H.205N-0670-08A-DH	6.7	43	53	91	36	8
DS50H.205N-0680-08A-DH	6.8	43	53	91	36	8
DS50H.205N-0690-08A-DH	6.9	43	53	91	36	8
DS50H.205N-0700-08A-DH	7	43	53	91	36	8
DS50H.205N-0710-08A-DH	7.1	43	53	91	36	8
DS50H.205N-0720-08A-DH	7.2	43	53	91	36	8
DS50H.205N-0730-08A-DH	7.3	43	53	91	36	8
DS50H.205N-0740-08A-DH	7.4	43	53	91	36	8

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DS50H.205N-0750-08A-DH	7.5	43	53	91	36	8
DS50H.205N-0760-08A-DH	7.6	43	53	91	36	8
DS50H.205N-0770-08A-DH	7.7	43	53	91	36	8
DS50H.205N-0780-08A-DH	7.8	43	53	91	36	8
DS50H.205N-0790-08A-DH	7.9	43	53	91	36	8
DS50H.205N-0800-08A-DH	8	43	53	91	36	8
DS50H.205N-0810-10A-DH	8.1	49	61	103	40	10
DS50H.205N-0820-10A-DH	8.2	49	61	103	40	10
DS50H.205N-0830-10A-DH	8.3	49	61	103	40	10
DS50H.205N-0840-10A-DH	8.4	49	61	103	40	10
DS50H.205N-0850-10A-DH	8.5	49	61	103	40	10
DS50H.205N-0860-10A-DH	8.6	49	61	103	40	10
DS50H.205N-0870-10A-DH	8.7	49	61	103	40	10
DS50H.205N-0880-10A-DH	8.8	49	61	103	40	10
DS50H.205N-0890-10A-DH	8.9	49	61	103	40	10
DS50H.205N-0900-10A-DH	9	49	61	103	40	10
DS50H.205N-0910-10A-DH	9.1	49	61	103	40	10
DS50H.205N-0920-10A-DH	9.2	49	61	103	40	10
DS50H.205N-0930-10A-DH	9.3	49	61	103	40	10
DS50H.205N-0940-10A-DH	9.4	49	61	103	40	10
DS50H.205N-0950-10A-DH	9.5	49	61	103	40	10
DS50H.205N-0960-10A-DH	9.6	49	61	103	40	10
DS50H.205N-0970-10A-DH	9.7	49	61	103	40	10
DS50H.205N-0980-10A-DH	9.8	49	61	103	40	10
DS50H.205N-0990-10A-DH	9.9	49	61	103	40	10
DS50H.205N-1000-10A-DH	10	49	61	103	40	10
DS50H.205N-1010-12A-DH	10.1	56	71	118	45	12
DS50H.205N-1020-12A-DH	10.2	56	71	118	45	12
DS50H.205N-1030-12A-DH	10.3	56	71	118	45	12
DS50H.205N-1040-12A-DH	10.4	56	71	118	45	12
DS50H.205N-1050-12A-DH	10.5	56	71	118	45	12
DS50H.205N-1060-12A-DH	10.6	56	71	118	45	12
DS50H.205N-1070-12A-DH	10.7	56	71	118	45	12
DS50H.205N-1080-12A-DH	10.8	56	71	118	45	12
DS50H.205N-1090-12A-DH	10.9	56	71	118	45	12
DS50H.205N-1100-12A-DH	11	56	71	118	45	12
DS50H.205N-1110-12A-DH	11.1	56	71	118	45	12
DS50H.205N-1120-12A-DH	11.2	56	71	118	45	12
DS50H.205N-1130-12A-DH	11.3	56	71	118	45	12
DS50H.205N-1140-12A-DH	11.4	56	71	118	45	12
DS50H.205N-1150-12A-DH	11.5	56	71	118	45	12
DS50H.205N-1160-12A-DH	11.6	56	71	118	45	12
DS50H.205N-1170-12A-DH	11.7	56	71	118	45	12
DS50H.205N-1180-12A-DH	11.8	56	71	118	45	12
DS50H.205N-1190-12A-DH	11.9	56	71	118	45	12
DS50H.205N-1200-12A-DH	12	56	71	118	45	12
DS50H.205N-1250-14A-DH	12.5	60	77	124	45	14
DS50H.205N-1300-14A-DH	13	60	77	124	45	14
DS50H.205N-1350-14A-DH	13.5	60	77	124	45	14
DS50H.205N-1400-14A-DH	14	60	77	124	45	14
DS50H.205N-1450-16A-DH	14.5	63	83	133	48	16
DS50H.205N-1500-16A-DH	15	63	83	133	48	16
DS50H.205N-1600-16A-DH	16	63	83	133	48	16

Notes

Notes: ① For requirements outside the catalogue range (special diameters, length-to-diameter ratios, etc.), non-standard custom tools are available.

② For cutting data, refer to the last page of this section of the catalogue.

③ SP: special-purpose tool

Cutting Data

Material group			Material	Strength / hardness [N/mm²] [HRC]	Cutting speed Vc [m/min]		Feed fr [mm/rev] by drill diameter (mm)						
					Internal coolant	External coolant	3	6	8	10	12	14	16
H	H1	H1.1	Hardened steel / cast steel	40-45HRC	50	40	0.04	0.06	0.08	0.1	0.12	0.15	0.15
		H1.2	Hardened steel / cast steel	45-50HRC	35	25	0.04	0.06	0.08	0.1	0.12	0.15	0.15
		H1.3	Hardened steel / cast steel	50-55HRC	35	25	0.04	0.06	0.08	0.1	0.12	0.15	0.15
	H2	H2.1	Wear-resistant cast iron / chilled cast iron, GJN		50	40	0.04	0.06	0.08	0.1	0.12	0.15	0.15

- Recommended minimum through-coolant pressure: 20 bar
- When machining with external coolant, reduce the feed per revolution if necessary to ensure smooth chip evacuation

Various non-standard solutions available

Scope of non-standard customization

- All intermediate drill diameters
- All intermediate drilling depths
- Hole tolerance ≥ IT8
- Optimization of drill-point geometry, e.g. cutting-edge preparation and point chamfering

Contact us for customized tooling (“Custom”).

Contact

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

- Address: No. 8 Maoyuan Road, Wujiang Economic Development Zone, Suzhou, China
- Tel: +86-512-63060818
- E-mail: ypp@yp-tec.com
- Website: www.yp-tec.com

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

QMD20U

Interchangeable Modular Drill



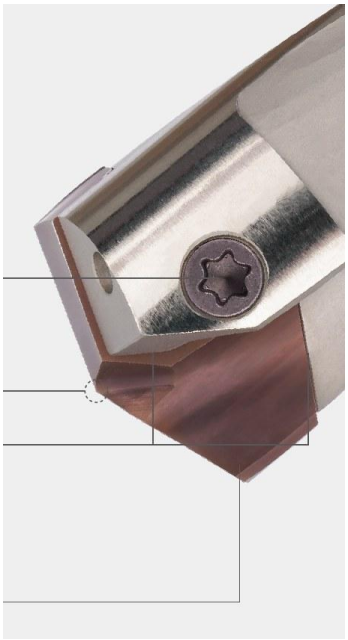
Product line	YPP Drill® – interchangeable modular drills (crown drills)
Components	QMD20U drill heads (inserts); QMS*3D / QMS*5D / QMS*8D drill bodies (holders)
Diameter range	Ø14 – Ø26.99 mm

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Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

Technical Features



- Front-locking design: the insert can be changed more easily without affecting cutting performance
- Drill point with a small chisel edge ensures good centring even with long overhangs
- Double-taper (two inclined faces) seating ensures high repeatability when changing heads
- Lighter insert weight and lower tooling cost

Applications

High-efficiency machining of steel, cast iron and stainless steel

- Diameter range: Ø14 – Ø26.99 mm
- Cutting-diameter tolerance: m7
- Point angle: 140°
- Drilling depth: 3×DC, 5×DC, 8×DC
- Internal coolant
- Achievable hole tolerance: IT8–9
- Carbide substrate
- Bronze-coloured nano-composite coating

Ordering Code

QMD modular exchangeable-head drill – insert (head)

QMD20	U	.	1400
1	2		3

Pos.	Code	Meaning
1	QMD20	QMD front-locking, side-clamped crown drill
2	U	General-purpose (universal) machining
3	1400	Drill-point cutting diameter (mm) – D: 14.00

QMS modular exchangeable-head drill – holder (drill body)

QMS	.	140	R3	B16

QMS	.	140	R3	B16
1		2	3	4

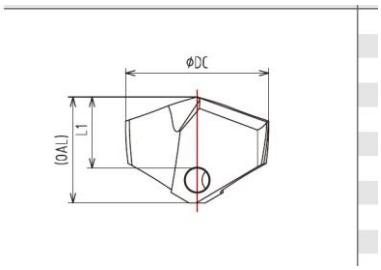
Pos.	Code	Meaning
1	QMS	QMS front-locking, side-clamped crown-drill body
2	140	Drill-point diameter range (mm) – D: 14.00–14.49
3	R3	Effective drilling depth (mm) – LU: R3 = 3×DC
4	B16	Holder shank size (mm) – DCON

Product Range

QMD20U – Interchangeable Modular Drill (drill heads)

Key data: General-purpose drilling | ECU (universal-series tool)

Material suitability (ISO): P ● M ○ K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)			
	DC	OAL	Point angle	Tolerance
061.QMD20U.1400	14	10.7	140°	m7
061.QMD20U.1410	14.1	10.7	140°	m7
061.QMD20U.1420	14.2	10.7	140°	m7
061.QMD20U.1430	14.3	10.7	140°	m7
061.QMD20U.1440	14.4	10.7	140°	m7
061.QMD20U.1450	14.5	10.84	140°	m7
061.QMD20U.1460	14.6	10.84	140°	m7
061.QMD20U.1470	14.7	10.84	140°	m7
061.QMD20U.1480	14.8	10.84	140°	m7
061.QMD20U.1500	15	11.19	140°	m7
061.QMD20U.1510	15.1	11.19	140°	m7
061.QMD20U.1520	15.2	11.19	140°	m7
061.QMD20U.1530	15.3	11.19	140°	m7
061.QMD20U.1540	15.4	11.19	140°	m7
061.QMD20U.1550	15.5	11.19	140°	m7
061.QMD20U.1560	15.6	11.19	140°	m7
061.QMD20U.1570	15.7	11.19	140°	m7
061.QMD20U.1580	15.8	11.19	140°	m7
061.QMD20U.1600	16	12.17	140°	m7
061.QMD20U.1610	16.1	12.17	140°	m7
061.QMD20U.1620	16.2	12.17	140°	m7
061.QMD20U.1630	16.3	12.17	140°	m7
061.QMD20U.1640	16.4	12.17	140°	m7
061.QMD20U.1650	16.5	12.17	140°	m7
061.QMD20U.1660	16.6	12.17	140°	m7
061.QMD20U.1670	16.7	12.17	140°	m7
061.QMD20U.1680	16.8	12.17	140°	m7
061.QMD20U.1700	17	12.62	140°	m7
061.QMD20U.1710	17.1	12.62	140°	m7
061.QMD20U.1720	17.2	12.62	140°	m7
061.QMD20U.1730	17.3	12.62	140°	m7
061.QMD20U.1740	17.4	12.62	140°	m7
061.QMD20U.1750	17.5	12.62	140°	m7
061.QMD20U.1760	17.6	12.62	140°	m7
061.QMD20U.1770	17.7	12.62	140°	m7
061.QMD20U.1780	17.8	12.62	140°	m7
061.QMD20U.1800	18	13.1	140°	m7
061.QMD20U.1810	18.1	13.1	140°	m7
061.QMD20U.1820	18.2	13.1	140°	m7
061.QMD20U.1830	18.3	13.1	140°	m7
061.QMD20U.1850	18.5	13.1	140°	m7
061.QMD20U.1860	18.6	13.1	140°	m7
061.QMD20U.1870	18.7	13.1	140°	m7
061.QMD20U.1880	18.8	13.1	140°	m7
061.QMD20U.1900	19	13.51	140°	m7
061.QMD20U.1910	19.1	13.51	140°	m7
061.QMD20U.1920	19.2	13.51	140°	m7
061.QMD20U.1930	19.3	13.51	140°	m7
061.QMD20U.1950	19.5	13.51	140°	m7
061.QMD20U.1960	19.6	13.51	140°	m7
061.QMD20U.1970	19.7	13.51	140°	m7
061.QMD20U.1980	19.8	13.51	140°	m7

Ordering code	Dimension (mm)			
	DC	OAL	Point angle	Tolerance
061.QMD20U.2000	20	14.19	140°	m7
061.QMD20U.2010	20.1	14.19	140°	m7
061.QMD20U.2020	20.2	14.19	140°	m7
061.QMD20U.2030	20.3	14.19	140°	m7
061.QMD20U.2040	20.4	14.19	140°	m7
061.QMD20U.2050	20.5	14.19	140°	m7
061.QMD20U.2060	20.6	14.19	140°	m7
061.QMD20U.2070	20.7	14.19	140°	m7
061.QMD20U.2080	20.8	14.19	140°	m7
061.QMD20U.2100	21	14.98	140°	m7
061.QMD20U.2110	21.1	14.98	140°	m7
061.QMD20U.2120	21.2	14.98	140°	m7
061.QMD20U.2130	21.3	14.98	140°	m7
061.QMD20U.2150	21.5	14.98	140°	m7
061.QMD20U.2170	21.7	14.98	140°	m7
061.QMD20U.2180	21.8	14.98	140°	m7
061.QMD20U.2200	22	15.46	140°	m7
061.QMD20U.2210	22.1	15.46	140°	m7
061.QMD20U.2220	22.2	15.46	140°	m7
061.QMD20U.2230	22.3	15.46	140°	m7
061.QMD20U.2250	22.5	15.46	140°	m7
061.QMD20U.2270	22.7	15.46	140°	m7
061.QMD20U.2300	23	15.95	140°	m7
061.QMD20U.2350	23.5	15.95	140°	m7
061.QMD20U.2370	23.7	15.95	140°	m7
061.QMD20U.2400	24	17.14	140°	m7
061.QMD20U.2410	24.1	17.14	140°	m7
061.QMD20U.2420	24.2	17.14	140°	m7
061.QMD20U.2440	24.4	17.14	140°	m7
061.QMD20U.2450	24.5	17.14	140°	m7
061.QMD20U.2470	24.7	17.14	140°	m7
061.QMD20U.2480	24.8	17.14	140°	m7
061.QMD20U.2500	25	17.62	140°	m7
061.QMD20U.2510	25.1	17.62	140°	m7
061.QMD20U.2520	25.2	17.62	140°	m7
061.QMD20U.2530	25.3	17.62	140°	m7
061.QMD20U.2540	25.4	17.62	140°	m7
061.QMD20U.2550	25.5	17.62	140°	m7
061.QMD20U.2560	25.6	17.62	140°	m7
061.QMD20U.2580	25.8	17.62	140°	m7
061.QMD20U.2590	25.9	17.62	140°	m7
061.QMD20U.2600	26	18	140°	m7
061.QMD20U.2620	26.2	18	140°	m7
061.QMD20U.2630	26.3	18	140°	m7
061.QMD20U.2650	26.5	18	140°	m7
061.QMD20U.2700	27	18	140°	m7

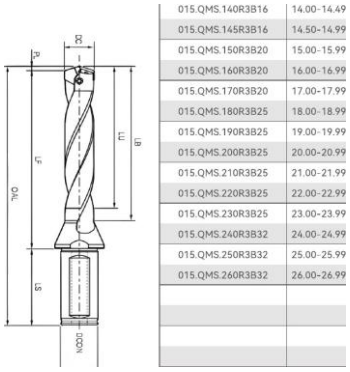
Notes

① Non-standard customization is available for requirements outside the catalogue range (special diameters, relief (clearance) diameters, etc.).

② For cutting data, refer to the last page of this section of the catalogue.

③ ECU: universal-series tool

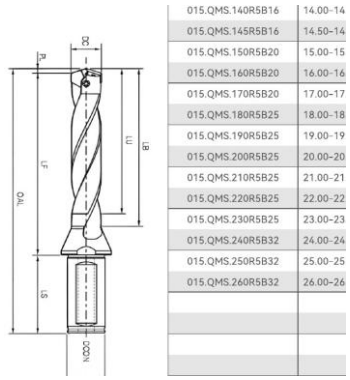
QMS*3D – Interchangeable Modular Drill Body (holder), drilling depth 3×DC



Ordering code	Dimension (mm)							Screw	Wrench
	DC	DCON	LS	LU	LF	LB	OAL		
015.QMS.140R3B16	14.00-14.49	16	48.00	44.41	63.09	51.91	113.5	QMS-CM2.5	QMS-TW8
015.QMS.145R3B16	14.50-14.99	16	48.00	46	66	53.75	116.5	QMS-CM2.5	QMS-TW8
015.QMS.150R3B20	15.00-15.99	20	50.00	49.17	70.03	57.42	122.7	QMS-CM2.5	QMS-TW8
015.QMS.160R3B20	16.00-16.99	20	50.00	523.34	74.06	61.09	126.9	QMS-CM2.5	QMS-TW8
015.QMS.170R3B20	17.00-17.99	20	50.00	55.51	79.09	64.76	132.1	QMS-CM3.0	QMS-TW10
015.QMS.180R3B25	18.00-18.99	25	56.00	58.69	83.01	68.44	142.2	QMS-CM3.0	QMS-TW10
015.QMS.190R3B25	19.00-19.99	25	56.00	61.86	87.94	72.11	147.3	QMS-CM3.5	QMS-TW15
015.QMS.200R3B25	20.00-20.99	25	56.00	65.3	91.97	75.78	151.5	QMS-CM3.5	QMS-TW15
015.QMS.210R3B25	21.00-21.99	25	56.00	68.2	93	79.45	156.7	QMS-CM3.5	QMS-TW15
015.QMS.220R3B25	22.00-22.99	25	56.00	71.37	97.03	83.12	160.9	QMS-CM3.5	QMS-TW15
015.QMS.230R3B25	23.00-23.99	25	56.00	74.55	102.05	86.8	166.1	QMS-CM4.0	QMS-TW15
015.QMS.240R3B32	24.00-24.99	32	60.00	77.72	110.08	90.47	174.3	QMS-CM4.0	QMS-TW15
015.QMS.250R3B32	25.00-25.99	32	60.00	81.02	114.98	94.27	179.5	QMS-CM4.0	QMS-TW15
015.QMS.260R3B32	26.00-26.99	32	60.00	82.6	117.1	96.1	181.7	QMS-CM4.0	QMS-TW15

Translator's note: the LU value "523.34" for 015.QMS.160R3B20 is reproduced as printed; it appears to be a misprint (probably 52.34).

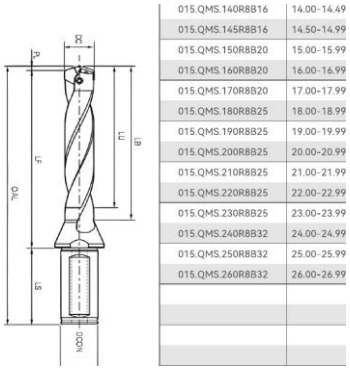
QMS*5D – Interchangeable Modular Drill Body (holder), drilling depth 5×DC



Ordering code	Dimension (mm)							Screw	Wrench
	DC	DCON	LS	LU	LF	LB	OAL		
015.QMS.140R5B16	14.00-14.49	16	48.00	72.41	91.09	79.91	141.5	QMS-CM2.5	QMS-TW8
015.QMS.145R5B16	14.50-14.99	16	48.00	75	95.1	82.75	145.6	QMS-CM2.5	QMS-TW8
015.QMS.150R5B20	15.00-15.99	20	50.00	80.17	101.03	88.42	153.7	QMS-CM2.5	QMS-TW8
015.QMS.160R5B20	16.00-16.99	20	50.00	85.34	107.06	94.09	159.9	QMS-CM2.5	QMS-TW8
015.QMS.170R5B20	17.00-17.99	20	50.00	90.51	114.09	99.76	167.1	QMS-CM3.0	QMS-TW10
015.QMS.180R5B25	18.00-18.99	25	56.00	95.69	120.01	105.44	179.2	QMS-CM3.0	QMS-TW10
015.QMS.190R5B25	19.00-19.99	25	56.00	100.86	126.94	111.11	186.3	QMS-CM3.5	QMS-TW15
015.QMS.200R5B25	20.00-20.99	25	56.00	106.03	132.97	116.78	192.5	QMS-CM3.5	QMS-TW15
015.QMS.210R5B25	21.00-21.99	25	56.00	111.2	136	122.45	199.7	QMS-CM3.5	QMS-TW15
015.QMS.220R5B25	22.00-22.99	25	56.00	116.37	142.03	128.12	205.9	QMS-CM3.5	QMS-TW15
015.QMS.230R5B25	23.00-23.99	25	56.00	121.55	149.05	133.8	213.1	QMS-CM4.0	QMS-TW15
015.QMS.240R5B32	24.00-24.99	32	60.00	126.72	159.08	139.47	223.3	QMS-CM4.0	QMS-TW15
015.QMS.250R5B32	25.00-25.99	32	60.00	132.02	165.98	145.27	230.5	QMS-CM4.0	QMS-TW15

Ordering code	Dimension (mm)							Screw	Wrench
	DC	DCON	LS	LU	LF	LB	OAL		
015.QMS.260R5B32	26.00-26.99	32	60.00	134.6	169.1	148.1	233.7	QMS-CM4.0	QMS-TW15

QMS*8D – Interchangeable Modular Drill Body (holder), drilling depth 8×DC



Ordering code	Dimension (mm)							Screw	Wrench
	DC	DCON	LS	LU	LF	LB	OAL		
015.QMS.140R8B16	14.00-14.49	16	48.00	114.41	133.09	121.91	183.5	QMS-CM2.5	QMS-TW8
015.QMS.145R8B16	14.50-14.99	16	48.00	118.5	138.6	126.25	189.1	QMS-CM2.5	QMS-TW8
015.QMS.150R8B20	15.00-15.99	20	50.00	126.67	147.53	134.92	200.2	QMS-CM2.5	QMS-TW8
015.QMS.160R8B20	16.00-16.99	20	50.00	134.84	156.56	143.59	209.4	QMS-CM2.5	QMS-TW8
015.QMS.170R8B20	17.00-17.99	20	50.00	143.01	166.59	152.26	219.6	QMS-CM3.0	QMS-TW10
015.QMS.180R8B25	18.00-18.99	25	56.00	151.19	175.51	160.94	234.7	QMS-CM3.0	QMS-TW10
015.QMS.190R8B25	19.00-19.99	25	56.00	159.36	185.44	169.61	244.8	QMS-CM3.5	QMS-TW15
015.QMS.200R8B25	20.00-20.99	25	56.00	167.53	194.47	178.28	254	QMS-CM3.5	QMS-TW15
015.QMS.210R8B25	21.00-21.99	25	56.00	175.7	200.5	186.95	264.2	QMS-CM3.5	QMS-TW15
015.QMS.220R8B25	22.00-22.99	25	56.00	183.87	209.73	195.62	273.6	QMS-CM3.5	QMS-TW15
015.QMS.230R8B25	23.00-23.99	25	56.00	192.05	219.55	204.3	283.6	QMS-CM4.0	QMS-TW15
015.QMS.240R8B32	24.00-24.99	32	60.00	200.22	232.58	212.97	296.8	QMS-CM4.0	QMS-TW15
015.QMS.250R8B32	25.00-25.99	32	60.00	208.52	242.48	221.77	307	QMS-CM4.0	QMS-TW15
015.QMS.260R8B32	26.00-26.99	32	60.00	212.6	247.1	226.1	311.7	QMS-CM4.0	QMS-TW15

Notes: ① Non-standard customization is available for requirements outside the catalogue range (special diameters, relief diameters, etc.). ② For cutting data, refer to the last page of this section of the catalogue.

