

INOX DRILLS

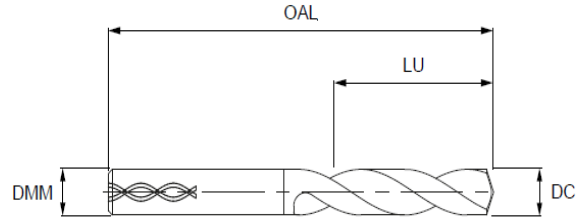


INOX DRILL 3XD

Series No. 823323



Special flute shape and geometry highly suited to machining stainless steels. Excellent chip evacuation due to better surface treatment. Point R-thinning gives superior centering and chip curling. Applied INOX coating achieves better surface finish and longer tool life.



ULDR 3

ISO		P			M		K		N					S		H	
VDI GROUP		1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-39	40-41
● Primary	○ Secondary	●	●	●	●	●			○					○	●		

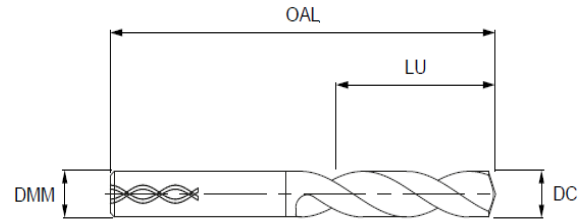
PART NUMBER	OD DC	SD DMM	FL.LTH LU	O/ALL OAL	PRICE	PART NUMBER	OD DC	SD DMM	FL.LTH LU	O/ALL OAL	PRICE
8233230300	3.0	6.0	20	62	£24.59	8233230610	6.1	8.0	34	79	£33.42
8233230310	3.1	6.0	20	62	£24.59	8233230620	6.2	8.0	34	79	£33.42
8233230320	3.2	6.0	20	62	£24.59	8233230630	6.3	8.0	34	79	£33.42
8233230330	3.3	6.0	20	62	£24.59	8233230640	6.4	8.0	34	79	£33.42
8233230340	3.4	6.0	20	62	£24.59	8233230650	6.5	8.0	34	79	£33.42
8233230350	3.5	6.0	20	62	£24.59	8233230660	6.6	8.0	34	79	£33.42
8233230360	3.6	6.0	20	62	£24.59	8233230670	6.7	8.0	34	79	£33.42
8233230370	3.7	6.0	20	62	£24.59	8233230680	6.8	8.0	34	79	£33.42
8233230380	3.8	6.0	24	66	£24.59	8233230690	6.9	8.0	34	79	£33.42
8233230390	3.9	6.0	24	66	£24.59	8233230700	7.0	8.0	34	79	£33.42
8233230400	4.0	6.0	24	66	£24.59	8233230710	7.1	8.0	41	79	£33.42
8233230410	4.1	6.0	24	66	£24.59	8233230720	7.2	8.0	41	79	£33.42
8233230420	4.2	6.0	24	66	£24.59	8233230730	7.3	8.0	41	79	£33.42
8233230430	4.3	6.0	24	66	£24.59	8233230740	7.4	8.0	41	79	£33.42
8233230440	4.4	6.0	24	66	£24.59	8233230750	7.5	8.0	41	79	£33.42
8233230450	4.5	6.0	24	66	£24.59	8233230760	7.6	8.0	41	79	£33.42
8233230460	4.6	6.0	24	66	£24.59	8233230770	7.7	8.0	41	79	£33.42
8233230470	4.7	6.0	24	66	£24.59	8233230780	7.8	8.0	41	79	£33.42
8233230480	4.8	6.0	28	66	£24.59	8233230790	7.9	8.0	41	79	£33.42
8233230490	4.9	6.0	28	66	£24.59	8233230800	8.0	8.0	41	79	£33.42
8233230500	5.0	6.0	28	66	£24.59	8233230810	8.1	10.0	47	89	£37.43
8233230510	5.1	6.0	28	66	£24.59	8233230820	8.2	10.0	47	89	£37.43
8233230520	5.2	6.0	28	66	£24.59	8233230830	8.3	10.0	47	89	£37.43
8233230530	5.3	6.0	28	66	£24.59	8233230840	8.4	10.0	47	89	£37.43
8233230540	5.4	6.0	28	66	£24.59	8233230850	8.5	10.0	47	89	£37.43
8233230550	5.5	6.0	28	66	£24.59	8233230860	8.6	10.0	47	89	£37.43
8233230560	5.6	6.0	28	66	£24.59	8233230870	8.7	10.0	47	89	£37.43
8233230570	5.7	6.0	28	66	£24.59	8233230880	8.8	10.0	47	89	£37.43
8233230580	5.8	6.0	28	66	£24.59	8233230890	8.9	10.0	47	89	£37.43
8233230590	5.9	6.0	28	66	£24.59	8233230900	9.0	10.0	47	89	£37.43
8233230600	6.0	6.0	28	66	£24.59	8233230910	9.1	10.0	47	89	£37.43

