

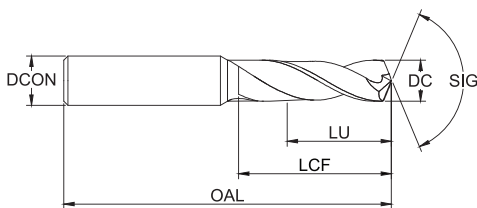
# MP1-SC

- ▶ MSTM's MP1 drills are designed for premium performance and excellent value when drilling a wide variety of materials, ranging from soft, non-ferrous materials to semi-hardened steels.
- ▶ Custom flute design to allow high feed rates with excellent chip flow.
- ▶ Unique cutting lip design results in uniform cutting forces improving tool life and increasing hole surface quality.
- ▶ Double margin design allows for stable machining even at higher speeds with superior surface finish.
- ▶ 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.
- ▶ Best performance holemaking solution for cast iron alloys and steel alloys.

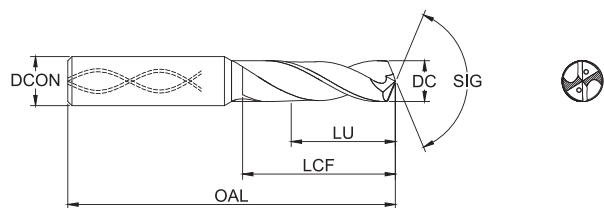


P	M	K	N	S	H
●	○	●	●		
● Recommended ○ Good					

## External Coolant



## Internal Coolant



### L/D - 5 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-MP1-05-1-0300-SC	3.0	6	23	28	66
MS-MP1-05-1-0310-SC	3.1	6	23	28	66
MS-MP1-05-1-0320-SC	3.2	6	23	28	66
MS-MP1-05-1-0330-SC	3.3	6	23	28	66
MS-MP1-05-1-0340-SC	3.4	6	23	28	66
MS-MP1-05-1-0350-SC	3.5	6	23	28	66
MS-MP1-05-1-0360-SC	3.6	6	23	28	66
MS-MP1-05-1-0370-SC	3.7	6	23	28	66
MS-MP1-05-1-0380-SC	3.8	6	29	36	74
MS-MP1-05-1-0390-SC	3.9	6	29	36	74
MS-MP1-05-1-0400-SC	4.0	6	29	36	74
MS-MP1-05-1-0410-SC	4.1	6	29	36	74
MS-MP1-05-1-0420-SC	4.2	6	29	36	74
MS-MP1-05-1-0430-SC	4.3	6	29	36	74
MS-MP1-05-1-0440-SC	4.4	6	29	36	74
MS-MP1-05-1-0450-SC	4.5	6	29	36	74
MS-MP1-05-1-0460-SC	4.6	6	29	36	74
MS-MP1-05-1-0470-SC	4.7	6	29	36	74
MS-MP1-05-1-0480-SC	4.8	6	35	44	82
MS-MP1-05-1-0490-SC	4.9	6	35	44	82
MS-MP1-05-1-0500-SC	5.0	6	35	44	82
MS-MP1-05-1-0510-SC	5.1	6	35	44	82
MS-MP1-05-1-0520-SC	5.2	6	35	44	82
MS-MP1-05-1-0530-SC	5.3	6	35	44	82
MS-MP1-05-1-0540-SC	5.4	6	35	44	82
MS-MP1-05-1-0550-SC	5.5	6	35	44	82
MS-MP1-05-1-0560-SC	5.6	6	35	44	82
MS-MP1-05-1-0570-SC	5.7	6	35	44	82
MS-MP1-05-1-0580-SC	5.8	6	35	44	82
MS-MP1-05-1-0590-SC	5.9	6	35	44	82
MS-MP1-05-1-0600-SC	6.0	6	35	44	82

