

ST machining of soft steel and stainless steel series twist drill

ST series drills with superior performance will solve the difficulties in machining of high-elongation materials such as soft steel, stainless steel, etc.

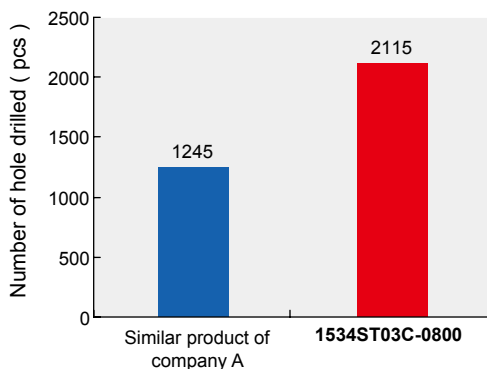
Optimized drill point design with strengthened chisel edge and ensures easy and fast cutting and excellent chip breaking.

Nano-structured TiAlN coating, outstanding wear resistance and heat resistance.

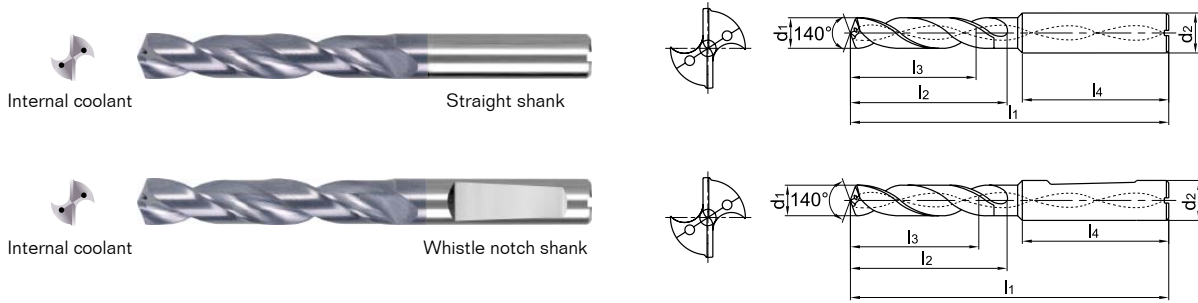
Special chipbreaker with large chip pocket ensures good chip evacuation and smooth drilling.

Application of st series twist drills

Tool type: 1534ST03C-0800
 Workpiece material: 1Cr18Ni9Ti
 Cooling system: oil water emulsion(internal cooling)
 Cutting speed: $V_c=85\text{m/min}$
 Feed rate: $f_r=0.16\text{mm/r}$
 Drilling depth: 24mm(blind hole)



ST series for machining of soft steel, stainless steel



- First choice for drilling soft steel and stainless steel.
- Sharp cutting edge can avoid build-up edge, suitable for drilling hole with high performance.

Drill diameter d1(m7)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d2(h6)	l1	l2	l3	l4	
3.0	3	Internal coolant	Straight shank	1534ST03C-0300	6	62	20	14	36	☆
	5			1536ST05C-0300	6	66	28	23	36	☆
5	Whistle notch shank		1736ST05C-0300	6	66	28	23	36	☆	
3			Straight shank	1534ST03C-0310	6	62	20	14	36	☆
5	Whistle notch shank			1536ST05C-0310	6	66	28	23	36	☆
5			Whistle notch shank	1736ST05C-0310	6	66	28	23	36	☆
3.2	3			Straight shank	1534ST03C-0320	6	62	20	14	36
	5		1536ST05C-0320		6	66	28	23	36	☆
5	Whistle notch shank		1736ST05C-0320	6	66	28	23	36	☆	
3.25			3	Straight shank	1534ST03C-0325	6	62	20	14	36
	5		1536ST05C-0325		6	66	28	23	36	☆
5	Whistle notch shank		1736ST05C-0325	6	66	28	23	36	☆	
3.3		3	Straight shank	1534ST03C-0330	6	62	20	14	36	☆
	5	1536ST05C-0330		6	66	28	23	36	☆	
5	Whistle notch shank	1736ST05C-0330	6	66	28	23	36	☆		
3.4		3	Straight shank	1534ST03C-0340	6	62	20	14	36	☆
	5	1536ST05C-0340		6	66	28	23	36	☆	
5	Whistle notch shank	1736ST05C-0340	6	66	28	23	36	☆		
3.5		3	Straight shank	1534ST03C-0350	6	62	20	14	36	☆
	5	1536ST05C-0350		6	66	28	23	36	☆	
5	Whistle notch shank	1736ST05C-0350	6	66	28	23	36	☆		

☆ Recommended grade (produce according to order)

Applicable material table

⊙ Very suitable ○ Suitable

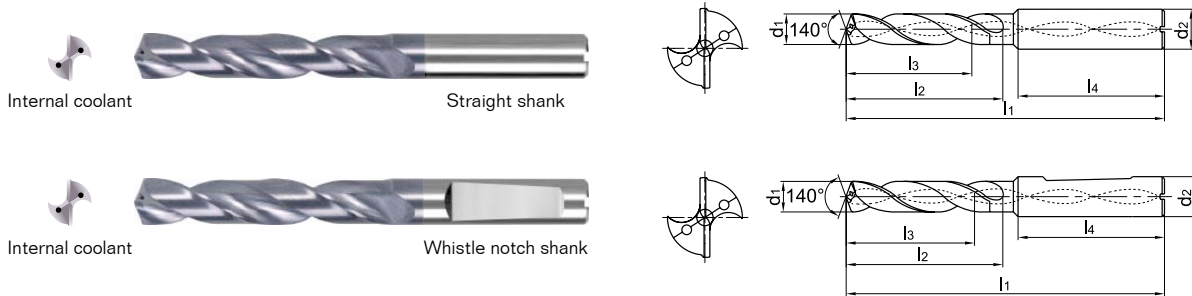
Grade	Workpiece material										
	Mild steel HB≤180	Carbon steel, Alloy steel	Pre-hardened steel, Hardened steel			Stainless steel	Cast iron	Nodular cast iron	Aluminum alloy	Copper alloy	Heat resistant alloy
			~40HRC	~50HRC	~60HRC						
KDG303	⊙	○				⊙					○





