

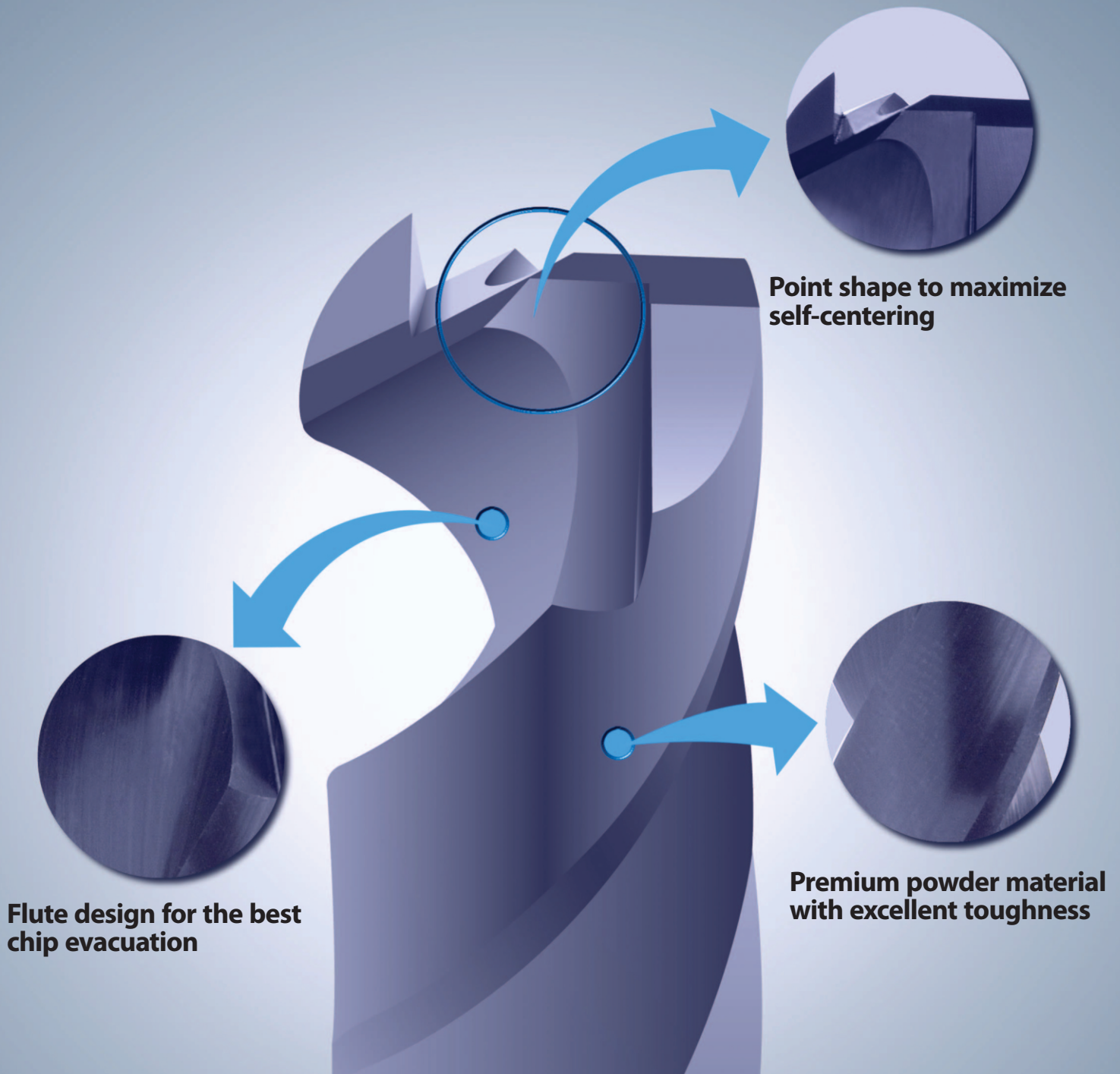


# HSS-PM Drills

STUB & JOBBER Length



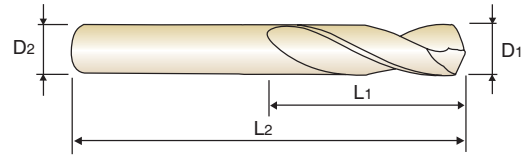
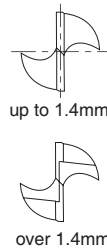
# HSS-PM Drills



