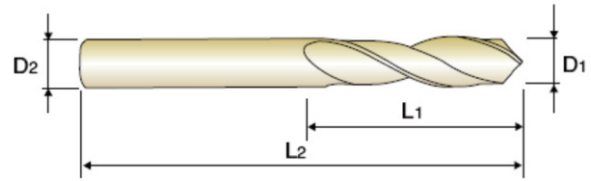
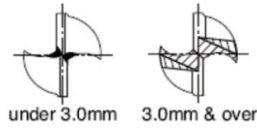




**STUB & JOBBER LENGTH
DIN 6539 & DIN 338**

General Carbide Drills

GCD15 Series (STUB)



Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

Unit : mm

| Part Number | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|-------------|-------------------|-------------------|-----------------|-------------------|
| GCD15010 | 1.0 | 1.0 | 6 | 26 |
| GCD15011 | 1.1 | 1.1 | 7 | 28 |
| GCD15012 | 1.2 | 1.2 | 8 | 30 |
| GCD15013 | 1.3 | 1.3 | 8 | 30 |
| GCD15014 | 1.4 | 1.4 | 9 | 32 |
| GCD15015 | 1.5 | 1.5 | 9 | 32 |
| GCD15016 | 1.6 | 1.6 | 10 | 34 |
| GCD15017 | 1.7 | 1.7 | 10 | 34 |
| GCD15018 | 1.8 | 1.8 | 11 | 36 |
| GCD15019 | 1.9 | 1.9 | 11 | 36 |
| GCD15020 | 2.0 | 2.0 | 12 | 38 |
| GCD15021 | 2.1 | 2.1 | 12 | 38 |
| GCD15022 | 2.2 | 2.2 | 13 | 40 |
| GCD15023 | 2.3 | 2.3 | 13 | 40 |
| GCD15024 | 2.4 | 2.4 | 14 | 43 |
| GCD15025 | 2.5 | 2.5 | 14 | 43 |
| GCD15026 | 2.6 | 2.6 | 14 | 43 |
| GCD15027 | 2.7 | 2.7 | 16 | 46 |
| GCD15028 | 2.8 | 2.8 | 16 | 46 |
| GCD15029 | 2.9 | 2.9 | 16 | 46 |
| GCD15030 | 3.0 | 3.0 | 16 | 46 |
| GCD15031 | 3.1 | 3.1 | 18 | 49 |
| GCD15032 | 3.2 | 3.2 | 18 | 49 |
| GCD15033 | 3.3 | 3.3 | 18 | 49 |
| GCD15034 | 3.4 | 3.4 | 20 | 52 |

| Part Number | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|-------------|-------------------|-------------------|-----------------|-------------------|
| GCD15035 | 3.5 | 3.5 | 20 | 52 |
| GCD15036 | 3.6 | 3.6 | 20 | 52 |
| GCD15037 | 3.7 | 3.7 | 20 | 52 |
| GCD15038 | 3.8 | 3.8 | 20 | 52 |
| GCD15039 | 3.9 | 3.9 | 22 | 55 |
| GCD15040 | 4.0 | 4.0 | 22 | 55 |
| GCD15041 | 4.1 | 4.1 | 22 | 55 |
| GCD15042 | 4.2 | 4.2 | 22 | 55 |
| GCD15043 | 4.3 | 4.3 | 24 | 58 |
| GCD15044 | 4.4 | 4.4 | 24 | 58 |
| GCD15045 | 4.5 | 4.5 | 24 | 58 |
| GCD15046 | 4.6 | 4.6 | 24 | 58 |
| GCD15047 | 4.7 | 4.7 | 24 | 58 |
| GCD15048 | 4.8 | 4.8 | 26 | 62 |
| GCD15049 | 4.9 | 4.9 | 26 | 62 |
| GCD15050 | 5.0 | 5.0 | 26 | 62 |
| GCD15051 | 5.1 | 5.1 | 26 | 62 |
| GCD15052 | 5.2 | 5.2 | 26 | 62 |
| GCD15053 | 5.3 | 5.3 | 26 | 62 |
| GCD15054 | 5.4 | 5.4 | 28 | 66 |
| GCD15055 | 5.5 | 5.5 | 28 | 66 |
| GCD15056 | 5.6 | 5.6 | 28 | 66 |
| GCD15057 | 5.7 | 5.7 | 28 | 66 |
| GCD15058 | 5.8 | 5.8 | 28 | 66 |
| GCD15059 | 5.9 | 5.9 | 28 | 66 |