Cutting Data – Modular Exchangeable-Tip Drill (metric)

Material group		Workpiece material	Cutting speed Vc – range (m/min)			Recommended feed fn (mm/rev) by diameter (mm)					
			Min.	Start value	Max.	12.5-16	16-20	20-25.4	25.4-32	32-36	36-40
P	1	Non-alloy steel	80	100	120	0.15-0.31	0.17-0.36	0.19-0.41	0.25-0.53	0.29-0.6	0.33-0.69
	2	Low-alloy steel	80	90	100	0.15-0.31	0.17-0.36	0.19-0.41	0.25-0.53	0.29-0.6	0.33-0.69
	3	High-alloy steel	60	70	80	0.15-0.26	0.17-0.31	0.19-0.36	0.25-0.46	0.23-0.53	0.33-0.6
	4	Ferritic and martensitic stainless steel	60	70	80	0.12-0.26	0.14-0.31	0.16-0.36	0.2-0.46	0.23-0.53	0.3-0.6
K	1	Malleable cast iron	100	110	120	0.17-0.33	0.21-0.42	0.25-0.48	0.31-0.59	0.37-0.7	0.43-0.81
	2	Grey cast iron	90	100	110	0.17-0.33	0.21-0.41	0.25-0.48	0.31-0.59	0.37-0.7	0.43-0.81
	3	Spheroidal graphite (ductile) cast iron	80	90	100	0.18-0.36	0.20-0.41	0.21-0.44	0.23-0.48	0.25-0.53	0.27-0.57
M	1	Austenitic stainless steel	50	60	70	0.09-0.14	0.11-0.17	0.13-0.20	0.16-0.25	0.18-0.28	0.21-0.31
	2	Super-austenitic stainless steel (Ni ≥ 20%)	20	40	60	0.09-0.14	0.11-0.17	0.13-0.20	0.16-0.25	0.18-0.28	0.21-0.31
	3	Duplex (austenitic/ferritic) stainless steel	40	55	70	0.09-0.14	0.11-0.17	0.13-0.20	0.16-0.25	0.18-0.28	0.21-0.31

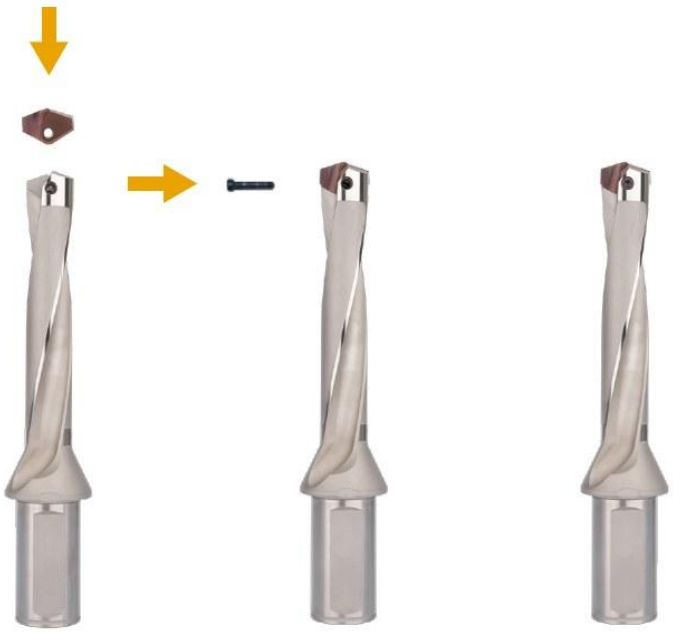
Recommended coolant pressure

Drilling depth	Coolant pressure
3×D	8 bar
5×D	12 bar
8×D	25 bar

Installation

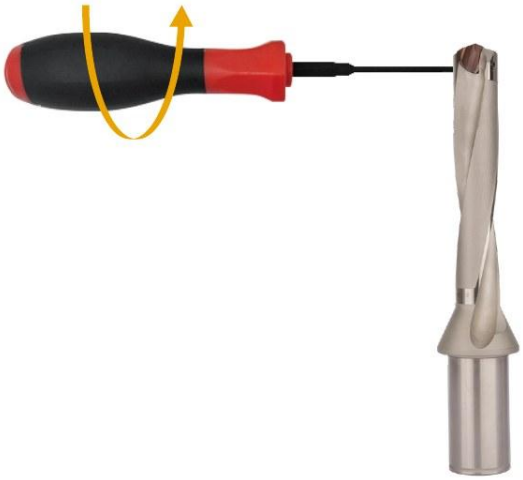
① Mounting the insert

- As shown, place the insert into the slot of the drill body so that the two locating tapers of the insert sit flush against the two tapered faces of the body.



② Tightening the locking screw

- Turn the wrench clockwise until the screw is tight.
- To change the insert, turn the wrench anticlockwise until the screw is released.



Contact

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Solid Round Tools | One-stop Machining Solution

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- Tel: +86-512-63060818
- E-mail: ypp@yp-tec.com
- Website: www.yp-tec.com

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

RD200U

Carbide Drill-Reamer



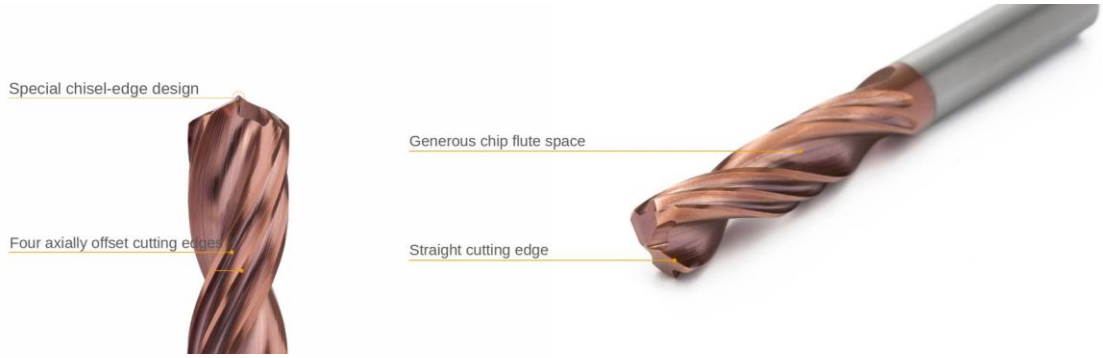
Product line	YPP Drill® – solid carbide drills
Diameter range	Φ6.00 – Φ12.00 mm
Drilling depth	3×Dc, 5×Dc

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Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

Technical Features



- Special chisel-edge design
- Generous chip flute space
- Four axially offset cutting edges
- Straight cutting edge

Applications

High-efficiency hole-making combining drilling and reaming

- Diameter range: Φ6.00 – Φ12.00 mm
- Drilling depth: 3×Dc, 5×Dc
- Internal (through-coolant) and external coolant solutions available
- Hole accuracy: ≥ IT7; standard tools are suitable for H7 holes
- Carbide substrate
- Bronze-coloured composite nano-coating

Ordering Code

RD200U	2	03	W	0800	08	A	DH
1	2	3	4	5	6	7	8

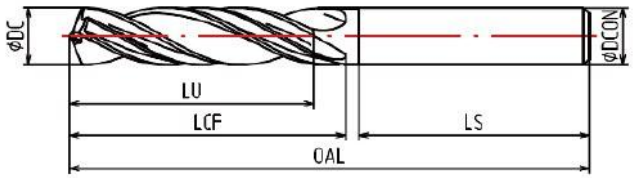
Pos.	Code	Meaning
1	RD200U	Product series
2	2	Number of cutting edges: 2 = two cutting edges
3	03	Drilling depth: 03 = 3×Dc, 05 = 5×Dc
4	W	Coolant type: W = external coolant, N = internal (through) coolant
5	0800	Cutting diameter: 0800 = Φ8.00
6	08	Shank diameter: 08 = Φ8
7	A	Shank type: A = cylindrical shank
8	DH	Coating: DH = DH coating

Product Range

RD200U.203W – Drill-Reamer Carbide Drill

Key data: SP | ±0.003 | 3XD | DIN 6535HA

Material suitability (ISO): P ● M – K ● N ○ S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)

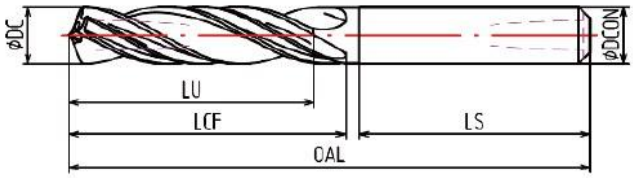


Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
RD200U.203W-0600-06A-DH	6	20	28	66	36	6
RD200U.203W-0700-08A-DH	7	24	34	79	40	8
RD200U.203W-0800-08A-DH	8	29	41	79	36	8
RD200U.203W-0900-10A-DH	9	35	47	89	40	10
RD200U.203W-1000-10A-DH	10	35	47	89	40	10
RD200U.203W-1100-12A-DH	11	40	55	102	45	12
RD200U.203W-1200-12A-DH	12	40	55	102	45	12

RD200U.203N – Drill-Reamer Carbide Drill

Key data: SP | ±0.003 | 3XD | DIN 6535HA

Material suitability (ISO): P ● M – K ● N ○ S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)

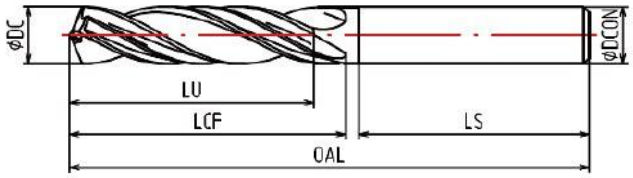


Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
RD200U.203N-0600-06A-DH	6	20	28	66	36	6
RD200U.203N-0700-08A-DH	7	24	34	79	40	8
RD200U.203N-0800-08A-DH	8	29	41	79	36	8
RD200U.203N-0900-10A-DH	9	35	47	89	40	10
RD200U.203N-1000-10A-DH	10	35	47	89	40	10
RD200U.203N-1100-12A-DH	11	40	55	102	45	12
RD200U.203N-1200-12A-DH	12	40	55	102	45	12

RD200U.205W – Drill-Reamer Carbide Drill

Key data: SP | ±0.003 | 5XD | DIN 6535HA

Material suitability (ISO): P ● M – K ● N ○ S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



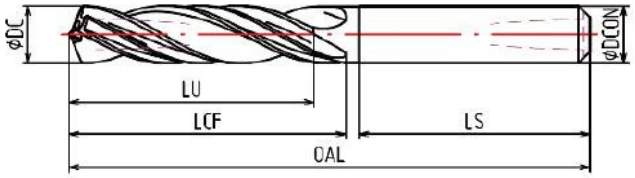
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
RD200U.205W-0600-06A-DH	6	35	44	82	36	6
RD200U.205W-0700-08A-DH	7	43	53	91	36	8
RD200U.205W-0800-08A-DH	8	43	53	91	36	8
RD200U.205W-0900-10A-DH	9	49	61	103	40	10
RD200U.205W-1000-10A-DH	10	49	61	103	40	10

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
RD200U.205W-1100-12A-DH	11	56	71	118	45	12
RD200U.205W-1200-12A-DH	12	56	71	118	45	12

RD200U.205N – Drill-Reamer Carbide Drill

Key data: SP | ±0.003 | 5XD | DIN 6535HA

Material suitability (ISO): P ● M – K ● N ○ S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
RD200U.203N-0600-06A-DH	6	20	28	66	36	6
RD200U.203N-0700-08A-DH	7	24	34	79	40	8
RD200U.203N-0800-08A-DH	8	29	41	79	36	8
RD200U.203N-0900-10A-DH	9	35	47	89	40	10
RD200U.203N-1000-10A-DH	10	35	47	89	40	10
RD200U.203N-1100-12A-DH	11	40	55	102	45	12
RD200U.203N-1200-12A-DH	12	40	55	102	45	12

Notes

Notes: ① For requirements outside the catalogue range (special diameters, length-to-diameter ratios, etc.), non-standard custom tools are available.

② For cutting data, refer to the last page of this section of the catalogue.

③ SP: special-purpose tool

Cutting Data

Material group			Material	Strength / hardness [N/mm²] [HRC]	Cutting speed Vc [m/min]				Feed fr [mm/rev] by drill diameter (mm)				
					Internal coolant	External coolant	MQL (oil mist)	Air	3	4.5	6.5	9.5	14
P	P1	P1.1	Non-alloy structural steel, free-cutting structural steel, case-hardening steel and quenched & tempered steel	<700	80	70	70		0.11	0.13	0.14	0.15	0.17
		P1.2	Non-alloy structural steel, free-cutting structural steel, case-hardening steel and quenched & tempered steel	<1200	70	60	60		0.14	0.16	0.17	0.19	0.21
	P2	P2.1	Alloy case-hardening steel, case-hardening steel and quenched & tempered steel	<900	80	70	70		0.13	0.15	0.16	0.18	0.2
		P2.2	Alloy case-hardening steel, case-hardening steel and quenched & tempered steel	<1400	55	50	50		0.11	0.12	0.13	0.15	0.16
	P3	P3.1	Tool steel, bearing steel, spring steel and high-speed steel	<900	60	50	50		0.12	0.13	0.15	0.16	0.18
		P3.2	Tool steel, bearing steel, spring steel and high-speed steel	<1500	50	45	45		0.1	0.11	0.12	0.14	0.15
	P4	P4.1	Ferritic and martensitic stainless steel		50	35	40		0.08	0.09	0.1	0.11	0.12
	P5	P5.1	Cast steel		80	70	70		0.13	0.15	0.16	0.18	0.2
	P6	P6.1	Ferritic and martensitic stainless cast steel		50	35	40		0.08	0.09	0.1	0.11	0.12
K	K1	K1.1	Lamellar graphite cast iron (grey cast iron), GJL	<300	95	70	70	70	0.17	0.19	0.22	0.25	0.27
	K2	K2.1	Spheroidal graphite (ductile) cast iron, GJS	<500	130	80	95	95	0.16	0.19	0.2	0.23	0.26
		K2.2	Spheroidal graphite (ductile) cast iron, GJS	500-800	80	60	60		0.14	0.16	0.18	0.2	0.22
		K2.3	Spheroidal graphite (ductile) cast iron, GJS	>800									
	K3	K3.1	Vermicular graphite (compacted graphite) cast iron, GJV; malleable cast iron, GJM	<500	70	65	65		0.16	0.17	0.19	0.22	0.24
		K3.2	Vermicular graphite (compacted graphite) cast iron, GJV; malleable cast iron, GJM	>500	65	55	55		0.13	0.14	0.16	0.17	0.19
N	N1	N1.1	Non-alloy and alloy aluminium <3% Si		240	160	200		0.11	0.13	0.14	0.15	0.17
		N1.2	Aluminium alloys ≤7% Si		200	145	160		0.14	0.16	0.18	0.2	0.22
		N1.3	Aluminium alloys 7–12% Si		175	120	145		0.14	0.16	0.18	0.2	0.22
		N1.4	Aluminium alloys >12% Si		145	95	120		0.14	0.16	0.18	0.2	0.22
	N2	N2.1	Non-alloy and low-alloy copper	<300									
		N2.2	Copper alloys	>300									
		N2.3	Brass, bronze, red copper	<1200	160	130			0.17	0.19	0.22	0.25	0.27

- Recommended minimum through-coolant pressure: 20 bar
- When machining with external coolant, reduce the feed per revolution if necessary to ensure smooth chip evacuation

Non-standard customization supported

Scope of non-standard customization

- Hole tolerance ≥ IT7
- Customized machining solutions for different workpiece materials
- Custom dimensions within the cutting-diameter range D6–D12

Contact us for customized tooling (“Custom”).

Contact

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

- Address: No. 8 Maoyuan Road, Wujiang Economic Development Zone, Suzhou, China
- Tel: +86-512-63060818
- E-mail: ypp@yp-tec.com
- Website: www.yp-tec.com

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

SFP Pro

Multi-Material Universal Drill



Product line	YPP Drill® – solid carbide drills
Cutting diameter	3 – 20 mm
Drilling depth	3/5/8/12/16/20/25/30×Dc

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Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

- New series – upgraded version of SFP
- Cutting diameter: 3–20 mm
- External coolant versions: 3D, 5D
- Internal coolant versions: 3D–30D

Technical Features



- Carbide substrate
- Double-margin design: higher stability, able to machine under unfavourable conditions
- Optimized chisel-edge design: combines good self-centring with chisel-edge strength
- Cutting-diameter tolerance: m7

Applications

Universal for multiple materials | Stable, high-efficiency machining

- Hole-making in steel, cast iron, stainless steel, difficult-to-machine materials, non-ferrous metals and other materials
- Drilling depth: 3/5/8/12/16/20/25/30×Dc
- Internal (through-coolant) and external coolant solutions available
- Through-coolant solution recommended for stainless steel and difficult-to-machine materials
- Achievable hole tolerance: IT8–9

Ordering Code

DF40U	2	03	W	0830	10	A
1	2	3	4	5	6	7

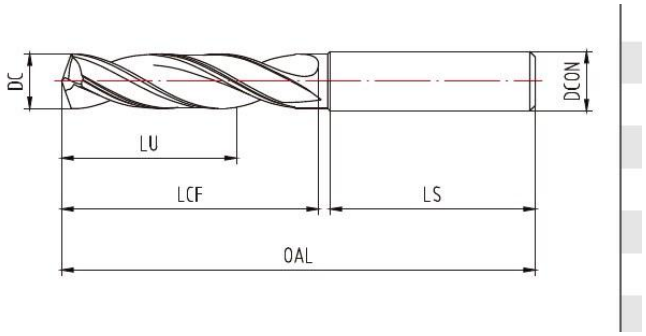
Pos.	Code	Meaning
1	DF40U	Product series
2	2	Number of cutting edges: 2 = two cutting edges
3	03	Drilling depth: 03 = 3×Dc, 05 = 5×Dc
4	W	Coolant type: W = external coolant, N = internal (through) coolant
5	0830	Cutting diameter: 0830 = D8.3
6	10	Shank diameter: 10 = D10
7	A	Shank type: A = cylindrical shank

Product Range

DF40U.203W – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 140° | m7 | 3XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.203W-0300-04A	3	14	20	62	36	4
DF40U.203W-0310-04A	3.1	14	20	62	36	4
DF40U.203W-0318-04A	3.18	14	20	62	36	4
DF40U.203W-0320-04A	3.2	14	20	62	36	4
DF40U.203W-0325-04A	3.25	14	20	62	36	4
DF40U.203W-0330-04A	3.3	14	20	62	36	4
DF40U.203W-0340-04A	3.4	14	20	62	36	4
DF40U.203W-0350-04A	3.5	14	20	62	36	4
DF40U.203W-0357-04A	3.57	14	20	62	36	4
DF40U.203W-0360-04A	3.6	14	20	62	36	4
DF40U.203W-0365-04A	3.65	14	20	62	36	4
DF40U.203W-0370-04A	3.7	14	20	62	36	4
DF40U.203W-0380-04A	3.8	17	24	66	36	4
DF40U.203W-0390-04A	3.9	17	24	66	36	4
DF40U.203W-0397-04A	3.97	17	24	66	36	4
DF40U.203W-0400-04A	4	17	24	66	36	4
DF40U.203W-0410-06A	4.1	17	24	66	36	6
DF40U.203W-0420-06A	4.2	17	24	66	36	6
DF40U.203W-0430-06A	4.3	17	24	66	36	6
DF40U.203W-0437-06A	4.37	17	24	66	36	6
DF40U.203W-0440-06A	4.4	17	24	66	36	6
DF40U.203W-0450-06A	4.5	17	24	66	36	6
DF40U.203W-0460-06A	4.6	17	24	66	36	6
DF40U.203W-0465-06A	4.65	17	24	66	36	6
DF40U.203W-0470-06A	4.7	17	24	66	36	6
DF40U.203W-0476-06A	4.76	20	28	66	36	6
DF40U.203W-0480-06A	4.8	20	28	66	36	6
DF40U.203W-0490-06A	4.9	20	28	66	36	6
DF40U.203W-0500-06A	5	20	28	66	36	6
DF40U.203W-0510-06A	5.1	20	28	66	36	6
DF40U.203W-0516-06A	5.16	20	28	66	36	6
DF40U.203W-0520-06A	5.2	20	28	66	36	6
DF40U.203W-0530-06A	5.3	20	28	66	36	6
DF40U.203W-0540-06A	5.4	20	28	66	36	6
DF40U.203W-0550-06A	5.5	20	28	66	36	6
DF40U.203W-0555-06A	5.55	20	28	66	36	6
DF40U.203W-0556-06A	5.56	20	28	66	36	6
DF40U.203W-0560-06A	5.6	20	28	66	36	6
DF40U.203W-0570-06A	5.7	20	28	66	36	6
DF40U.203W-0580-06A	5.8	20	28	66	36	6
DF40U.203W-0590-06A	5.9	20	28	66	36	6
DF40U.203W-0595-06A	5.95	20	28	66	36	6
DF40U.203W-0600-06A	6	20	28	66	36	6
DF40U.203W-0610-08A	6.1	24	34	79	36	8
DF40U.203W-0620-08A	6.2	24	34	79	36	8
DF40U.203W-0630-08A	6.3	24	34	79	36	8
DF40U.203W-0635-08A	6.35	24	34	79	36	8
DF40U.203W-0640-08A	6.4	24	34	79	36	8
DF40U.203W-0650-08A	6.5	24	34	79	36	8
DF40U.203W-0660-08A	6.6	24	34	79	36	8

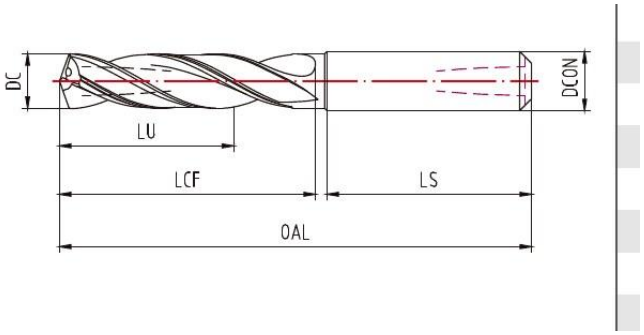
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.203W-0670-08A	6.7	24	34	79	36	8
DF40U.203W-0675-08A	6.75	24	34	79	36	8
DF40U.203W-0680-08A	6.8	24	34	79	36	8
DF40U.203W-0690-08A	6.9	24	34	79	36	8
DF40U.203W-0700-08A	7	24	34	79	36	8
DF40U.203W-0710-08A	7.1	29	41	79	36	8
DF40U.203W-0714-08A	7.14	29	41	79	36	8
DF40U.203W-0720-08A	7.2	29	41	79	36	8
DF40U.203W-0730-08A	7.3	29	41	79	36	8
DF40U.203W-0740-08A	7.4	29	41	79	36	8
DF40U.203W-0750-08A	7.5	29	41	79	36	8
DF40U.203W-0754-08A	7.54	29	41	79	36	8
DF40U.203W-0755-08A	7.55	29	41	79	36	8
DF40U.203W-0760-08A	7.6	29	41	79	36	8
DF40U.203W-0770-08A	7.7	29	41	79	36	8
DF40U.203W-0780-08A	7.8	29	41	79	36	8
DF40U.203W-0790-08A	7.9	29	41	79	36	8
DF40U.203W-0794-08A	7.94	29	41	79	36	8
DF40U.203W-0800-08A	8	29	41	79	36	8
DF40U.203W-0810-10A	8.1	35	47	89	40	10
DF40U.203W-0820-10A	8.2	35	47	89	40	10
DF40U.203W-0830-10A	8.3	35	47	89	40	10
DF40U.203W-0833-10A	8.33	35	47	89	40	10
DF40U.203W-0840-10A	8.4	35	47	89	40	10
DF40U.203W-0850-10A	8.5	35	47	89	40	10
DF40U.203W-0860-10A	8.6	35	47	89	40	10
DF40U.203W-0870-10A	8.7	35	47	89	40	10
DF40U.203W-0873-10A	8.73	35	47	89	40	10
DF40U.203W-0880-10A	8.8	35	47	89	40	10
DF40U.203W-0890-10A	8.9	35	47	89	40	10
DF40U.203W-0900-10A	9	35	47	89	40	10
DF40U.203W-0910-10A	9.1	35	47	89	40	10
DF40U.203W-0913-10A	9.13	35	47	89	40	10
DF40U.203W-0920-10A	9.2	35	47	89	40	10
DF40U.203W-0930-10A	9.3	35	47	89	40	10
DF40U.203W-0940-10A	9.4	35	47	89	40	10
DF40U.203W-0950-10A	9.5	35	47	89	40	10
DF40U.203W-0953-10A	9.53	35	47	89	40	10
DF40U.203W-0955-10A	9.55	35	47	89	40	10
DF40U.203W-0960-10A	9.6	35	47	89	40	10
DF40U.203W-0970-10A	9.7	35	47	89	40	10
DF40U.203W-0980-10A	9.8	35	47	89	40	10
DF40U.203W-0990-10A	9.9	35	47	89	40	10
DF40U.203W-0992-10A	9.92	35	47	89	40	10
DF40U.203W-1000-10A	10	35	47	89	40	10
DF40U.203W-1010-12A	10.1	40	55	102	45	12
DF40U.203W-1020-12A	10.2	40	55	102	45	12
DF40U.203W-1030-12A	10.3	40	55	102	45	12
DF40U.203W-1032-12A	10.32	40	55	102	45	12
DF40U.203W-1040-12A	10.4	40	55	102	45	12
DF40U.203W-1050-12A	10.5	40	55	102	45	12
DF40U.203W-1060-12A	10.6	40	55	102	45	12
DF40U.203W-1070-12A	10.7	40	55	102	45	12
DF40U.203W-1072-12A	10.72	40	55	102	45	12
DF40U.203W-1080-12A	10.8	40	55	102	45	12
DF40U.203W-1090-12A	10.9	40	55	102	45	12
DF40U.203W-1100-12A	11	40	55	102	45	12
DF40U.203W-1110-12A	11.1	40	55	102	45	12
DF40U.203W-1111-12A	11.11	40	55	102	45	12
DF40U.203W-1120-12A	11.2	40	55	102	45	12
DF40U.203W-1130-12A	11.3	40	55	102	45	12
DF40U.203W-1140-12A	11.4	40	55	102	45	12
DF40U.203W-1150-12A	11.5	40	55	102	45	12
DF40U.203W-1151-12A	11.51	40	55	102	45	12
DF40U.203W-1155-12A	11.55	40	55	102	45	12
DF40U.203W-1160-12A	11.6	40	55	102	45	12
DF40U.203W-1170-12A	11.7	40	55	102	45	12
DF40U.203W-1180-12A	11.8	40	55	102	45	12
DF40U.203W-1190-12A	11.9	40	55	102	45	12
DF40U.203W-1191-12A	11.91	40	55	102	45	12
DF40U.203W-1200-12A	12	40	55	102	45	12
DF40U.203W-1210-14A	12.1	43	60	107	45	14