### L/D - 5 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-MP1-05-1-0610-SC	6.1	8	43	53	91
MS-MP1-05-1-0620-SC	6.2	8	43	53	91
MS-MP1-05-1-0630-SC	6.3	8	43	53	91
MS-MP1-05-1-0640-SC	6.4	8	43	53	91
MS-MP1-05-1-0650-SC	6.5	8	43	53	91
MS-MP1-05-1-0660-SC	6.6	8	43	53	91
MS-MP1-05-1-0670-SC	6.7	8	43	53	91
MS-MP1-05-1-0680-SC	6.8	8	43	53	91
MS-MP1-05-1-0690-SC	6.9	8	43	53	91
MS-MP1-05-1-0700-SC	7.0	8	43	53	91
MS-MP1-05-1-0710-SC	7.1	8	43	53	91
MS-MP1-05-1-0720-SC	7.2	8	43	53	91
MS-MP1-05-1-0730-SC	7.3	8	43	53	91
MS-MP1-05-1-0740-SC	7.4	8	43	53	91
MS-MP1-05-1-0750-SC	7.5	8	43	53	91
MS-MP1-05-1-0760-SC	7.6	8	43	53	91
MS-MP1-05-1-0770-SC	7.7	8	43	53	91
MS-MP1-05-1-0780-SC	7.8	8	43	53	91
MS-MP1-05-1-0790-SC	7.9	8	43	53	91
MS-MP1-05-1-0800-SC	8.0	8	43	53	91
MS-MP1-05-1-0810-SC	8.1	10	49	61	103
MS-MP1-05-1-0820-SC	8.2	10	49	61	103
MS-MP1-05-1-0830-SC	8.3	10	49	61	103
MS-MP1-05-1-0840-SC	8.4	10	49	61	103
MS-MP1-05-1-0850-SC	8.5	10	49	61	103
MS-MP1-05-1-0860-SC	8.6	10	49	61	103
MS-MP1-05-1-0870-SC	8.7	10	49	61	103
MS-MP1-05-1-0880-SC	8.8	10	49	61	103
MS-MP1-05-1-0890-SC	8.9	10	49	61	103
MS-MP1-05-1-0900-SC	9.0	10	49	61	103
MS-MP1-05-1-0910-SC	9.1	10	49	61	103

### L/D - 5 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-MP1-05-1-0920-SC	9.2	10	49	61	103
MS-MP1-05-1-0930-SC	9.3	10	49	61	103
MS-MP1-05-1-0940-SC	9.4	10	49	61	103
MS-MP1-05-1-0950-SC	9.5	10	49	61	103
MS-MP1-05-1-0960-SC	9.6	10	49	61	103
MS-MP1-05-1-0970-SC	9.7	10	49	61	103
MS-MP1-05-1-0980-SC	9.8	10	49	61	103
MS-MP1-05-1-0990-SC	9.9	10	49	61	103
MS-MP1-05-1-1000-SC	10	10	49	61	103
MS-MP1-05-1-1010-SC	10.1	12	56	71	118
MS-MP1-05-1-1020-SC	10.2	12	56	71	118
MS-MP1-05-1-1030-SC	10.3	12	56	71	118
MS-MP1-05-1-1040-SC	10.4	12	56	71	118
MS-MP1-05-1-1050-SC	10.5	12	56	71	118
MS-MP1-05-1-1060-SC	10.6	12	56	71	118
MS-MP1-05-1-1070-SC	10.7	12	56	71	118
MS-MP1-05-1-1080-SC	10.8	12	56	71	118
MS-MP1-05-1-1090-SC	10.9	12	56	71	118
MS-MP1-05-1-1100-SC	11	12	56	71	118
MS-MP1-05-1-1110-SC	11.1	12	56	71	118
MS-MP1-05-1-1120-SC	11.2	12	56	71	118
MS-MP1-05-1-1130-SC	11.3	12	56	71	118
MS-MP1-05-1-1140-SC	11.4	12	56	71	118
MS-MP1-05-1-1150-SC	11.5	12	56	71	118
MS-MP1-05-1-1160-SC	11.6	12	56	71	118
MS-MP1-05-1-1170-SC	11.7	12	56	71	118
MS-MP1-05-1-1180-SC	11.8	12	56	71	118
MS-MP1-05-1-1190-SC	11.9	12	56	71	118
MS-MP1-05-1-1200-SC	12	12	56	71	118
MS-MP1-05-1-1210-SC	12.1	14	60	77	124
MS-MP1-05-1-1220-SC	12.2	14	60	77	124