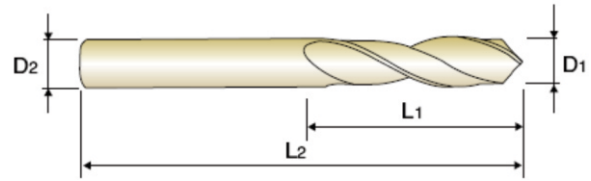
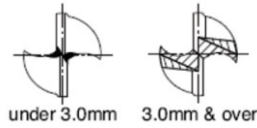
- TiN (GCD25), TiCN (GCD35) and TiAlN (GCD45) are available on your request.

| Carbon Steels ~HB225 | Alloy Steels HB225-325 | Prehardened Steels HRc30-45 | Hardened Steels HRc45-55 HRc55- | | Cast Iron | Aluminum | Stainless Steels | Titanium | Mild Steels | CFRP |
|----------------------|------------------------|-----------------------------|-----------------------------------|--|-----------|----------|------------------|----------|-------------|------|
| ● | ● | | | | ○ | ○ | ○ | ○ | ● | |

● - Excellent
○ - Good



GCD15 Series (STUB)



Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

Unit : mm

| Part Number | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|-------------|-------------------|-------------------|-----------------|-------------------|
| GCD15060 | 6.0 | 6.0 | 28 | 66 |
| GCD15061 | 6.1 | 6.1 | 31 | 70 |
| GCD15062 | 6.2 | 6.2 | 31 | 70 |
| GCD15063 | 6.3 | 6.3 | 31 | 70 |
| GCD15064 | 6.4 | 6.4 | 31 | 70 |
| GCD15065 | 6.5 | 6.5 | 31 | 70 |
| GCD15066 | 6.6 | 6.6 | 31 | 70 |
| GCD15067 | 6.7 | 6.7 | 31 | 70 |
| GCD15068 | 6.8 | 6.8 | 34 | 74 |
| GCD15069 | 6.9 | 6.9 | 34 | 74 |
| GCD15070 | 7.0 | 7.0 | 34 | 74 |
| GCD15071 | 7.1 | 7.1 | 34 | 74 |
| GCD15072 | 7.2 | 7.2 | 34 | 74 |
| GCD15073 | 7.3 | 7.3 | 34 | 74 |
| GCD15074 | 7.4 | 7.4 | 34 | 74 |
| GCD15075 | 7.5 | 7.5 | 34 | 74 |
| GCD15076 | 7.6 | 7.6 | 37 | 79 |
| GCD15077 | 7.7 | 7.7 | 37 | 79 |
| GCD15078 | 7.8 | 7.8 | 37 | 79 |
| GCD15079 | 7.9 | 7.9 | 37 | 79 |
| GCD15080 | 8.0 | 8.0 | 37 | 79 |
| GCD15081 | 8.1 | 8.1 | 37 | 79 |
| GCD15082 | 8.2 | 8.2 | 37 | 79 |
| GCD15083 | 8.3 | 8.3 | 37 | 79 |

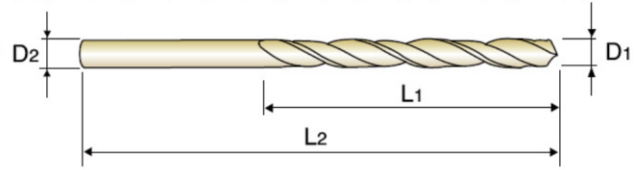
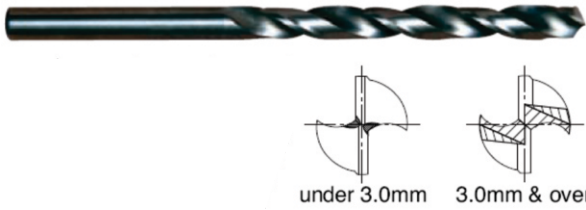
| Part Number | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|-------------|-------------------|-------------------|-----------------|-------------------|
| GCD15084 | 8.4 | 8.4 | 37 | 79 |
| GCD15085 | 8.5 | 8.5 | 37 | 79 |
| GCD15086 | 8.6 | 8.6 | 40 | 84 |
| GCD15087 | 8.7 | 8.7 | 40 | 84 |
| GCD15088 | 8.8 | 8.8 | 40 | 84 |
| GCD15089 | 8.9 | 8.9 | 40 | 84 |
| GCD15090 | 9.0 | 9.0 | 40 | 84 |
| GCD15091 | 9.1 | 9.1 | 40 | 84 |
| GCD15092 | 9.2 | 9.2 | 40 | 84 |
| GCD15093 | 9.3 | 9.3 | 40 | 84 |
| GCD15094 | 9.4 | 9.4 | 40 | 84 |
| GCD15095 | 9.5 | 9.5 | 40 | 84 |
| GCD15096 | 9.6 | 9.6 | 43 | 89 |
| GCD15097 | 9.7 | 9.7 | 43 | 89 |
| GCD15098 | 9.8 | 9.8 | 43 | 89 |
| GCD15099 | 9.9 | 9.9 | 43 | 89 |
| GCD15100 | 10.0 | 10.0 | 43 | 89 |
| GCD15102 | 10.2 | 10.2 | 43 | 89 |
| GCD15105 | 10.5 | 10.5 | 43 | 89 |
| GCD15110 | 11.0 | 11.0 | 47 | 95 |
| GCD15115 | 11.5 | 11.5 | 47 | 95 |
| GCD15120 | 12.0 | 12.0 | 51 | 102 |
| GCD15130 | 13.0 | 13.0 | 51 | 102 |

