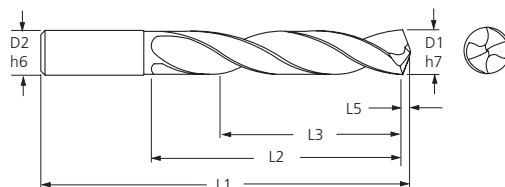


Twister® HPD Performance Drill

Series HPDSR & HPDCR 5xD

Series HPDSR							
Series HPDCR							



Features

- Self centring point
- h7 tolerance
- h6 shank tolerance
- Wide material application area
- Economical choice

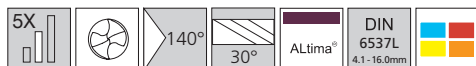
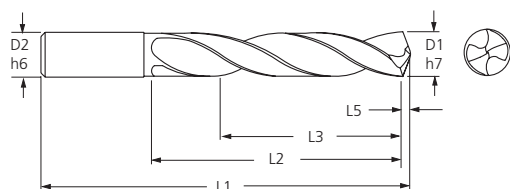
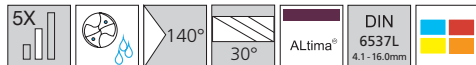
Benefits

- Eliminates the need for spot drilling
- Precision holes
- Shrink fit applications
- Steels, Stainless Steels, Cast Irons, Titanium & Heat resistant alloys
- Perfect for contract machining and small batch production requiring a high-performance drill



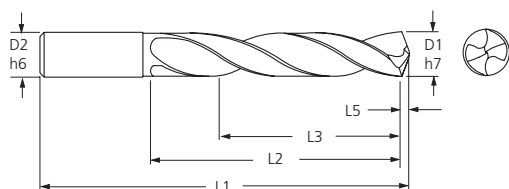
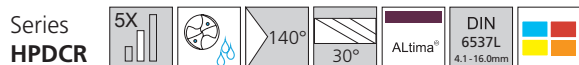
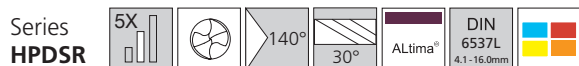
Tool Dimensions						Series HPDSR		Series HPDCR	
Ø D1 (h7)	Ø D2 (h6)	L1	L2 (Max.)	L3	L5	Tool No.	GBP	Tool No.	GBP
3.0	3.0	66.0	28.0	23.0	0.46	HPDSR 0300A	£22.00	HPDCR 0300A	£31.00
3.1	4.0	66.0	28.0	23.0	0.48	HPDSR 0310A	£22.00	HPDCR 0310A	£31.00
3.2	4.0	66.0	28.0	23.0	0.49	HPDSR 0320A	£22.00	HPDCR 0320A	£31.00
3.3	4.0	66.0	28.0	23.0	0.51	HPDSR 0330A	£22.00	HPDCR 0330A	£31.00
3.4	4.0	66.0	28.0	23.0	0.52	HPDSR 0340A	£22.00	HPDCR 0340A	£31.00
3.5	4.0	66.0	28.0	23.0	0.54	HPDSR 0350A	£22.00	HPDCR 0350A	£31.00
3.6	4.0	66.0	28.0	23.0	0.55	HPDSR 0360A	£22.00	HPDCR 0360A	£31.00