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.203W-1220-14A	12.2	43	60	107	45	14
DF40U.203W-1225-14A	12.25	43	60	107	45	14
DF40U.203W-1230-14A	12.3	43	60	107	45	14
DF40U.203W-1240-14A	12.4	43	60	107	45	14
DF40U.203W-1250-14A	12.5	43	60	107	45	14
DF40U.203W-1260-14A	12.6	43	60	107	45	14
DF40U.203W-1270-14A	12.7	43	60	107	45	14
DF40U.203W-1275-14A	12.75	43	60	107	45	14
DF40U.203W-1280-14A	12.8	43	60	107	45	14
DF40U.203W-1290-14A	12.9	43	60	107	45	14
DF40U.203W-1300-14A	13	43	60	107	45	14
DF40U.203W-1310-14A	13.1	43	60	107	45	14
DF40U.203W-1320-14A	13.2	43	60	107	45	14
DF40U.203W-1330-14A	13.3	43	60	107	45	14
DF40U.203W-1340-14A	13.4	43	60	107	45	14
DF40U.203W-1349-14A	13.49	43	60	107	45	14
DF40U.203W-1350-14A	13.5	43	60	107	45	14
DF40U.203W-1360-14A	13.6	43	60	107	45	14
DF40U.203W-1370-14A	13.7	43	60	107	45	14
DF40U.203W-1380-14A	13.8	43	60	107	45	14
DF40U.203W-1390-14A	13.9	43	60	107	45	14
DF40U.203W-1400-14A	14	43	60	107	45	14
DF40U.203W-1410-16A	14.1	45	65	115	48	16
DF40U.203W-1420-16A	14.2	45	65	115	48	16
DF40U.203W-1429-16A	14.29	45	65	115	48	16
DF40U.203W-1430-16A	14.3	45	65	115	48	16
DF40U.203W-1440-16A	14.4	45	65	115	48	16
DF40U.203W-1450-16A	14.5	45	65	115	48	16
DF40U.203W-1460-16A	14.6	45	65	115	48	16
DF40U.203W-1470-16A	14.7	45	65	115	48	16
DF40U.203W-1475-16A	14.75	45	65	115	48	16
DF40U.203W-1480-16A	14.8	45	65	115	48	16
DF40U.203W-1500-16A	15	45	65	115	48	16
DF40U.203W-1510-16A	15.1	45	65	115	48	16
DF40U.203W-1520-16A	15.2	45	65	115	48	16
DF40U.203W-1530-16A	15.3	45	65	115	48	16
DF40U.203W-1540-16A	15.4	45	65	115	48	16
DF40U.203W-1550-16A	15.5	45	65	115	48	16
DF40U.203W-1560-16A	15.6	45	65	115	48	16
DF40U.203W-1570-16A	15.7	45	65	115	48	16
DF40U.203W-1580-16A	15.8	45	65	115	48	16
DF40U.203W-1588-16A	15.88	45	65	115	48	16
DF40U.203W-1590-16A	15.9	45	65	115	48	16
DF40U.203W-1600-16A	16	45	65	115	48	16
DF40U.203W-1610-18A	16.1	51	73	123	48	18
DF40U.203W-1620-18A	16.2	51	73	123	48	18
DF40U.203W-1630-18A	16.3	51	73	123	48	18
DF40U.203W-1640-18A	16.4	51	73	123	48	18
DF40U.203W-1650-18A	16.5	51	73	123	48	18
DF40U.203W-1660-18A	16.6	51	73	123	48	18
DF40U.203W-1670-18A	16.7	51	73	123	48	18
DF40U.203W-1675-18A	16.75	51	73	123	48	18
DF40U.203W-1680-18A	16.8	51	73	123	48	18
DF40U.203W-1700-18A	17	51	73	123	48	18
DF40U.203W-1720-18A	17.2	51	73	123	48	18
DF40U.203W-1730-18A	17.3	51	73	123	48	18
DF40U.203W-1740-18A	17.4	51	73	123	48	18
DF40U.203W-1750-18A	17.5	51	73	123	48	18
DF40U.203W-1760-18A	17.6	51	73	123	48	18
DF40U.203W-1770-18A	17.7	51	73	123	48	18
DF40U.203W-1780-18A	17.8	51	73	123	48	18
DF40U.203W-1800-18A	18	51	73	123	48	18
DF40U.203W-1820-20A	18.2	55	79	131	50	20
DF40U.203W-1850-20A	18.5	55	79	131	50	20
DF40U.203W-1870-20A	18.7	55	79	131	50	20
DF40U.203W-1880-20A	18.8	55	79	131	50	20
DF40U.203W-1900-20A	19	55	79	131	50	20
DF40U.203W-1905-20A	19.05	55	79	131	50	20
DF40U.203W-1950-20A	19.5	55	79	131	50	20
DF40U.203W-1970-20A	19.7	55	79	131	50	20
DF40U.203W-1980-20A	19.8	55	79	131	50	20
DF40U.203W-2000-20A	20	55	79	131	50	20

DF40U.203N – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 140° | m7 | 3XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.203N-0300-04A	3	14	20	62	36	4
DF40U.203N-0310-04A	3.1	14	20	62	36	4
DF40U.203N-0318-04A	3.18	14	20	62	36	4
DF40U.203N-0320-04A	3.2	14	20	62	36	4
DF40U.203N-0325-04A	3.25	14	20	62	36	4
DF40U.203N-0330-04A	3.3	14	20	62	36	4
DF40U.203N-0340-04A	3.4	14	20	62	36	4
DF40U.203N-0350-04A	3.5	14	20	62	36	4
DF40U.203N-0357-04A	3.57	14	20	62	36	4
DF40U.203N-0360-04A	3.6	14	20	62	36	4
DF40U.203N-0365-04A	3.65	14	20	62	36	4
DF40U.203N-0370-04A	3.7	14	20	62	36	4
DF40U.203N-0380-04A	3.8	17	24	66	36	4
DF40U.203N-0390-04A	3.9	17	24	66	36	4
DF40U.203N-0397-04A	3.97	17	24	66	36	4
DF40U.203N-0400-04A	4	17	24	66	36	4
DF40U.203N-0410-06A	4.1	17	24	66	36	6
DF40U.203N-0420-06A	4.2	17	24	66	36	6
DF40U.203N-0430-06A	4.3	17	24	66	36	6
DF40U.203N-0437-06A	4.37	17	24	66	36	6
DF40U.203N-0440-06A	4.4	17	24	66	36	6
DF40U.203N-0450-06A	4.5	17	24	66	36	6
DF40U.203N-0460-06A	4.6	17	24	66	36	6
DF40U.203N-0465-06A	4.65	17	24	66	36	6
DF40U.203N-0470-06A	4.7	17	24	66	36	6
DF40U.203N-0476-06A	4.76	20	28	66	36	6
DF40U.203N-0480-06A	4.8	20	28	66	36	6
DF40U.203N-0490-06A	4.9	20	28	66	36	6
DF40U.203N-0500-06A	5	20	28	66	36	6
DF40U.203N-0510-06A	5.1	20	28	66	36	6
DF40U.203N-0516-06A	5.16	20	28	66	36	6
DF40U.203N-0520-06A	5.2	20	28	66	36	6
DF40U.203N-0530-06A	5.3	20	28	66	36	6
DF40U.203N-0540-06A	5.4	20	28	66	36	6
DF40U.203N-0550-06A	5.5	20	28	66	36	6
DF40U.203N-0555-06A	5.55	20	28	66	36	6
DF40U.203N-0556-06A	5.56	20	28	66	36	6
DF40U.203N-0560-06A	5.6	20	28	66	36	6
DF40U.203N-0570-06A	5.7	20	28	66	36	6
DF40U.203N-0580-06A	5.8	20	28	66	36	6
DF40U.203N-0590-06A	5.9	20	28	66	36	6
DF40U.203N-0595-06A	5.95	20	28	66	36	6
DF40U.203N-0600-06A	6	20	28	66	36	6
DF40U.203N-0610-08A	6.1	24	34	79	36	8
DF40U.203N-0620-08A	6.2	24	34	79	36	8
DF40U.203N-0630-08A	6.3	24	34	79	36	8
DF40U.203N-0635-08A	6.35	24	34	79	36	8
DF40U.203N-0640-08A	6.4	24	34	79	36	8
DF40U.203N-0650-08A	6.5	24	34	79	36	8
DF40U.203N-0660-08A	6.6	24	34	79	36	8

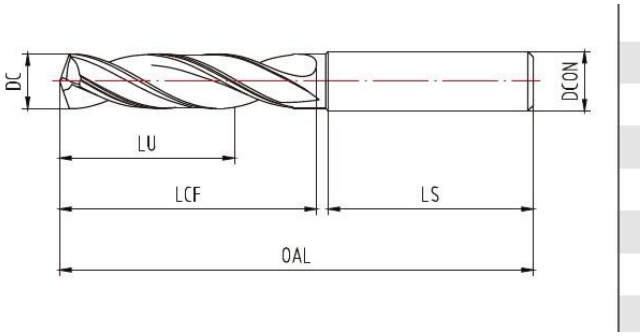
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.203N-0670-08A	6.7	24	34	79	36	8
DF40U.203N-0675-08A	6.75	24	34	79	36	8
DF40U.203N-0680-08A	6.8	24	34	79	36	8
DF40U.203N-0690-08A	6.9	24	34	79	36	8
DF40U.203N-0700-08A	7	24	34	79	36	8
DF40U.203N-0710-08A	7.1	29	41	79	36	8
DF40U.203N-0714-08A	7.14	29	41	79	36	8
DF40U.203N-0720-08A	7.2	29	41	79	36	8
DF40U.203N-0730-08A	7.3	29	41	79	36	8
DF40U.203N-0740-08A	7.4	29	41	79	36	8
DF40U.203N-0750-08A	7.5	29	41	79	36	8
DF40U.203N-0754-08A	7.54	29	41	79	36	8
DF40U.203N-0755-08A	7.55	29	41	79	36	8
DF40U.203N-0760-08A	7.6	29	41	79	36	8
DF40U.203N-0770-08A	7.7	29	41	79	36	8
DF40U.203N-0780-08A	7.8	29	41	79	36	8
DF40U.203N-0790-08A	7.9	29	41	79	36	8
DF40U.203N-0794-08A	7.94	29	41	79	36	8
DF40U.203N-0800-08A	8	29	41	79	36	8
DF40U.203N-0810-10A	8.1	35	47	89	40	10
DF40U.203N-0820-10A	8.2	35	47	89	40	10
DF40U.203N-0830-10A	8.3	35	47	89	40	10
DF40U.203N-0833-10A	8.33	35	47	89	40	10
DF40U.203N-0840-10A	8.4	35	47	89	40	10
DF40U.203N-0850-10A	8.5	35	47	89	40	10
DF40U.203N-0860-10A	8.6	35	47	89	40	10
DF40U.203N-0870-10A	8.7	35	47	89	40	10
DF40U.203N-0873-10A	8.73	35	47	89	40	10
DF40U.203N-0880-10A	8.8	35	47	89	40	10
DF40U.203N-0890-10A	8.9	35	47	89	40	10
DF40U.203N-0900-10A	9	35	47	89	40	10
DF40U.203N-0910-10A	9.1	35	47	89	40	10
DF40U.203N-0913-10A	9.13	35	47	89	40	10
DF40U.203N-0920-10A	9.2	35	47	89	40	10
DF40U.203N-0930-10A	9.3	35	47	89	40	10
DF40U.203N-0940-10A	9.4	35	47	89	40	10
DF40U.203N-0950-10A	9.5	35	47	89	40	10
DF40U.203N-0953-10A	9.53	35	47	89	40	10
DF40U.203N-0955-10A	9.55	35	47	89	40	10
DF40U.203N-0960-10A	9.6	35	47	89	40	10
DF40U.203N-0970-10A	9.7	35	47	89	40	10
DF40U.203N-0980-10A	9.8	35	47	89	40	10
DF40U.203N-0990-10A	9.9	35	47	89	40	10
DF40U.203N-0992-10A	9.92	35	47	89	40	10
DF40U.203N-1000-10A	10	35	47	89	40	10
DF40U.203N-1010-12A	10.1	40	55	102	45	12
DF40U.203N-1020-12A	10.2	40	55	102	45	12
DF40U.203N-1030-12A	10.3	40	55	102	45	12
DF40U.203N-1032-12A	10.32	40	55	102	45	12
DF40U.203N-1040-12A	10.4	40	55	102	45	12
DF40U.203N-1050-12A	10.5	40	55	102	45	12
DF40U.203N-1060-12A	10.6	40	55	102	45	12
DF40U.203N-1070-12A	10.7	40	55	102	45	12
DF40U.203N-1072-12A	10.72	40	55	102	45	12
DF40U.203N-1080-12A	10.8	40	55	102	45	12
DF40U.203N-1090-12A	10.9	40	55	102	45	12
DF40U.203N-1100-12A	11	40	55	102	45	12
DF40U.203N-1110-12A	11.1	40	55	102	45	12
DF40U.203N-1111-12A	11.11	40	55	102	45	12
DF40U.203N-1120-12A	11.2	40	55	102	45	12
DF40U.203N-1130-12A	11.3	40	55	102	45	12
DF40U.203N-1140-12A	11.4	40	55	102	45	12
DF40U.203N-1150-12A	11.5	40	55	102	45	12
DF40U.203N-1151-12A	11.51	40	55	102	45	12
DF40U.203N-1155-12A	11.55	40	55	102	45	12
DF40U.203N-1160-12A	11.6	40	55	102	45	12
DF40U.203N-1170-12A	11.7	40	55	102	45	12
DF40U.203N-1180-12A	11.8	40	55	102	45	12
DF40U.203N-1190-12A	11.9	40	55	102	45	12
DF40U.203N-1191-12A	11.91	40	55	102	45	12
DF40U.203N-1200-12A	12	40	55	102	45	12
DF40U.203N-1210-14A	12.1	43	60	107	45	14

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.203N-1220-14A	12.2	43	60	107	45	14
DF40U.203N-1225-14A	12.25	43	60	107	45	14
DF40U.203N-1230-14A	12.3	43	60	107	45	14
DF40U.203N-1240-14A	12.4	43	60	107	45	14
DF40U.203N-1250-14A	12.5	43	60	107	45	14
DF40U.203N-1260-14A	12.6	43	60	107	45	14
DF40U.203N-1270-14A	12.7	43	60	107	45	14
DF40U.203N-1275-14A	12.75	43	60	107	45	14
DF40U.203N-1280-14A	12.8	43	60	107	45	14
DF40U.203N-1290-14A	12.9	43	60	107	45	14
DF40U.203N-1300-14A	13	43	60	107	45	14
DF40U.203N-1310-14A	13.1	43	60	107	45	14
DF40U.203N-1320-14A	13.2	43	60	107	45	14
DF40U.203N-1330-14A	13.3	43	60	107	45	14
DF40U.203N-1340-14A	13.4	43	60	107	45	14
DF40U.203N-1349-14A	13.49	43	60	107	45	14
DF40U.203N-1350-14A	13.5	43	60	107	45	14
DF40U.203N-1360-14A	13.6	43	60	107	45	14
DF40U.203N-1370-14A	13.7	43	60	107	45	14
DF40U.203N-1380-14A	13.8	43	60	107	45	14
DF40U.203N-1390-14A	13.9	43	60	107	45	14
DF40U.203N-1400-14A	14	43	60	107	45	14
DF40U.203N-1410-16A	14.1	45	65	115	48	16
DF40U.203N-1420-16A	14.2	45	65	115	48	16
DF40U.203N-1429-16A	14.29	45	65	115	48	16
DF40U.203N-1430-16A	14.3	45	65	115	48	16
DF40U.203N-1440-16A	14.4	45	65	115	48	16
DF40U.203N-1450-16A	14.5	45	65	115	48	16
DF40U.203N-1460-16A	14.6	45	65	115	48	16
DF40U.203N-1470-16A	14.7	45	65	115	48	16
DF40U.203N-1475-16A	14.75	45	65	115	48	16
DF40U.203N-1480-16A	14.8	45	65	115	48	16
DF40U.203N-1500-16A	15	45	65	115	48	16
DF40U.203N-1510-16A	15.1	45	65	115	48	16
DF40U.203N-1520-16A	15.2	45	65	115	48	16
DF40U.203N-1530-16A	15.3	45	65	115	48	16
DF40U.203N-1540-16A	15.4	45	65	115	48	16
DF40U.203N-1550-16A	15.5	45	65	115	48	16
DF40U.203N-1560-16A	15.6	45	65	115	48	16
DF40U.203N-1570-16A	15.7	45	65	115	48	16
DF40U.203N-1580-16A	15.8	45	65	115	48	16
DF40U.203N-1588-16A	15.88	45	65	115	48	16
DF40U.203N-1590-16A	15.9	45	65	115	48	16
DF40U.203N-1600-16A	16	45	65	115	48	16
DF40U.203N-1610-18A	16.1	51	73	123	48	18
DF40U.203N-1620-18A	16.2	51	73	123	48	18
DF40U.203N-1630-18A	16.3	51	73	123	48	18
DF40U.203N-1640-18A	16.4	51	73	123	48	18
DF40U.203N-1650-18A	16.5	51	73	123	48	18
DF40U.203N-1660-18A	16.6	51	73	123	48	18
DF40U.203N-1670-18A	16.7	51	73	123	48	18
DF40U.203N-1675-18A	16.75	51	73	123	48	18
DF40U.203N-1680-18A	16.8	51	73	123	48	18
DF40U.203N-1700-18A	17	51	73	123	48	18
DF40U.203N-1720-18A	17.2	51	73	123	48	18
DF40U.203N-1730-18A	17.3	51	73	123	48	18
DF40U.203N-1740-18A	17.4	51	73	123	48	18
DF40U.203N-1750-18A	17.5	51	73	123	48	18
DF40U.203N-1760-18A	17.6	51	73	123	48	18
DF40U.203N-1770-18A	17.7	51	73	123	48	18
DF40U.203N-1780-18A	17.8	51	73	123	48	18
DF40U.203N-1800-18A	18	51	73	123	48	18
DF40U.203N-1820-20A	18.2	55	79	131	50	20
DF40U.203N-1850-20A	18.5	55	79	131	50	20
DF40U.203N-1870-20A	18.7	55	79	131	50	20
DF40U.203N-1880-20A	18.8	55	79	131	50	20
DF40U.203N-1900-20A	19	55	79	131	50	20
DF40U.203N-1905-20A	19.05	55	79	131	50	20
DF40U.203N-1950-20A	19.5	55	79	131	50	20
DF40U.203N-1970-20A	19.7	55	79	131	50	20
DF40U.203N-1980-20A	19.8	55	79	131	50	20
DF40U.203N-2000-20A	20	55	79	131	50	20

DF40U.205W – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 140° | m7 | 5XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.205W-0300-04A	3	23	28	66	36	4
DF40U.205W-0310-04A	3.1	23	28	66	36	4
DF40U.205W-0318-04A	3.18	23	28	66	36	4
DF40U.205W-0320-04A	3.2	23	28	66	36	4
DF40U.205W-0325-04A	3.25	23	28	66	36	4
DF40U.205W-0330-04A	3.3	23	28	66	36	4
DF40U.205W-0340-04A	3.4	23	28	66	36	4
DF40U.205W-0350-04A	3.5	23	28	66	36	4
DF40U.205W-0357-04A	3.57	23	28	66	36	4
DF40U.205W-0360-04A	3.6	23	28	66	36	4
DF40U.205W-0365-04A	3.65	23	28	66	36	4
DF40U.205W-0370-04A	3.7	23	28	66	36	4
DF40U.205W-0380-04A	3.8	29	36	74	36	4
DF40U.205W-0390-04A	3.9	29	36	74	36	4
DF40U.205W-0397-04A	3.97	29	36	74	36	4
DF40U.205W-0400-04A	4	29	36	74	36	4
DF40U.205W-0410-06A	4.1	29	36	74	36	6
DF40U.205W-0420-06A	4.2	29	36	74	36	6
DF40U.205W-0430-06A	4.3	29	36	74	36	6
DF40U.205W-0437-06A	4.37	29	36	74	36	6
DF40U.205W-0440-06A	4.4	29	36	74	36	6
DF40U.205W-0450-06A	4.5	29	36	74	36	6
DF40U.205W-0460-06A	4.6	29	36	74	36	6
DF40U.205W-0465-06A	4.65	29	36	74	36	6
DF40U.205W-0470-06A	4.7	29	36	74	36	6
DF40U.205W-0476-06A	4.76	35	44	82	36	6
DF40U.205W-0480-06A	4.8	35	44	82	36	6
DF40U.205W-0490-06A	4.9	35	44	82	36	6
DF40U.205W-0500-06A	5	35	44	82	36	6
DF40U.205W-0510-06A	5.1	35	44	82	36	6
DF40U.205W-0516-06A	5.16	35	44	82	36	6
DF40U.205W-0520-06A	5.2	35	44	82	36	6
DF40U.205W-0530-06A	5.3	35	44	82	36	6
DF40U.205W-0540-06A	5.4	35	44	82	36	6
DF40U.205W-0550-06A	5.5	35	44	82	36	6
DF40U.205W-0555-06A	5.55	35	44	82	36	6
DF40U.205W-0556-06A	5.56	35	44	82	36	6
DF40U.205W-0560-06A	5.6	35	44	82	36	6
DF40U.205W-0570-06A	5.7	35	44	82	36	6
DF40U.205W-0580-06A	5.8	35	44	82	36	6
DF40U.205W-0590-06A	5.9	35	44	82	36	6
DF40U.205W-0595-06A	5.95	35	44	82	36	6
DF40U.205W-0600-06A	6	35	44	82	36	6
DF40U.205W-0610-08A	6.1	43	53	91	36	8
DF40U.205W-0620-08A	6.2	43	53	91	36	8
DF40U.205W-0630-08A	6.3	43	53	91	36	8
DF40U.205W-0635-08A	6.35	43	53	91	36	8
DF40U.205W-0640-08A	6.4	43	53	91	36	8
DF40U.205W-0650-08A	6.5	43	53	91	36	8
DF40U.205W-0660-08A	6.6	43	53	91	36	8

