



HSS-E, HPD-SUS TWIST DRILLS for STAINLESS STEELS

JOBBER

- HSS-E, HPD-SUS SPIRALBOHRER für ROSTFREIER STÄHLE
- Forets HPD-SUS HSS-E pour INOX, série courte
- PUNTE ELICOIDALI HPD-SUS IN HSS-E, PER ACCIAI INOX

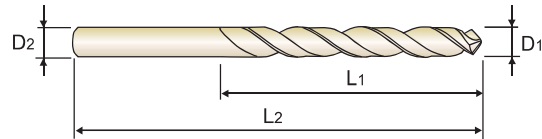
KURZ
COURTE
CORTA

- ▶ **Application** : Designed for 4D~5D drilling stainless steels, mild steels, aluminum, aluminum alloys, aluminum die casting, copper, copper alloys, etc.
- ▶ **Advantage** : High helix-sharp cutting edges to avoid built-up and to be suitable for high performance drilling
Reinforced web and jobbers length-increasing rigidity and suitable for 4D~5D drilling.
High vanadium HSS-E material with superior TiN coating - higher speed and feed, longer tool life
High quality & good surface finish, high productivity.

- ▶ **Anwendung** : Für 4D~5D Bohrtiefe, geeignet für rostfreier stähle, Stahl, Aluminium, Aluminium-Legierungen, Aluminium-Guss, Kupfer, Kupfer-Legierung usw.
- ▶ **Vorteile** : Helixwinkel, durch scharfe Hauptschneide wird Spanstau vermieden, geeignet zum Hochleistungsbohren, verstärkte Kerndicke, kurze Ausführung, Hoch Vanadium HSS-E-Material mit TiN-Beschichtung, höhere Geschwindigkeit und Vorschub, längere Standzeit, verbesserte Stabilität, Oberflächengüte und Produktivität.



up to 13mm over 13mm



for STAINLESS STEELS
für rostfreier Stäle

up to 4mm over 4mm

D₁=D₂

EDP No.	Drill Diameter	Flute Length	Overall Length
DJ544020	2.00	24	56
DJ544021	2.10	24	56
DJ544022	2.20	27	59
DJ544023	2.30	27	59
DJ544024	2.40	30	62
DJ544025	2.50	30	62
DJ544026	2.60	30	62
DJ544027	2.70	33	65
DJ544028	2.80	33	65
DJ544029	2.90	33	65
DJ544030	3.00	33	65
DJ544031	3.10	36	68
DJ544032	3.20	36	68
DJ544033	3.30	36	68
DJ544034	3.40	39	71
DJ544035	3.50	39	71
DJ544036	3.60	39	71
DJ544037	3.70	39	71
DJ544038	3.80	43	75
DJ544039	3.90	43	75
DJ544040	4.00	43	75
DJ544041	4.10	43	87

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
DJ544042	4.20	43	87
DJ544043	4.30	47	91
DJ544044	4.40	47	91
DJ544045	4.50	47	91
DJ544046	4.60	47	91
DJ544047	4.70	47	91
DJ544048	4.80	52	96
DJ544049	4.90	52	96
DJ544050	5.00	52	96
DJ544051	5.10	52	96
DJ544052	5.20	52	96
DJ544053	5.30	52	96
DJ544054	5.40	57	101
DJ544055	5.50	57	101
DJ544056	5.60	57	101
DJ544057	5.70	57	101
DJ544058	5.80	57	101
DJ544059	5.90	57	101
DJ544060	6.00	57	101
DJ544061	6.10	63	107
DJ544062	6.20	63	107
DJ544063	6.30	63	107

▶ TiCN(DW544), TiAlN(DY544) are available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○									◎	◎	○	◎							

ISO	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron					
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	200	280	55	60	42	55
Recommended	◎	◎				○												550	630	400	550

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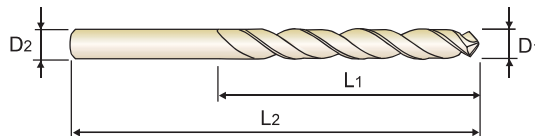
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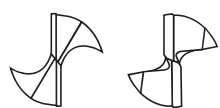
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for STAINLESS STEELS
für rostfreier Stäle



up to 13mm over 13mm

HSS-E
38°
h7
h8
130°
120°
P.200-201

D1=D2

up to 4mm over 4mm

Unit : mm

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DJ544064	6.40	63	107
DJ544065	6.50	63	107
DJ544066	6.60	63	107
DJ544067	6.70	63	107
DJ544068	6.80	69	113
DJ544069	6.90	69	113
DJ544070	7.00	69	113
DJ544071	7.10	69	113
DJ544072	7.20	69	113
DJ544073	7.30	69	113
DJ544074	7.40	69	113
DJ544075	7.50	69	113
DJ544076	7.60	75	119
DJ544077	7.70	75	119
DJ544078	7.80	75	119
DJ544079	7.90	75	119
DJ544080	8.00	75	119
DJ544081	8.10	75	125
DJ544082	8.20	75	125
DJ544083	8.30	75	125
DJ544084	8.40	75	125
DJ544085	8.50	75	125

