
























DRILL SELECTION CHART

DRILLING | DRILL SELECTION CHART

Cutting Mode	Type	Drill Type	Product Code	Coolant	Shape	Coating	Range of Size	Work Material					Page			
								P	H	M	K	N	Dimensions	Cutting Conditions		
								Mild Steel	General Steel	Hardened Steel	Stainless Steel	Cast Iron			Light Alloy	
General Drilling	Solid Carbide	MPS/MSL STANDARD AND EXTRA LONG	MPS/MSL	Internal		VP	φ3.0 - φ20.0	⊙	⊙		⊙	⊙	○	D006	D025	
		MSE DRILLS (SMALL DIAMETER)	MSE	External		VP	φ0.10 - φ3.00	⊙	⊙		○	○	○	D026	D029	
		MWE/MWS DRILLS	MWE	External		VP	φ3.0 - φ20.0	⊙	⊙	○	○	○	○	D030	D041	
			MWS	External		VP	φ1.0 - φ25.0	⊙	⊙		○	○	○	D030	D041	
		Brazed	BRS/BRM/BRK DRILLS	BRS	Internal		UP	φ14.0 - φ30.0	⊙	⊙		⊙	○		D060	D061
				BRM	Internal		UP	φ14.0 - φ30.0	⊙	⊙		⊙	○		D062	D063
	BRK			Internal		UP	φ14.0 - φ30.0		⊙			○		D064	D065	
	BRA DRILLS	BRA	Internal		UP	φ8.0 - φ40.0	○	⊙		○	○		D066	D068		
	Indexable	TAW DRILLS	TAW	Internal			φ14.0 - φ30.4	⊙	⊙		○	○		D070	D080	
		TAF DRILLS	TAFS	Internal			φ12.0 - φ56.0	⊙	⊙		⊙	⊙		D082	D090	
			TAFM	Internal			φ12.0 - φ56.0	⊙	⊙		⊙	⊙		D082	D090	
			T AFL	Internal			φ12.0 - φ56.0	⊙	⊙		⊙	⊙		D082	D090	
	High-Speed Steel	VIOLET DRILLS	VSD	External		V	φ0.5 - φ13.0	⊙	⊙		○	○	○	D116	D121	

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								Mild Steel	General Steel	Hardened Steel	Stainless Steel	Cast Iron			Light Alloy
General, High-Precision	High Grade, High Speed Steel	VIOLET DRILLS	VAPDS			V	φ0.5 - φ13.0	⊙	⊙			○	○	D093	D118
			VAPDM			V	φ0.5 - φ32.0	⊙	⊙			○	○	D098	D118
High Hardness Material	Solid Carbide	MKE DRILLS	MKE	External		VP	φ2.5 - φ16.0			⊙				D052	D053
Stainless Steel	High-Precision, Stainless Steel	VIOLET DRILLS	VAPD5SUS			V	φ0.5 - φ20.0	⊙	⊙		⊙	○	○	D102	D119
			VAPDM5SUS			V	φ0.5 - φ13.0	⊙	⊙		⊙	○	○	D108	D119
Stainless Steel	Cobalt High-Speed Steel	VIOLET DRILLS	VELUSM			V	φ1.0 - φ13.0	⊙	⊙		⊙	○	○	D114	D120
Aluminium, Cast Iron Drilling	Solid Carbide	MAE/MAS DRILLS	MAE			-	φ3.0 - φ16.0					○	⊙	D054	D059
			MAS			-	φ3.0 - φ16.0					○	⊙	D054	D059
Deep Hole		MWS DRILLS (LONG)		Internal		VP	φ3.0 - φ14.0	⊙	⊙		⊙	○	D043	D049	

