

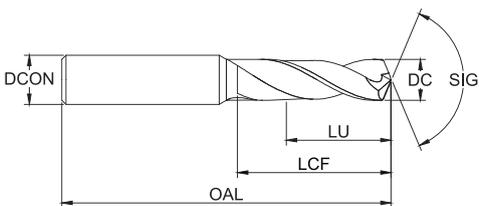
# HD1-SC

- ▶ MSTM's HD1 drills are designed for high performance and excellent value when drilling stainless steel alloys.
- ▶ Custom design of flute results in super-fast chip evacuation improving the hole surface quality.
- ▶ Wavy design of cutting-edge lip improves sharpness as well as cutting-edge strength.
- ▶ Suitable margin width for low cutting resistance
- ▶ Newest-generation of TiAlSiN-based coating with HiPIMS technology, SteelCon coating provides extreme wear resistance at extreme cutting temperatures, and exotic material machining. High hot hardness and diffusion wear resistance increases process stability and helps to combat the work-hardening nature of SS alloys.

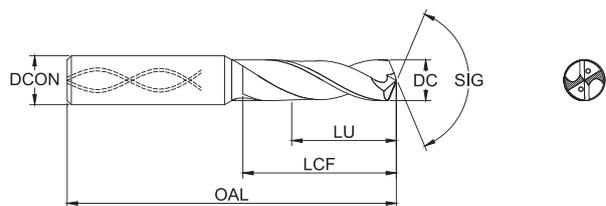


P	M	K	N	S	H
●	●			○	
● Recommended ○ Good					

## External Coolant



## Internal Coolant



### L/D - 3 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-HD1-03-1-0300-SC	3.0	6	14	20	62
MS-HD1-03-1-0310-SC	3.1	6	14	20	62
MS-HD1-03-1-0320-SC	3.2	6	14	20	62
MS-HD1-03-1-0330-SC	3.3	6	14	20	62
MS-HD1-03-1-0340-SC	3.4	6	14	20	62
MS-HD1-03-1-0350-SC	3.5	6	14	20	62
MS-HD1-03-1-0360-SC	3.6	6	14	20	62
MS-HD1-03-1-0370-SC	3.7	6	14	20	62
MS-HD1-03-1-0380-SC	3.8	6	17	24	66
MS-HD1-03-1-0390-SC	3.9	6	17	24	66
MS-HD1-03-1-0400-SC	4.0	6	17	24	66
MS-HD1-03-1-0410-SC	4.1	6	17	24	66
MS-HD1-03-1-0420-SC	4.2	6	17	24	66
MS-HD1-03-1-0430-SC	4.3	6	17	24	66
MS-HD1-03-1-0440-SC	4.4	6	17	24	66
MS-HD1-03-1-0450-SC	4.5	6	17	24	66
MS-HD1-03-1-0460-SC	4.6	6	17	24	66
MS-HD1-03-1-0470-SC	4.7	6	17	24	66
MS-HD1-03-1-0480-SC	4.8	6	20	28	66
MS-HD1-03-1-0490-SC	4.9	6	20	28	66
MS-HD1-03-1-0500-SC	5.0	6	20	28	66
MS-HD1-03-1-0510-SC	5.1	6	20	28	66
MS-HD1-03-1-0520-SC	5.2	6	20	28	66
MS-HD1-03-1-0530-SC	5.3	6	20	28	66
MS-HD1-03-1-0540-SC	5.4	6	20	28	66
MS-HD1-03-1-0550-SC	5.5	6	20	28	66
MS-HD1-03-1-0560-SC	5.6	6	20	28	66
MS-HD1-03-1-0570-SC	5.7	6	20	28	66
MS-HD1-03-1-0580-SC	5.8	6	20	28	66
MS-HD1-03-1-0590-SC	5.9	6	20	28	66
MS-HD1-03-1-0600-SC	6.0	6	20	28	66