ST series

ST series for machining of soft steel, stainless steel



- First choice for drilling soft steel and stainless steel.
- Sharp cutting edge can avoid build-up edge, suitable for drilling hole with high performance.

Drill diameter d1(m7)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d2(h6)	l1	l2	l3	l4	KDG303
3.6	3	Internal coolant	Straight shank	1534ST03C-0360	6	62	20	14	36	☆
	5			1536ST05C-0360	6	66	28	23	36	☆
5	Whistle notch shank		1736ST05C-0360	6	66	28	23	36	☆	
3.7	3		Straight shank	1534ST03C-0370	6	62	20	14	36	☆
	5			1536ST05C-0370	6	66	28	23	36	☆
	5		Whistle notch shank	1736ST05C-0370	6	66	28	23	36	☆
3.8	3		Straight shank	1534ST03C-0380	6	66	24	17	36	☆
	5			1536ST05C-0380	6	74	36	29	36	☆
	5		Whistle notch shank	1736ST05C-0380	6	74	36	29	36	☆
3.9	3		Straight shank	1534ST03C-0390	6	66	24	17	36	☆
	5			1536ST05C-0390	6	74	36	29	36	☆
	5		Whistle notch shank	1736ST05C-0390	6	74	36	29	36	☆
4.0	3		Straight shank	1534ST03C-0400	6	66	24	17	36	☆
	5			1536ST05C-0400	6	74	36	29	36	☆
	5		Whistle notch shank	1736ST05C-0400	6	74	36	29	36	☆
4.1	3		Straight shank	1534ST03C-0410	6	66	24	17	36	☆
	5			1536ST05C-0410	6	74	36	29	36	☆
	5		Whistle notch shank	1736ST05C-0410	6	74	36	29	36	☆
4.2	3	Straight shank	1534ST03C-0420	6	66	24	17	36	☆	
	5		1536ST05C-0420	6	74	36	29	36	☆	
	5	Whistle notch shank	1736ST05C-0420	6	74	36	29	36	☆	
4.3	3	Straight shank	1534ST03C-0430	6	66	24	17	36	☆	
	5		1536ST05C-0430	6	74	36	29	36	☆	
	5	Whistle notch shank	1736ST05C-0430	6	74	36	29	36	☆	
4.4	3	Straight shank	1534ST03C-0440	6	66	24	17	36	☆	
	5		1536ST05C-0440	6	74	36	29	36	☆	
	5	Whistle notch shank	1736ST05C-0440	6	74	36	29	36	☆	
4.5	3	Straight shank	1534ST03C-0450	6	66	24	17	36	☆	
	5		1536ST05C-0450	6	74	36	29	36	☆	
	5	Whistle notch shank	1736ST05C-0450	6	74	36	29	36	☆	

☆ Recommended grade (produce according to order)



Drill diameter d ₁ (m7)	Drilling depth l/d	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h ₆)	l ₁	l ₂	l ₃	l ₄	KDG303
4.6	3	Internal coolant	Straight shank	1534ST03C-0460	6	66	24	17	36	☆
	5			1536ST05C-0460	6	74	36	29	36	☆
4.65	3		Straight shank	1534ST03C-0465	6	66	24	17	36	☆
	5			1536ST05C-0465	6	74	36	29	36	☆
4.7	5		Whistle notch shank	1736ST05C-0460	6	74	36	29	36	☆
	3		Straight shank	1534ST03C-0470	6	66	24	17	36	☆
	5			1536ST05C-0470	6	74	36	29	36	☆
4.8	5		Whistle notch shank	1736ST05C-0470	6	74	36	29	36	☆
	3		Straight shank	1534ST03C-0480	6	66	28	20	36	☆
	5			1536ST05C-0480	6	82	44	35	36	☆
4.9	5		Whistle notch shank	1736ST05C-0480	6	82	44	35	36	☆
	3		Straight shank	1534ST03C-0490	6	66	28	20	36	☆
	5			1536ST05C-0490	6	82	44	35	36	☆
5.0	5		Whistle notch shank	1736ST05C-0490	6	82	44	35	36	☆
	3		Straight shank	1534ST03C-0500	6	66	28	20	36	☆
	5			1536ST05C-0500	6	82	44	35	36	☆
5.1	5		Whistle notch shank	1736ST05C-0500	6	82	44	35	36	☆
	3		Straight shank	1534ST03C-0510	6	66	28	20	36	☆
	5			1536ST05C-0510	6	82	44	35	36	☆
5.2	5		Whistle notch shank	1736ST05C-0510	6	82	44	35	36	☆
	3		Straight shank	1534ST03C-0520	6	66	28	20	36	☆
	5			1536ST05C-0520	6	82	44	35	36	☆
5.3	5		Whistle notch shank	1736ST05C-0520	6	82	44	35	36	☆
	3		Straight shank	1534ST03C-0530	6	66	28	20	36	☆
	5	1536ST05C-0530		6	82	44	35	36	☆	
5.4	5	Whistle notch shank	1736ST05C-0530	6	82	44	35	36	☆	
	3	Straight shank	1534ST03C-0540	6	66	28	20	36	☆	
	5		1536ST05C-0540	6	82	44	35	36	☆	
5.5	5	Whistle notch shank	1736ST05C-0540	6	82	44	35	36	☆	
	3	Straight shank	1534ST03C-0550	6	66	28	20	36	☆	
	5		1536ST05C-0550	6	82	44	35	36	☆	
	5	Whistle notch shank	1736ST05C-0550	6	82	44	35	36	☆	