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ISO		P			M		K		N					S		H	
VDI GROUP		1-5	6-9	10-11	12, 13	14	15-16	17-20	21-25	26-28	29.1	29.2	30	31-35	36-37	38-39	40-41
● Primary	○ Secondary	●	●	●	●	●			○					○	●		

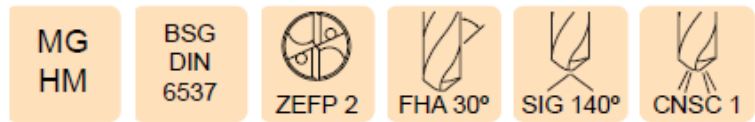
PART NUMBER	OD DC	SD DMM	FL.LTH LU	O/ALL OAL	PRICE
8233230920	9.2	10.0	47	89	£37.43
8233230930	9.3	10.0	47	89	£37.43
8233230940	9.4	10.0	47	89	£37.43
8233230950	9.5	10.0	47	89	£37.43
8233230960	9.6	10.0	47	89	£37.43
8233230970	9.7	10.0	47	89	£37.43
8233230980	9.8	10.0	47	89	£37.43
8233230990	9.9	10.0	47	89	£37.43
8233231000	10.0	10.0	47	89	£37.43
8233231010	10.1	12.0	55	102	£53.60
8233231020	10.2	12.0	55	102	£53.60
8233231030	10.3	12.0	55	102	£53.60
8233231040	10.4	12.0	55	102	£53.60
8233231050	10.5	12.0	55	102	£53.60
8233231060	10.6	12.0	55	102	£53.60
8233231070	10.7	12.0	55	102	£53.60
8233231080	10.8	12.0	55	102	£53.60
8233231090	10.9	12.0	55	102	£53.60
8233231100	11.0	12.0	55	102	£53.60
8233231110	11.1	12.0	55	102	£53.60
8233231120	11.2	12.0	55	102	£53.60
8233231130	11.3	12.0	55	102	£53.60
8233231140	11.4	12.0	55	102	£53.60

PART NUMBER	OD DC	SD DMM	FL.LTH LU	O/ALL OAL	PRICE
8233231150	11.5	12.0	55	102	£53.60
8233231160	11.6	12.0	55	102	£53.60
8233231170	11.7	12.0	55	102	£53.60
8233231180	11.8	12.0	55	102	£53.60
8233231190	11.9	12.0	55	102	£53.60
8233231200	12.0	12.0	55	102	£53.60
8233231230	12.3	14.0	60	107	£76.06
8233231250	12.5	14.0	60	107	£74.87
8233231300	13.0	14.0	60	107	£74.87
8233231350	13.5	14.0	60	107	£74.87
8233231400	14.0	14.0	60	107	£74.87
8233231450	14.5	16.0	65	115	£91.38
8233231500	15.0	16.0	65	115	£91.38
8233231550	15.5	16.0	65	115	£91.38
8233231600	16.0	16.0	65	115	£91.38
8233231650	16.5	18.0	73	123	£146.82
8233231700	17.0	18.0	73	123	£146.82
8233231750	17.5	18.0	73	123	£146.82
8233231800	18.0	18.0	73	123	£146.82
8233231850	18.5	20.0	79	131	£160.39
8233231900	19.0	20.0	79	131	£160.39
8233231950	19.5	20.0	79	131	£160.39
8233232000	20.0	20.0	79	131	£160.39

