



Carbide Drills for Non-ferrous Materials

# HYP-AL-SERIES

Volume 1



## KEY FEATURES: HYP-AL-3D / HYP-ALO-5D

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**1** Carbide drill, bright finish, also with internal coolant

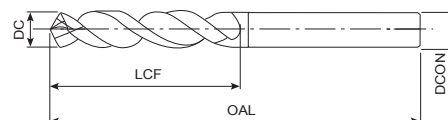
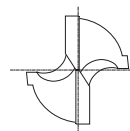
**2** Up to 3xD & 5xD

**3** For general aluminum machining



# HYP-AL-3D

Drilling | Solid carbide | 3xD



- Carbide drill, bright finish
- Up to 3xD
- For Aluminium and cast Aluminium
- 137 sizes



| EDP       | DC   | LCF | OAL | DCON |
|-----------|------|-----|-----|------|
| 110301000 | 1    | 7   | 35  | 3    |
| 110301100 | 1,1  | 7   | 35  | 3    |
| 110301200 | 1,2  | 8   | 35  | 3    |
| 110301300 | 1,3  | 8   | 35  | 3    |
| 110301400 | 1,4  | 9   | 35  | 3    |
| 110301500 | 1,5  | 9   | 40  | 3    |
| 110301600 | 1,6  | 10  | 40  | 3    |
| 110301700 | 1,7  | 10  | 40  | 3    |
| 110301800 | 1,8  | 11  | 40  | 3    |
| 110301900 | 1,9  | 11  | 40  | 3    |
| 110302000 | 2    | 13  | 45  | 3    |
| 110302100 | 2,1  | 13  | 45  | 3    |
| 110302200 | 2,2  | 13  | 45  | 3    |
| 110302300 | 2,3  | 13  | 45  | 3    |
| 110302400 | 2,4  | 15  | 45  | 3    |
| 110302500 | 2,5  | 15  | 50  | 3    |
| 110302600 | 2,6  | 15  | 50  | 3    |
| 110302700 | 2,7  | 17  | 50  | 3    |
| 110302800 | 2,8  | 17  | 50  | 3    |
| 110302900 | 2,9  | 17  | 50  | 3    |
| 110303000 | 3    | 20  | 62  | 6    |
| 110303100 | 3,1  | 20  | 62  | 6    |
| 110303170 | 3,17 | 20  | 62  | 6    |
| 110303200 | 3,2  | 20  | 62  | 6    |
| 110303300 | 3,3  | 20  | 62  | 6    |
| 110303400 | 3,4  | 20  | 62  | 6    |
| 110303500 | 3,5  | 20  | 62  | 6    |
| 110303570 | 3,57 | 20  | 62  | 6    |
| 110303600 | 3,6  | 20  | 62  | 6    |
| 110303700 | 3,7  | 20  | 62  | 6    |
| 110303800 | 3,8  | 24  | 66  | 6    |
| 110303900 | 3,9  | 24  | 66  | 6    |
| 110303970 | 3,97 | 24  | 66  | 6    |
| 110304000 | 4    | 24  | 66  | 6    |
| 110304100 | 4,1  | 24  | 66  | 6    |
| 110304200 | 4,2  | 24  | 66  | 6    |
| 110304300 | 4,3  | 24  | 66  | 6    |
| 110304370 | 4,37 | 24  | 66  | 6    |
| 110304400 | 4,4  | 24  | 66  | 6    |
| 110304500 | 4,5  | 24  | 66  | 6    |
| 110304600 | 4,6  | 24  | 66  | 6    |
| 110304700 | 4,7  | 24  | 66  | 6    |
| 110304760 | 4,76 | 28  | 66  | 6    |
| 110304800 | 4,8  | 28  | 66  | 6    |
| 110304900 | 4,9  | 28  | 66  | 6    |
| 110305000 | 5    | 28  | 66  | 6    |

