



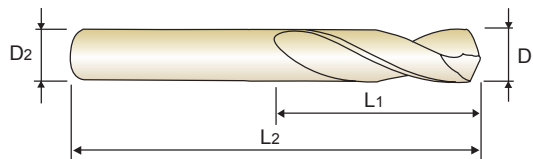
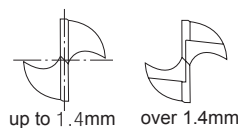
PREMIUM HSS-PM MULTI-1 DRILLS
PREMIUM HSS-PM MULTI-1 BROHER

STUB

EXTRA KURZ

- **Application** : Structural steels, Carbon steels, Alloy steels, Pre-hardened steels, Mold steels, stainless steels, Hardened steels(HRC30~45), Cast iron, Aluminum alloys, Nonferrous alloys.
- **Advantage** : Point shape to maximize self-centering. Flute design for the best chip evacuation. Premium powder materials with excellent toughness.

- **Anwendung** : Baustähle, Kohlenstoffstähle, legierte Stähle, vorgehärtete Stähle, Formstähle, rostfreie Stähle, gehärtete Stähle (HRC 30 – 45), Gusseisen, Aluminiumlegierungen, Nichteisen Legierungen.
- **Vorteile** : Maximale Selbstzentrierung durch besonderen Spitzenanschleiß
Bohrergeometrie für optimale Spanabfuhr.
Premium Pulverstahl mit ausgezeichneter Zähigkeit.



up to 1.9mm over 1.9mm

Unit : mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2	TiAlN	D1	D2	L1	L2
CDRA03010	1.0	3	6	38	CDRA03041	4.1	6	22	66
CDRA03011	1.1	3	7	39	CDRA03042	4.2	6	22	66
CDRA03012	1.2	3	8	40	CDRA03043	4.3	6	24	68
CDRA03013	1.3	3	8	40	CDRA03044	4.4	6	24	68
CDRA03014	1.4	3	9	41	CDRA03045	4.5	6	24	68
CDRA03015	1.5	3	9	41	CDRA03046	4.6	6	24	68
CDRA03016	1.6	3	10	42	CDRA03047	4.7	6	24	68
CDRA03017	1.7	3	10	42	CDRA03048	4.8	6	26	70
CDRA03018	1.8	3	11	43	CDRA03049	4.9	6	26	70
CDRA03019	1.9	3	11	43	CDRA03050	5.0	6	26	70
CDRA03020	2.0	3	12	44	CDRA03051	5.1	6	26	70
CDRA03021	2.1	3	12	44	CDRA03052	5.2	6	26	70
CDRA03022	2.2	3	13	45	CDRA03053	5.3	6	26	70
CDRA03023	2.3	3	13	45	CDRA03054	5.4	6	28	72
CDRA03024	2.4	3	14	46	CDRA03055	5.5	6	28	72
CDRA03025	2.5	3	14	46	CDRA03056	5.6	6	28	72
CDRA03026	2.6	3	14	46	CDRA03057	5.7	6	28	72
CDRA03027	2.7	3	16	48	CDRA03058	5.8	6	28	72
CDRA03028	2.8	3	16	48	CDRA03059	5.9	6	28	72
CDRA03029	2.9	3	16	48	CDRA03060	6.0	6	28	72
CDRA03030	3.0	3	16	48	CDRA03061	6.1	8	31	75
CDRA03031	3.1	4	18	50	CDRA03062	6.2	8	31	75
CDRA03032	3.2	4	18	50	CDRA03063	6.3	8	31	75
CDRA03033	3.3	4	18	50	CDRA03064	6.4	8	31	75
CDRA03034	3.4	4	20	52	CDRA03065	6.5	8	31	75
CDRA03035	3.5	4	20	52	CDRA03066	6.6	8	31	75
CDRA03036	3.6	4	20	52	CDRA03067	6.7	8	31	75
CDRA03037	3.7	4	20	52	CDRA03068	6.8	8	34	78
CDRA03038	3.8	4	22	54	CDRA03069	6.9	8	34	78
CDRA03039	3.9	4	22	54	CDRA03070	7.0	8	34	78
CDRA03040	4.0	4	22	54	CDRA03071	7.1	8	34	78

◎ : 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~							
◎	◎	○			○	○	○		◎		



MULTI-1 DRILLS

CDRA03 SERIES

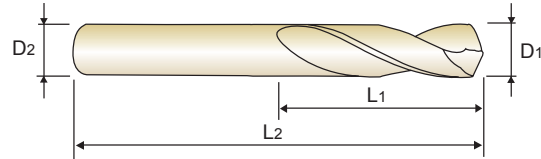
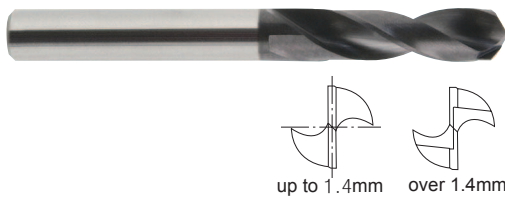
PREMIUM HSS-PM MULTI-1 DRILLS PREMIUM HSS-PM MULTI-1 BROHER