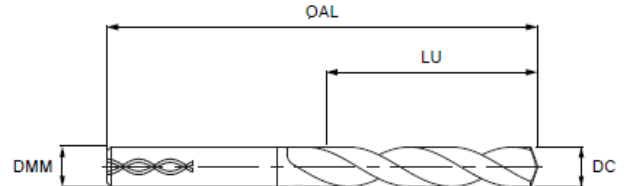
Drill Dia. Tolerance TCDC	Shank Dia. Tolerance TCDMM
m7	h6

INOX DRILL 5XD

Series No. 825323



Special flute shape and geometry highly suited to machining stainless steels. Excellent chip evacuation due to better surface treatment. Point R-thinning gives superior centering and chip curling. Applied INOX coating achieves better surface finish and longer tool life.



ULDR 5

ISO	P			M		K		N					S			H			
VDI	1-5	6-9	10-11	12-13	14	15-16	17-20	21-24	25	26-28	29.1	29.2	30	31-32	33-35	36-37	38	39	40-41
● ○ Primary Secondary	●	●	●	●	●			○	○					○	○	●			

PART NUMBER	OD DC	SD DMM	FL.LTH LU	O/ALL OAL	PRICE
8253230150	1.5	3.0	16	55	£27.91
8253230160	1.6	3.0	16	55	£27.91
8253230170	1.7	3.0	16	55	£27.91
8253230180	1.8	3.0	16	55	£27.91
8253230190	1.9	3.0	16	55	£27.91
8253230200	2.0	4.0	21	57	£27.91
8253230210	2.1	4.0	21	57	£27.91
8253230220	2.2	4.0	21	57	£27.91
8253230230	2.3	4.0	21	57	£27.91
8253230240	2.4	4.0	21	57	£27.91
8253230250	2.5	4.0	21	57	£27.91
8253230260	2.6	4.0	21	57	£27.91
8253230270	2.7	4.0	21	57	£27.91
8253230280	2.8	4.0	21	57	£27.91
8253230290	2.9	4.0	21	57	£27.91
8253230300	3.0	6.0	28	66	£31.55
8253230310	3.1	6.0	28	66	£31.55
8253230320	3.2	6.0	28	66	£31.55
8253230330	3.3	6.0	28	66	£31.55
8253230340	3.4	6.0	28	66	£31.55
8253230350	3.5	6.0	28	66	£31.55
8253230360	3.6	6.0	28	66	£31.55
8253230370	3.7	6.0	28	66	£31.55
8253230380	3.8	6.0	36	74	£31.55
8253230390	3.9	6.0	36	74	£31.55
8253230400	4.0	6.0	36	74	£31.55
8253230410	4.1	6.0	36	74	£31.55
8253230420	4.2	6.0	36	74	£31.55
8253230430	4.3	6.0	36	74	£31.55
8253230440	4.4	6.0	36	74	£31.55
8253230450	4.5	6.0	36	74	£31.55

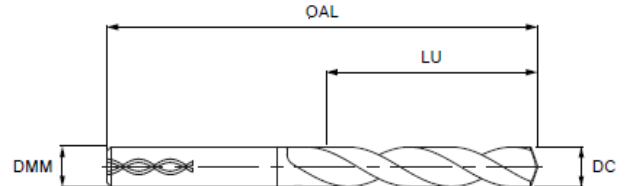
PART NUMBER	OD DC	SD DMM	FL.LTH LU	O/ALL OAL	PRICE
8253230460	4.6	6.0	36	74	£31.55
8253230470	4.7	6.0	36	74	£31.55
8253230480	4.8	6.0	44	82	£31.55
8253230490	4.9	6.0	44	82	£31.55
8253230500	5.0	6.0	44	82	£31.55
8253230510	5.1	6.0	44	82	£31.55
8253230520	5.2	6.0	44	82	£31.55
8253230530	5.3	6.0	44	82	£31.55
8253230540	5.4	6.0	44	82	£31.55
8253230550	5.5	6.0	44	82	£31.55
8253230560	5.6	6.0	44	82	£31.55
8253230570	5.7	6.0	44	82	£31.55
8253230580	5.8	6.0	44	82	£31.55
8253230590	5.9	6.0	44	82	£31.55
8253230600	6.0	6.0	44	82	£31.55
8253230610	6.1	8.0	53	91	£34.89
8253230620	6.2	8.0	53	91	£34.89
8253230630	6.3	8.0	53	91	£34.89
8253230640	6.4	8.0	53	91	£34.89
8253230650	6.5	8.0	53	91	£34.89
8253230660	6.6	8.0	53	91	£34.89
8253230670	6.7	8.0	53	91	£34.89
8253230680	6.8	8.0	53	91	£34.89
8253230690	6.9	8.0	53	91	£34.89
8253230700	7.0	8.0	53	91	£34.89
8253230710	7.1	8.0	53	91	£34.89
8253230720	7.2	8.0	53	91	£34.89
8253230730	7.3	8.0	53	91	£34.89
8253230740	7.4	8.0	53	91	£34.89
8253230750	7.5	8.0	53	91	£34.89
8253230760	7.6	8.0	53	91	£34.89