3.7	4.0	66.0	28.0	23.0	0.57	HPDSR 0370A	£22.00	HPDCR 0370A	£31.00
3.8	4.0	74.0	36.0	29.0	0.58	HPDSR 0380A	£22.00	HPDCR 0380A	£31.00
3.9	4.0	74.0	36.0	29.0	0.60	HPDSR 0390A	£22.00	HPDCR 0390A	£31.00
4.0	4.0	74.0	36.0	29.0	0.61	HPDSR 0400A	£22.00	HPDCR 0400A	£31.00
4.1	6.0	74.0	36.0	29.0	0.64	HPDSR 0410A	£23.60	HPDCR 0410A	£31.00
4.2	6.0	74.0	36.0	29.0	0.64	HPDSR 0420A	£23.60	HPDCR 0420A	£31.00
4.3	6.0	74.0	36.0	29.0	0.66	HPDSR 0430A	£23.60	HPDCR 0430A	£31.00
4.4	6.0	74.0	36.0	29.0	0.67	HPDSR 0440A	£23.60	HPDCR 0440A	£31.00
4.5	6.0	74.0	36.0	29.0	0.69	HPDSR 0450A	£23.60	HPDCR 0450A	£31.00
4.6	6.0	74.0	36.0	29.0	0.71	HPDSR 0460A	£23.60	HPDCR 0460A	£31.00
4.7	6.0	74.0	36.0	29.0	0.72	HPDSR 0470A	£23.60	HPDCR 0470A	£31.00
4.8	6.0	82.0	44.0	35.0	0.74	HPDSR 0480A	£23.60	HPDCR 0480A	£31.00
4.9	6.0	82.0	44.0	35.0	0.75	HPDSR 0490A	£23.60	HPDCR 0490A	£31.00
5.0	6.0	82.0	44.0	35.0	0.77	HPDSR 0500A	£23.60	HPDCR 0500A	£31.00
5.1	6.0	82.0	44.0	35.0	0.78	HPDSR 0510A	£23.60	HPDCR 0510A	£31.00
5.2	6.0	82.0	44.0	35.0	0.80	HPDSR 0520A	£23.60	HPDCR 0520A	£31.00
5.3	6.0	82.0	44.0	35.0	0.81	HPDSR 0530A	£23.60	HPDCR 0530A	£31.00
5.4	6.0	82.0	44.0	35.0	0.83	HPDSR 0540A	£23.60	HPDCR 0540A	£31.00
5.5	6.0	82.0	44.0	35.0	0.84	HPDSR 0550A	£23.60	HPDCR 0550A	£31.00
5.6	6.0	82.0	44.0	35.0	0.86	HPDSR 0560A	£23.60	HPDCR 0560A	£31.00
5.7	6.0	82.0	44.0	35.0	0.87	HPDSR 0570A	£23.60	HPDCR 0570A	£31.00