| EDP       | DC   | LCF | OAL | DCON |
|-----------|------|-----|-----|------|
| 110305100 | 5,1  | 28  | 66  | 6    |
| 110305160 | 5,16 | 28  | 66  | 6    |
| 110305200 | 5,2  | 28  | 66  | 6    |
| 110305300 | 5,3  | 28  | 66  | 6    |
| 110305400 | 5,4  | 28  | 66  | 6    |
| 110305500 | 5,5  | 28  | 66  | 6    |
| 110305560 | 5,56 | 28  | 66  | 6    |
| 110305600 | 5,6  | 28  | 66  | 6    |
| 110305700 | 5,7  | 28  | 66  | 6    |
| 110305800 | 5,8  | 28  | 66  | 6    |
| 110305900 | 5,9  | 28  | 66  | 6    |
| 110305950 | 5,95 | 28  | 66  | 6    |
| 110306000 | 6    | 28  | 66  | 6    |
| 110306100 | 6,1  | 34  | 79  | 8    |
| 110306200 | 6,2  | 34  | 79  | 8    |
| 110306300 | 6,3  | 34  | 79  | 8    |
| 110306350 | 6,35 | 34  | 79  | 8    |
| 110306400 | 6,4  | 34  | 79  | 8    |
| 110306500 | 6,5  | 34  | 79  | 8    |
| 110306600 | 6,6  | 34  | 79  | 8    |
| 110306700 | 6,7  | 34  | 79  | 8    |
| 110306750 | 6,75 | 34  | 79  | 8    |
| 110306800 | 6,8  | 34  | 79  | 8    |
| 110306900 | 6,9  | 34  | 79  | 8    |
| 110307000 | 7    | 34  | 79  | 8    |
| 110307100 | 7,1  | 41  | 79  | 8    |
| 110307140 | 7,14 | 41  | 79  | 8    |
| 110307200 | 7,2  | 41  | 79  | 8    |
| 110307300 | 7,3  | 41  | 79  | 8    |
| 110307400 | 7,4  | 41  | 79  | 8    |
| 110307500 | 7,5  | 41  | 79  | 8    |
| 110307540 | 7,54 | 41  | 79  | 8    |
| 110307600 | 7,6  | 41  | 79  | 8    |
| 110307700 | 7,7  | 41  | 79  | 8    |
| 110307800 | 7,8  | 41  | 79  | 8    |
| 110307900 | 7,9  | 41  | 79  | 8    |
| 110307940 | 7,94 | 41  | 79  | 8    |
| 110308000 | 8    | 41  | 79  | 8    |
| 110308100 | 8,1  | 47  | 89  | 10   |
| 110308200 | 8,2  | 47  | 89  | 10   |
| 110308300 | 8,3  | 47  | 89  | 10   |
| 110308330 | 8,33 | 47  | 89  | 10   |
| 110308400 | 8,4  | 47  | 89  | 10   |
| 110308500 | 8,5  | 47  | 89  | 10   |
| 110308600 | 8,6  | 47  | 89  | 10   |
| 110308700 | 8,7  | 47  | 89  | 10   |



# HYP-AL-3D

Drilling | Solid carbide | 3xD



- Carbide drill, bright finish
- Up to 3xD
- For Aluminium and cast Aluminium
- 137 sizes