## HSS-PM Drills Application Range:

STRUCTURAL STEELS, CARBON STEELS, ALLOY STEELS, PRE-HARDENED STEELS,  
MOLD STEELS, STAINLESS STEELS, HARDENED STEELS(HRC30~45), CAST IRONS,  
ALUMINUM ALLOYS, NONFERROUS ALLOYS.

HSP3 Series (STUB)



- Application : - Excellent wear resistance by using Premium powder metallurgy materials.  
 - With special point geometry, no centering required.  
 - Minimal drill wandering and improved hole tolerances.  
 - Better tool life with excellent coating.
- Advantage : - Applicable to various materials including aluminum and stainless steel, as well carbon steel and structural steel.

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
HSP3010	1.0	3	6	38
HSP3011	1.1	3	7	39
HSP3012	1.2	3	8	40
HSP3013	1.3	3	8	40
HSP3014	1.4	3	9	41
HSP3015	1.5	3	9	41
HSP3016	1.6	3	10	42
HSP3017	1.7	3	10	42
HSP3018	1.8	3	11	43
HSP3019	1.9	3	11	43
HSP3020	2.0	3	12	44
HSP3021	2.1	3	12	44
HSP3022	2.2	3	13	45
HSP3023	2.3	3	13	45
HSP3024	2.4	3	14	46
HSP3025	2.5	3	14	46
HSP3026	2.6	3	14	46
HSP3027	2.7	3	16	48
HSP3028	2.8	3	16	48
HSP3029	2.9	3	16	48
HSP3030	3.0	3	16	48
HSP3031	3.1	4	18	50
HSP3032	3.2	4	18	50
HSP3033	3.3	4	18	50
HSP3034	3.4	4	20	52
HSP3035	3.5	4	20	52
HSP3036	3.6	4	20	52
HSP3037	3.7	4	20	52
HSP3038	3.8	4	22	54
HSP3039	3.9	4	22	54

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
HSP3040	4.0	4	22	54
HSP3041	4.1	6	22	66
HSP3042	4.2	6	22	66
HSP3043	4.3	6	24	68
HSP3044	4.4	6	24	68
HSP3045	4.5	6	24	68
HSP3046	4.6	6	24	68
HSP3047	4.7	6	24	68
HSP3048	4.8	6	26	70
HSP3049	4.9	6	26	70
HSP3050	5.0	6	26	70
HSP3051	5.1	6	26	70
HSP3052	5.2	6	26	70
HSP3053	5.3	6	26	70
HSP3054	5.4	6	28	72
HSP3055	5.5	6	28	72
HSP3056	5.6	6	28	72
HSP3057	5.7	6	28	72
HSP3058	5.8	6	28	72
HSP3059	5.9	6	28	72
HSP3060	6.0	6	28	72
HSP3061	6.1	8	31	75
HSP3062	6.2	8	31	75
HSP3063	6.3	8	31	75
HSP3064	6.4	8	31	75
HSP3065	6.5	8	31	75
HSP3066	6.6	8	31	75
HSP3067	6.7	8	31	75
HSP3068	6.8	8	34	78
HSP3069	6.9	8	34	78



HSP3 Series (STUB)