### L/D - 3 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-HD1-03-1-0610-SC	6.1	8	24	34	79
MS-HD1-03-1-0620-SC	6.2	8	24	34	79
MS-HD1-03-1-0630-SC	6.3	8	24	34	79
MS-HD1-03-1-0640-SC	6.4	8	24	34	79
MS-HD1-03-1-0650-SC	6.5	8	24	34	79
MS-HD1-03-1-0660-SC	6.6	8	24	34	79
MS-HD1-03-1-0670-SC	6.7	8	24	34	79
MS-HD1-03-1-0680-SC	6.8	8	24	34	79
MS-HD1-03-1-0690-SC	6.9	8	24	34	79
MS-HD1-03-1-0700-SC	7.0	8	24	34	79
MS-HD1-03-1-0710-SC	7.1	8	29	41	79
MS-HD1-03-1-0720-SC	7.2	8	29	41	79
MS-HD1-03-1-0730-SC	7.3	8	29	41	79
MS-HD1-03-1-0740-SC	7.4	8	29	41	79
MS-HD1-03-1-0750-SC	7.5	8	29	41	79
MS-HD1-03-1-0760-SC	7.6	8	29	41	79
MS-HD1-03-1-0770-SC	7.7	8	29	41	79
MS-HD1-03-1-0780-SC	7.8	8	29	41	79
MS-HD1-03-1-0790-SC	7.9	8	29	41	79
MS-HD1-03-1-0800-SC	8.0	8	29	41	79
MS-HD1-03-1-0810-SC	8.1	10	35	47	89
MS-HD1-03-1-0820-SC	8.2	10	35	47	89
MS-HD1-03-1-0830-SC	8.3	10	35	47	89
MS-HD1-03-1-0840-SC	8.4	10	35	47	89
MS-HD1-03-1-0850-SC	8.5	10	35	47	89
MS-HD1-03-1-0860-SC	8.6	10	35	47	89
MS-HD1-03-1-0870-SC	8.7	10	35	47	89
MS-HD1-03-1-0880-SC	8.8	10	35	47	89
MS-HD1-03-1-0890-SC	8.9	10	35	47	89
MS-HD1-03-1-0900-SC	9.0	10	35	47	89
MS-HD1-03-1-0910-SC	9.1	10	35	47	89

### L/D - 3 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-HD1-03-1-0920-SC	9.2	10	35	47	89
MS-HD1-03-1-0930-SC	9.3	10	35	47	89
MS-HD1-03-1-0940-SC	9.4	10	35	47	89
MS-HD1-03-1-0950-SC	9.5	10	35	47	89
MS-HD1-03-1-0960-SC	9.6	10	35	47	89
MS-HD1-03-1-0970-SC	9.7	10	35	47	89
MS-HD1-03-1-0980-SC	9.8	10	35	47	89
MS-HD1-03-1-0990-SC	9.9	10	35	47	89
MS-HD1-03-1-1000-SC	10	10	35	47	89
MS-HD1-03-1-1010-SC	10.1	12	40	55	105
MS-HD1-03-1-1020-SC	10.2	12	40	55	105
MS-HD1-03-1-1030-SC	10.3	12	40	55	105
MS-HD1-03-1-1040-SC	10.4	12	40	55	105
MS-HD1-03-1-1050-SC	10.5	12	40	55	105
MS-HD1-03-1-1060-SC	10.6	12	40	55	105
MS-HD1-03-1-1070-SC	10.7	12	40	55	105
MS-HD1-03-1-1080-SC	10.8	12	40	55	105
MS-HD1-03-1-1090-SC	10.9	12	40	55	105
MS-HD1-03-1-1100-SC	11	12	40	55	105
MS-HD1-03-1-1110-SC	11.1	12	40	55	105
MS-HD1-03-1-1120-SC	11.2	12	40	55	105
MS-HD1-03-1-1130-SC	11.3	12	40	55	105
MS-HD1-03-1-1140-SC	11.4	12	40	55	105
MS-HD1-03-1-1150-SC	11.5	12	40	55	105
MS-HD1-03-1-1160-SC	11.6	12	40	55	105
MS-HD1-03-1-1170-SC	11.7	12	40	55	105
MS-HD1-03-1-1180-SC	11.8	12	40	55	105
MS-HD1-03-1-1190-SC	11.9	12	40	55	105
MS-HD1-03-1-1200-SC	12	12	40	55	105
MS-HD1-03-1-1210-SC	12.1	14	43	60	107
MS-HD1-03-1-1220-SC	12.2	14	43	60	107