☆ Recommended grade (produce according to order)

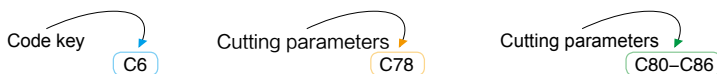
Drilling tools

ST series

Applicable material table

⊙ Very suitable ○ Suitable

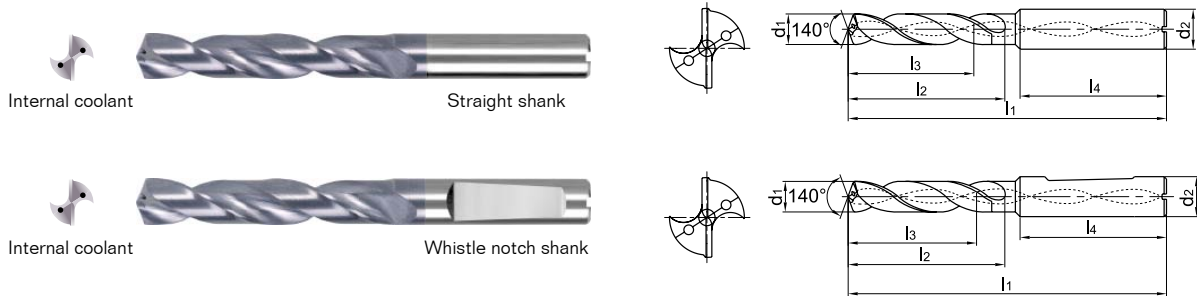
Grade	Workpiece material										
	Mild steel HB≤180	Carbon steel, Alloy steel	Pre-hardened steel, Hardened steel			Stainless steel	Cast iron	Nodular cast iron	Aluminum alloy	Copper alloy	Heat resistant alloy
		~40HRC	~50HRC	~60HRC							
KDG303	⊙	○				⊙					○





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- First choice for drilling soft steel and stainless steel.
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Drill diameter d1(m7)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade KDG303
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d2(h6)	l1	l2	l3	l4	
5.55	3	Internal coolant	Straight shank	1534ST03C-0555	6	66	28	20	36	☆
	5			1536ST05C-0555	6	82	44	35	36	☆
	5		Whistle notch shank	1736ST05C-0555	6	82	44	35	36	☆
5.6	3		Straight shank	1534ST03C-0560	6	66	28	20	36	☆
	5			1536ST05C-0560	6	82	44	35	36	☆
	5		Whistle notch shank	1736ST05C-0560	6	82	44	35	36	☆
5.7	3		Straight shank	1534ST03C-0570	6	66	28	20	36	☆
	5			1536ST05C-0570	6	82	44	35	36	☆
	5		Whistle notch shank	1736ST05C-0570	6	82	44	35	36	☆
5.8	3		Straight shank	1534ST03C-0580	6	66	28	20	36	☆
	5			1536ST05C-0580	6	82	44	35	36	☆
	5		Whistle notch shank	1736ST05C-0580	6	82	44	35	36	☆
5.9	3		Straight shank	1534ST03C-0590	6	66	28	20	36	☆
	5			1536ST05C-0590	6	82	44	35	36	☆
	5		Whistle notch shank	1736ST05C-0590	6	82	44	35	36	☆
6.0	3		Straight shank	1534ST03C-0600	6	66	28	20	36	☆
	5			1536ST05C-0600	6	82	44	35	36	☆
	5		Whistle notch shank	1736ST05C-0600	6	82	44	35	36	☆
6.1	3	Straight shank	1534ST03C-0610	8	79	34	24	36	☆	
	5		1536ST05C-0610	8	91	53	43	36	☆	
	5	Whistle notch shank	1736ST05C-0610	8	91	53	43	36	☆	
6.2	3	Straight shank	1534ST03C-0620	8	79	34	24	36	☆	
	5		1536ST05C-0620	8	91	53	43	36	☆	
	5	Whistle notch shank	1736ST05C-0620	8	91	53	43	36	☆	
6.3	3	Straight shank	1534ST03C-0630	8	79	34	24	36	☆	
	5		1536ST05C-0630	8	91	53	43	36	☆	
	5	Whistle notch shank	1736ST05C-0630	8	91	53	43	36	☆	
6.4	3	Straight shank	1534ST03C-0640	8	79	34	24	36	☆	
	5		1536ST05C-0640	8	91	53	43	36	☆	
	5	Whistle notch shank	1736ST05C-0640	8	91	53	43	36	☆	

☆ Recommended grade (produce according to order)