- TiN (GCD25), TiCN (GCD35) and TiAlN (GCD45) are available on your request.

| Carbon Steels ~HB225 | Alloy Steels HB225-325 | Prehardened Steels HRc30-45 | Hardened Steels HRc45-55 HRc55- | | Cast Iron | Aluminum | Stainless Steels | Titanium | Mild Steels | CFRP |
|----------------------|------------------------|-----------------------------|-----------------------------------|--|-----------|----------|------------------|----------|-------------|------|
| ● | ● | | | | ○ | ○ | ○ | ○ | ● | |

● : Excellent
○ : Good

GCD17 Series (JOBBER)



Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

Unit : mm

| Part Number | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|-------------|-------------------|-------------------|-----------------|-------------------|
| GCD17010 | 1.0 | 1.0 | 12 | 34 |
| GCD17011 | 1.1 | 1.1 | 14 | 36 |
| GCD17012 | 1.2 | 1.2 | 16 | 38 |
| GCD17013 | 1.3 | 1.3 | 16 | 38 |
| GCD17014 | 1.4 | 1.4 | 18 | 40 |
| GCD17015 | 1.5 | 1.5 | 18 | 40 |
| GCD17016 | 1.6 | 1.6 | 20 | 43 |
| GCD17017 | 1.7 | 1.7 | 20 | 43 |
| GCD17018 | 1.8 | 1.8 | 22 | 46 |
| GCD17019 | 1.9 | 1.9 | 22 | 46 |
| GCD17020 | 2.0 | 2.0 | 24 | 49 |
| GCD17021 | 2.1 | 2.1 | 24 | 49 |
| GCD17022 | 2.2 | 2.2 | 27 | 53 |
| GCD17023 | 2.3 | 2.3 | 27 | 53 |
| GCD17024 | 2.4 | 2.4 | 30 | 57 |
| GCD17025 | 2.5 | 2.5 | 30 | 57 |
| GCD17026 | 2.6 | 2.6 | 30 | 57 |
| GCD17027 | 2.7 | 2.7 | 33 | 61 |
| GCD17028 | 2.8 | 2.8 | 33 | 61 |
| GCD17029 | 2.9 | 2.9 | 33 | 61 |
| GCD17030 | 3.0 | 3.0 | 33 | 61 |
| GCD17031 | 3.1 | 3.1 | 36 | 65 |

| Part Number | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|-------------|-------------------|-------------------|-----------------|-------------------|
| GCD17032 | 3.2 | 3.2 | 36 | 65 |
| GCD17033 | 3.3 | 3.3 | 36 | 65 |
| GCD17034 | 3.4 | 3.4 | 39 | 70 |
| GCD17035 | 3.5 | 3.5 | 39 | 70 |
| GCD17036 | 3.6 | 3.6 | 39 | 70 |
| GCD17037 | 3.7 | 3.7 | 39 | 70 |
| GCD17038 | 3.8 | 3.8 | 43 | 75 |
| GCD17039 | 3.9 | 3.9 | 43 | 75 |
| GCD17040 | 4.0 | 4.0 | 43 | 75 |
| GCD17041 | 4.1 | 4.1 | 43 | 75 |
| GCD17042 | 4.2 | 4.2 | 43 | 75 |
| GCD17043 | 4.3 | 4.3 | 47 | 80 |
| GCD17044 | 4.4 | 4.4 | 47 | 80 |
| GCD17045 | 4.5 | 4.5 | 47 | 80 |
| GCD17046 | 4.6 | 4.6 | 47 | 80 |
| GCD17047 | 4.7 | 4.7 | 47 | 80 |
| GCD17048 | 4.8 | 4.8 | 52 | 86 |
| GCD17049 | 4.9 | 4.9 | 52 | 86 |
| GCD17050 | 5.0 | 5.0 | 52 | 86 |
| GCD17051 | 5.1 | 5.1 | 52 | 86 |
| GCD17052 | 5.2 | 5.2 | 52 | 86 |
| GCD17053 | 5.3 | 5.3 | 52 | 86 |