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.205W-0670-08A	6.7	43	53	91	36	8
DF40U.205W-0675-08A	6.75	43	53	91	36	8
DF40U.205W-0680-08A	6.8	43	53	91	36	8
DF40U.205W-0690-08A	6.9	43	53	91	36	8
DF40U.205W-0700-08A	7	43	53	91	36	8
DF40U.205W-0710-08A	7.1	43	53	91	36	8
DF40U.205W-0714-08A	7.14	43	53	91	36	8
DF40U.205W-0720-08A	7.2	43	53	91	36	8
DF40U.205W-0730-08A	7.3	43	53	91	36	8
DF40U.205W-0740-08A	7.4	43	53	91	36	8
DF40U.205W-0750-08A	7.5	43	53	91	36	8
DF40U.205W-0754-08A	7.54	43	53	91	36	8
DF40U.205W-0755-08A	7.55	43	53	91	36	8
DF40U.205W-0760-08A	7.6	43	53	91	36	8
DF40U.205W-0770-08A	7.7	43	53	91	36	8
DF40U.205W-0780-08A	7.8	43	53	91	36	8
DF40U.205W-0790-08A	7.9	43	53	91	36	8
DF40U.205W-0794-08A	7.94	43	53	91	36	8
DF40U.205W-0800-08A	8	43	53	91	36	8
DF40U.205W-0810-10A	8.1	49	61	103	40	10
DF40U.205W-0820-10A	8.2	49	61	103	40	10
DF40U.205W-0830-10A	8.3	49	61	103	40	10
DF40U.205W-0833-10A	8.33	49	61	103	40	10
DF40U.205W-0840-10A	8.4	49	61	103	40	10
DF40U.205W-0850-10A	8.5	49	61	103	40	10
DF40U.205W-0860-10A	8.6	49	61	103	40	10
DF40U.205W-0870-10A	8.7	49	61	103	40	10
DF40U.205W-0873-10A	8.73	49	61	103	40	10
DF40U.205W-0880-10A	8.8	49	61	103	40	10
DF40U.205W-0890-10A	8.9	49	61	103	40	10
DF40U.205W-0900-10A	9	49	61	103	40	10
DF40U.205W-0910-10A	9.1	49	61	103	40	10
DF40U.205W-0913-10A	9.13	49	61	103	40	10
DF40U.205W-0920-10A	9.2	49	61	103	40	10
DF40U.205W-0930-10A	9.3	49	61	103	40	10
DF40U.205W-0940-10A	9.4	49	61	103	40	10
DF40U.205W-0950-10A	9.5	49	61	103	40	10
DF40U.205W-0953-10A	9.53	49	61	103	40	10
DF40U.205W-0955-10A	9.55	49	61	103	40	10
DF40U.205W-0960-10A	9.6	49	61	103	40	10
DF40U.205W-0970-10A	9.7	49	61	103	40	10
DF40U.205W-0980-10A	9.8	49	61	103	40	10
DF40U.205W-0990-10A	9.9	49	61	103	40	10
DF40U.205W-0992-10A	9.92	49	61	103	40	10
DF40U.205W-1000-10A	10	49	61	103	40	10
DF40U.205W-1010-12A	10.1	56	71	118	45	12
DF40U.205W-1020-12A	10.2	56	71	118	45	12
DF40U.205W-1030-12A	10.3	56	71	118	45	12
DF40U.205W-1032-12A	10.32	56	71	118	45	12
DF40U.205W-1040-12A	10.4	56	71	118	45	12
DF40U.205W-1050-12A	10.5	56	71	118	45	12
DF40U.205W-1060-12A	10.6	56	71	118	45	12
DF40U.205W-1070-12A	10.7	56	71	118	45	12
DF40U.205W-1072-12A	10.72	56	71	118	45	12
DF40U.205W-1080-12A	10.8	56	71	118	45	12
DF40U.205W-1090-12A	10.9	56	71	118	45	12
DF40U.205W-1100-12A	11	56	71	118	45	12
DF40U.205W-1110-12A	11.1	56	71	118	45	12
DF40U.205W-1111-12A	11.11	56	71	118	45	12
DF40U.205W-1120-12A	11.2	56	71	118	45	12
DF40U.205W-1130-12A	11.3	56	71	118	45	12
DF40U.205W-1140-12A	11.4	56	71	118	45	12
DF40U.205W-1150-12A	11.5	56	71	118	45	12
DF40U.205W-1151-12A	11.51	56	71	118	45	12
DF40U.205W-1155-12A	11.55	56	71	118	45	12
DF40U.205W-1160-12A	11.6	56	71	118	45	12
DF40U.205W-1170-12A	11.7	56	71	118	45	12
DF40U.205W-1180-12A	11.8	56	71	118	45	12
DF40U.205W-1190-12A	11.9	56	71	118	45	12
DF40U.205W-1191-12A	11.91	56	71	118	45	12
DF40U.205W-1200-12A	12	56	71	118	45	12
DF40U.205W-1210-14A	12.1	60	77	124	45	14

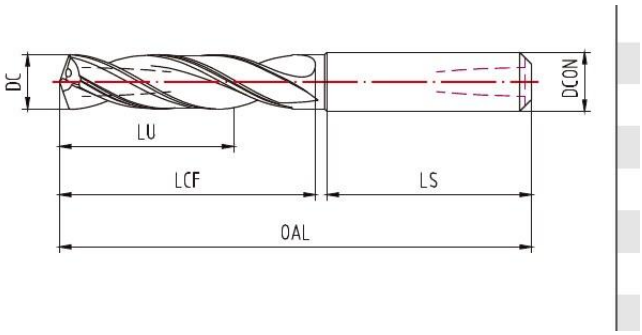
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.205W-1220-14A	12.2	60	77	124	45	14
DF40U.205W-1225-14A	12.25	60	77	124	45	14
DF40U.205W-1230-14A	12.3	60	77	124	45	14
DF40U.205W-1240-14A	12.4	60	77	124	45	14
DF40U.205W-1250-14A	12.5	60	77	124	45	14
DF40U.205W-1260-14A	12.6	60	77	124	45	14
DF40U.205W-1270-14A	12.7	60	77	124	45	14
DF40U.205W-1275-14A	12.75	60	77	124	45	14
DF40U.205W-1280-14A	12.8	60	77	124	45	14
DF40U.205W-1290-14A	12.9	60	77	124	45	14
DF40U.205W-1300-14A	13	60	77	124	45	14
DF40U.205W-1310-14A	13.1	60	77	124	45	14
DF40U.205W-1320-14A	13.2	60	77	124	45	14
DF40U.205W-1330-14A	13.3	60	77	124	45	14
DF40U.205W-1340-14A	13.4	60	77	124	45	14
DF40U.205W-1349-14A	13.49	60	77	124	45	14
DF40U.205W-1350-14A	13.5	60	77	124	45	14
DF40U.205W-1360-14A	13.6	60	77	124	45	14
DF40U.205W-1370-14A	13.7	60	77	124	45	14
DF40U.205W-1380-14A	13.8	60	77	124	45	14
DF40U.205W-1390-14A	13.9	60	77	124	45	14
DF40U.205W-1400-14A	14	60	77	124	45	14
DF40U.205W-1410-16A	14.1	63	83	133	48	16
DF40U.205W-1420-16A	14.2	63	83	133	48	16
DF40U.205W-1429-16A	14.29	63	83	133	48	16
DF40U.205W-1430-16A	14.3	63	83	133	48	16
DF40U.205W-1440-16A	14.4	63	83	133	48	16
DF40U.205W-1450-16A	14.5	63	83	133	48	16
DF40U.205W-1460-16A	14.6	63	83	133	48	16
DF40U.205W-1470-16A	14.7	63	83	133	48	16
DF40U.205W-1475-16A	14.75	63	83	133	48	16
DF40U.205W-1480-16A	14.8	63	83	133	48	16
DF40U.205W-1490-16A	14.9	63	83	133	48	16
DF40U.205W-1500-16A	15	63	83	133	48	16
DF40U.205W-1510-16A	15.1	63	83	133	48	16
DF40U.205W-1520-16A	15.2	63	83	133	48	16
DF40U.205W-1530-16A	15.3	63	83	133	48	16
DF40U.205W-1540-16A	15.4	63	83	133	48	16
DF40U.205W-1550-16A	15.5	63	83	133	48	16
DF40U.205W-1560-16A	15.6	63	83	133	48	16
DF40U.205W-1570-16A	15.7	63	83	133	48	16
DF40U.205W-1580-16A	15.8	63	83	133	48	16
DF40U.205W-1588-16A	15.88	63	83	133	48	16
DF40U.205W-1590-16A	15.9	63	83	133	48	16
DF40U.205W-1600-16A	16	63	83	133	48	16
DF40U.205W-1610-18A	16.1	71	93	143	48	18
DF40U.205W-1620-18A	16.2	71	93	143	48	18
DF40U.205W-1630-18A	16.3	71	93	143	48	18
DF40U.205W-1640-18A	16.4	71	93	143	48	18
DF40U.205W-1650-18A	16.5	71	93	143	48	18
DF40U.205W-1660-18A	16.6	71	93	143	48	18
DF40U.205W-1670-18A	16.7	71	93	143	48	18
DF40U.205W-1675-18A	16.75	71	93	143	48	18
DF40U.205W-1680-18A	16.8	71	93	143	48	18
DF40U.205W-1690-18A	16.9	71	93	143	48	18
DF40U.205W-1700-18A	17	71	93	143	48	18
DF40U.205W-1710-18A	17.1	71	93	143	48	18
DF40U.205W-1720-18A	17.2	71	93	143	48	18
DF40U.205W-1730-18A	17.3	71	93	143	48	18
DF40U.205W-1740-18A	17.4	71	93	143	48	18
DF40U.205W-1750-18A	17.5	71	93	143	48	18
DF40U.205W-1760-18A	17.6	71	93	143	48	18
DF40U.205W-1770-18A	17.7	71	93	143	48	18
DF40U.205W-1780-18A	17.8	71	93	143	48	18
DF40U.205W-1790-18A	17.9	71	93	143	48	18
DF40U.205W-1800-18A	18	71	93	143	48	18
DF40U.205W-1810-20A	18.1	77	101	153	50	20
DF40U.205W-1820-20A	18.2	77	101	153	50	20
DF40U.205W-1830-20A	18.3	77	101	153	50	20
DF40U.205W-1840-20A	18.4	77	101	153	50	20
DF40U.205W-1850-20A	18.5	77	101	153	50	20
DF40U.205W-1860-20A	18.6	77	101	153	50	20

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.205W-1870-20A	18.7	77	101	153	50	20
DF40U.205W-1880-20A	18.8	77	101	153	50	20
DF40U.205W-1890-20A	18.9	77	101	153	50	20
DF40U.205W-1900-20A	19	77	101	153	50	20
DF40U.205W-1905-20A	19.05	77	101	153	50	20
DF40U.205W-1910-20A	19.1	77	101	153	50	20
DF40U.205W-1920-20A	19.2	77	101	153	50	20
DF40U.205W-1930-20A	19.3	77	101	153	50	20
DF40U.205W-1940-20A	19.4	77	101	153	50	20
DF40U.205W-1950-20A	19.5	77	101	153	50	20
DF40U.205W-1960-20A	19.6	77	101	153	50	20
DF40U.205W-1970-20A	19.7	77	101	153	50	20
DF40U.205W-1980-20A	19.8	77	101	153	50	20
DF40U.205W-1990-20A	19.9	77	101	153	50	20
DF40U.205W-2000-20A	20	77	101	153	50	20

DF40U.205N – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 140° | m7 | 5XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.205N-0300-04A	3	23	28	66	36	4
DF40U.205N-0310-04A	3.1	23	28	66	36	4
DF40U.205N-0318-04A	3.18	23	28	66	36	4
DF40U.205N-0320-04A	3.2	23	28	66	36	4
DF40U.205N-0325-04A	3.25	23	28	66	36	4
DF40U.205N-0330-04A	3.3	23	28	66	36	4
DF40U.205N-0340-04A	3.4	23	28	66	36	4
DF40U.205N-0350-04A	3.5	23	28	66	36	4
DF40U.205N-0357-04A	3.57	23	28	66	36	4
DF40U.205N-0360-04A	3.6	23	28	66	36	4
DF40U.205N-0365-04A	3.65	23	28	66	36	4
DF40U.205N-0370-04A	3.7	23	28	66	36	4
DF40U.205N-0380-04A	3.8	29	36	74	36	4
DF40U.205N-0390-04A	3.9	29	36	74	36	4
DF40U.205N-0397-04A	3.97	29	36	74	36	4
DF40U.205N-0400-04A	4	29	36	74	36	4
DF40U.205N-0410-06A	4.1	29	36	74	36	6
DF40U.205N-0420-06A	4.2	29	36	74	36	6
DF40U.205N-0430-06A	4.3	29	36	74	36	6
DF40U.205N-0437-06A	4.37	29	36	74	36	6
DF40U.205N-0440-06A	4.4	29	36	74	36	6
DF40U.205N-0450-06A	4.5	29	36	74	36	6
DF40U.205N-0460-06A	4.6	29	36	74	36	6
DF40U.205N-0465-06A	4.65	29	36	74	36	6
DF40U.205N-0470-06A	4.7	29	36	74	36	6
DF40U.205N-0476-06A	4.76	35	44	82	36	6
DF40U.205N-0480-06A	4.8	35	44	82	36	6
DF40U.205N-0490-06A	4.9	35	44	82	36	6
DF40U.205N-0500-06A	5	35	44	82	36	6
DF40U.205N-0510-06A	5.1	35	44	82	36	6
DF40U.205N-0516-06A	5.16	35	44	82	36	6
DF40U.205N-0520-06A	5.2	35	44	82	36	6
DF40U.205N-0530-06A	5.3	35	44	82	36	6

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.205N-0540-06A	5.4	35	44	82	36	6
DF40U.205N-0550-06A	5.5	35	44	82	36	6
DF40U.205N-0555-06A	5.55	35	44	82	36	6
DF40U.205N-0556-06A	5.56	35	44	82	36	6
DF40U.205N-0560-06A	5.6	35	44	82	36	6
DF40U.205N-0570-06A	5.7	35	44	82	36	6
DF40U.205N-0580-06A	5.8	35	44	82	36	6
DF40U.205N-0590-06A	5.9	35	44	82	36	6
DF40U.205N-0595-06A	5.95	35	44	82	36	6
DF40U.205N-0600-06A	6	35	44	82	36	6
DF40U.205N-0610-08A	6.1	43	53	91	36	8
DF40U.205N-0620-08A	6.2	43	53	91	36	8
DF40U.205N-0630-08A	6.3	43	53	91	36	8
DF40U.205N-0635-08A	6.35	43	53	91	36	8
DF40U.205N-0640-08A	6.4	43	53	91	36	8
DF40U.205N-0650-08A	6.5	43	53	91	36	8
DF40U.205N-0660-08A	6.6	43	53	91	36	8
DF40U.205N-0670-08A	6.7	43	53	91	36	8
DF40U.205N-0675-08A	6.75	43	53	91	36	8
DF40U.205N-0680-08A	6.8	43	53	91	36	8
DF40U.205N-0690-08A	6.9	43	53	91	36	8
DF40U.205N-0700-08A	7	43	53	91	36	8
DF40U.205N-0710-08A	7.1	43	53	91	36	8
DF40U.205N-0714-08A	7.14	43	53	91	36	8
DF40U.205N-0720-08A	7.2	43	53	91	36	8
DF40U.205N-0730-08A	7.3	43	53	91	36	8
DF40U.205N-0740-08A	7.4	43	53	91	36	8
DF40U.205N-0750-08A	7.5	43	53	91	36	8
DF40U.205N-0754-08A	7.54	43	53	91	36	8
DF40U.205N-0755-08A	7.55	43	53	91	36	8
DF40U.205N-0760-08A	7.6	43	53	91	36	8
DF40U.205N-0770-08A	7.7	43	53	91	36	8
DF40U.205N-0780-08A	7.8	43	53	91	36	8
DF40U.205N-0790-08A	7.9	43	53	91	36	8
DF40U.205N-0794-08A	7.94	43	53	91	36	8
DF40U.205N-0800-08A	8	43	53	91	36	8
DF40U.205N-0810-10A	8.1	49	61	103	40	10
DF40U.205N-0820-10A	8.2	49	61	103	40	10
DF40U.205N-0830-10A	8.3	49	61	103	40	10
DF40U.205N-0833-10A	8.33	49	61	103	40	10
DF40U.205N-0840-10A	8.4	49	61	103	40	10
DF40U.205N-0850-10A	8.5	49	61	103	40	10
DF40U.205N-0860-10A	8.6	49	61	103	40	10
DF40U.205N-0870-10A	8.7	49	61	103	40	10
DF40U.205N-0873-10A	8.73	49	61	103	40	10
DF40U.205N-0880-10A	8.8	49	61	103	40	10
DF40U.205N-0890-10A	8.9	49	61	103	40	10
DF40U.205N-0900-10A	9	49	61	103	40	10
DF40U.205N-0910-10A	9.1	49	61	103	40	10
DF40U.205N-0913-10A	9.13	49	61	103	40	10
DF40U.205N-0920-10A	9.2	49	61	103	40	10
DF40U.205N-0930-10A	9.3	49	61	103	40	10
DF40U.205N-0940-10A	9.4	49	61	103	40	10
DF40U.205N-0950-10A	9.5	49	61	103	40	10
DF40U.205N-0953-10A	9.53	49	61	103	40	10
DF40U.205N-0955-10A	9.55	49	61	103	40	10
DF40U.205N-0960-10A	9.6	49	61	103	40	10
DF40U.205N-0970-10A	9.7	49	61	103	40	10
DF40U.205N-0980-10A	9.8	49	61	103	40	10
DF40U.205N-0990-10A	9.9	49	61	103	40	10
DF40U.205N-0992-10A	9.92	49	61	103	40	10
DF40U.205N-1000-10A	10	49	61	103	40	10
DF40U.205N-1010-12A	10.1	56	71	118	45	12
DF40U.205N-1020-12A	10.2	56	71	118	45	12
DF40U.205N-1030-12A	10.3	56	71	118	45	12
DF40U.205N-1032-12A	10.32	56	71	118	45	12
DF40U.205N-1040-12A	10.4	56	71	118	45	12
DF40U.205N-1050-12A	10.5	56	71	118	45	12
DF40U.205N-1060-12A	10.6	56	71	118	45	12
DF40U.205N-1070-12A	10.7	56	71	118	45	12
DF40U.205N-1072-12A	10.72	56	71	118	45	12
DF40U.205N-1080-12A	10.8	56	71	118	45	12

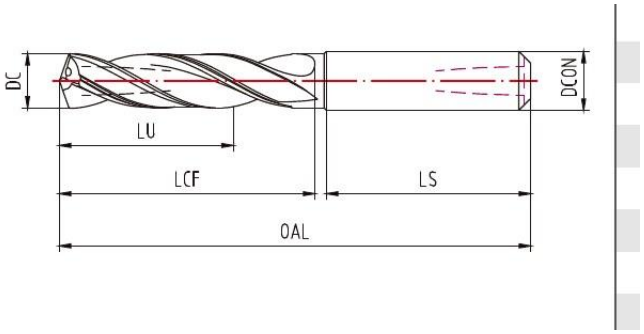
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.205N-1090-12A	10.9	56	71	118	45	12
DF40U.205N-1100-12A	11	56	71	118	45	12
DF40U.205N-1110-12A	11.1	56	71	118	45	12
DF40U.205N-1111-12A	11.11	56	71	118	45	12
DF40U.205N-1120-12A	11.2	56	71	118	45	12
DF40U.205N-1130-12A	11.3	56	71	118	45	12
DF40U.205N-1140-12A	11.4	56	71	118	45	12
DF40U.205N-1150-12A	11.5	56	71	118	45	12
DF40U.205N-1151-12A	11.51	56	71	118	45	12
DF40U.205N-1155-12A	11.55	56	71	118	45	12
DF40U.205N-1160-12A	11.6	56	71	118	45	12
DF40U.205N-1170-12A	11.7	56	71	118	45	12
DF40U.205N-1180-12A	11.8	56	71	118	45	12
DF40U.205N-1190-12A	11.9	56	71	118	45	12
DF40U.205N-1191-12A	11.91	56	71	118	45	12
DF40U.205N-1200-12A	12	56	71	118	45	12
DF40U.205N-1210-14A	12.1	60	77	124	45	14
DF40U.205N-1220-14A	12.2	60	77	124	45	14
DF40U.205N-1225-14A	12.25	60	77	124	45	14
DF40U.205N-1230-14A	12.3	60	77	124	45	14
DF40U.205N-1240-14A	12.4	60	77	124	45	14
DF40U.205N-1250-14A	12.5	60	77	124	45	14
DF40U.205N-1260-14A	12.6	60	77	124	45	14
DF40U.205N-1270-14A	12.7	60	77	124	45	14
DF40U.205N-1275-14A	12.75	60	77	124	45	14
DF40U.205N-1280-14A	12.8	60	77	124	45	14
DF40U.205N-1290-14A	12.9	60	77	124	45	14
DF40U.205N-1300-14A	13	60	77	124	45	14
DF40U.205N-1310-14A	13.1	60	77	124	45	14
DF40U.205N-1320-14A	13.2	60	77	124	45	14
DF40U.205N-1330-14A	13.3	60	77	124	45	14
DF40U.205N-1340-14A	13.4	60	77	124	45	14
DF40U.205N-1349-14A	13.49	60	77	124	45	14
DF40U.205N-1350-14A	13.5	60	77	124	45	14
DF40U.205N-1360-14A	13.6	60	77	124	45	14
DF40U.205N-1370-14A	13.7	60	77	124	45	14
DF40U.205N-1380-14A	13.8	60	77	124	45	14
DF40U.205N-1390-14A	13.9	60	77	124	45	14
DF40U.205N-1400-14A	14	60	77	124	45	14
DF40U.205N-1410-16A	14.1	63	83	133	48	16
DF40U.205N-1420-16A	14.2	63	83	133	48	16
DF40U.205N-1429-16A	14.29	63	83	133	48	16
DF40U.205N-1430-16A	14.3	63	83	133	48	16
DF40U.205N-1440-16A	14.4	63	83	133	48	16
DF40U.205N-1450-16A	14.5	63	83	133	48	16
DF40U.205N-1460-16A	14.6	63	83	133	48	16
DF40U.205N-1470-16A	14.7	63	83	133	48	16
DF40U.205N-1475-16A	14.75	63	83	133	48	16
DF40U.205N-1480-16A	14.8	63	83	133	48	16
DF40U.205N-1490-16A	14.9	63	83	133	48	16
DF40U.205N-1500-16A	15	63	83	133	48	16
DF40U.205N-1510-16A	15.1	63	83	133	48	16
DF40U.205N-1520-16A	15.2	63	83	133	48	16
DF40U.205N-1530-16A	15.3	63	83	133	48	16
DF40U.205N-1540-16A	15.4	63	83	133	48	16
DF40U.205N-1550-16A	15.5	63	83	133	48	16
DF40U.205N-1560-16A	15.6	63	83	133	48	16
DF40U.205N-1570-16A	15.7	63	83	133	48	16
DF40U.205N-1580-16A	15.8	63	83	133	48	16
DF40U.205N-1588-16A	15.88	63	83	133	48	16
DF40U.205N-1590-16A	15.9	63	83	133	48	16
DF40U.205N-1600-16A	16	63	83	133	48	16
DF40U.205N-1610-18A	16.1	71	93	143	48	18
DF40U.205N-1620-18A	16.2	71	93	143	48	18
DF40U.205N-1630-18A	16.3	71	93	143	48	18
DF40U.205N-1640-18A	16.4	71	93	143	48	18
DF40U.205N-1650-18A	16.5	71	93	143	48	18
DF40U.205N-1660-18A	16.6	71	93	143	48	18
DF40U.205N-1670-18A	16.7	71	93	143	48	18
DF40U.205N-1675-18A	16.75	71	93	143	48	18
DF40U.205N-1680-18A	16.8	71	93	143	48	18
DF40U.205N-1690-18A	16.9	71	93	143	48	18

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.205N-1700-18A	17	71	93	143	48	18
DF40U.205N-1710-18A	17.1	71	93	143	48	18
DF40U.205N-1720-18A	17.2	71	93	143	48	18
DF40U.205N-1730-18A	17.3	71	93	143	48	18
DF40U.205N-1740-18A	17.4	71	93	143	48	18
DF40U.205N-1750-18A	17.5	71	93	143	48	18
DF40U.205N-1760-18A	17.6	71	93	143	48	18
DF40U.205N-1770-18A	17.7	71	93	143	48	18
DF40U.205N-1780-18A	17.8	71	93	143	48	18
DF40U.205N-1790-18A	17.9	71	93	143	48	18
DF40U.205N-1800-18A	18	71	93	143	48	18
DF40U.205N-1810-20A	18.1	77	101	153	50	20
DF40U.205N-1820-20A	18.2	77	101	153	50	20
DF40U.205N-1830-20A	18.3	77	101	153	50	20
DF40U.205N-1840-20A	18.4	77	101	153	50	20
DF40U.205N-1850-20A	18.5	77	101	153	50	20
DF40U.205N-1860-20A	18.6	77	101	153	50	20
DF40U.205N-1870-20A	18.7	77	101	153	50	20
DF40U.205N-1880-20A	18.8	77	101	153	50	20
DF40U.205N-1890-20A	18.9	77	101	153	50	20
DF40U.205N-1900-20A	19	77	101	153	50	20
DF40U.205N-1905-20A	19.05	77	101	153	50	20
DF40U.205N-1910-20A	19.1	77	101	153	50	20
DF40U.205N-1920-20A	19.2	77	101	153	50	20
DF40U.205N-1930-20A	19.3	77	101	153	50	20
DF40U.205N-1940-20A	19.4	77	101	153	50	20
DF40U.205N-1950-20A	19.5	77	101	153	50	20
DF40U.205N-1960-20A	19.6	77	101	153	50	20
DF40U.205N-1970-20A	19.7	77	101	153	50	20
DF40U.205N-1980-20A	19.8	77	101	153	50	20
DF40U.205N-1990-20A	19.9	77	101	153	50	20
DF40U.205N-2000-20A	20	77	101	153	50	20