Drill diameter d ₁ (m7)	Drilling depth l/d	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h ₆)	l ₁	l ₂	l ₃	l ₄	KDG303
6.5	3	Internal coolant	Straight shank	1534ST03C-0650	8	79	34	24	36	☆
	5			1536ST05C-0650	8	91	53	43	36	☆
5	Whistle notch shank		1736ST05C-0650	8	91	53	43	36	☆	
6.6	3		Straight shank	1534ST03C-0660	8	79	34	24	36	☆
	5			1536ST05C-0660	8	91	53	43	36	☆
	5			Whistle notch shank	1736ST05C-0660	8	91	53	43	36
6.7	3		Straight shank	1534ST03C-0670	8	79	34	24	36	☆
	5			1536ST05C-0670	8	91	53	43	36	☆
	5			Whistle notch shank	1736ST05C-0670	8	91	53	43	36
6.75	3		Straight shank	1534ST03C-0675	8	79	34	24	36	☆
	5			1536ST05C-0675	8	91	53	43	36	☆
	5			Whistle notch shank	1736ST05C-0675	8	91	53	43	36
6.9	3		Straight shank	1534ST03C-0690	8	79	34	24	36	☆
	5			1536ST05C-0690	8	91	53	43	36	☆
	5			Whistle notch shank	1736ST05C-0690	8	91	53	43	36
7.0	3		Straight shank	1534ST03C-0700	8	79	34	24	36	☆
	5			1536ST05C-0700	8	91	53	43	36	☆
	5			Whistle notch shank	1736ST05C-0700	8	91	53	43	36
7.1	3		Straight shank	1534ST03C-0710	8	79	41	29	36	☆
	5			1536ST05C-0710	8	91	53	43	36	☆
	5			Whistle notch shank	1736ST05C-0710	8	91	53	43	36
7.2	3		Straight shank	1534ST03C-0720	8	79	41	29	36	☆
	5			1536ST05C-0720	8	91	53	43	36	☆
	5			Whistle notch shank	1736ST05C-0720	8	91	53	43	36
7.3	3	Straight shank	1534ST03C-0730	8	79	41	29	36	☆	
	5		1536ST05C-0730	8	91	53	43	36	☆	
	5		Whistle notch shank	1736ST05C-0730	8	91	53	43	36	☆
7.4	3	Straight shank	1534ST03C-0740	8	79	41	29	36	☆	
	5		1536ST05C-0740	8	91	53	43	36	☆	
	5		Whistle notch shank	1736ST05C-0740	8	91	53	43	36	☆
7.5	3	Straight shank	1534ST03C-0750	8	79	41	29	36	☆	
	5		1536ST05C-0750	8	91	53	43	36	☆	
	5		Whistle notch shank	1736ST05C-0750	8	91	53	43	36	☆

☆ Recommended grade (produce according to order)

Drilling tools

ST series

Applicable material table

⊙ Very suitable ○ Suitable

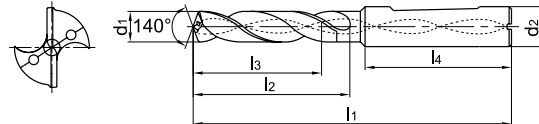
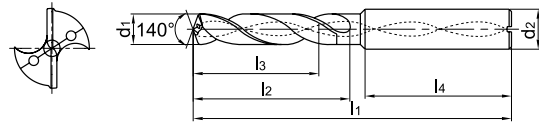
Grade	Workpiece material										
	Mild steel HB≤180	Carbon steel, Alloy steel	Pre-hardened steel, Hardened steel			Stainless steel	Cast iron	Nodular cast iron	Aluminum alloy	Copper alloy	Heat resistant alloy
		~40HRC	~50HRC	~60HRC							
KDG303	⊙	○				⊙					○





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- First choice for drilling soft steel and stainless steel.
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Drill diameter d ₁ (m7)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG303
7.6	3	Internal coolant	Straight shank	1534ST03C-0760	8	79	41	29	36	☆
	5			1536ST05C-0760	8	91	53	43	36	☆
	5		Whistle notch shank	1736ST05C-0760	8	91	53	43	36	☆
7.7	3		Straight shank	1534ST03C-0770	8	79	41	29	36	☆
	5			1536ST05C-0770	8	91	53	43	36	☆
	5		Whistle notch shank	1736ST05C-0770	8	91	53	43	36	☆
7.8	3		Straight shank	1534ST03C-0780	8	79	41	29	36	☆
	5			1536ST05C-0780	8	91	53	43	36	☆
	5		Whistle notch shank	1736ST05C-0780	8	91	53	43	36	☆
7.9	3		Straight shank	1534ST03C-0790	8	79	41	29	36	☆
	5			1536ST05C-0790	8	91	53	43	36	☆
	5		Whistle notch shank	1736ST05C-0790	8	91	53	43	36	☆
8.0	3		Straight shank	1534ST03C-0800	8	79	41	29	36	☆
	5			1536ST05C-0800	8	91	53	43	36	☆
	5		Whistle notch shank	1736ST05C-0800	8	91	53	43	36	☆
8.1	3	Straight shank	1534ST03C-0810	10	89	47	35	40	☆	
	5		1536ST05C-0810	10	103	61	49	40	☆	
	5	Whistle notch shank	1736ST05C-0810	10	103	61	49	40	☆	
8.2	3	Straight shank	1534ST03C-0820	10	89	47	35	40	☆	
	5		1536ST05C-0820	10	103	61	49	40	☆	
	5	Whistle notch shank	1736ST05C-0820	10	103	61	49	40	☆	
8.3	3	Straight shank	1534ST03C-0830	10	89	47	35	40	☆	
	5		1536ST05C-0830	10	103	61	49	40	☆	
	5	Whistle notch shank	1736ST05C-0830	10	103	61	49	40	☆	
8.4	3	Straight shank	1534ST03C-0840	10	89	47	35	40	☆	
	5		1536ST05C-0840	10	103	61	49	40	☆	
	5	Whistle notch shank	1736ST05C-0840	10	103	61	49	40	☆	
8.5	3	Straight shank	1534ST03C-0850	10	89	47	35	40	☆	
	5		1536ST05C-0850	10	103	61	49	40	☆	
	5	Whistle notch shank	1736ST05C-0850	10	103	61	49	40	☆	

