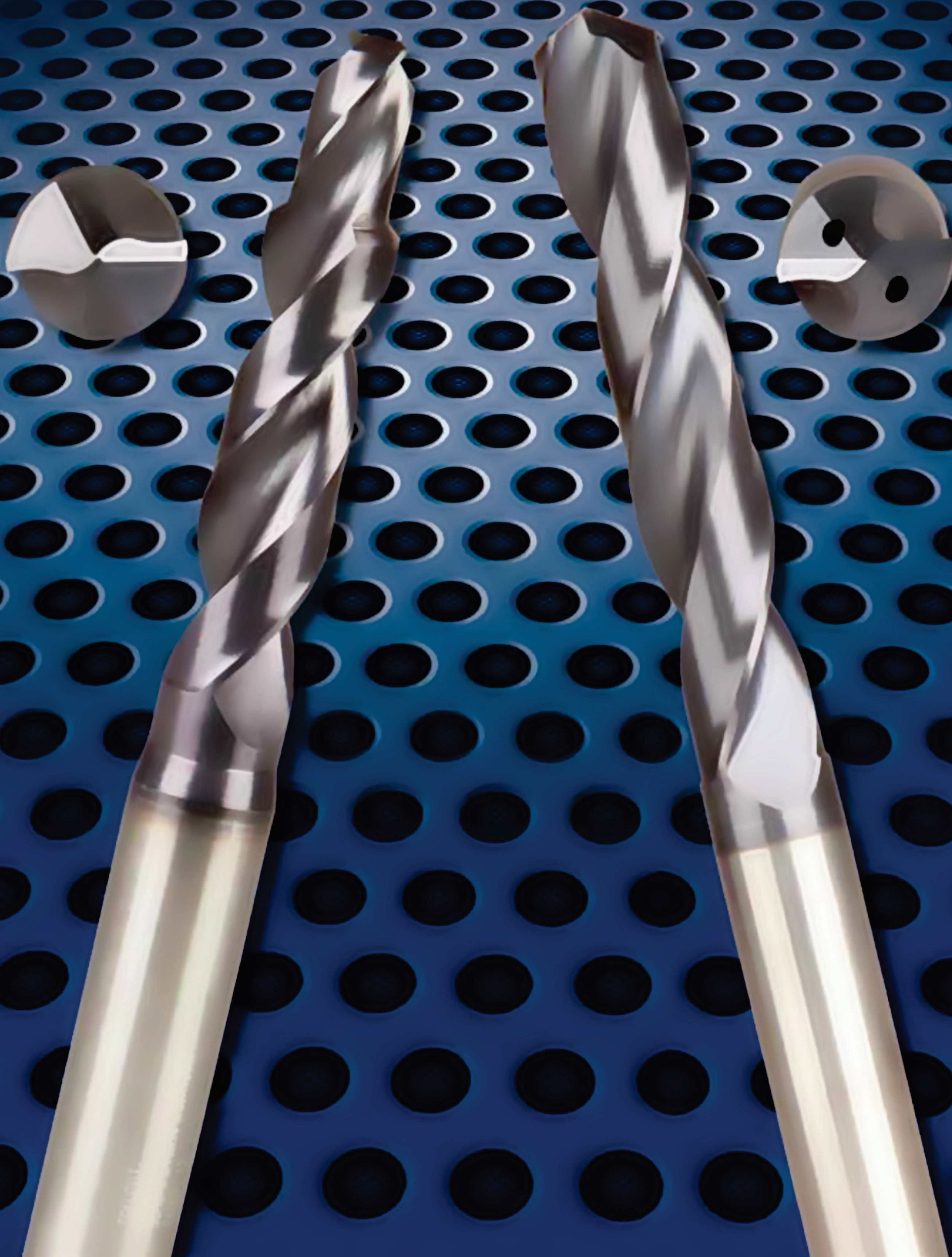


SOLID CARBIDE DRILL

TRU CUT[®]
QUALITY CUTTING TOOLS

HYPERLine[®]
Hi-Feed Drilling 



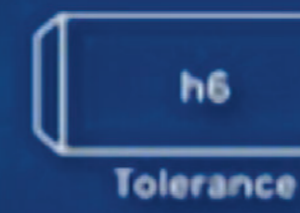
STANDARD

AS PER
DIN
6537

TOLERANCE



SHANK



POINT



HELIX



Item Code 3 L/D	Drill Dia	Cutting Length	Overall Length	Shank Dia
203-0300	3.0	20	62	6
203-0320	3.2	20	62	6
203-0330	3.3	20	62	6
203-0350	3.5	20	62	6
203-0380	3.8	24	66	6
203-0400	4.0	24	66	6
203-0420	4.2	24	66	6
203-0450	4.5	24	66	6
203-0480	4.8	28	66	6
203-0500	5.0	28	66	6
203-0520	5.2	28	66	6
203-0550	5.5	28	66	6
203-0580	5.8	28	66	6
203-0600	6.0	28	66	6
203-0620	6.2	34	79	8
203-0650	6.5	34	79	8
203-0680	6.8	34	79	8
203-0700	7.0	34	79	8
203-0720	7.2	41	79	8
203-0750	7.5	41	79	8
203-0780	7.8	41	79	8
203-0800	8.0	41	79	8
203-0820	8.2	47	89	10
203-0830	8.3	47	89	10
203-0850	8.5	47	89	10
203-0880	8.8	47	89	10
203-0900	9.0	47	89	10
203-0920	9.2	47	89	10
203-0950	9.5	47	89	10
203-0980	9.8	47	89	10
203-1000	10.0	47	89	10
203-1020	10.2	55	102	12
203-1030	10.3	55	102	12
203-1050	10.5	55	102	12
203-1080	10.8	55	102	12
203-1100	11.0	55	102	12
203-1120	11.2	55	102	12
203-1130	11.3	55	102	12
203-1150	11.5	55	102	12
203-1180	11.8	55	102	12
203-1200	12.0	55	102	12
203-1250	12.5	60	107	14
203-1270	12.7	60	107	14
203-1280	12.8	60	107	14
203-1300	13.0	60	107	14
203-1320	13.2	60	107	14
203-1350	13.5	60	107	14
203-1380	13.8	60	107	14
203-1400	14.0	60	107	14
203-1450	14.5	65	115	16
203-1500	15.0	65	115	16
203-1550	15.5	65	115	16
203-1600	16.0	65	115	16
203-1650	16.5	73	123	18
203-1700	17.0	73	123	18
203-1750	17.5	73	123	18