### L/D - 3 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-HD1-03-1-1230-SC	12.3	14	43	60	107
MS-HD1-03-1-1240-SC	12.4	14	43	60	107
MS-HD1-03-1-1250-SC	12.5	14	43	60	107
MS-HD1-03-1-1260-SC	12.6	14	43	60	107
MS-HD1-03-1-1270-SC	12.7	14	43	60	107
MS-HD1-03-1-1280-SC	12.8	14	43	60	107
MS-HD1-03-1-1290-SC	12.9	14	43	60	107
MS-HD1-03-1-1300-SC	13	14	43	60	107
MS-HD1-03-1-1310-SC	13.1	14	43	60	107
MS-HD1-03-1-1320-SC	13.2	14	43	60	107
MS-HD1-03-1-1330-SC	13.3	14	43	60	107
MS-HD1-03-1-1340-SC	13.4	14	43	60	107
MS-HD1-03-1-1350-SC	13.5	14	43	60	107
MS-HD1-03-1-1360-SC	13.6	14	43	60	107
MS-HD1-03-1-1370-SC	13.7	14	43	60	107
MS-HD1-03-1-1380-SC	13.8	14	43	60	107
MS-HD1-03-1-1390-SC	13.9	14	43	60	107
MS-HD1-03-1-1400-SC	14	14	43	60	107
MS-HD1-03-1-1410-SC	14.1	16	45	65	115
MS-HD1-03-1-1420-SC	14.2	16	45	65	115
MS-HD1-03-1-1430-SC	14.3	16	45	65	115
MS-HD1-03-1-1440-SC	14.4	16	45	65	115
MS-HD1-03-1-1450-SC	14.5	16	45	65	115
MS-HD1-03-1-1460-SC	14.6	16	45	65	115
MS-HD1-03-1-1470-SC	14.7	16	45	65	115
MS-HD1-03-1-1480-SC	14.8	16	45	65	115
MS-HD1-03-1-1490-SC	14.9	16	45	65	115
MS-HD1-03-1-1500-SC	15	16	45	65	115
MS-HD1-03-1-1510-SC	15.1	16	45	65	115
MS-HD1-03-1-1520-SC	15.2	16	45	65	115
MS-HD1-03-1-1530-SC	15.3	16	45	65	115

### L/D - 3 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-HD1-03-1-1540-SC	15.4	16	45	65	115
MS-HD1-03-1-1550-SC	15.5	16	45	65	115
MS-HD1-03-1-1560-SC	15.6	16	45	65	115
MS-HD1-03-1-1570-SC	15.7	16	45	65	115
MS-HD1-03-1-1580-SC	15.8	16	45	65	115
MS-HD1-03-1-1590-SC	15.9	16	45	65	115
MS-HD1-03-1-1600-SC	16	16	45	65	115
MS-HD1-03-1-1610-SC	16.1	18	51	73	123
MS-HD1-03-1-1620-SC	16.2	18	51	73	123
MS-HD1-03-1-1630-SC	16.3	18	51	73	123
MS-HD1-03-1-1640-SC	16.4	18	51	73	123
MS-HD1-03-1-1650-SC	16.5	18	51	73	123
MS-HD1-03-1-1660-SC	16.6	18	51	73	123
MS-HD1-03-1-1670-SC	16.7	18	51	73	123
MS-HD1-03-1-1680-SC	16.8	18	51	73	123
MS-HD1-03-1-1690-SC	16.9	18	51	73	123
MS-HD1-03-1-1700-SC	17	18	51	73	123
MS-HD1-03-1-1710-SC	17.1	18	51	73	123
MS-HD1-03-1-1720-SC	17.2	18	51	73	123
MS-HD1-03-1-1730-SC	17.3	18	51	73	123
MS-HD1-03-1-1740-SC	17.4	18	51	73	123
MS-HD1-03-1-1750-SC	17.5	18	51	73	123
MS-HD1-03-1-1760-SC	17.6	18	51	73	123
MS-HD1-03-1-1770-SC	17.7	18	51	73	123
MS-HD1-03-1-1780-SC	17.8	18	51	73	123
MS-HD1-03-1-1790-SC	17.9	18	51	73	123
MS-HD1-03-1-1800-SC	18	18	51	73	123
MS-HD1-03-1-1810-SC	18.1	20	55	79	131
MS-HD1-03-1-1820-SC	18.2	20	55	79	131
MS-HD1-03-1-1830-SC	18.3	20	55	79	131
MS-HD1-03-1-1840-SC	18.4	20	55	79	131

### L/D - 3 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-HD1-03-1-1850-SC	18.5	20	55	79	131
MS-HD1-03-1-1860-SC	18.6	20	55	79	131
MS-HD1-03-1-1870-SC	18.7	20	55	79	131
MS-HD1-03-1-1880-SC	18.8	20	55	79	131
MS-HD1-03-1-1890-SC	18.9	20	55	79	131
MS-HD1-03-1-1900-SC	19	20	55	79	131
MS-HD1-03-1-1910-SC	19.1	20	55	79	131
MS-HD1-03-1-1920-SC	19.2	20	55	79	131
MS-HD1-03-1-1930-SC	19.3	20	55	79	131
MS-HD1-03-1-1940-SC	19.4	20	55	79	131
MS-HD1-03-1-1950-SC	19.5	20	55	79	131
MS-HD1-03-1-1960-SC	19.6	20	55	79	131
MS-HD1-03-1-1970-SC	19.7	20	55	79	131
MS-HD1-03-1-1980-SC	19.8	20	55	79	131
MS-HD1-03-1-1990-SC	19.9	20	55	79	131
MS-HD1-03-1-2000-SC	20	20	55	79	131