☆ Recommended grade (produce according to order)



Drill diameter d ₁ (m7)	Drilling depth l/d	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h ₆)	l ₁	l ₂	l ₃	l ₄	KDG303
8.6	3	Internal coolant	Straight shank	1534ST03C-0860	10	89	47	35	40	☆
	5			1536ST05C-0860	10	103	61	49	40	☆
5	Whistle notch shank		1736ST05C-0860	10	103	61	49	40	☆	
3			Straight shank	1534ST03C-0870	10	89	47	35	40	☆
5	1536ST05C-0870			10	103	61	49	40	☆	
5	Whistle notch shank		1736ST05C-0870	10	103	61	49	40	☆	
3			Straight shank	1534ST03C-0880	10	89	47	35	40	☆
5	1536ST05C-0880			10	103	61	49	40	☆	
5	Whistle notch shank		1736ST05C-0880	10	103	61	49	40	☆	
3			Straight shank	1534ST03C-0890	10	89	47	35	40	☆
5	1536ST05C-0890			10	103	61	49	40	☆	
5	Whistle notch shank		1736ST05C-0890	10	103	61	49	40	☆	
3			Straight shank	1534ST03C-0900	10	89	47	35	40	☆
5	1536ST05C-0900			10	103	61	49	40	☆	
5	Whistle notch shank		1736ST05C-0900	10	103	61	49	40	☆	
3			Straight shank	1534ST03C-0910	10	89	47	35	40	☆
5	1536ST05C-0910			10	103	61	49	40	☆	
5	Whistle notch shank		1736ST05C-0910	10	103	61	49	40	☆	
3			Straight shank	1534ST03C-0930	10	89	47	35	40	☆
5	1536ST05C-0930			10	103	61	49	40	☆	
5	Whistle notch shank		1736ST05C-0930	10	103	61	49	40	☆	
3			Straight shank	1534ST03C-0940	10	89	47	35	40	☆
5	1536ST05C-0940			10	103	61	49	40	☆	
5	Whistle notch shank		1736ST05C-0940	10	103	61	49	40	☆	
3		Straight shank	1534ST03C-0950	10	89	47	35	40	☆	
5	1536ST05C-0950		10	103	61	49	40	☆		
5	Whistle notch shank	1736ST05C-0950	10	103	61	49	40	☆		
3		Straight shank	1534ST03C-0960	10	89	47	35	40	☆	
5	1536ST05C-0960		10	103	61	49	40	☆		
5	Whistle notch shank	1736ST05C-0960	10	103	61	49	40	☆		
3		Straight shank	1534ST03C-0970	10	89	47	35	40	☆	
5	1536ST05C-0970		10	103	61	49	40	☆		
5	Whistle notch shank	1736ST05C-0970	10	103	61	49	40	☆		

☆ Recommended grade (produce according to order)

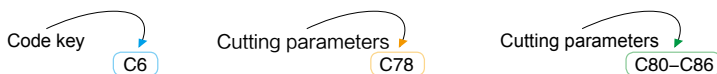
Drilling tools

ST series

Applicable material table

⊙ Very suitable ○ Suitable

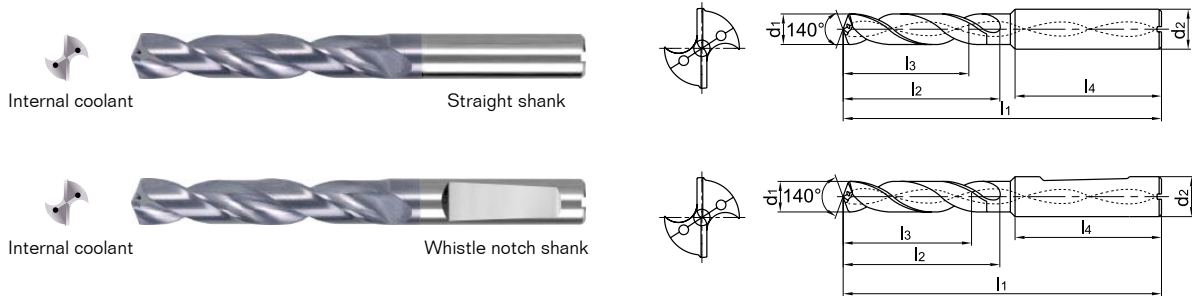
Grade	Workpiece material										
	Mild steel HB≤180	Carbon steel, Alloy steel	Pre-hardened steel, Hardened steel			Stainless steel	Cast iron	Nodular cast iron	Aluminum alloy	Copper alloy	Heat resistant alloy
		~40HRC	~50HRC	~60HRC							
KDG303	⊙	○				⊙					○





ST series

ST series for machining of soft steel, stainless steel



- First choice for drilling soft steel and stainless steel.
- Sharp cutting edge can avoid build-up edge, suitable for drilling hole with high performance.

