

HSSCo8, STRAIGHT SHANK SCREW MACHINE
D4107 SERIES

WORK MATERIAL	P												M	
	CARBON STEELS		CARBON STEELS		CARBON STEELS		ALLOY STEELS		ALLOY STEELS		TOOL STEELS		STAINLESS STEELS	
HARDNESS			~ HRc23		~ HRc23 ~ 28		HRc23 ~ 34		HRc34 ~ 38				HRc23	
STRENGTH	~ 570 N/mm ²		~ 830 N/mm ²		830 ~ 950 N/mm ²		830 ~ 1110 N/mm ²		1110 ~ 1260 N/mm ²		~ 270 N/mm ²		830 N/mm ²	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S
2.5	4225	.0010	3200	.0010	2500	.0006	2980	.0008	1750	.0006	3975	.0017	3200	.0010
3.0	3375	.0020	2500	.0020	2000	.0010	2350	.0020	1375	.0008	3125	.0020	2500	.0020
5.0	2125	.0025	1600	.0025	1280	.0015	1500	.0025	875	.0010	2000	.0025	1600	.0025
8.0	1310	.0051	975	.0051	785	.0030	910	.0051	535	.0015	1210	.0051	975	.0051
11.0	935	.0059	700	.0059	565	.0030	650	.0071	385	.0020	875	.0071	700	.0059
19.0	550	.0091	410	.0091	340	.0051	375	.0091	225	.0020	550	.0091	410	.0091
31.0	325	.0110	244	.0110	193	.0071	225	.0071	134	.0030	300	.0118	244	.0110

WORK MATERIAL	K		N								S	
	CAST IRON		ALUMINUM ALLOYS		MAGNESIUM ALLOYS		ZINC ALLOYS		PLASTIC		TITANIUM ALLOYS	
HARDNESS	~ HRc21											
STRENGTH	~ 800 N/mm ²										410 N/mm ²	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
2.5	2800	.0010	7950	.0015	10700	.0015	7950	.0015	4225	.0010	1750	.0008
3.0	2500	.0020	6200	.0025	8450	.0025	6200	.0025	3350	.0020	1375	.0010
5.0	1600	.0025	3950	.0030	5350	.0030	3950	.0030	2125	.0025	875	.0015
8.0	975	.0051	2490	.0071	3240	.0071	2490	.0071	1310	.0051	535	.0030
11.0	700	.0059	1740	.0079	2365	.0079	1740	.0079	935	.0059	535	.0030
19.0	410	.0091	1020	.0118	1370	.0118	1020	.0118	550	.0091	225	.0051
31.0	244	.0110	610	.0150	820	.0150	610	.0150	325	.0110	134	.0071

N = R.P.M

S =Inch per Revolution (inch/rev.)

CARBIDE

HSS

I-DREAM
DRILLS

DREAM
DRILLS
-GENERAL

DREAM
DRILLS
-HIGH FEED

DREAM
DRILLS
-INOX

DREAM
DRILLS
-ALU

DREAM
DRILLS
-CFRP

DREAM
DRILLS
-MQL TYPE

DREAM DRILLS
for HIGH
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
DRILLS
& COUNTERSINK

SPADE
DRILLS

TECHNICAL
DATA