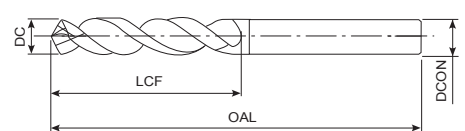
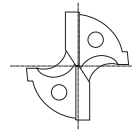
| EDP       | DC    | LCF | OAL | DCON | EDP | DC | LCF | OAL | DCON |
|-----------|-------|-----|-----|------|-----|----|-----|-----|------|
| 110308730 | 8,73  | 47  | 89  | 10   |     |    |     |     |      |
| 110308800 | 8,8   | 47  | 89  | 10   |     |    |     |     |      |
| 110308900 | 8,9   | 47  | 89  | 10   |     |    |     |     |      |
| 110309000 | 9     | 47  | 89  | 10   |     |    |     |     |      |
| 110309100 | 9,1   | 47  | 89  | 10   |     |    |     |     |      |
| 110309130 | 9,13  | 47  | 89  | 10   |     |    |     |     |      |
| 110309200 | 9,2   | 47  | 89  | 10   |     |    |     |     |      |
| 110309300 | 9,3   | 47  | 89  | 10   |     |    |     |     |      |
| 110309400 | 9,4   | 47  | 89  | 10   |     |    |     |     |      |
| 110309500 | 9,5   | 47  | 89  | 10   |     |    |     |     |      |
| 110309520 | 9,52  | 47  | 89  | 10   |     |    |     |     |      |
| 110309600 | 9,6   | 47  | 89  | 10   |     |    |     |     |      |
| 110309700 | 9,7   | 47  | 89  | 10   |     |    |     |     |      |
| 110309800 | 9,8   | 47  | 89  | 10   |     |    |     |     |      |
| 110309900 | 9,9   | 47  | 89  | 10   |     |    |     |     |      |
| 110309920 | 9,92  | 47  | 89  | 10   |     |    |     |     |      |
| 110310000 | 10    | 47  | 89  | 10   |     |    |     |     |      |
| 110310100 | 10,1  | 55  | 102 | 12   |     |    |     |     |      |
| 110310200 | 10,2  | 55  | 102 | 12   |     |    |     |     |      |
| 110310300 | 10,3  | 55  | 102 | 12   |     |    |     |     |      |
| 110310320 | 10,32 | 55  | 102 | 12   |     |    |     |     |      |
| 110310400 | 10,4  | 55  | 102 | 12   |     |    |     |     |      |
| 110310500 | 10,5  | 55  | 102 | 12   |     |    |     |     |      |
| 110310600 | 10,6  | 55  | 102 | 12   |     |    |     |     |      |
| 110310700 | 10,7  | 55  | 102 | 12   |     |    |     |     |      |
| 110310720 | 10,72 | 55  | 102 | 12   |     |    |     |     |      |
| 110310800 | 10,8  | 55  | 102 | 12   |     |    |     |     |      |
| 110310900 | 10,9  | 55  | 102 | 12   |     |    |     |     |      |
| 110311000 | 11    | 55  | 102 | 12   |     |    |     |     |      |
| 110311100 | 11,1  | 55  | 102 | 12   |     |    |     |     |      |
| 110311110 | 11,11 | 55  | 102 | 12   |     |    |     |     |      |
| 110311200 | 11,2  | 55  | 102 | 12   |     |    |     |     |      |
| 110311300 | 11,3  | 55  | 102 | 12   |     |    |     |     |      |
| 110311400 | 11,4  | 55  | 102 | 12   |     |    |     |     |      |
| 110311500 | 11,5  | 55  | 102 | 12   |     |    |     |     |      |
| 110311510 | 11,51 | 55  | 102 | 12   |     |    |     |     |      |
| 110311600 | 11,6  | 55  | 102 | 12   |     |    |     |     |      |
| 110311700 | 11,7  | 55  | 102 | 12   |     |    |     |     |      |
| 110311800 | 11,8  | 55  | 102 | 12   |     |    |     |     |      |
| 110311900 | 11,9  | 55  | 102 | 12   |     |    |     |     |      |
| 110311910 | 11,91 | 55  | 102 | 12   |     |    |     |     |      |
| 110312000 | 12    | 55  | 102 | 12   |     |    |     |     |      |
| 110312300 | 12,3  | 60  | 107 | 14   |     |    |     |     |      |
| 110312500 | 12,5  | 60  | 107 | 14   |     |    |     |     |      |
| 110312700 | 12,7  | 60  | 107 | 14   |     |    |     |     |      |

