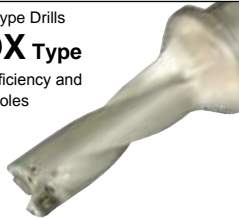



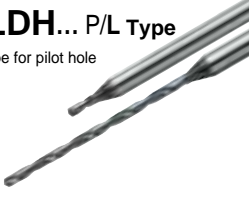



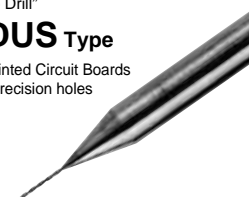



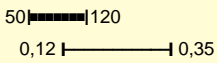
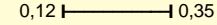
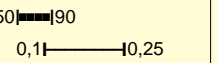
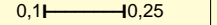
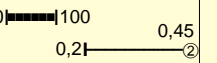
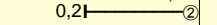
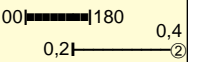
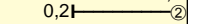
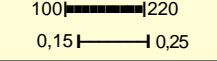
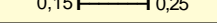
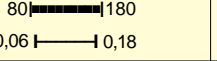
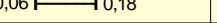
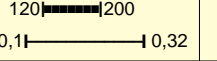
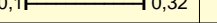
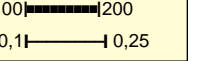
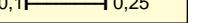
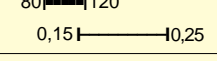
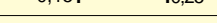
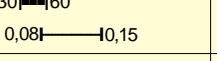
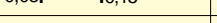
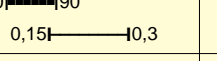
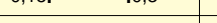
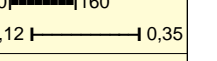
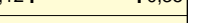
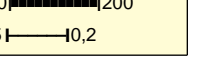

Multi-Drill Series Selection Guide



● According to Drill Types / Applications

Application	General ↔ Special	
Indexable Drills	Insert Type Drills WDX Type High Efficiency and Deep Holes  $\varnothing D : 13,0 \sim 65,0\text{mm}$ L/D: 2, 3, 4, 5 ⇒ K50 ~ 59	Replaceable Head Type Drills SMD Type  $\varnothing D : 12,0 \sim 42,5\text{mm}$ L/D: 3, 5, 8 ⇒ K43 ~ 49
	"Multi-Function" Types PDL & PCT Plunge Drills and Plunge Mills  $\varnothing D : 16,0 \sim 40,0\text{mm}$ L/D: 2, 3, 5 ⇒ K60 ~ 62	

Application	Deep Hole	Very Small Hole	Precision Hole
Special Purpose Drills	"Super Long Multi-Drill" MDW...XHT Type New General Purpose Deep Hole Drill  $\varnothing D : 4,0 \sim 12,0\text{mm}$ L/D: 10/15/20/25/30 ⇒ K24 ~ 27	"Long Micro Drill" MLDH... P/L Type "P" type for pilot hole  $\varnothing D : 0,8 \sim 2,0\text{mm}$ L/D: 5/12/20/30 ⇒ K30 ~ 31	AURORA-Coat Drill MDW...NHGS Type For Aluminium Alloy  $\varnothing D : 3,0 \sim 16,0\text{mm}$ L/D: 3 / 5 / 10 ⇒ K28 ~ 29
	—	"Mini-MultiDrill" MDSS Type  $\varnothing D : 0,20 \sim 1,00\text{mm}$ L/D: 10 ⇒ K32	"SUMI-DIA" coated Drill MDS...SDC Type For Aluminium & CFRP*  CFRP* (Carbon Fibre Reinforced Plastic) $\varnothing D : 2 \sim 10\text{mm}$ L/D: ~ 3 ⇒ K33
	—	"Micro Drill" MDUS Type For Printed Circuit Boards High precision holes  $\varnothing D : 0,05 \sim 0,19\text{mm}$ L/D: ~ 8 ⇒ K32	PCD Brazed Drill SumiDia Drill  $\varnothing D : 5 \sim 12\text{mm}$ L/D: ~ 3 ⇒ K63 ~ 64

■ Recommended Cutting Conditions by Work Materials

Drill \ Work	Steel	Stainless Steel	Cast Iron	Non-ferrous Metals
SMD (ø20)	50  120 0,12  0,35	50  90 0,1  0,25	50  100 0,45 0,2  ②	100  180 0,4 0,2  ②
WDX (ø18)	100  220 0,15  0,25	80  180 0,06  0,18	120  200 0,1  0,32	100  200 0,1  0,25
MDW...XHT (ø5)	80  120 0,15  0,25	30  60 0,08  0,15	50  90 0,15  0,3	80  160 0,12  0,35
SumiDia Drill	—	—	—	80  200 0,05  0,2

 Cutting speed v_c (m/min)
 Feed f (mm/rev)