Twister® HPD Performance Drill Series HPDSR & HPDCR 5xD

Series
HPDSR

Series
HPDCR


Tool Dimensions						Series HPDSR		Series HPDCR	
Ø D1 (h7)	Ø D2 (h6)	L1	L2 (Max.)	L3	L5	Tool No.	GBP	Tool No.	GBP
5.8	6.0	82.0	44.0	35.0	0.89	HPDSR 0580A	£23.60	HPDCR 0580A	£31.00
5.9	6.0	82.0	44.0	35.0	0.90	HPDSR 0590A	£23.60	HPDCR 0590A	£31.00
6.0	6.0	82.0	44.0	35.0	0.92	HPDSR 0600A	£23.60	HPDCR 0600A	£31.00
6.1	8.0	91.0	53.0	43.0	0.94	HPDSR 0610A	£23.60	HPDCR 0610A	£38.60
6.2	8.0	91.0	53.0	43.0	0.95	HPDSR 0620A	£23.60	HPDCR 0620A	£38.60
6.3	8.0	91.0	53.0	43.0	0.97	HPDSR 0630A	£23.60	HPDCR 0630A	£38.60
6.4	8.0	91.0	53.0	43.0	0.98	HPDSR 0640A	£23.60	HPDCR 0640A	£38.60
6.5	8.0	91.0	53.0	43.0	1.00	HPDSR 0650A	£23.60	HPDCR 0650A	£38.60
6.6	8.0	91.0	53.0	43.0	1.01	HPDSR 0660A	£23.60	HPDCR 0660A	£38.60
6.7	8.0	91.0	53.0	43.0	1.03	HPDSR 0670A	£23.60	HPDCR 0670A	£38.60
6.8	8.0	91.0	53.0	43.0	1.04	HPDSR 0680A	£23.60	HPDCR 0680A	£38.60
6.9	8.0	91.0	53.0	43.0	1.06	HPDSR 0690A	£23.60	HPDCR 0690A	£38.60
7.0	8.0	91.0	53.0	43.0	1.07	HPDSR 0700A	£23.60	HPDCR 0700A	£38.60
7.1	8.0	91.0	53.0	43.0	1.09	HPDSR 0710A	£23.60	HPDCR 0710A	£38.60
7.2	8.0	91.0	53.0	43.0	1.10	HPDSR 0720A	£23.60	HPDCR 0720A	£38.60
7.3	8.0	91.0	53.0	43.0	1.12	HPDSR 0730A	£23.60	HPDCR 0730A	£38.60
7.4	8.0	91.0	53.0	43.0	1.13	HPDSR 0740A	£23.60	HPDCR 0740A	£38.60
7.5	8.0	91.0	53.0	43.0	1.15	HPDSR 0750A	£23.60	HPDCR 0750A	£38.60
7.6	8.0	91.0	53.0	43.0	1.17	HPDSR 0760A	£23.60	HPDCR 0760A	£38.60
7.7	8.0	91.0	53.0	43.0	1.18	HPDSR 0770A	£23.60	HPDCR 0770A	£38.60
7.8	8.0	91.0	53.0	43.0	1.20	HPDSR 0780A	£23.60	HPDCR 0780A	£38.60
7.9	8.0	91.0	53.0	43.0	1.21	HPDSR 0790A	£23.60	HPDCR 0790A	£38.60
8.0	8.0	91.0	53.0	43.0	1.23	HPDSR 0800A	£23.60	HPDCR 0800A	£38.60
8.1	10.0	103.0	61.0	49.0	1.24	HPDSR 0810A	£26.50	HPDCR 0810A	£45.00
8.2	10.0	103.0	61.0	49.0	1.26	HPDSR 0820A	£26.50	HPDCR 0820A	£45.00
8.3	10.0	103.0	61.0	49.0	1.27	HPDSR 0830A	£26.50	HPDCR 0830A	£45.00
8.4	10.0	103.0	61.0	49.0	1.29	HPDSR 0840A	£26.50	HPDCR 0840A	£45.00
8.5	10.0	103.0	61.0	49.0	1.30	HPDSR 0850A	£26.50	HPDCR 0850A	£45.00
8.6	10.0	103.0	61.0	49.0	1.32	HPDSR 0860A	£26.50	HPDCR 0860A	£45.00
8.7	10.0	103.0	61.0	49.0	1.33	HPDSR 0870A	£26.50	HPDCR 0870A	£45.00
8.8	10.0	103.0	61.0	49.0	1.35	HPDSR 0880A	£26.50	HPDCR 0880A	£45.00
8.9	10.0	103.0	61.0	49.0	1.36	HPDSR 0890A	£26.50	HPDCR 0890A	£45.00
9.0	10.0	103.0	61.0	49.0	1.38	HPDSR 0900A	£26.50	HPDCR 0900A	£45.00
9.1	10.0	103.0	61.0	49.0	1.40	HPDSR 0910A	£26.50	HPDCR 0910A	£45.00
9.2	10.0	103.0	61.0	49.0	1.41	HPDSR 0920A	£26.50	HPDCR 0920A	£45.00
9.3	10.0	103.0	61.0	49.0	1.43	HPDSR 0930A	£26.50	HPDCR 0930A	£45.00
9.4	10.0	103.0	61.0	49.0	1.44	HPDSR 0940A	£26.50	HPDCR 0940A	£45.00
9.5	10.0	103.0	61.0	49.0	1.46	HPDSR 0950A	£26.50	HPDCR 0950A	£45.00
9.6	10.0	103.0	61.0	49.0	1.47	HPDSR 0960A	£26.50	HPDCR 0960A	£45.00