Drilling | Solid carbide

3xD

# HYP-ALO-5D

Drilling | Solid carbide | 5xD



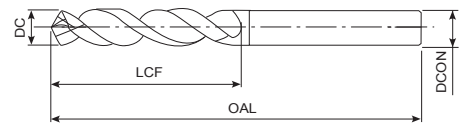
- Carbide drill with internal coolant, bright finish
- Up to 5xD
- For Aluminium and cast Aluminium
- 119 sizes



| EDP       | DC   | LCF | OAL | DCON |
|-----------|------|-----|-----|------|
| 111503000 | 3    | 28  | 66  | 6    |
| 111503100 | 3,1  | 28  | 66  | 6    |
| 111503170 | 3,17 | 28  | 66  | 6    |
| 111503200 | 3,2  | 28  | 66  | 6    |
| 111503300 | 3,3  | 28  | 66  | 6    |
| 111503400 | 3,4  | 28  | 66  | 6    |
| 111503500 | 3,5  | 28  | 66  | 6    |
| 111503570 | 3,57 | 28  | 66  | 6    |
| 111503600 | 3,6  | 28  | 66  | 6    |
| 111503700 | 3,7  | 28  | 66  | 6    |
| 111503800 | 3,8  | 36  | 74  | 6    |
| 111503900 | 3,9  | 36  | 74  | 6    |
| 111503970 | 3,97 | 36  | 74  | 6    |
| 111504000 | 4    | 36  | 74  | 6    |
| 111504100 | 4,1  | 36  | 74  | 6    |
| 111504200 | 4,2  | 36  | 74  | 6    |
| 111504300 | 4,3  | 36  | 74  | 6    |
| 111504370 | 4,37 | 36  | 74  | 6    |
| 111504400 | 4,4  | 36  | 74  | 6    |
| 111504500 | 4,5  | 36  | 74  | 6    |
| 111504600 | 4,6  | 36  | 74  | 6    |
| 111504650 | 4,65 | 36  | 74  | 6    |
| 111504700 | 4,7  | 36  | 74  | 6    |
| 111504760 | 4,76 | 44  | 82  | 6    |
| 111504800 | 4,8  | 44  | 82  | 6    |
| 111504900 | 4,9  | 44  | 82  | 6    |
| 111505000 | 5    | 44  | 82  | 6    |
| 111505100 | 5,1  | 44  | 82  | 6    |
| 111505160 | 5,16 | 44  | 82  | 6    |
| 111505200 | 5,2  | 44  | 82  | 6    |
| 111505300 | 5,3  | 44  | 82  | 6    |
| 111505400 | 5,4  | 44  | 82  | 6    |
| 111505500 | 5,5  | 44  | 82  | 6    |
| 111505550 | 5,55 | 44  | 82  | 6    |
| 111505560 | 5,56 | 44  | 82  | 6    |
| 111505600 | 5,6  | 44  | 82  | 6    |
| 111505700 | 5,7  | 44  | 82  | 6    |
| 111505800 | 5,8  | 44  | 82  | 6    |
| 111505900 | 5,9  | 44  | 82  | 6    |
| 111505950 | 5,95 | 44  | 82  | 6    |
| 111506000 | 6    | 44  | 82  | 6    |
| 111506100 | 6,1  | 53  | 91  | 8    |
| 111506200 | 6,2  | 53  | 91  | 8    |
| 111506300 | 6,3  | 53  | 91  | 8    |
| 111506350 | 6,35 | 53  | 91  | 8    |
| 111506400 | 6,4  | 53  | 91  | 8    |