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up to 1.9mm over 1.9mm

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
CDRA03072	7.2	8	34	78
CDRA03073	7.3	8	34	78
CDRA03074	7.4	8	34	78
CDRA03075	7.5	8	34	78
CDRA03076	7.6	8	37	81
CDRA03077	7.7	8	37	81
CDRA03078	7.8	8	37	81
CDRA03079	7.9	8	37	81
CDRA03080	8.0	8	37	81
CDRA03081	8.1	10	37	87
CDRA03082	8.2	10	37	87
CDRA03083	8.3	10	37	87
CDRA03084	8.4	10	37	87
CDRA03085	8.5	10	37	87
CDRA03086	8.6	10	40	90
CDRA03087	8.7	10	40	90
CDRA03088	8.8	10	40	90
CDRA03089	8.9	10	40	90
CDRA03090	9.0	10	40	90
CDRA03091	9.1	10	40	90
CDRA03092	9.2	10	40	90
CDRA03093	9.3	10	40	90
CDRA03094	9.4	10	40	90
CDRA03095	9.5	10	40	90
CDRA03096	9.6	10	43	93
CDRA03097	9.7	10	43	93
CDRA03098	9.8	10	43	93
CDRA03099	9.9	10	43	93
CDRA03100	10.0	10	43	93
CDRA03101	10.1	12	43	100

EDP No.	Drill Diameter	Shank Diameter	Flute Length	Overall Length
TiAlN	D1	D2	L1	L2
CDRA03102	10.2	12	43	100
CDRA03103	10.3	12	43	100
CDRA03104	10.4	12	43	100
CDRA03105	10.5	12	43	100
CDRA03106	10.6	12	43	100
CDRA03107	10.7	12	47	104
CDRA03108	10.8	12	47	104
CDRA03109	10.9	12	47	104
CDRA03110	11.0	12	47	104
CDRA03111	11.1	12	47	104
CDRA03112	11.2	12	47	104
CDRA03113	11.3	12	47	104
CDRA03114	11.4	12	47	104
CDRA03115	11.5	12	47	104
CDRA03116	11.6	12	47	104
CDRA03117	11.7	12	47	104
CDRA03118	11.8	12	47	104
CDRA03119	11.9	12	51	108
CDRA03120	12.0	12	51	108
CDRA03121	12.1	12	51	108
CDRA03122	12.2	12	51	108
CDRA03123	12.3	12	51	108
CDRA03124	12.4	12	51	108
CDRA03125	12.5	12	51	108
CDRA03126	12.6	12	51	108
CDRA03127	12.7	12	51	108
CDRA03128	12.8	12	51	108
CDRA03129	12.9	12	51	108
CDRA03130	13.0	12	51	108

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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~							
◎	◎	○			○	○	○		◎		

CARBIDE

HSS

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA



PREMIUM HSS-PM MULTI-1 DRILLS, TiAIN COATED

PREMIUM HSS-PM MULTI-1 BROHER, TiAIN-BESCHICHTET

CDRA03 SERIES

Unit : mm

WORK MATERIAL	CARBON STEELS		ALLOY STEELS PRE-HARDENED STEELS		CAST IRON		ALUMINUM ALLOYS NONFERROUS ALLOYS		MOLD STEELS, HARDENED STEELS (HRc30~45) STAINLESS STEELS (SUS304, 200)		STAINLESS STEELS (SUS420, 440)		
	DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
2.0	5800	0.06	4700	0.05	6500	0.08	10500	0.17	2600	0.04	3100	0.08	
3.0	4300	0.12	3500	0.09	4900	0.14	10500	0.27	1800	0.05	2100	0.09	
4.0	3200	0.15	2600	0.13	3600	0.18	8000	0.33	1300	0.07	1600	0.11	
5.0	2600	0.18	2100	0.16	2900	0.21	6500	0.39	1050	0.09	1250	0.17	
6.0	2100	0.20	1700	0.18	2400	0.25	5200	0.46	900	0.10	1050	0.19	
8.0	1600	0.24	1300	0.20	1800	0.29	4200	0.51	650	0.14	800	0.26	
10.0	1300	0.27	1000	0.24	1500	0.32	3400	0.61	550	0.17	630	0.33	
12.0	1100	0.29	850	0.26	1200	0.36	2700	0.73	450	0.20	530	0.39	

N = R.P.M

S = Feed per Revolution (mm/rev.)

PREMIUM HSS-PM MULTI-1 DRILLS, TiAIN COATED

PREMIUM HSS-PM MULTI-1 BROHER, TiAIN-BESCHICHTET

CDRA04 SERIES

Unit : mm

WORK MATERIAL	CARBON STEELS		ALLOY STEELS PRE-HARDENED STEELS		CAST IRON		ALUMINUM ALLOYS NONFERROUS ALLOYS		MOLD STEELS, HARDENED STEELS (HRc30~45) STAINLESS STEELS (SUS304, 200)		STAINLESS STEELS (SUS420, 440)		
	DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
2.0	5800	0.05	4700	0.04	6500	0.07	10500	0.14	2600	0.03	3100	0.07	
3.0	4300	0.10	3500	0.08	4900	0.12	10500	0.23	1800	0.04	2100	0.08	
4.0	3200	0.13	2600	0.11	3600	0.15	8000	0.28	1300	0.06	1600	0.09	
5.0	2600	0.15	2100	0.14	2900	0.18	6500	0.33	1050	0.08	1250	0.14	
6.0	2100	0.17	1700	0.15	2400	0.21	5200	0.39	900	0.09	1050	0.16	
8.0	1600	0.20	1300	0.17	1800	0.25	4200	0.43	650	0.12	800	0.22	
10.0	1300	0.23	1000	0.20	1500	0.27	3400	0.52	550	0.14	630	0.28	
12.0	1100	0.25	850	0.22	1200	0.31	2700	0.62	450	0.17	530	0.33	

N = R.P.M

S = Feed per Revolution (mm/rev.)