Drill diameter d_1 (m7)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d_2 (h6)	l_1	l_2	l_3	l_4	
9.8	3	Internal coolant	Straight shank	1534ST03C-0980	10	89	47	35	40	☆
	5		Straight shank	1536ST05C-0980	10	103	61	49	40	☆
	5		Whistle notch shank	1736ST05C-0980	10	103	61	49	40	☆
9.9	3		Straight shank	1534ST03C-0990	10	89	47	35	40	☆
	5		Straight shank	1536ST05C-0990	10	103	61	49	40	☆
	5		Whistle notch shank	1736ST05C-0990	10	103	61	49	40	☆
10.0	3		Straight shank	1534ST03C-1000	10	89	47	35	40	☆
	5		Straight shank	1536ST05C-1000	10	103	61	49	40	☆
	5		Whistle notch shank	1736ST05C-1000	10	103	61	49	40	☆
10.1	3		Straight shank	1534ST03C-1010	12	102	55	40	45	☆
	5		Straight shank	1536ST05C-1010	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1010	12	118	71	56	45	☆
10.25	3		Straight shank	1534ST03C-1025	12	102	55	40	45	☆
	5		Straight shank	1536ST05C-1025	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1025	12	118	71	56	45	☆
10.3	3		Straight shank	1534ST03C-1030	12	102	55	40	45	☆
	5		Straight shank	1536ST05C-1030	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1030	12	118	71	56	45	☆
10.4	3	Straight shank	1534ST03C-1040	12	102	55	40	45	☆	
	5	Straight shank	1536ST05C-1040	12	118	71	56	45	☆	
	5	Whistle notch shank	1736ST05C-1040	12	118	71	56	45	☆	
10.5	3	Straight shank	1534ST03C-1050	12	102	55	40	45	☆	
	5	Straight shank	1536ST05C-1050	12	118	71	56	45	☆	
	5	Whistle notch shank	1736ST05C-1050	12	118	71	56	45	☆	
10.6	3	Straight shank	1534ST03C-1060	12	102	55	40	45	☆	
	5	Straight shank	1536ST05C-1060	12	118	71	56	45	☆	
	5	Whistle notch shank	1736ST05C-1060	12	118	71	56	45	☆	
10.7	3	Straight shank	1534ST03C-1070	12	102	55	40	45	☆	
	5	Straight shank	1536ST05C-1070	12	118	71	56	45	☆	
	5	Whistle notch shank	1736ST05C-1070	12	118	71	56	45	☆	

☆ Recommended grade (produce according to order)



Drill diameter d ₁ (m7)	Drilling depth l/d	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h ₆)	l ₁	l ₂	l ₃	l ₄	KDG303
10.8	3	Internal coolant	Straight shank	1534ST03C-1080	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1080	12	118	71	56	45	☆
10.9	3		Straight shank	1534ST03C-1090	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1090	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1090	12	118	71	56	45	☆
11.0	3		Straight shank	1534ST03C-1100	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1100	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1100	12	118	71	56	45	☆
11.1	3		Straight shank	1534ST03C-1110	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1110	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1110	12	118	71	56	45	☆
11.2	3		Straight shank	1534ST03C-1120	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1120	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1120	12	118	71	56	45	☆
11.3	3		Straight shank	1534ST03C-1130	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1130	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1130	12	118	71	56	45	☆
11.4	3		Straight shank	1534ST03C-1140	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1140	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1140	12	118	71	56	45	☆
11.5	3		Straight shank	1534ST03C-1150	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1150	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1150	12	118	71	56	45	☆
11.6	3		Straight shank	1534ST03C-1160	12	102	55	40	45	☆
	5	Whistle notch shank	1536ST05C-1160	12	118	71	56	45	☆	
	5	Whistle notch shank	1736ST05C-1160	12	118	71	56	45	☆	
11.7	3	Straight shank	1534ST03C-1170	12	102	55	40	45	☆	
	5	Whistle notch shank	1536ST05C-1170	12	118	71	56	45	☆	
	5	Whistle notch shank	1736ST05C-1170	12	118	71	56	45	☆	
11.8	3	Straight shank	1534ST03C-1180	12	102	55	40	45	☆	
	5	Whistle notch shank	1536ST05C-1180	12	118	71	56	45	☆	
	5	Whistle notch shank	1736ST05C-1180	12	118	71	56	45	☆	

☆ Recommended grade (produce according to order)

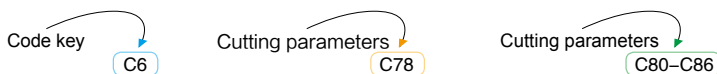
Drilling tools

ST series

Applicable material table

⊙ Very suitable ○ Suitable

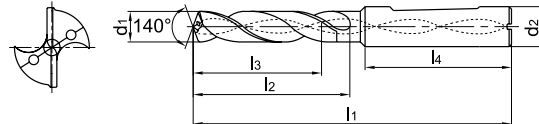
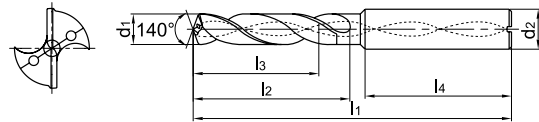
Grade	Workpiece material										
	Mild steel HB≤180	Carbon steel, Alloy steel	Pre-hardened steel, Hardened steel			Stainless steel	Cast iron	Nodular cast iron	Aluminum alloy	Copper alloy	Heat resistant alloy
		~40HRC	~50HRC	~60HRC							
KDG303	⊙	○				⊙					○





ST series

ST series for machining of soft steel, stainless steel



- First choice for drilling soft steel and stainless steel.
- Sharp cutting edge can avoid build-up edge, suitable for drilling hole with high performance.