| EDP       | DC   | LCF | OAL | DCON |
|-----------|------|-----|-----|------|
| 111506500 | 6,5  | 53  | 91  | 8    |
| 111506600 | 6,6  | 53  | 91  | 8    |
| 111506700 | 6,7  | 53  | 91  | 8    |
| 111506750 | 6,75 | 53  | 91  | 8    |
| 111506800 | 6,8  | 53  | 91  | 8    |
| 111506900 | 6,9  | 53  | 91  | 8    |
| 111507000 | 7    | 53  | 91  | 8    |
| 111507100 | 7,1  | 53  | 91  | 8    |
| 111507140 | 7,14 | 53  | 91  | 8    |
| 111507200 | 7,2  | 53  | 91  | 8    |
| 111507300 | 7,3  | 53  | 91  | 8    |
| 111507400 | 7,4  | 53  | 91  | 8    |
| 111507500 | 7,5  | 53  | 91  | 8    |
| 111507540 | 7,54 | 53  | 91  | 8    |
| 111507600 | 7,6  | 53  | 91  | 8    |
| 111507700 | 7,7  | 53  | 91  | 8    |
| 111507800 | 7,8  | 53  | 91  | 8    |
| 111507900 | 7,9  | 53  | 91  | 8    |
| 111507940 | 7,94 | 53  | 91  | 8    |
| 111508000 | 8    | 53  | 91  | 8    |
| 111508100 | 8,1  | 61  | 103 | 10   |
| 111508200 | 8,2  | 61  | 103 | 10   |
| 111508300 | 8,3  | 61  | 103 | 10   |
| 111508330 | 8,33 | 61  | 103 | 10   |
| 111508400 | 8,4  | 61  | 103 | 10   |
| 111508500 | 8,5  | 61  | 103 | 10   |
| 111508600 | 8,6  | 61  | 103 | 10   |
| 111508700 | 8,7  | 61  | 103 | 10   |
| 111508730 | 8,73 | 61  | 103 | 10   |
| 111508800 | 8,8  | 61  | 103 | 10   |
| 111508900 | 8,9  | 61  | 103 | 10   |
| 111509000 | 9    | 61  | 103 | 10   |
| 111509100 | 9,1  | 61  | 103 | 10   |
| 111509130 | 9,13 | 61  | 103 | 10   |
| 111509200 | 9,2  | 61  | 103 | 10   |
| 111509300 | 9,3  | 61  | 103 | 10   |
| 111509400 | 9,4  | 61  | 103 | 10   |
| 111509500 | 9,5  | 61  | 103 | 10   |
| 111509520 | 9,52 | 61  | 103 | 10   |
| 111509600 | 9,6  | 61  | 103 | 10   |
| 111509700 | 9,7  | 61  | 103 | 10   |
| 111509800 | 9,8  | 61  | 103 | 10   |
| 111509900 | 9,9  | 61  | 103 | 10   |
| 111509920 | 9,92 | 61  | 103 | 10   |
| 111510000 | 10   | 61  | 103 | 10   |
| 111510100 | 10,1 | 71  | 118 | 12   |

**Drilling | Solid carbide | 5xD**



- |          |                                                                                   |          |                                                                                   |
|----------|-----------------------------------------------------------------------------------|----------|-----------------------------------------------------------------------------------|
| <b>N</b> |  | <b>N</b> |  |
| AI       |                                                                                   | AC, ADC  |                                                                                   |

[illegible]