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ISO	P			M		K		N					S			H			
VDI	1-5	6-9	10-11	12-13	14	15-16	17-20	21-24	25	26-28	29.1	29.2	30	31-32	33-35	36-37	38	39	40-41
● ○ Primary Secondary	●	●	●	●	●			○	○					○	○	●			

PART NUMBER	OD DC	SD DMM	FL.LTH LU	O/ALL OAL	PRICE
8253230770	7.7	8.0	53	91	£34.89
8253230780	7.8	8.0	53	91	£34.89
8253230790	7.9	8.0	53	91	£34.89
8253230800	8.0	8.0	53	91	£34.89
8253230810	8.1	10.0	61	103	£41.52
8253230820	8.2	10.0	61	103	£41.52
8253230830	8.3	10.0	61	103	£41.52
8253230840	8.4	10.0	61	103	£41.52
8253230850	8.5	10.0	61	103	£41.52
8253230860	8.6	10.0	61	103	£41.52
8253230870	8.7	10.0	61	103	£41.52
8253230880	8.8	10.0	61	103	£41.52
8253230890	8.9	10.0	61	103	£41.52
8253230900	9.0	10.0	61	103	£41.52
8253230910	9.1	10.0	61	103	£41.52
8253230920	9.2	10.0	61	103	£41.52
8253230930	9.3	10.0	61	103	£41.52
8253230940	9.4	10.0	61	103	£41.52
8253230950	9.5	10.0	61	103	£41.52
8253230960	9.6	10.0	61	103	£41.52
8253230970	9.7	10.0	61	103	£41.52
8253230980	9.8	10.0	61	103	£41.52
8253230990	9.9	10.0	61	103	£41.52
8253231000	10.0	10.0	61	103	£41.52
8253231010	10.1	12.0	71	118	£58.36
8253231020	10.2	12.0	71	118	£58.36
8253231030	10.3	12.0	71	118	£58.36
8253231040	10.4	12.0	71	118	£58.36
8253231050	10.5	12.0	71	118	£58.36
8253231060	10.6	12.0	71	118	£58.36

PART NUMBER	OD DC	SD DMM	FL.LTH LU	O/ALL OAL	PRICE
8253231070	10.7	12.0	71	118	£58.36
8253231080	10.8	12.0	71	118	£58.36
8253231090	10.9	12.0	71	118	£58.36
8253231100	11.0	12.0	71	118	£58.36
8253231110	11.1	12.0	71	118	£58.36
8253231120	11.2	12.0	71	118	£58.36
8253231130	11.3	12.0	71	118	£58.36
8253231140	11.4	12.0	71	118	£58.36
8253231150	11.5	12.0	71	118	£58.36
8253231160	11.6	12.0	71	118	£58.36
8253231170	11.7	12.0	71	118	£58.36
8253231180	11.8	12.0	71	118	£58.36
8253231190	11.9	12.0	71	118	£58.36
8253231200	12.0	12.0	71	118	£58.36
8253231250	12.5	14.0	77	124	£78.56
8253231300	13.0	14.0	77	124	£78.56
8253231350	13.5	14.0	77	124	£78.56
8253231400	14.0	14.0	77	124	£78.56
8253231450	14.5	16.0	83	133	£103.80
8253231500	15.0	16.0	83	133	£103.80
8253231550	15.5	16.0	83	133	£103.80
8253231600	16.0	16.0	83	133	£103.80
8253231650	16.5	18.0	93	143	£155.28
8253231700	17.0	18.0	93	143	£155.28
8253231750	17.5	18.0	93	143	£155.28
8253231800	18.0	18.0	93	143	£155.28
8253231850	18.5	20.0	101	153	£177.77
8253231900	19.0	20.0	101	153	£177.77
8253231950	19.5	20.0	101	153	£177.77
8253232000	20.0	20.0	101	153	£177.77