203-1800	18.0	73	123	18
203-1850	18.5	79	131	20
203-1900	19.0	79	131	20
203-1950	19.5	79	131	20
203-2000	20.0	79	131	20

Item Code 5 L/D	Drill Dia	Cutting Length	Overall Length	Shank Dia
205-0300	3.0	28	66	6
205-0320	3.2	28	66	6
205-0330	3.3	28	66	6
205-0350	3.5	28	66	6
205-0380	3.8	36	74	6
205-0400	4.0	36	74	6
205-0420	4.2	36	74	6
205-0450	4.5	36	74	6
205-0480	4.8	44	82	6
205-0500	5.0	44	82	6
205-0520	5.2	44	82	6
205-0550	5.5	44	82	6
205-0580	5.8	44	82	6
205-0600	6.0	44	82	6
205-0620	6.2	53	91	8
205-0650	6.5	53	91	8
205-0680	6.8	53	91	8
205-0700	7.0	53	91	8
205-0720	7.2	53	91	8
205-0750	7.5	53	91	8
205-0780	7.8	53	91	8
205-0800	8.0	53	91	8
205-0820	8.2	61	103	10
205-0830	8.3	61	103	10
205-0850	8.5	61	103	10
205-0880	8.8	61	103	10
205-0900	9.0	61	103	10
205-0920	9.2	61	103	10
205-0950	9.5	61	103	10
205-0980	9.8	61	103	10
205-1000	10.0	61	103	10
205-1020	10.2	71	118	12
205-1030	10.3	71	118	12
205-1050	10.5	71	118	12
205-1080	10.8	71	118	12
205-1100	11.0	71	118	12
205-1120	11.2	71	118	12
205-1130	11.3	71	118	12
205-1150	11.5	71	118	12
205-1180	11.8	71	118	12
205-1200	12.0	71	118	12
205-1250	12.5	77	124	14
205-1270	12.7	77	124	14
205-1280	12.8	77	124	14
205-1300	13.0	77	124	14
205-1320	13.2	77	124	14
205-1350	13.5	77	124	14
205-1380	13.8	77	124	14
205-1400	14.0	77	124	14
205-1450	14.5	83	133	16
205-1500	15.0	83	133	16
205-1550	15.5	83	133	16
205-1600	16.0	83	133	16
205-1650	16.5	93	143	18
205-1700	17.0	93	143	18
205-1750	17.5	93	143	18
205-1800	18.0	93	143	18
205-1850	18.5	101	153	20
205-1900	19.0	101	153	20
205-1950	19.5	101	153	20
205-2000	20.0	101	153	20