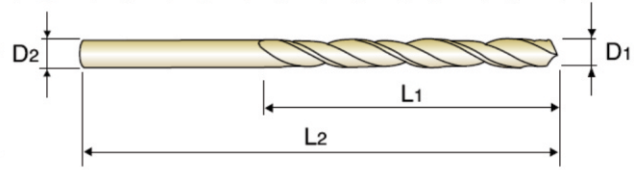
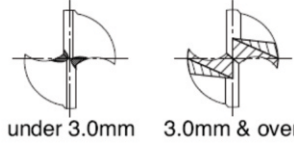
- TiN (GCD27), TiCN (GCD37) and TiAlN (GCD47) are available on your request.

| Carbon Steels ~HB225 | Alloy Steels HB225-325 | Prehardened Steels HRc30-45 | Hardened Steels HRc45-55 HRc55- | | Cast Iron | Aluminum | Stainless Steels | Titanium | Mild Steels | CFRP |
|----------------------|------------------------|-----------------------------|-----------------------------------|--|-----------|----------|------------------|----------|-------------|------|
| ● | ● | | | | ○ | ○ | ○ | ○ | ● | |

● - Excellent
○ - Good



GCD17 Series (JOBBER)



Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.

Unit : mm

| Part Number | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|-------------|-------------------|-------------------|-----------------|-------------------|
| GCD17054 | 5.4 | 5.4 | 57 | 93 |
| GCD17055 | 5.5 | 5.5 | 57 | 93 |
| GCD17056 | 5.6 | 5.6 | 57 | 93 |
| GCD17057 | 5.7 | 5.7 | 57 | 93 |
| GCD17058 | 5.8 | 5.8 | 57 | 93 |
| GCD17059 | 5.9 | 5.9 | 57 | 93 |
| GCD17060 | 6.0 | 6.0 | 57 | 93 |
| GCD17061 | 6.1 | 6.1 | 63 | 101 |
| GCD17062 | 6.2 | 6.2 | 63 | 101 |
| GCD17063 | 6.3 | 6.3 | 63 | 101 |
| GCD17064 | 6.4 | 6.4 | 63 | 101 |
| GCD17065 | 6.5 | 6.5 | 63 | 101 |
| GCD17068 | 6.8 | 6.8 | 69 | 109 |

| Part Number | Drill Diameter D1 | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|-------------|-------------------|-------------------|-----------------|-------------------|
| GCD17070 | 7.0 | 7.0 | 69 | 109 |
| GCD17075 | 7.5 | 7.5 | 69 | 109 |
| GCD17080 | 8.0 | 8.0 | 75 | 117 |
| GCD17085 | 8.5 | 8.5 | 75 | 117 |
| GCD17090 | 9.0 | 9.0 | 81 | 125 |
| GCD17095 | 9.5 | 9.5 | 81 | 125 |
| GCD17100 | 10.0 | 10.0 | 87 | 133 |
| GCD17102 | 10.2 | 10.2 | 87 | 133 |
| GCD17105 | 10.5 | 10.5 | 87 | 133 |
| GCD17110 | 11.0 | 11.0 | 94 | 142 |
| GCD17115 | 11.5 | 11.5 | 94 | 142 |
| GCD17120 | 12.0 | 12.0 | 101 | 151 |
| GCD17130 | 13.0 | 13.0 | 101 | 151 |

- TiN (GCD27), TiCN (GCD37) and TiAlN (GCD47) are available on your request.

| Carbon Steels ~HB225 | Alloy Steels HB225-325 | Prehardened Steels HRc30-45 | Hardened Steels HRc45-55 HRc55- | | Cast Iron | Aluminum | Stainless Steels | Titanium | Mild Steels | CFRP |
|----------------------|------------------------|-----------------------------|-----------------------------------|--|-----------|----------|------------------|----------|-------------|------|
| ● | ● | | | | ○ | ○ | ○ | ○ | ● | |