Twister® HPD Performance Drill Series HPDSR & HPDCR 5xD

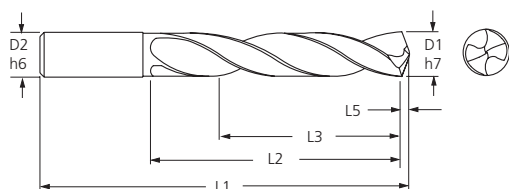


Tool Dimensions						Series HPDSR		Series HPDCR	
Ø D1 (h7)	Ø D2 (h6)	L1	L2 (Max.)	L3	L5	Tool No.	GBP	Tool No.	GBP
9.7	10.0	103.0	61.0	49.0	1.49	HPDSR 0970A	£26.50	HPDCR 0970A	£45.00
9.8	10.0	103.0	61.0	49.0	1.50	HPDSR 0980A	£26.50	HPDCR 0980A	£45.00
9.9	10.0	103.0	61.0	49.0	1.52	HPDSR 0990A	£26.50	HPDCR 0990A	£45.00
10.0	10.0	103.0	61.0	49.0	1.53	HPDSR 1000A	£26.50	HPDCR 1000A	£45.00
10.1	12.0	118.0	71.0	56.0	1.55	HPDSR 1010A	£39.50	HPDCR 1010A	£62.00
10.2	12.0	118.0	71.0	56.0	1.56	HPDSR 1020A	£39.50	HPDCR 1020A	£62.00
10.3	12.0	118.0	71.0	56.0	1.58	HPDSR 1030A	£39.50	HPDCR 1030A	£62.00
10.4	12.0	118.0	71.0	56.0	1.59	HPDSR 1040A	£39.50	HPDCR 1040A	£62.00
10.5	12.0	118.0	71.0	56.0	1.61	HPDSR 1050A	£39.50	HPDCR 1050A	£62.00
10.6	12.0	118.0	71.0	56.0	1.63	HPDSR 1060A	£39.50	HPDCR 1060A	£62.00
10.7	12.0	118.0	71.0	56.0	1.64	HPDSR 1070A	£39.50	HPDCR 1070A	£62.00
10.8	12.0	118.0	71.0	56.0	1.66	HPDSR 1080A	£39.50	HPDCR 1080A	£62.00
10.9	12.0	118.0	71.0	56.0	1.67	HPDSR 1090A	£39.50	HPDCR 1090A	£62.00
11.0	12.0	118.0	71.0	56.0	1.69	HPDSR 1100A	£39.50	HPDCR 1100A	£62.00
11.1	12.0	118.0	71.0	56.0	1.70	HPDSR 1110A	£39.50	HPDCR 1110A	£62.00
11.2	12.0	118.0	71.0	56.0	1.72	HPDSR 1120A	£39.50	HPDCR 1120A	£62.00
11.3	12.0	118.0	71.0	56.0	1.73	HPDSR 1130A	£39.50	HPDCR 1130A	£62.00
11.4	12.0	118.0	71.0	56.0	1.75	HPDSR 1140A	£39.50	HPDCR 1140A	£62.00
11.5	12.0	118.0	71.0	56.0	1.76	HPDSR 1150A	£39.50	HPDCR 1150A	£62.00
11.6	12.0	118.0	71.0	56.0	1.78	HPDSR 1160A	£39.50	HPDCR 1160A	£62.00
11.7	12.0	118.0	71.0	56.0	1.79	HPDSR 1170A	£39.50	HPDCR 1170A	£62.00
11.8	12.0	118.0	71.0	56.0	1.81	HPDSR 1180A	£39.50	HPDCR 1180A	£62.00
11.9	12.0	118.0	71.0	56.0	1.82	HPDSR 1190A	£39.50	HPDCR 1190A	£62.00
12.0	12.0	118.0	71.0	56.0	1.84	HPDSR 1200A	£39.50	HPDCR 1200A	£62.00
12.1	14.0	124.0	77.0	60.0	1.86	HPDSR 1210A	£52.50	HPDCR 1210A	£84.00
12.2	14.0	124.0	77.0	60.0	1.87	HPDSR 1220A	£52.50	HPDCR 1220A	£84.00
12.3	14.0	124.0	77.0	60.0	1.89	HPDSR 1230A	£52.50	HPDCR 1230A	£84.00
12.4	14.0	124.0	77.0	60.0	1.90	HPDSR 1240A	£52.50	HPDCR 1240A	£84.00
12.5	14.0	124.0	77.0	60.0	1.92	HPDSR 1250A	£52.50	HPDCR 1250A	£84.00
12.6	14.0	124.0	77.0	60.0	1.93	HPDSR 1260A	£52.50	HPDCR 1260A	£84.00
12.7	14.0	124.0	77.0	60.0	1.95	HPDSR 1270A	£52.50	HPDCR 1270A	£84.00
12.8	14.0	124.0	77.0	60.0	1.96	HPDSR 1280A	£52.50	HPDCR 1280A	£84.00
12.9	14.0	124.0	77.0	60.0	1.99	HPDSR 1290A	£52.50	HPDCR 1290A	£84.00
13.0	14.0	124.0	77.0	60.0	1.98	HPDSR 1300A	£52.50	HPDCR 1300A	£84.00
13.1	14.0	124.0	77.0	60.0	2.01	HPDSR 1310A	£52.50	HPDCR 1310A	£84.00
13.2	14.0	124.0	77.0	60.0	2.02	HPDSR 1320A	£52.50	HPDCR 1320A	£84.00
13.3	14.0	124.0	77.0	60.0	2.04	HPDSR 1330A	£52.50	HPDCR 1330A	£84.00
13.4	14.0	124.0	77.0	60.0	2.05	HPDSR 1340A	£52.50	HPDCR 1340A	£84.00
13.5	14.0	124.0	77.0	60.0	2.07	HPDSR 1350A	£52.50	HPDCR 1350A	£84.00