Item Code 7 L/D	Drill Dia	Cutting Length	Overall Length	Shank Dia
207-0500	5.0	50	90	6
207-0520	5.1	50	90	6
207-0550	5.5	57	97	6
207-0580	5.8	57	97	6
207-0600	6.0	57	97	6
207-0620	6.2	66	106	8
207-0650	6.5	66	106	8
207-0680	6.8	66	106	8
207-0700	7.0	76	116	8
207-0720	7.2	76	116	8
207-0750	7.5	76	116	8
207-0780	7.8	76	116	8
207-0800	8.0	76	116	8
207-0820	8.2	87	131	10
207-0850	8.5	87	131	10
207-0880	8.8	87	131	10
207-0900	9.0	87	131	10
207-0920	9.2	95	139	10
207-0950	9.5	95	139	10
207-0980	9.8	95	139	10
207-1000	10.0	95	139	10
207-1020	10.2	106	155	12
207-1050	10.5	106	155	12
207-1080	10.8	106	155	12
207-1100	11.0	106	155	12
207-1120	11.2	114	163	12
207-1150	11.5	114	163	12
207-1180	11.8	114	163	12
207-1200	12.0	114	163	12
207-1250	12.5	133	182	14
207-1270	12.7	133	182	14
207-1280	12.8	133	182	14
207-1300	13.0	133	182	14
207-1350	13.5	133	182	14
207-1400	14.0	133	182	14
207-1450	14.5	152	204	16
207-1500	15.0	152	204	16
207-1550	15.5	152	204	16
207-1600	16.0	152	204	16
207-1650	16.5	171	223	18
207-1700	17.0	171	223	18
207-1750	17.5	171	223	18
207-1800	18.0	171	223	18
207-1850	18.5	190	244	20
207-1900	19.0	190	244	20
207-1950	19.5	190	244	20
207-2000	20.0	190	244	20

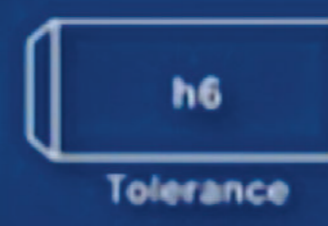
STANDARD

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TOLERANCE



SHANK



POINT



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TRU CUT[®]
 QUALITY CUTTING TOOLS

