

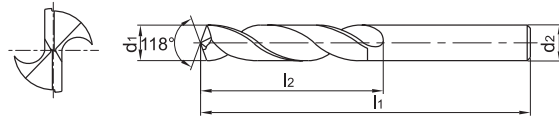


SC series (twist drill) for machining of cast iron, Al alloy



External coolant

Straight shank



- For materials with short chips such as cast iron, silicon-aluminum alloy, etc.
- Cutting edge and shank with same diameter.

Drill diameter $d_1(h_8)$	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)			Recommended grade
					Shank diameter	Overall length	Flute length	
					$d_2(h_7)$	l_1	l_2	YK20F
2.0	3	External coolant	Straight shank	1105SC03-0200	2.0	38	12	☆
	5			1101SC05-0200	2.0	49	24	☆
2.5	3			1105SC03-0250	2.5	43	14	☆
	5			1101SC05-0250	2.5	57	30	☆
2.8	3			1105SC03-0280	2.8	46	16	☆
	5			1101SC05-0280	2.8	61	33	☆
3.0	3			1105SC03-0300	3.0	46	16	☆
	5			1101SC05-0300	3.0	61	33	☆
3.1	3			1105SC03-0310	3.1	49	18	☆
3.2	3			1105SC03-0320	3.2	49	18	☆
3.3	3			1105SC03-0330	3.3	49	18	☆
3.4	3			1105SC03-0340	3.4	52	20	☆
3.5	3			1105SC03-0350	3.5	52	20	☆
	5			1101SC05-0350	3.5	70	39	☆
3.6	3			1105SC03-0360	3.6	52	20	☆
3.7	3			1105SC03-0370	3.7	52	20	☆
3.8	3			1105SC03-0380	3.8	55	22	☆
	5			1101SC05-0380	3.8	75	43	☆
3.9	3			1105SC03-0390	3.9	55	22	☆
4.0	3			1105SC03-0400	4.0	55	22	☆
	5			1101SC05-0400	4.0	75	43	☆
4.1	3			1105SC03-0410	4.1	55	22	☆
4.2	3			1105SC03-0420	4.2	55	22	☆
	5			1101SC05-0420	4.2	75	43	☆
4.3	3	1105SC03-0430	4.3	58	24	☆		
4.4	3	1105SC03-0440	4.4	58	24	☆		
	5	1101SC05-0440	4.4	75	43	☆		
4.5	3	1105SC03-0450	4.5	58	24	☆		
	5	1101SC05-0450	4.5	80	47	☆		
4.6	3	1105SC03-0460	4.6	58	24	☆		
4.7	3	1105SC03-0470	4.7	58	24	☆		
4.8	3	1105SC03-0480	4.8	62	26	☆		
	5	1101SC05-0480	4.8	86	52	☆		

☆ Recommended grade (produce according to order)



Drill diameter d ₁ (h8)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)			Recommended grade
					Shank diameter	Overall length	Flute length	YK20F
					d ₂ (h7)	l ₁	l ₂	
4.9	3	External coolant	Straight shank	1105SC03-0490	4.9	62	26	☆
5.0	3			1105SC03-0500	5.0	62	26	☆
	5			1101SC05-0500	5.0	86	52	☆
5.1	3			1105SC03-0510	5.1	62	26	☆
5.2	3			1105SC03-0520	5.2	62	26	☆
5.3	3			1105SC03-0530	5.3	62	26	☆
5.4	3			1105SC03-0540	5.4	66	28	☆
5.5	3			1105SC03-0550	5.5	66	28	☆
	5			1101SC05-0550	5.5	93	57	☆
5.6	3			1105SC03-0560	5.6	66	28	☆
5.7	3			1105SC03-0570	5.7	66	28	☆
5.8	3			1105SC03-0580	5.8	66	28	☆
	5			1101SC05-0580	5.8	93	57	☆
5.9	3			1105SC03-0590	5.9	66	28	☆
6.0	3			1105SC03-0600	6.0	66	28	☆
	5			1101SC05-0600	6.0	93	57	☆
6.1	3			1105SC03-0610	6.1	70	31	☆
6.2	3			1105SC03-0620	6.2	70	31	☆
6.3	3			1105SC03-0630	6.3	70	31	☆
6.4	3			1105SC03-0640	6.4	70	31	☆
6.5	3			1105SC03-0650	6.5	70	31	☆
	5			1101SC05-0650	6.5	101	63	☆
6.6	3			1105SC03-0660	6.6	70	31	☆
6.7	3			1105SC03-0670	6.7	70	31	☆
6.8	3			1105SC03-0680	6.8	74	34	☆
	5			1101SC05-0680	6.8	109	69	☆
6.9	3			1105SC03-0690	6.9	74	34	☆
7.0	3			1105SC03-0700	7.0	74	34	☆
	5			1101SC05-0700	7.0	109	69	☆
7.1	3			1105SC03-0710	7.1	74	34	☆
7.2	3	1105SC03-0720	7.2	74	34	☆		
7.3	3	1105SC03-0730	7.3	74	34	☆		
7.4	3	1105SC03-0740	7.4	74	34	☆		

☆ Recommended grade (produce according to order)

Drilling tools

SC series

▶▶ Applicable material table

⊙ Very suitable ○ Suitable

Grade	Workpiece material										
	Mild steel HB≤180	Carbon steel, Alloy steel	Pre-hardened steel, Hardened steel			Stainless steel	Cast iron	Nodular cast iron	Aluminum alloy	Copper alloy	Heat resistant alloy
			~40HRC	~50HRC	~60HRC						
YK20F							⊙	○	⊙		