EDP No.	Drill Diameter	Flute Length	Overall Length
	D1	L1	L2
DJ544086	8.60	81	131
DJ544087	8.70	81	131
DJ544088	8.80	81	131
DJ544089	8.90	81	131
DJ544090	9.00	81	131
DJ544091	9.10	81	131
DJ544092	9.20	81	131
DJ544093	9.30	81	131
DJ544094	9.40	81	131
DJ544095	9.50	81	131
DJ544096	9.60	87	137
DJ544097	9.70	87	137
DJ544098	9.80	87	137
DJ544099	9.90	87	137
DJ544100	10.00	87	137
DJ544101	10.10	87	144
DJ544102	10.20	87	144
DJ544103	10.30	87	144
DJ544104	10.40	87	144
DJ544105	10.50	87	144
DJ544106	10.60	87	144
DJ544107	10.70	94	151

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► NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○											◎	○	◎							

ISO	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys			Titanium Alloys			Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎				○															



DJ543, DJ544 SERIES

HPD-SUS DRILLS for STAINLESS STEELS

RPM = rev./min.
FEED = mm/rev.

ISO	VDI 3323	Material Description	Vc (m/min)	Parameter	Drill Diameter (mm)				
					2.0	3.0	4.0	5.0	6.0
P	1	Non-alloy steel	35	RPM FEED	5570	3710	2790	2230	1860
	2				0.04-0.1	0.07-0.13	0.09-0.15	0.12-0.18	0.13-0.19
	3								
	4								
	5								
	6	Low alloy steel							
	7								
	8								
	9								
	10		High alloyed steel, and tool steel						
	11								
M	12	Stainless steel	20	RPM FEED	3180	2120	1590	1270	1060
	13		18	RPM FEED	2860	1910	1430	1150	950
	14		15	RPM FEED	2390	1590	1190	950	800
K	15	Grey cast iron							
	16								
	17	Nodular cast iron							
	18								
	19								
20	Malleable cast iron								
N	21	Aluminum-wrought alloy	90	RPM FEED	14320	9550	7160	5730	4770
	22		90	RPM FEED	14320	9550	7160	5730	4770
	23	Aluminum-cast, alloyed							
	24								
	25								
	26	Copper and Copper Alloys (Bronze / Brass)	35	RPM FEED	5570	3710	2790	2230	1860
	27			0.03-0.06	0.05-0.09	0.05-0.11	0.08-0.14	0.11-0.17	
	28	Non Metallic Materials							
	29								
	30								
S	31	Heat Resistant Super Alloys							
	32								
	33								
	34								
	35	Titanium Alloys							
	36								
	37								
H	38	Hardened steel							
	39								
	40	Chilled Cast Iron							
	41	Hardened Cast Iron							

Please decrease the feed rate (15~20%) in DJ544 SERIES HPD-SUS drills.
Den Vorschub in der DJ544 Gruppe HPD-SUS Bohrer bitte verringern

RPM = rev./min.
FEED = mm/rev.

VDI 3323	Parameter	Drill Diameter (mm)						
		8.0	10.0	12.0	14.0	16.0	18.0	20.0
1	RPM	1390	1110	930	800	700	620	560
	FEED	0.18-0.24	0.20-0.30	0.22-0.32	0.25-0.35	0.28-0.38	0.34-0.44	0.35-0.45
2								
3								
4								
5								
6								
7								
8								
9								
10								
11								
12	RPM	800	640	530	450	400	350	320
	FEED	0.18-0.24	0.20-0.30	0.26-0.36	0.34-0.44	0.38-0.48	0.40-0.50	0.43-0.53
13	RPM	720	570	480	410	360	320	290
	FEED	0.18-0.24	0.20-0.30	0.26-0.36	0.34-0.44	0.38-0.48	0.40-0.50	0.43-0.53
14	RPM	600	480	400	340	300	270	240
	FEED	0.10-0.160	0.12-0.22	0.14-0.24	0.24-0.34	0.28-0.38	0.30-0.40	0.33-0.43
15								
16								
17								
18								
19								
20								
21	RPM	3580	2860	2390	2050	1790	1590	1430
	FEED	0.25-0.35	0.35-0.45	0.40-0.55	0.45-0.60	0.55-0.70	0.60-0.75	0.65-0.80
22	RPM	3580	2860	2390	2050	1790	1590	1430
	FEED	0.25-0.35	0.35-0.45	0.40-0.55	0.45-0.60	0.55-0.70	0.60-0.75	0.65-0.80
23								
24								
25								
26	RPM	1390	1110	930	800	700	620	560
	FEED	0.14-0.20	0.16-0.26	0.18-0.28	0.22-0.32	0.26-0.36	0.28-0.38	0.30-0.40
27								
28								
29								
30								
31								
32								
33								
34								
35								
36								
37								
38								
39	Please decrease the feed rate (15~20%) in DJ544 SERIES HPD-SUS drills. Den Vorschub in der DJ544 Gruppe HPD-SUS Bohrer bitte verringern							
40								
41								

i-ONE DRILLS

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -HIGH FEED

DREAM DRILLS -FLAT BOTTOM

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -CFRP

DREAM DRILLS -MQL

DREAM DRILLS for HIGH HARDENED STEELS

GENERAL CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

SUPER-GP DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

REAMERS

COUNTER SINKS

COUNTER BORES

TECHNICAL DATA