DF40U.208N – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 140° | m7 | 8XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.208N-0300-04A	3	28	34	74	36	4
DF40U.208N-0310-04A	3.1	28	34	74	36	4
DF40U.208N-0318-04A	3.18	28	34	74	36	4
DF40U.208N-0320-04A	3.2	28	34	74	36	4
DF40U.208N-0330-04A	3.3	28	34	74	36	4
DF40U.208N-0340-04A	3.4	28	34	74	36	4
DF40U.208N-0350-04A	3.5	28	34	74	36	4
DF40U.208N-0357-04A	3.57	28	34	74	36	4
DF40U.208N-0360-04A	3.6	28	34	74	36	4
DF40U.208N-0370-04A	3.7	28	34	74	36	4
DF40U.208N-0380-04A	3.8	37	45	85	36	4
DF40U.208N-0390-04A	3.9	37	45	85	36	4
DF40U.208N-0397-04A	3.97	37	45	85	36	4
DF40U.208N-0400-04A	4	37	45	85	36	4
DF40U.208N-0410-06A	4.1	37	45	85	36	6
DF40U.208N-0420-06A	4.2	37	45	85	36	6

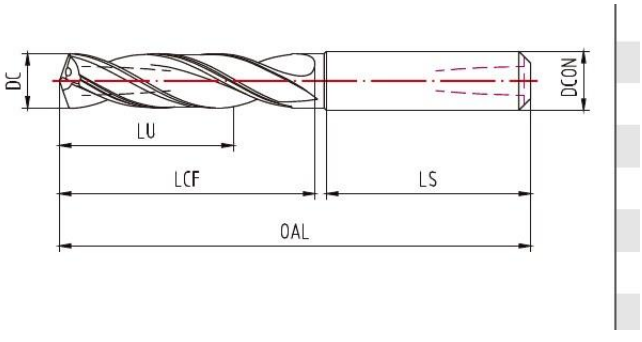
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.208N-0430-06A	4.3	37	45	85	36	6
DF40U.208N-0437-06A	4.37	37	45	85	36	6
DF40U.208N-0440-06A	4.4	37	45	85	36	6
DF40U.208N-0450-06A	4.5	37	45	85	36	6
DF40U.208N-0460-06A	4.6	37	45	85	36	6
DF40U.208N-0470-06A	4.7	37	45	85	36	6
DF40U.208N-0476-06A	4.76	48	57	97	36	6
DF40U.208N-0480-06A	4.8	48	57	97	36	6
DF40U.208N-0490-06A	4.9	48	57	97	36	6
DF40U.208N-0500-06A	5	48	57	97	36	6
DF40U.208N-0510-06A	5.1	48	57	97	36	6
DF40U.208N-0516-06A	5.16	48	57	97	36	6
DF40U.208N-0520-06A	5.2	48	57	97	36	6
DF40U.208N-0530-06A	5.3	48	57	97	36	6
DF40U.208N-0540-06A	5.4	48	57	97	36	6
DF40U.208N-0550-06A	5.5	48	57	97	36	6
DF40U.208N-0555-06A	5.55	48	57	97	36	6
DF40U.208N-0556-06A	5.56	48	57	97	36	6
DF40U.208N-0560-06A	5.6	48	57	97	36	6
DF40U.208N-0570-06A	5.7	48	57	97	36	6
DF40U.208N-0580-06A	5.8	48	57	97	36	6
DF40U.208N-0590-06A	5.9	48	57	97	36	6
DF40U.208N-0595-06A	5.95	48	57	97	36	6
DF40U.208N-0600-06A	6	48	57	97	36	6
DF40U.208N-0610-08A	6.1	55	66	106	36	8
DF40U.208N-0620-08A	6.2	55	66	106	36	8
DF40U.208N-0630-08A	6.3	55	66	106	36	8
DF40U.208N-0635-08A	6.35	55	66	106	36	8
DF40U.208N-0640-08A	6.4	55	66	106	36	8
DF40U.208N-0650-08A	6.5	55	66	106	36	8
DF40U.208N-0660-08A	6.6	55	66	106	36	8
DF40U.208N-0670-08A	6.7	55	66	106	36	8
DF40U.208N-0675-08A	6.75	55	66	106	36	8
DF40U.208N-0680-08A	6.8	55	66	106	36	8
DF40U.208N-0690-08A	6.9	55	66	106	36	8
DF40U.208N-0700-08A	7	55	66	106	36	8
DF40U.208N-0710-08A	7.1	64	76	116	36	8
DF40U.208N-0714-08A	7.14	64	76	116	36	8
DF40U.208N-0720-08A	7.2	64	76	116	36	8
DF40U.208N-0730-08A	7.3	64	76	116	36	8
DF40U.208N-0740-08A	7.4	64	76	116	36	8
DF40U.208N-0750-08A	7.5	64	76	116	36	8
DF40U.208N-0754-08A	7.54	64	76	116	36	8
DF40U.208N-0780-08A	7.8	64	76	116	36	8
DF40U.208N-0790-08A	7.9	64	76	116	36	8
DF40U.208N-0794-08A	7.94	64	76	116	36	8
DF40U.208N-0800-08A	8	64	76	116	36	8
DF40U.208N-0810-10A	8.1	80	95	139	40	10
DF40U.208N-0820-10A	8.2	80	95	139	40	10
DF40U.208N-0830-10A	8.3	80	95	139	40	10
DF40U.208N-0833-10A	8.33	80	95	139	40	10
DF40U.208N-0840-10A	8.4	80	95	139	40	10
DF40U.208N-0850-10A	8.5	80	95	139	40	10
DF40U.208N-0860-10A	8.6	80	95	139	40	10
DF40U.208N-0870-10A	8.7	80	95	139	40	10
DF40U.208N-0873-10A	8.73	80	95	139	40	10
DF40U.208N-0880-10A	8.8	80	95	139	40	10
DF40U.208N-0890-10A	8.9	80	95	139	40	10
DF40U.208N-0900-10A	9	80	95	139	40	10
DF40U.208N-0910-10A	9.1	80	95	139	40	10
DF40U.208N-0913-10A	9.13	80	95	139	40	10
DF40U.208N-0920-10A	9.2	80	95	139	40	10
DF40U.208N-0930-10A	9.3	80	95	139	40	10
DF40U.208N-0940-10A	9.4	80	95	139	40	10
DF40U.208N-0950-10A	9.5	80	95	139	40	10
DF40U.208N-0953-10A	9.53	80	95	139	40	10
DF40U.208N-0960-10A	9.6	80	95	139	40	10
DF40U.208N-0970-10A	9.7	80	95	139	40	10
DF40U.208N-0980-10A	9.8	80	95	139	40	10
DF40U.208N-0990-10A	9.9	80	95	139	40	10
DF40U.208N-0992-10A	9.92	80	95	139	40	10
DF40U.208N-1000-10A	10	80	95	139	40	10

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.208N-1010-12A	10.1	96	114	163	45	12
DF40U.208N-1020-12A	10.2	96	114	163	45	12
DF40U.208N-1030-12A	10.3	96	114	163	45	12
DF40U.208N-1032-12A	10.32	96	114	163	45	12
DF40U.208N-1040-12A	10.4	96	114	163	45	12
DF40U.208N-1050-12A	10.5	96	114	163	45	12
DF40U.208N-1060-12A	10.6	96	114	163	45	12
DF40U.208N-1070-12A	10.7	96	114	163	45	12
DF40U.208N-1072-12A	10.72	96	114	163	45	12
DF40U.208N-1080-12A	10.8	96	114	163	45	12
DF40U.208N-1090-12A	10.9	96	114	163	45	12
DF40U.208N-1100-12A	11	96	114	163	45	12
DF40U.208N-1110-12A	11.1	96	114	163	45	12
DF40U.208N-1111-12A	11.11	96	114	163	45	12
DF40U.208N-1120-12A	11.2	96	114	163	45	12
DF40U.208N-1130-12A	11.3	96	114	163	45	12
DF40U.208N-1140-12A	11.4	96	114	163	45	12
DF40U.208N-1150-12A	11.5	96	114	163	45	12
DF40U.208N-1151-12A	11.51	96	114	163	45	12
DF40U.208N-1160-12A	11.6	96	114	163	45	12
DF40U.208N-1170-12A	11.7	96	114	163	45	12
DF40U.208N-1180-12A	11.8	96	114	163	45	12
DF40U.208N-1190-12A	11.9	96	114	163	45	12
DF40U.208N-1191-12A	11.91	96	114	163	45	12
DF40U.208N-1200-12A	12	96	114	163	45	12
DF40U.208N-1230-14A	12.3	119	133	182	45	14
DF40U.208N-1250-14A	12.5	119	133	182	45	14
DF40U.208N-1270-14A	12.7	119	133	182	45	14
DF40U.208N-1300-14A	13	119	133	182	45	14
DF40U.208N-1349-14A	13.49	119	133	182	45	14
DF40U.208N-1350-14A	13.5	119	133	182	45	14
DF40U.208N-1400-14A	14	119	133	182	45	14
DF40U.208N-1429-16A	14.29	136	152	204	48	16
DF40U.208N-1450-16A	14.5	136	152	204	48	16
DF40U.208N-1500-16A	15	136	152	204	48	16
DF40U.208N-1550-16A	15.5	136	152	204	48	16
DF40U.208N-1588-16A	15.88	136	152	204	48	16
DF40U.208N-1600-16A	16	136	152	204	48	16
DF40U.208N-1650-18A	16.5	153	171	223	48	18
DF40U.208N-1700-18A	17	153	171	223	48	18
DF40U.208N-1750-18A	17.5	153	171	223	48	18
DF40U.208N-1800-18A	18	153	171	223	48	18
DF40U.208N-1850-20A	18.5	170	190	244	50	20
DF40U.208N-1900-20A	19	170	190	244	50	20
DF40U.208N-1905-20A	19.05	170	190	244	50	20
DF40U.208N-1950-20A	19.5	170	190	244	50	20
DF40U.208N-2000-20A	20	170	190	244	50	20

DF40U.212N – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 140° | m7 | 12XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.212N-0300-04A	3	48	54	92	36	4

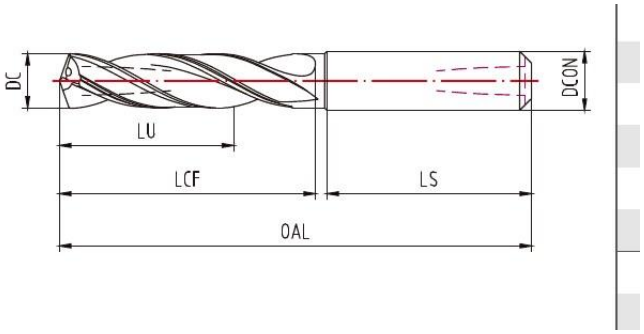
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.212N-0310-04A	3.1	48	54	92	36	4
DF40U.212N-0318-04A	3.18	48	54	92	36	4
DF40U.212N-0320-04A	3.2	48	54	92	36	4
DF40U.212N-0330-04A	3.3	48	54	92	36	4
DF40U.212N-0340-04A	3.4	48	54	92	36	4
DF40U.212N-0350-04A	3.5	48	54	92	36	4
DF40U.212N-0357-04A	3.57	48	54	92	36	4
DF40U.212N-0360-04A	3.6	48	54	92	36	4
DF40U.212N-0370-04A	3.7	48	54	92	36	4
DF40U.212N-0380-04A	3.8	56	64	102	36	4
DF40U.212N-0390-04A	3.9	56	64	102	36	4
DF40U.212N-0397-04A	3.97	56	64	102	36	4
DF40U.212N-0400-04A	4	56	64	102	36	4
DF40U.212N-0410-06A	4.1	56	64	102	36	6
DF40U.212N-0420-06A	4.2	56	64	102	36	6
DF40U.212N-0430-06A	4.3	56	64	102	36	6
DF40U.212N-0437-06A	4.37	56	64	102	36	6
DF40U.212N-0440-06A	4.4	56	64	102	36	6
DF40U.212N-0450-06A	4.5	56	64	102	36	6
DF40U.212N-0460-06A	4.6	56	64	102	36	6
DF40U.212N-0470-06A	4.7	56	64	102	36	6
DF40U.212N-0476-06A	4.76	74	83	121	36	6
DF40U.212N-0480-06A	4.8	74	83	121	36	6
DF40U.212N-0490-06A	4.9	74	83	121	36	6
DF40U.212N-0500-06A	5	74	83	121	36	6
DF40U.212N-0510-06A	5.1	74	83	121	36	6
DF40U.212N-0516-06A	5.16	74	83	121	36	6
DF40U.212N-0520-06A	5.2	74	83	121	36	6
DF40U.212N-0530-06A	5.3	74	83	121	36	6
DF40U.212N-0540-06A	5.4	74	83	121	36	6
DF40U.212N-0550-06A	5.5	74	83	121	36	6
DF40U.212N-0555-06A	5.55	74	83	121	36	6
DF40U.212N-0556-06A	5.56	74	83	121	36	6
DF40U.212N-0560-06A	5.6	74	83	121	36	6
DF40U.212N-0570-06A	5.7	74	83	121	36	6
DF40U.212N-0580-06A	5.8	74	83	121	36	6
DF40U.212N-0590-06A	5.9	74	83	121	36	6
DF40U.212N-0600-06A	6	74	83	121	36	6
DF40U.212N-0610-08A	6.1	98	110	148	36	8
DF40U.212N-0620-08A	6.2	98	110	148	36	8
DF40U.212N-0630-08A	6.3	98	110	148	36	8
DF40U.212N-0635-08A	6.35	98	110	148	36	8
DF40U.212N-0640-08A	6.4	98	110	148	36	8
DF40U.212N-0650-08A	6.5	98	110	148	36	8
DF40U.212N-0660-08A	6.6	98	110	148	36	8
DF40U.212N-0670-08A	6.7	98	110	148	36	8
DF40U.212N-0675-08A	6.75	98	110	148	36	8
DF40U.212N-0680-08A	6.8	98	110	148	36	8
DF40U.212N-0690-08A	6.9	98	110	148	36	8
DF40U.212N-0700-08A	7	98	110	148	36	8
DF40U.212N-0710-08A	7.1	98	110	148	36	8
DF40U.212N-0714-08A	7.14	98	110	148	36	8
DF40U.212N-0720-08A	7.2	98	110	148	36	8
DF40U.212N-0730-08A	7.3	98	110	148	36	8
DF40U.212N-0740-08A	7.4	98	110	148	36	8
DF40U.212N-0750-08A	7.5	98	110	148	36	8
DF40U.212N-0754-08A	7.54	98	110	148	36	8
DF40U.212N-0780-08A	7.8	98	110	148	36	8
DF40U.212N-0790-08A	7.9	98	110	148	36	8
DF40U.212N-0794-08A	7.94	98	110	148	36	8
DF40U.212N-0800-08A	8	98	110	148	36	8
DF40U.212N-0810-10A	8.1	123	138	180	40	10
DF40U.212N-0820-10A	8.2	123	138	180	40	10
DF40U.212N-0830-10A	8.3	123	138	180	40	10
DF40U.212N-0840-10A	8.4	123	138	180	40	10
DF40U.212N-0850-10A	8.5	123	138	180	40	10
DF40U.212N-0860-10A	8.6	123	138	180	40	10
DF40U.212N-0870-10A	8.7	123	138	180	40	10
DF40U.212N-0873-10A	8.73	123	138	180	40	10
DF40U.212N-0880-10A	8.8	123	138	180	40	10
DF40U.212N-0900-10A	9	123	138	180	40	10
DF40U.212N-0913-10A	9.13	123	138	180	40	10

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.212N-0920-10A	9.2	123	138	180	40	10
DF40U.212N-0930-10A	9.3	123	138	180	40	10
DF40U.212N-0950-10A	9.5	123	138	180	40	10
DF40U.212N-0953-10A	9.53	123	138	180	40	10
DF40U.212N-0960-10A	9.6	123	138	180	40	10
DF40U.212N-0970-10A	9.7	123	138	180	40	10
DF40U.212N-0980-10A	9.8	123	138	180	40	10
DF40U.212N-0992-10A	9.92	123	138	180	40	10
DF40U.212N-1000-10A	10	123	138	180	40	10
DF40U.212N-1010-12A	10.1	140	158	206	45	12
DF40U.212N-1020-12A	10.2	140	158	206	45	12
DF40U.212N-1030-12A	10.3	140	158	206	45	12
DF40U.212N-1032-12A	10.32	140	158	206	45	12
DF40U.212N-1040-12A	10.4	140	158	206	45	12
DF40U.212N-1050-12A	10.5	140	158	206	45	12
DF40U.212N-1072-12A	10.72	140	158	206	45	12
DF40U.212N-1080-12A	10.8	140	158	206	45	12
DF40U.212N-1100-12A	11	140	158	206	45	12
DF40U.212N-1110-12A	11.1	140	158	206	45	12
DF40U.212N-1111-12A	11.11	140	158	206	45	12
DF40U.212N-1120-12A	11.2	140	158	206	45	12
DF40U.212N-1150-12A	11.5	140	158	206	45	12
DF40U.212N-1151-12A	11.51	140	158	206	45	12
DF40U.212N-1170-12A	11.7	140	158	206	45	12
DF40U.212N-1180-12A	11.8	140	158	206	45	12
DF40U.212N-1191-12A	11.91	140	158	206	45	12
DF40U.212N-1200-12A	12	140	158	206	45	12
DF40U.212N-1210-14A	12.1	168	182	230	45	14
DF40U.212N-1220-14A	12.2	168	182	230	45	14
DF40U.212N-1230-14A	12.3	168	182	230	45	14
DF40U.212N-1250-14A	12.5	168	182	230	45	14
DF40U.212N-1260-14A	12.6	168	182	230	45	14
DF40U.212N-1270-14A	12.7	168	182	230	45	14
DF40U.212N-1300-14A	13	168	182	230	45	14
DF40U.212N-1349-14A	13.49	168	182	230	45	14
DF40U.212N-1350-14A	13.5	168	182	230	45	14
DF40U.212N-1400-14A	14	168	182	230	45	14
DF40U.212N-1429-16A	14.29	192	208	260	48	16
DF40U.212N-1450-16A	14.5	192	208	260	48	16
DF40U.212N-1500-16A	15	192	208	260	48	16
DF40U.212N-1550-16A	15.5	192	208	260	48	16
DF40U.212N-1588-16A	15.88	192	208	260	48	16
DF40U.212N-1600-16A	16	192	208	260	48	16
DF40U.212N-1650-18A	16.5	216	234	285	48	18
DF40U.212N-1700-18A	17	216	234	285	48	18
DF40U.212N-1750-18A	17.5	216	234	285	48	18
DF40U.212N-1800-18A	18	216	234	285	48	18
DF40U.212N-1850-20A	18.5	238	258	310	50	20
DF40U.212N-1900-20A	19	238	258	310	50	20
DF40U.212N-1950-20A	19.5	238	258	310	50	20
DF40U.212N-2000-20A	20	238	258	310	50	20

DF40U.216N – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 135° | h7 | 16XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)

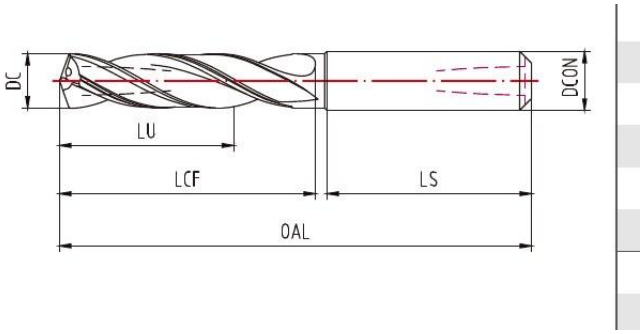


Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.216N-0300-04A	3	52	57	89	28	4
DF40U.216N-0318-04A	3.18	60	66	98	28	4
DF40U.216N-0350-04A	3.5	72	78	110	28	4
DF40U.216N-0357-04A	3.57	72	78	110	28	4
DF40U.216N-0397-04A	3.97	72	78	110	28	4
DF40U.216N-0400-04A	4	72	78	110	28	4
DF40U.216N-0450-06A	4.5	92	100	140	36	6
DF40U.216N-0476-06A	4.76	92	100	140	36	6
DF40U.216N-0480-06A	4.8	92	100	140	36	6
DF40U.216N-0500-06A	5	92	100	140	36	6
DF40U.216N-0550-06A	5.5	101	110	150	36	6
DF40U.216N-0556-06A	5.56	111	120	160	36	6
DF40U.216N-0580-06A	5.8	111	120	160	36	6
DF40U.216N-0600-06A	6	111	120	160	36	6
DF40U.216N-0610-08A	6.1	124	135	175	36	8
DF40U.216N-0635-08A	6.35	124	135	175	36	8
DF40U.216N-0650-08A	6.5	124	135	175	36	8
DF40U.216N-0680-08A	6.8	124	135	175	36	8
DF40U.216N-0700-08A	7	124	135	175	36	8
DF40U.216N-0714-08A	7.14	140	152	192	36	8
DF40U.216N-0740-08A	7.4	140	152	192	36	8
DF40U.216N-0750-08A	7.5	140	152	192	36	8
DF40U.216N-0794-08A	7.94	140	152	192	36	8
DF40U.216N-0800-08A	8	140	152	192	36	8
DF40U.216N-0830-10A	8.3	148	162	206	40	10
DF40U.216N-0850-10A	8.5	148	162	206	40	10
DF40U.216N-0873-10A	8.73	148	162	206	40	10
DF40U.216N-0900-10A	9	148	162	206	40	10
DF40U.216N-0953-10A	9.53	165	180	224	40	10
DF40U.216N-0980-10A	9.8	165	180	224	40	10
DF40U.216N-1000-10A	10	165	180	224	40	10
DF40U.216N-1020-12A	10.2	181	198	247	45	12
DF40U.216N-1032-12A	10.32	181	198	247	45	12
DF40U.216N-1100-12A	11	181	198	247	45	12
DF40U.216N-1111-12A	11.11	198	216	265	45	12
DF40U.216N-1150-12A	11.5	198	216	265	45	12
DF40U.216N-1180-12A	11.8	198	216	265	45	12
DF40U.216N-1191-12A	11.91	198	216	265	45	12
DF40U.216N-1200-12A	12	198	216	265	45	12
DF40U.216N-1270-14A	12.7	238	252	301	45	14
DF40U.216N-1300-14A	13	238	252	301	45	14
DF40U.216N-1400-14A	14	238	252	301	45	14
DF40U.216N-1429-16A	14.29	272	288	340	48	16
DF40U.216N-1500-16A	15	272	288	340	48	16
DF40U.216N-1600-16A	16	272	288	340	48	16

DF40U.220N – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 135° | h7 | 20XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



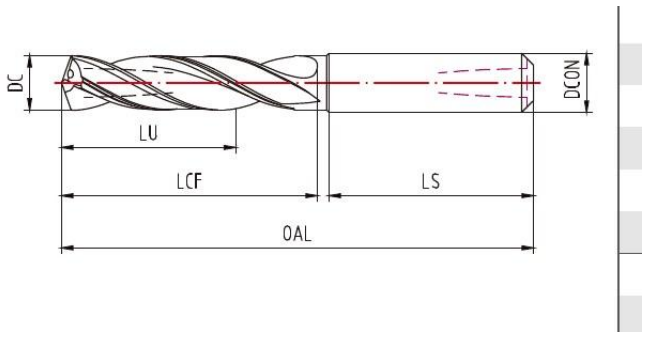
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.220N-0300-04A	3	60	65	97	28	4
DF40U.220N-0318-04A	3.18	74	80	112	28	4
DF40U.220N-0350-04A	3.5	86	92	124	28	4

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.220N-0357-04A	3.57	86	92	124	28	4
DF40U.220N-0397-04A	3.97	86	92	124	28	4
DF40U.220N-0400-04A	4	86	92	124	28	4
DF40U.220N-0450-06A	4.5	110	118	158	36	6
DF40U.220N-0476-06A	4.76	110	118	158	36	6
DF40U.220N-0480-06A	4.8	110	118	158	36	6
DF40U.220N-0500-06A	5	110	118	158	36	6
DF40U.220N-0550-06A	5.5	123	132	170	36	6
DF40U.220N-0556-06A	5.56	135	144	182	36	6
DF40U.220N-0580-06A	5.8	135	144	182	36	6
DF40U.220N-0600-06A	6	135	144	182	36	6
DF40U.220N-0610-08A	6.1	151	162	200	36	8
DF40U.220N-0635-08A	6.35	151	162	200	36	8
DF40U.220N-0650-08A	6.5	151	162	200	36	8
DF40U.220N-0680-08A	6.8	151	162	200	36	8
DF40U.220N-0700-08A	7	151	162	200	36	8
DF40U.220N-0714-08A	7.14	172	184	222	36	8
DF40U.220N-0740-08A	7.4	172	184	222	36	8
DF40U.220N-0750-08A	7.5	172	184	222	36	8
DF40U.220N-0794-08A	7.94	172	184	222	36	8
DF40U.220N-0800-08A	8	172	184	222	36	8
DF40U.220N-0830-10A	8.3	184	198	240	40	10
DF40U.220N-0850-10A	8.5	184	198	240	40	10
DF40U.220N-0873-10A	8.73	184	198	240	40	10
DF40U.220N-0900-10A	9	184	198	240	40	10
DF40U.220N-0953-10A	9.53	205	220	262	40	10
DF40U.220N-0980-10A	9.8	205	220	262	40	10
DF40U.220N-1000-10A	10	205	220	262	40	10
DF40U.220N-1020-12A	10.2	225	242	289	45	12
DF40U.220N-1032-12A	10.32	225	242	289	45	12
DF40U.220N-1100-12A	11	225	242	289	45	12
DF40U.220N-1111-12A	11.11	246	264	311	45	12
DF40U.220N-1150-12A	11.5	246	264	311	45	12
DF40U.220N-1180-12A	11.8	246	264	311	45	12
DF40U.220N-1191-12A	11.91	246	264	311	45	12
DF40U.220N-1200-12A	12	246	264	311	45	12
DF40U.220N-1270-14A	12.7	294	308	357	45	14
DF40U.220N-1300-14A	13	294	308	357	45	14
DF40U.220N-1400-14A	14	294	308	357	45	14
DF40U.220N-1429-16A	14.29	336	352	404	48	16
DF40U.220N-1500-16A	15	336	352	404	48	16
DF40U.220N-1600-16A	16	336	352	404	48	16