Code key C6

Cutting parameters C83

Technical information C87-C93

Non-standard customization tools C94-C98

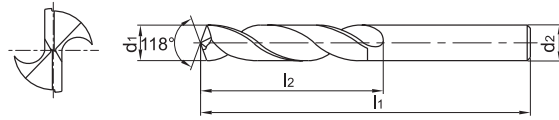


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Drill diameter $d_1(h_8)$	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)			Recommended grade
					Shank diameter	Overall length	Flute length	
					$d_2(h_7)$	l_1	l_2	YK20F
7.5	3	External coolant	Straight shank	1105SC03-0750	7.5	74	34	☆
	5			1101SC05-0750	7.5	109	69	☆
7.6	3			1105SC03-0760	7.6	79	37	☆
7.7	3			1105SC03-0770	7.7	79	37	☆
7.8	3			1105SC03-0780	7.8	79	37	☆
	5			1101SC05-0780	7.8	117	75	☆
7.9	3			1105SC03-0790	7.9	79	37	☆
8.0	3			1105SC03-0800	8.0	79	37	☆
	5			1101SC05-0800	8.0	117	75	☆
8.1	3			1105SC03-0810	8.1	79	37	☆
8.2	3			1105SC03-0820	8.2	79	37	☆
8.3	3			1105SC03-0830	8.3	79	37	☆
8.4	3			1105SC03-0840	8.4	79	37	☆
8.5	3			1105SC03-0850	8.5	79	37	☆
	5			1101SC05-0850	8.5	117	75	☆
8.6	3			1105SC03-0860	8.6	84	40	☆
8.7	3			1105SC03-0870	8.7	84	40	☆
8.8	3			1105SC03-0880	8.8	84	40	☆
	5			1101SC05-0880	8.8	125	81	☆
8.9	3			1105SC03-0890	8.9	84	40	☆
9.0	3			1105SC03-0900	9.0	84	40	☆
	5			1101SC05-0900	9.0	125	81	☆
9.1	3			1105SC03-0910	9.1	84	40	☆
9.2	3			1105SC03-0920	9.2	84	40	☆
9.3	3	1105SC03-0930	9.3	84	40	☆		
9.4	3	1105SC03-0940	9.4	84	40	☆		
9.5	3	1105SC03-0950	9.5	84	40	☆		
	5	1101SC05-0950	9.5	125	81	☆		
9.6	3	1105SC03-0960	9.6	89	43	☆		
9.7	3	1105SC03-0970	9.7	89	43	☆		
9.8	3	1105SC03-0980	9.8	89	43	☆		
	5	1101SC05-0980	9.8	133	87	☆		
9.9	3	1105SC03-0990	9.9	89	43	☆		

☆ Recommended grade (produce according to order)



Drill diameter d ₁ (h8)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)			Recommended grade
					Shank diameter	Overall length	Flute length	YK20F
					d ₂ (h7)	l ₁	l ₂	
10.0	3	External coolant	Straight shank	1105SC03-1000	10.0	89	43	☆
	5			1101SC05-1000	10.0	133	87	☆
10.1	3			1105SC03-1010	10.1	89	43	☆
10.2	3			1105SC03-1020	10.2	89	43	☆
10.4	3			1105SC03-1040	10.4	89	43	☆
10.5	3			1105SC03-1050	10.5	89	43	☆
	5			1101SC05-1050	10.5	133	87	☆
10.7	3			1105SC03-1070	10.7	95	47	☆
10.8	3			1105SC03-1080	10.8	95	47	☆
	5			1101SC05-1080	10.8	142	94	☆
11.0	3			1105SC03-1100	11.0	95	47	☆
	5			1101SC05-1100	11.0	142	94	☆
11.5	3			1105SC03-1150	11.5	95	47	☆
	5			1101SC05-1150	11.5	142	94	☆
12.0	3			1105SC03-1200	12.0	102	51	☆
	5			1101SC05-1200	12.0	151	101	☆
12.5	3			1105SC03-1250	12.5	102	51	☆
	5			1101SC05-1250	12.5	151	101	☆
12.8	3			1105SC03-1280	12.8	102	51	☆
13.0	3			1105SC03-1300	13.0	102	51	☆
	5			1101SC05-1300	13.0	151	101	☆
13.1	3			1105SC03-1310	13.1	102	51	☆
13.5	3			1105SC03-1350	13.5	107	54	☆
	5			1101SC05-1350	13.5	160	108	☆
14.0	3			1105SC03-1400	14.0	107	54	☆
	5			1101SC05-1400	14.0	160	108	☆
14.3	3			1105SC03-1430	14.3	111	56	☆
14.5	3			1105SC03-1450	14.5	111	56	☆
	5			1101SC05-1450	14.5	169	114	☆
15.0	3			1105SC03-1500	15.0	111	56	☆
	5			1101SC05-1500	15.0	169	114	☆
15.5	5			1101SC05-1550	15.5	178	120	☆
16.0	3	1105SC03-1600	16.0	115	58	☆		
	5	1101SC05-1600	16.0	178	120	☆		

☆ Recommended grade (produce according to order)

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	Mild steel HB≤180	Carbon steel, Alloy steel	Pre-hardened steel, Hardened steel			Stainless steel	Cast iron	Nodular cast iron	Aluminum alloy	Copper alloy	Heat resistant alloy
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