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
HSP3070	7.0	8	34	78
HSP3071	7.1	8	34	78
HSP3072	7.2	8	34	78
HSP3073	7.3	8	34	78
HSP3074	7.4	8	34	78
HSP3075	7.5	8	34	78
HSP3076	7.6	8	37	81
HSP3077	7.7	8	37	81
HSP3078	7.8	8	37	81
HSP3079	7.9	8	37	81
HSP3080	8.0	8	37	81
HSP3081	8.1	10	37	87
HSP3082	8.2	10	37	87
HSP3083	8.3	10	37	87
HSP3084	8.4	10	37	87
HSP3085	8.5	10	37	87
HSP3086	8.6	10	40	90
HSP3087	8.7	10	40	90
HSP3088	8.8	10	40	90
HSP3089	8.9	10	40	90
HSP3090	9.0	10	40	90
HSP3091	9.1	10	40	90
HSP3092	9.2	10	40	90
HSP3093	9.3	10	40	90
HSP3094	9.4	10	40	90
HSP3095	9.5	10	40	90
HSP3096	9.6	10	43	93
HSP3097	9.7	10	43	93
HSP3098	9.8	10	43	93
HSP3099	9.9	10	43	93
HSP3100	10.0	10	43	93

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
HSP3101	10.1	12	43	100
HSP3102	10.2	12	43	100
HSP3103	10.3	12	43	100
HSP3104	10.4	12	43	100
HSP3105	10.5	12	43	100
HSP3106	10.6	12	43	100
HSP3107	10.7	12	47	104
HSP3108	10.8	12	47	104
HSP3109	10.9	12	47	104
HSP3110	11.0	12	47	104
HSP3111	11.1	12	47	104
HSP3112	11.2	12	47	104
HSP3113	11.3	12	47	104
HSP3114	11.4	12	47	104
HSP3115	11.5	12	47	104
HSP3116	11.6	12	47	104
HSP3117	11.7	12	47	104
HSP3118	11.8	12	47	104
HSP3119	11.9	12	51	108
HSP3120	12.0	12	51	108
HSP3121	12.1	12	51	108
HSP3122	12.2	12	51	108
HSP3123	12.3	12	51	108
HSP3124	12.4	12	51	108
HSP3125	12.5	12	51	108
HSP3126	12.6	12	51	108
HSP3127	12.7	12	51	108
HSP3128	12.8	12	51	108
HSP3129	12.9	12	51	108
HSP3130	13.0	12	51	108

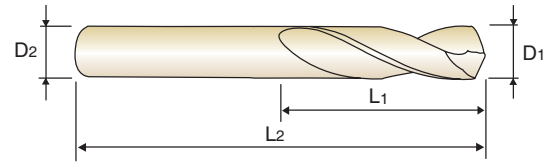
Cutting Condition

Unit:mm

Work Material	Carbon Steel		Alloy Steels Pre-Hardened Steel		Cast Iron		Aluminum Alloys Non Ferrous Alloys		Mold Steel Hardened Steels (HRC30~45) Stainless Steels (SUS304, 200)		Stainless Steels (SUS420,440)	
	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.)

HSP4 Series (JOBBER)



- Application : - Excellent wear resistance by using Premium powder metallurgy materials.  
 - With special point geometry, no centering required.  
 - Minimal drill wandering and improved hole tolerances.  
 - Better tool life with excellent coating.
- Advantage : - Applicable to various materials including aluminum and stainless steel, as well carbon steel and structural steel.

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
HSP4020	2.0	3	24	56
HSP4021	2.1	3	24	56
HSP4022	2.2	3	25	56
HSP4023	2.3	3	25	56
HSP4024	2.4	3	30	61
HSP4025	2.5	3	30	61
HSP4026	2.6	3	30	61
HSP4027	2.7	3	33	64
HSP4028	2.8	3	33	64
HSP4029	2.9	3	33	64
HSP4030	3.0	3	33	64
HSP4031	3.1	4	36	68
HSP4032	3.2	4	36	68
HSP4033	3.3	4	36	68
HSP4034	3.4	4	39	71
HSP4035	3.5	4	39	71
HSP4036	3.6	4	39	71
HSP4037	3.7	4	39	71
HSP4038	3.8	4	43	75
HSP4039	3.9	4	43	75
HSP4040	4.0	4	43	75
HSP4041	4.1	6	43	85
HSP4042	4.2	6	43	85
HSP4043	4.3	6	47	89
HSP4044	4.4	6	47	89
HSP4045	4.5	6	47	89
HSP4046	4.6	6	47	89
HSP4047	4.7	6	47	89
HSP4048	4.8	6	52	94
HSP4049	4.9	6	52	94