DF40U.225N – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 135° | h7 | 25XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



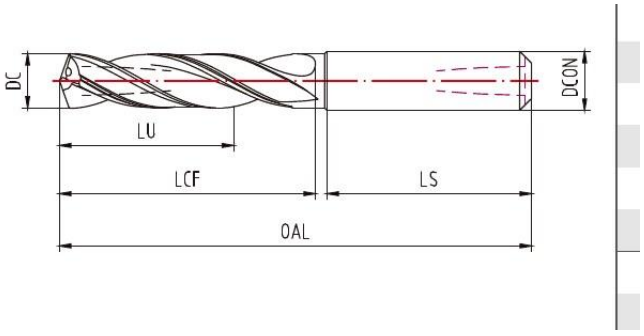
Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.225N-0300-04A	3	79	84	119	28	4
DF40U.225N-0318-04A	3.18	96	102	148	28	4
DF40U.225N-0350-04A	3.5	108	114	148	28	4
DF40U.225N-0357-04A	3.57	108	114	148	28	4
DF40U.225N-0397-04A	3.97	108	114	148	28	4
DF40U.225N-0400-04A	4	108	114	148	28	4

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.225N-0450-06A	4.5	138	145	185	36	6
DF40U.225N-0476-06A	4.76	138	145	185	36	6
DF40U.225N-0480-06A	4.8	138	145	185	36	6
DF40U.225N-0500-06A	5	138	145	185	36	6
DF40U.225N-0550-06A	5.5	151	160	200	36	6
DF40U.225N-0556-06A	5.56	165	174	214	36	6
DF40U.225N-0580-06A	5.8	165	174	214	36	6
DF40U.225N-0600-06A	6	165	174	214	36	6
DF40U.225N-0610-08A	6.1	183	194	234	36	8
DF40U.225N-0635-08A	6.35	183	194	234	36	8
DF40U.225N-0650-08A	6.5	183	194	234	36	8
DF40U.225N-0680-08A	6.8	183	194	234	36	8
DF40U.225N-0700-08A	7	183	194	234	36	8
DF40U.225N-0714-08A	7.14	208	220	260	36	8
DF40U.225N-0740-08A	7.4	208	220	260	36	8
DF40U.225N-0750-08A	7.5	208	220	260	36	8
DF40U.225N-0794-08A	7.94	208	220	260	36	8
DF40U.225N-0800-08A	8	208	220	260	36	8
DF40U.225N-0830-10A	8.3	229	243	289	40	10
DF40U.225N-0850-10A	8.5	229	243	289	40	10
DF40U.225N-0873-10A	8.73	229	243	289	40	10
DF40U.225N-0900-10A	9	229	243	289	40	10
DF40U.225N-0953-10A	9.53	257	270	314	40	10
DF40U.225N-0980-10A	9.8	257	270	314	40	10
DF40U.225N-1000-10A	10	257	270	314	40	10
DF40U.225N-1020-12A	10.2	280	297	346	45	12
DF40U.225N-1032-12A	10.32	280	297	346	45	12
DF40U.225N-1100-12A	11	280	297	346	45	12
DF40U.225N-1111-12A	11.11	306	324	373	45	12
DF40U.225N-1150-12A	11.5	306	324	373	45	12
DF40U.225N-1180-12A	11.8	306	324	373	45	12
DF40U.225N-1191-12A	11.91	306	324	373	45	12
DF40U.225N-1200-12A	12	306	324	373	45	12

DF40U.230N – Multi-Material Universal Drill

Key data: ECU (economical universal tool) | 135° | h7 | 30XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N ○ S ○ H □ C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.230N-0300-04A	3	92	97	132	28	4
DF40U.230N-0318-04A	3.18	114	120	166	28	4
DF40U.230N-0350-04A	3.5	127	133	166	28	4
DF40U.230N-0357-04A	3.57	127	133	166	28	4
DF40U.230N-0397-04A	3.97	127	133	166	28	4
DF40U.230N-0400-04A	4	127	133	166	28	4
DF40U.230N-0450-06A	4.5	162	169	208	36	6
DF40U.230N-0476-06A	4.76	162	169	208	36	6
DF40U.230N-0480-06A	4.8	162	169	208	36	6
DF40U.230N-0500-06A	5	162	169	208	36	6
DF40U.230N-0550-06A	5.5	178	187	225	36	6
DF40U.230N-0556-06A	5.56	195	204	242	36	6
DF40U.230N-0580-06A	5.8	195	204	242	36	6
DF40U.230N-0600-06A	6	195	204	242	36	6
DF40U.230N-0610-08A	6.1	217	228	268	36	8

Ordering code	Dimension (mm)					
	DC	LU	LCF	OAL	LS	DCON
DF40U.230N-0635-08A	6.35	217	228	268	36	8
DF40U.230N-0650-08A	6.5	217	228	268	36	8
DF40U.230N-0680-08A	6.8	217	228	268	36	8
DF40U.230N-0700-08A	7	217	228	268	36	8
DF40U.230N-0714-08A	7.14	244	256	294	36	8
DF40U.230N-0740-08A	7.4	244	256	294	36	8
DF40U.230N-0750-08A	7.5	244	256	294	36	8
DF40U.230N-0794-08A	7.94	244	256	294	36	8
DF40U.230N-0800-08A	8	244	256	294	36	8
DF40U.230N-0830-10A	8.3	273	287	330	40	10
DF40U.230N-0850-10A	8.5	273	287	330	40	10
DF40U.230N-0873-10A	8.73	273	287	330	40	10
DF40U.230N-0900-10A	9	273	287	330	40	10
DF40U.230N-0953-10A	9.53	305	320	364	40	10
DF40U.230N-0980-10A	9.8	305	320	364	40	10
DF40U.230N-1000-10A	10	305	320	364	40	10
DF40U.230N-1020-12A	10.2	335	352	401	45	12
DF40U.230N-1032-12A	10.32	335	352	401	45	12
DF40U.230N-1100-12A	11	335	352	401	45	12
DF40U.230N-1111-12A	11.11	364	382	430	45	12
DF40U.230N-1150-12A	11.5	364	382	430	45	12
DF40U.230N-1180-12A	11.8	364	382	430	45	12
DF40U.230N-1191-12A	11.91	364	382	430	45	12
DF40U.230N-1200-12A	12	364	382	430	45	12

Notes

Notes: ① For requirements outside the catalogue range (special diameters, length-to-diameter ratios, etc.), non-standard custom tools are available.

② For cutting data, refer to the last page of this section of the catalogue.

③ ECU: universal-series tool

Cutting Data

Material group			Material	Strength / hardness [N/mm²] [HRC]	Cutting speed Vc [m/min]				Feed fr [mm/rev] by drill diameter (mm)					
					Internal coolant	External coolant	MQL (oil mist)	Air	3	4.5	6.5	9.5	14	16
P	P1	P1.1	Non-alloy structural steel, free-cutting structural steel, case-hardening steel and quenched & tempered steel	<700	150	135	135		0.10	0.13	0.16	0.21	0.27	0.33
		P1.2	Non-alloy structural steel, free-cutting structural steel, case-hardening steel and quenched & tempered steel	<1200	135	115	115		0.13	0.16	0.21	0.27	0.34	0.41
	P2	P2.1	Alloy case-hardening steel, case-hardening steel and quenched & tempered steel	<900	150	130	130		0.12	0.15	0.19	0.25	0.32	0.39
		P2.2	Alloy case-hardening steel, case-hardening steel and quenched & tempered steel	<1400	105	90	90		0.10	0.13	0.16	0.2	0.26	0.31
	P3	P3.1	Tool steel, bearing steel, spring steel and high-speed steel	<900	115	100	100		0.11	0.14	0.17	0.23	0.29	0.35
		P3.2	Tool steel, bearing steel, spring steel and high-speed steel	<1500	90	85	85		0.09	0.12	0.15	0.19	0.24	0.29
	P4	P4.1	Ferritic and martensitic stainless steel		70	55	60		0.07	0.09	0.12	0.15	0.19	0.23
	P5	P5.1	Cast steel		150	130	130		0.12	0.15	0.19	0.25	0.32	0.39
	P6	P6.1	Ferritic and martensitic stainless cast steel		70	55	60		0.07	0.09	0.12	0.15	0.19	0.23
M	M1	M1.1	Austenitic stainless steel	<700	60	50	50		0.06	0.08	0.10	0.14	0.17	0.21
		M1.2	Ferritic/austenitic (duplex) stainless steel	<1000	75	45	45		0.05	0.07	0.09	0.12	0.15	0.18
	M2	M2.1	Austenitic stainless cast steel	<700	80	50	50		0.06	0.08	0.10	0.14	0.17	0.21
	M3	M3.1	Ferritic/austenitic (duplex) stainless cast steel	<1000	75	45	45		0.05	0.07	0.09	0.12	0.15	0.18
K	K1	K1.1	Lamellar graphite cast iron (grey cast iron), GJL	<300	150	105	105	105	0.12	0.17	0.23	0.31	0.41	0.50
	K2	K2.1	Spheroidal graphite (ductile) cast iron, GJS	<500	200	125	150	150	0.13	0.17	0.22	0.29	0.38	0.46
		K2.2	Spheroidal graphite (ductile) cast iron, GJS	500-800	125	95	95		0.11	0.15	0.19	0.25	0.32	0.40
		K2.3	Spheroidal graphite (ductile) cast iron, GJS	>800										
	K3	K3.1	Vermicular graphite (compacted graphite) cast iron, GJV; malleable cast iron, GJM	<500	115	100	100		0.12	0.16	0.21	0.27	0.35	0.43
		K3.2	Vermicular graphite (compacted graphite) cast iron, GJV; malleable cast iron, GJM	>500	100	90	90		0.11	0.13	0.17	0.22	0.28	0.34
N	N1	N1.1	Non-alloy and alloy aluminium <3% Si		170	215			0.03	0.03	0.04	0.05	0.07	0.1
		N1.2	Aluminium alloys ≤7% Si		155	170			0.03	0.04	0.05	0.06	0.09	0.12
		N1.3	Aluminium alloys >7–12% Si		130	155			0.03	0.04	0.05	0.06	0.09	0.12
		N1.4	Aluminium alloys >12% Si		100	130			0.03	0.04	0.05	0.06	0.09	0.12
	N2	N2.1	Non-alloy and low-alloy copper	<300	85				0.03	0.03	0.04	0.05	0.07	0.1
		N2.2	Copper alloys	>300	75				0.03	0.04	0.05	0.06	0.09	0.12
		N2.3	Brass, bronze, red copper	<1200	135	135			0.03	0.03	0.05	0.07	0.1	0.15
S	S1	S1.1	Titanium, titanium alloys	<400	40	25			0.06	0.08	0.1	0.14	0.17	0.21
	S2	S2.1	Titanium, titanium alloys	<1200	30	20			0.05	0.07	0.09	0.12	0.15	0.18
		S2.2	Titanium, titanium alloys	>1200	25	15			0.05	0.06	0.07	0.1	0.12	0.15
	S3	S3.1	Non-alloy and alloy nickel	<900	20	15			0.04	0.05	0.06	0.08	0.1	0.12
		S3.2	Non-alloy and alloy nickel	>900	15	10			0.05	0.06	0.07	0.1	0.12	0.15
	S4	S4.1	Nickel-, cobalt*- and iron-based heat-resistant superalloys		15	10			0.04	0.05	0.06	0.08	0.1	0.12
		S4.2	Tungsten alloys and aluminium alloys		15	10			0.04	0.05	0.06	0.08	0.1	0.12
H	H1	H1.1	Hardened steel / cast steel	40-45HRC	25	25	25		0.05	0.06	0.08	0.1	0.13	0.16
		H1.2	Hardened steel / cast steel	45-50HRC										
		H1.3	Hardened steel / cast steel	50-55HRC										
	H2	H2.1	Wear-resistant cast iron / chilled cast iron, GJN											

- Recommended minimum through-coolant pressure: 20 bar
- When machining with external coolant, reduce the feed per revolution if necessary to ensure smooth chip evacuation

Various non-standard solutions available

Scope of non-standard customization

- All intermediate drill diameters
- All intermediate drilling depths
- Point angle 120–150°
- Hole tolerance ≥ IT8
- Optimization of drill-point geometry, e.g. cutting-edge preparation and point chamfering

Contact us for customized tooling (“Custom”).

Contact

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

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- Tel: +86-512-63060818
- E-mail: ypp@yp-tec.com
- Website: www.yp-tec.com

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

WFP

High-Performance Carbide Drill for Wheel Hub Units



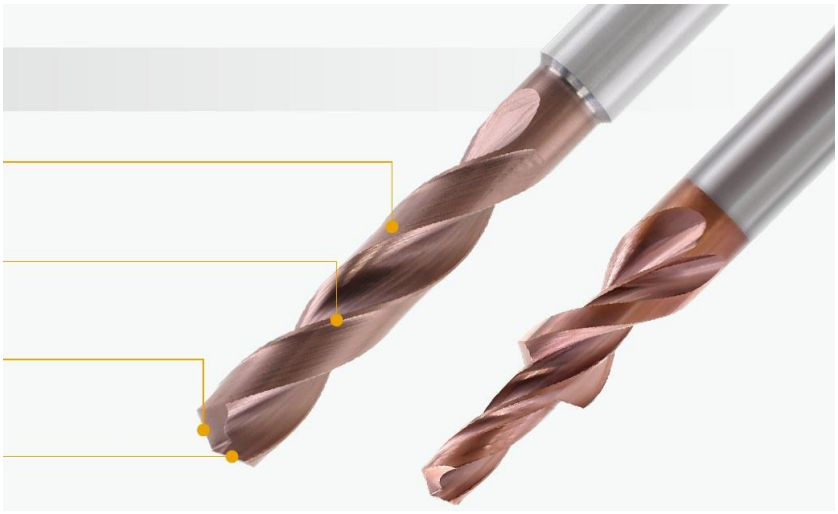
Product line	YPP Drill® – solid carbide drills
Types	Twist drill and step drill, external coolant
Application	Automotive wheel hub units (ISO-P steel)

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Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

Tool Design Features



- **High-performance customized coating** – low thermal conductivity and high wear resistance
- **Reinforced margin treatment, optimized margin strength** – improves tool stability after regrinding
- **Curved clearance and crescent-shaped cutting-edge design** – reduces cutting forces and improves chip breaking
- **Special drill-point treatment, lower cutting resistance** – reduces the risk of work hardening of the hole wall

Applications

Workpiece materials: first choice for ISO-P steel workpieces; complementary choice for ISO-K cast iron and ISO-M stainless steel.

Industries: first choice for wheel hub unit products in the automotive industry; complementary choice for the general machinery, die & mould and energy industries.

Ordering Code

Twist drill

WFP	2	03	W	0900	10	01	RA	H
1	2	3	4	5	6	7	8	9

Pos.	Code	Meaning
1	WFP	Product series
2	2	2 = 2 flutes (cutting edges)
3	03	03 = 3×D
4	W	W = external coolant
5	0900	0900 = drill diameter DC 9 mm
6	10	10 = shank diameter
7	01	01 = substrate grade AK40
8	RA	R = right-hand helix, right-hand cutting / A = HA cylindrical shank
9	H	H = coating

Step drill

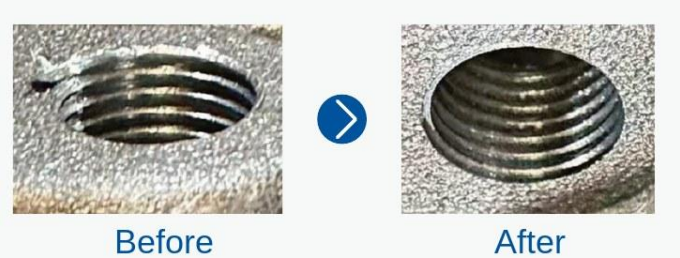
WFP	0900	16,00	C45	12A	W	2	H
1	2	3	4	5	6	7	8

Pos.	Code	Meaning

Pos.	Code	Meaning
1	WFP	Product series
2	0900	0900 = drill diameter DC 9 mm
3	16,00	16,00 = step length
4	C45	C45 = chamfer angle
5	12A	12 = shank diameter / A = cylindrical straight shank
6	W	W = external coolant
7	2	2 = number of steps
8	H	H = coating

Special Requirements

Where exit burrs are a concern, an optimized drill-point geometry can be selected to suppress the formation of exit burrs and reduce deburring problems. For special requirements, please request a non-standard custom tool.



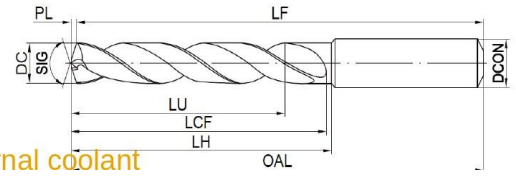
Before (left) and after (right) the improvement

Standard Specifications

Twist drill



Shank tolerance: h6 SIG: 140°
Max. regrinds: 5

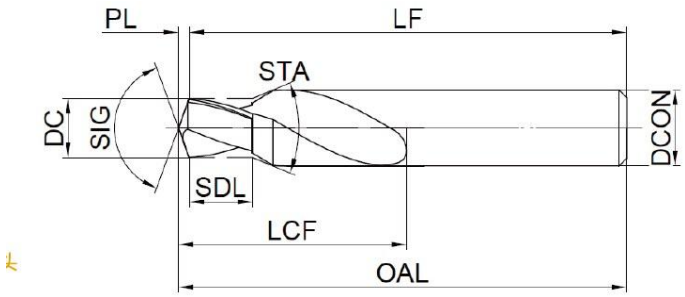


External coolant

Shank diameter tolerance: h6 | SIG: 140° | Maximum number of regrinds: 5 | External-coolant drill

Ordering code	Dimension (mm)					L/D ratio	Stock
	DC	LU	LCF	OAL	DCON	ULDR	
WFP203W-0510-06-01RA-H	5.1	16.1	28	66	6	3	●
WFP203W-0680-08-01RA-H	6.8	21.5	34	79	8	3	●
WFP203W-0860-10-01RA-H	8.6	27.2	47	89	10	3	●
WFP203W-1030-12-01RA-H	10.3	32.6	55	102	12	3	●
WFP203W-1060-12-01RA-H	10.6	33.5	55	102	12	3	●
WFP203W-1080-12-01RA-H	10.8	34.2	55	102	12	3	●
WFP203W-1200-12-01RA-H	12	38	55	102	12	3	●
WFP203W-1260-14-01RA-H	12.6	39.9	60	107	14	3	●

Step drill



Shank diameter tolerance: h6 | SIG: 140° | Maximum number of regrinds: 5 | External-coolant drill

Ordering code	Dimension (mm)					Stock
	DC	SDL	LCF	OAL	DCON	
WFP-0510-16,00C45-08AW2-H	5.1	16	28	66	8	○
WFP-0680-16,00C45-10AW2-H	6.8	16	37	79	10	○
WFP-0860-16,00C45-12AW2-H	8.6	16	42	89	12	○
WFP-1030-16,00C45-14AW2-H	10.3	16	55	102	14	○
WFP-1060-16,00C45-14AW2-H	10.6	16	55	102	14	○
WFP-1080-16,00C45-14AW2-H	10.8	16	55	102	14	○
WFP-1200-16,00C45-16AW2-H	12	16	57	107	16	○
WFP-1260-16,00C45-16AW2-H	12.6	16	57	107	16	○

Note: ● – standard item in stock. (○ is not defined in the original legend; it presumably indicates a non-stock item.)

Success Case

The automotive wheel hub unit is the drive-line component connecting the vehicle suspension and the wheel. Its main functions are to carry the weight of the vehicle and to provide precise guidance for the rotation of the hub. The hub unit bears both radial and axial loads and is a critical safety component.



Automotive wheel hub unit

Workpiece information and machining requirements

Item	Details
Workpiece	Wheel hub unit
Workpiece material	1055 steel, HB280
Operation	Drill 5 × M12×1.25 tapped-hole pilot holes to D10.8; through-hole depth 12 mm
Machine	Domestic vertical machining centre, spindle BT40
Cooling	Emulsion, external coolant
Tool holder	ER collet chuck
Tool	D10.8 twist drill

Parameter	Competitor (domestic brand)	Yongpu (D10.8*46*L93*SD12, DH)
N (rpm)	S1800	S1800
VC (m/min)	61	61
VF (mm/min)	F380	F380
Fn (mm/r)	0.21	0.21
Tool life (holes)	6000 holes	9000 holes
Tool life (m)	72	108
Result	**Yongpu tool life increased by 50%; better cost-performance than the competitor!**	

Contact

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

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- Website: www.yp-tec.com

Suzhou Yongpu Precision Technology Co., Ltd.