● - Excellent
○ - Good

Carbide Drills, DIN 6539 & DIN 338
GCD15 & GCD17 Series

Unit:mm

| Work Material | Non-Alloy Steels | | Alloy Steels | | Soft Grey Cast Iron | | Hard Grey Cast Iron | | Stainless Steels | | Al-Si Alloys, Si<10% | | Al-Si Alloys, Si>10% | | Ti-Ni Alloys, Steels | |
|----------------|-------------------------|------|--------------------------|------|---------------------|------|---------------------|------|------------------|------|----------------------|------|----------------------|------|----------------------|------|
| | N | S | N | S | N | S | N | S | N | S | N | S | N | S | N | S |
| Strength | < 700 N/mm ² | | < 1000 N/mm ² | | < HB240, GG25 | | < HB300, GG40 | | | | | | | | | |
| Drilling Speed | 65~75 m/min | | 45~55 m/min | | 80~100 m/min | | 50~70 m/min | | 30~40 m/min | | 150~170 m/min | | 110~130 m/min | | 33~38 m/min | |
| Diameter | N | S | N | S | N | S | N | S | N | S | N | S | N | S | N | S |
| 1.0 | 23000 | 0.03 | 17200 | 0.03 | 32000 | 0.04 | 23000 | 0.04 | 12000 | 0.04 | 54000 | 0.05 | 42000 | 0.05 | 11800 | 0.02 |
| 2.0 | 11500 | 0.04 | 8600 | 0.04 | 16000 | 0.05 | 11500 | 0.05 | 6000 | 0.03 | 27000 | 0.06 | 21000 | 0.06 | 5900 | 0.03 |
| 3.0 | 7800 | 0.05 | 5750 | 0.05 | 10500 | 0.06 | 7600 | 0.06 | 4000 | 0.04 | 18000 | 0.07 | 14000 | 0.07 | 3900 | 0.04 |
| 4.0 | 5800 | 0.06 | 4300 | 0.06 | 7800 | 0.07 | 5700 | 0.07 | 3000 | 0.05 | 13000 | 0.08 | 10500 | 0.08 | 2950 | 0.05 |
| 5.0 | 4700 | 0.07 | 3450 | 0.07 | 6200 | 0.08 | 4550 | 0.08 | 2400 | 0.06 | 10500 | 0.09 | 8500 | 0.09 | 2350 | 0.06 |
| 6.0 | 3900 | 0.08 | 2850 | 0.08 | 5200 | 0.09 | 3800 | 0.09 | 2000 | 0.07 | 8800 | 0.11 | 7100 | 0.11 | 1950 | 0.07 |
| 7.0 | 3350 | 0.09 | 2450 | 0.09 | 4500 | 0.10 | 3250 | 0.10 | 1700 | 0.08 | 7600 | 0.13 | 6100 | 0.13 | 1700 | 0.08 |
| 8.0 | 2900 | 0.10 | 2150 | 0.10 | 3900 | 0.12 | 2850 | 0.12 | 1500 | 0.09 | 6600 | 0.15 | 5350 | 0.15 | 1450 | 0.09 |
| 9.0 | 2600 | 0.11 | 1900 | 0.11 | 3450 | 0.14 | 2550 | 0.14 | 1350 | 0.10 | 5900 | 0.17 | 4750 | 0.17 | 1300 | 0.10 |
| 10.0 | 2350 | 0.12 | 1700 | 0.12 | 3100 | 0.16 | 2300 | 0.16 | 1200 | 0.11 | 5300 | 0.19 | 4250 | 0.19 | 1200 | 0.11 |
| 11.0 | 2150 | 0.13 | 1600 | 0.13 | 2850 | 0.18 | 2100 | 0.18 | 1100 | 0.12 | 4850 | 0.21 | 3900 | 0.21 | 1050 | 0.12 |
| 12.0 | 1950 | 0.14 | 1450 | 0.14 | 2600 | 0.20 | 1900 | 0.20 | 1000 | 0.13 | 4450 | 0.23 | 3550 | 0.23 | 980 | 0.13 |
| 13.0 | 1800 | 0.16 | 1350 | 0.16 | 2400 | 0.20 | 1750 | 0.20 | 950 | 0.13 | 4100 | 0.25 | 3300 | 0.25 | 905 | 0.13 |

N = R.P.M
 S = Feed per Revolution (mm/rev.)



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