Drill diameter d ₁ (m7)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h ₆)	l ₁	l ₂	l ₃	l ₄	
11.9	3	Internal coolant	Straight shank	1534ST03C-1190	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1190	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1190	12	118	71	56	45	☆
12.0	3		Straight shank	1534ST03C-1200	12	102	55	40	45	☆
	5		Whistle notch shank	1536ST05C-1200	12	118	71	56	45	☆
	5		Whistle notch shank	1736ST05C-1200	12	118	71	56	45	☆
12.25	3		Straight shank	1534ST03C-1225	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1225	14	124	77	60	45	☆
	5		Whistle notch shank	1736ST05C-1225	14	124	77	60	45	☆
12.3	3		Straight shank	1534ST03C-1230	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1230	14	124	77	60	45	☆
	5		Whistle notch shank	1736ST05C-1230	14	124	77	60	45	☆
12.5	3		Straight shank	1534ST03C-1250	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1250	14	124	77	60	45	☆
	5		Whistle notch shank	1736ST05C-1250	14	124	77	60	45	☆
12.7	3		Straight shank	1534ST03C-1270	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1270	14	124	77	60	45	☆
	5		Whistle notch shank	1736ST05C-1270	14	124	77	60	45	☆
12.75	3		Straight shank	1534ST03C-1275	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1275	14	124	77	60	45	☆
	5		Whistle notch shank	1736ST05C-1275	14	124	77	60	45	☆
12.8	3		Straight shank	1534ST03C-1280	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1280	14	124	77	60	45	☆
	5		Whistle notch shank	1736ST05C-1280	14	124	77	60	45	☆
13.0	3	Straight shank	1534ST03C-1300	14	107	60	43	45	☆	
	5	Whistle notch shank	1536ST05C-1300	14	124	77	60	45	☆	
	5	Whistle notch shank	1736ST05C-1300	14	124	77	60	45	☆	
13.1	3	Straight shank	1534ST03C-1310	14	107	60	43	45	☆	
	5	Whistle notch shank	1536ST05C-1310	14	124	77	60	45	☆	
	5	Whistle notch shank	1736ST05C-1310	14	124	77	60	45	☆	

☆ Recommended grade (produce according to order)

Drilling tools

ST series



Drill diameter d ₁ (m7)	Drilling depth l/d	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade KDG303
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h ₆)	l ₁	l ₂	l ₃	l ₄	
13.5	3	Internal coolant	Straight shank	1534ST03C-1350	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1350	14	124	77	60	45	☆
13.8	3		Straight shank	1534ST03C-1380	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1380	14	124	77	60	45	☆
	5		Whistle notch shank	1736ST05C-1380	14	124	77	60	45	☆
14.0	3		Straight shank	1534ST03C-1400	14	107	60	43	45	☆
	5		Whistle notch shank	1536ST05C-1400	14	124	77	60	45	☆
	5		Whistle notch shank	1736ST05C-1400	14	124	77	60	45	☆
14.25	3		Straight shank	1534ST03C-1425	16	115	65	45	48	☆
	5		Whistle notch shank	1536ST05C-1425	16	133	83	63	48	☆
	5		Whistle notch shank	1736ST05C-1425	16	133	83	63	48	☆
14.3	3		Straight shank	1534ST03C-1430	16	115	65	45	48	☆
	5		Whistle notch shank	1536ST05C-1430	16	133	83	63	48	☆
	5		Whistle notch shank	1736ST05C-1430	16	133	83	63	48	☆
14.5	3		Straight shank	1534ST03C-1450	16	115	65	45	48	☆
	5		Whistle notch shank	1536ST05C-1450	16	133	83	63	48	☆
	5		Whistle notch shank	1736ST05C-1450	16	133	83	63	48	☆
14.75	3		Straight shank	1534ST03C-1475	16	115	65	45	48	☆
	5		Whistle notch shank	1536ST05C-1475	16	133	83	63	48	☆
	5		Whistle notch shank	1736ST05C-1475	16	133	83	63	48	☆
14.8	3		Straight shank	1534ST03C-1480	16	115	65	45	48	☆
	5		Whistle notch shank	1536ST05C-1480	16	133	83	63	48	☆
	5		Whistle notch shank	1736ST05C-1480	16	133	83	63	48	☆
15.0	3		Straight shank	1534ST03C-1500	16	115	65	45	48	☆
	5	Whistle notch shank	1536ST05C-1500	16	133	83	63	48	☆	
	5	Whistle notch shank	1736ST05C-1500	16	133	83	63	48	☆	
15.1	3	Straight shank	1534ST03C-1510	16	115	65	45	48	☆	
	5	Whistle notch shank	1536ST05C-1510	16	133	83	63	48	☆	
	5	Whistle notch shank	1736ST05C-1510	16	133	83	63	48	☆	
15.5	3	Straight shank	1534ST03C-1550	16	115	65	45	48	☆	
	5	Whistle notch shank	1536ST05C-1550	16	133	83	63	48	☆	
	5	Whistle notch shank	1736ST05C-1550	16	133	83	63	48	☆	

☆ Recommended grade (produce according to order)