Solid Round Tools | One-stop Machining Solution

YPP Drill®

YMD20PR

Burr-Suppressing (Burrless) Carbide Drill



Product line	YPP Drill® – solid carbide drills
Application	Drilling with exit-burr suppression
Drilling depth	3×Dc, 5×Dc

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Solid Round Tools | One-stop Machining Solution

One-stop service | Non-standard customization | Backed by more than a century of technical expertise

Technical Features



- Special chisel-edge design
- Wide chip evacuation space
- Large corner radius at the outer edge
- Crescent-shaped cutting edge

Applications

Drilling solution for exit-burr suppression

- Point angle: 140°
- Drilling depth: 3×Dc, 5×Dc
- Internal (through-coolant) and external coolant solutions available
- Achievable hole tolerance: IT8–9
- Carbide substrate
- Bronze-coloured composite nano-coating

Ordering Code

YMD20PR	2	03	W	0800	08	A	DH
1	2	3	4	5	6	7	8

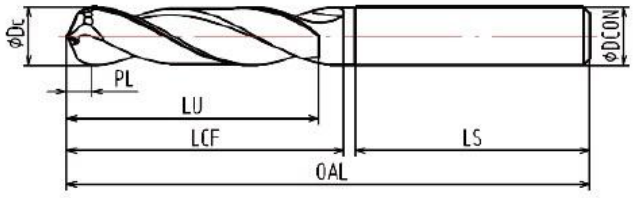
Pos.	Code	Meaning
1	YMD20PR	Product series
2	2	Number of cutting edges: 2 = two cutting edges
3	03	Drilling depth: 03 = 3×Dc, 05 = 5×Dc
4	W	Coolant type: W = external coolant, N = internal (through) coolant
5	0800	Cutting diameter: 0800 = Φ8.00
6	08	Shank diameter: 08 = Φ8
7	A	Shank type: A = cylindrical shank
8	DH	Coating: DH = DH coating

Product Range

YMD20PR.203W – Burrless Carbide Drill

Key data: SP (special-purpose tool) | m7 | 3XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.203W-0300-04A-DH	3	1.4	14	20	62	40	4
YMD20PR.203W-0310-04A-DH	3.1	1.4	14	20	62	40	4
YMD20PR.203W-0320-04A-DH	3.2	1.4	14	20	62	40	4
YMD20PR.203W-0330-04A-DH	3.3	1.5	14	20	62	40	4
YMD20PR.203W-0340-04A-DH	3.4	1.5	14	20	62	40	4
YMD20PR.203W-0350-04A-DH	3.5	1.6	14	20	62	40	4
YMD20PR.203W-0360-04A-DH	3.6	1.6	14	20	62	40	4
YMD20PR.203W-0370-04A-DH	3.7	1.7	14	20	62	40	4
YMD20PR.203W-0380-04A-DH	3.8	1.7	17	24	66	40	4
YMD20PR.203W-0390-04A-DH	3.9	1.8	17	24	66	40	4
YMD20PR.203W-0400-04A-DH	4	1.8	17	24	66	40	4
YMD20PR.203W-0410-06A-DH	4.1	1.8	17	24	66	40	6
YMD20PR.203W-0420-06A-DH	4.2	1.9	17	24	66	40	6
YMD20PR.203W-0430-06A-DH	4.3	1.9	17	24	66	40	6
YMD20PR.203W-0440-06A-DH	4.4	2.0	17	24	66	40	6
YMD20PR.203W-0450-06A-DH	4.5	2.0	17	24	66	40	6
YMD20PR.203W-0460-06A-DH	4.6	2.1	17	24	66	40	6
YMD20PR.203W-0470-06A-DH	4.7	2.1	20	28	66	36	6
YMD20PR.203W-0480-06A-DH	4.8	2.2	20	28	66	36	6
YMD20PR.203W-0490-06A-DH	4.9	2.2	20	28	66	36	6
YMD20PR.203W-0500-06A-DH	5	2.3	20	28	66	36	6
YMD20PR.203W-0510-06A-DH	5.1	2.3	20	28	66	36	6
YMD20PR.203W-0520-06A-DH	5.2	2.3	20	28	66	36	6
YMD20PR.203W-0530-06A-DH	5.3	2.4	20	28	66	36	6
YMD20PR.203W-0540-06A-DH	5.4	2.4	20	28	66	36	6
YMD20PR.203W-0550-06A-DH	5.5	2.5	20	28	66	36	6
YMD20PR.203W-0560-06A-DH	5.6	2.5	20	28	66	36	6
YMD20PR.203W-0570-06A-DH	5.7	2.6	20	28	66	36	6
YMD20PR.203W-0580-06A-DH	5.8	2.6	20	28	66	36	6
YMD20PR.203W-0590-06A-DH	5.9	2.7	20	28	66	36	6
YMD20PR.203W-0600-06A-DH	6	2.7	20	28	66	36	6
YMD20PR.203W-0610-08A-DH	6.1	2.7	24	34	79	40	8
YMD20PR.203W-0620-08A-DH	6.2	2.8	24	34	79	40	8
YMD20PR.203W-0630-08A-DH	6.3	2.8	24	34	79	40	8
YMD20PR.203W-0640-08A-DH	6.4	2.9	24	34	79	40	8
YMD20PR.203W-0650-08A-DH	6.5	2.9	24	34	79	40	8
YMD20PR.203W-0660-08A-DH	6.6	3.0	24	34	79	40	8
YMD20PR.203W-0670-08A-DH	6.7	3.0	24	34	79	40	8
YMD20PR.203W-0680-08A-DH	6.8	3.1	24	34	79	40	8
YMD20PR.203W-0690-08A-DH	6.9	3.1	24	34	79	40	8
YMD20PR.203W-0700-08A-DH	7.0	3.2	24	34	79	40	8
YMD20PR.203W-0710-08A-DH	7.1	3.2	29	41	79	40	8
YMD20PR.203W-0720-08A-DH	7.2	3.2	29	41	79	40	8
YMD20PR.203W-0730-08A-DH	7.3	3.3	29	41	79	40	8
YMD20PR.203W-0740-08A-DH	7.4	3.3	29	41	79	40	8
YMD20PR.203W-0750-08A-DH	7.5	3.4	29	41	79	40	8
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YMD20PR.203W-0790-08A-DH	7.9	3.6	29	41	79	40	8
YMD20PR.203W-0800-08A-DH	8.0	3.6	29	41	79	40	8
YMD20PR.203W-0810-10A-DH	8.1	3.6	35	47	89	40	10
YMD20PR.203W-0820-10A-DH	8.2	3.7	35	47	89	36	10
YMD20PR.203W-0830-10A-DH	8.3	3.7	35	47	89	36	10

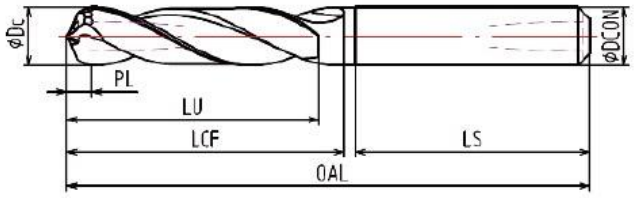
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YMD20PR.203W-0860-10A-DH	8.6	3.9	35	47	89	36	10
YMD20PR.203W-0870-10A-DH	8.7	3.9	35	47	89	36	10
YMD20PR.203W-0880-10A-DH	8.8	4.0	35	47	89	36	10
YMD20PR.203W-0890-10A-DH	8.9	4.0	35	47	89	36	10
YMD20PR.203W-0900-10A-DH	9.0	4.1	35	47	89	36	10
YMD20PR.203W-0910-10A-DH	9.1	4.1	35	47	89	36	10
YMD20PR.203W-0920-10A-DH	9.2	4.1	35	47	89	36	10
YMD20PR.203W-0930-10A-DH	9.3	4.2	35	47	89	36	10
YMD20PR.203W-0940-10A-DH	9.4	4.2	35	47	89	36	10
YMD20PR.203W-0950-10A-DH	9.5	4.3	35	47	89	36	10
YMD20PR.203W-0960-10A-DH	9.6	4.3	35	47	89	40	10
YMD20PR.203W-0970-10A-DH	9.7	4.4	35	47	89	40	10
YMD20PR.203W-0980-10A-DH	9.8	4.4	35	47	89	40	10
YMD20PR.203W-0990-10A-DH	9.9	4.5	35	47	89	40	10
YMD20PR.203W-1000-10A-DH	10	4.5	35	47	89	40	10
YMD20PR.203W-1010-12A-DH	10.1	4.5	40	55	102	45	12
YMD20PR.203W-1020-12A-DH	10.2	4.6	40	55	102	45	12
YMD20PR.203W-1030-12A-DH	10.3	4.6	40	55	102	45	12
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YMD20PR.203W-1100-12A-DH	11	5.0	40	55	102	45	12
YMD20PR.203W-1110-12A-DH	11.1	5.0	40	55	102	45	12
YMD20PR.203W-1120-12A-DH	11.2	5.0	40	55	102	45	12
YMD20PR.203W-1130-12A-DH	11.3	5.1	40	55	102	45	12
YMD20PR.203W-1140-12A-DH	11.4	5.1	40	55	102	45	12
YMD20PR.203W-1150-12A-DH	11.5	5.2	40	55	102	45	12
YMD20PR.203W-1160-12A-DH	11.6	5.2	40	55	102	45	12
YMD20PR.203W-1170-12A-DH	11.7	5.3	40	55	102	45	12
YMD20PR.203W-1180-12A-DH	11.8	5.3	40	55	102	45	12
YMD20PR.203W-1190-12A-DH	11.9	5.4	40	55	102	45	12
YMD20PR.203W-1200-12A-DH	12	5.4	40	55	102	45	12
YMD20PR.203W-1210-14A-DH	12.1	5.4	43	60	107	45	14
YMD20PR.203W-1220-14A-DH	12.2	5.5	43	60	107	45	14
YMD20PR.203W-1230-14A-DH	12.3	5.5	43	60	107	45	14
YMD20PR.203W-1240-14A-DH	12.4	5.6	43	60	107	45	14
YMD20PR.203W-1250-14A-DH	12.5	5.6	43	60	107	45	14
YMD20PR.203W-1260-14A-DH	12.6	5.7	43	60	107	45	14
YMD20PR.203W-1270-14A-DH	12.7	5.7	43	60	107	45	14
YMD20PR.203W-1280-14A-DH	12.8	5.8	43	60	107	45	14
YMD20PR.203W-1290-14A-DH	12.9	5.8	43	60	107	45	14
YMD20PR.203W-1300-14A-DH	13	5.9	43	60	107	45	14
YMD20PR.203W-1310-14A-DH	13.1	5.9	43	60	107	45	14
YMD20PR.203W-1320-14A-DH	13.2	5.9	43	60	107	45	14
YMD20PR.203W-1330-14A-DH	13.3	6.0	43	60	107	45	14
YMD20PR.203W-1340-14A-DH	13.4	6.0	43	60	107	45	14
YMD20PR.203W-1350-14A-DH	13.5	6.1	43	60	107	45	14
YMD20PR.203W-1360-14A-DH	13.6	6.1	43	60	107	45	14
YMD20PR.203W-1370-14A-DH	13.7	6.2	43	60	107	45	14
YMD20PR.203W-1380-14A-DH	13.8	6.2	43	60	107	45	14
YMD20PR.203W-1390-14A-DH	13.9	6.3	43	60	107	45	14
YMD20PR.203W-1400-14A-DH	14	6.3	43	60	107	45	14
YMD20PR.203W-1410-16A-DH	14.1	6.3	45	65	115	48	16
YMD20PR.203W-1420-16A-DH	14.2	6.4	45	65	115	48	16
YMD20PR.203W-1430-16A-DH	14.3	6.4	45	65	115	48	16
YMD20PR.203W-1440-16A-DH	14.4	6.5	45	65	115	48	16
YMD20PR.203W-1450-16A-DH	14.5	6.5	45	65	115	48	16
YMD20PR.203W-1460-16A-DH	14.6	6.6	45	65	115	48	16
YMD20PR.203W-1470-16A-DH	14.7	6.6	45	65	115	48	16
YMD20PR.203W-1480-16A-DH	14.8	6.7	45	65	115	48	16
YMD20PR.203W-1490-16A-DH	14.9	6.7	45	65	115	48	16
YMD20PR.203W-1500-16A-DH	15	6.8	45	65	115	48	16
YMD20PR.203W-1510-16A-DH	15.1	6.8	45	65	115	48	16
YMD20PR.203W-1520-16A-DH	15.2	6.8	45	65	115	48	16
YMD20PR.203W-1530-16A-DH	15.3	6.9	45	65	115	48	16
YMD20PR.203W-1540-16A-DH	15.4	6.9	45	65	115	48	16
YMD20PR.203W-1550-16A-DH	15.5	7.0	45	65	115	48	16

Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.203W-1560-16A-DH	15.6	7.0	45	65	115	48	16
YMD20PR.203W-1570-16A-DH	15.7	7.1	45	65	115	48	16
YMD20PR.203W-1580-16A-DH	15.8	7.1	45	65	115	48	16
YMD20PR.203W-1590-16A-DH	15.9	7.2	45	65	115	48	16
YMD20PR.203W-1600-16A-DH	16	7.2	45	65	115	48	16

YMD20PR.203N – Burrless Carbide Drill

Key data: SP (special-purpose tool) | m7 | 3XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.203N-0300-04A-DH	3	1.4	14	20	62	40	4
YMD20PR.203N-0310-04A-DH	3.1	1.4	14	20	62	40	4
YMD20PR.203N-0320-04A-DH	3.2	1.4	14	20	62	40	4
YMD20PR.203N-0330-04A-DH	3.3	1.5	14	20	62	40	4
YMD20PR.203N-0340-04A-DH	3.4	1.5	14	20	62	40	4
YMD20PR.203N-0350-04A-DH	3.5	1.6	14	20	62	40	4
YMD20PR.203N-0360-04A-DH	3.6	1.6	14	20	62	40	4
YMD20PR.203N-0370-04A-DH	3.7	1.7	14	20	62	40	4
YMD20PR.203N-0380-04A-DH	3.8	1.7	17	24	66	40	4
YMD20PR.203N-0390-04A-DH	3.9	1.8	17	24	66	40	4
YMD20PR.203N-0400-04A-DH	4	1.8	17	24	66	40	4
YMD20PR.203N-0410-06A-DH	4.1	1.8	17	24	66	40	6
YMD20PR.203N-0420-06A-DH	4.2	1.9	17	24	66	40	6
YMD20PR.203N-0430-06A-DH	4.3	1.9	17	24	66	40	6
YMD20PR.203N-0440-06A-DH	4.4	2.0	17	24	66	40	6
YMD20PR.203N-0450-06A-DH	4.5	2.0	17	24	66	40	6
YMD20PR.203N-0460-06A-DH	4.6	2.1	17	24	66	40	6
YMD20PR.203N-0470-06A-DH	4.7	2.1	20	28	66	36	6
YMD20PR.203N-0480-06A-DH	4.8	2.2	20	28	66	36	6
YMD20PR.203N-0490-06A-DH	4.9	2.2	20	28	66	36	6
YMD20PR.203N-0500-06A-DH	5	2.3	20	28	66	36	6
YMD20PR.203N-0510-06A-DH	5.1	2.3	20	28	66	36	6
YMD20PR.203N-0520-06A-DH	5.2	2.3	20	28	66	36	6
YMD20PR.203N-0530-06A-DH	5.3	2.4	20	28	66	36	6
YMD20PR.203N-0540-06A-DH	5.4	2.4	20	28	66	36	6
YMD20PR.203N-0550-06A-DH	5.5	2.5	20	28	66	36	6
YMD20PR.203N-0560-06A-DH	5.6	2.5	20	28	66	36	6
YMD20PR.203N-0570-06A-DH	5.7	2.6	20	28	66	36	6
YMD20PR.203N-0580-06A-DH	5.8	2.6	20	28	66	36	6
YMD20PR.203N-0590-06A-DH	5.9	2.7	20	28	66	36	6
YMD20PR.203N-0600-06A-DH	6	2.7	20	28	66	36	6
YMD20PR.203N-0610-08A-DH	6.1	2.7	24	34	79	40	8
YMD20PR.203N-0620-08A-DH	6.2	2.8	24	34	79	40	8
YMD20PR.203N-0630-08A-DH	6.3	2.8	24	34	79	40	8
YMD20PR.203N-0640-08A-DH	6.4	2.9	24	34	79	40	8
YMD20PR.203N-0650-08A-DH	6.5	2.9	24	34	79	40	8
YMD20PR.203N-0660-08A-DH	6.6	3.0	24	34	79	40	8
YMD20PR.203N-0670-08A-DH	6.7	3.0	24	34	79	40	8
YMD20PR.203N-0680-08A-DH	6.8	3.1	24	34	79	40	8
YMD20PR.203N-0690-08A-DH	6.9	3.1	24	34	79	40	8
YMD20PR.203N-0700-08A-DH	7.0	3.2	24	34	79	40	8
YMD20PR.203N-0710-08A-DH	7.1	3.2	29	41	79	40	8
YMD20PR.203N-0720-08A-DH	7.2	3.2	29	41	79	40	8
YMD20PR.203N-0730-08A-DH	7.3	3.3	29	41	79	40	8
YMD20PR.203N-0740-08A-DH	7.4	3.3	29	41	79	40	8
YMD20PR.203N-0750-08A-DH	7.5	3.4	29	41	79	40	8
YMD20PR.203N-0760-08A-DH	7.6	3.4	29	41	79	40	8
YMD20PR.203N-0770-08A-DH	7.7	3.5	29	41	79	40	8

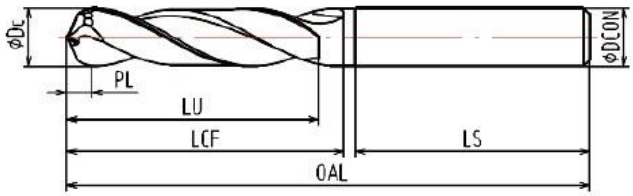
Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.203N-0780-08A-DH	7.8	3.5	29	41	79	40	8
YMD20PR.203N-0790-08A-DH	7.9	3.6	29	41	79	40	8
YMD20PR.203N-0800-08A-DH	8.0	3.6	29	41	79	40	8
YMD20PR.203N-0810-10A-DH	8.1	3.6	35	47	89	40	10
YMD20PR.203N-0820-10A-DH	8.2	3.7	35	47	89	36	10
YMD20PR.203N-0830-10A-DH	8.3	3.7	35	47	89	36	10
YMD20PR.203N-0840-10A-DH	8.4	3.8	35	47	89	36	10
YMD20PR.203N-0850-10A-DH	8.5	3.8	35	47	89	36	10
YMD20PR.203N-0860-10A-DH	8.6	3.9	35	47	89	36	10
YMD20PR.203N-0870-10A-DH	8.7	3.9	35	47	89	36	10
YMD20PR.203N-0880-10A-DH	8.8	4.0	35	47	89	36	10
YMD20PR.203N-0890-10A-DH	8.9	4.0	35	47	89	36	10
YMD20PR.203N-0900-10A-DH	9.0	4.1	35	47	89	36	10
YMD20PR.203N-0910-10A-DH	9.1	4.1	35	47	89	36	10
YMD20PR.203N-0920-10A-DH	9.2	4.1	35	47	89	36	10
YMD20PR.203N-0930-10A-DH	9.3	4.2	35	47	89	36	10
YMD20PR.203N-0940-10A-DH	9.4	4.2	35	47	89	36	10
YMD20PR.203N-0950-10A-DH	9.5	4.3	35	47	89	36	10
YMD20PR.203N-0960-10A-DH	9.6	4.3	35	47	89	40	10
YMD20PR.203N-0970-10A-DH	9.7	4.4	35	47	89	40	10
YMD20PR.203N-0980-10A-DH	9.8	4.4	35	47	89	40	10
YMD20PR.203N-0990-10A-DH	9.9	4.5	35	47	89	40	10
YMD20PR.203N-1000-10A-DH	10	4.5	35	47	89	40	10
YMD20PR.203N-1010-12A-DH	10.1	4.5	40	55	102	45	12
YMD20PR.203N-1020-12A-DH	10.2	4.6	40	55	102	45	12
YMD20PR.203N-1030-12A-DH	10.3	4.6	40	55	102	45	12
YMD20PR.203N-1040-12A-DH	10.4	4.7	40	55	102	45	12
YMD20PR.203N-1050-12A-DH	10.5	4.7	40	55	102	45	12
YMD20PR.203N-1060-12A-DH	10.6	4.8	40	55	102	45	12
YMD20PR.203N-1070-12A-DH	10.7	4.8	40	55	102	45	12
YMD20PR.203N-1080-12A-DH	10.8	4.9	40	55	102	45	12
YMD20PR.203N-1090-12A-DH	10.9	4.9	40	55	102	45	12
YMD20PR.203N-1100-12A-DH	11	5.0	40	55	102	45	12
YMD20PR.203N-1110-12A-DH	11.1	5.0	40	55	102	45	12
YMD20PR.203N-1120-12A-DH	11.2	5.0	40	55	102	45	12
YMD20PR.203N-1130-12A-DH	11.3	5.1	40	55	102	45	12
YMD20PR.203N-1140-12A-DH	11.4	5.1	40	55	102	45	12
YMD20PR.203N-1150-12A-DH	11.5	5.2	40	55	102	45	12
YMD20PR.203N-1160-12A-DH	11.6	5.2	40	55	102	45	12
YMD20PR.203N-1170-12A-DH	11.7	5.3	40	55	102	45	12
YMD20PR.203N-1180-12A-DH	11.8	5.3	40	55	102	45	12
YMD20PR.203N-1190-12A-DH	11.9	5.4	40	55	102	45	12
YMD20PR.203N-1200-12A-DH	12	5.4	40	55	102	45	12
YMD20PR.203N-1210-14A-DH	12.1	5.4	43	60	107	45	14
YMD20PR.203N-1220-14A-DH	12.2	5.5	43	60	107	45	14
YMD20PR.203N-1230-14A-DH	12.3	5.5	43	60	107	45	14
YMD20PR.203N-1240-14A-DH	12.4	5.6	43	60	107	45	14
YMD20PR.203N-1250-14A-DH	12.5	5.6	43	60	107	45	14
YMD20PR.203N-1260-14A-DH	12.6	5.7	43	60	107	45	14
YMD20PR.203N-1270-14A-DH	12.7	5.7	43	60	107	45	14
YMD20PR.203N-1280-14A-DH	12.8	5.8	43	60	107	45	14
YMD20PR.203N-1290-14A-DH	12.9	5.8	43	60	107	45	14
YMD20PR.203N-1300-14A-DH	13	5.9	43	60	107	45	14
YMD20PR.203N-1310-14A-DH	13.1	5.9	43	60	107	45	14
YMD20PR.203N-1320-14A-DH	13.2	5.9	43	60	107	45	14
YMD20PR.203N-1330-14A-DH	13.3	6.0	43	60	107	45	14
YMD20PR.203N-1340-14A-DH	13.4	6.0	43	60	107	45	14
YMD20PR.203N-1350-14A-DH	13.5	6.1	43	60	107	45	14
YMD20PR.203N-1360-14A-DH	13.6	6.1	43	60	107	45	14
YMD20PR.203N-1370-14A-DH	13.7	6.2	43	60	107	45	14
YMD20PR.203N-1380-14A-DH	13.8	6.2	43	60	107	45	14
YMD20PR.203N-1390-14A-DH	13.9	6.3	43	60	107	45	14
YMD20PR.203N-1400-14A-DH	14	6.3	43	60	107	45	14
YMD20PR.203N-1410-16A-DH	14.1	6.3	45	65	115	48	16
YMD20PR.203N-1420-16A-DH	14.2	6.4	45	65	115	48	16
YMD20PR.203N-1430-16A-DH	14.3	6.4	45	65	115	48	16
YMD20PR.203N-1440-16A-DH	14.4	6.5	45	65	115	48	16
YMD20PR.203N-1450-16A-DH	14.5	6.5	45	65	115	48	16
YMD20PR.203N-1460-16A-DH	14.6	6.6	45	65	115	48	16
YMD20PR.203N-1470-16A-DH	14.7	6.6	45	65	115	48	16
YMD20PR.203N-1480-16A-DH	14.8	6.7	45	65	115	48	16
YMD20PR.203N-1490-16A-DH	14.9	6.7	45	65	115	48	16

Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.203N-1500-16A-DH	15	6.8	45	65	115	48	16
YMD20PR.203N-1510-16A-DH	15.1	6.8	45	65	115	48	16
YMD20PR.203N-1520-16A-DH	15.2	6.8	45	65	115	48	16
YMD20PR.203N-1530-16A-DH	15.3	6.9	45	65	115	48	16
YMD20PR.203N-1540-16A-DH	15.4	6.9	45	65	115	48	16
YMD20PR.203N-1550-16A-DH	15.5	7.0	45	65	115	48	16
YMD20PR.203N-1560-16A-DH	15.6	7.0	45	65	115	48	16
YMD20PR.203N-1570-16A-DH	15.7	7.1	45	65	115	48	16
YMD20PR.203N-1580-16A-DH	15.8	7.1	45	65	115	48	16
YMD20PR.203N-1590-16A-DH	15.9	7.2	45	65	115	48	16
YMD20PR.203N-1600-16A-DH	16	7.2	45	65	115	48	16

YMD20PR.205W – Burrless Carbide Drill

Key data: SP (special-purpose tool) | m7 | 5XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.205W-0300-04A-DH	3	1.4	23	28	66	36	4
YMD20PR.205W-0310-04A-DH	3.1	1.4	23	28	66	36	4
YMD20PR.205W-0320-04A-DH	3.2	1.4	23	28	66	36	4
YMD20PR.205W-0330-04A-DH	3.3	1.5	23	28	66	36	4
YMD20PR.205W-0340-04A-DH	3.4	1.5	23	28	66	36	4
YMD20PR.205W-0350-04A-DH	3.5	1.6	23	28	66	36	4
YMD20PR.205W-0360-04A-DH	3.6	1.6	23	28	66	36	4
YMD20PR.205W-0370-04A-DH	3.7	1.7	23	28	66	36	4
YMD20PR.205W-0380-04A-DH	3.8	1.7	23	28	66	36	4
YMD20PR.205W-0390-04A-DH	3.9	1.8	29	36	74	36	4
YMD20PR.205W-0400-04A-DH	4	1.8	29	36	74	36	4
YMD20PR.205W-0410-06A-DH	4.1	1.8	29	36	74	36	6
YMD20PR.205W-0420-06A-DH	4.2	1.9	29	36	74	36	6
YMD20PR.205W-0430-06A-DH	4.3	1.9	29	36	74	36	6
YMD20PR.205W-0440-06A-DH	4.4	2.0	29	36	74	36	6
YMD20PR.205W-0450-06A-DH	4.5	2.0	29	36	74	36	6
YMD20PR.205W-0460-06A-DH	4.6	2.1	29	36	74	36	6
YMD20PR.205W-0470-06A-DH	4.7	2.1	29	36	74	36	6
YMD20PR.205W-0480-06A-DH	4.8	2.2	35	44	82	36	6
YMD20PR.205W-0490-06A-DH	4.9	2.2	35	44	82	36	6
YMD20PR.205W-0500-06A-DH	5	2.3	35	44	82	36	6
YMD20PR.205W-0510-06A-DH	5.1	2.3	35	44	82	36	6
YMD20PR.205W-0520-06A-DH	5.2	2.3	35	44	82	36	6
YMD20PR.205W-0530-06A-DH	5.3	2.4	35	44	82	36	6
YMD20PR.205W-0540-06A-DH	5.4	2.4	35	44	82	36	6
YMD20PR.205W-0550-06A-DH	5.5	2.5	35	44	82	36	6
YMD20PR.205W-0560-06A-DH	5.6	2.5	35	44	82	36	6
YMD20PR.205W-0570-06A-DH	5.7	2.6	35	44	82	36	6
YMD20PR.205W-0580-06A-DH	5.8	2.6	35	44	82	36	6
YMD20PR.205W-0590-06A-DH	5.9	2.7	35	44	82	36	6
YMD20PR.205W-0600-06A-DH	6	2.7	35	44	82	36	6
YMD20PR.205W-0610-08A-DH	6.1	2.7	43	53	91	36	8
YMD20PR.205W-0620-08A-DH	6.2	2.8	43	53	91	36	8
YMD20PR.205W-0630-08A-DH	6.3	2.8	43	53	91	36	8
YMD20PR.205W-0640-08A-DH	6.4	2.9	43	53	91	36	8
YMD20PR.205W-0650-08A-DH	6.5	2.9	43	53	91	36	8
YMD20PR.205W-0660-08A-DH	6.6	3.0	43	53	91	36	8
YMD20PR.205W-0670-08A-DH	6.7	3.0	43	53	91	36	8
YMD20PR.205W-0680-08A-DH	6.8	3.1	43	53	91	36	8
YMD20PR.205W-0690-08A-DH	6.9	3.1	43	53	91	36	8
YMD20PR.205W-0700-08A-DH	7	3.2	43	53	91	36	8
YMD20PR.205W-0710-08A-DH	7.1	3.2	43	53	91	36	8