Drill Dia. Tolerance TCDC	Shank Dia. Tolerance TCDMM
m7	h6

823323, 825323, 828323 INOX DRILL

VDI MATERIAL GROUP	HRC	V _c (m/min)	f _n (mm/rev)															
			ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0		
P	1-5 Non-alloy Steel	<25	115 (105-125)	0.02	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12	0.15	0.20	0.22	0.24	
	6-9 Low alloy Steel	25-35	105 (95-115)	0.02	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12	0.15	0.20	0.22	0.24	
	10-11 High alloy Steel, Tool Steel	35-45	95 (85-105)	0.02	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12	0.15	0.20	0.22	0.24	
M	12-13 Ferritic/ Martensitic Stainless Steel		65 (60-70)	0.02	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12	0.16	0.20	0.22	0.24	
	14 Austenitic Stainless Steel		40 (35-45)	0.02	0.03	0.03	0.03	0.03	0.04	0.05	0.06	0.08	0.10	0.12	0.15	0.17	0.19	
N	21-24 Aluminium Si<12%		210 (200-220)	0.04	0.08	0.12	0.18	0.20	0.25	0.28	0.30	0.40	0.50	0.60	0.80	1.00	1.20	
	25 Aluminium Si>12%		165 (155-175)	0.03	0.06	0.10	0.15	0.18	0.25	0.28	0.30	0.35	0.40	0.50	0.60	0.70	0.80	
S	31-32 HRSA Fe Based		30 (25-35)	0.05	0.05	0.06	0.08	0.08	0.10	0.10	0.11	0.12	0.14	0.14	0.15	0.15	0.15	
	33-35 HRSA Ni/Co Based		25 (20-30)	0.03	0.03	0.04	0.06	0.06	0.08	0.08	0.09	0.10	0.12	0.12	0.13	0.13	0.13	
	36 Titanium unalloyed		45 (40-50)	0.01	0.02	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.10	0.12	0.14	0.16	0.18	
	37 Titanium Alloys		40 (35-45)	0.01	0.02	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.10	0.12	0.14	0.16	0.18	

- For 8xD drills reduce feed rate by 15%
- For recommended coolant pressure refer to P.59

v_c - cutting speed (m/min)

n - RPM (rev/min)

f_n - feed rate (mm/rev)

ϕ - drill diameter (mm)

To calculate RPM from cutting speed:
$$n = \frac{v_c \times 1000}{\pi \times \phi}$$

To calculate cutting speed from RPM:
$$v_c = \frac{n \times \pi \times \phi}{1000}$$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in these charts are nominal recommendations and should be considered only as good starting points.

COOLANT PRESSURE

Recommended guidelines for through coolant carbide drills.

Type	Size					
Inox, SX, HF, BF Alu-XP, GP Drill	<ø3.0	ø3.0 -5.0	ø5.0 -8.0	ø8.0 -12.0	ø12.0 -16.0	ø16.0 -20.0
3xD to 5xD	60 bar	50 bar	30 bar	25 bar	20 bar	15 bar
8xD	80 bar	60 bar	40 bar	30 bar	25 bar	20 bar

Recommended guidelines for minimum quantity lubricant carbide drills.

Type	ULDR				
MQL	10 x D	15 X D	20 X D	25 X D	30 X D
PRESSURE	20 bar	20 bar	45 bar	45 bar	45 bar

All recommendations are for guidance only. Adjustments may need to be made according to your set-up.



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