Item Code 3 L/D	Drill Dia	Cutting Length	Overall Length	Shank Dia	Item Code 5 L/D	Drill Dia	Cutting Length	Overall Length	Shank Dia	Item Code 7 L/D	Drill Dia	Cutting Length	Overall Length	Shank Dia
203 TC-0300	3.0	20	62	6	205 TC-0300	3.0	28	66	6	207 TC-0500	5.0	50	90	6
203 TC-0320	3.2	20	62	6	205 TC-0320	3.2	28	66	6	207 TC-0520	5.1	50	90	6
203 TC-0330	3.3	20	62	6	205 TC-0330	3.3	28	66	6	207 TC-0550	5.5	57	97	6
203 TC-0350	3.5	20	62	6	205 TC-0350	3.5	28	66	6	207 TC-0580	5.8	57	97	6
203 TC-0380	3.8	24	66	6	205 TC-0380	3.8	36	74	6	207 TC-0600	6.0	57	97	6
203 TC-0400	4.0	24	66	6	205 TC-0400	4.0	36	74	6	207 TC-0620	6.2	66	106	8
203 TC-0420	4.2	24	66	6	205 TC-0420	4.2	36	74	6	207 TC-0650	6.5	66	106	8
203 TC-0450	4.5	24	66	6	205 TC-0450	4.5	36	74	6	207 TC-0680	6.8	66	106	8
203 TC-0480	4.8	28	66	6	205 TC-0480	4.8	44	82	6	207 TC-0700	7.0	76	116	8
203 TC-0500	5.0	28	66	6	205 TC-0500	5.0	44	82	6	207 TC-0720	7.2	76	116	8
203 TC-0520	5.2	28	66	6	205 TC-0520	5.2	44	82	6	207 TC-0750	7.5	76	116	8
203 TC-0550	5.5	28	66	6	205 TC-0550	5.5	44	82	6	207 TC-0780	7.8	76	116	8
203 TC-0580	5.8	28	66	6	205 TC-0580	5.8	44	82	6	207 TC-0800	8.0	76	116	8
203 TC-0600	6.0	28	66	6	205 TC-0600	6.0	44	82	6	207 TC-0820	8.2	87	131	10
203 TC-0620	6.2	34	79	8	205 TC-0620	6.2	53	91	8	207 TC-0850	8.5	87	131	10
203 TC-0650	6.5	34	79	8	205 TC-0650	6.5	53	91	8	207 TC-0880	8.8	87	131	10
203 TC-0680	6.8	34	79	8	205 TC-0680	6.8	53	91	8	207 TC-0900	9.0	87	131	10
203 TC-0700	7.0	34	79	8	205 TC-0700	7.0	53	91	8	207 TC-0920	9.2	95	139	10
203 TC-0720	7.2	41	79	8	205 TC-0720	7.2	53	91	8	207 TC-0950	9.5	95	139	10
203 TC-0750	7.5	41	79	8	205 TC-0750	7.5	53	91	8	207 TC-0980	9.8	95	139	10
203 TC-0780	7.8	41	79	8	205 TC-0780	7.8	53	91	8	207 TC-1000	10.0	95	139	10
203 TC-0800	8.0	41	79	8	205 TC-0800	8.0	53	91	8	207 TC-1020	10.2	106	155	12
203 TC-0820	8.2	47	89	10	205 TC-0820	8.2	61	103	10	207 TC-1050	10.5	106	155	12
203 TC-0830	8.3	47	89	10	205 TC-0830	8.3	61	103	10	207 TC-1080	10.8	106	155	12
203 TC-0850	8.5	47	89	10	205 TC-0850	8.5	61	103	10	207 TC-1100	11.0	106	155	12
203 TC-0880	8.8	47	89	10	205 TC-0880	8.8	61	103	10	207 TC-1120	11.2	114	163	12
203 TC-0900	9.0	47	89	10	205 TC-0900	9.0	61	103	10	207 TC-1150	11.5	114	163	12
203 TC-0920	9.2	47	89	10	205 TC-0920	9.2	61	103	10	207 TC-1180	11.8	114	163	12
203 TC-0950	9.5	47	89	10	205 TC-0950	9.5	61	103	10	207 TC-1200	12.0	114	163	12
203 TC-0980	9.8	47	89	10	205 TC-0980	9.8	61	103	10	207 TC-1250	12.5	133	182	14
203 TC-1000	10.0	47	89	10	205 TC-1000	10.0	61	103	10	207 TC-1270	12.7	133	182	14
203 TC-1020	10.2	55	102	12	205 TC-1020	10.2	71	118	12	207 TC-1280	12.8	133	182	14
203 TC-1030	10.3	55	102	12	205 TC-1030	10.3	71	118	12	207 TC-1300	13.0	133	182	14
203 TC-1050	10.5	55	102	12	205 TC-1050	10.5	71	118	12	207 TC-1350	13.5	133	182	14
203 TC-1080	10.8	55	102	12	205 TC-1080	10.8	71	118	12	207 TC-1400	14.0	133	182	14
203 TC-1100	11.0	55	102	12	205 TC-1100	11.0	71	118	12	207 TC-1450	14.5	152	204	16
203 TC-1120	11.2	55	102	12	205 TC-1120	11.2	71	118	12	207 TC-1500	15.0	152	204	16
203 TC-1130	11.3	55	102	12	205 TC-1130	11.3	71	118	12	207 TC-1550	15.5	152	204	16
203 TC-1150	11.5	55	102	12	205 TC-1150	11.5	71	118	12	207 TC-1600	16.0	152	204	16
203 TC-1180	11.8	55	102	12	205 TC-1180	11.8	71	118	12	207 TC-1650	16.5	171	223	18
203 TC-1200	12.0	55	102	12	205 TC-1200	12.0	71	118	12	207 TC-1700	17.0	171	223	18
203 TC-1250	12.5	60	107	14	205 TC-1250	12.5	77	124	14	207 TC-1750	17.5	171	223	18
203 TC-1270	12.7	60	107	14	205 TC-1270	12.7	77	124	14	207 TC-1800	18.0	171	223	18
203 TC-1280	12.8	60	107	14	205 TC-1280	12.8	77	124	14	207 TC-1850	18.5	190	244	20
203 TC-1300	13.0	60	107	14	205 TC-1300	13.0	77	124	14	207 TC-1900	19.0	190	244	20
203 TC-1320	13.2	60	107	14	205 TC-1320	13.2	77	124	14	207 TC-1950	19.5	190	244	20
203 TC-1350	13.5	60	107	14	205 TC-1350	13.5	77	124	14	207 TC-2000	20.0	190	244	20
203 TC-1380	13.8	60	107	14	205 TC-1380	13.8	77	124	14					
203 TC-1400	14.0	60	107	14	205 TC-1400	14.0	77	124	14					
203 TC-1450	14.5	65	115	16	205 TC-1450	14.5	83	133	16					
203 TC-1500	15.0	65	115	16	205 TC-1500	15.0	83	133	16					
203 TC-1550	15.5	65	115	16	205 TC-1550	15.5	83	133	16					
203 TC-1600	16.0	65	115	16	205 TC-1600	16.0	83	133	16					
203 TC-1650	16.5	73	123	18	205 TC-1650	16.5	93	143	18					
203 TC-1700	17.0	73	123	18	205 TC-1700	17.0	93	143	18					
203 TC-1750	17.5	73	123	18	205 TC-1750	17.5	93	143	18					
203 TC-1800	18.0	73	123	18	205 TC-1800	18.0	93	143	18					
203 TC-1850	18.5	79	131	20	205 TC-1850	18.5	101	153	20					
203 TC-1900	19.0	79	131	20	205 TC-1900	19.0	101	153	20					
203 TC-1950	19.5	79	131	20	205 TC-1950	19.5	101	153	20					
203 TC-2000	20.0	79	131	20	205 TC-2000	20.0	101	153	20					



