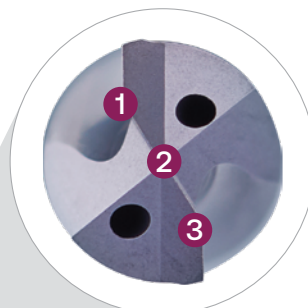


FEATURES & BENEFITS

DR Mini



1 Split Point Design

Provides self centering ability and reduced thrust

2 X-Thinning

Better self-centering on initial cutting

3 Straight Edge Profile

Shorter chip and reinforced cutting edge

4 Polished Flute

- Smoother chips evacuation
- Less build up edge

5 Suitable for Material



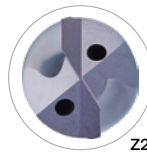
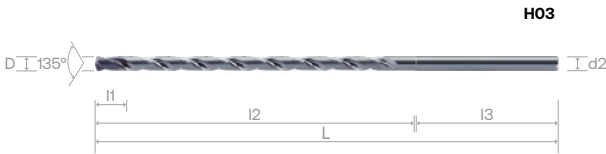
DR MINI OIL FEED MINIATURE TWIST DRILLS - 135° POINT ANGLE - 5 X Ø, 8X Ø, 12 X Ø, 15X Ø, 20X Ø, 25X Ø, 30X Ø

 VHM DR MINI Kühlkanalbohrer nach 135° Spitzenwinkel, Schaft nach DIN 6535HA 5 x Ø, 8x Ø, 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø

 Punte elicoidali DR MINI, con foro di lubrificazione, angolo di punta 135°, codolo DIN 6535HA- 5 x Ø, 8x Ø, 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø

 Forets hélicoïdaux DR MINI à trous d'huile angle de pointe 135°, queue selon DIN 6535HA- 5 x Ø, 8x Ø, 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø

 整体硬质合金 DR MINI 系列 内冷孔钻头-相当于2刃, 柄部标准DIN6535HA, 顶角135° 5 x Ø, 8x Ø, 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø



Order Number	Dimension (mm)						T8090
	Hole Depth L2/D	D (h7)	I1	I2	L	d2 (h6)	
H03 0100 5	5 x D	100	6.5	8.0	50	3	•
H03 0100 8	8 x D		9.5	11.0	50	3	•
H03 0100 12	12 x D		13.5	15.0	55	3	•
H03 0100 20	20 x D		21.5	23.0	65	3	•
H03 0100 25	25 x D		26.5	28.0	70	3	•
H03 0100 30	30 x D	110	31.5	33.0	75	3	•
H03 0100 5	5 x D		7.2	8.7	50	3	•
H03 0100 8	8 x D		10.5	12.0	50	3	•
H03 0100 12	12 x D		14.9	16.4	55	3	•
H03 0100 20	20 x D		23.7	25.2	65	3	•
H03 0100 25	25 x D	120	29.2	30.7	70	3	•
H03 0100 30	30 x D		34.7	36.2	75	3	•
H03 0120 5	5 x D		7.8	9.3	50	3	•
H03 0120 8	8 x D		11.4	12.9	50	3	•
H03 0120 12	12 x D		16.2	17.7	55	3	•
H03 0120 20	20 x D	130	25.8	27.3	65	3	•
H03 0120 25	25 x D		31.8	33.3	75	3	•
H03 0120 30	30 x D		37.8	39.3	75	3	•
H03 0130 5	5 x D		8.5	10.0	50	3	•
H03 0130 8	8 x D		12.4	13.9	50	3	•
H03 0130 12	12 x D	140	17.6	19.1	55	3	•
H03 0130 20	20 x D		28.0	29.5	65	3	•
H03 0130 25	25 x D		34.5	36.0	75	3	•
H03 0130 30	30 x D		41.0	42.5	85	3	•
H03 0140 5	5 x D		9.1	10.6	50	3	•
H03 0140 8	8 x D	150	13.3	14.8	50	3	•
H03 0140 12	12 x D		18.9	20.4	55	3	•
H03 0140 20	20 x D		30.1	31.6	65	3	•
H03 0140 25	25 x D		37.1	38.6	75	3	•
H03 0140 30	30 x D		44.1	45.6	85	3	•
H03 0150 5	5 x D	160	9.8	11.3	50	3	•
H03 0150 8	8 x D		14.3	15.8	50	3	•
H03 0150 12	12 x D		20.3	21.8	55	3	•
H03 0150 20	20 x D		32.3	33.8	75	3	•
H03 0150 25	25 x D		39.8	41.3	80	3	•
H03 0150 30	30 x D	170	47.3	48.8	85	3	•
H03 0160 5	5 x D		10.4	11.9	50	3	•
H03 0160 8	8 x D		15.2	16.7	50	3	•
H03 0160 12	12 x D		21.6	23.1	65	3	•
H03 0160 20	20 x D		34.4	35.9	75	3	•
H03 0160 25	25 x D	240	42.4	43.9	80	3	•
H03 0160 30	30 x D		50.4	51.9	90	3	•
H03 0170 5	5 x D		11.1	12.6	55	3	•
H03 0170 8	8 x D		16.2	17.7	60	3	•
H03 0170 12	12 x D		23.0	24.5	65	3	•
H03 0170 20	20 x D	250	36.6	38.1	75	3	•
H03 0170 25	25 x D		45.1	46.6	80	3	•
H03 0170 30	30 x D		53.6	55.1	90	3	•
H03 0180 5	5 x D	180	11.7	13.2	55	3	•
H03 0180 8	8 x D		17.1	18.6	60	3	•
H03 0180 12	12 x D		24.3	25.8	65	3	•
H03 0180 20	20 x D		38.7	40.2	75	3	•
H03 0180 25	25 x D		47.7	49.2	90	3	•
H03 0180 30	30 x D	190	56.7	58.2	100	3	•
H03 0190 5	5 x D		12.4	13.9	55	3	•
H03 0190 8	8 x D		18.1	19.6	60	3	•
H03 0190 12	12 x D		25.7	27.2	65	3	•
H03 0190 20	20 x D		40.9	42.4	75	3	•
H03 0190 25	25 x D	200	50.4	51.9	90	3	•
H03 0190 30	30 x D		59.9	61.4	100	3	•
H03 0200 5	5 x D		13.0	16.0	55	3	•
H03 0200 8	8 x D		19.0	22.0	60	3	•
H03 0200 12	12 x D		27.0	30.0	65	3	•
H03 0200 20	20 x D	210	43.0	46.0	82	3	•
H03 0200 25	25 x D		53.0	56.0	90	3	•
H03 0200 30	30 x D		63.0	66.0	100	3	•
H03 0210 5	5 x D		13.7	16.9	55	3	•
H03 0210 8	8 x D		20.0	23.2	60	3	•
H03 0210 12	12 x D	220	28.4	31.6	65	3	•
H03 0210 20	20 x D		45.2	48.4	82	3	•
H03 0210 25	25 x D		55.7	58.8	100	3	•
H03 0210 30	30 x D		66.2	69.3	110	3	•
H03 0220 5	5 x D		14.3	17.6	55	3	•
H03 0220 8	8 x D	230	20.9	24.2	60	3	•
H03 0220 12	12 x D		29.7	33.0	65	3	•
H03 0220 20	20 x D		47.3	50.6	82	3	•
H03 0220 25	25 x D		58.3	61.6	100	3	•
H03 0220 30	30 x D		69.3	72.6	110	3	•
H03 0230 5	5 x D	240	15.0	18.5	55	3	•
H03 0230 8	8 x D		21.9	25.4	60	3	•
H03 0230 12	12 x D		31.1	34.6	65	3	•
H03 0230 20	20 x D		49.5	53.0	100	3	•
H03 0230 25	25 x D		61.0	64.4	100	3	•
H03 0230 30	30 x D	250	72.5	75.9	110	3	•
H03 0240 5	5 x D		15.6	19.2	55	3	•
H03 0240 8	8 x D		22.8	26.4	60	3	•
H03 0240 12	12 x D		32.4	36.0	75	3	•
H03 0240 20	20 x D		51.6	55.2	100	3	•
H03 0240 25	25 x D	260	63.6	67.2	100	3	•
H03 0240 30	30 x D		75.6	79.2	120	3	•
H03 0250 5	5 x D		16.3	20.1	55	3	•
H03 0250 8	8 x D		23.8	27.6	60	3	•
H03 0250 12	12 x D		33.8	37.6	75	3	•
H03 0250 20	20 x D		53.8	57.6	100	3	•
H03 0250 25	25 x D		66.3	70.0	110	3	•
H03 0250 30	30 x D		78.8	82.5	120	3	•

* - DIN 6535

cont'd ▶

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02
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481 - 482

DR MINI OIL FEED MINIATURE TWIST DRILLS - 135° POINT ANGLE - 5 X Ø, 8X Ø, 12 X Ø, 15X Ø, 20X Ø, 25X Ø, 30X Ø

 VHM DR MINI Kühlkanalbohrer nach 135° Spitzenwinkel, Schaft nach DIN 6535HA 5 x Ø, 8x Ø, Ø12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø

 Punte elicoidali DR MINI, con foro di lubrificazione, angolo di punta 135°, codolo DIN 6535HA-5 x Ø, 8x Ø, 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø

 Forêts hélicoïdaux DR MINI à trous d'huile angle de pointe 135°, queue selon DIN 6535HA- 5 x Ø, 8x Ø, 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø

 整体硬质合金 DR MINI 系列 内冷孔钻头-相等于2刃, 柄部标准DIN6535HA, 顶角135° 5 x Ø, 8x Ø, 12 x Ø, 15x Ø, 20x Ø, 25x Ø, 30x Ø

[illegible]

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter

481 - 482

Recommended Cutting Data



Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



DR Mini Oil Feed Twist Drill - Point Angle 135°, 5 × D, 8 × D - H03



Working Material	N						K				S	
	Wrought Aluminium		Cast Aluminium		Copper Alloy		Grey Cast Iron		Ductile Cast Iron		Titanium alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0	145	0.017	125	0.018	115	0.016	85	0.018	65	0.016	30	0.013
1.5		0.026		0.026		0.024		0.027		0.024		0.019
2.0		0.035		0.035		0.032		0.035		0.032		0.025
2.5		0.043		0.044		0.040		0.044		0.040		0.031
3.0		0.052		0.053		0.049		0.053		0.048		0.038

DR Mini Oil Feed Twist Drill - Point Angle 135°, 5 × D, 8 × D - H03



Working Material	P						M				S	
	Carbon Steel		Alloy Steel		Prehardened Steel		Stainless Steel		Stainless Steel		Nickel Alloy	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0	90	0.017	80	0.016	65	0.014	60	0.015	40	0.014	20	0.009
1.5		0.026		0.024		0.022		0.022		0.021		0.016
2.0		0.035		0.031		0.029		0.029		0.028		0.025
2.5		0.043		0.039		0.036		0.036		0.035		0.035
3.0		0.052		0.047		0.043		0.044		0.042		0.045

DR Mini Oil Feed Twist Drill - Point Angle 135°, 12 × D, 20 × D - H03



Working Material	N						K				S	
	Wrought Aluminium		Cast Aluminium		Copper Alloy		Grey Cast Iron		Ductile Cast Iron		Titanium alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0	130	0.016	115	0.016	105	0.015	80	0.014	55	0.014	30	0.010
1.5		0.025		0.024		0.022		0.021		0.021		0.016
2.0		0.033		0.032		0.029		0.028		0.028		0.021
2.5		0.041		0.039		0.037		0.035		0.035		0.026
3.0		0.049		0.047		0.044		0.042		0.042		0.031

DR Mini Oil Feed Twist Drill - Point Angle 135°, 12 × D, 20 × D - H03



Working Material	P						M				S	
	Carbon Steel		Alloy Steel		Prehardened Steel		Stainless Steel		Stainless Steel		Nickel Alloy	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0	85	0.014	65	0.014	55	0.010	50	0.010	40	0.009	15	0.010
1.5		0.021		0.020		0.015		0.015		0.014		0.016
2.0		0.028		0.027		0.020		0.020		0.019		0.025
2.5		0.035		0.034		0.025		0.025		0.024		0.035
3.0		0.042		0.041		0.031		0.030		0.028		0.044

Recommended Cutting Data



Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



DR Mini Oil Feed Twist Drill - Point Angle 135°, 25 × D, 30 × D - H03



Working Material	N						K				S	
	Wrought Aluminium		Cast Aluminium		Copper Alloy		Grey Cast Iron		Ductile Cast Iron		Titanium alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0	125	0.014	105	0.014	95	0.012	75	0.010	50	0.013	30	0.006
1.5		0.021		0.021		0.018		0.015		0.019		0.009
2.0		0.028		0.027		0.024		0.020		0.025		0.013
2.5		0.035		0.034		0.030		0.025		0.031		0.015
3.0		0.042		0.041		0.036		0.030		0.037		0.019

DR Mini Oil Feed Twist Drill - Point Angle 135°, 25 × D, 30 × D - H03



Working Material	P						M				S	
	Carbon Steel		Alloy Steel		Prehardened Steel		Stainless Steel		Stainless Steel		Nickel Alloy	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0	80	0.010	60	0.011	50	0.008	45	0.007	35	0.007	15	0.008
1.5		0.015		0.016		0.011		0.010		0.011		0.013
2.0		0.020		0.022		0.015		0.014		0.014		0.021
2.5		0.025		0.027		0.019		0.017		0.018		0.030
3.0		0.031		0.033		0.022		0.021		0.021		0.038

NC SPOT
DR ALU
EZ LINE -
DRILL
DR NITCO
DR VA
DR-S
DR MINI
DR-LX
DR 45 SB
DR 60