

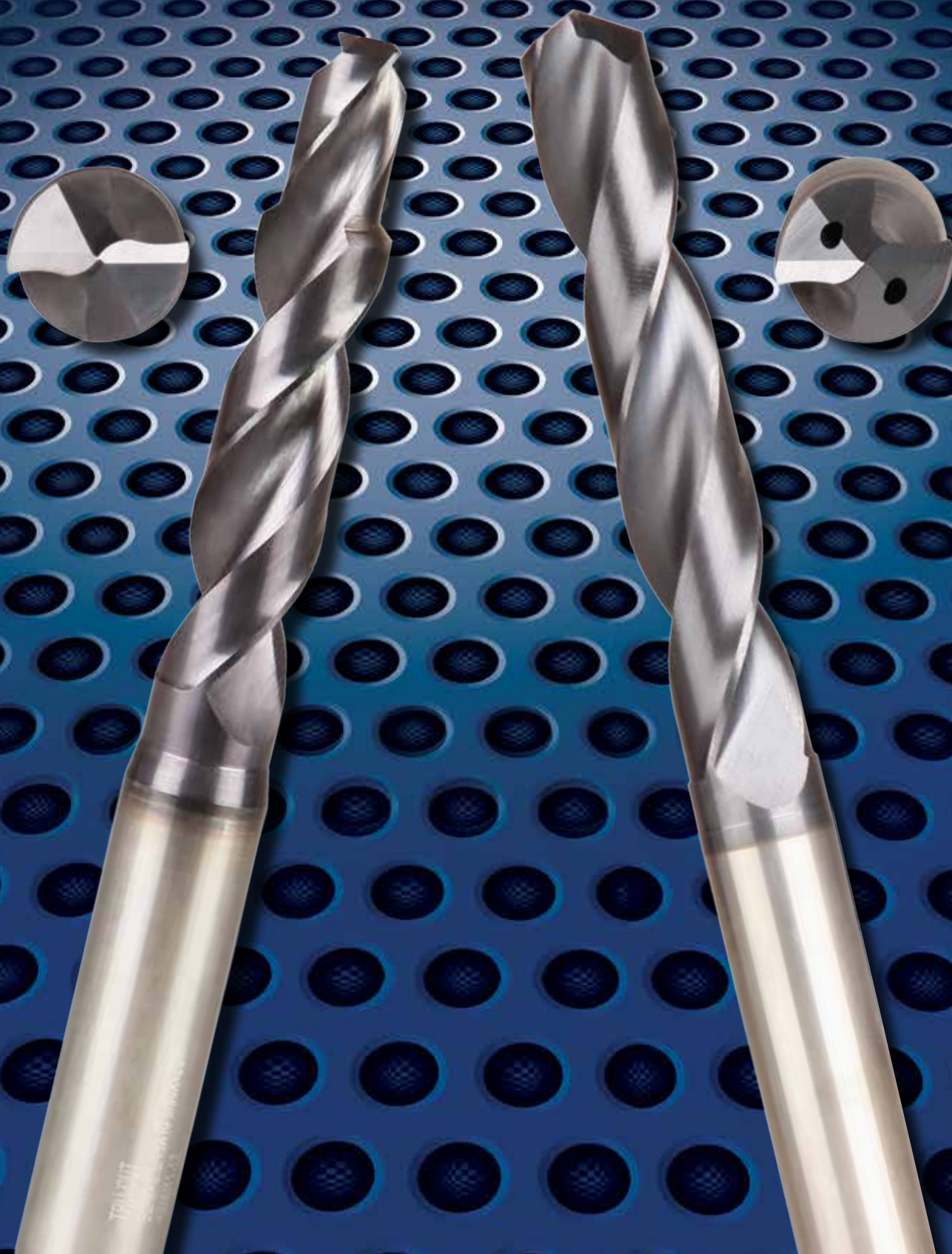
# SOLID CARBIDE DRILL

**TRU CUT**

QUALITY CARBIDE TOOLS

**HYPERLine** 

*Hi-Feed Drilling*





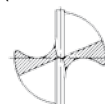
| Item Code | Drill Dia | Cutting Length | Overall Length | Shank Dia | Item Code | Drill Dia | Cutting Length | Overall Length | Shank Dia | Item Code | Drill Dia | Cutting Length | Overall Length | Shank Dia |
|-----------|-----------|----------------|----------------|-----------|-----------|-----------|----------------|----------------|-----------|-----------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

**K-Series**



**For General Steel & Forged Steel**  
**Order Example**

6mm X 3D (Item Code-203K-0600)



**For Hardened Steel & Cast Iron**  
**Order Example**

6mm X 3D (Item Code-203-0600)



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



**K-Series**

**For General Steel & Forged Steel**  
**Order Example**  
 6mm X 3D (Item Code-203K-TC-0600)

**For Hardened Steel & Cast Iron**  
**Order Example**  
 6mm X 3D (Item Code-203-TC-0600)

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

| Material                            | Cutting Speed Vc (m / min)               |   | Feed Rate f (mm / rev) with Drill Ø |             |             |             |
|-------------------------------------|--|---|-------------------------------------|-------------|-------------|-------------|
|                                     | Without coolant<br>Hole 203,<br>205, 207 | With Coolant<br>Hole 203Tc,<br>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 datas 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



QUALITY CARBIDE TOOLS

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