### L/D - 5 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-MP1-05-1-1230-SC	12.3	14	60	77	124
MS-MP1-05-1-1240-SC	12.4	14	60	77	124
MS-MP1-05-1-1250-SC	12.5	14	60	77	124
MS-MP1-05-1-1260-SC	12.6	14	60	77	124
MS-MP1-05-1-1270-SC	12.7	14	60	77	124
MS-MP1-05-1-1280-SC	12.8	14	60	77	124
MS-MP1-05-1-1290-SC	12.9	14	60	77	124
MS-MP1-05-1-1300-SC	13	14	60	77	124
MS-MP1-05-1-1310-SC	13.1	14	60	77	124
MS-MP1-05-1-1320-SC	13.2	14	60	77	124
MS-MP1-05-1-1330-SC	13.3	14	60	77	124
MS-MP1-05-1-1340-SC	13.4	14	60	77	124
MS-MP1-05-1-1350-SC	13.5	14	60	77	124
MS-MP1-05-1-1360-SC	13.6	14	60	77	124
MS-MP1-05-1-1370-SC	13.7	14	60	77	124
MS-MP1-05-1-1380-SC	13.8	14	60	77	124
MS-MP1-05-1-1390-SC	13.9	14	60	77	124
MS-MP1-05-1-1400-SC	14	14	60	77	124
MS-MP1-05-1-1410-SC	14.1	16	63	83	133
MS-MP1-05-1-1420-SC	14.2	16	63	83	133
MS-MP1-05-1-1430-SC	14.3	16	63	83	133
MS-MP1-05-1-1440-SC	14.4	16	63	83	133
MS-MP1-05-1-1450-SC	14.5	16	63	83	133
MS-MP1-05-1-1460-SC	14.6	16	63	83	133
MS-MP1-05-1-1470-SC	14.7	16	63	83	133
MS-MP1-05-1-1480-SC	14.8	16	63	83	133
MS-MP1-05-1-1490-SC	14.9	16	63	83	133
MS-MP1-05-1-1500-SC	15	16	63	83	133
MS-MP1-05-1-1510-SC	15.1	16	63	83	133
MS-MP1-05-1-1520-SC	15.2	16	63	83	133
MS-MP1-05-1-1530-SC	15.3	16	63	83	133

### L/D - 5 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-MP1-05-1-1540-SC	15.4	16	63	83	133
MS-MP1-05-1-1550-SC	15.5	16	63	83	133
MS-MP1-05-1-1560-SC	15.6	16	63	83	133
MS-MP1-05-1-1570-SC	15.7	16	63	83	133
MS-MP1-05-1-1580-SC	15.8	16	63	83	133
MS-MP1-05-1-1590-SC	15.9	16	63	83	133
MS-MP1-05-1-1600-SC	16	16	63	83	133
MS-MP1-05-1-1610-SC	16.1	18	71	93	143
MS-MP1-05-1-1620-SC	16.2	18	71	93	143
MS-MP1-05-1-1630-SC	16.3	18	71	93	143
MS-MP1-05-1-1640-SC	16.4	18	71	93	143
MS-MP1-05-1-1650-SC	16.5	18	71	93	143
MS-MP1-05-1-1660-SC	16.6	18	71	93	143
MS-MP1-05-1-1670-SC	16.7	18	71	93	143
MS-MP1-05-1-1680-SC	16.8	18	71	93	143
MS-MP1-05-1-1690-SC	16.9	18	71	93	143
MS-MP1-05-1-1700-SC	17	18	71	93	143
MS-MP1-05-1-1710-SC	17.1	18	71	93	143
MS-MP1-05-1-1720-SC	17.2	18	71	93	143
MS-MP1-05-1-1730-SC	17.3	18	71	93	143
MS-MP1-05-1-1740-SC	17.4	18	71	93	143
MS-MP1-05-1-1750-SC	17.5	18	71	93	143
MS-MP1-05-1-1760-SC	17.6	18	71	93	143
MS-MP1-05-1-1770-SC	17.7	18	71	93	143
MS-MP1-05-1-1780-SC	17.8	18	71	93	143
MS-MP1-05-1-1790-SC	17.9	18	71	93	143
MS-MP1-05-1-1800-SC	18	18	71	93	143
MS-MP1-05-1-1810-SC	18.1	20	77	101	153
MS-MP1-05-1-1820-SC	18.2	20	77	101	153
MS-MP1-05-1-1830-SC	18.3	20	77	101	153
MS-MP1-05-1-1840-SC	18.4	20	77	101	153

### L/D - 5 (Internal Coolant)



units in mm

CODE	DC	DCON	LU	LCF	OAL
MS-MP1-05-1-1850-SC	18.5	20	77	101	153
MS-MP1-05-1-1860-SC	18.6	20	77	101	153
MS-MP1-05-1-1870-SC	18.7	20	77	101	153
MS-MP1-05-1-1880-SC	18.8	20	77	101	153
MS-MP1-05-1-1890-SC	18.9	20	77	101	153
MS-MP1-05-1-1900-SC	19	20	77	101	153
MS-MP1-05-1-1910-SC	19.1	20	77	101	153
MS-MP1-05-1-1920-SC	19.2	20	77	101	153
MS-MP1-05-1-1930-SC	19.3	20	77	101	153
MS-MP1-05-1-1940-SC	19.4	20	77	101	153
MS-MP1-05-1-1950-SC	19.5	20	77	101	153
MS-MP1-05-1-1960-SC	19.6	20	77	101	153
MS-MP1-05-1-1970-SC	19.7	20	77	101	153
MS-MP1-05-1-1980-SC	19.8	20	77	101	153
MS-MP1-05-1-1990-SC	19.9	20	77	101	153
MS-MP1-05-1-2000-SC	20	20	77	101	153