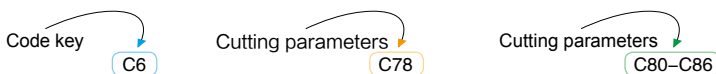
Drilling tools

ST series

Applicable material table

⊙ Very suitable ○ Suitable

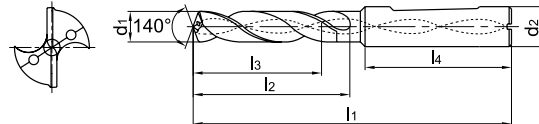
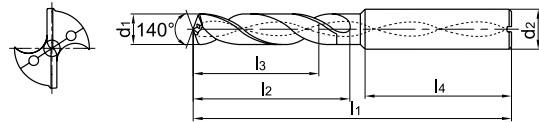
Grade	Workpiece material										
	Mild steel HB≤180	Carbon steel, Alloy steel	Pre-hardened steel, Hardened steel			Stainless steel	Cast iron	Nodular cast iron	Aluminum alloy	Copper alloy	Heat resistant alloy
KDG303	⊙	○	~40HRC	~50HRC	~60HRC	⊙					○





ST series

ST series for machining of soft steel, stainless steel



- First choice for drilling soft steel and stainless steel.
- Sharp cutting edge can avoid build-up edge, suitable for drilling hole with high performance.

Drill diameter d ₁ (m7)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h ₆)	l ₁	l ₂	l ₃	l ₄	
15.8	3	Internal coolant	Straight shank	1534ST03C-1580	16	115	65	45	48	☆
	5		Straight shank	1536ST05C-1580	16	133	83	63	48	☆
	5		Whistle notch shank	1736ST05C-1580	16	133	83	63	48	☆
16.0	3		Straight shank	1534ST03C-1600	16	115	65	45	48	☆
	5		Straight shank	1536ST05C-1600	16	133	83	63	48	☆
	5		Whistle notch shank	1736ST05C-1600	16	133	83	63	48	☆
16.5	3		Straight shank	1534ST03C-1650	18	123	73	51	48	☆
	5		Straight shank	1536ST05C-1650	18	143	93	71	48	☆
	5		Whistle notch shank	1736ST05C-1650	18	143	93	71	48	☆
16.75	3		Straight shank	1534ST03C-1675	18	123	73	51	48	☆
	5		Straight shank	1536ST05C-1675	18	143	93	71	48	☆
	5		Whistle notch shank	1736ST05C-1675	18	143	93	71	48	☆
16.8	3		Straight shank	1534ST03C-1680	18	123	73	51	48	☆
	5		Straight shank	1536ST05C-1680	18	143	93	71	48	☆
	5		Whistle notch shank	1736ST05C-1680	18	143	93	71	48	☆
17.0	3		Straight shank	1534ST03C-1700	18	123	73	51	48	☆
	5		Straight shank	1536ST05C-1700	18	143	93	71	48	☆
	5		Whistle notch shank	1736ST05C-1700	18	143	93	71	48	☆
17.5	3	Straight shank	1534ST03C-1750	18	123	73	51	48	☆	
	5	Straight shank	1536ST05C-1750	18	143	93	71	48	☆	
	5	Whistle notch shank	1736ST05C-1750	18	143	93	71	48	☆	
17.8	3	Straight shank	1534ST03C-1780	18	123	73	51	48	☆	
	5	Straight shank	1536ST05C-1780	18	143	93	71	48	☆	
	5	Whistle notch shank	1736ST05C-1780	18	143	93	71	48	☆	
18.0	3	Straight shank	1534ST03C-1800	18	123	73	51	48	☆	
	5	Straight shank	1536ST05C-1800	18	143	93	71	48	☆	
	5	Whistle notch shank	1736ST05C-1800	18	143	93	71	48	☆	
18.5	3	Straight shank	1534ST03C-1850	20	131	79	55	50	☆	
	5	Straight shank	1536ST05C-1850	20	153	101	77	50	☆	
	5	Whistle notch shank	1736ST05C-1850	20	153	101	77	50	☆	

☆ Recommended grade (produce according to order)



Drill diameter d ₁ (mm)	Drilling depth (l/d)	Cooling mode	Shank type	Type	Basic dimension(mm)					Recommended grade KDG303
					Shank diameter	Overall length	Flute length	Recommended drilling depth	Shank length	
					d ₂ (h ₆)	l ₁	l ₂	l ₃	l ₄	
18.8	3	Internal coolant	Straight shank	1534ST03C-1880	20	131	79	55	50	☆
	5			1536ST05C-1880	20	153	101	77	50	☆
	5		Whistle notch shank	1736ST05C-1880	20	153	101	77	50	☆
19.0	3		Straight shank	1534ST03C-1900	20	131	79	55	50	☆
	5			1536ST05C-1900	20	153	101	77	50	☆
	5		Whistle notch shank	1736ST05C-1900	20	153	101	77	50	☆
19.5	3		Straight shank	1534ST03C-1950	20	131	79	55	50	☆
	5			1536ST05C-1950	20	153	101	77	50	☆
	5		Whistle notch shank	1736ST05C-1950	20	153	101	77	50	☆
19.8	3		Straight shank	1534ST03C-1980	20	131	79	55	50	☆
	5			1536ST05C-1980	20	153	101	77	50	☆
	5		Whistle notch shank	1736ST05C-1980	20	153	101	77	50	☆
20.0	3	Straight shank	1534ST03C-2000	20	131	79	55	50	☆	
	5		1536ST05C-2000	20	153	101	77	50	☆	
	5	Whistle notch shank	1736ST05C-2000	20	153	101	77	50	☆	

☆ Recommended grade (produce according to order)

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						
KDG303	⊙	○				⊙					○