Twister® HPD Performance Drill Series HPDSR & HPDCR 5xD

Series **HPDSR**

Series **HPDCR**



Tool Dimensions						Series HPDSR		Series HPDCR	
Ø D1 (h7)	Ø D2 (h6)	L1	L2 (Max.)	L3	L5	Tool No.	GBP	Tool No.	GBP
13.6	14.0	124.0	77.0	60.0	2.09	HPDSR 1360A	£52.50	HPDCR 1360A	£84.00
13.7	14.0	124.0	77.0	60.0	2.10	HPDSR 1370A	£52.50	HPDCR 1370A	£84.00
13.8	14.0	124.0	77.0	60.0	2.12	HPDSR 1380A	£52.50	HPDCR 1380A	£84.00
13.9	14.0	124.0	77.0	60.0	2.13	HPDSR 1390A	£52.50	HPDCR 1390A	£84.00
14.0	14.0	124.0	77.0	60.0	2.15	HPDSR 1400A	£52.50	HPDCR 1400A	£84.00
14.1	16.0	133.0	83.0	63.0	2.16	HPDSR 1410A	£62.50	HPDCR 1410A	£88.00
14.2	16.0	133.0	83.0	63.0	2.18	HPDSR 1420A	£62.50	HPDCR 1420A	£88.00
14.3	16.0	133.0	83.0	63.0	2.19	HPDSR 1430A	£62.50	HPDCR 1430A	£88.00
14.4	16.0	133.0	83.0	63.0	2.21	HPDSR 1440A	£62.50	HPDCR 1440A	£88.00
14.5	16.0	133.0	83.0	63.0	2.22	HPDSR 1450A	£62.50	HPDCR 1450A	£88.00
14.6	16.0	133.0	83.0	63.0	2.24	HPDSR 1460A	£62.50	HPDCR 1460A	£88.00
14.7	16.0	133.0	83.0	63.0	2.25	HPDSR 1470A	£62.50	HPDCR 1470A	£88.00
14.8	16.0	133.0	83.0	63.0	2.27	HPDSR 1480A	£62.50	HPDCR 1480A	£88.00
14.9	16.0	133.0	83.0	63.0	2.28	HPDSR 1490A	£62.50	HPDCR 1490A	£88.00
15.0	16.0	133.0	83.0	63.0	2.30	HPDSR 1500A	£62.50	HPDCR 1500A	£88.00
15.1	16.0	133.0	83.0	63.0	2.32	HPDSR 1510A	£62.50	HPDCR 1510A	£95.00
15.2	16.0	133.0	83.0	63.0	2.33	HPDSR 1520A	£62.50	HPDCR 1520A	£95.00
15.3	16.0	133.0	83.0	63.0	2.35	HPDSR 1530A	£62.50	HPDCR 1530A	£95.00
15.4	16.0	133.0	83.0	63.0	2.36	HPDSR 1540A	£62.50	HPDCR 1540A	£95.00
15.5	16.0	133.0	83.0	63.0	2.38	HPDSR 1550A	£62.50	HPDCR 1550A	£95.00
15.6	16.0	133.0	83.0	63.0	2.39	HPDSR 1560A	£62.50	HPDCR 1560A	£95.00
15.7	16.0	133.0	83.0	63.0	2.41	HPDSR 1570A	£62.50	HPDCR 1570A	£95.00
15.8	16.0	133.0	83.0	63.0	2.42	HPDSR 1580A	£62.50	HPDCR 1580A	£95.00
15.9	16.0	133.0	83.0	63.0	2.44	HPDSR 1590A	£62.50	HPDCR 1590A	£95.00
16.0	16.0	133.0	83.0	63.0	2.45	HPDSR 1600A	£62.50	HPDCR 1600A	£95.00

