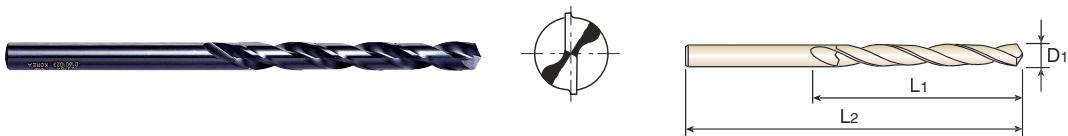


# HSS, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT STEAM OXIDE

- ▶ **Flute Geometry** : Right hand spiral, 30° helix
- ▶ **Point Angle** : 135°:Split point
- ▶ **Application** : Improved chip removal in most materials, especially in deep drilling applications.



HSS
NAS 907
30°
135°
P.176

## ▶ Wire gauge sizes

EDP No.	Diameter		Flute Length L1	Overall Length L2	EDP No.	Diameter		Flute Length L1	Overall Length L2
	Wire gauge	Decimal				Wire gauge	Decimal		
	D1					D1			
* D1633256	1	.2280	2-5/8	6	* D1633233	24	.1520	2	6
* D1633255	2	.2210	2-5/8	6	* D1633232	25	.1495	1-7/8	6
* D1633254	3	.2130	2-1/2	6	* D1633231	26	.1470	1-7/8	6
* D1633253	4	.2090	2-1/2	6	* D1633230	27	.1440	1-7/8	6
* D1633252	5	.2055	2-1/2	6	* D1633229	28	.1405	1-3/4	6
* D1633251	6	.2040	2-1/2	6	* D1633228	29	.1360	1-3/4	6
* D1633250	7	.2010	2-7/16	6	* D1633227	30	.1280	1-5/8	6
* D1633249	8	.1990	2-7/16	6	* D1633226	31	.1200	1-5/8	6
* D1633248	9	.1960	2-7/16	6	* D1633225	32	.1160	1-5/8	6
* D1633247	10	.1935	2-7/16	6	* D1633224	33	.1130	1-1/2	6
* D1633246	11	.1910	2-5/16	6	* D1633223	34	.1110	1-1/2	6
* D1633245	12	.1890	2-5/16	6	* D1633222	35	.1100	1-1/2	6
* D1633244	13	.1850	2-5/16	6	* D1633221	36	.1065	1-7/16	6
* D1633243	14	.1820	2-3/16	6	* D1633220	37	.1040	1-7/16	6
* D1633242	15	.1800	2-3/16	6	* D1633219	38	.1015	1-7/16	6
* D1633241	16	.1770	2-3/16	6	* D1633218	39	.0995	1-3/8	6
* D1633240	17	.1730	2-3/16	6	* D1633217	40	.0980	1-3/8	6
* D1633239	18	.1695	2-1/8	6	* D1633216	41	.0960	1-3/8	6
* D1633238	19	.1660	2-1/8	6	* D1633215	42	.0935	1-1/4	6
* D1633237	20	.1610	2-1/8	6	* D1633214	43	.0890	1-1/4	6
* D1633236	21	.1590	2-1/8	6	* D1636256	1	.2280	2-5/8	12
* D1633235	22	.1570	2	6	* D1636254	3	.2130	2-1/2	12
* D1633234	23	.1540	2	6					

\* 10per package

Tolerance Diameter (Inch)	
up to 1/8(.1250)	0 ~ -.0005
over 1/8(.1250) up to 1/4(.2500)	0 ~ -.0007
over 1/4(.2500) up to 1/2(.5000)	0 ~ -.0010

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○	○	○	○	○

i-DREAM DRILLS

DREAM DRILLS

DREAM DRILLS -INOX

DREAM DRILLS -ALU

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

STANDARD CARBIDE DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

STRAIGHT SHANK DRILLS

AIRCRAFT DRILLS

SILVER & DEMING DRILLS

TAPER SHANK DRILLS

NC SPOTTING DRILLS

COMBINATION DRILL & COUNTER SINK

SPADE DRILLS

TECHNICAL DATA



**HSS & HSSCo5, AIRCRAFT EXTENSION DRILL 135° SPLIT POINT**

**DL601, DL602, DL603, D1631, D1632, D1633 SERIES**

WORK MATERIAL	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS	
	HARDNESS		~ HRc23		~ HRc23 ~ 28		HRc23 ~ 34		HRc34 ~ 38	
STRENGTH	~ 570 N/mm <sup>2</sup>		~ 830 N/mm <sup>2</sup>		830 ~ 950 N/mm <sup>2</sup>		830 ~ 1110 N/mm <sup>2</sup>		1110 ~ 1260 N/mm <sup>2</sup>	
DIAMETER	N	S	N	S	N	S	N	S	N	S
0 ~ 3/32	3380	.0010	2550	.0010	1900	.0006	2380	.0008	1400	.0006
3/32 ~ 5/32	2700	.0020	2000	.0020	1500	.0010	1880	.0020	1100	.0008
11/64 ~ 1/4	1700	.0025	1280	.0025	960	.0015	1190	.0025	700	.0010
17/64 ~ 23/64	1050	.0051	780	.0051	590	.0030	730	.0051	430	.0015
3/8 ~ 37/64	750	.0059	560	.0060	425	.0030	520	.0070	310	.0020
19/32 ~ 1	440	.0090	330	.0090	255	.0051	300	.0090	180	.0020
1 ~	260	.0110	195	.0110	145	.0070	180	.0070	107	.0030

WORK MATERIAL	STAINLESS STEELS		TITANIUM ALLOYS		TOOL STEELS		CAST IRON		ALUMINUM ALLOYS	
	HARDNESS		HRc23				~ HRc21			
STRENGTH	830 N/mm <sup>2</sup>		410 N/mm <sup>2</sup>		~ 270 N/mm <sup>2</sup>		~ 800 N/mm <sup>2</sup>			
DIAMETER	N	S	N	S	N	S	N	S	N	S
0 ~ 3/32	2550	.0010	1400	.0008	3180	.0016	2250	.0010	6400	.0015
3/32 ~ 5/32	2000	.0020	1100	.0010	2500	.0020	2000	.0020	5000	.0025
11/64 ~ 1/4	1280	.0025	700	.0015	1590	.0025	1280	.0025	3200	.0030
17/64 ~ 23/64	780	.0051	430	.0030	970	.0051	780	.0051	2000	.0070
3/8 ~ 37/64	560	.0060	430	.0030	700	.0070	560	.0060	1400	.0078
19/32 ~ 1	330	.0090	180	.0051	440	.0090	330	.0090	820	.0118
1 ~	195	.0110	107	.0070	240	.1180	195	.0110	490	.0150

WORK MATERIAL	MAGNESIUM ALLOYS		ZINC ALLOYS		PLASTIC	
	HARDNESS					
STRENGTH						
DIAMETER	N	S	N	S	N	S
0 ~ 3/32	8600	.0015	6400	.0015	3380	.0010
3/32 ~ 5/32	6800	.0025	5000	.0025	2700	.0020
11/64 ~ 1/4	4300	.0030	3200	.0030	1700	.0025
17/64 ~ 23/64	2600	.0070	2000	.0070	1050	.0051
3/8 ~ 37/64	1900	.0078	1400	.0078	750	.0060
19/32 ~ 1	1100	.0118	820	.0118	440	.0090
1 ~	660	.0150	490	.0150	260	.0110

N = R.P.M  
S =Inch per Revolution(inch/rev.)

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