# CUTTING CONDITIONS

Drilling | Solid | Cutting conditions

## HYP-AL-3D

|    | Cast Aluminum             |               | Aluminum Alloy            |               | Copper Alloy              |               | Magnesium Alloy           |               |
|----|---------------------------|---------------|---------------------------|---------------|---------------------------|---------------|---------------------------|---------------|
| Vc | 80 ~ 200 m/min            |               | 80 ~ 150 m/min            |               | 40 ~ 100 m/min            |               | 60 ~ 100 m/min            |               |
| Ø  | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev) | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev) | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev) | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev) |
| 1  | 25000                     | 0,02 ~ 0,08   | 25000                     | 0,02 ~ 0,05   | 22300                     | 0,008 ~ 0,02  | 25000                     | 0,02 ~ 0,05   |
| 2  | 22300                     | 0,04 ~ 0,16   | 18300                     | 0,04 ~ 0,10   | 11100                     | 0,016 ~ 0,04  | 12700                     | 0,04 ~ 0,10   |
| 3  | 14900                     | 0,06 ~ 0,24   | 12200                     | 0,06 ~ 0,15   | 7400                      | 0,024 ~ 0,06  | 8500                      | 0,06 ~ 0,15   |
| 4  | 11100                     | 0,08 ~ 0,32   | 9200                      | 0,08 ~ 0,20   | 5600                      | 0,032 ~ 0,08  | 6400                      | 0,08 ~ 0,20   |
| 6  | 7400                      | 0,12 ~ 0,48   | 6100                      | 0,12 ~ 0,30   | 3700                      | 0,048 ~ 0,12  | 4200                      | 0,12 ~ 0,30   |
| 8  | 5600                      | 0,16 ~ 0,64   | 4600                      | 0,16 ~ 0,40   | 2800                      | 0,064 ~ 0,16  | 3200                      | 0,16 ~ 0,40   |
| 10 | 4500                      | 0,20 ~ 0,80   | 3700                      | 0,20 ~ 0,50   | 2200                      | 0,080 ~ 0,20  | 2500                      | 0,20 ~ 0,50   |
| 12 | 3700                      | 0,24 ~ 0,96   | 3100                      | 0,24 ~ 0,60   | 1900                      | 0,096 ~ 0,24  | 2100                      | 0,24 ~ 0,60   |

## HYP-ALO-5D

|    | Cast Aluminum             |               | Aluminum Alloy            |               | Copper Alloy              |               | Magnesium Alloy           |               |
|----|---------------------------|---------------|---------------------------|---------------|---------------------------|---------------|---------------------------|---------------|
| Vc | 120 ~ 250 m/min           |               | 80 ~ 200 m/min            |               | 40 ~ 120 m/min            |               | 60 ~ 130 m/min            |               |
| Ø  | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev) | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev) | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev) | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev) |
| 1  | 25000                     | 0,02 ~ 0,08   | 25000                     | 0,02 ~ 0,05   | 25000                     | 0,008 ~ 0,02  | 25000                     | 0,02 ~ 0,05   |
| 2  | 29500                     | 0,04 ~ 0,16   | 22300                     | 0,04 ~ 0,10   | 12700                     | 0,016 ~ 0,04  | 15100                     | 0,04 ~ 0,10   |
| 3  | 19600                     | 0,06 ~ 0,24   | 14900                     | 0,06 ~ 0,15   | 8500                      | 0,024 ~ 0,06  | 10100                     | 0,06 ~ 0,15   |
| 4  | 14700                     | 0,08 ~ 0,32   | 11100                     | 0,08 ~ 0,20   | 6400                      | 0,032 ~ 0,08  | 7600                      | 0,08 ~ 0,20   |
| 6  | 9800                      | 0,12 ~ 0,48   | 7400                      | 0,12 ~ 0,30   | 4200                      | 0,048 ~ 0,12  | 5000                      | 0,12 ~ 0,30   |
| 8  | 7400                      | 0,16 ~ 0,64   | 5600                      | 0,16 ~ 0,40   | 3200                      | 0,064 ~ 0,16  | 3800                      | 0,16 ~ 0,40   |
| 10 | 5900                      | 0,20 ~ 0,80   | 4500                      | 0,20 ~ 0,50   | 2500                      | 0,080 ~ 0,20  | 3000                      | 0,20 ~ 0,50   |
| 12 | 4900                      | 0,24 ~ 0,96   | 3700                      | 0,24 ~ 0,60   | 2100                      | 0,096 ~ 0,24  | 2500                      | 0,24 ~ 0,60   |



*shaping your dreams*

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