Twister® HPD Performance Drill

Series HPDSS & HPDCS 3xD, Series HPDSR & HPDCR 5xD

Recommended cutting data

Workpiece Material Group		Material Type	HPDSS			HPDCS		
			3xD			3xD - Through Coolant		
			Low	Mid	High	Low	Mid	High
			Vc-m/min			Vc-m/min		
Steels	P	Low Carbon Steels ≤180HB	140	160	180	170	190	210
		Med Carbon / Alloy Steels 180-350HB	80	90	100	90	110	130
		Pre-Hardened Steels 35-45HRC	40	50	60	60	70	80
Stainless Steels	M	Martensitic Stainless - 400 Series	90	100	110	100	120	140
		Austenitic Stainless - 300 Series	40	50	60	60	70	80
Cast Irons	K	Grey Cast Iron	100	120	140	130	150	170
		Ductile Cast Iron	50	60	70	70	80	90

RPM Formula For Metric Drills - $RPM = (Vc \times 318) / \text{Drill } \varnothing D1$

Workpiece Material Group		Material Type	HPDSR			HPDCR		
			5xD			5xD - Through Coolant		
			Low	Mid	High	Low	Mid	High
			Vc-m/min			Vc-m/min		
Steels	P	Low Carbon Steels ≤180HB	130	150	170	160	180	200
		Med Carbon / Alloy Steels 180-350HB	70	80	90	90	100	110
		Pre-Hardened Steels 35-45HRC	40	50	60	50	60	70
Stainless Steels	M	Martensitic Stainless - 400 Series	80	90	100	90	110	130
		Austenitic Stainless - 300 Series	40	50	60	50	60	70
Cast Irons	K	Grey Cast Iron	90	110	130	120	140	160
		Ductile Cast Iron	40	50	60	60	70	80

RPM Formula For Metric Drills - $RPM = (Vc \times 318) / \text{Drill } \varnothing D1$

Workpiece Material Group		Material Type	Drill Diameter (mm)							
			3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0
			Feed (mm/rev)							
Steels	P	Low Carbon Steels ≤180HB	0.145	0.181	0.181	0.226	0.285	0.362	0.3632	0.453
		Med Carbon / Alloy Steels 180-350HB								
		Pre-Hardened Steels 35-45HRC								
Stainless Steels	M	Martensitic Stainless - 400 Series	0.07	0.09	0.09	0.11	0.14	0.18	0.18	0.225
		Austenitic Stainless - 300 Series								
Cast Irons	K	Grey Cast Iron	0.155	0.193	0.217	0.305	0.305	0.386	0.435	0.532
		Ductile Cast Iron								

Feedrate Formula For Metric Drills - $\text{Feed} = RPM \times \text{mm/rev}$