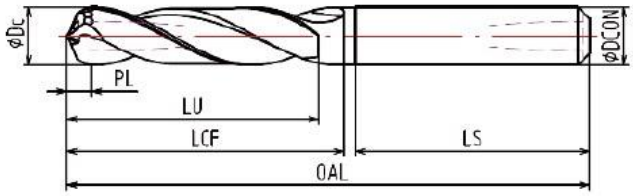
Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.205W-0720-08A-DH	7.2	3.2	43	53	91	36	8
YMD20PR.205W-0730-08A-DH	7.3	3.3	43	53	91	36	8
YMD20PR.205W-0740-08A-DH	7.4	3.3	43	53	91	36	8
YMD20PR.205W-0750-08A-DH	7.5	3.4	43	53	91	36	8
YMD20PR.205W-0760-08A-DH	7.6	3.4	43	53	91	36	8
YMD20PR.205W-0770-08A-DH	7.7	3.5	43	53	91	36	8
YMD20PR.205W-0780-08A-DH	7.8	3.5	43	53	91	36	8
YMD20PR.205W-0790-08A-DH	7.9	3.6	43	53	91	36	8
YMD20PR.205W-0800-08A-DH	8	3.6	43	53	91	36	8
YMD20PR.205W-0810-10A-DH	8.1	3.6	49	61	103	40	10
YMD20PR.205W-0820-10A-DH	8.2	3.7	49	61	103	40	10
YMD20PR.205W-0830-10A-DH	8.3	3.7	49	61	103	40	10
YMD20PR.205W-0840-10A-DH	8.4	3.8	49	61	103	40	10
YMD20PR.205W-0850-10A-DH	8.5	3.8	49	61	103	40	10
YMD20PR.205W-0860-10A-DH	8.6	3.9	49	61	103	40	10
YMD20PR.205W-0870-10A-DH	8.7	3.9	49	61	103	40	10
YMD20PR.205W-0880-10A-DH	8.8	4.0	49	61	103	40	10
YMD20PR.205W-0890-10A-DH	8.9	4.0	49	61	103	40	10
YMD20PR.205W-0900-10A-DH	9	4.1	49	61	103	40	10
YMD20PR.205W-0910-10A-DH	9.1	4.1	49	61	103	40	10
YMD20PR.205W-0920-10A-DH	9.2	4.1	49	61	103	40	10
YMD20PR.205W-0930-10A-DH	9.3	4.2	49	61	103	40	10
YMD20PR.205W-0940-10A-DH	9.4	4.2	49	61	103	40	10
YMD20PR.205W-0950-10A-DH	9.5	4.3	49	61	103	40	10
YMD20PR.205W-0960-10A-DH	9.6	4.3	49	61	103	40	10
YMD20PR.205W-0970-10A-DH	9.7	4.4	49	61	103	40	10
YMD20PR.205W-0980-10A-DH	9.8	4.4	49	61	103	40	10
YMD20PR.205W-0990-10A-DH	9.9	4.5	49	61	103	40	10
YMD20PR.205W-1000-10A-DH	10	4.5	49	61	103	40	10
YMD20PR.205W-1010-12A-DH	10.1	4.5	56	71	118	45	12
YMD20PR.205W-1020-12A-DH	10.2	4.6	56	71	118	45	12
YMD20PR.205W-1030-12A-DH	10.3	4.6	56	71	118	45	12
YMD20PR.205W-1040-12A-DH	10.4	4.7	56	71	118	45	12
YMD20PR.205W-1050-12A-DH	10.5	4.7	56	71	118	45	12
YMD20PR.205W-1060-12A-DH	10.6	4.8	56	71	118	45	12
YMD20PR.205W-1070-12A-DH	10.7	4.8	56	71	118	45	12
YMD20PR.205W-1080-12A-DH	10.8	4.9	56	71	118	45	12
YMD20PR.205W-1090-12A-DH	10.9	4.9	56	71	118	45	12
YMD20PR.205W-1100-12A-DH	11	5.0	56	71	118	45	12
YMD20PR.205W-1110-12A-DH	11.1	5.0	56	71	118	45	12
YMD20PR.205W-1120-12A-DH	11.2	5.0	56	71	118	45	12
YMD20PR.205W-1130-12A-DH	11.3	5.1	56	71	118	45	12
YMD20PR.205W-1140-12A-DH	11.4	5.1	56	71	118	45	12
YMD20PR.205W-1150-12A-DH	11.5	5.2	56	71	118	45	12
YMD20PR.205W-1160-12A-DH	11.6	5.2	56	71	118	45	12
YMD20PR.205W-1170-12A-DH	11.7	5.3	56	71	118	45	12
YMD20PR.205W-1180-12A-DH	11.8	5.3	56	71	118	45	12
YMD20PR.205W-1190-12A-DH	11.9	5.4	56	71	118	45	12
YMD20PR.205W-1200-12A-DH	12	5.4	56	71	118	45	12
YMD20PR.205W-1210-14A-DH	12.1	5.4	60	77	124	45	14
YMD20PR.205W-1220-14A-DH	12.2	5.5	60	77	124	45	14
YMD20PR.205W-1230-14A-DH	12.3	5.5	60	77	124	45	14
YMD20PR.205W-1240-14A-DH	12.4	5.6	60	77	124	45	14
YMD20PR.205W-1250-14A-DH	12.5	5.6	60	77	124	45	14
YMD20PR.205W-1260-14A-DH	12.6	5.7	60	77	124	45	14
YMD20PR.205W-1270-14A-DH	12.7	5.7	60	77	124	45	14
YMD20PR.205W-1280-14A-DH	12.8	5.8	60	77	124	45	14
YMD20PR.205W-1290-14A-DH	12.9	5.8	60	77	124	45	14
YMD20PR.205W-1300-14A-DH	13	5.9	60	77	124	45	14
YMD20PR.205W-1310-14A-DH	13.1	5.9	60	77	124	45	14
YMD20PR.205W-1320-14A-DH	13.2	5.9	60	77	124	45	14
YMD20PR.205W-1330-14A-DH	13.3	6.0	60	77	124	45	14
YMD20PR.205W-1340-14A-DH	13.4	6.0	60	77	124	45	14
YMD20PR.205W-1350-14A-DH	13.5	6.1	60	77	124	45	14
YMD20PR.205W-1360-14A-DH	13.6	6.1	60	77	124	45	14
YMD20PR.205W-1370-14A-DH	13.7	6.2	60	77	124	45	14
YMD20PR.205W-1380-14A-DH	13.8	6.2	60	77	124	45	14
YMD20PR.205W-1390-14A-DH	13.9	6.3	60	77	124	45	14
YMD20PR.205W-1400-14A-DH	14	6.3	60	77	124	45	14
YMD20PR.205W-1410-16A-DH	14.1	6.3	63	83	133	48	16
YMD20PR.205W-1420-16A-DH	14.2	6.4	63	83	133	48	16
YMD20PR.205W-1430-16A-DH	14.3	6.4	63	83	133	48	16

Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.205W-1440-16A-DH	14.4	6.5	63	83	133	48	16
YMD20PR.205W-1450-16A-DH	14.5	6.5	63	83	133	48	16
YMD20PR.205W-1460-16A-DH	14.6	6.6	63	83	133	48	16
YMD20PR.205W-1470-16A-DH	14.7	6.6	63	83	133	48	16
YMD20PR.205W-1480-16A-DH	14.8	6.7	63	83	133	48	16
YMD20PR.205W-1490-16A-DH	14.9	6.7	63	83	133	48	16
YMD20PR.205W-1500-16A-DH	15	6.8	63	83	133	48	16
YMD20PR.205W-1510-16A-DH	15.1	6.8	63	83	133	48	16
YMD20PR.205W-1520-16A-DH	15.2	6.8	63	83	133	48	16
YMD20PR.205W-1530-16A-DH	15.3	6.9	63	83	133	48	16
YMD20PR.205W-1540-16A-DH	15.4	6.9	63	83	133	48	16
YMD20PR.205W-1550-16A-DH	15.5	7.0	63	83	133	48	16
YMD20PR.205W-1560-16A-DH	15.6	7.0	63	83	133	48	16
YMD20PR.205W-1570-16A-DH	15.7	7.1	63	83	133	48	16
YMD20PR.205W-1580-16A-DH	15.8	7.1	63	83	133	48	16
YMD20PR.205W-1590-16A-DH	15.9	7.2	63	83	133	48	16
YMD20PR.205W-1600-16A-DH	16	7.2	63	83	133	48	16

YMD20PR.205N – Burrless Carbide Drill

Key data: SP (special-purpose tool) | m7 | 5XD | DIN 6535HA

Material suitability (ISO): P ● M ● K ● N – S – H – C – (● first choice ○ suitable □ limited suitability; – = not recommended)



Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.205N-0300-04A-DH	3	1.4	23	28	66	36	4
YMD20PR.205N-0310-04A-DH	3.1	1.4	23	28	66	36	4
YMD20PR.205N-0320-04A-DH	3.2	1.4	23	28	66	36	4
YMD20PR.205N-0330-04A-DH	3.3	1.5	23	28	66	36	4
YMD20PR.205N-0340-04A-DH	3.4	1.5	23	28	66	36	4
YMD20PR.205N-0350-04A-DH	3.5	1.6	23	28	66	36	4
YMD20PR.205N-0360-04A-DH	3.6	1.6	23	28	66	36	4
YMD20PR.205N-0370-04A-DH	3.7	1.7	23	28	66	36	4
YMD20PR.205N-0380-04A-DH	3.8	1.7	23	28	66	36	4
YMD20PR.205N-0390-04A-DH	3.9	1.8	29	36	74	36	4
YMD20PR.205N-0400-04A-DH	4	1.8	29	36	74	36	4
YMD20PR.205N-0410-06A-DH	4.1	1.8	29	36	74	36	6
YMD20PR.205N-0420-06A-DH	4.2	1.9	29	36	74	36	6
YMD20PR.205N-0430-06A-DH	4.3	1.9	29	36	74	36	6
YMD20PR.205N-0440-06A-DH	4.4	2.0	29	36	74	36	6
YMD20PR.205N-0450-06A-DH	4.5	2.0	29	36	74	36	6
YMD20PR.205N-0460-06A-DH	4.6	2.1	29	36	74	36	6
YMD20PR.205N-0470-06A-DH	4.7	2.1	29	36	74	36	6
YMD20PR.205N-0480-06A-DH	4.8	2.2	35	44	82	36	6
YMD20PR.205N-0490-06A-DH	4.9	2.2	35	44	82	36	6
YMD20PR.205N-0500-06A-DH	5	2.3	35	44	82	36	6
YMD20PR.205N-0510-06A-DH	5.1	2.3	35	44	82	36	6
YMD20PR.205N-0520-06A-DH	5.2	2.3	35	44	82	36	6
YMD20PR.205N-0530-06A-DH	5.3	2.4	35	44	82	36	6
YMD20PR.205N-0540-06A-DH	5.4	2.4	35	44	82	36	6
YMD20PR.205N-0550-06A-DH	5.5	2.5	35	44	82	36	6
YMD20PR.205N-0560-06A-DH	5.6	2.5	35	44	82	36	6
YMD20PR.205N-0570-06A-DH	5.7	2.6	35	44	82	36	6
YMD20PR.205N-0580-06A-DH	5.8	2.6	35	44	82	36	6
YMD20PR.205N-0590-06A-DH	5.9	2.7	35	44	82	36	6
YMD20PR.205N-0600-06A-DH	6	2.7	35	44	82	36	6
YMD20PR.205N-0610-08A-DH	6.1	2.7	43	53	91	36	8
YMD20PR.205N-0620-08A-DH	6.2	2.8	43	53	91	36	8
YMD20PR.205N-0630-08A-DH	6.3	2.8	43	53	91	36	8
YMD20PR.205N-0640-08A-DH	6.4	2.9	43	53	91	36	8
YMD20PR.205N-0650-08A-DH	6.5	2.9	43	53	91	36	8

Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.205N-0660-08A-DH	6.6	3.0	43	53	91	36	8
YMD20PR.205N-0670-08A-DH	6.7	3.0	43	53	91	36	8
YMD20PR.205N-0680-08A-DH	6.8	3.1	43	53	91	36	8
YMD20PR.205N-0690-08A-DH	6.9	3.1	43	53	91	36	8
YMD20PR.205N-0700-08A-DH	7	3.2	43	53	91	36	8
YMD20PR.205N-0710-08A-DH	7.1	3.2	43	53	91	36	8
YMD20PR.205N-0720-08A-DH	7.2	3.2	43	53	91	36	8
YMD20PR.205N-0730-08A-DH	7.3	3.3	43	53	91	36	8
YMD20PR.205N-0740-08A-DH	7.4	3.3	43	53	91	36	8
YMD20PR.205N-0750-08A-DH	7.5	3.4	43	53	91	36	8
YMD20PR.205N-0760-08A-DH	7.6	3.4	43	53	91	36	8
YMD20PR.205N-0770-08A-DH	7.7	3.5	43	53	91	36	8
YMD20PR.205N-0780-08A-DH	7.8	3.5	43	53	91	36	8
YMD20PR.205N-0790-08A-DH	7.9	3.6	43	53	91	36	8
YMD20PR.205N-0800-08A-DH	8	3.6	43	53	91	36	8
YMD20PR.205N-0810-10A-DH	8.1	3.6	49	61	103	40	10
YMD20PR.205N-0820-10A-DH	8.2	3.7	49	61	103	40	10
YMD20PR.205N-0830-10A-DH	8.3	3.7	49	61	103	40	10
YMD20PR.205N-0840-10A-DH	8.4	3.8	49	61	103	40	10
YMD20PR.205N-0850-10A-DH	8.5	3.8	49	61	103	40	10
YMD20PR.205N-0860-10A-DH	8.6	3.9	49	61	103	40	10
YMD20PR.205N-0870-10A-DH	8.7	3.9	49	61	103	40	10
YMD20PR.205N-0880-10A-DH	8.8	4.0	49	61	103	40	10
YMD20PR.205N-0890-10A-DH	8.9	4.0	49	61	103	40	10
YMD20PR.205N-0900-10A-DH	9	4.1	49	61	103	40	10
YMD20PR.205N-0910-10A-DH	9.1	4.1	49	61	103	40	10
YMD20PR.205N-0920-10A-DH	9.2	4.1	49	61	103	40	10
YMD20PR.205N-0930-10A-DH	9.3	4.2	49	61	103	40	10
YMD20PR.205N-0940-10A-DH	9.4	4.2	49	61	103	40	10
YMD20PR.205N-0950-10A-DH	9.5	4.3	49	61	103	40	10
YMD20PR.205N-0960-10A-DH	9.6	4.3	49	61	103	40	10
YMD20PR.205N-0970-10A-DH	9.7	4.4	49	61	103	40	10
YMD20PR.205N-0980-10A-DH	9.8	4.4	49	61	103	40	10
YMD20PR.205N-0990-10A-DH	9.9	4.5	49	61	103	40	10
YMD20PR.205N-1000-10A-DH	10	4.5	49	61	103	40	10
YMD20PR.205N-1010-12A-DH	10.1	4.5	56	71	118	45	12
YMD20PR.205N-1020-12A-DH	10.2	4.6	56	71	118	45	12
YMD20PR.205N-1030-12A-DH	10.3	4.6	56	71	118	45	12
YMD20PR.205N-1040-12A-DH	10.4	4.7	56	71	118	45	12
YMD20PR.205N-1050-12A-DH	10.5	4.7	56	71	118	45	12
YMD20PR.205N-1060-12A-DH	10.6	4.8	56	71	118	45	12
YMD20PR.205N-1070-12A-DH	10.7	4.8	56	71	118	45	12
YMD20PR.205N-1080-12A-DH	10.8	4.9	56	71	118	45	12
YMD20PR.205N-1090-12A-DH	10.9	4.9	56	71	118	45	12
YMD20PR.205N-1100-12A-DH	11	5.0	56	71	118	45	12
YMD20PR.205N-1110-12A-DH	11.1	5.0	56	71	118	45	12
YMD20PR.205N-1120-12A-DH	11.2	5.0	56	71	118	45	12
YMD20PR.205N-1130-12A-DH	11.3	5.1	56	71	118	45	12
YMD20PR.205N-1140-12A-DH	11.4	5.1	56	71	118	45	12
YMD20PR.205N-1150-12A-DH	11.5	5.2	56	71	118	45	12
YMD20PR.205N-1160-12A-DH	11.6	5.2	56	71	118	45	12
YMD20PR.205N-1170-12A-DH	11.7	5.3	56	71	118	45	12
YMD20PR.205N-1180-12A-DH	11.8	5.3	56	71	118	45	12
YMD20PR.205N-1190-12A-DH	11.9	5.4	56	71	118	45	12
YMD20PR.205N-1200-12A-DH	12	5.4	56	71	118	45	12
YMD20PR.205N-1210-14A-DH	12.1	5.4	60	77	124	45	14
YMD20PR.205N-1220-14A-DH	12.2	5.5	60	77	124	45	14
YMD20PR.205N-1230-14A-DH	12.3	5.5	60	77	124	45	14
YMD20PR.205N-1240-14A-DH	12.4	5.6	60	77	124	45	14
YMD20PR.205N-1250-14A-DH	12.5	5.6	60	77	124	45	14
YMD20PR.205N-1260-14A-DH	12.6	5.7	60	77	124	45	14
YMD20PR.205N-1270-14A-DH	12.7	5.7	60	77	124	45	14
YMD20PR.205N-1280-14A-DH	12.8	5.8	60	77	124	45	14
YMD20PR.205N-1290-14A-DH	12.9	5.8	60	77	124	45	14
YMD20PR.205N-1300-14A-DH	13	5.9	60	77	124	45	14
YMD20PR.205N-1310-14A-DH	13.1	5.9	60	77	124	45	14
YMD20PR.205N-1320-14A-DH	13.2	5.9	60	77	124	45	14
YMD20PR.205N-1330-14A-DH	13.3	6.0	60	77	124	45	14
YMD20PR.205N-1340-14A-DH	13.4	6.0	60	77	124	45	14
YMD20PR.205N-1350-14A-DH	13.5	6.1	60	77	124	45	14
YMD20PR.205N-1360-14A-DH	13.6	6.1	60	77	124	45	14
YMD20PR.205N-1370-14A-DH	13.7	6.2	60	77	124	45	14

Ordering code	Dimension (mm)						
	DC	PL	LU	LCF	OAL	LS	DCON
YMD20PR.205N-1380-14A-DH	13.8	6.2	60	77	124	45	14
YMD20PR.205N-1390-14A-DH	13.9	6.3	60	77	124	45	14
YMD20PR.205N-1400-14A-DH	14	6.3	60	77	124	45	14
YMD20PR.205N-1410-16A-DH	14.1	6.3	63	83	133	48	16
YMD20PR.205N-1420-16A-DH	14.2	6.4	63	83	133	48	16
YMD20PR.205N-1430-16A-DH	14.3	6.4	63	83	133	48	16
YMD20PR.205N-1440-16A-DH	14.4	6.5	63	83	133	48	16
YMD20PR.205N-1450-16A-DH	14.5	6.5	63	83	133	48	16
YMD20PR.205N-1460-16A-DH	14.6	6.6	63	83	133	48	16
YMD20PR.205N-1470-16A-DH	14.7	6.6	63	83	133	48	16
YMD20PR.205N-1480-16A-DH	14.8	6.7	63	83	133	48	16
YMD20PR.205N-1490-16A-DH	14.9	6.7	63	83	133	48	16
YMD20PR.205N-1500-16A-DH	15	6.8	63	83	133	48	16
YMD20PR.205N-1510-16A-DH	15.1	6.8	63	83	133	48	16
YMD20PR.205N-1520-16A-DH	15.2	6.8	63	83	133	48	16
YMD20PR.205N-1530-16A-DH	15.3	6.9	63	83	133	48	16
YMD20PR.205N-1540-16A-DH	15.4	6.9	63	83	133	48	16
YMD20PR.205N-1550-16A-DH	15.5	7.0	63	83	133	48	16
YMD20PR.205N-1560-16A-DH	15.6	7.0	63	83	133	48	16
YMD20PR.205N-1570-16A-DH	15.7	7.1	63	83	133	48	16
YMD20PR.205N-1580-16A-DH	15.8	7.1	63	83	133	48	16
YMD20PR.205N-1590-16A-DH	15.9	7.2	63	83	133	48	16
YMD20PR.205N-1600-16A-DH	16	7.2	63	83	133	48	16

Notes

Notes: ① For requirements outside the catalogue range (special diameters, length-to-diameter ratios, etc.), non-standard custom tools are available.

② For cutting data, refer to the last page of this section of the catalogue.

③ SP: special-purpose tool

Cutting Data

Material group			Material	Strength / hardness [N/mm²] [HRC]	Cutting speed Vc [m/min]		Feed fr [mm/rev] by drill diameter (mm)					
					Internal coolant	External coolant	3	4	6	8	10	12
P	P1	P1.1	Non-alloy structural steel, free-cutting structural steel, case-hardening steel and quenched & tempered steel	<700	90	70	0.1	0.15	0.2	0.22	0.25	0.28
		P1.2	Non-alloy structural steel, free-cutting structural steel, case-hardening steel and quenched & tempered steel	<1200	80	60	0.09	0.15	0.2	0.22	0.25	0.28
	P2	P2.1	Alloy case-hardening steel, case-hardening steel and quenched & tempered steel	<900	80	60	0.09	0.15	0.2	0.22	0.25	0.28
		P2.2	Alloy case-hardening steel, case-hardening steel and quenched & tempered steel	<1400	70	50	0.09	0.12	0.16	0.18	0.2	0.22
	P3	P3.1	Tool steel, bearing steel, spring steel and high-speed steel	<900	75	55	0.08	0.1	0.15	0.18	0.22	0.25
		P3.2	Tool steel, bearing steel, spring steel and high-speed steel	<1500	60	40	0.06	0.1	0.12	0.15	0.18	0.2
	P4	P4.1	Ferritic and martensitic stainless steel		60	40	0.06	0.1	0.12	0.15	0.18	0.2
	P5	P5.1	Cast steel		80	70	0.1	0.15	0.2	0.22	0.25	0.28
	P6	P6.1	Ferritic and martensitic stainless cast steel		60	40	0.06	0.1	0.12	0.15	0.18	0.2
M	M1	M1.1	Austenitic stainless steel	<700	36	50	0.045	0.06	0.075	0.105	0.128	0.158
		M1.2	Ferritic/austenitic (duplex) stainless steel	<1000	45	30	0.038	0.053	0.068	0.09	0.113	0.135
	M2	M2.1	Austenitic stainless steel	<700	48	35	0.045	0.06	0.075	0.105	0.128	0.158
	M3	M3.1	Ferritic/austenitic (duplex) stainless steel	<1000	45	30	0.038	0.053	0.068	0.09	0.113	0.135
K	K1	K1.1	Lamellar graphite cast iron (grey cast iron), GJL	<300	80	60	0.09	0.15	0.2	0.22	0.25	0.28
	K2	K2.1	Spheroidal graphite (ductile) cast iron, GJS	<500	85	65	0.09	0.15	0.2	0.22	0.25	0.28
		K2.2	Spheroidal graphite (ductile) cast iron, GJS	500-800	80	60	0.09	0.15	0.18	0.2	0.22	0.25
		K2.3	Spheroidal graphite (ductile) cast iron, GJS	>800	75	55	0.06	0.1	0.15	0.18	0.2	0.22

- Recommended minimum through-coolant pressure: 20 bar
- When machining with external coolant, reduce the feed per revolution if necessary to ensure smooth chip evacuation

Various non-standard solutions available

Scope of non-standard customization

- All intermediate drill diameters
- All intermediate drilling depths
- Point angle 120°–150°
- Hole tolerance ≥ IT8
- Optimization of drill-point geometry, e.g. cutting-edge preparation and point chamfering

Contact us for customized tooling (“Custom”).

Contact

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