Recommended Cutting Condition for Series - 203, 205, 207, 203-TC, 205-TC, 207-TC

Material	Cutting Speed Vc (m / min)		Feed Rate f (mm / rev) with Drill Ø			
	Without coolant Hole 203, 205, 207	With Coolant Hole 203Tc, 205Tc, 207Tc	Ø 3 - 5	Ø 6 - 8	Ø 10 - 12	Ø 16 - 20
Carbon & Alloy Steel < Upto 30 HRC	110 - 140	140 - 180	0.100-0.160	0.200-0.240	0.260-0.300	0.440-0.500
Carbon & Alloy Steel < 38 - 40 HRC	70 - 110	90 - 140	0.100-0.160	0.200-0.240	0.220-0.240	0.440-0.500
Alloyed Steel < 48 < 55 HRC	20 - 30	40 - 50	0.060-0.070	0.080-0.120	0.070-0.090	0.090-0.100
Stainless Steels - 300 & 400 Series	60 - 80	70 - 100	0.060-0.010	0.080-0.150	0.070-0.150	0.090-0.150
Cast Iron and Malleable Cast Iron	100 - 180	140 - 220	0.200-0.240	0.260-0.300	0.300-0.320	0.500-0.600
Titanium Alloys	70 - 90	90 - 110	0.080-0.120	0.160-0.200	0.240-0.260	0.400-0.500
Copper / Brass	140 - 220	180 - 270	0.160-0.200	0.300-0.400	0.560-0.600	0.500-0.600

 These data are recommended considering Cutting Speed and Feed of 3 L/D
 Considering Rigid Component Clamping and Drill Holding with Hydrogrip or Power Chuck.
 Please Multiply with specific correction factor as below.

Non Through Coolant

Drilling Depth:	1 X D	3 X D	5 X D	7 X D
Vc & Feed Factor:	1.2 Time	1.0 Time	0.8 Time	0.6 Time

Internal Coolant

Drilling Depth:	3 X D	5 X D	7 X D
Vc & Feed Factor:	1.2 Time	1 Time	0.8 Time

**SINGLE
STEP DRILL**
on Request






**MULTI
STEP DRILL**
on Request



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