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
HSP4050	5.0	6	52	94
HSP4051	5.1	6	52	94
HSP4052	5.2	6	52	94
HSP4053	5.3	6	52	94
HSP4054	5.4	6	57	99
HSP4055	5.5	6	57	99
HSP4056	5.6	6	57	99
HSP4057	5.7	6	57	99
HSP4058	5.8	6	57	99
HSP4059	5.9	6	57	99
HSP4060	6.0	6	57	99
HSP4061	6.1	8	63	107
HSP4062	6.2	8	63	107
HSP4063	6.3	8	63	107
HSP4064	6.4	8	63	107
HSP4065	6.5	8	63	107
HSP4066	6.6	8	63	107
HSP4067	6.7	8	63	107
HSP4068	6.8	8	69	113
HSP4069	6.9	8	69	113
HSP4070	7.0	8	69	113
HSP4071	7.1	8	69	113
HSP4072	7.2	8	69	113
HSP4073	7.3	8	69	113
HSP4074	7.4	8	69	113
HSP4075	7.5	8	69	113
HSP4076	7.6	8	75	119
HSP4077	7.7	8	75	119
HSP4078	7.8	8	75	119
HSP4079	7.9	8	75	119





HSP4 Series (JOBBER)

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
HSP4080	8.0	8	75	119
HSP4081	8.1	10	75	125
HSP4082	8.2	10	75	125
HSP4083	8.3	10	75	125
HSP4084	8.4	10	75	125
HSP4085	8.5	10	75	125
HSP4086	8.6	10	81	131
HSP4087	8.7	10	81	131
HSP4088	8.8	10	81	131
HSP4089	8.9	10	81	131
HSP4090	9.0	10	81	131
HSP4091	9.1	10	81	131
HSP4092	9.2	10	81	131
HSP4093	9.3	10	81	131
HSP4094	9.4	10	81	131
HSP4095	9.5	10	81	131
HSP4096	9.6	10	87	137
HSP4097	9.7	10	87	137
HSP4098	9.8	10	87	137
HSP4099	9.9	10	87	137
HSP4100	10.0	10	87	137
HSP4101	10.1	12	87	144
HSP4102	10.2	12	87	144
HSP4103	10.3	12	87	144
HSP4104	10.4	12	87	144
HSP4105	10.5	12	87	144

Part Number	Drill Diameter D1	Shank Diameter D2	Flute Length L1	Overall Length L2
HSP4106	10.6	12	87	144
HSP4107	10.7	12	94	151
HSP4108	10.8	12	94	151
HSP4109	10.9	12	94	151
HSP4110	11.0	12	94	151
HSP4111	11.1	12	94	151
HSP4112	11.2	12	94	151
HSP4113	11.3	12	94	151
HSP4114	11.4	12	94	151
HSP4115	11.5	12	94	151
HSP4116	11.6	12	94	151
HSP4117	11.7	12	94	151
HSP4118	11.8	12	94	151
HSP4119	11.9	12	101	158
HSP4120	12.0	12	101	158
HSP4121	12.1	12	101	158
HSP4122	12.2	12	101	158
HSP4123	12.3	12	101	158
HSP4124	12.4	12	101	158
HSP4125	12.5	12	101	158
HSP4126	12.6	12	101	158
HSP4127	12.7	12	101	158
HSP4128	12.8	12	101	158
HSP4129	12.9	12	101	158
HSP4130	13.0	12	101	158

Cutting Condition

Unit:mm

Work Material	Carbon Steel		Alloy Steels Pre-Hardened Steel		Cast Iron		Aluminum Alloys Non Ferrous Alloys		Mold Steel Hardened Steels (HRC30~45) Stainless Steels (SUS304, 200)		Stainless Steels (SUS420,440)	
	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.)



Brisloy Tools India Private Limited  
711, Tower - C, Business Zone  
Nirvana Country, Sec - 50  
Gurugram - 122018  
INDIA  
Phone +91 124 494 9505  
tools@brisloy.com



<http://www.brisloy-tools.com>